

FIT DRIVE GEAR ASSEMBLY

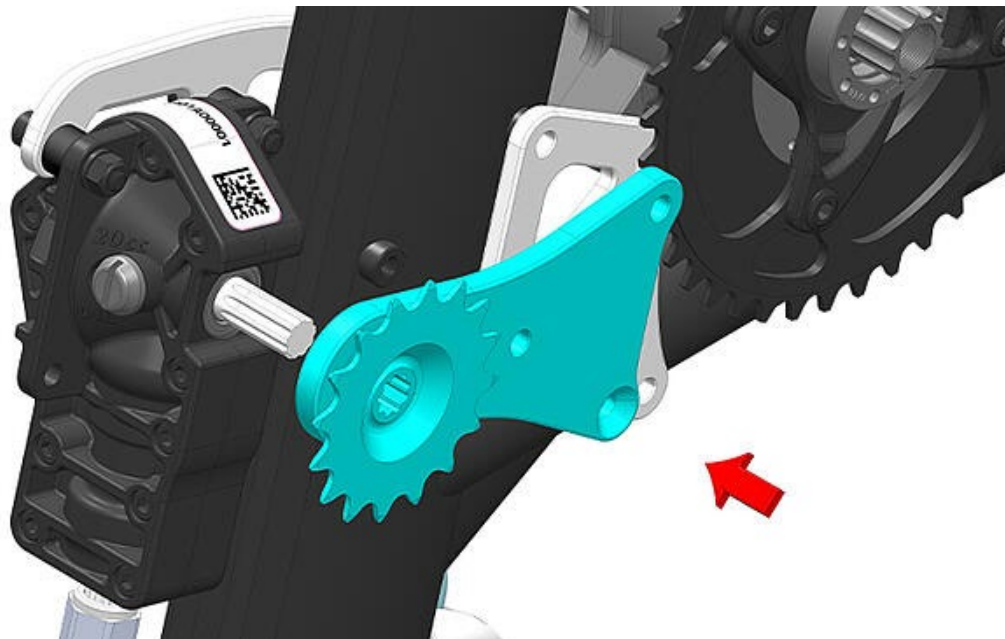
This tutorial shows how to fit the Drive Gear Assembly into the XE-1

1. Fit Drive Gear Assembly

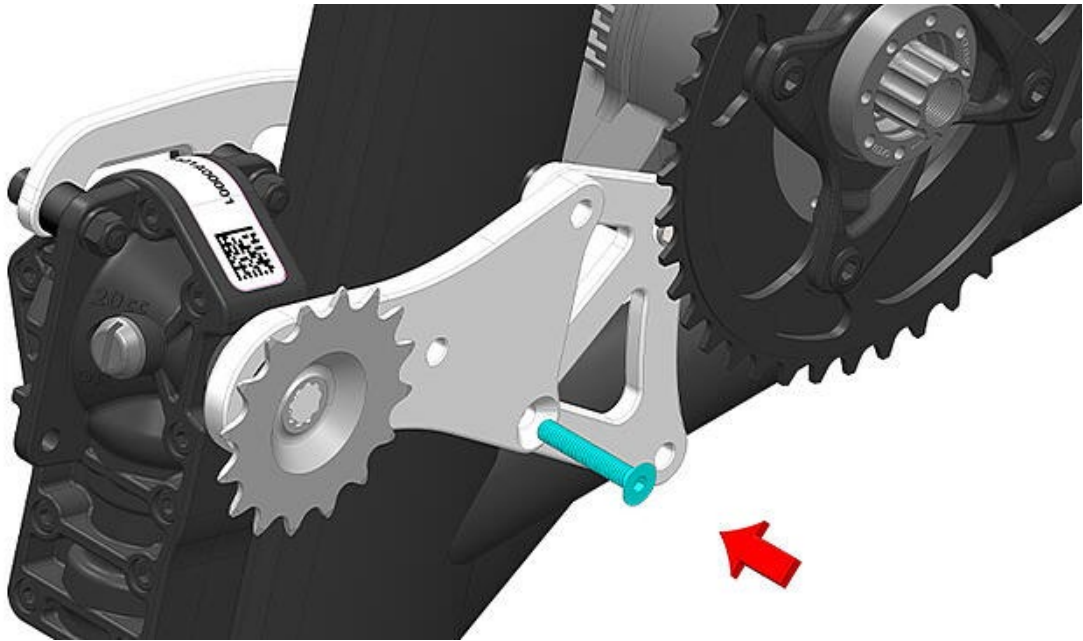
TOOLS REQUIRED

ID	Description	Task
	Tef-Gel	Assemble Drive Gear Assembly to Top Gearbox Input Shaft
	M4 Hex Key	Fit M6 Torque Plate Countersink Head Screw
	Loctite 243 Thread Locking Compound	Fit M6 Torque Plate Countersink Head Screw
	Torque Wrench	Fasten M6 Torque Plate Countersink Head Screw

1.1 Apply Tef-Gel (or equivalent lubricant) to the Top Gearbox Input Shaft. Insert the Drive Gear Assembly with the Sprocket internal spline fitting onto the external spline of the Top Gearbox Input Shaft.



1.2 Apply Loctite 243 (or equivalent thread locker) to the thread and assemble the M6 Torque Plate Screw through the Torque Plate and Lower Right-Hand Motor Mount to engage with the threaded boss on the Frame. Fasten to 5 Nm. [Tools: M4 Hex, Torque Wrench]



INFORMATION: The M6 Torque Plate Screw has a countersink head and thread length 35mm. Do not exchange for a shorter length screw.