

FIT BOTTOM GEARBOX

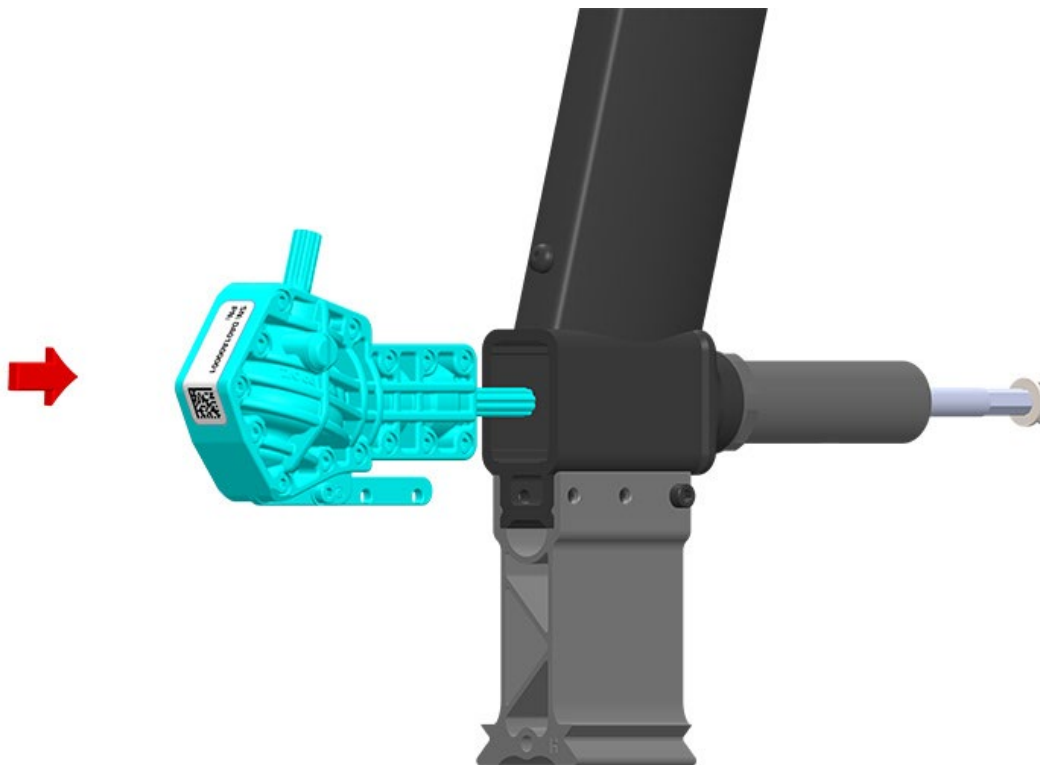
This tutorial shows how to fit the Bottom Gearbox into the XE-1

1. Work Instruction - Fit Bottom Gearbox

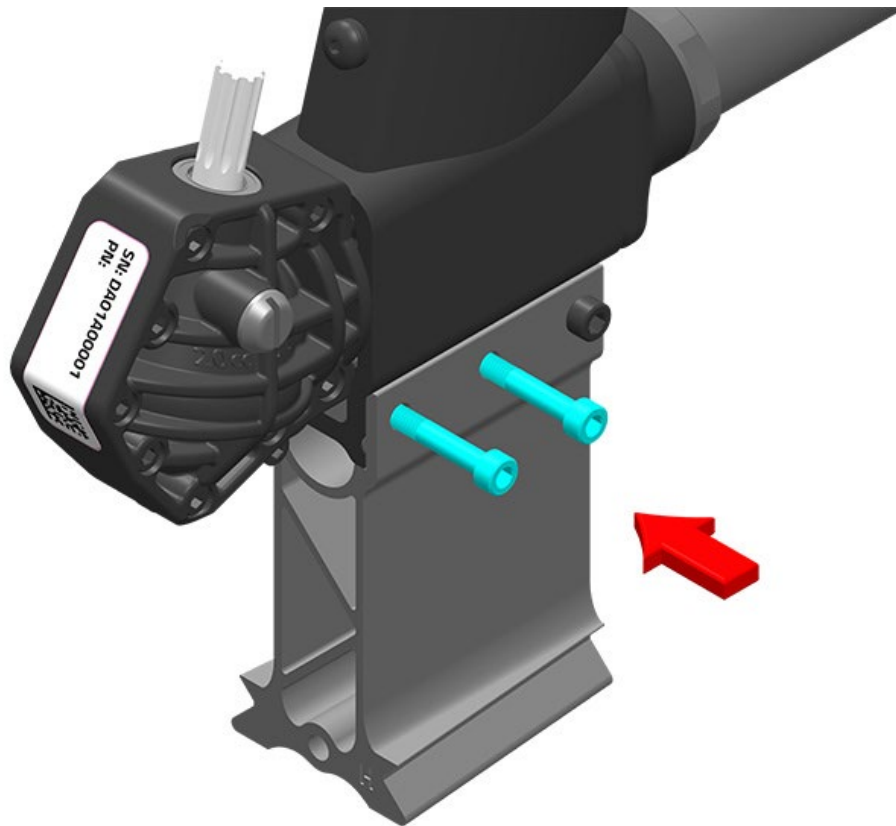
TOOLS REQUIRED

ID	Description	Task
	5 mm Hex Drive /Allen Key	Fasten M6 Cap Screws
	10 mm Open / Combination Wrench	Fasten M6 Nylock Nut
	Torque Wrench (1 – 15 Nm range)	Fasten M6 Nylock Nuts
	10 mm Socket	Fasten M6 Nylock Nuts

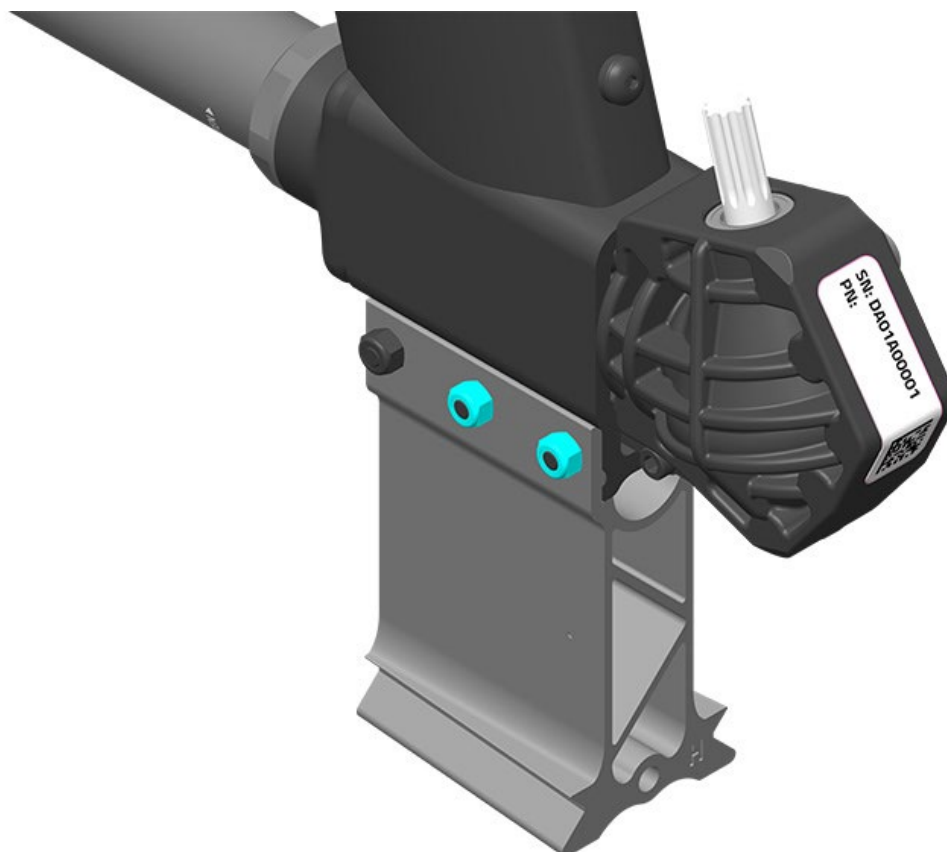
1.1 Fit the Bottom Gearbox to the Frame and engage the Bottom Gearbox Input Shaft to the Propeller Drive Shaft. Rotate the Propeller Drive Shaft until the splines align. [Tools: By Hand Only]



1.2 Fit the two aft 45 mm length cap screws through the Bayonet Upright and Bottom Gearbox Bracket from the right-hand side. [Tools: By Hand]



1.3 Fit the two aft M6 nylock nuts and fasten to a Torque value of 5 Nm. [Tools: Torque Wrench with 10 mm socket, 10 mm Wrench].



INFORMATION: If a Torque Wrench is not used, be careful not to over tighten the Nylock Nuts. Given the nylon locking seal, the nuts are not likely to come loose once fastened.