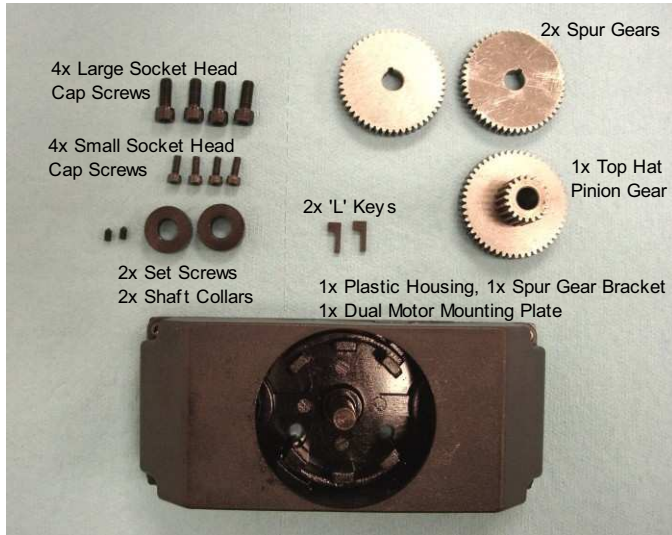


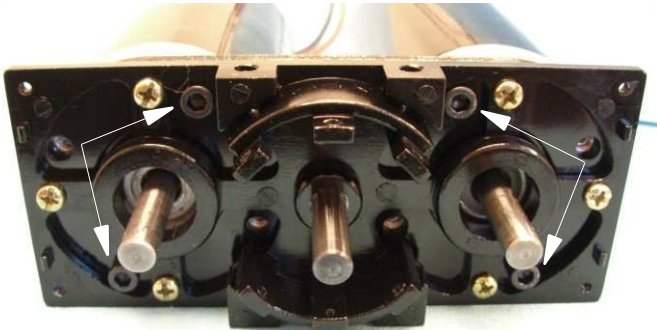
1. Kit contents:



2. Remove the four (4) socket head cap screws holding the plastic housing to the spur gear bracket as shown below.



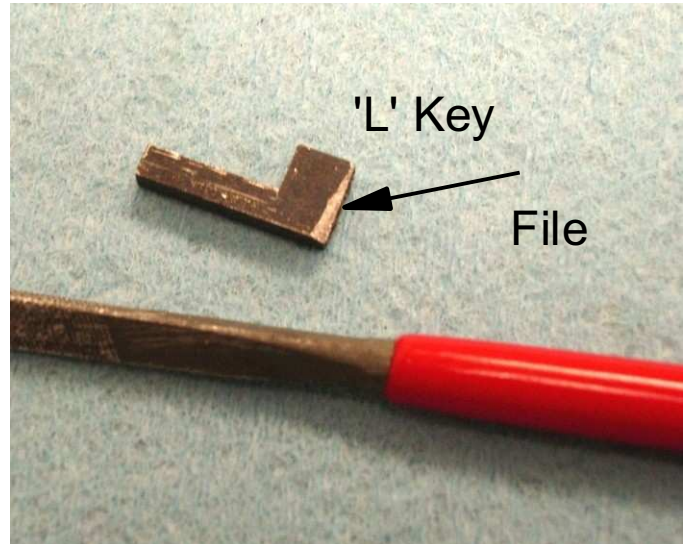
3. Insert the two CIM motors into the spur gear bracket. Rotate each motor until the two screw holes on the motor face line up with the locations shown below. Secure each motor with two (2) of the supplied Large Socket Head Cap Screws in the locations shown below.



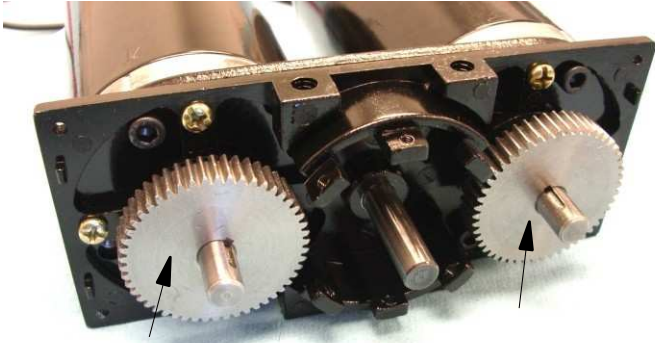
4. Install an 'L' key onto each motor shaft as shown below. Push the key as far back in the slot as possible. Due to manufacturing variances, it may be necessary to bevel the key end with a file prior to installing (see step 5).



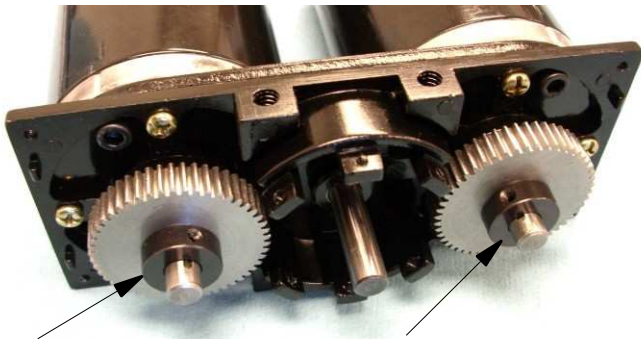
5. If necessary, bevel the shaft key end using a small file so that the key will slide all the way to the rear of the shaft slot.



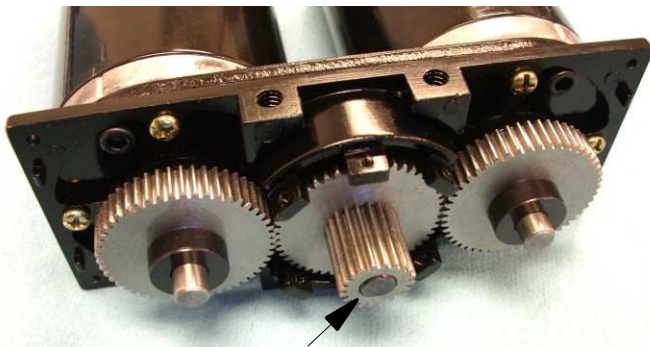
6. Install the two (2) spur gears over the motor shafts and keys as shown below. Make sure that the gears are pressed back as far as possible onto the 'L' key.



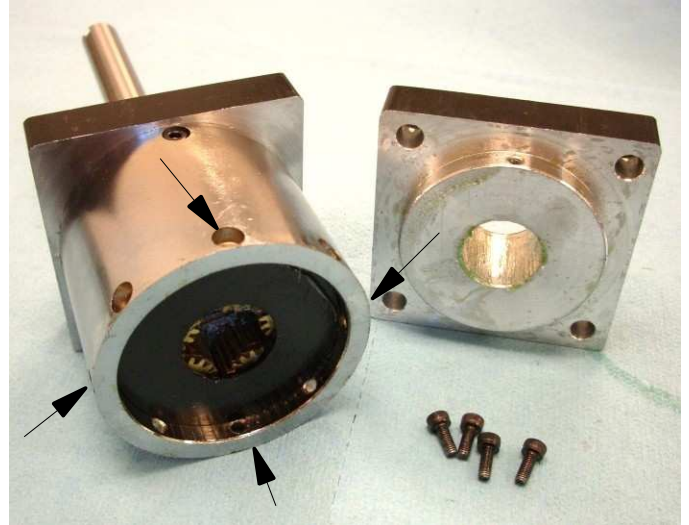
7. Install the two (2) shaft collars and secure with the two (2) set screws as shown below.



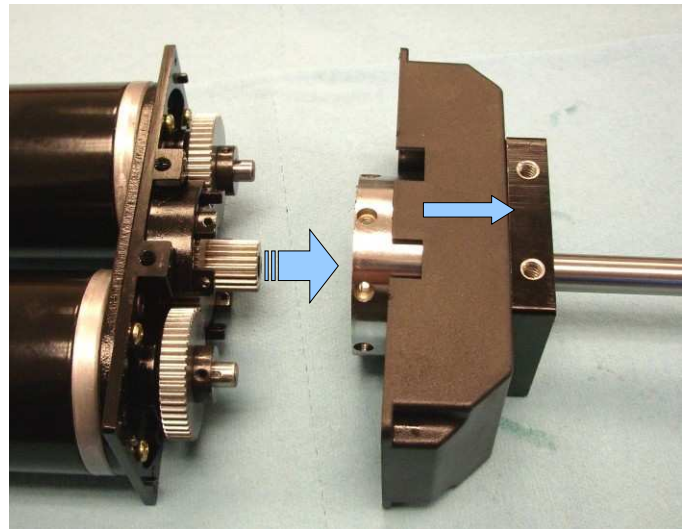
8. Install the Top Hat Gear as shown below.



9. Remove the back plate from the 56mm gearbox as shown. There are four (4) screws in the identified locations that need to be removed. Once removed, the back plate will slide off. Make sure that the thin metal separation plate stays with the planetary gearbox as shown.

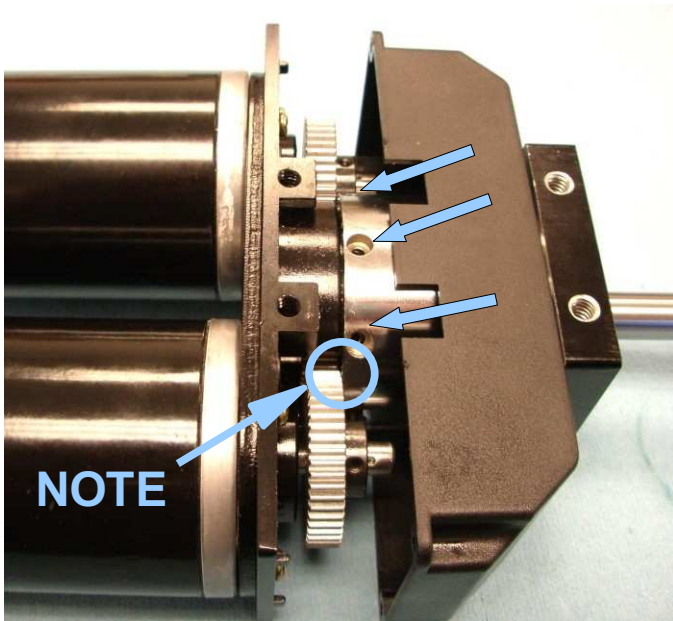


10. Slide the plastic housing over the 56mm planetary gearbox as shown. Next, insert the planetary gearbox onto the motor / spur gear assembly.



11. Slide the planetary gearbox onto the motor / spur gear assembly and line up the six (6) screw holes. Secure the planetary gearbox in six (6) places with the small socket head cap screws.

NOTE: Due to motor/gearbox variances, the spur gear may come into contact with the planetary ring gear as shown. If this is the case, refer to step 5 and file down the key so that the spur gear can move farther back towards the motor mount and away from the planetary ring gear.



12. Secure the plastic housing with four (4) small socket head cap screws as indicated.

