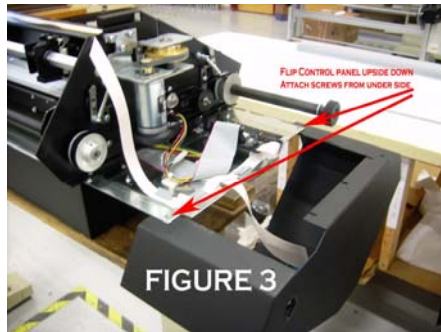
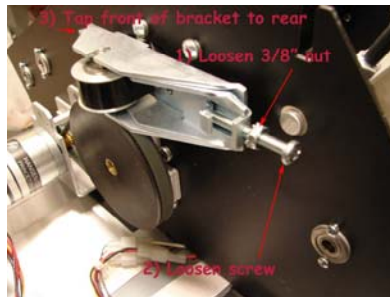


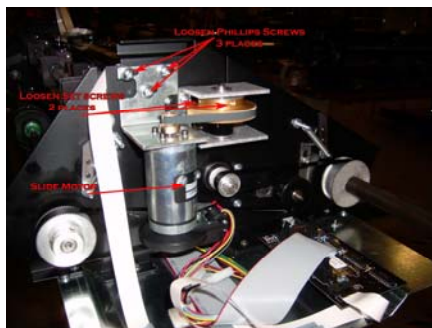
- 1) Open the left and right control panels and place in the service positions (below)



- 2) Loosen the belt tensioner, located under the right control panel. This is done by loosening the 3/8" locking nut on the jack screw, and loosening the screw. Tap on the front of the bracket to loosen tension.



- 3) Loosen the 3 motor bracket screws using a Phillips screwdriver and 2 set screws in large gold pulley using 5/64 Allen wrench. Slide motor forward to loosen belt on motor. Older machines may have the set screws under the belt, in the teeth of the pulley, which requires the belt to be removed first.

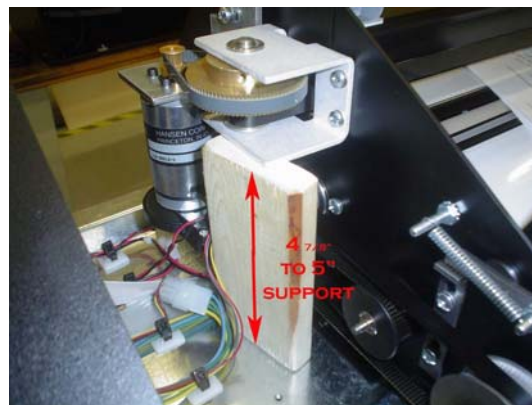


- 3) Loosen set screw in pulley below large gold one by inserting 3/32 allen wrench into the cutout in the left sideplate that the belt disappears into (below)

NOTE: Older machines may have a 1/16" Allen instead of the 3/32" Allen.



- 5) Cut a 4 7/8"-5" (124mm) piece of wood strapping or other material to support the bottom of the U-shaped bracket holding the large gold pulley. Insert as shown below. This prevents the bracket from getting bent when you tap out the shaft. This will be placed between the bottom of the bracket and the base tray of the machine (below).



- 6) Tap the shaft out of the bracket assembly. Remove any burrs on the shaft using a file or sandpaper. This will allow for easier reassembly. Remove the gold pulley from the bracket, leaving the lower drive pulley in place.

- 7) Place the new belt over the gold pulley and insert belt and pulley back into bracket.

- 8) Tap shaft back into place from the top, replacing any spacers that may have fallen out during the disassembly. Be very careful not to hit bottom of motor, as damage may occur to the digital encoder housed inside the black box at base of motor.

9) Tighten all pulley set screws and reverse procedure to complete assembly. Tension the motor belt by applying hand pressure only to the motor bracket until the belt has about 1/16"-1/8" of free play and tighten motor bracket screws.

10) Be sure to tighten y axis belt tensioner loosened in step 1. Turn the machine on prior to installing right control panel to insure belt is tight enough. If it is not, the head will get to side plate on power-up and ratchet against sideplate. Tighten belt tensioner more to eliminate this.

