



Procedure for Fitting Rollers/Bearings/Gears

- 1) Loose assemble bearings/flanges and gears to roller shafts. Note the allen screw side of the bearing goes toward the roller.
- 2) Fit rollers to the chassis side channels using M13 bolts through the bearing flanges. Note that the whole assembly fits inside the chassis, to allow for this one side of the chassis must be unbolted from the brackets. Hand tight bolts only.
- 3) Re-fit the removed chassis channel and fully tighten the bolts holding it to the brackets.
- 4) Align roller in the middle of the chassis rails.
- 5) Tighten allen grub screws in bearings to lock onto shafts.
- 6) Set gears 19mm from motor flange to face of gear & lock up allen grub screws.
- 7) Set motors in flanges.
- 8) Remove motor covers (Fig. A) and manually work the solenoid (push the switch down) to push gears into mesh. Check the backlash by carefully placing a finger on the motor gear whilst still holding down the motor switch (Fig. B) and moving the roller with your other hand. Reduce backlash to minimum by tapping the roller with a rubber mallet either toward or away from the motor gear, checking per Fig. B after each adjustment.. If necessary, tightening the flange bolts slightly will prevent too much movement when tapping the roller with the hammer. Check motor gear returns freely in all positions.
- 9) Tighten flange bolts on both sides (tight!) and check backlash again.

NB. We use loctite nut lock on the allen grub screws and permanent glue on the gears. The permanent glue requires the application of heat to remove the gear.



Fig. A



Fig. B

Video of the process:

https://www.instagram.com/reel/C0TsJ0eCXCF/?utm_source=ig_web_copy_link&igshid=MzRIODBiNWFIZA==