

The background of the top section is a solid green color. Overlaid on this background are various line drawings of vegetables in a lighter green shade. These include a head of broccoli, a carrot, a corn cob, a bell pepper, a chili pepper, a tomato, and some leafy greens. The word "Full" is written in a large, white, serif font across the center of this section.

Full

Solutions, Inc.

ASSEMBLY WORK INSTRUCTIONS

Assembly P/N: 2-200-2688

Assembly Revision: 01

Assembly Description: Motor Box 2.1

Document Number: 2-600-2861

Document Revision: 03

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REV Notes

- Notes Start here.
- It is up to you to make good notes.

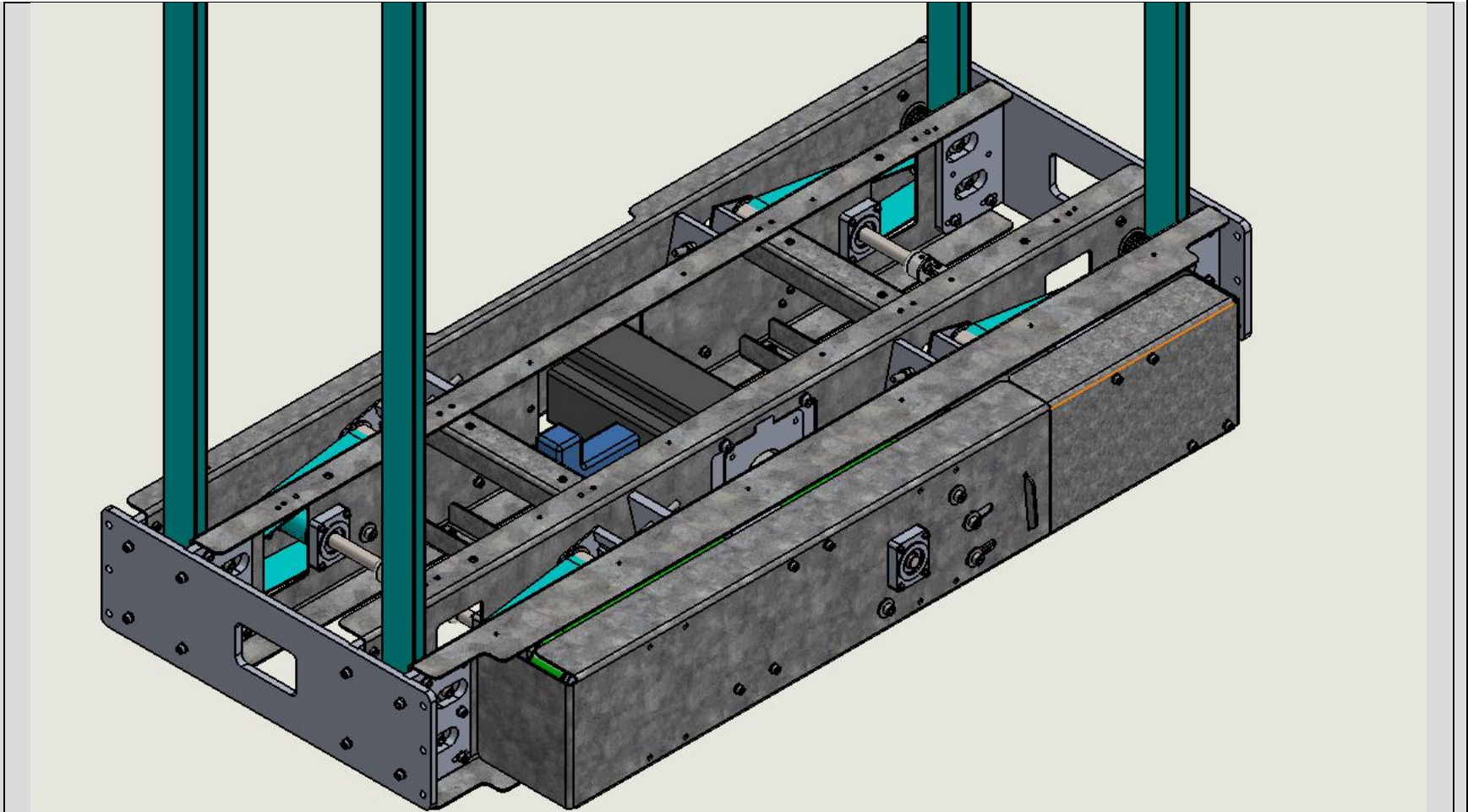
Revision	Date	Author	Description
00		Rocky Jewell	Initial Release
01	7/01/2020	Matt Hohenberger	- Updated Cover Instructions for parts that are not installed at vendor - Small Changes Throughout - Completely Revamped 2-200-2767 Assembly Instructions
02	7/15/2020	Matt Hohenberger	Added Shipping Instructions
03	12/2/2020	Matt Hohenberger	Replaced drive component instructions

Recommended PPE

DESCRIPTION	IMAGE		
Hard hat			
Hearing Protection			
Steel Toe			

2-200-2688 Motor Box 2.1

Overview



Description

- Motor Box for VLS 2.1

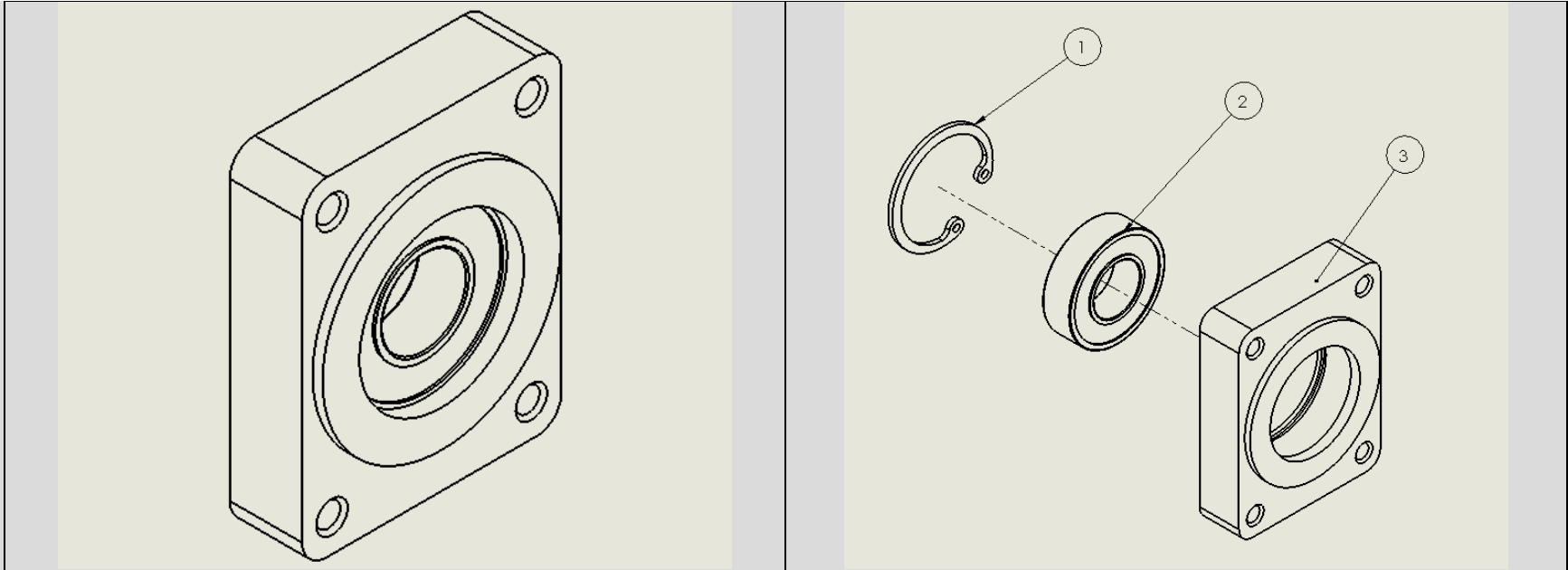
1 Subassemblies Without Major Dependencies

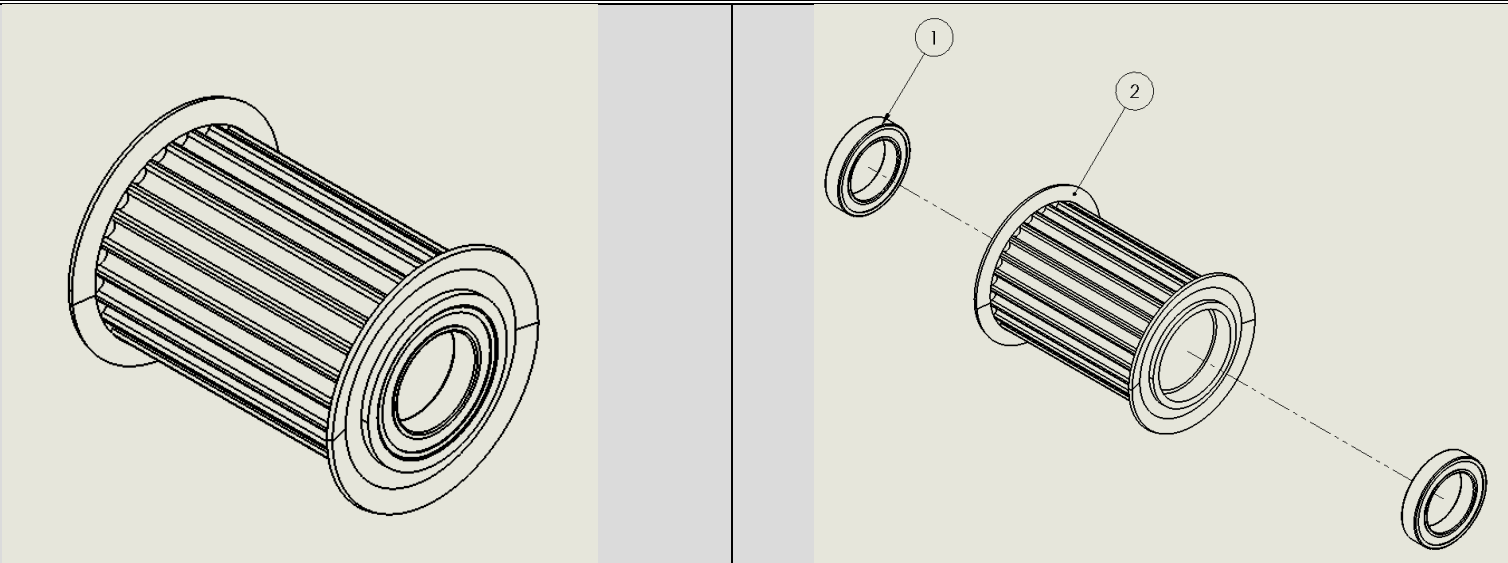
Overview

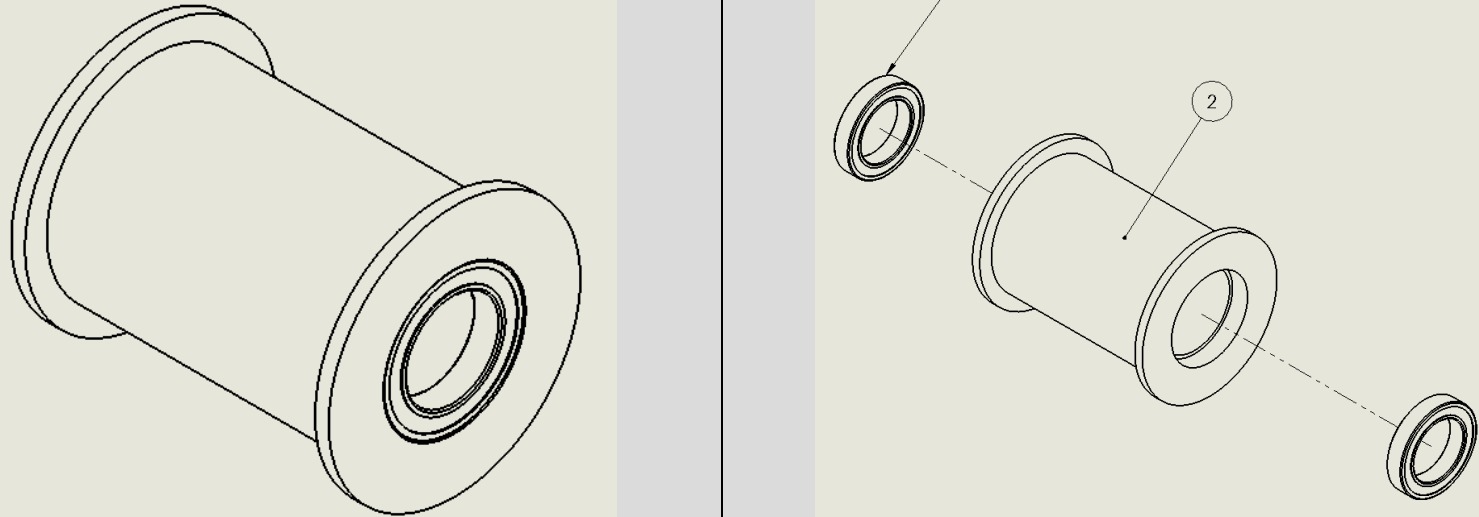


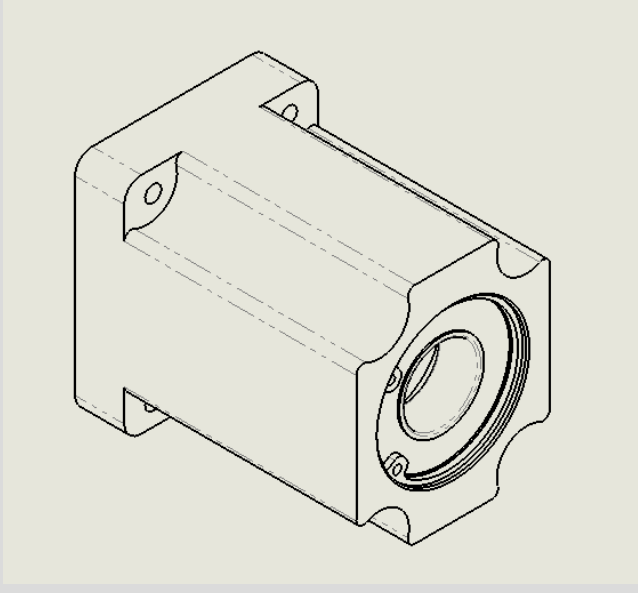
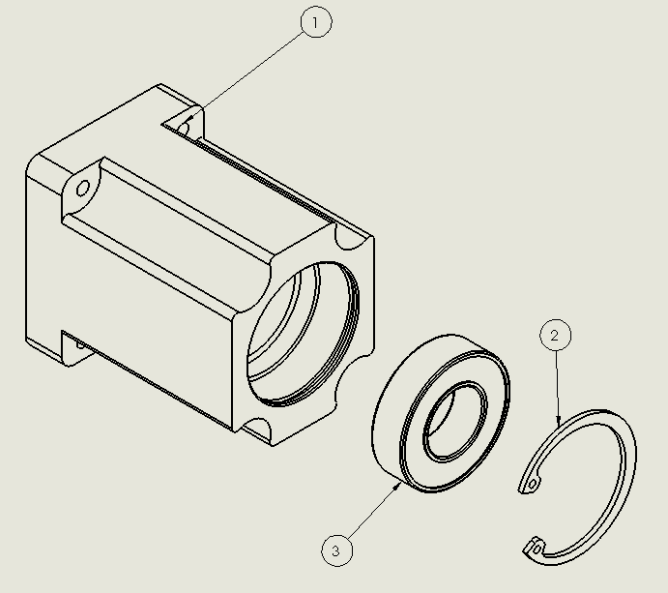
Description

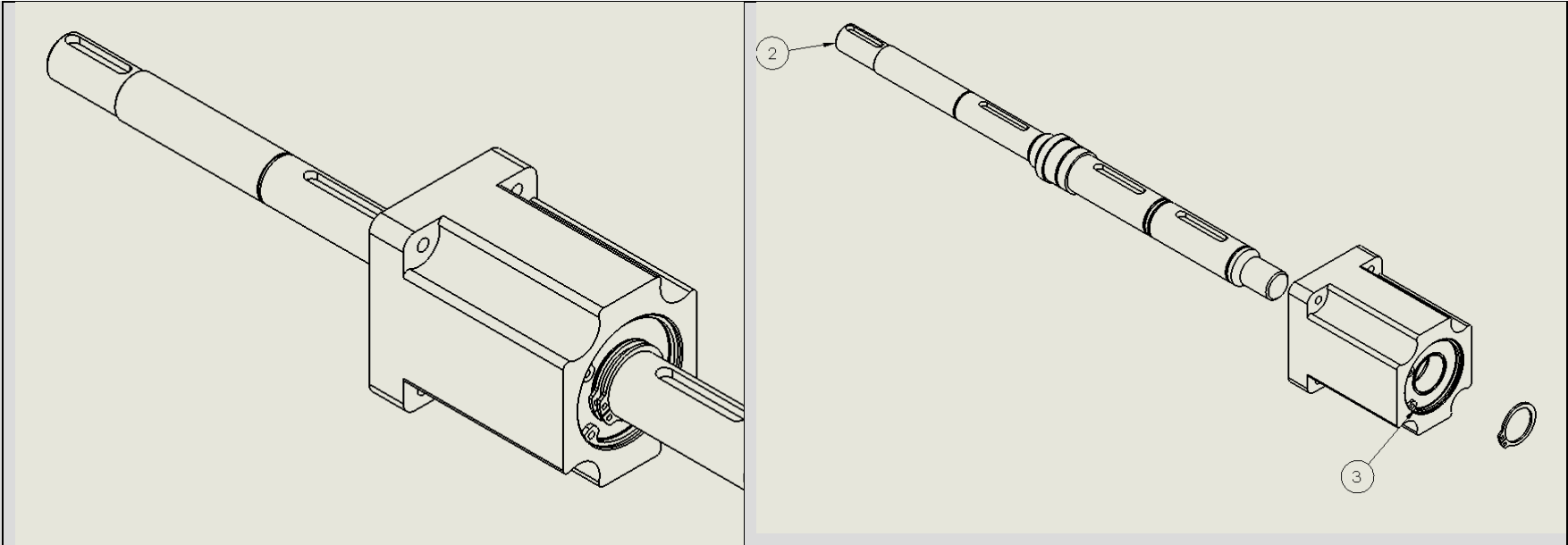
- All Subassemblies

1.1 2-200-2697 Bearing Block Subassembly			Qty to Build: 10	Danger: None
Tools	DESCRIPTION		IMAGE	
	Small Arbor Press			
	Snap ring pliers			
BOM for Qty 1	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	RTWS35	RETAINING RING, INTERNAL, 35MM	1
	2	6003h-2rs	bearing, 6003, stainless steel, double sealed	1
	3	2-300-2698	BEARING BLOCK	1
Explode/s				
Notes	Part Used In: 2-200-2764, 2-200-2762, 2-200-2761, 2-200-2754, and 2-200-2767			
Steps	- Using a small arbor press, press on the outer race of the bearing and install it into its housing. - Install the retaining ring with snap ring pliers.			

1.2 2-200-2701 Idler, 24 Teeth, 55mm Wide, Subassembly			Qty to Build: 7		Danger: None	
Tools	DESCRIPTION				IMAGE	
	Arbor Press					
BOM for Qty 1	ITEM NO.	PART NUMBER	DESCRIPTION			QTY.
	1	B6803DDU	Deep Groove Ball Bearing, OD 26mm, ID 17mm			2
	2	2-300-2695	IDLER, FLAT BELT, 38MM DIAM			1
Explode/s						
Notes	Part Used In: 2-200-2752, 2-200-2717, 2-200-2758, and 2-200-2769					
Steps	- Using an arbor press, press on the outer race of the bearing and install it into its housing. - Repeat to the other side					

1.3 2-200-2699 Idler, Flat Belt, 60mm Diam, Subassy			Qty to Build: 13		Danger: None	
Tools	DESCRIPTION			IMAGE		
	Arbor Press					
BOM for Qty 1	ITEM NO.	PART NUMBER	DESCRIPTION			QTY.
	1	B6803DDU	Deep Groove Ball Bearing, OD 26mm, ID 17mm			2
	2	2-300-2695	IDLER, FLAT BELT, 38MM DIAM			1
Explode/s						
Notes	Part Used In: 2-200-2753 and 2-200-2770					
Steps	- Using an arbor press, press on the outer race of the bearing and install it into its housing. - Repeat to the other side					

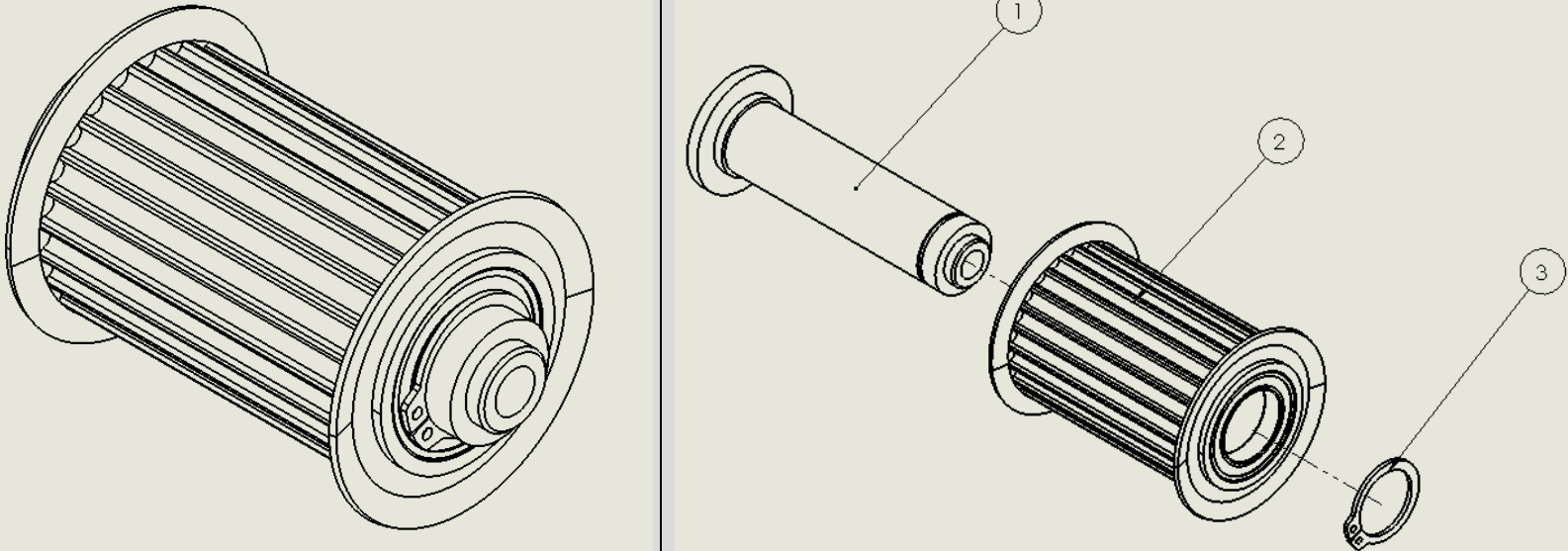
1.4 2-200-3733 Offset Bearing Block			Qty to Build: 1		Danger: None	
Tools	DESCRIPTION			IMAGE		
	Arbor Press					
BOM for Qty 1	ITEM NO.	PART NUMBER	DESCRIPTION		QTY.	
	1	2-300-3647	STANDOFF BEARING BLCOK		1	
	2	98455A236	RETAINING RING		1	
	3	6003H-2RS	BEARING, 6003, STAINLESS STEEL, DOUBLE SEALED		1	
Explode/s						
Notes	Assembly Used In: 2-200-3651					
Steps	- Using an arbor press, press on the OUTER race of the bearing and install it into its housing. - DO NOT PRESS THE BEARING ANYWHERE EXCEPT FOR THE OUTER RACE - Install the retaining ring with snap ring pliers.					

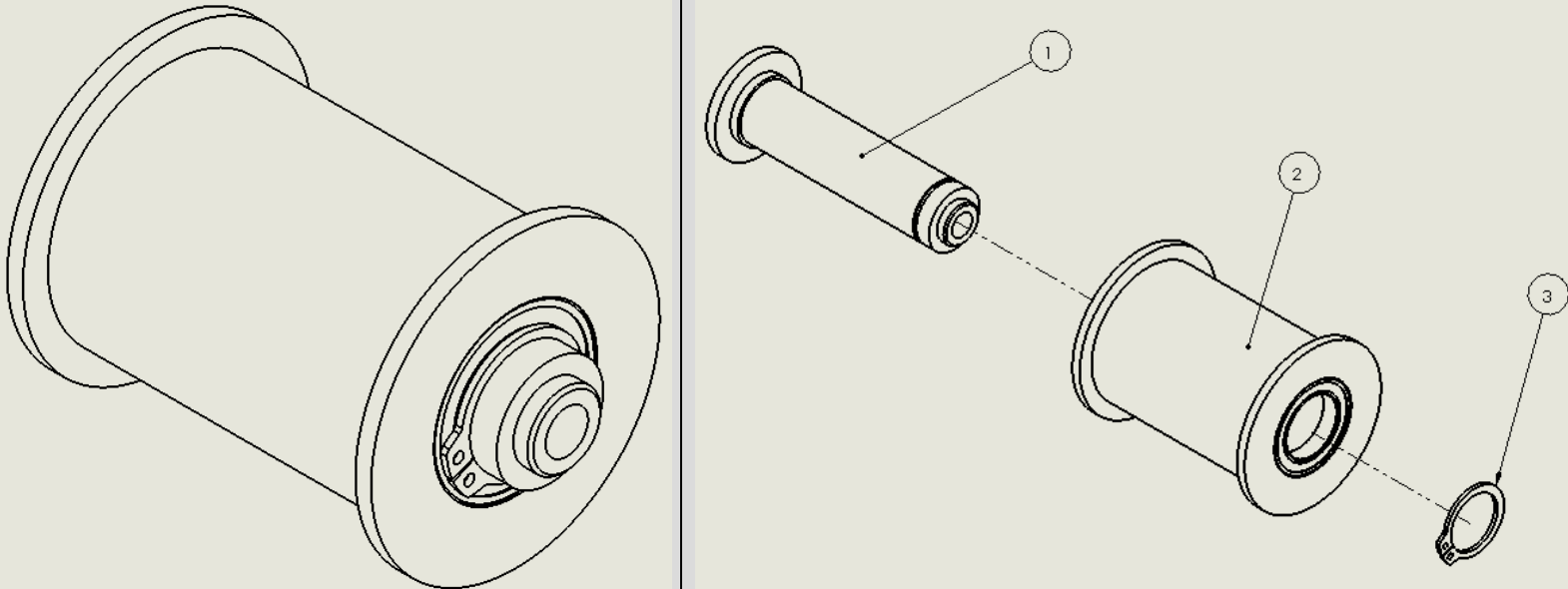
1.5 2-200-3734 Large Diameter Bearing Block			Qty to Build: 1	Danger: None
Tools	DESCRIPTION		IMAGE	
	Arbor Press			
BOM for Qty 1	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	B6803DDU	Deep Groove Ball Bearing, OD 26mm, ID 17mm	2
	2	2-300-2695	IDLER, FLAT BELT, 38MM DIAM	1
Explode/s				
Notes	Part Used In: 2-200-2753 and 2-200-2770			
Steps	- Using an arbor press, press on the OUTER race of the bearing and install it into its housing. - Install the retaining ring with snap ring pliers.			

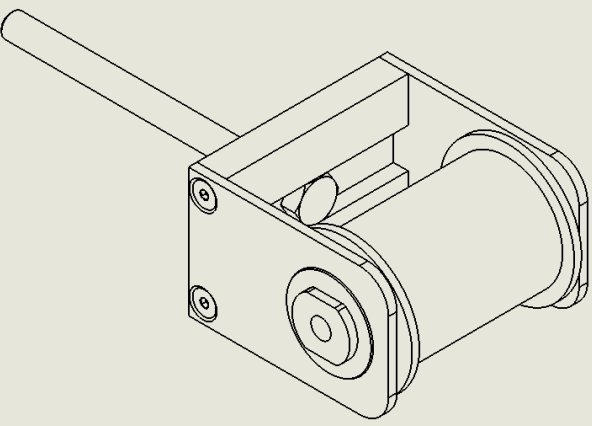
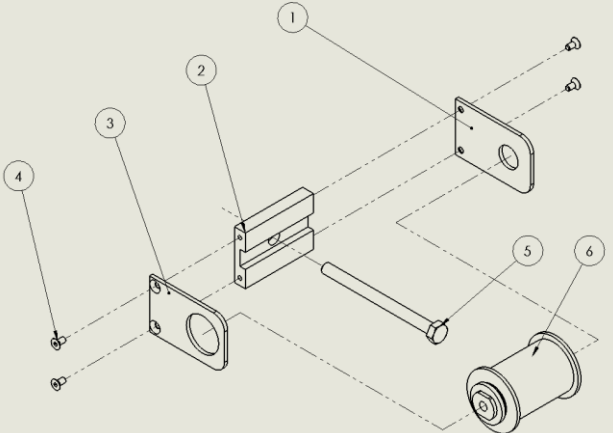
1.6 2-200-2752 Pulley Assembly

Qty to Build: 4

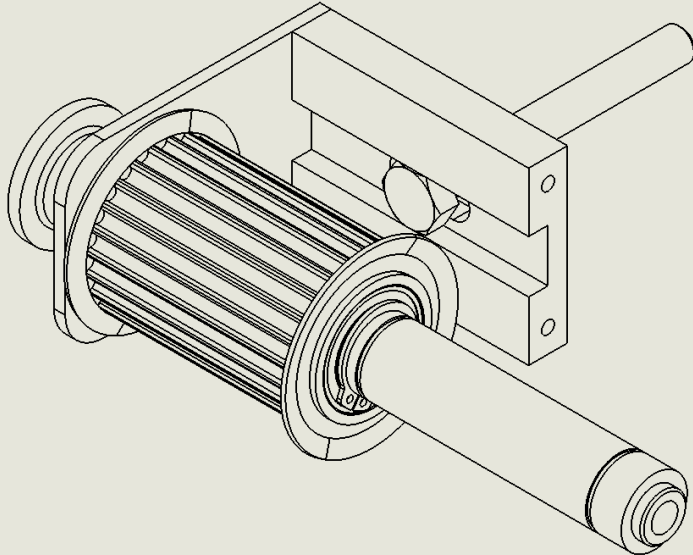
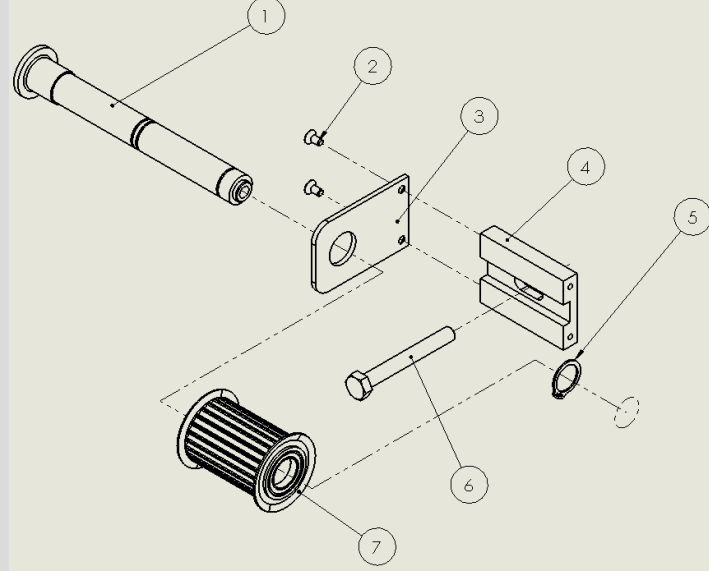
Danger: None

Tools	DESCRIPTION		IMAGE	
	Snap ring pliers			
BOM for Qty 1	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-300-2696	ELEVATOR PULLEY SHAFT	1
	2	2-200-2701	Idler, 24 Teeth, 55mm Wide, Subassembly	1
	3	90967A210	RETAINING RING, EXTERNAL, STAINLESS STEEL, 17MM	1
Explode/s				
Notes	Parts Used In: 2-200-2754			
Steps	- Slide the Pin through the pulley. - Install the retaining ring with snap ring pliers.			

1.7 2-200-2753 Idler on Shaft, Flat			Qty to Build: 12		Danger: None	
Tools	DESCRIPTION			IMAGE		
	Snap ring pliers					
BOM for Qty 1	ITEM NO.	PART NUMBER	DESCRIPTION			QTY.
	1	2-300-2696	ELEVATOR PULLEY SHAFT			1
	2	2-200-2699	IDLER, FLAT BELT, 60MM DIAM, SUBASSY			1
	3	90967A210	RETAINING RING, EXTERNAL, STAINLESS STEEL, 17MM			1
Explode/s						
Notes	Part Used In: 2-200-2691 and 2-200-2754					
Steps	- Slide the Pin through the pulley. - Install the retaining ring with snap ring pliers.					

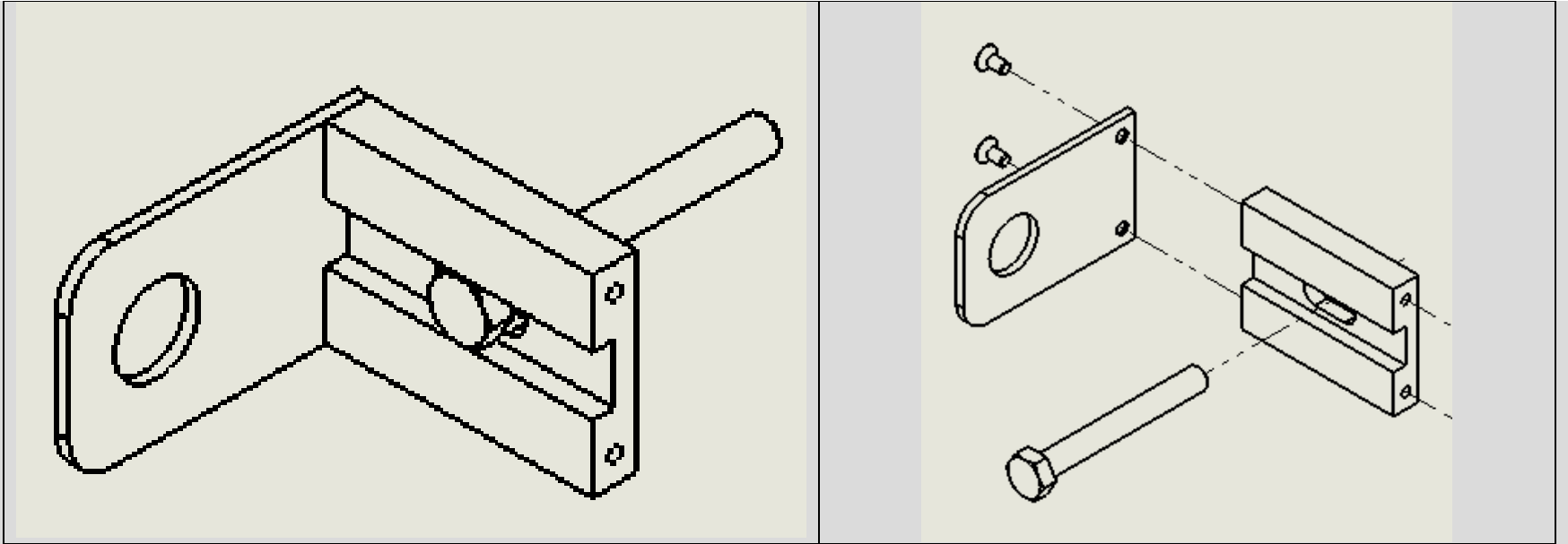
1.8 2-200-2691 Elevator Belt Tensioner Subassembly			Qty to Build: 4	Danger: None
Tools	DESCRIPTION		IMAGE	
	Snap ring pliers			
	Metric Allen Keys			
	Loctite			
BOM for Qty 1	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-300-2693	ELEVATOR BELT TENSIONER SIDE WALL	1
	2	2-300-2692	TENSIONING BOLT CAPTURE BLOCK	1
	3	2-300-2694	TENSIONER SIDE WALL - LARGE	1
	4	92125A188	18-8 Stainless Steel Hex Drive Flat Head Screw, M4 x 0.7 mm Thread, 8 mm Long	4
	5	91287A457	18-8 Stainless Steel Hex Head Screw, M8 x 1.25 mm Thread, 100 mm Long, Fully Threaded	1
	6	2-200-2753	IDLER ON SHAFT, FLAT	1
Explode/s				
				
Notes	Parts Used In: 2-200-2754			
Steps	- Slide the Pin into the pulley. - Install the retaining ring with snap ring pliers. - Use Single Drop of Loctite on Items 4			

1.9 2-200-2717 Drive Belt Tensioner Subassembly**Qty to Build: 1****Danger: None**

Tools	DESCRIPTION			IMAGE
	Metric Allen Keys			
	Snap Ring Pliers			
	Loctite			
BOM for Qty 1	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-300-2710	DRIVE PULLEY SHAFT	1
	2	92125A188	18-8 Stainless Steel Hex Drive Flat Head Screw, M4 x 0.7 mm Thread, 8 mm Long	2
	3	2-300-2736	ELEVATOR BELT TENSIONER SIDE WALL, INNER	1
	4	2-300-2718	TENSIONING BOLT CAPTURE BLOCK, DRIVE SIDE	1
	5	90967A210	RETAINING RING, EXTERNAL, STAINLESS STEEL, 17MM	1
	6	91287A311	18-8 Stainless Steel Hex Head Screw, M8 x 1.25 mm Thread, 55 mm Long	1
	7	2-200-2701	IDLER, 24 TEETH, 55MM WIDE, SUBASSY	1
Final Assembly				
				
Notes	Part Used In: 2-200-2757			

1.9.1 Step 1 Order of Assembly

Images

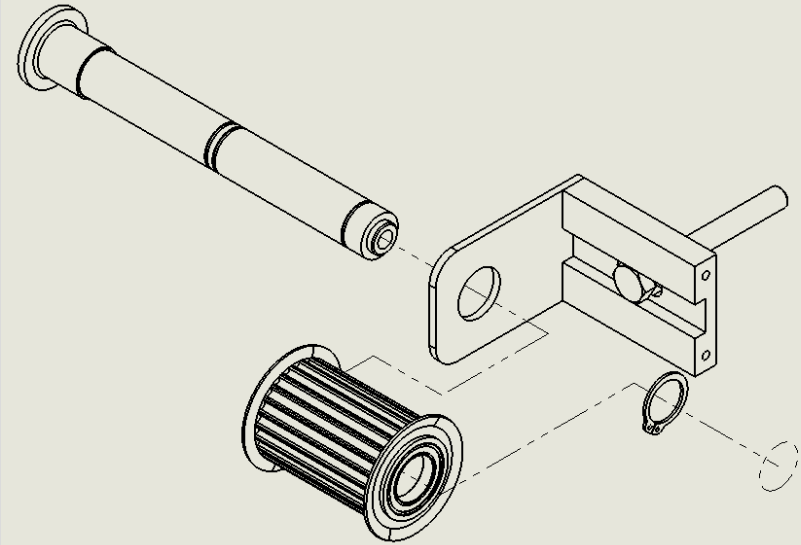
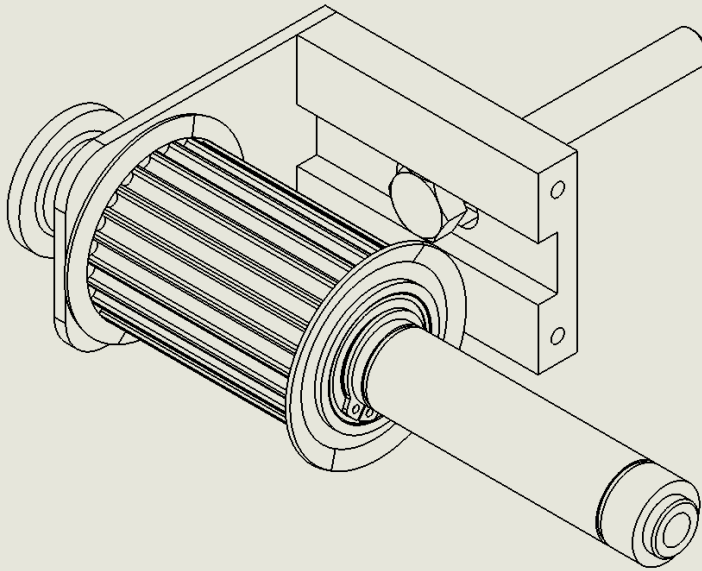


Directions

- Assemble as shown.
- Use Single Drop of Loctite on hardware (Bubble 2).

1.9.2 Step 2 Order of Assembly

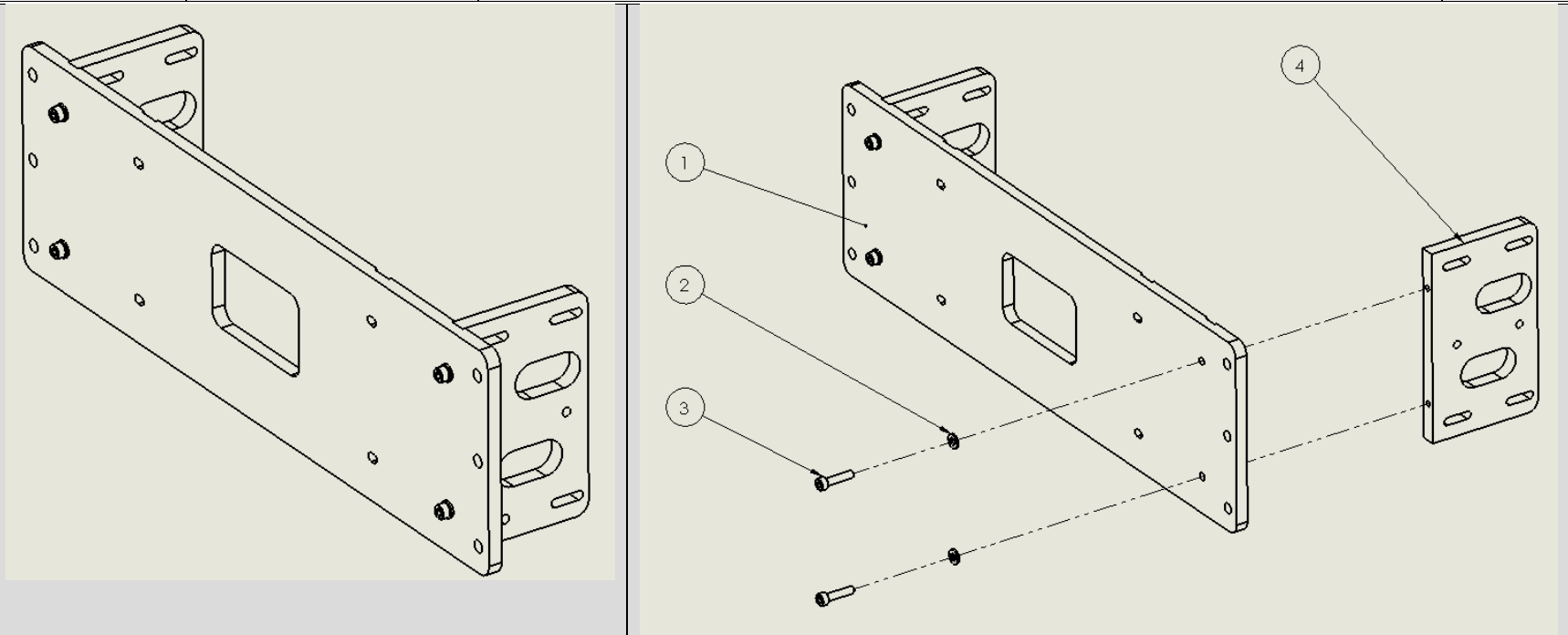
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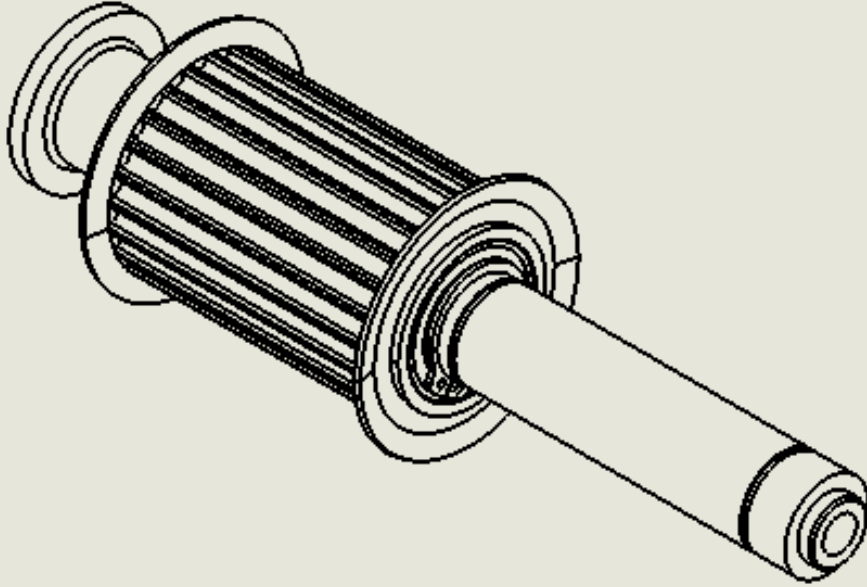
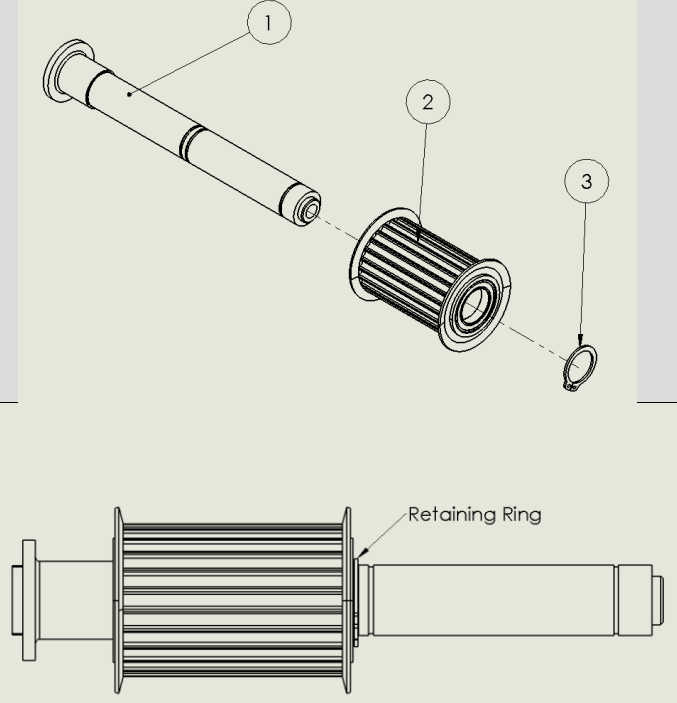


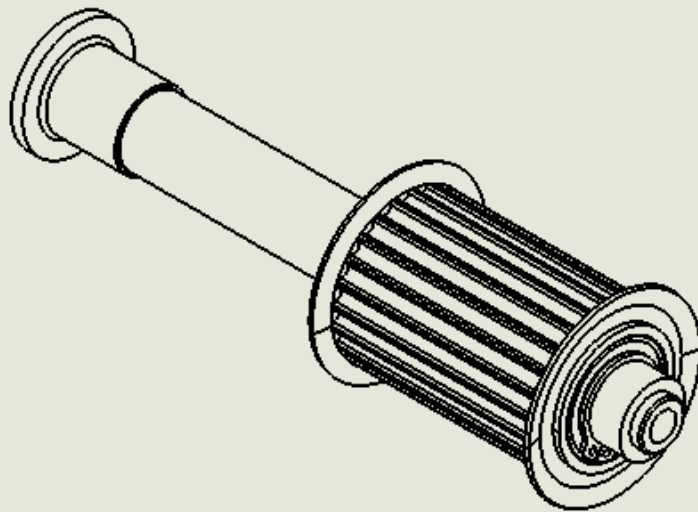
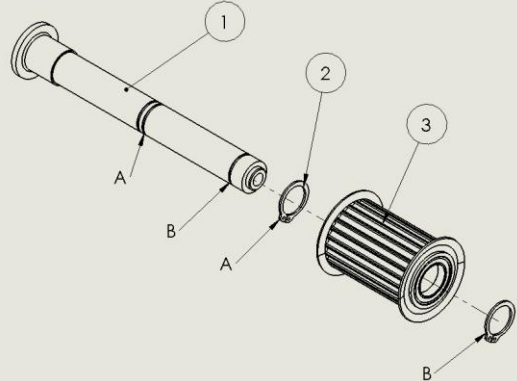
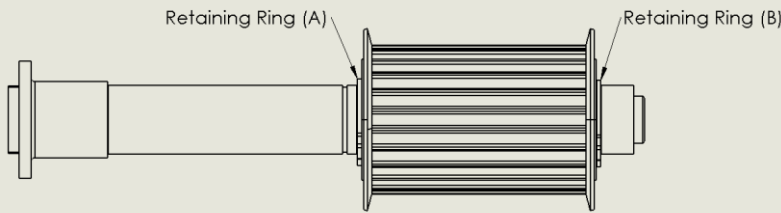
Directions

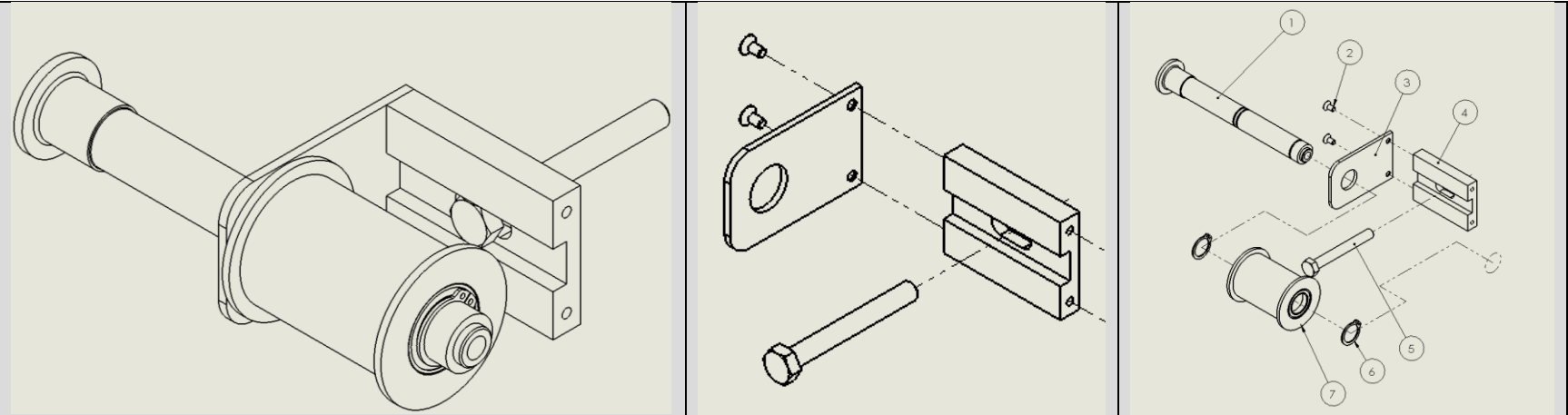
- Push Pin through step 1s assembly and through the pulley.
- Then, using the snap ring pliers, Install the retaining ring.

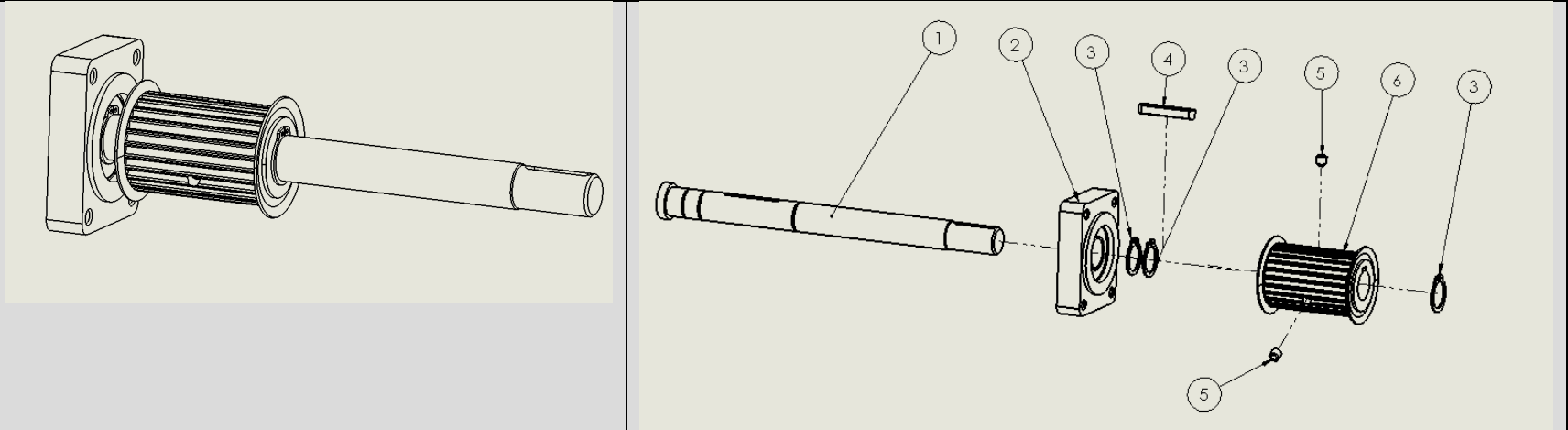
1.10 2-200-2724 End Wall Plate Subassy**Qty to Build: 2****Danger: Low**

Tools	DESCRIPTION			IMAGE	
	Metric Allen Keys				
BOM for Qty 1	ITEM NO.	PART NUMBER	DESCRIPTION		QTY.
	1	2-300-2726	END WALL PLATE		1
	2	93475A250	18-8 Stainless Steel Washer for M6 Screw Size, 6.4 mm ID, 12 mm OD		4
	3	91292A138	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 25mm		4
	4	2-300-2725	END WALL CONNECTING PLATE		2
Explode/s					
	Notes				
Steps	- Part Used In: 2-200-2767 - Using Allen keys or a drill Assemble as shown. - Repeat to both sides.				

1.11 2-200-2758 Idler on Shaft, Long, 24 Teeth, Inside			Qty to Build: 1	Danger: None
Tools	DESCRIPTION		IMAGE	
	Snap Ring Pliers			
BOM for Qty 1	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-300-2710	DRIVE PULLEY SHAFT	1
	2	2-200-2701	Idler, 24 Teeth, 55mm Wide, Subassembly	1
	3	90967A210	RETAINING RING, EXTERNAL, STAINLESS STEEL, 17MM	1
Explode/s	 			
Notes	Parts Used In: 2-200-2757			
Steps	- Slide the Pin through the pulley. - Install the retaining ring with snap ring pliers.			

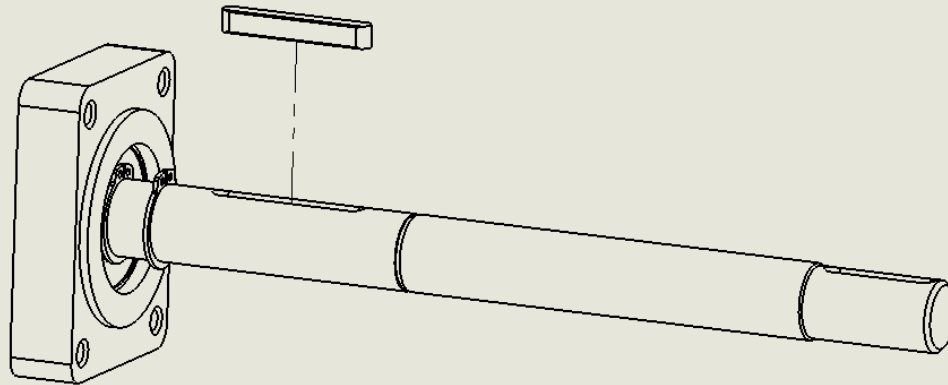
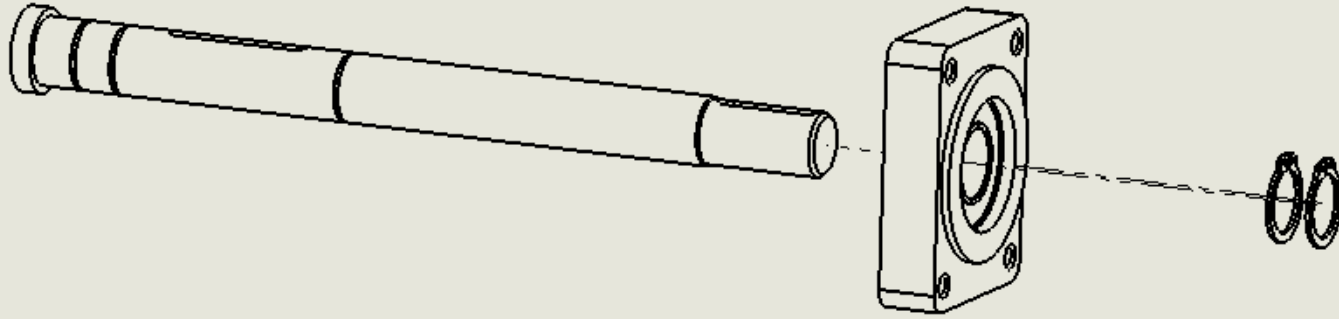
1.12 2-200-2769 Idler on Shaft, Long, 24 Teeth, Outside			Qty to Build: 1		Danger: None	
Tools	DESCRIPTION			IMAGE		
	Snap Ring Pliers					
BOM for Qty 1	ITEM NO.	PART NUMBER	DESCRIPTION			QTY.
	1	2-300-2710	DRIVE PULLEY SHAFT			1
	2	90967A210	RETAINING RING, EXTERNAL, STAINLESS STEEL, 17MM			2
	3	2-200-2701	Idler, 24 Teeth, 55mm Wide, Subassembly			1
Explode/s						
						
Notes	Parts Used In: 2-200-2757					
Steps	1. Install the First retaining ring with the pliers 2. Then slide the pin through the pulley 3. Install the last retaining ring with snap ring pliers.					

1.13 2-200-2770 Drive Belt Tensioner Subassembly, Smooth Idler			Qty to Build: 1	Danger: None
Tools	DESCRIPTION		IMAGE	
	Snap Ring Pliers			
	Metric Allen Keys			
	Loctite			
BOM for Qty 1	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-300-2710	DRIVE PULLEY SHAFT	1
	2	92125A188	18-8 Stainless Steel Hex Drive Flat Head Screw, M4 x 0.7 mm Thread, 8 mm Long	2
	3	2-300-2693	ELEVATOR BELT TENSIONER SIDE WALL	1
	4	2-300-2718	TENSIONING BOLT CAPTURE BLOCK, DRIVE SIDE	1
	5	91287A311	18-8 Stainless Steel Hex Head Screw, M8 x 1.25 mm Thread, 55 mm Long	1
	6	90967A210	RETAINING RING, EXTERNAL, STAINLESS STEEL, 17MM	2
	7	2-200-2699	Idler, Flat Belt, 60mm Diam, Subassy	1
Explode/s				
Notes	Part Used In: 2-200-2757			
Steps	- Follow Assembly - If more Instructions needed refer to 2-200-2717 build guide. - Use Single Drop of Loctite			

1.14 2-200-2764 Elevator Drive Shaft Subassembly, Drive Side			Qty to Build: 2	Danger: None
Tools	DESCRIPTION		IMAGE	
	Metric Allen Keys			
	Snap Ring Pliers			
	Loctite			
	Torque Wrench			
BOM for Qty 1	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-300-2723	ELEVATOR DRIVE SHAFT, DRIVEN SIDE	1
	2	2-200-2697	BEARING BLOCK SUBASSEMBLY	1
	3	90967A210	RETAINING RING, EXTERNAL, STAINLESS STEEL, 17MM	3
	4	KESS5-35	Parallel Key (with both ends round), Width 5mm, Length 35 mm	1
	5	92015A126	18-8 Stainless Steel Cup-Point Set Screw, M6 x 1 mm Thread, 6 mm Long	2
	6	2-300-2711	DRIVE, 24 TEETH, 53MM WIDE	1
Final Assembly				
Notes	- Part Used In: 2-200-2763 - Torque set screws to – 55in-lbs. - Use Single Drop of Loctite on set screws			

1.14.1 Step 1 & 2 Order of Assembly

Images

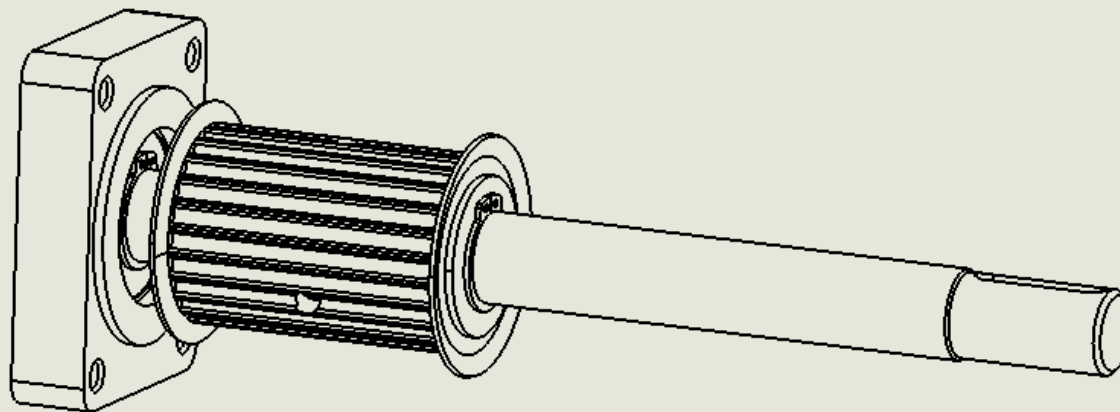
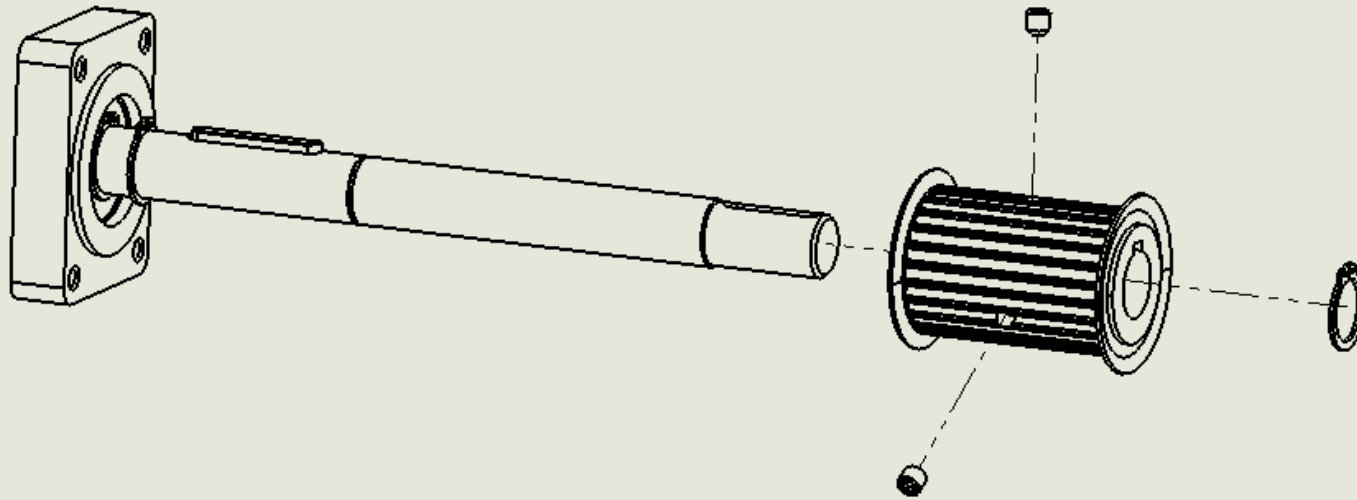


Directions

- Assemble as shown.

1.14.2 Step 3 & 4 Order of Assembly

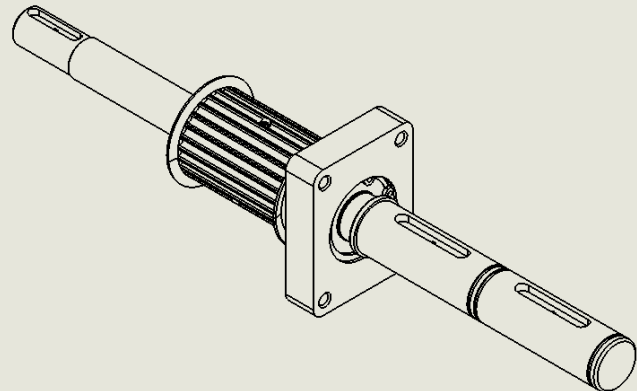
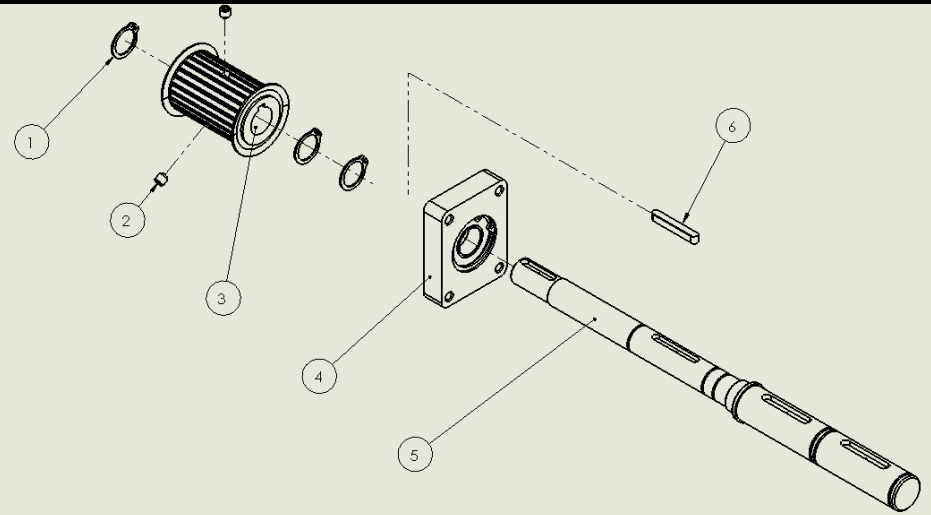
Images



Directions

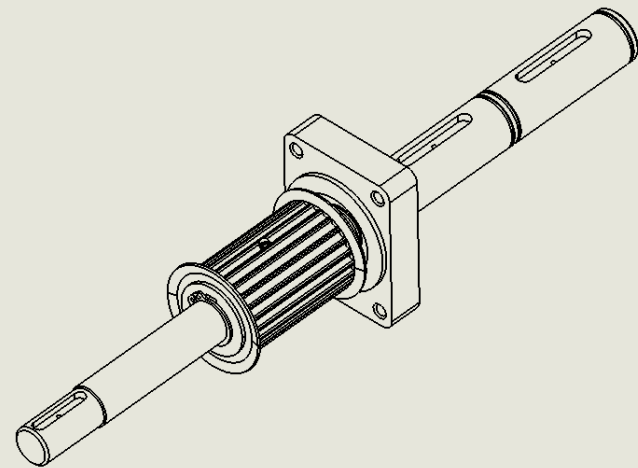
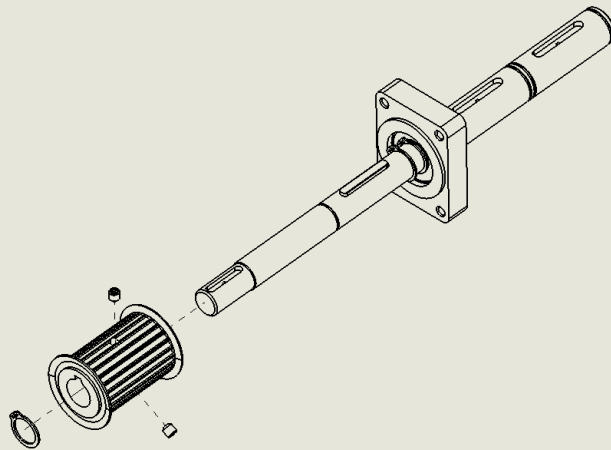
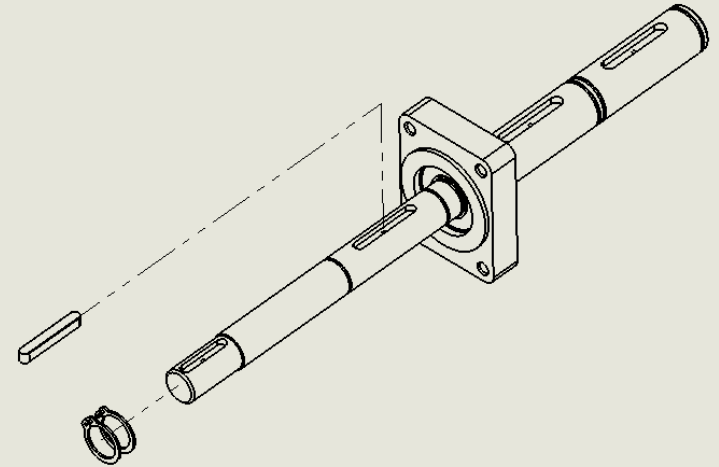
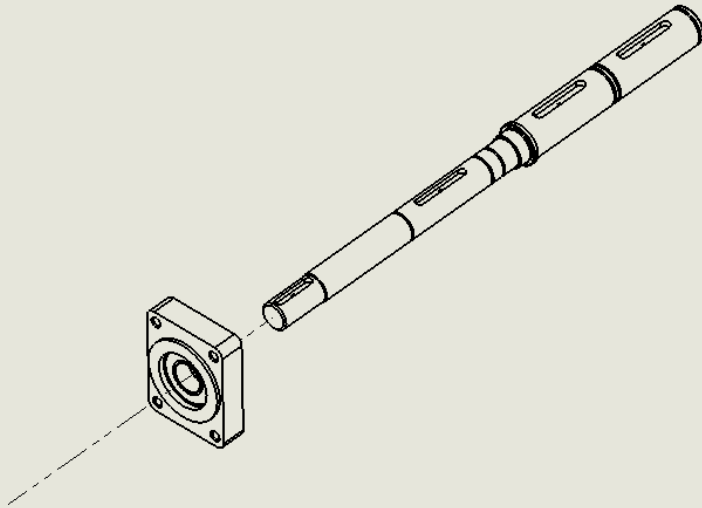
- Assemble as shown.
- Torque set screws to – 55in-lbs
- Use Single Drop of Loctite on set screws

1.15 2-200-2762 Elevator Drive Shaft Subassembly**Qty to Build: 2****Danger: None**

Tools	DESCRIPTION		IMAGE	
	Metric Allen Keys			
	Snap Ring Pliers			
	Loctite			
	Torque Wrench			
BOM for Qty 1	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	90967A210	RETAINING RING, EXTERNAL, STAINLESS STEEL, 17MM	3
	2	92015A126	18-8 Stainless Steel Cup-Point Set Screw, M6 x 1 mm Thread, 6 mm Long	2
	3	2-300-2711	DRIVE, 24 TEETH, 53MM WIDE	1
	4	2-200-2697	BEARING BLOCK SUBASSEMBLY	1
	5	2-300-2714	ELEVATOR DRIVE SHAFT, DRIVE SIDE	1
	6	KESS5-35	Parallel Key (with both ends round), Width 5mm, Length 35 mm	1
Final Assembly				
				
Notes	- Part Used In: 2-200-2760 - Torque set screws to – 55in-lbs - Use Single Drop of Loctite on set screws			

1.15.1 Step 1, 2, 3 & 4 Order of Assembly

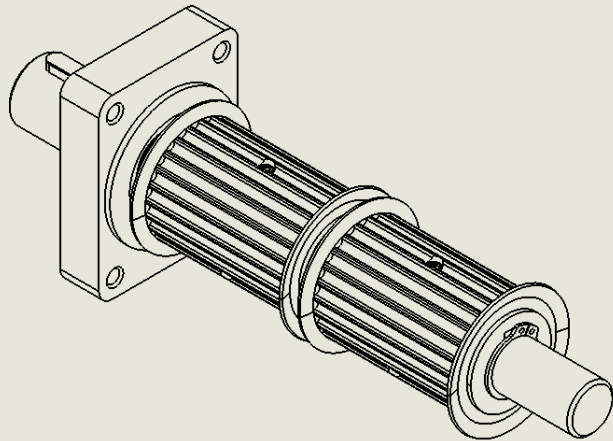
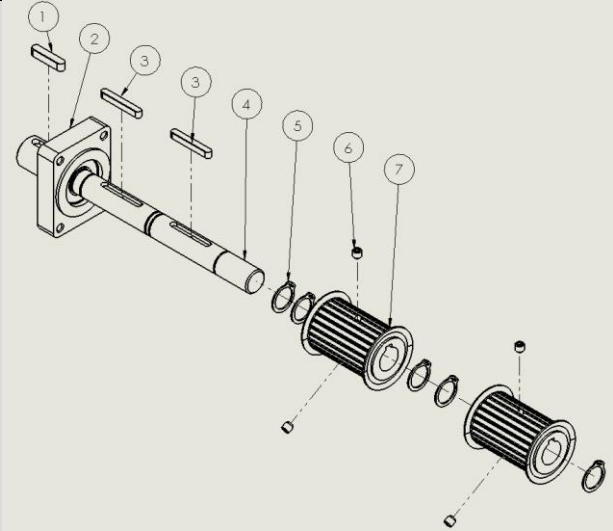
Images



Directions

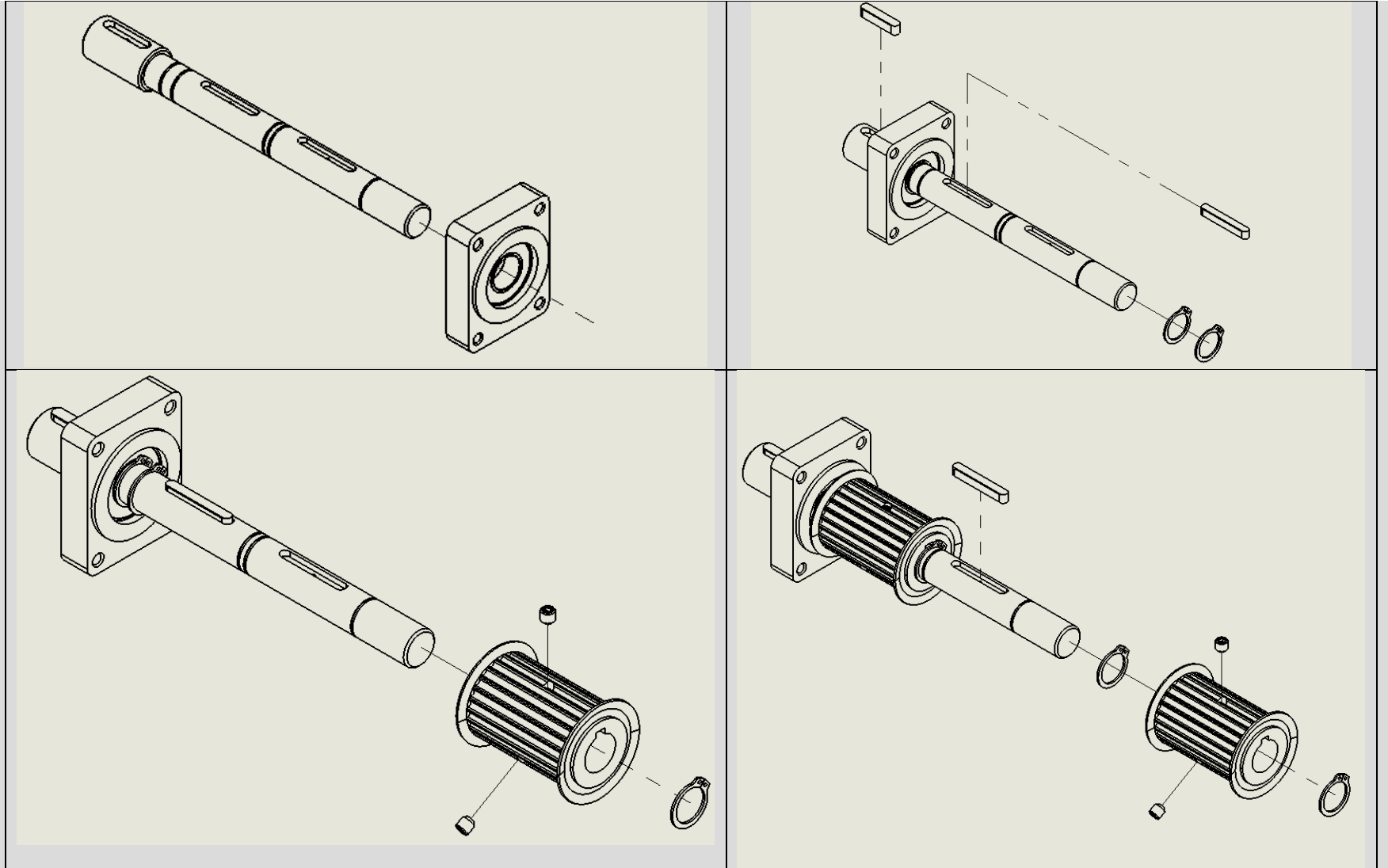
- Assemble as shown.
- Torque set screws to – 55in-lbs
- Use Single Drop of Loctite on set screws

1.16 2-200-2761 Drive Belt Drive Shaft Subassembly**Qty to Build: 1****Danger: None**

Tools	DESCRIPTION		IMAGE	
	Metric Allen Keys			
	Snap Ring Pliers			
	Loctite			
	Torque Wrench			
BOM for Qty 1	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	KESS6-28	Parallel Key (with both ends round), Width 6mm, Length 28 mm	1
	2	2-200-2697	BEARING BLOCK SUBASSEMBLY	1
	3	KESS5-35	Parallel Key (with both ends round), Width 5mm, Length 35 mm	2
	4	2-300-2712	DRIVE SHAFT, MOTOR	1
	5	90967A210	RETAINING RING, EXTERNAL, STAINLESS STEEL, 17MM	5
	6	92015A126	18-8 Stainless Steel Cup-Point Set Screw, M6 x 1 mm Thread, 6 mm Long	4
	7	2-300-2711	DRIVE, 24 TEETH, 53MM WIDE	2
Final Assembly				
Notes	• Part Used In: 2-200-2757 • Torque set screws to – 55in-lbs • Use Single Drop of Loctite on set screws			

1.16.1 Step 1, 2,3 & 4 Order of Assembly

Images

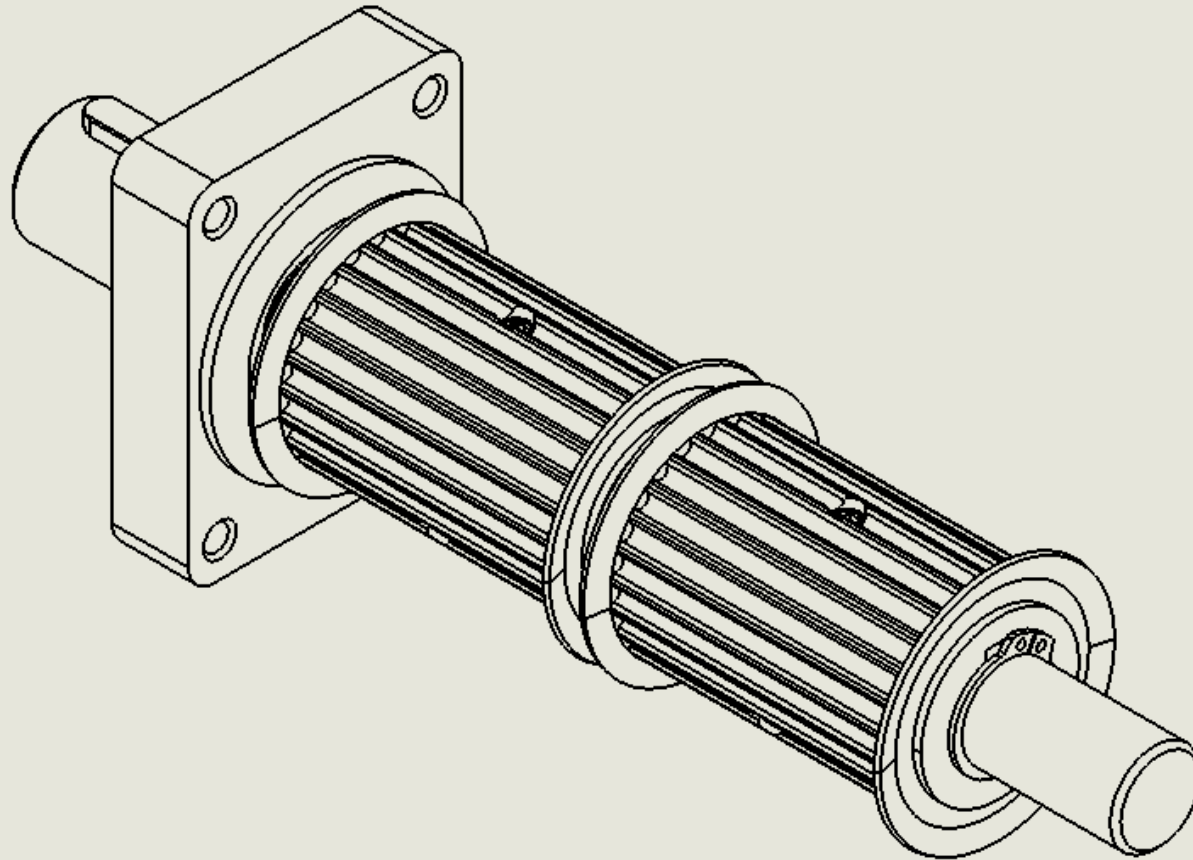


Directions

- Assemble as shown.
- Torque set screws to – 55in-lbs
- Use Single Drop of Loctite on set screws

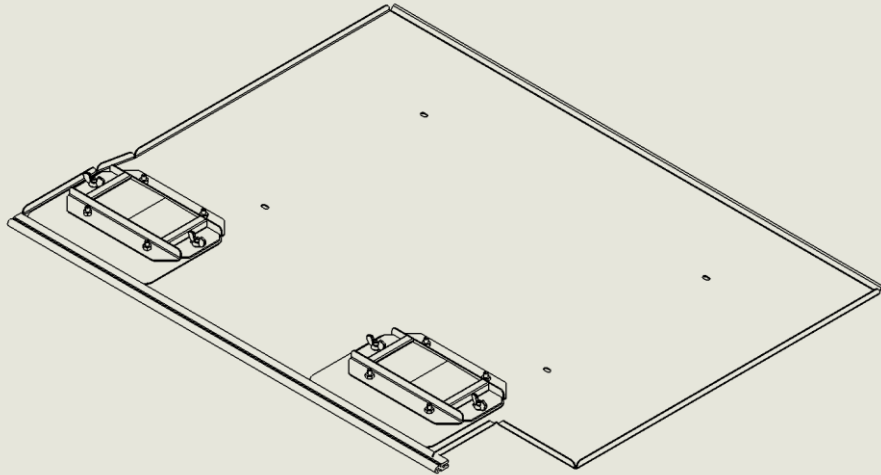
1.16.2 Final View of Assembly

Images

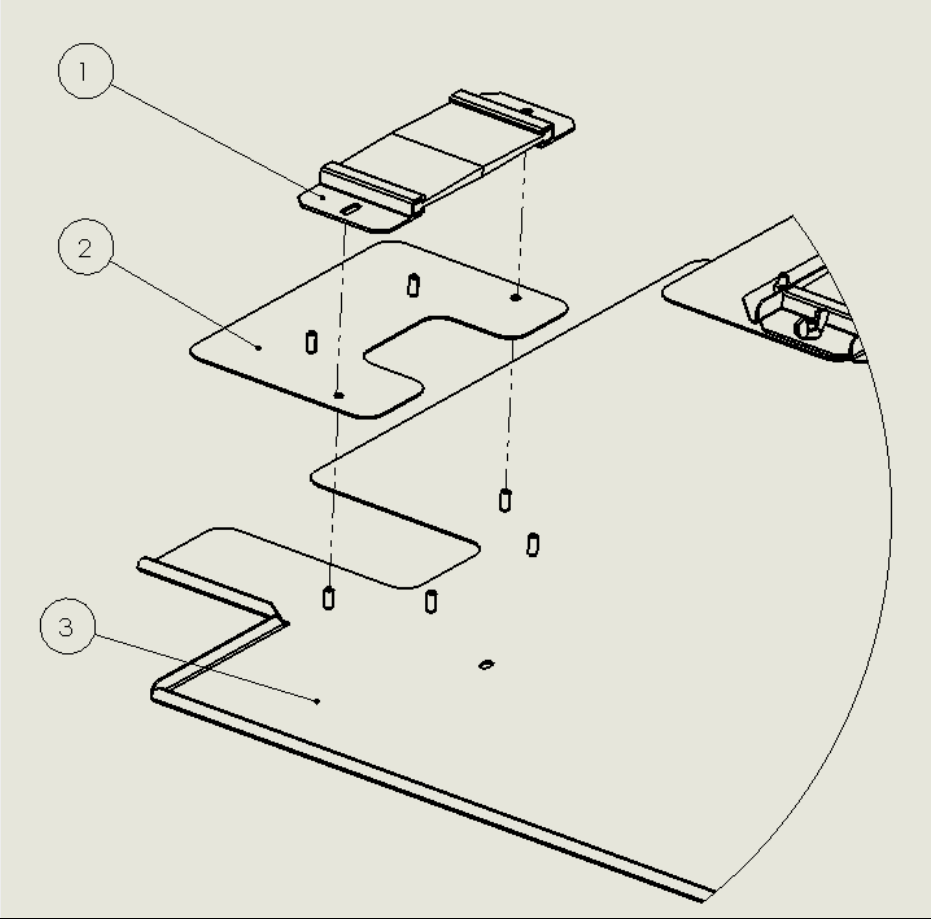


Directions

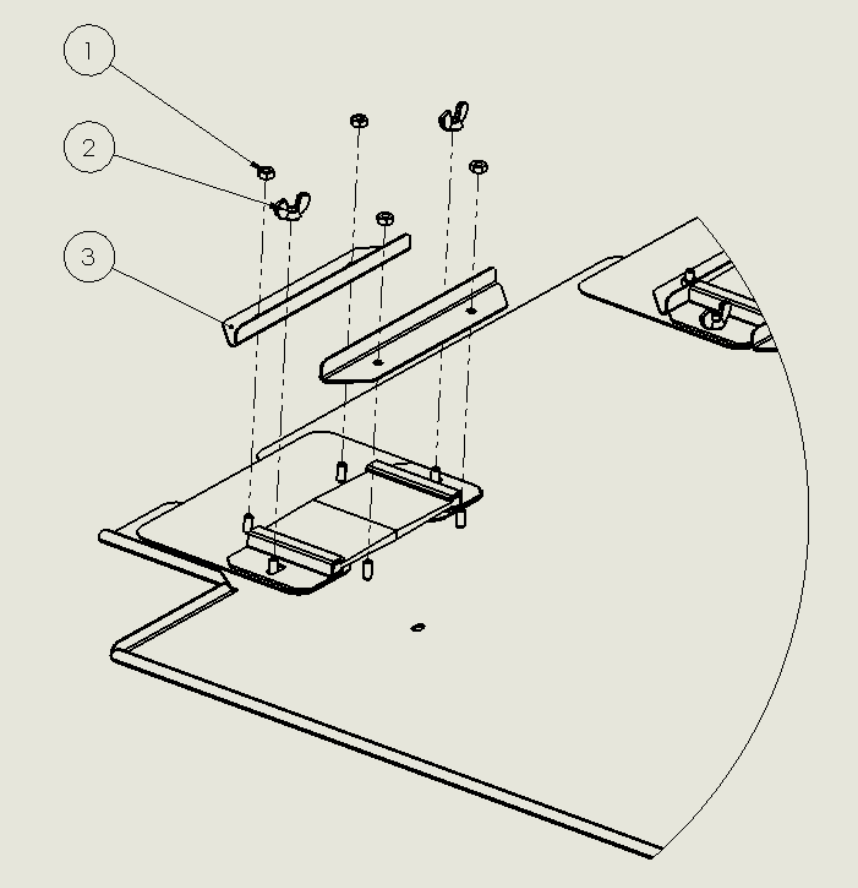
- Assemble as shown.

1.17 2-200-2765 Right Cover Subassembly				Qty to Build: 1	Danger: None
Tools	DESCRIPTION			IMAGE	
	Wrench Set				
BOM for Qty 1	ITEM NO.	PART NUMBER	DESCRIPTION		QTY.
	1	94545A220	18-8 Stainless Steel Wing Nut, M4 x 0.7 mm Thread		4
	2	91828A231	18-8 STAINLESS STEEL HEX NUT - M4		8
	3	2-300-2745	ELEVATOR BELT WINDOW GUARD		4
	4	2-300-2746	ELEVATOR BELT WINDOW GUARD BACKSIDE		2
	5	1120A7	Water- and Weather-Resistant Rubber Push-on Seal with Bulb on Top, Hollow – Not Installed at Kunshan Currently		1
	6	2-300-2729	RIGHT COVER		1
	7	2-200-2862	Belt Brush Assembly – Not Installed at Kunshan Currently		4
Final Assembly					
Notes	- Heavy, wear steel toe shoes. - Part Used In:				

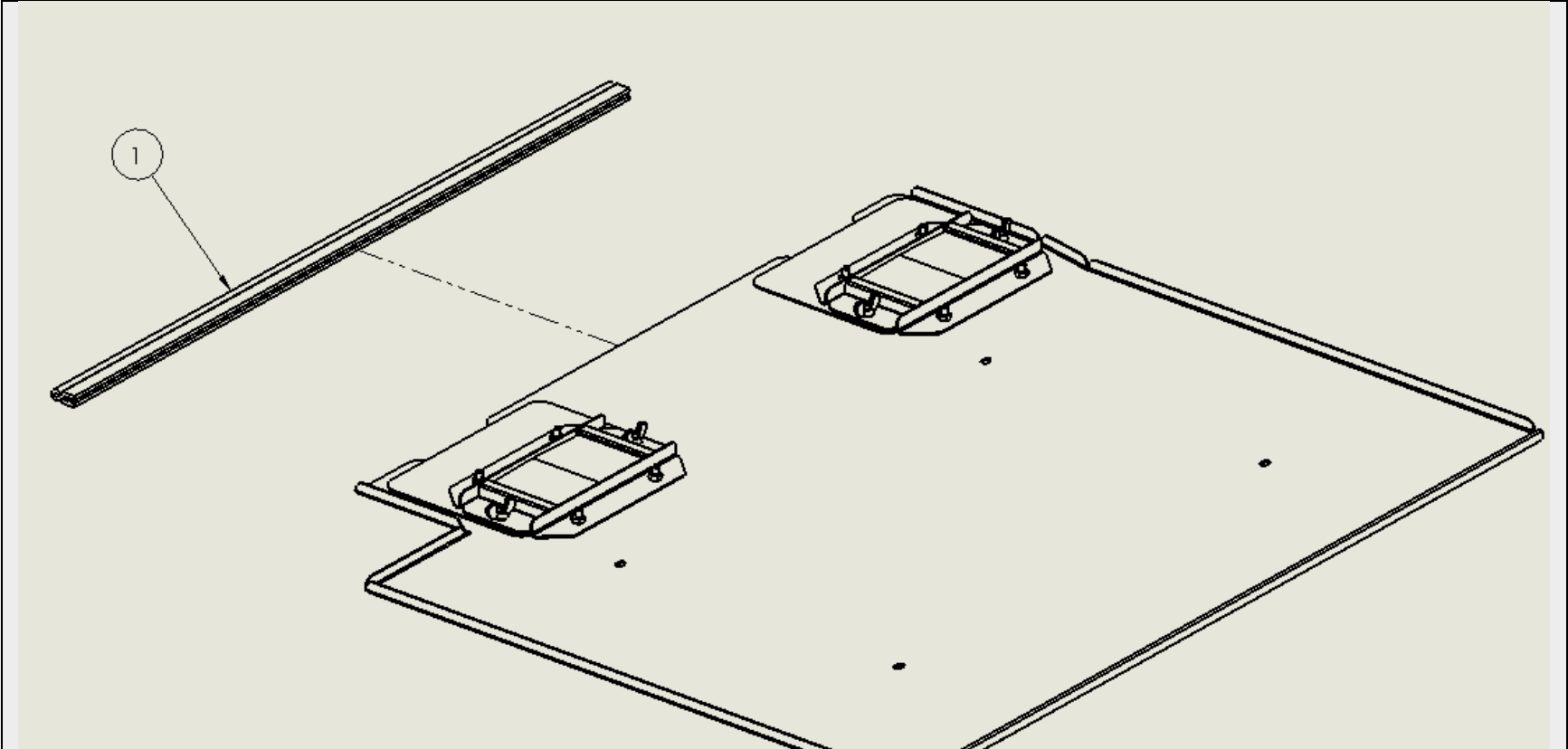
1.17.1 Step 1 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-200-2862	Belt Brush Assembly– Not Installed at Kunshan Currently	4
	2	2-300-2746	ELEVATOR BELT WINDOW GUARD BACKSIDE	2
	3	2-300-2729	RIGHT COVER	1
Images				
Directions	- Assemble as shown. - Repeat to both sides			

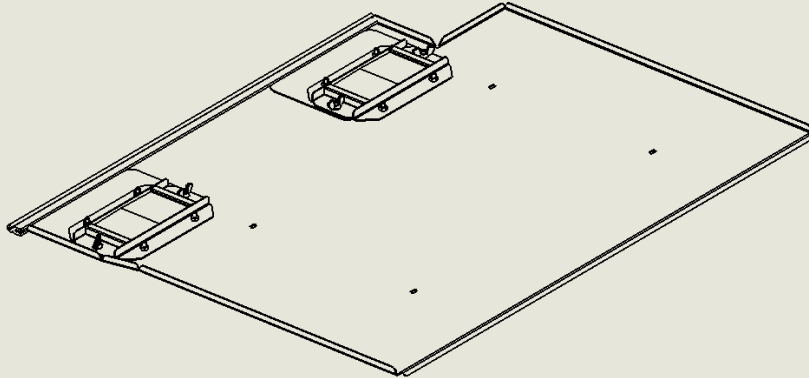
1.17.2 Step 2 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	91828A231	18-8 STAINLESS STEEL HEX NUT - M4	8
	2	94545A220	18-8 Stainless Steel Wing Nut, M4 x 0.7 mm Thread	4
	3	2-300-2745	ELEVATOR BELT WINDOW GUARD	4
Images				
Directions	• Assemble as shown. • Repeat to both sides			

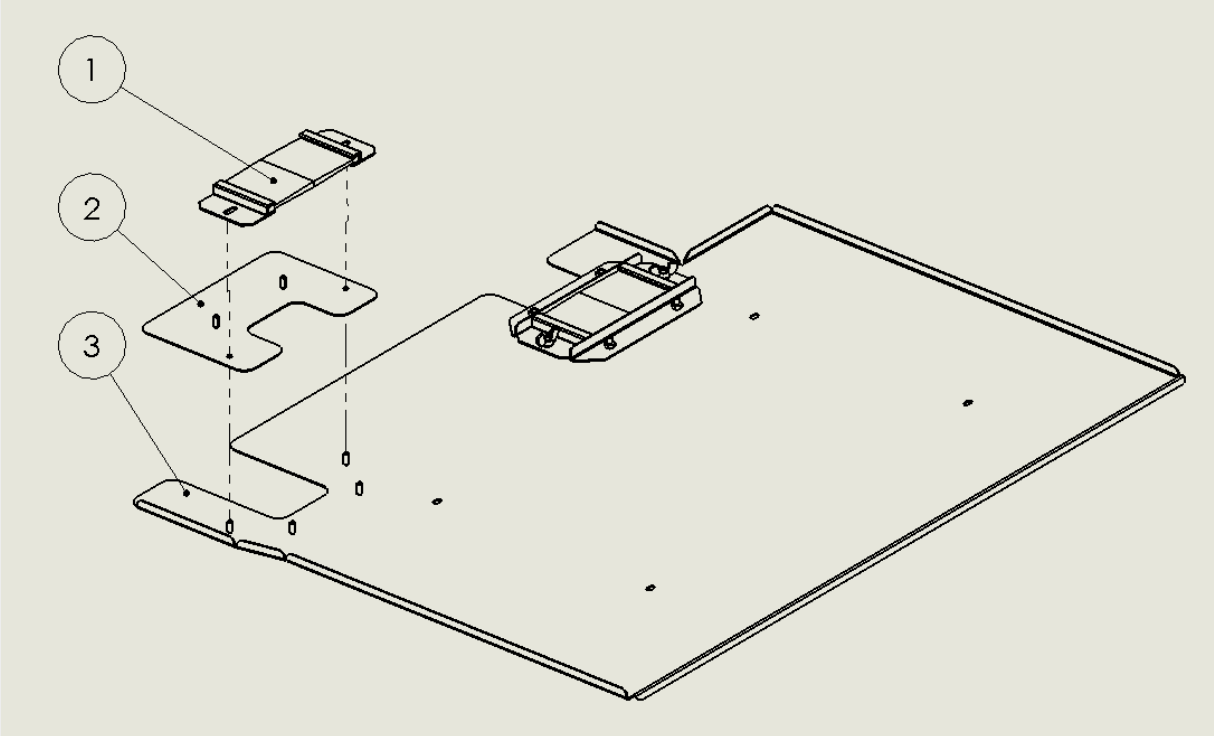
1.17.3 Step 3 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	1120A7	Water- and Weather-Resistant Rubber Push-on Seal with Bulb on Top, Hollow – Not Installed at Kunshan Currently	1
Images				
Directions				

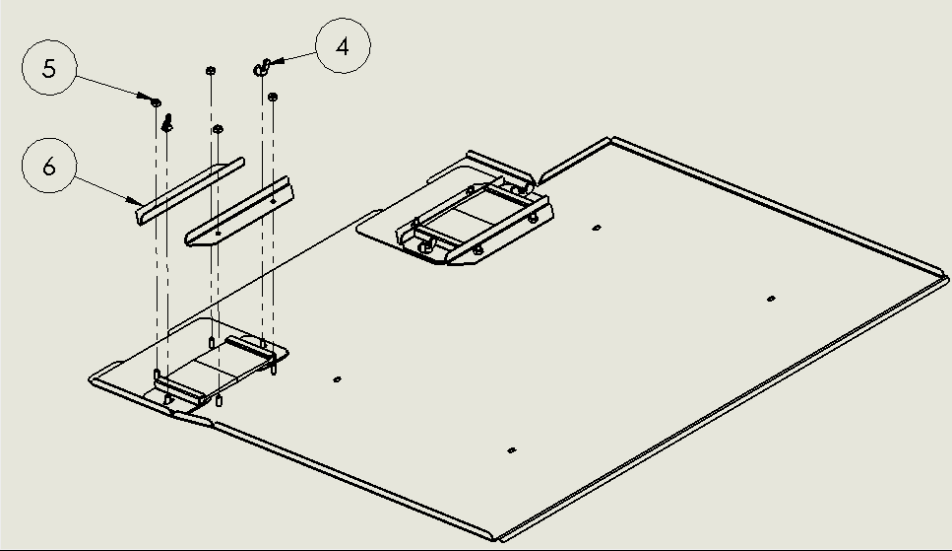
- Assemble as shown.

1.18 2-200-2766 LEFT COVER SUBASSEMBLY			Qty to Build: 1	Danger: None
Tools	DESCRIPTION		IMAGE	
	Wrench Set			
BOM for Qty 1	PART NUMBER	DESCRIPTION	QTY.	
	2-200-2862	Belt Brush Assembly – Not Installed at Kunshan Currently	4	
	2-300-2746	ELEVATOR BELT WINDOW GUARD BACKSIDE	2	
	2-300-2731	LEFT COVER	1	
	94545A220	18-8 Stainless Steel Wing Nut, M4 x 0.7 mm Thread	4	
	91828A231	18-8 STAINLESS STEEL HEX NUT - M4	8	
	2-300-2745	ELEVATOR BELT WINDOW GUARD	4	
	1120A7	Water- and Weather-Resistant Rubber Push-on Seal with Bulb on Top, Hollow – Not Installed at Kunshan Currently	1	
Final Assembly				
Notes	- Heavy, wear steel toe shoes. - Part Used In:			

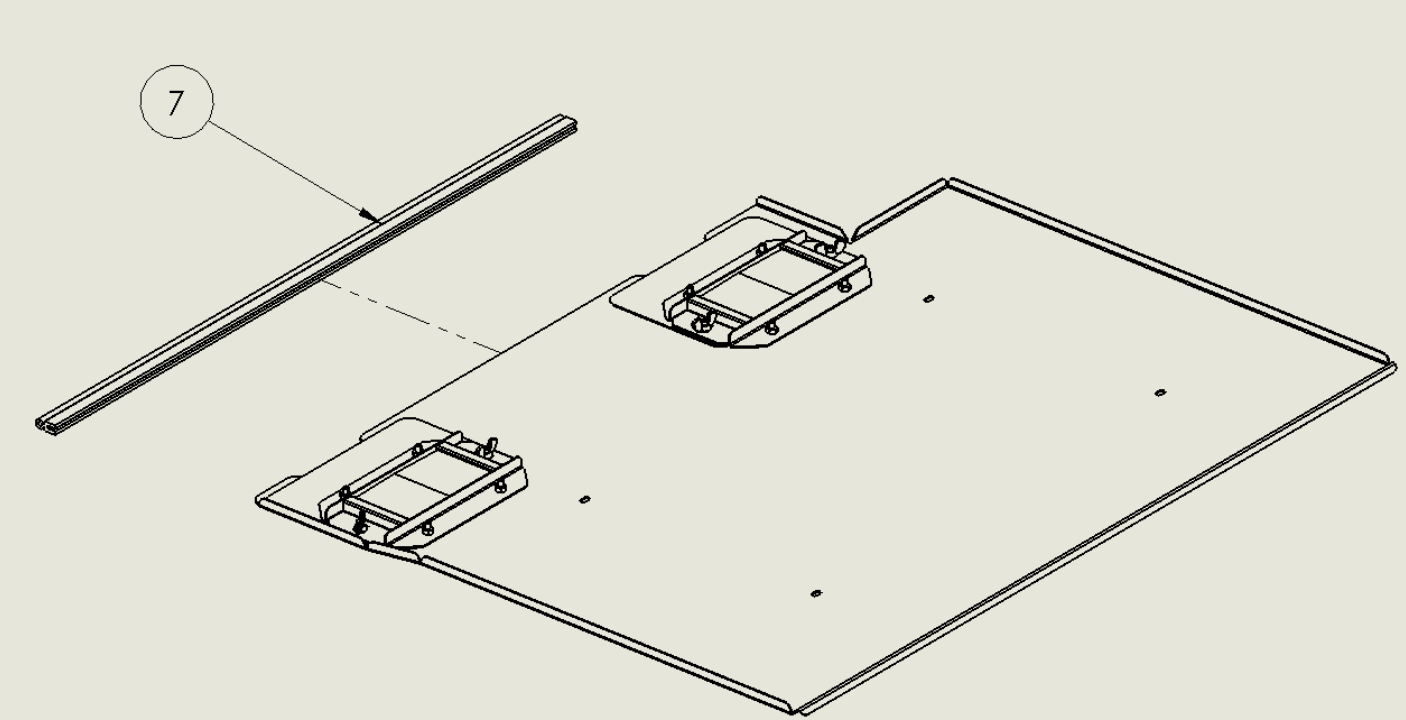
1.18.1 Step 1 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-200-2862	Belt Brush Assembly– Not Installed at Kunshan Currently	4
	2	2-300-2746	ELEVATOR BELT WINDOW GUARD BACKSIDE	2
	3	2-300-2731	LEFT COVER	1
Images				
Directions	• Assemble as shown. • Repeat to both sides			

1.18.2 Step 2 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	4	94545A220	18-8 Stainless Steel Wing Nut, M4 x 0.7 mm Thread	4
	5	91828A231	18-8 STAINLESS STEEL HEX NUT - M4	8
	6	2-300-2745	ELEVATOR BELT WINDOW GUARD	4
Images				
Directions	• Assemble as shown. • Repeat to both sides			

1.18.3 Step 3 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	7	1120A7	Water- and Weather-Resistant Rubber Push-on Seal with Bulb on Top, Hollow – Not Installed at Kunshan Currently	1
Images				
Directions	Assemble as shown.			

2 Wall Subassemblies

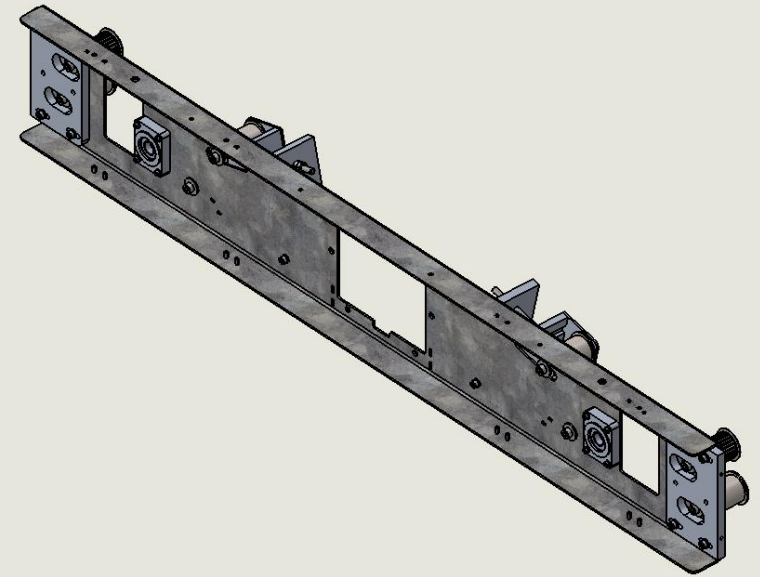
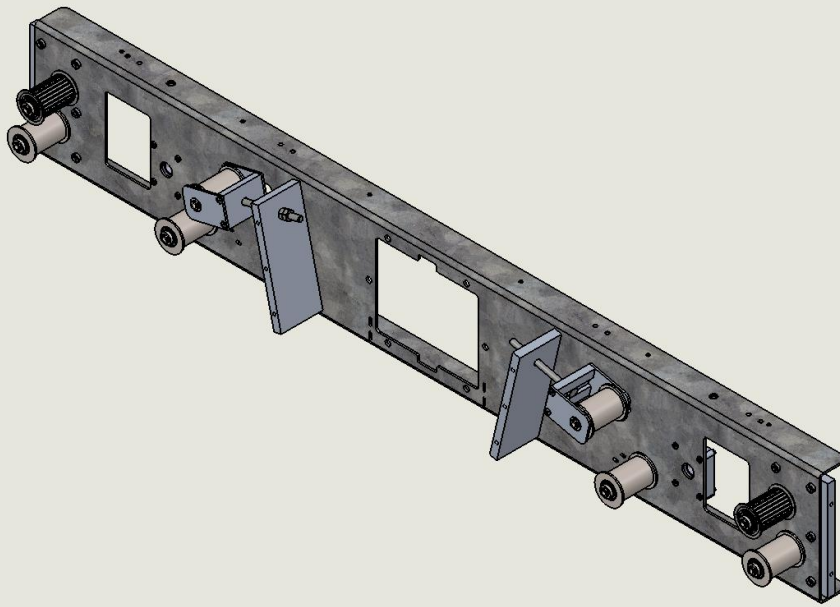
Overview



Description

- All Subassemblies

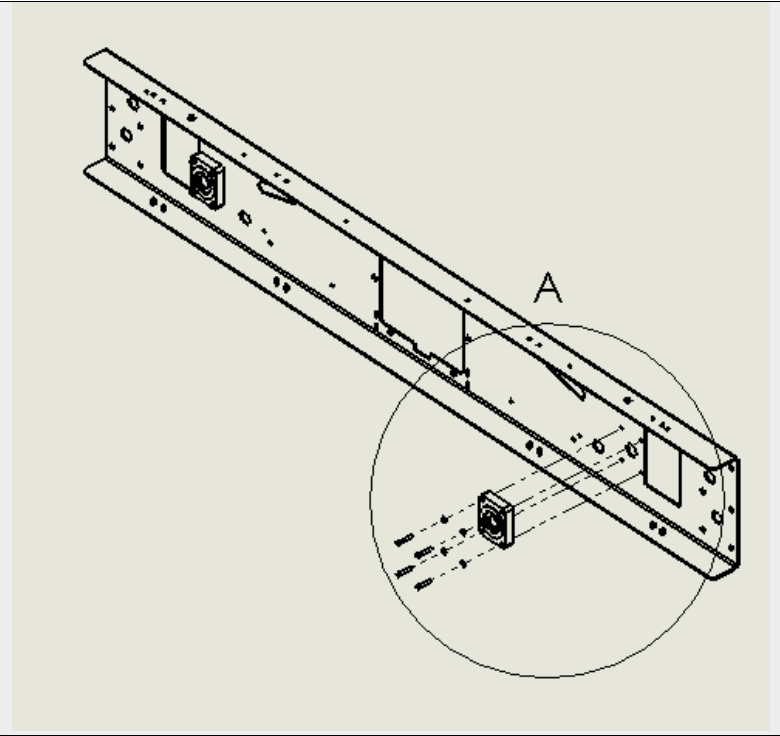
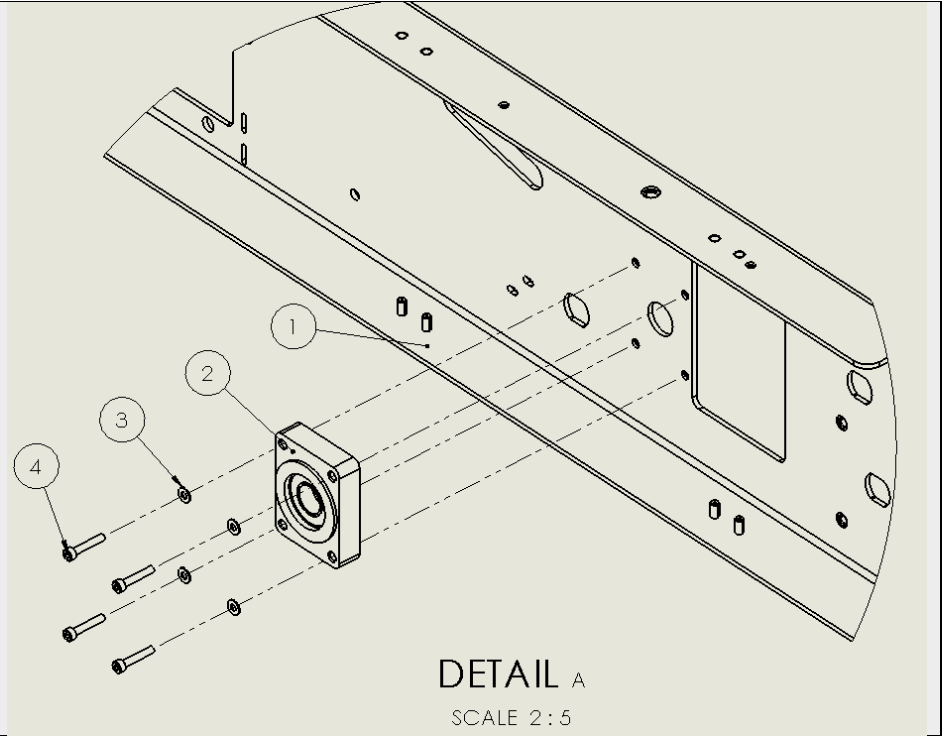
2.1 2-200-2754 Motor Wall Subassembly			Qty to Build: 2	Danger: None
Tools	DESCRIPTION		IMAGE	
	Metric Allen Keys			
	Drill and bits			
	Wrench Set			
	Loctite			
	Torque Wrench			
BOM for Qty 1	PART NUMBER	DESCRIPTION	QTY.	
	2-200-2691	ELEVATOR BELT TENSIONER SUBASSEMBLY	2	
	2-200-2697	BEARING BLOCK SUBASSEMBLY	2	
	2-200-2752	IDLER ON SHAFT, Teeth	2	
	2-200-2753	IDLER ON SHAFT, FLAT	4	
	2-300-2702	MOTOR C BRACKET	1	
	2-300-2705	TENSION FIXED BRACKET	2	
	2-300-2725	END WALL CONNECTING PLATE	2	
	91100A160	Zinc-Plated Steel Oversized Washer for M8 Screw Size, 8.4 mm ID, 24 mm OD	8	
	91292A145	18-8 Stainless Steel Socket Head Screw, M8 x 1.25 mm Thread, 16 mm Long	8	
	91828A410	18-8 Stainless Steel Hex Nut, M8 x 1.25 mm Thread	4	
	91292A806	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 22mm	8	
	91292A070	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 14mm	4	
	91292A073	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 22mm	8	
	93475A250	18-8 Stainless Steel Washer for M6 Screw Size, 6.4 mm ID, 12 mm OD	12	
	93475A230	18-8 Stainless Steel Washer for M4 Screw Size, 4.3 mm ID, 9 mm OD	8	

Final
Assembly

Notes

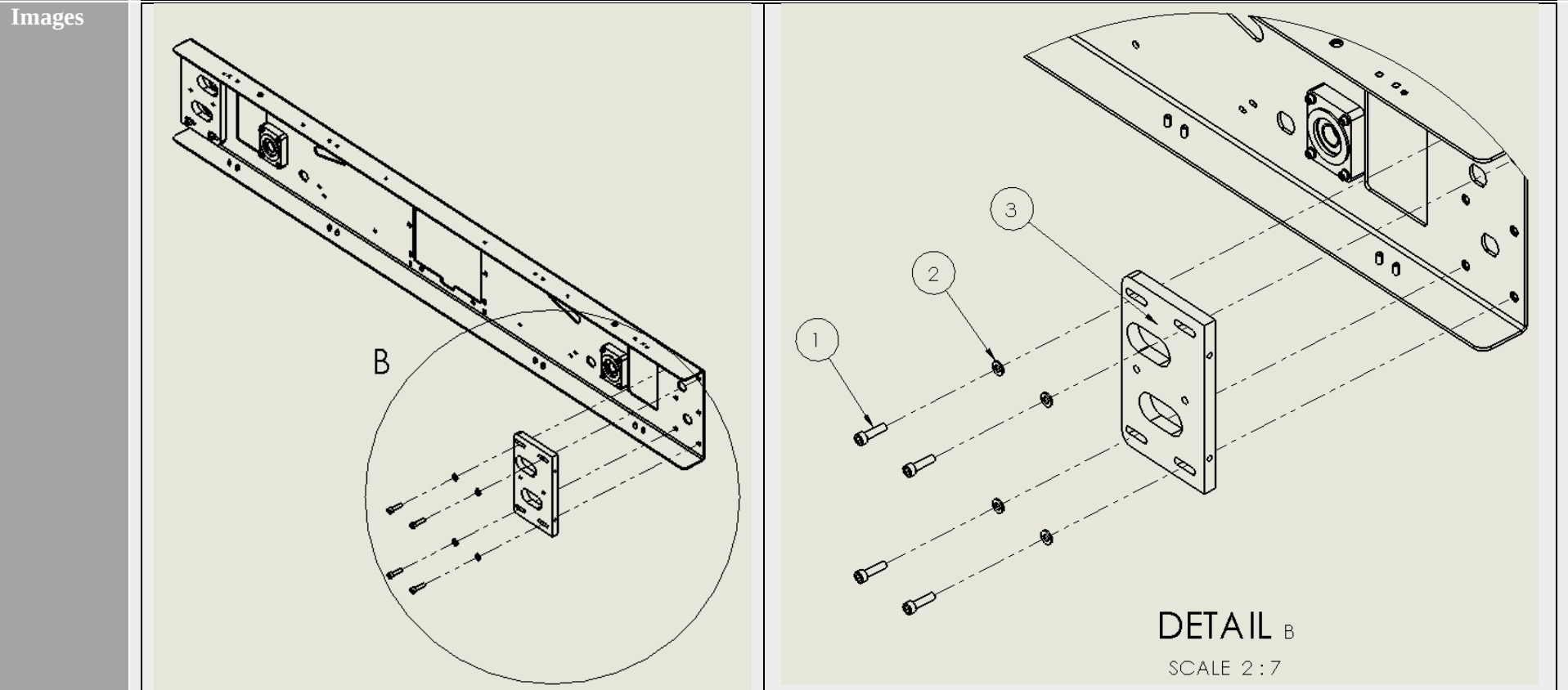
- Heavy, wear steel toe shoes.
- Part Used In: [2-200-2759](#), [2-200-2763](#)

2.1.1 Step 1 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-300-2702	MOTOR C BRACKET	1
	2	2-200-2697	BEARING BLOCK SUBASSEMBLY	2
	3	93475A230	18-8 Stainless Steel Washer for M4 Screw Size, 4.3 mm ID, 9 mm OD	8
	4	91292A806	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 22mm	8
Images				
				
Directions	• Assemble as shown. • Boss on the bearing block subassembly faces outwards. • Use Single Drop of Loctite on Items 4 • Repeat to both sides			

2.1.2 Step 2 Order of Assembly

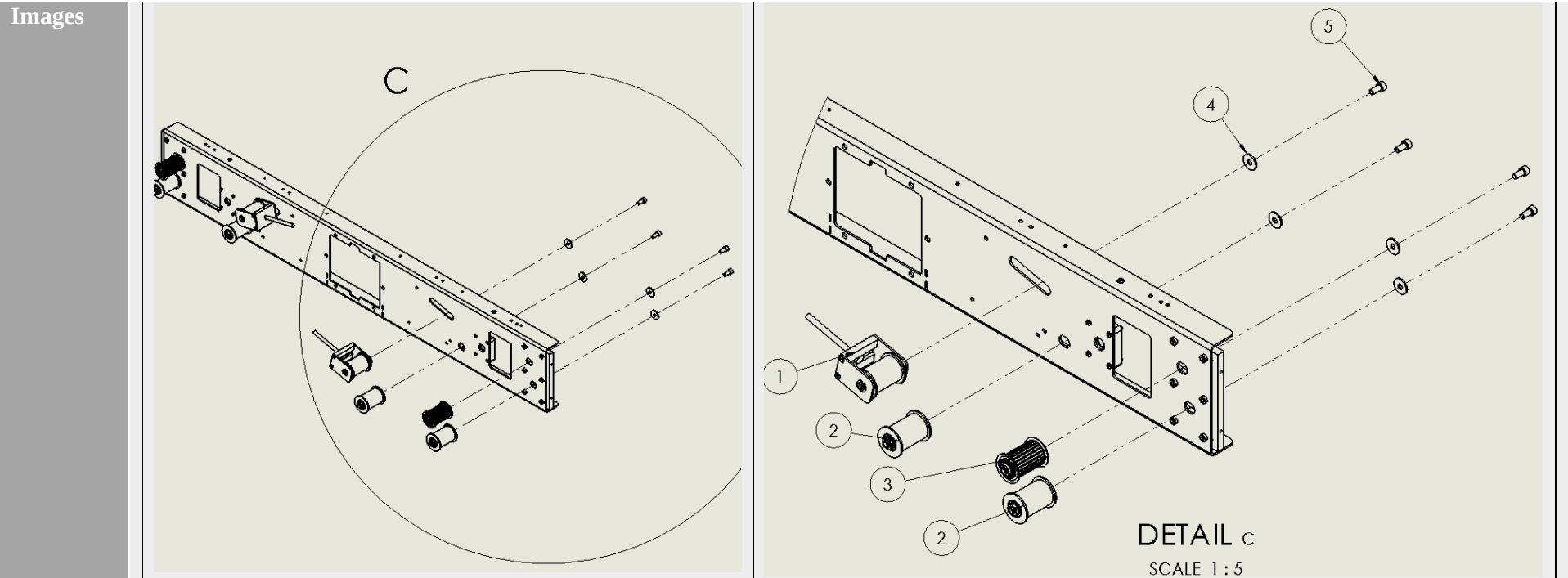
BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	91292A073	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 22mm	8
	2	93475A250	18-8 Stainless Steel Washer for M6 Screw Size, 6.4 mm ID, 12 mm OD	8
	3	2-300-2725	END WALL CONNECTING PLATE	2

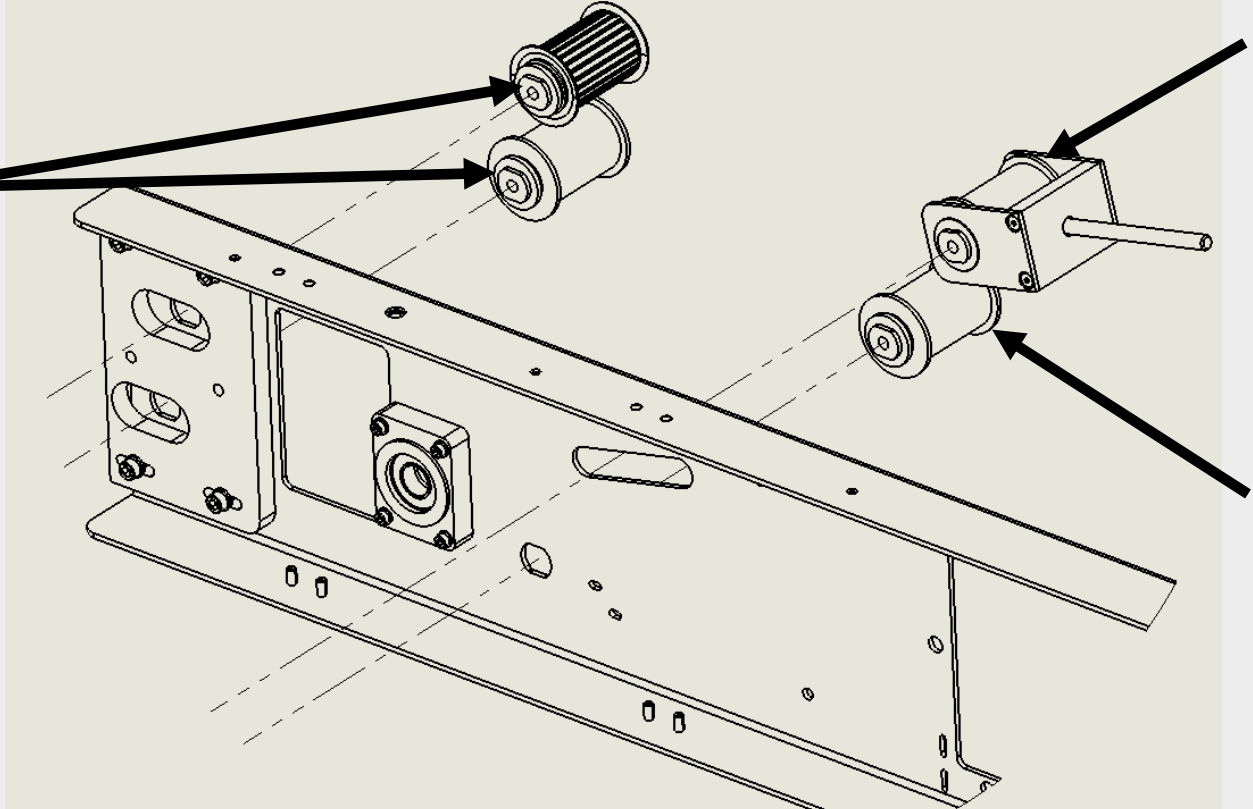


Directions	• Assemble as shown. • Plates should be installed loosely; they need to be adjusted in a higher-level assembly. • Repeat to both sides
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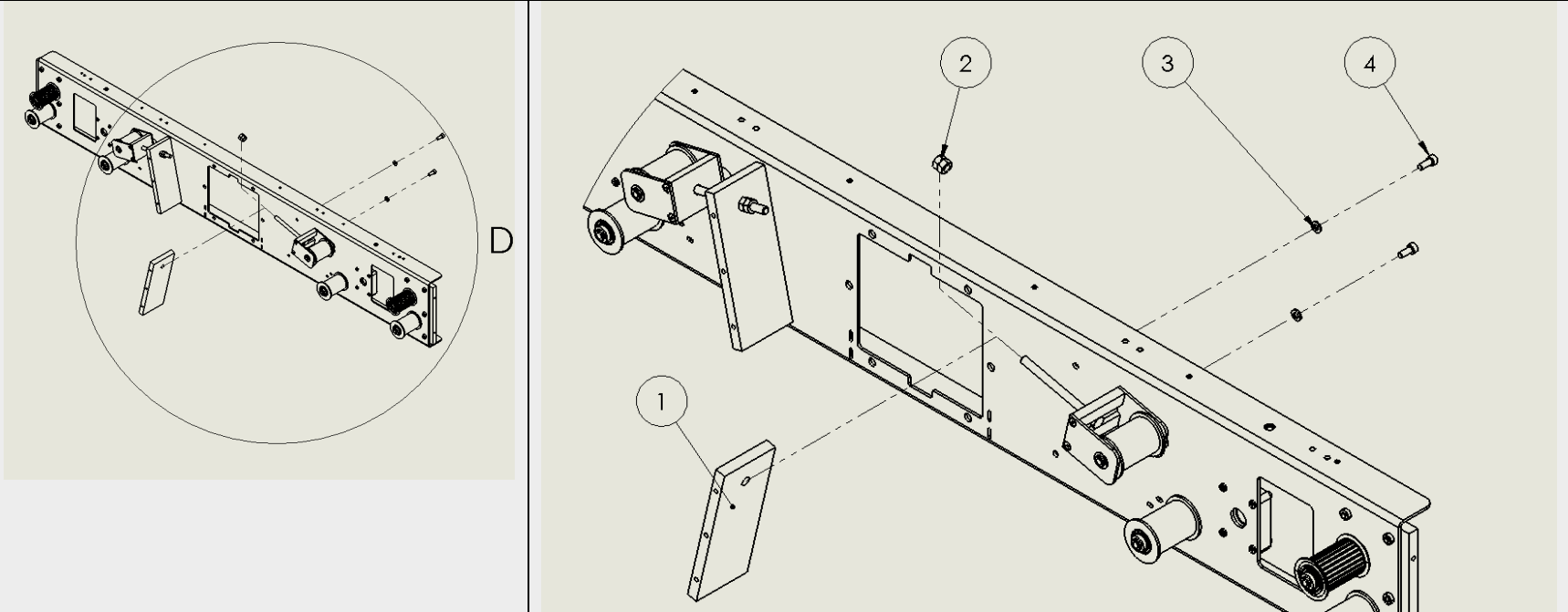
2.1.3 Step 3 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-200-2691	ELEVATOR BELT TENSIONER SUBASSEMBLY	2
	2	2-200-2753	IDLER ON SHAFT, FLAT	4
	3	2-200-2752	IDLER ON SHAFT, TEETH	2
	4	91100A160	Zinc-Plated Steel Oversized Washer for M8 Screw Size, 8.4 mm ID, 24 mm OD	8
	5	91292A145	18-8 Stainless Steel Socket Head Screw, M8 x 1.25 mm Thread, 16 mm Long	8



	 Orientation of Pulleys Torque to 169in-lbs Orientation of Pulleys Torque to 10in-lbs. Will be torqued at location. Orientation of Pulleys Torque to 169in-lbs
Directions	• Assemble as shown. • Repeat to both sides • Torque Requirement when screwing into these shafts – 169in-lbs • Use Single Drop of Loctite to Items 5

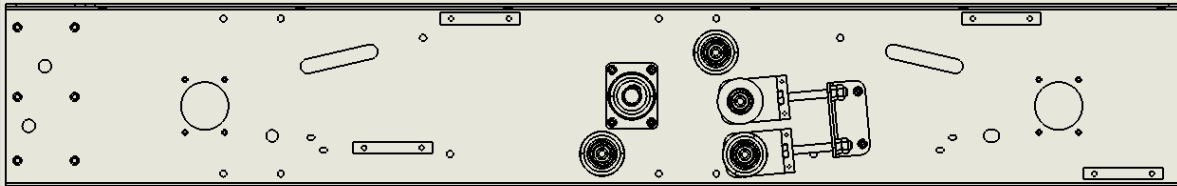
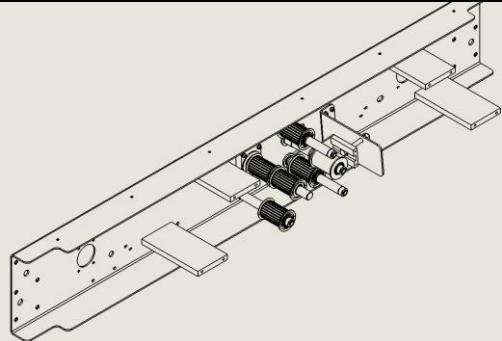
2.1.4 Step 4 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-300-2705	TENSION FIXED BRACKET	2
	2	91828A410	18-8 Stainless Steel Hex Nut, M8 x 1.25 mm Thread	4
	3	93475A250	18-8 Stainless Steel Washer for M6 Screw Size, 6.4 mm ID, 12 mm OD	12
	4	91292A070	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 14mm	4
Images				
	Directions • Assemble as shown. • Use Single Drop of Loctite to Items 4 • Repeat to both sides			

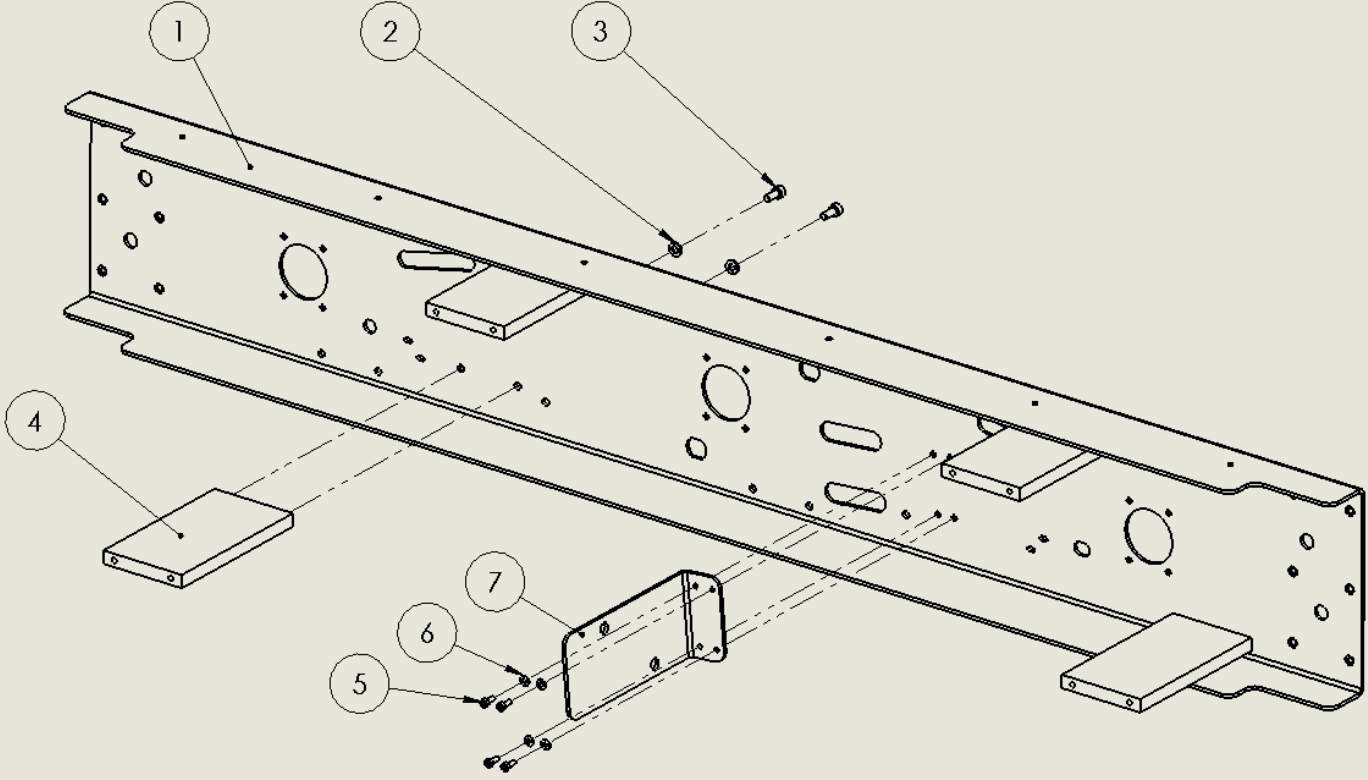
2.2 2-200-2757 Drive Wall Subassembly

Qty to Build: 1

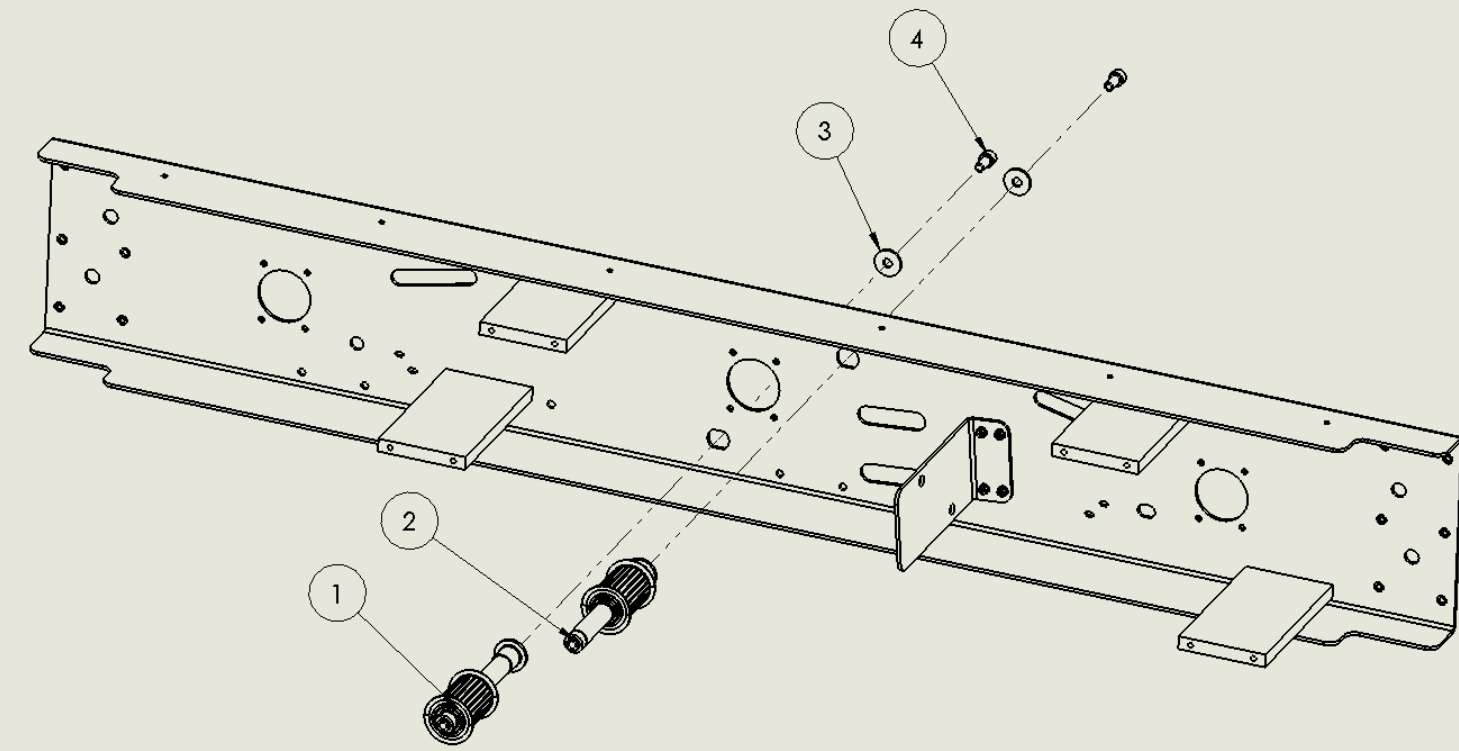
Danger: None

Tools	DESCRIPTION		IMAGE	
	Metric Allen Keys			
	Drill and bits			
BOM for Qty 1	PART NUMBER	DESCRIPTION	QTY.	
	2-200-2717	DRIVE BELT TENSIONER SUBASSEMBLY	1	
	2-200-2758	IDLER ON SHAFT, LONG, 24 TEETH, OUTSIDE	1	
	2-200-2761	DRIVE BELT DRIVE SHAFT SUBASSEMBLY	1	
	2-200-2769	IDLER ON SHAFT, LONG, 24 TEETH, OUTSIDE	1	
	2-200-2770	DRIVE BELT TENSIONER SUBASSEMBLY, SMOOTH IDLER	1	
	2-300-2703	DRIVE SIDE LARGE C BRACKET	1	
	2-300-2713	DRIVE SIDE TENSIONER, FIXED BRACKET	1	
	2-300-2715	OFFSET BLOCK, DRIVE SIDE	4	
	91100A160	Zinc-Plated Steel Oversized Washer for M8 Screw Size, 8.4 mm ID, 24 mm OD	4	
	91292A145	18-8 Stainless Steel Socket Head Screw, M8 x 1.25 mm Thread, 16 mm Long	4	
	91828A410	18-8 Stainless Steel Hex Nut, M8 x 1.25 mm Thread	4	
	91292A116	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 10mm	4	
	91292A806	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 22mm	4	
	91292A070	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 14mm	8	
	93475A250	18-8 Stainless Steel Washer for M6 Screw Size, 6.4 mm ID, 12 mm OD	8	
	93475A230	18-8 Stainless Steel Washer for M4 Screw Size, 4.3 mm ID, 9 mm OD	8	
Final Assembly				
Notes	• Heavy, wear steel toe shoes. • Part Used In: 2-200-2760			

2.2.1 Step 1 Order of Assembly

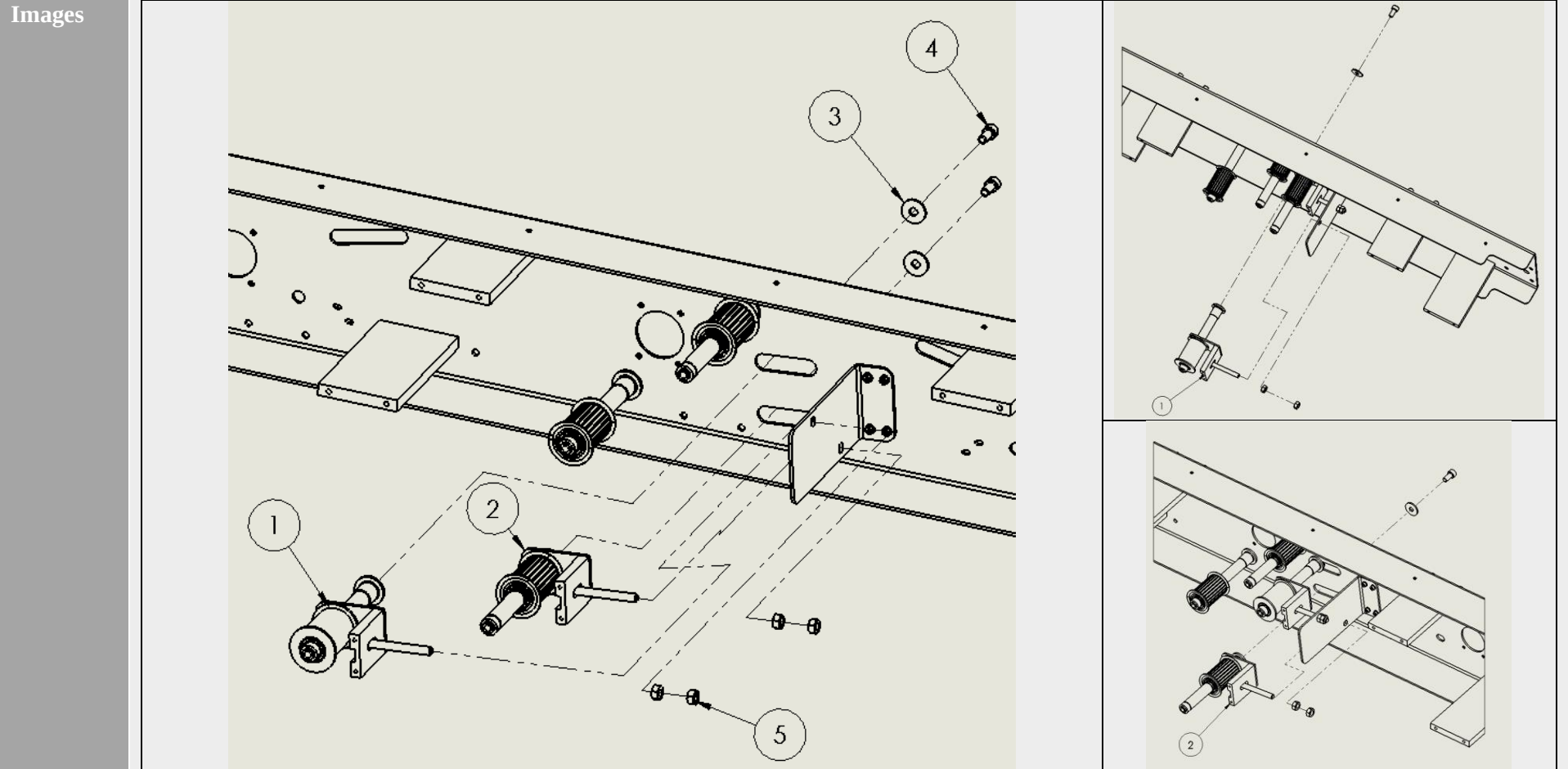
BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-300-2703	DRIVE SIDE LARGE C BRACKET	1
	2	93475A250	18-8 Stainless Steel Washer for M6 Screw Size, 6.4 mm ID, 12 mm OD	8
	3	91292A070	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 14mm	8
	4	2-300-2715	OFFSET BLOCK, DRIVE SIDE	4
	5	91292A116	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 10mm	4
	6	93475A230	18-8 Stainless Steel Washer for M4 Screw Size, 4.3 mm ID, 9 mm OD	4
	7	2-300-2713	DRIVE SIDE TENSIONER, FIXED BRACKET	1
Images				
Directions	• Assemble as shown. • Install all 4 of 2-300-2715 • Use Single Drop of Loctite to Items 3 and 5 • It is acceptable to install items 5, 6, and 7 after step 3 of this Subassembly if it makes assembly easier.			

2.2.2 Step 2 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-200-2769	IDLER ON SHAFT, LONG, 24 TEETH, OUTSIDE	1
	2	2-200-2758	IDLER ON SHAFT, LONG, 24 TEETH, INSIDE	1
	3	91100A160	Zinc-Plated Steel Oversized Washer for M8 Screw Size, 8.4 mm ID, 24 mm OD	2
	4	91292A145	18-8 Stainless Steel Socket Head Screw, M8 x 1.25 mm Thread, 16 mm Long	2
Images				
Directions	• Assemble as shown. • Torque Requirement when screwing into these shafts – 169in-lbs • Use Single Drop of Loctite to Items 4			

2.2.3 Step 3 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-200-2770	DRIVE BELT TENSIONER SUBASSEMBLY, SMOOTH IDLER	1
	2	2-200-2717	DRIVE BELT TENSIONER SUBASSEMBLY	1
	3	91100A160	Zinc-Plated Steel Oversized Washer for M8 Screw Size, 8.4 mm ID, 24 mm OD	4
	4	91292A145	18-8 Stainless Steel Socket Head Screw, M8 x 1.25 mm Thread, 16 mm Long	4
	5	91828A410	18-8 Stainless Steel Hex Nut, M8 x 1.25 mm Thread	4

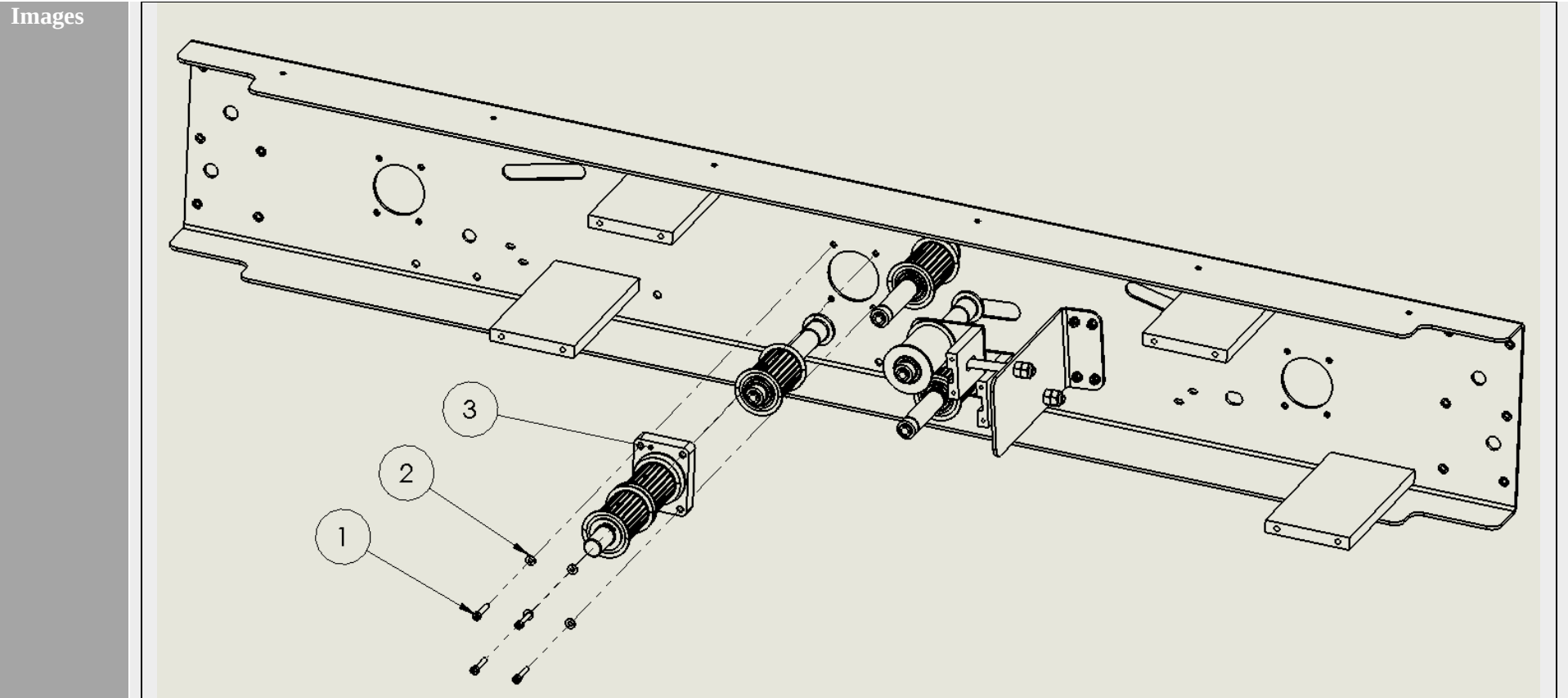


Directions

- Assemble as shown.
- Torque fingertight on item 4 and 5. These will be torqued at a later step

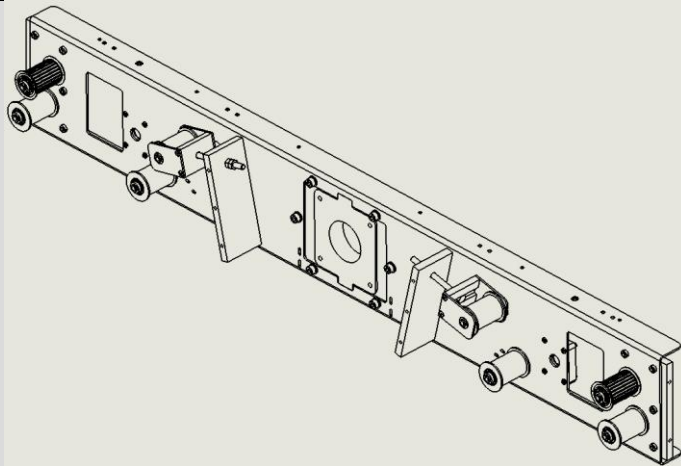
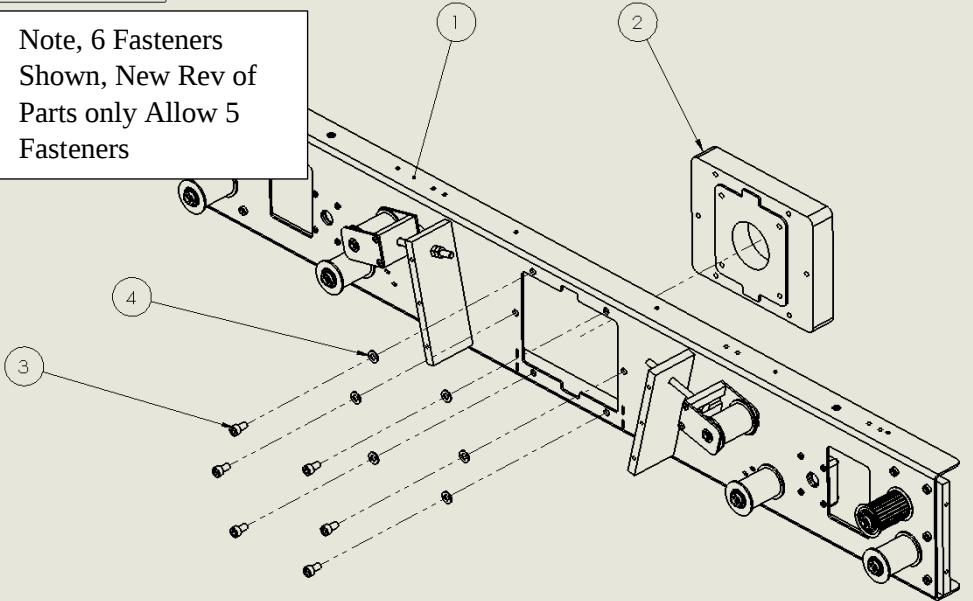
2.2.4 Step 4 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	91292A806	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 22mm	4
	2	93475A230	18-8 Stainless Steel Washer for M4 Screw Size, 4.3 mm ID, 9 mm OD	8
	3	2-200-2761	DRIVE BELT DRIVE SHAFT SUBASSEMBLY	1



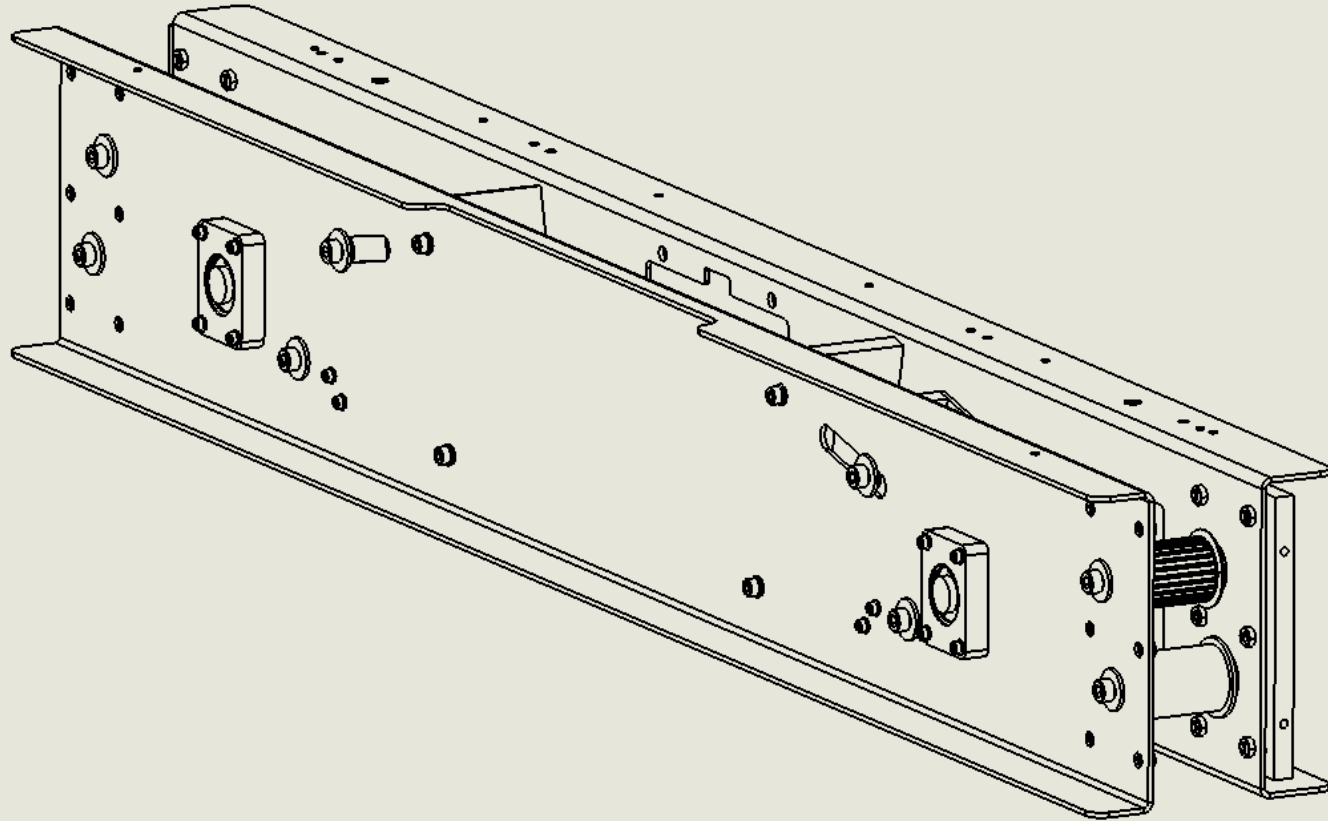
Directions	- Assemble as shown. - Use Single Drop of Loctite to Items 1
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2.3 2-200-2759 Motor Wall Subassembly**Qty to Build: 1****Danger: None**

Tools	DESCRIPTION		IMAGE	
	Metric Allen Keys			
	Loctite			
BOM for Qty 1	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-200-2754	MOTOR WALL SUBASSEMBLY	1
	2	2-300-2706	MOTOR MACHINED PLATE	1
	3	91292A150	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M8 X 1.25mm, 14mm	5
	4	93475A270	18-8 Stainless Steel Washer for M8 Screw Size, 8.4 mm ID, 16 mm OD	5
Explode/s			Note, 6 Fasteners Shown, New Rev of Parts only Allow 5 Fasteners 	
Notes	• Heavy, wear steel toe shoes. • Part Used In: 2-200-2760			
Steps	1. Assemble as shown 2. Use Single Drop of Loctite to Items 3			

2.4 2-200-2763 Driven Side Subassembly			Qty to Build: 1	Danger: None
Tools	DESCRIPTION		IMAGE	
	Metric Allen Keys			
	Drill and bits			
	Torque Wrench			
	Loctite			
BOM for Qty 1	PART NUMBER	DESCRIPTION	QTY.	
	2-200-2754	MOTOR WALL SUBASSEMBLY	1	
	2-200-2764	ELEVATOR DRIVE SHAFT SUBASSEMBLY, DRIVEN SIDE	2	
	2-300-2704	BELT FEED ASSIST	2	
	2-300-2744	MOTOR BACK BRACE	1	
	2-300-2772	FULL WALL, DRIVEN SIDE	1	
	91100A160	Zinc-Plated Steel Oversized Washer for M8 Screw Size, 8.4 mm ID, 24 mm OD	8	
	91292A145	18-8 Stainless Steel Socket Head Screw, M8 x 1.25 mm Thread, 16 mm Long	8	
	KESS5-25	Parallel Key (with both ends round), Width 5mm, Length 25mm	2	
	91292A806	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 22mm	8	
	91292A116	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 10mm	8	
	91292A070	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 14mm	4	
	93475A250	18-8 Stainless Steel Washer for M6 Screw Size, 6.4 mm ID, 12 mm OD	4	
	93475A230	18-8 Stainless Steel Washer for M4 Screw Size, 4.3 mm ID, 9 mm OD	16	
	93475A210	18-8 Stainless Steel Washer for M3 Screw Size, 3.2 mm ID, 7 mm OD	4	
	91828A211	18-8 Stainless Steel Hex Nut, M3 x 0.5 mm Thread	4	

Final
Assembly

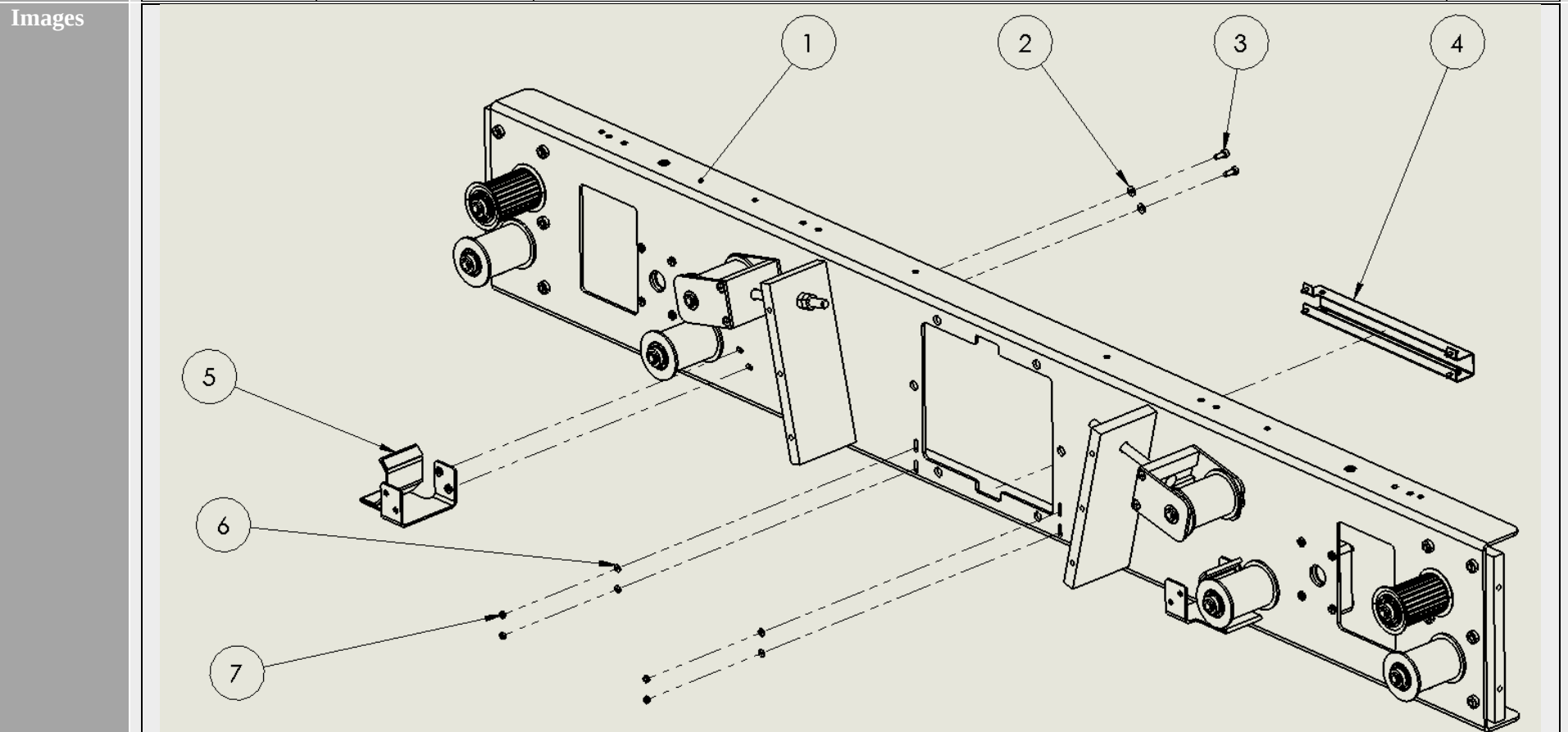


Notes

- Heavy, wear steel toe shoes.

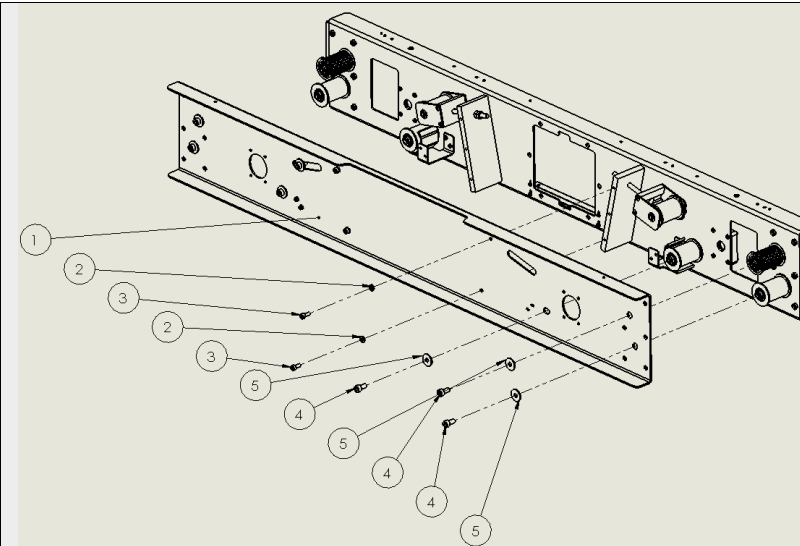
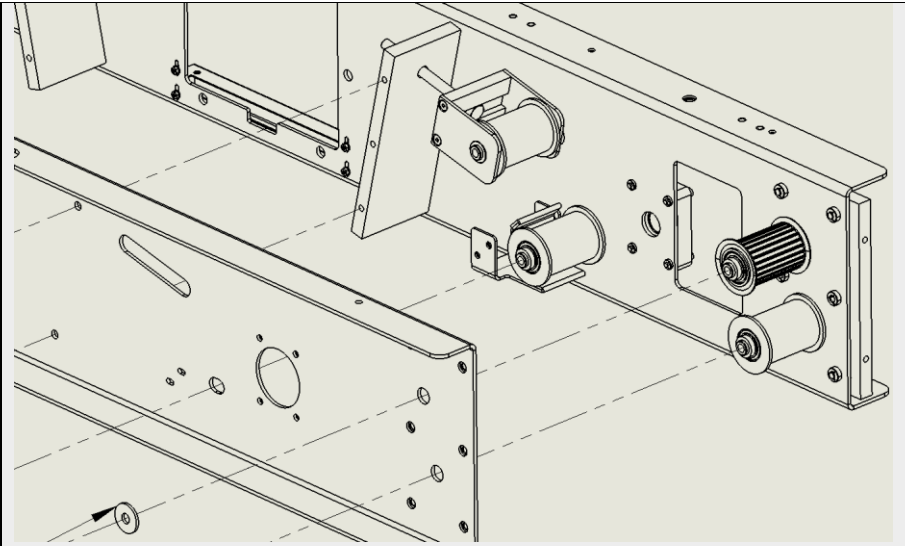
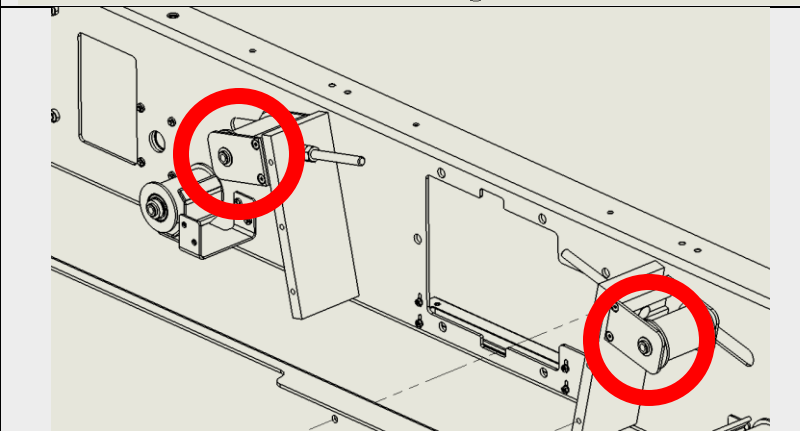
2.4.1 Step 1 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-200-2754	MOTOR WALL SUBASSEMBLY	1
	2	93475A230	18-8 Stainless Steel Washer for M4 Screw Size, 4.3 mm ID, 9 mm OD	2
	3	91292A116	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 10mm	2
	4	2-300-2744	MOTOR BACK BRACE	1
	5	2-300-2704	BELT FEED ASSIST	2
	6	93475A210	18-8 Stainless Steel Washer for M3 Screw Size, 3.2 mm ID, 7 mm OD	4
	7	91828A211	18-8 Stainless Steel Hex Nut, M3 x 0.5 mm Thread	4

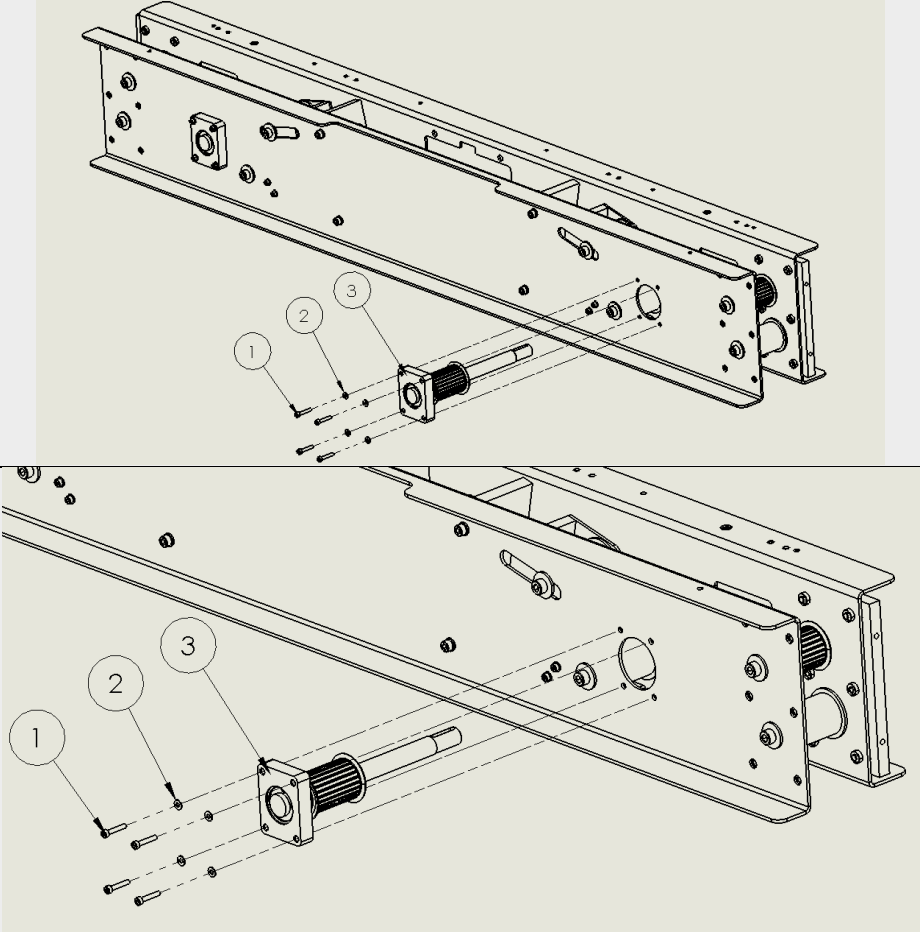


- Directions
- Assemble as shown.
 - Repeat to both sides (2-300-2704)
 - Install Item 7 Fingertight. This will be torqued down by installation team.

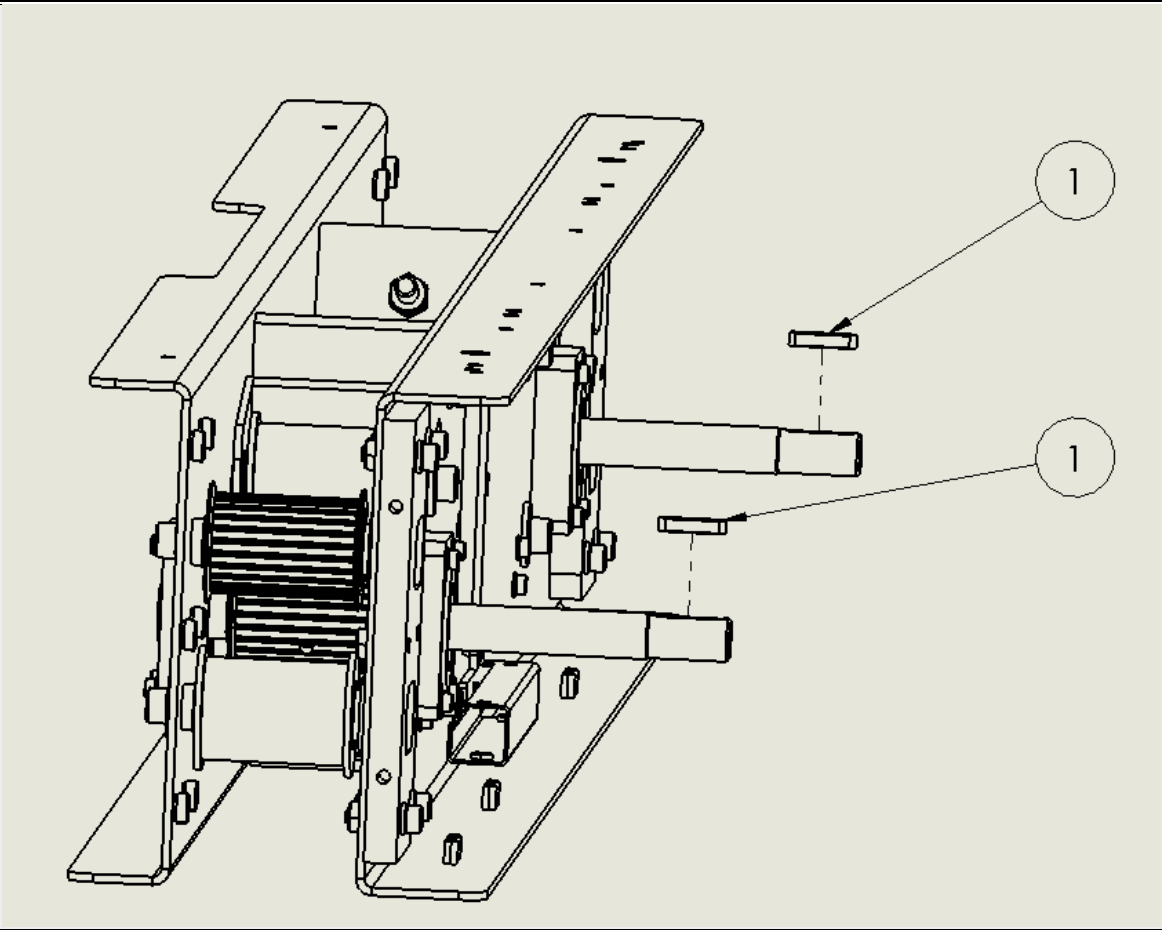
2.4.2 Step 2 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-300-2772	FULL WALL, DRIVEN SIDE	1
	2	93475A250	18-8 Stainless Steel Washer for M6 Screw Size, 6.4 mm ID, 12 mm OD	4
	3	91292A070	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 14mm	4
	4	91292A145	18-8 Stainless Steel Socket Head Screw, M8 x 1.25 mm Thread, 16 mm Long	7
	5	91100A160	Zinc-Plated Steel Oversized Washer for M8 Screw Size, 8.4 mm ID, 24 mm OD	7
Images				
				
Directions				
	- Assemble as shown. - Torque Requirement bubble 4 (M8 SHCS) – 169in-lbs – QTY 6. Torque Red Circled Bolts to 10in-lbs - Use Single Drop of Loctite on Item 4			

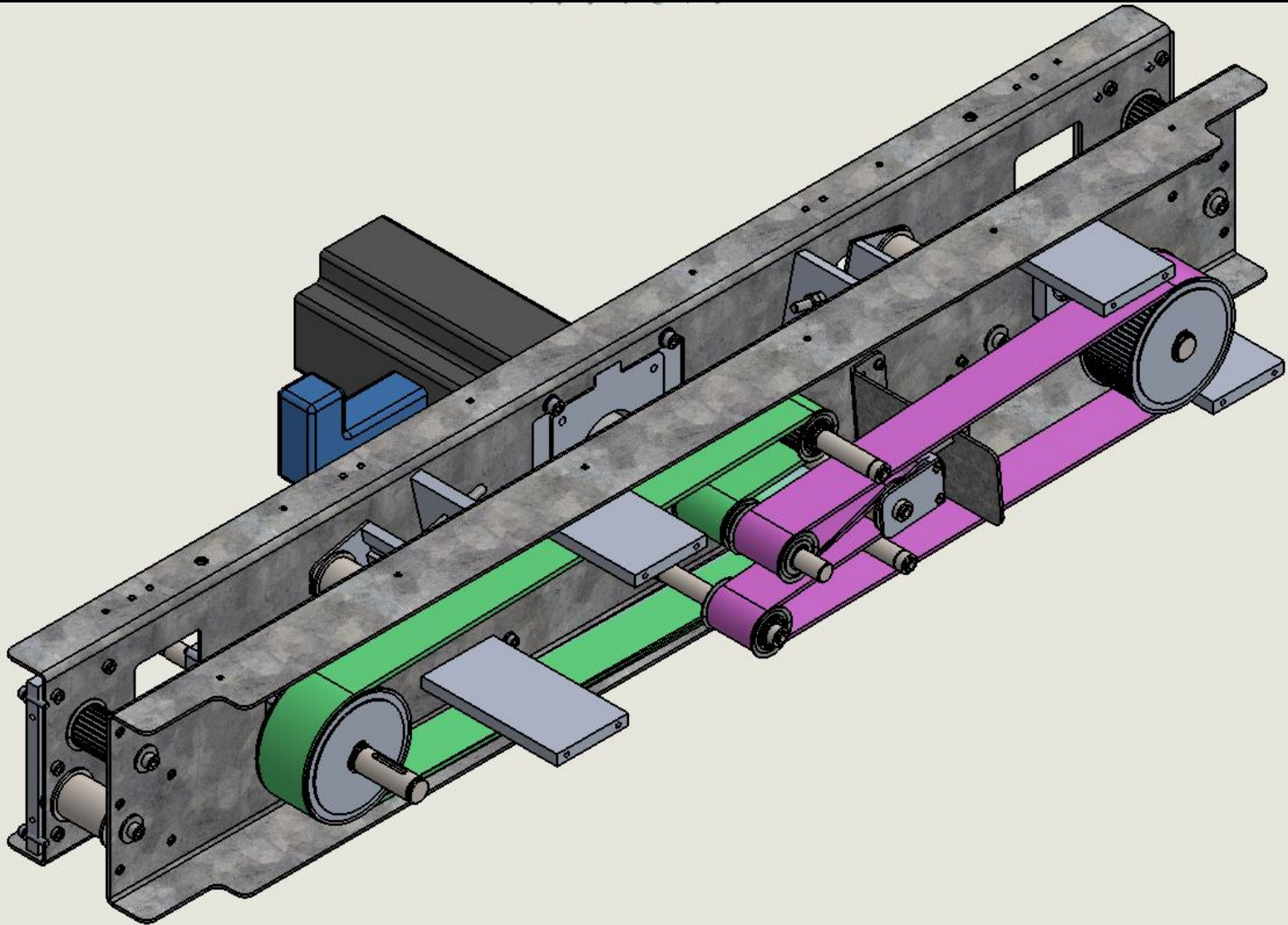
2.4.3 Step 3 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	91292A806	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 22mm	8
	2	93475A230	18-8 Stainless Steel Washer for M4 Screw Size, 4.3 mm ID, 9 mm OD	8
	3	2-200-2764	ELEVATOR DRIVE SHAFT SUBASSEMBLY, DRIVEN SIDE	2
Images				
	• Assemble as shown. • Use Single Drop of Loctite on Item 1 • Repeat to both Sides			
Directions				

2.4.4 Step 4 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	KESS5-25	Parallel Key (with both ends round), Width 5mm, Length 35 mm	2
Images				
Directions	• Assemble as shown. • Repeat to both Sides			

2.5 2-200-2760 Drive I Beam Subassembly			Qty to Build: 1	Danger: None
Tools	DESCRIPTION		IMAGE	
	Metric Allen Keys			
	Drill and bits			
	Loctite			
	Torque Wrench			
BOM for Qty 1	PART NUMBER	DESCRIPTION	QTY.	
	2-200-2757	DRIVE WALL SUBASSEMBLY	1	
	2-200-2759	MOTOR WALL SUBASSEMBLY	1	
	2-200-2762	ELEVATOR DRIVE SHAFT SUBASSEMBLY	2	
	2-300-2704	BELT FEED ASSIST	1	
	2-300-2716	DRIVE, 72 TEETH, 53MM WIDE	2	
	90967A241	External Retaining Ring for 22 mm OD, DIN 1.4122 Stainless Steel	3	
	91100A160	Zinc-Plated Steel Oversized Washer for M8 Screw Size, 8.4 mm ID, 24 mm OD	7	
	91292A145	18-8 Stainless Steel Socket Head Screw, M8 x 1.25 mm Thread, 16 mm Long	7	
	92015A129	18-8 Stainless Steel Cup-Point Set Screw, M6 x 1 mm Thread, 6 mm Long	4	
	KESS5-25	Parallel Key (with both ends round), Width 5mm, Length 25mm	2	
	KESS6-28	Parallel Key (with both ends round), Width 6mm, Length 28 mm	1	
	KESS6-35	Parallel Key (with both ends round), Width 6mm, Length 28 mm	2	
	130ST-M07725	130ST-M07725 Motor	1	
	91292A806	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 22mm	8	
	91292A116	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 10mm	4	
	91292A070	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 14mm	4	
	91292A149	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M8 X 1.25mm, 30mm	4	
	93475A270	18-8 Stainless Steel Washer for M8 Screw Size, 8.4 mm ID, 16 mm OD	4	
	93475A230	18-8 Stainless Steel Washer for M4 Screw Size, 4.3 mm ID, 9 mm OD	12	
	93475A250	18-8 Stainless Steel Washer for M6 Screw Size, 6.4 mm ID, 12 mm OD	4	
	92125A188	18-8 Stainless Steel Hex Drive Flat Head Screw, M4 x 0.7 mm Thread, 8 mm Long	4	
	MJT-55K-WH-22-22 Hub	MJT flexible coupling disk type – Hub	2	
	MJT-55K-WH Sleeve	MJT flexible coupling disk type - Sleeve	1	
	HTD-5, 50MM, 1525mm	HTD-5M, 50mm Wide, Endless, 1525mm Long, PU with Steel Cords	1	
	HTD-5, 50MM, 1640mm	HTD-5M Double Sided Teeth, 50mm Wide, Endless, 1640mm Long, PUwith Steel Cords	1	

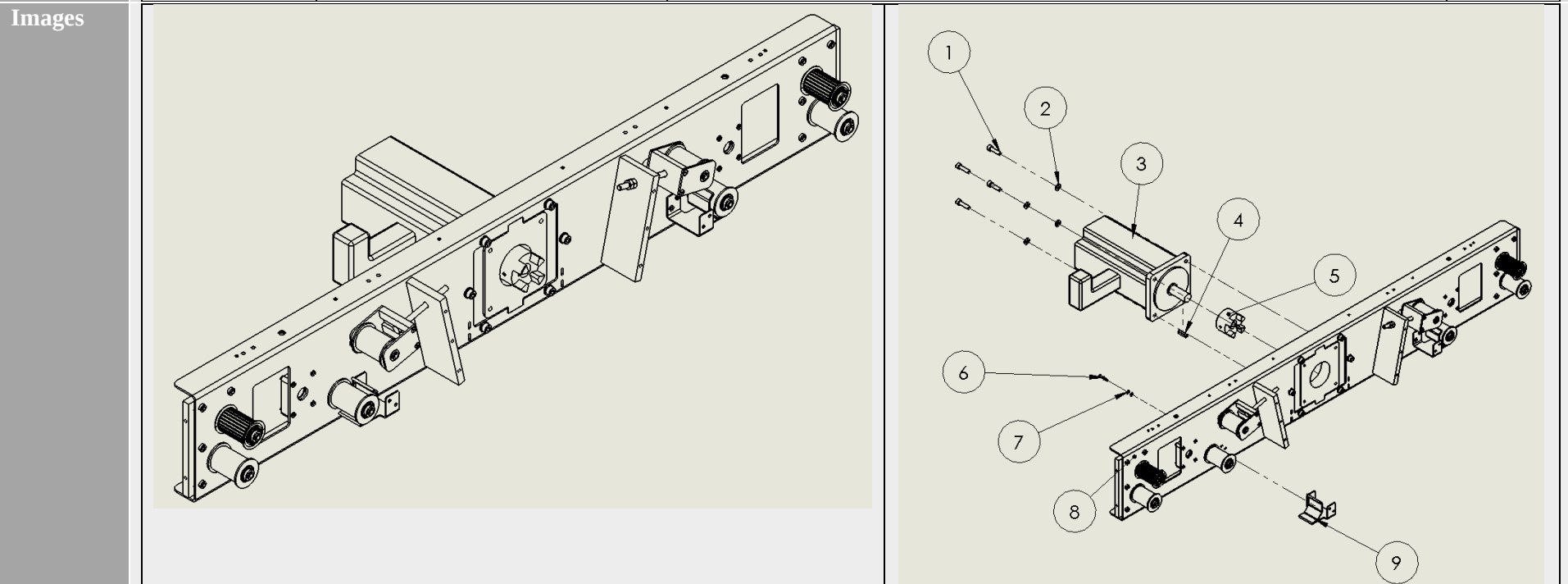
Final
Assembly

Notes

- Heavy, wear steel toe shoes.
- Part Used In: [2-200-2767](#)

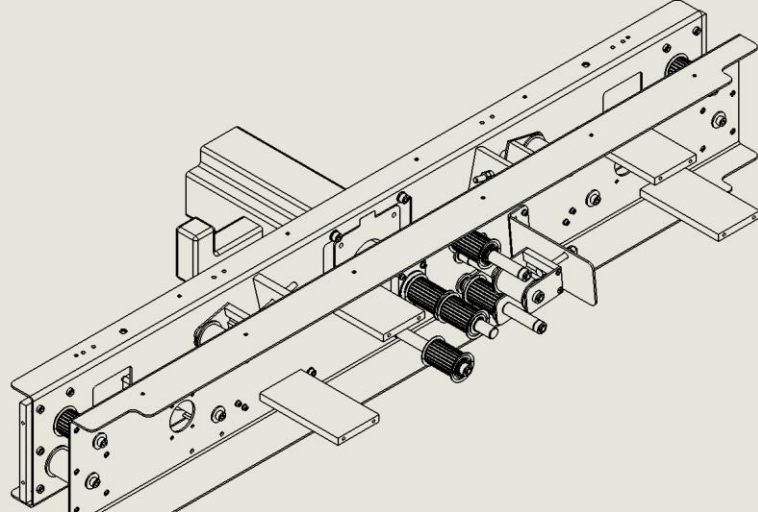
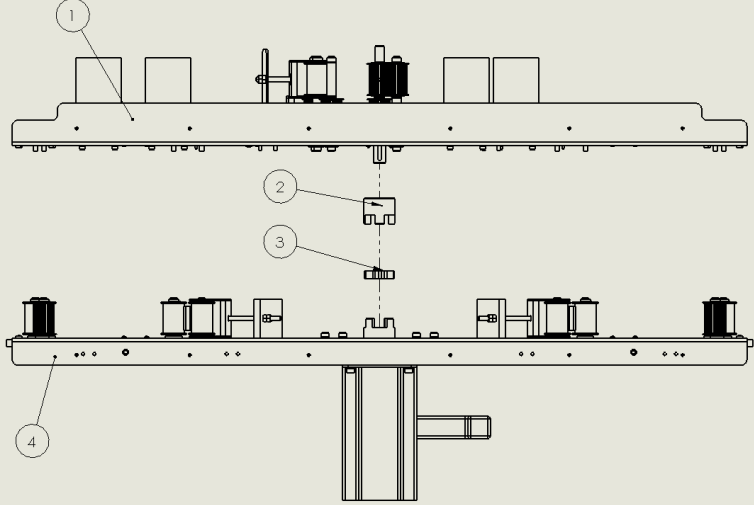
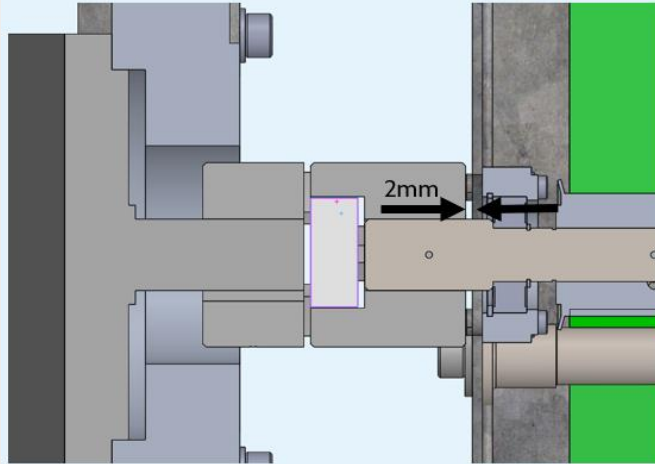
2.5.1 Step 1 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	91292A149	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M8 X 1.25mm, 30mm	4
	2	93475A270	18-8 Stainless Steel Washer for M8 Screw Size, 8.4 mm ID, 16 mm OD	4
	3	130ST-M07725	130ST-M07725 Motor	1
	4	KESS6-28	Parallel Key (with both ends round), Width 6mm, Length 28 mm	1
	5	MJT-55K-WH-22-22 Hub	MJT flexible coupling disk type – Hub	1
	6	91292A116	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 10mm	2
	7	93475A230	18-8 Stainless Steel Washer for M4 Screw Size, 4.3 mm ID, 9 mm OD	2
	8	2-200-2759	MOTOR WALL SUBASSEMBLY	1
	9	2-300-2704	BELT FEED ASSIST	2



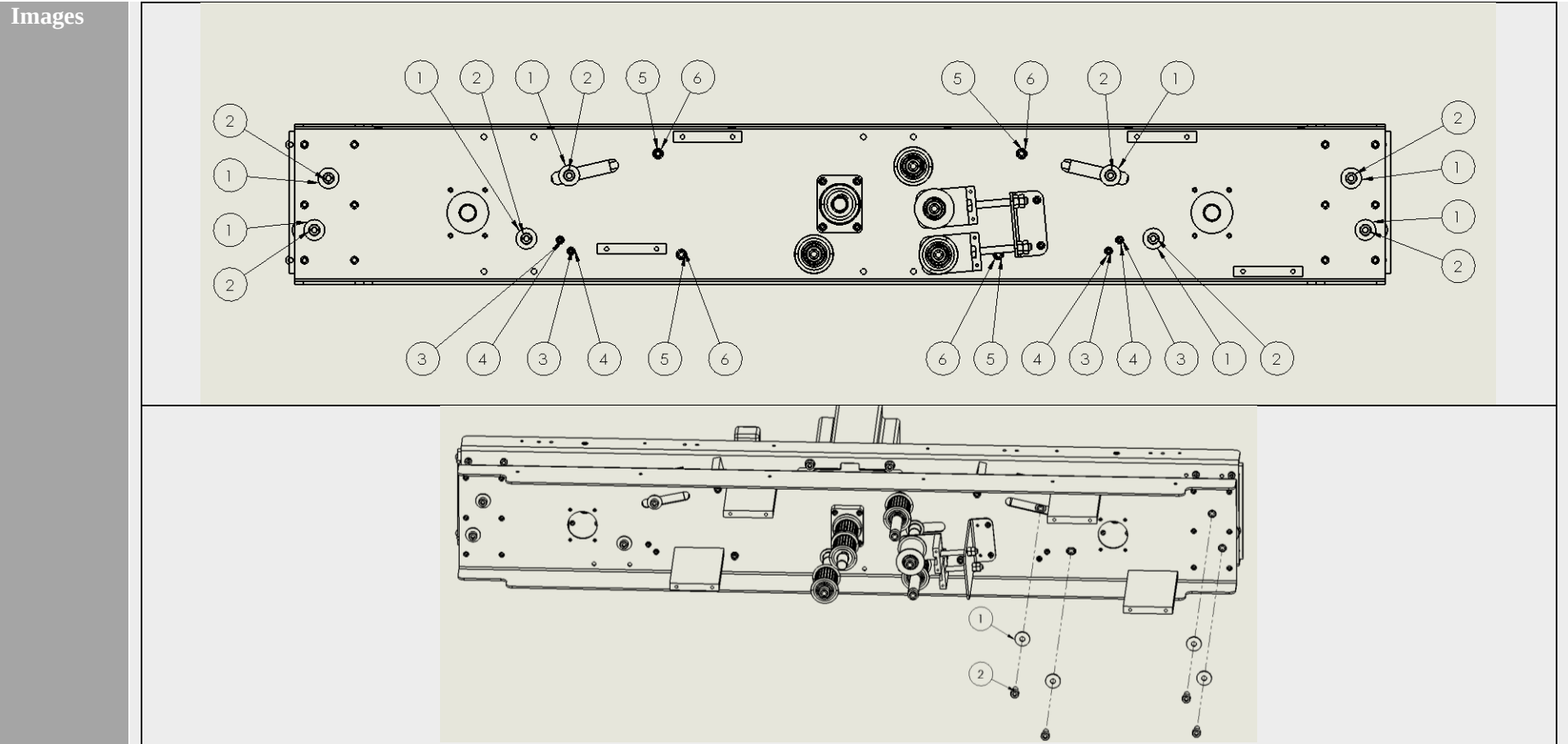
Directions	• Assemble as shown. • Install the Coupler half, bubble 5, and tighten it down. • Use Loctite on Item 6 and 1. No Loctite on Item 5. • Repeat Bubble 9 to both sides.
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2.5.2 Step 2 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-200-2757	DRIVE WALL SUBASSEMBLY	1
	2	MJC-55K-W -22-22 Hub 1	MJT flexible coupling disk type – Hub	2
	3	MJC-55K-WH Sleeve	MJT flexible coupling disk type - Sleeve	1
	4	2-200-2759	MOTOR WALL SUBASSEMBLY	1
Images				
				
Directions	• Assemble as shown. • Use Single Drop of Loctite on Set Screw for Item 2 • Torque Set Screw in Item 2 to 40in-lbs • Ensure there is a minimum gap of 2mm, max gap of 3mm for the coupler			

2.5.3 Step 2.1 Order of Assembly

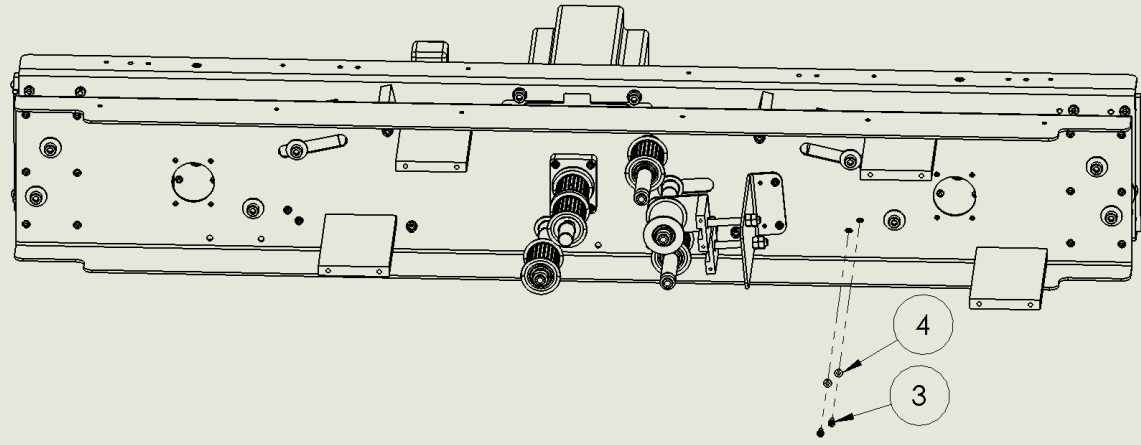
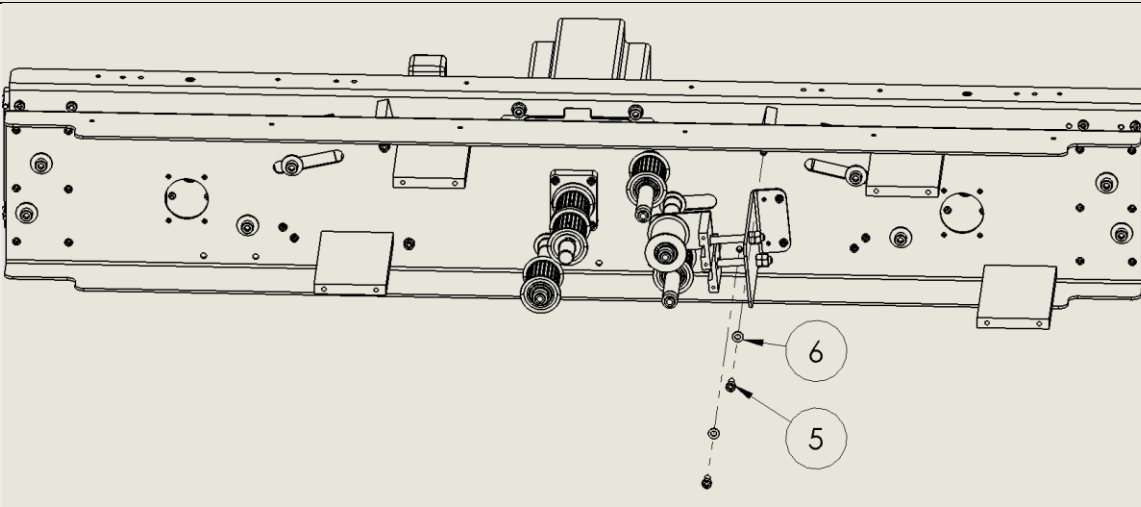
BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	91100A160	Zinc-Plated Steel Oversized Washer for M8 Screw Size, 8.4 mm ID, 24 mm OD	8
	2	91292A145	18-8 Stainless Steel Socket Head Screw, M8 x 1.25 mm Thread, 16 mm Long	8
	3	91292A116	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 10mm	8
	4	93475A230	18-8 Stainless Steel Washer for M4 Screw Size, 4.3 mm ID, 9 mm OD	8
	5	91292A070	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 14mm	4
	6	93475A250	18-8 Stainless Steel Washer for M6 Screw Size, 6.4 mm ID, 12 mm OD	4



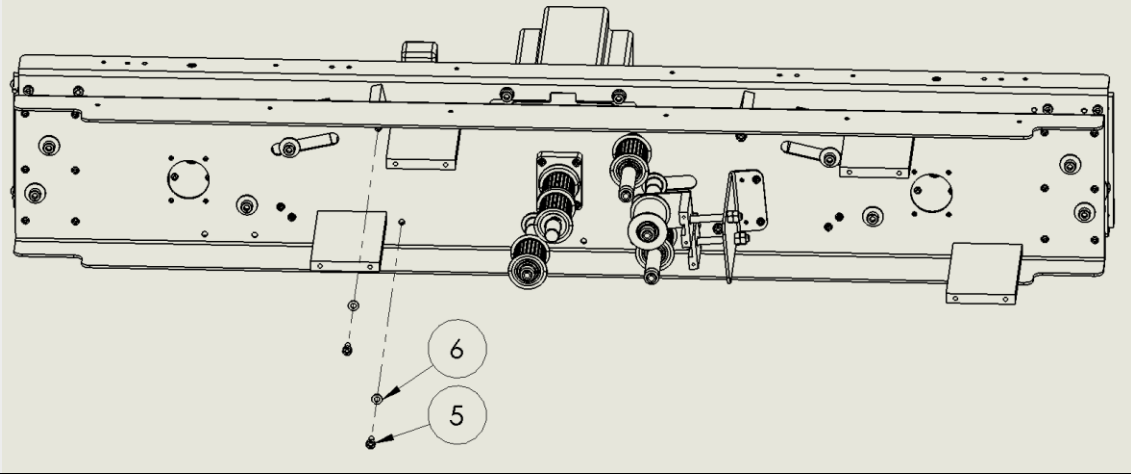
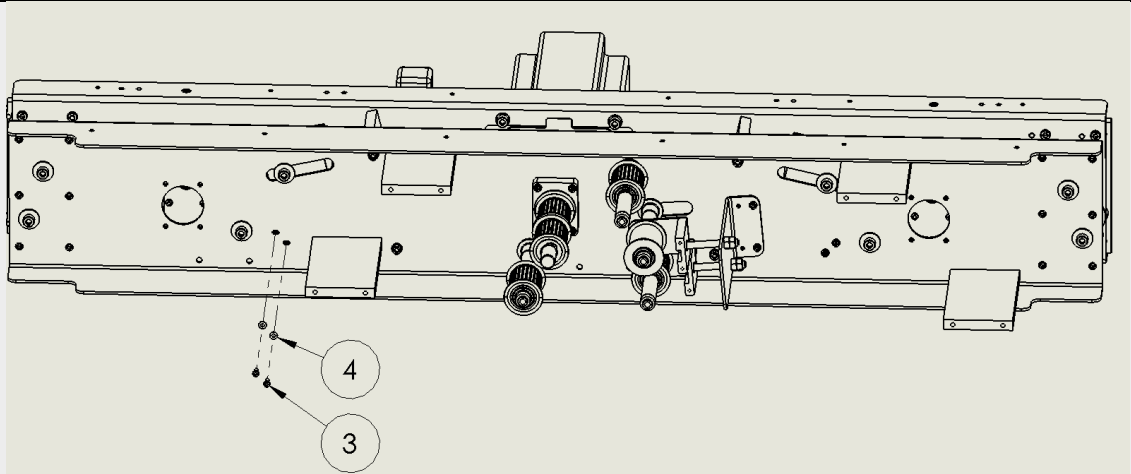
Directions

- Assemble as shown.
- Torque Requirement bubbles 2 (M8 SHCS)– 169in-lbs. Red circled bolts torque to 10in-lbs
- Use Single Drop of Loctite

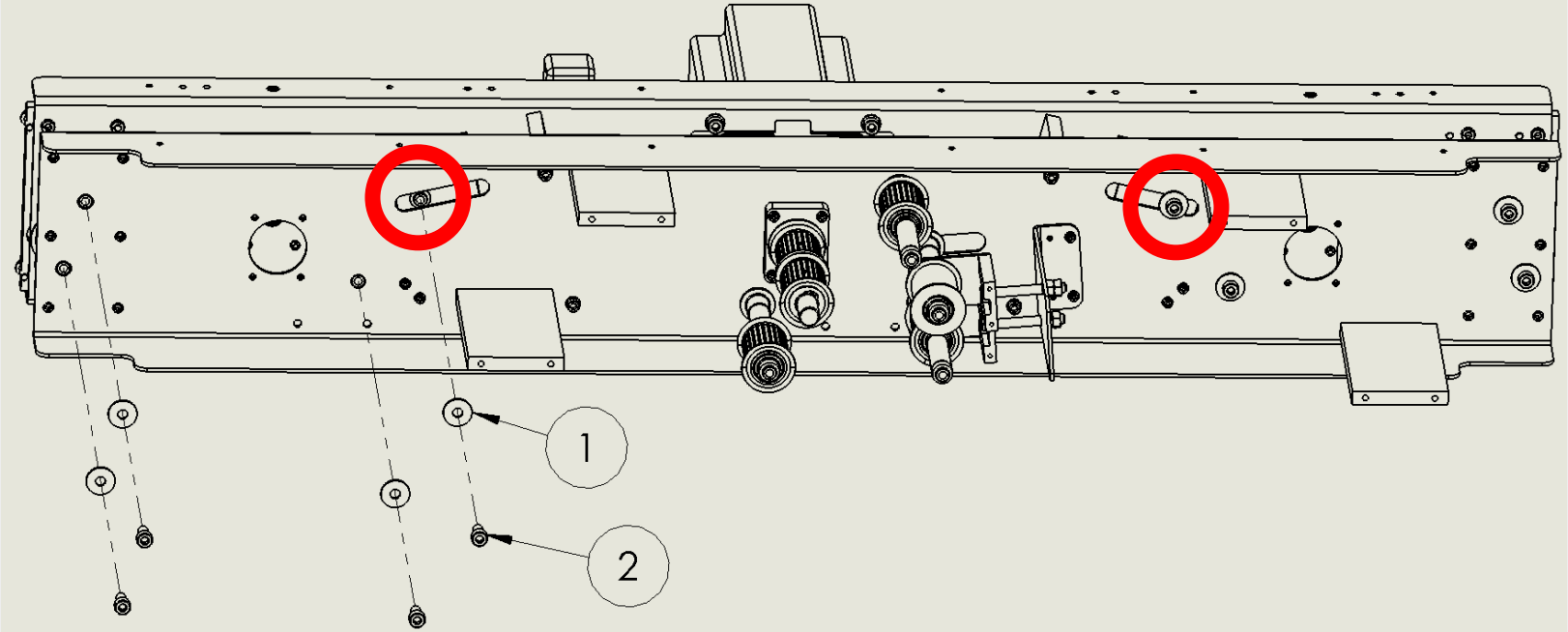
2.5.4 Step 2.2 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	3	91292A116	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 10mm	2
	4	93475A230	18-8 Stainless Steel Washer for M4 Screw Size, 4.3 mm ID, 9 mm OD	2
	5	91292A070	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 14mm	2
	6	93475A250	18-8 Stainless Steel Washer for M6 Screw Size, 6.4 mm ID, 12 mm OD	2
Images				
				
Directions	- Assemble as shown. - Use Single Drop of Loctite			

2.5.5 Step 2.3 Order of Assembly

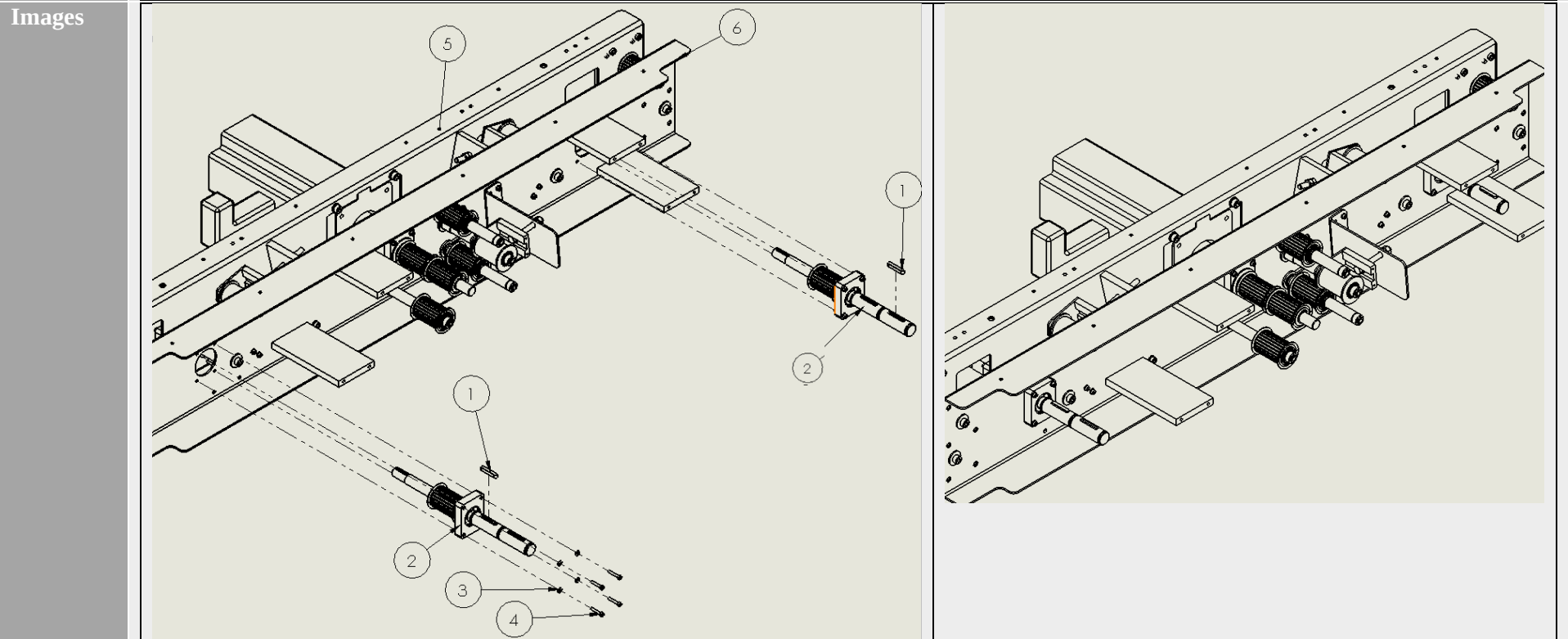
BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	3	91292A116	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 10mm	2
	4	93475A230	18-8 Stainless Steel Washer for M4 Screw Size, 4.3 mm ID, 9 mm OD	2
	5	91292A070	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 14mm	2
	6	93475A250	18-8 Stainless Steel Washer for M6 Screw Size, 6.4 mm ID, 12 mm OD	2
Images				
				
Directions	• Assemble as shown. • Use Single Drop of Loctite			

2.5.6 Step 2.4 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	91100A160	Zinc-Plated Steel Oversized Washer for M8 Screw Size, 8.4 mm ID, 24 mm OD	8
	2	91292A145	18-8 Stainless Steel Socket Head Screw, M8 x 1.25 mm Thread, 16 mm Long	8
Images				
Directions	• Assemble as shown. • Torque Requirement bubbles 2 (M8 SHCS)– 169in-lbs. Red circled bolts torque to 10in-lbs • Use Single Drop of Loctite • Ensure you do both sides			

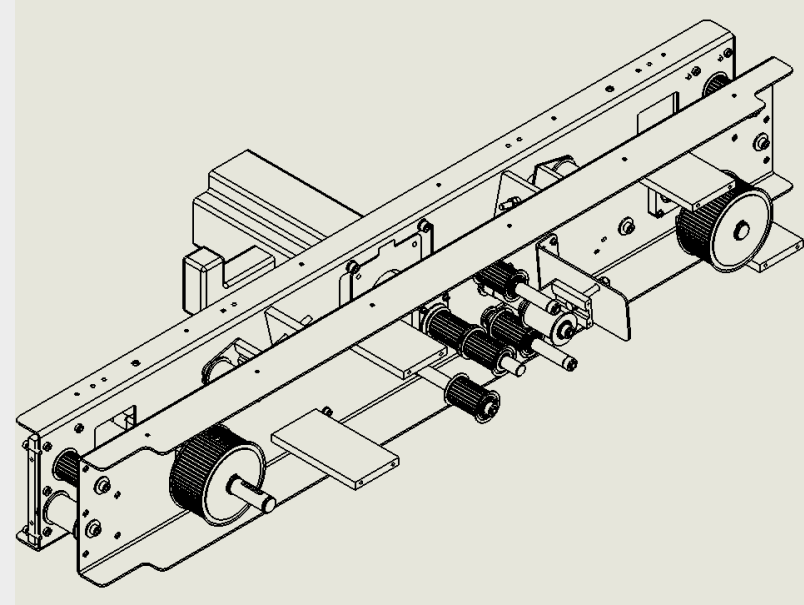
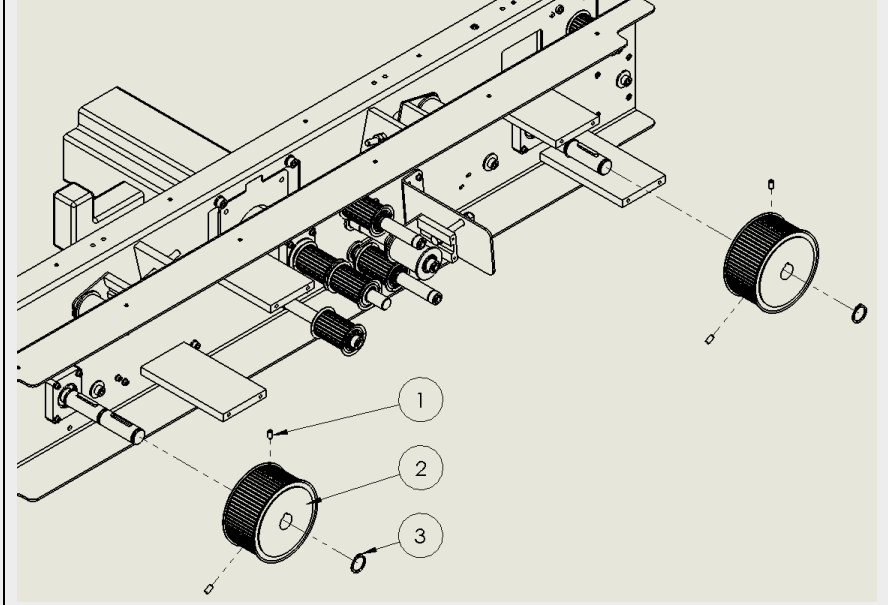
2.5.7 Step 3 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	KESS6-35	Parallel Key (with both ends round), Width 6mm, Length 28 mm	2
	2	2-200-2762	ELEVATOR DRIVE SHAFT SUBASSEMBLY	2
	3	93475A230	18-8 Stainless Steel Washer for M4 Screw Size, 4.3 mm ID, 9 mm OD	8
	4	91292A806	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 22mm	8
	5	2-200-2759	MOTOR WALL SUBASSEMBLY	1
	6	2-200-2757	DRIVE WALL SUBASSEMBLY	1



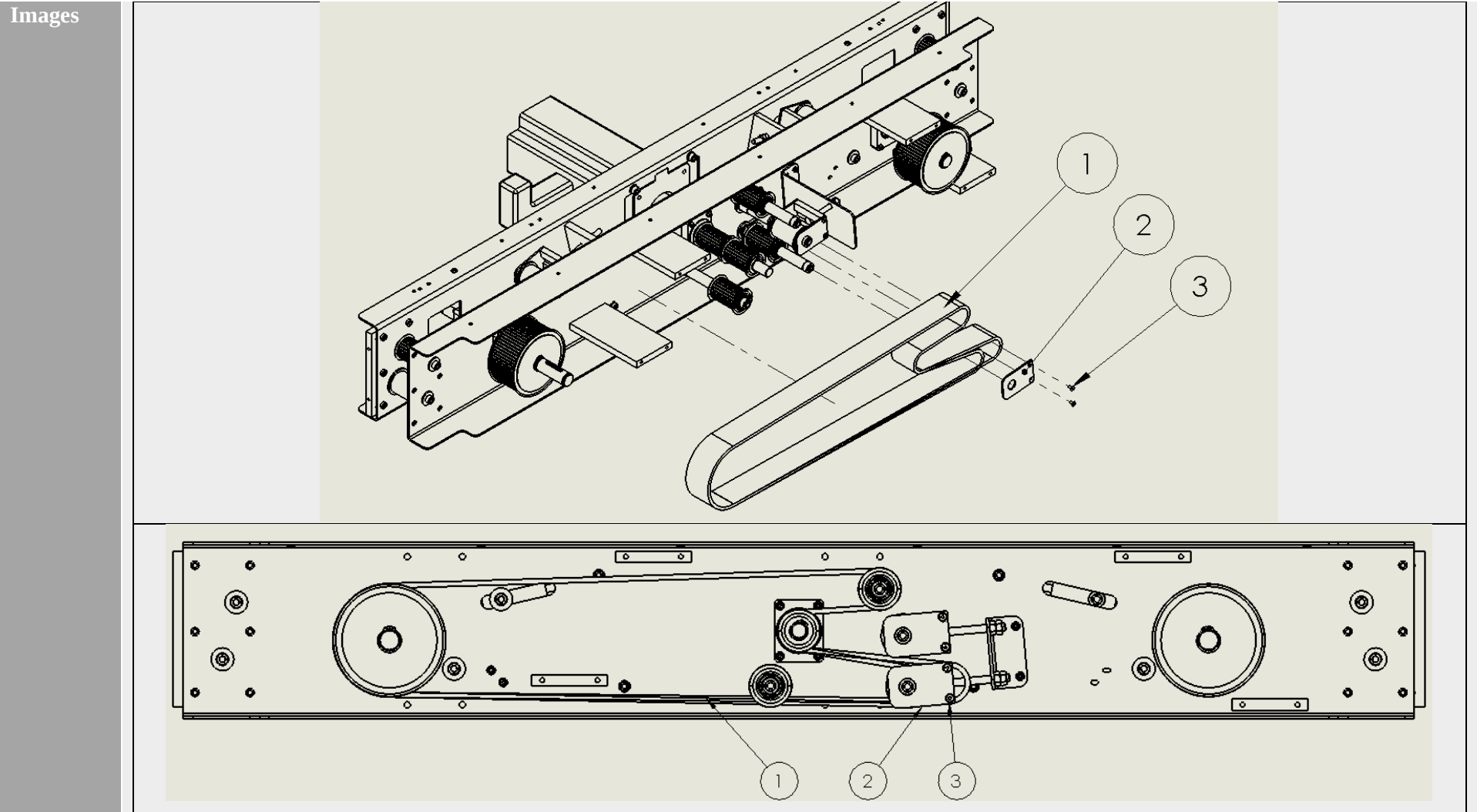
Directions	- Assemble as shown. - Use Single Drop of Loctite on Items 4
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2.5.8 Step 4 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	92015A129	18-8 Stainless Steel Cup-Point Set Screw, M6 x 1 mm Thread, 12 mm Long	4
	2	2-300-2716	DRIVE, 72 TEETH, 53MM WIDE	2
	3	90967A241	External Retaining Ring for 22 mm OD, DIN 1.4122 Stainless Steel	3
Images				
				
Directions	• Assemble as shown. • Use Loctite on Set screws • Torque set screws to – 55in-lbs • Left Pulley goes all the way on the shaft. • Right Pulley goes towards the front of the shaft.			

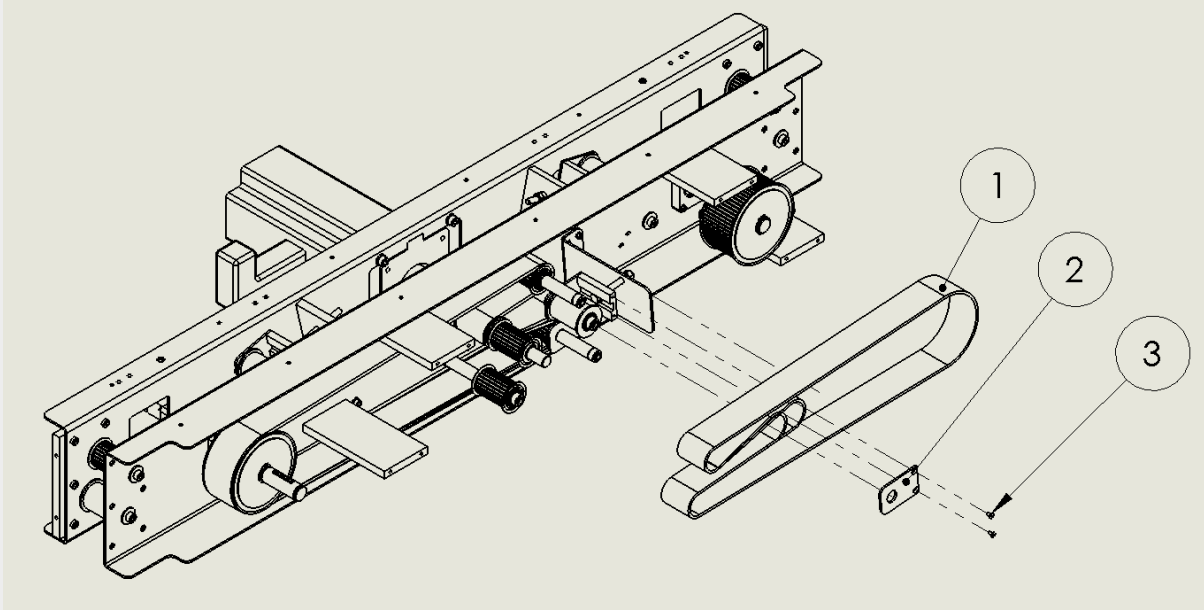
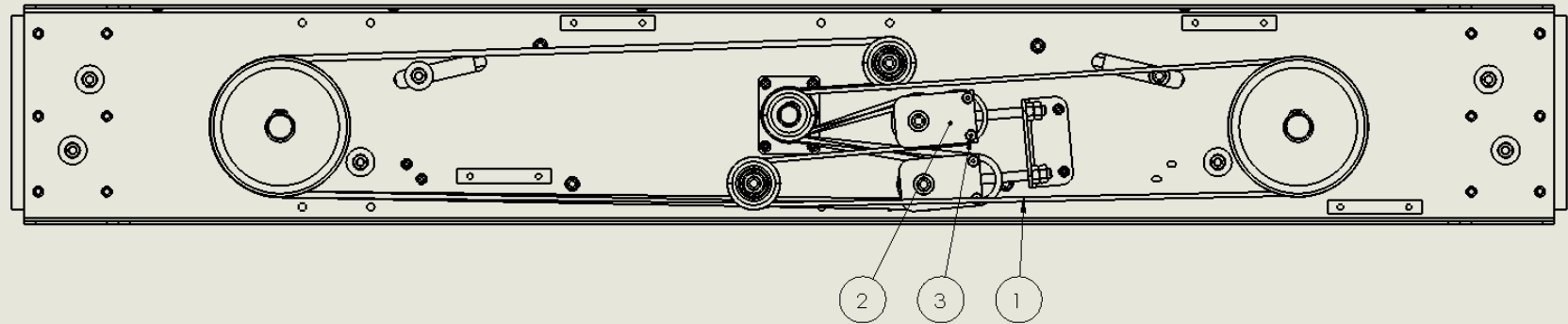
2.5.9 Step 5 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	HTD-5, 50MM, 1640mm	HTD-5M Double Sided Teeth, 50mm Wide, Endless, 1640mm Long, PU with Steel Cords	1
	2	2-300-2693	ELEVATOR BELT TENSIONER SIDE WALL	5
	3	92125A188	18-8 Stainless Steel Hex Drive Flat Head Screw, M4 x 0.7 mm Thread, 8 mm Long	2



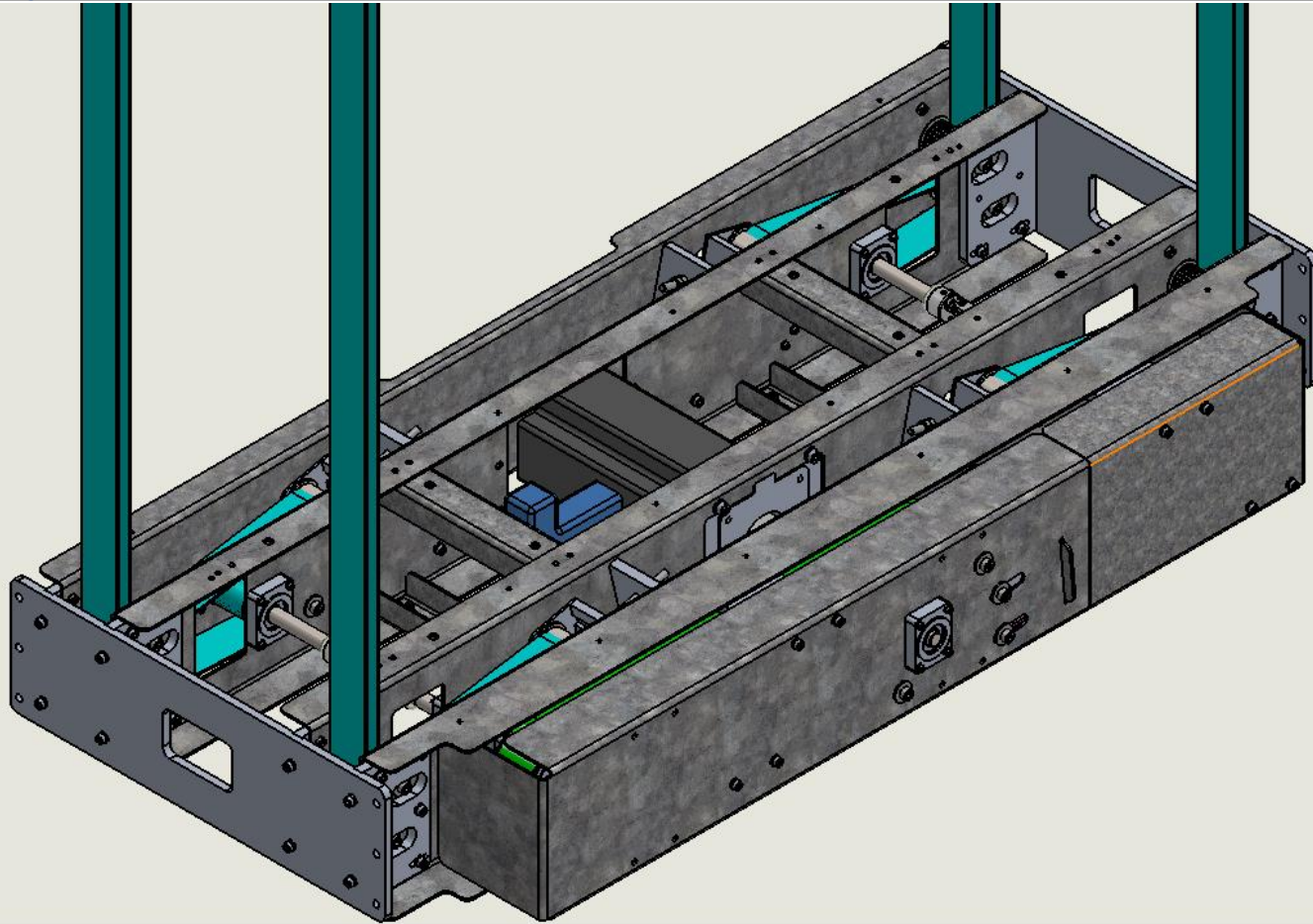
Directions	- Assemble as shown. - When installing the belt make sure to time the drive shafts to Top Dead Center (TDC).
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2.5.10 Step 6 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	HTD-5, 50MM, 1525mm	HTD-5M, 50mm Wide, Endless, 1525mm Long, PU with Steel Cords	1
	2	2-300-2693	ELEVATOR BELT TENSIONER SIDE WALL	5
	3	92125A188	18-8 Stainless Steel Hex Drive Flat Head Screw, M4 x 0.7 mm Thread, 8 mm Long	2
Images				
				
Directions	- Assemble as shown. - When installing the belt make sure to time the drive shafts to Top Dead Center (TDC)			

3 Final Assembly

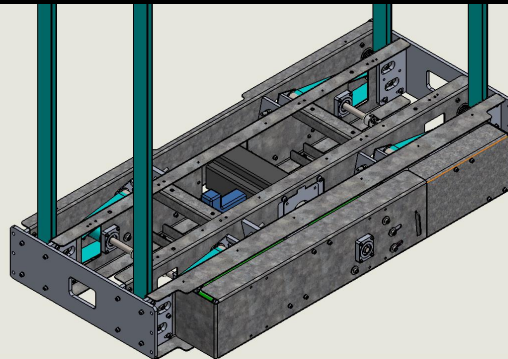
Overview



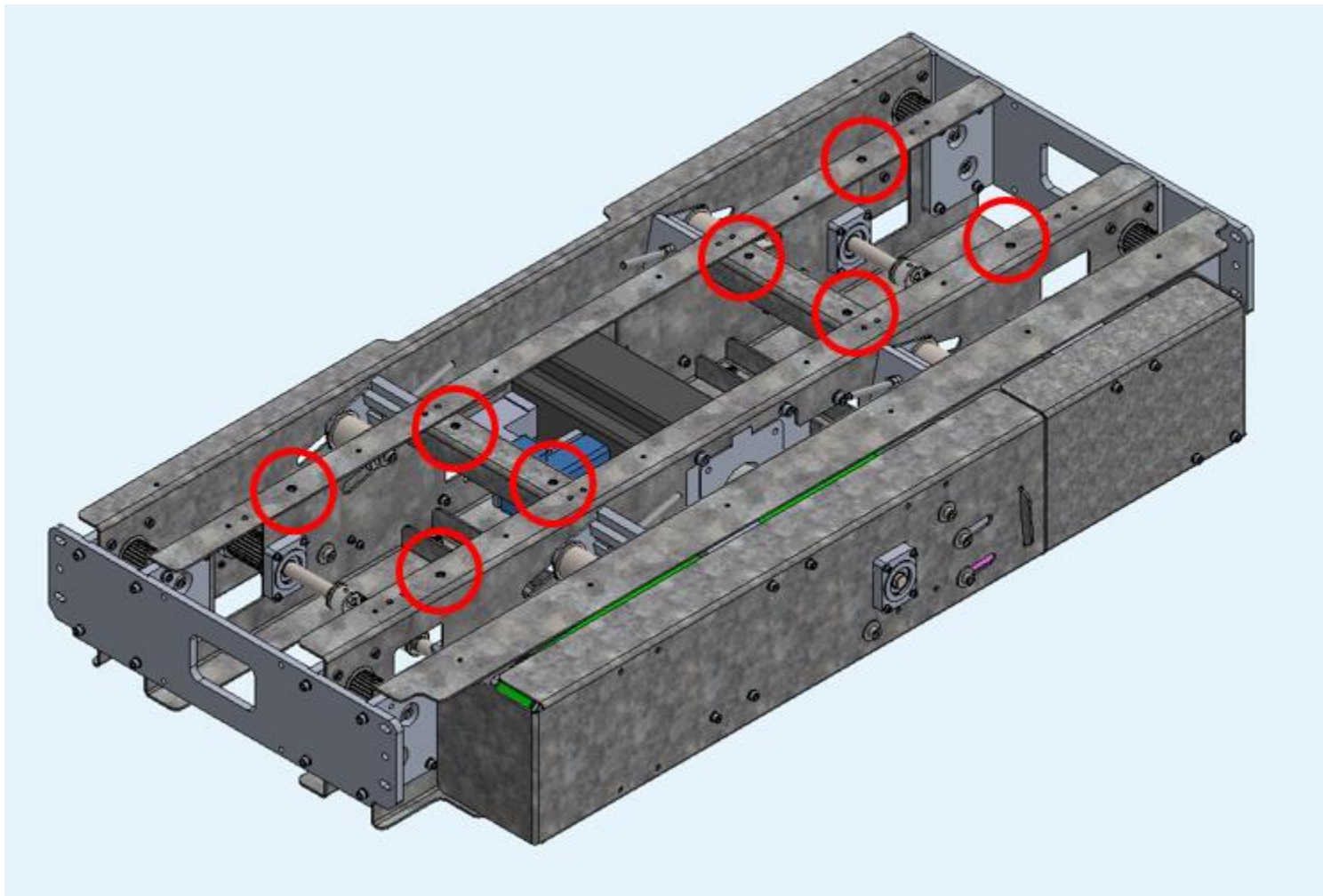
Description

- Bringing all the parts together

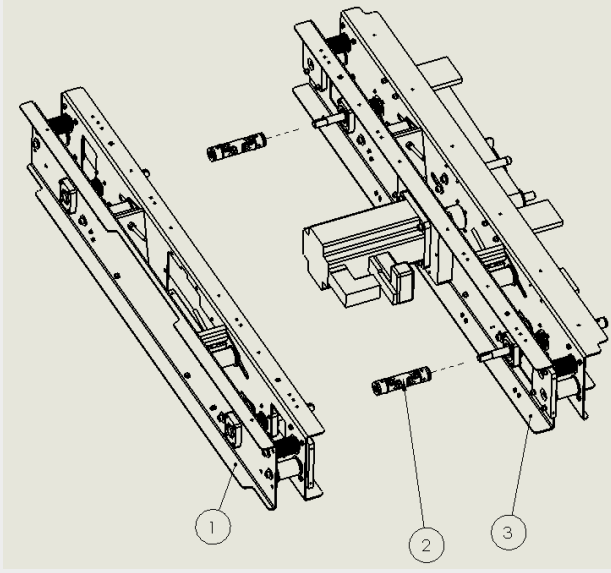
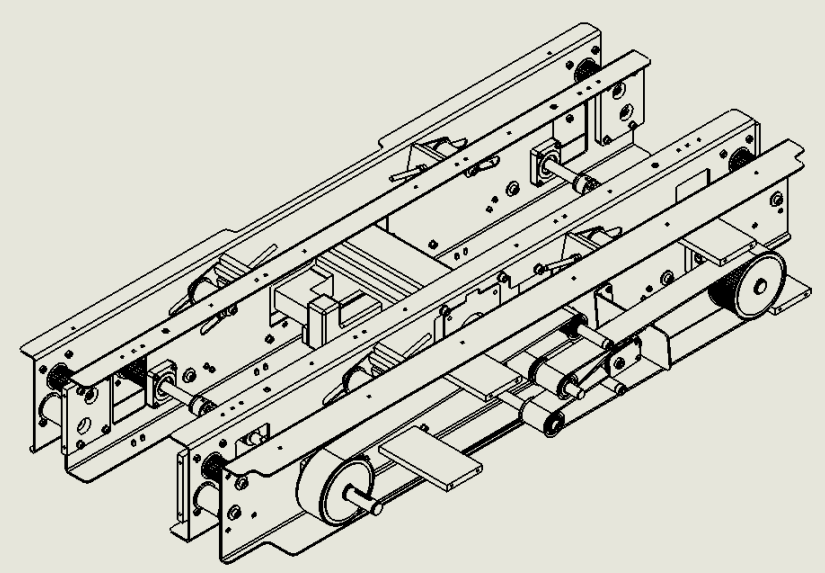
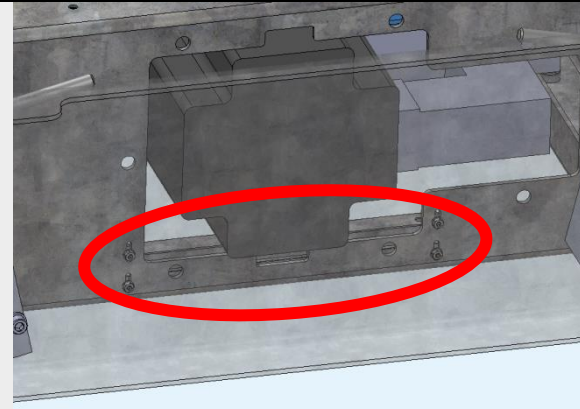
3.1 2-200-2767 Finalized Structure, Shipping, No Cover**Qty to Build: 1****Danger: None**

Tools	DESCRIPTION		
	Metric Allen Keys, Drill and bits, Wrench Set, Loctite, Torque Wrench		
BOM for Qty 1	PART NUMBER	DESCRIPTION	QTY.
	2-300-2773	ELEVATOR TIMINGBELT	4
	2-200-2697	BEARING BLOCK SUBASSEMBLY	1
	2-200-2724	END WALL PLATE SUBASSY	2
	2-200-2760	DRIVE I BEAM SUBASSEMBLY	1
	2-200-2763	DRIVEN SIDE SUBASSEMBLY	1
	2-300-2708	DRIVE BELT C BRACKET, LOAD WALL	1
	2-300-2709	DRIVE WALL COVER, NO LOAD	1
	2-300-2727	SUPPORT U BRACKET	4
	91100A160	Zinc-Plated Steel Oversized Washer for M8 Screw Size, 8.4 mm ID, 24 mm OD	4
	91292A145	18-8 Stainless Steel Socket Head Screw, M8 x 1.25 mm Thread, 16 mm Long	4
	91292A806	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 22mm	4
	91292A070	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 14mm	8
	91292A073	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 22mm	24
	91292A138	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 25mm	8
	UNKW16	Universal Joints - Keyway, Set Screw	2
	93475A250	18-8 Stainless Steel Washer for M6 Screw Size, 6.4 mm ID, 12 mm OD	40
	93475A230	18-8 Stainless Steel Washer for M4 Screw Size, 4.3 mm ID, 9 mm OD	4
	91828A241	18-8 Stainless Steel Hex Nut, M5 x 0.8 mm Thread	16
	93475A240	18-8 Stainless Steel Washer for M5 Screw Size, 5.3 mm ID, 10 mm OD	16
Final Assembly			
Notes	• Very Heavy, wear steel toe shoes. • Requires two people to lift. Use lifting points where helpful		

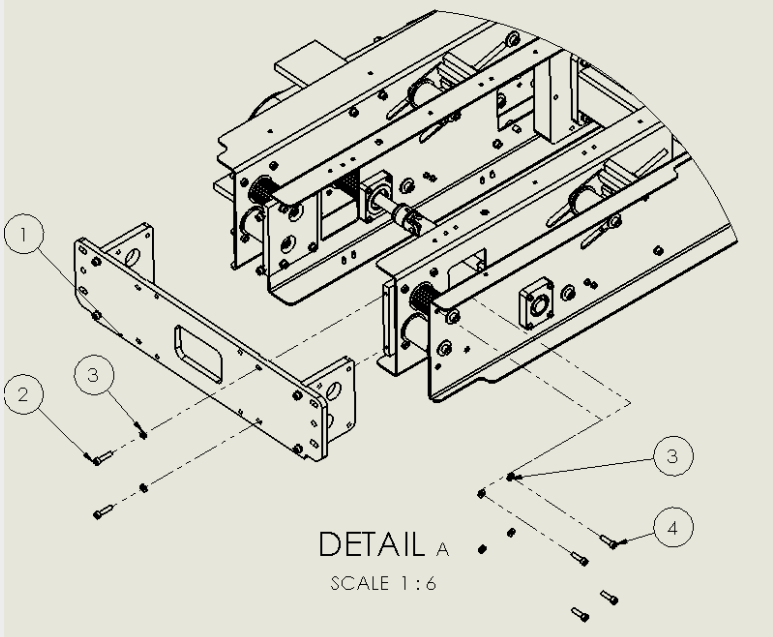
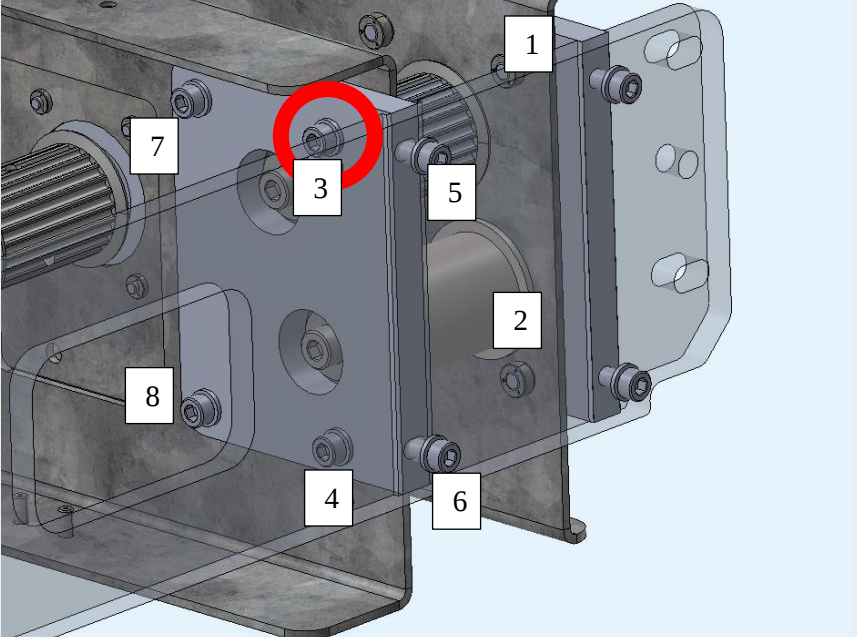
Use M8 PEM Nut Lift Point Locations. USE AT MINIMUM 2 LOCATIONS WHEN LIFTING ASSEMBLY



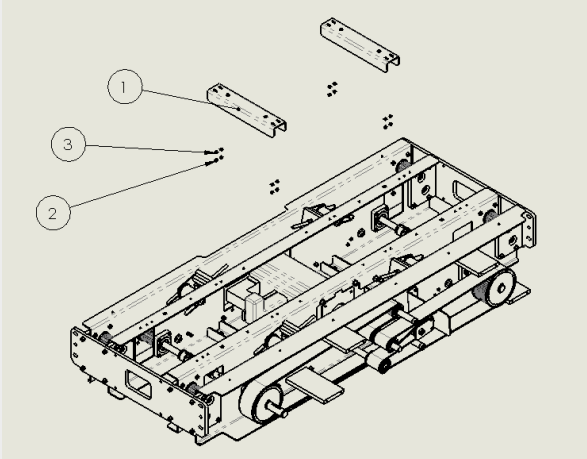
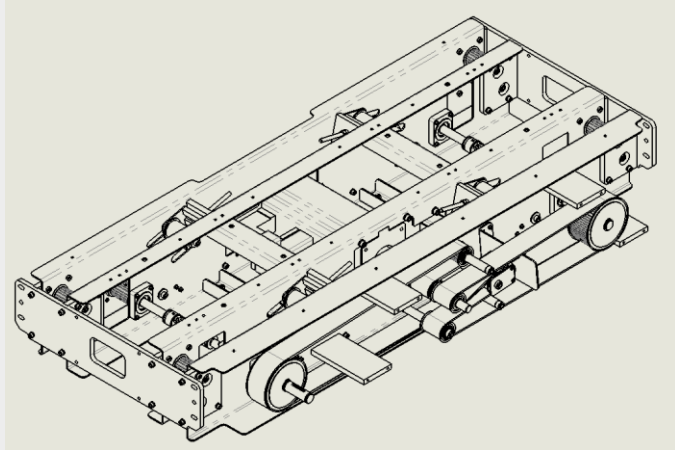
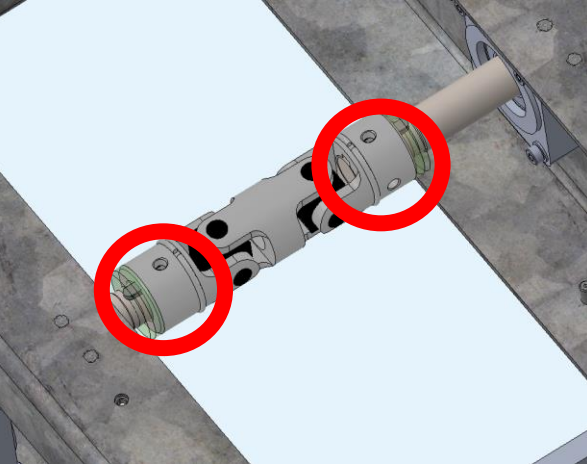
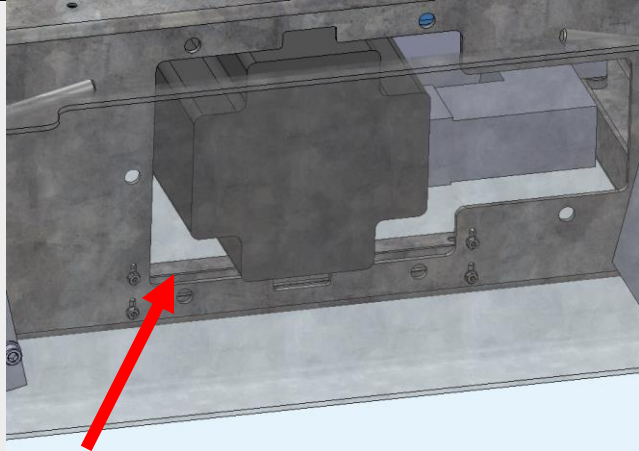
3.1.1 Step 1 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-200-2763	DRIVEN SIDE SUBASSEMBLY	1
	3	UNKW16	Universal Joints - Keyway, Set Screw	2
	4	2-200-2760	DRIVE I BEAM SUBASSEMBLY	1
Images				
				
Directions	• Assemble as shown. • Install couplers LOOSE. Do not torque down any set screws at this point • Note, part indicated may need to be loosened and slid down in slots to allow for motor to fit. Do not torque nuts at this stage			

3.1.2 Step 2 Order of Assembly

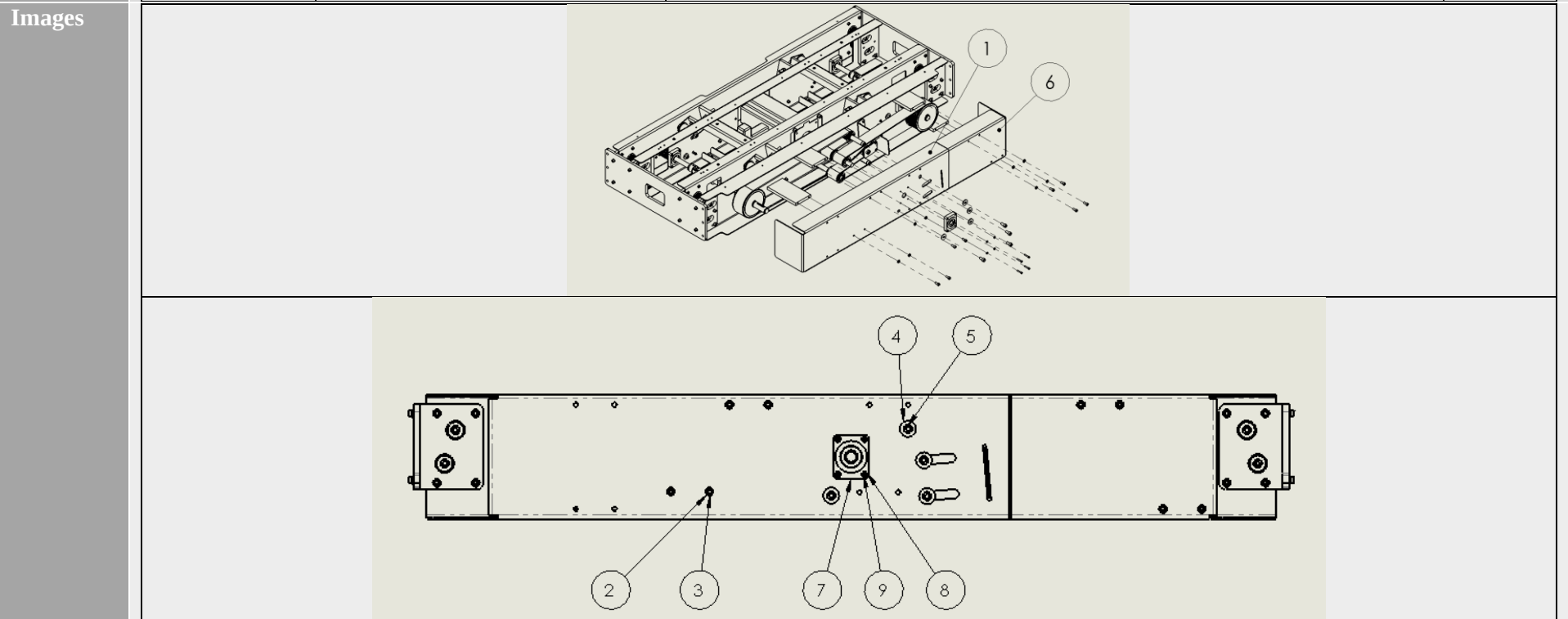
BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-200-2724	END WALL PLATE SUBASSY	2
	2	91292A138	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 25mm	8
	3	93475A250	18-8 Stainless Steel Washer for M6 Screw Size, 6.4 mm ID, 12 mm OD	24
	4	91292A073	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 22mm	16
Images				
				
Directions	• Assemble as shown. • Use Single Drop of Loctite for Item 2 and 4 • Lightly install item 4 on all 4 sides first. • Lightly install item 2. Loosen all bolts from previously installed step (circled in red). • Tighten finger tight bolts in order of 1 through 6. Then tighten bolts in order 1 through 6 hand tight. Then Torque bolts in order 1 through 6 to 69 in-lbs. • Then Torque down bolts 7-10 in and order (Bolts 7 and 8 shown, 9 and 10 on opposite face not shown) • Repeat to all four corners			

3.1.3 Step 3 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-300-2727	SUPPORT U BRACKET	4
	2	91828A241	18-8 Stainless Steel Hex Nut, M5 x 0.8 mm Thread	16
	3	93475A240	18-8 Stainless Steel Washer for M5 Screw Size, 5.3 mm ID, 10 mm OD	16
Images				
				
Directions	• Assemble as shown. • Item 1 goes on the inside edge of the flange, not the outer edge. • Assemble both the top side and bottom side • Once all U Brackets Installed • Torque Set Screw of Coupler to 55in-lbs • Move indicated part up so it is in contact with the motor and torque nuts down 15in-lbs			

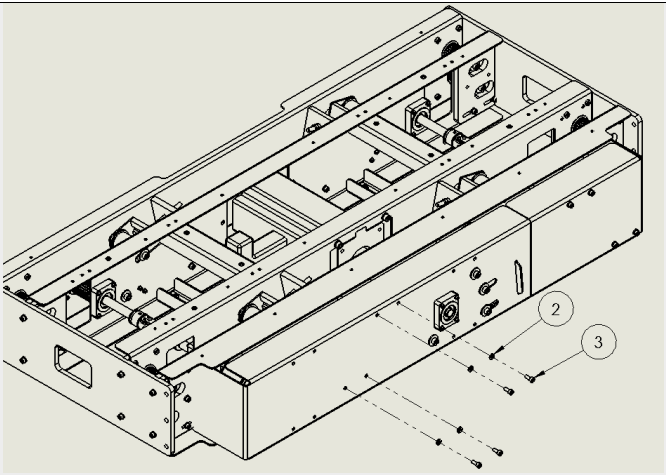
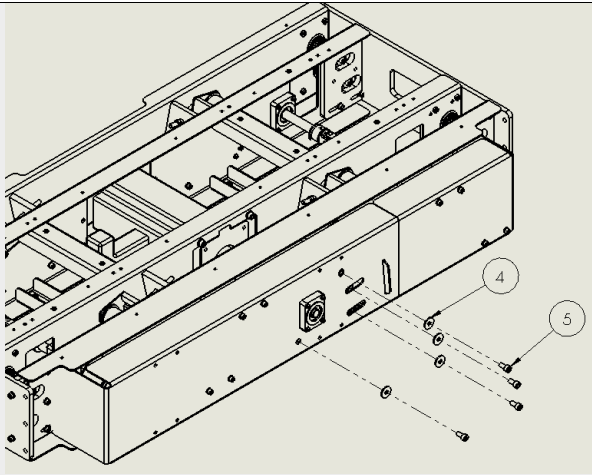
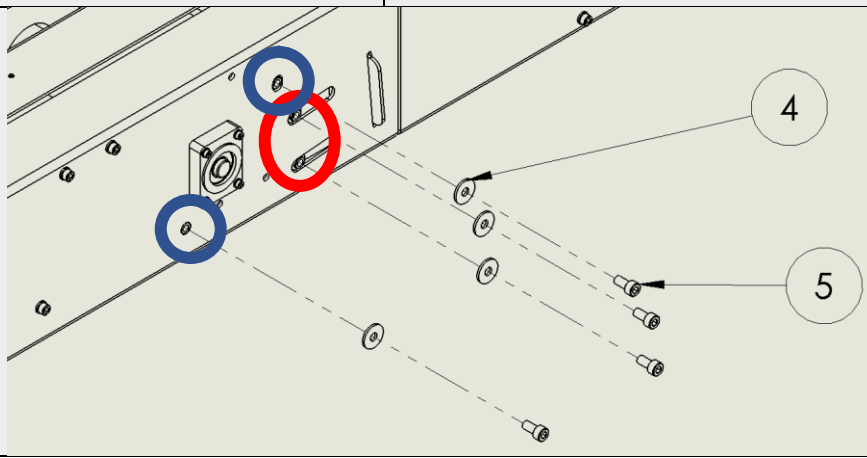
3.1.4 Step 4 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	1	2-300-2708	DRIVE BELT C BRACKET, LOAD WALL	1
	2	93475A250	18-8 Stainless Steel Washer for M6 Screw Size, 6.4 mm ID, 12 mm OD	12
	3	91292A070	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 14mm	8
	4	91100A160	Zinc-Plated Steel Oversized Washer for M8 Screw Size, 8.4 mm ID, 24 mm OD	4
	5	91292A145	18-8 Stainless Steel Socket Head Screw, M8 x 1.25 mm Thread, 16 mm Long	4
	6	2-300-2709	DRIVE WALL COVER, NO LOAD	1
	7	2-200-2697	BEARING BLOCK SUBASSEMBLY	1
	8	93475A230	18-8 Stainless Steel Washer for M4 Screw Size, 4.3 mm ID, 9 mm OD	4
	9	91292A806	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 22mm	4

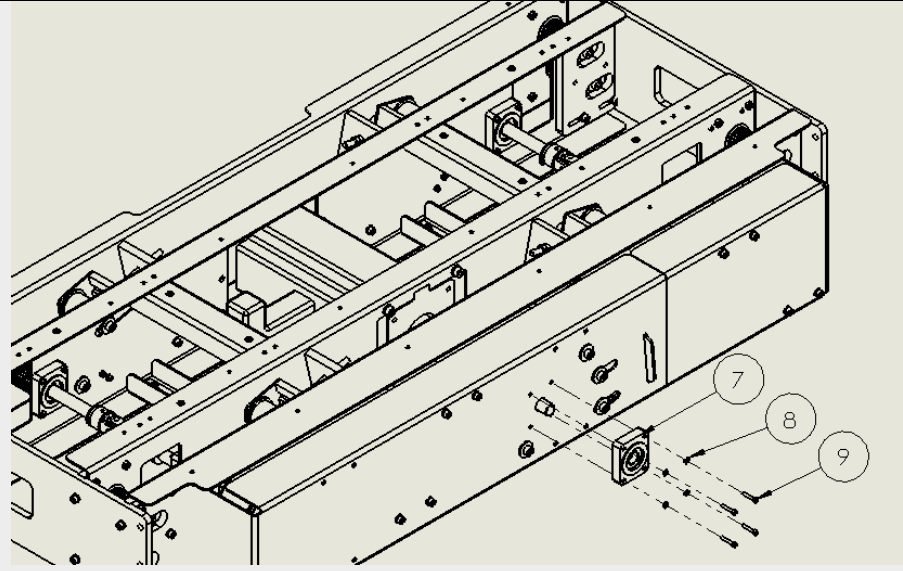
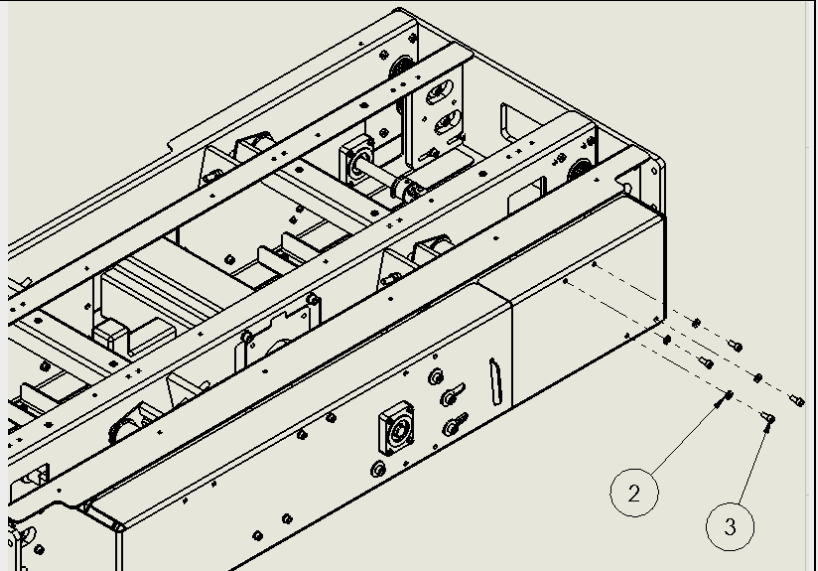


Directions	- Assemble as shown. - Follow sub steps on next slides
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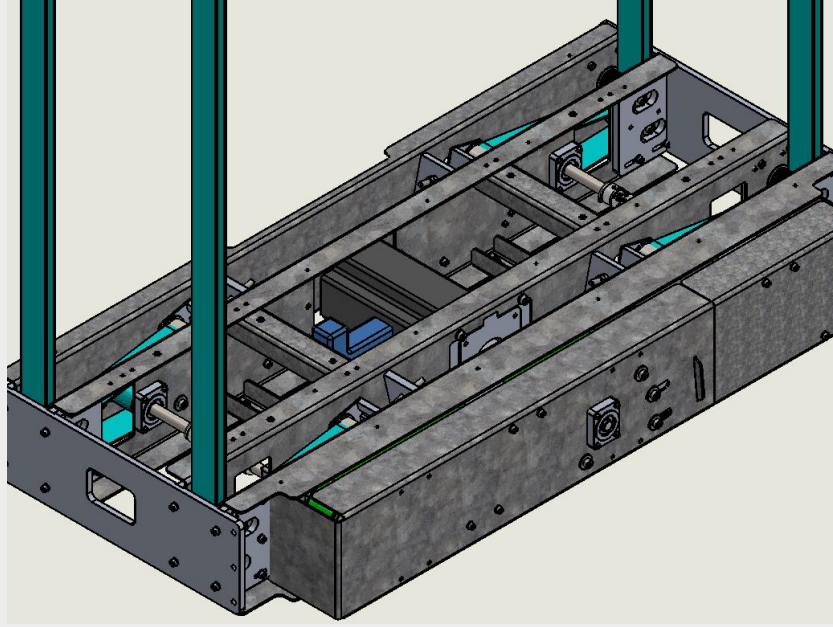
3.1.5 Step 4.1 Order of Assembly

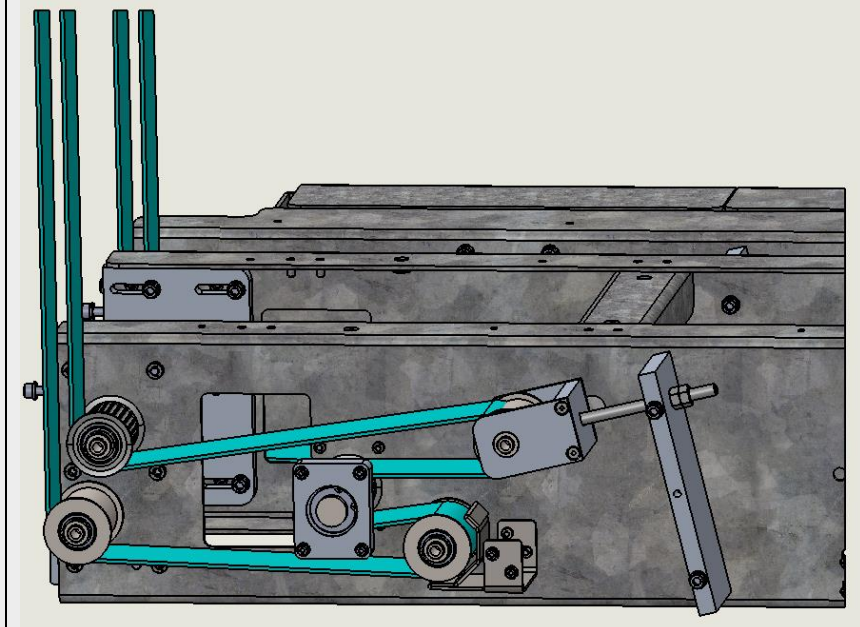
BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	2	93475A250	18-8 Stainless Steel Washer for M6 Screw Size, 6.4 mm ID, 12 mm OD	4
	3	91292A070	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 14mm	4
	4	91100A160	Zinc-Plated Steel Oversized Washer for M8 Screw Size, 8.4 mm ID, 24 mm OD	4
	5	91292A145	18-8 Stainless Steel Socket Head Screw, M8 x 1.25 mm Thread, 16 mm Long	4
Images				
				
Directions				
	• Assemble as shown. • Repeat to both sides • Torque Requirement Blue Circled Bolt – 169in-lbs • Torque Requirement Red Circled Bolt – 10in-lbs • Use Single Drop of Loctite			

3.1.6 Step 4.2 Order of Assembly

BOM for 1 unit	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	2	93475A250	18-8 Stainless Steel Washer for M6 Screw Size, 6.4 mm ID, 12 mm OD	2
	3	91292A070	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M6 X 1mm, 14mm	2
	7	2-200-2697	BEARING BLOCK SUBASSEMBLY	1
	8	93475A230	18-8 Stainless Steel Washer for M4 Screw Size, 4.3 mm ID, 9 mm OD	4
	9	91292A806	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M4 X .7mm, 22mm	4
Images				
				
Directions	• Assemble as shown. • Repeat to both sides			

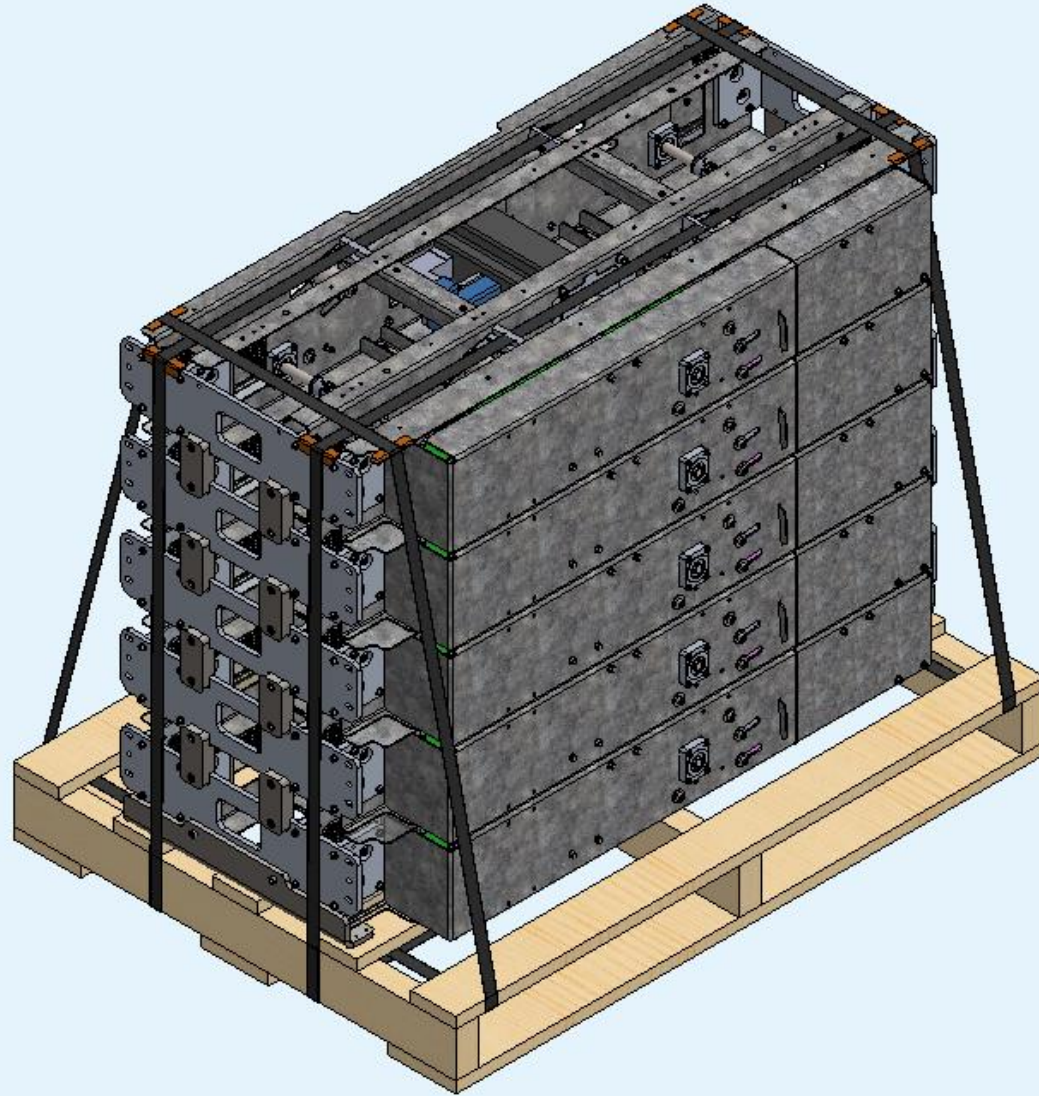
3.1.7 Step 5 Order of Assembly

BOM for 1 unit	PART NUMBER 2-300-2773	DESCRIPTION ELEVATOR TIMINGBELT	QTY. 4
Images			
Directions	This step occurs upon installation. Disregard during subassembly at vendor.		



4 Shipping

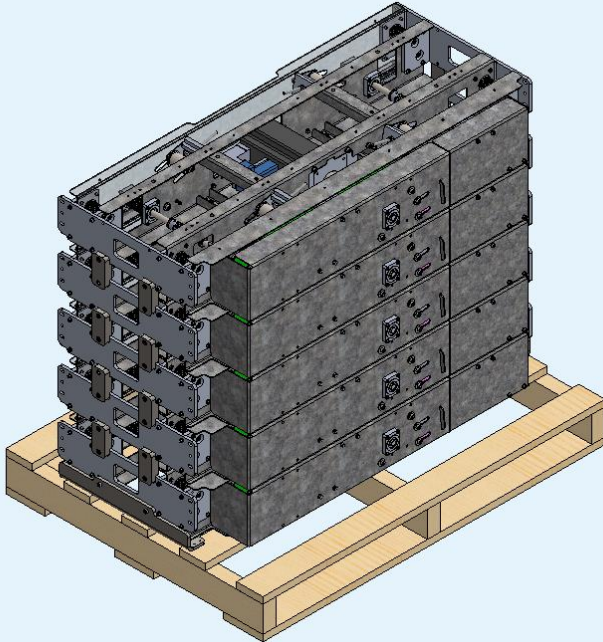
Overview

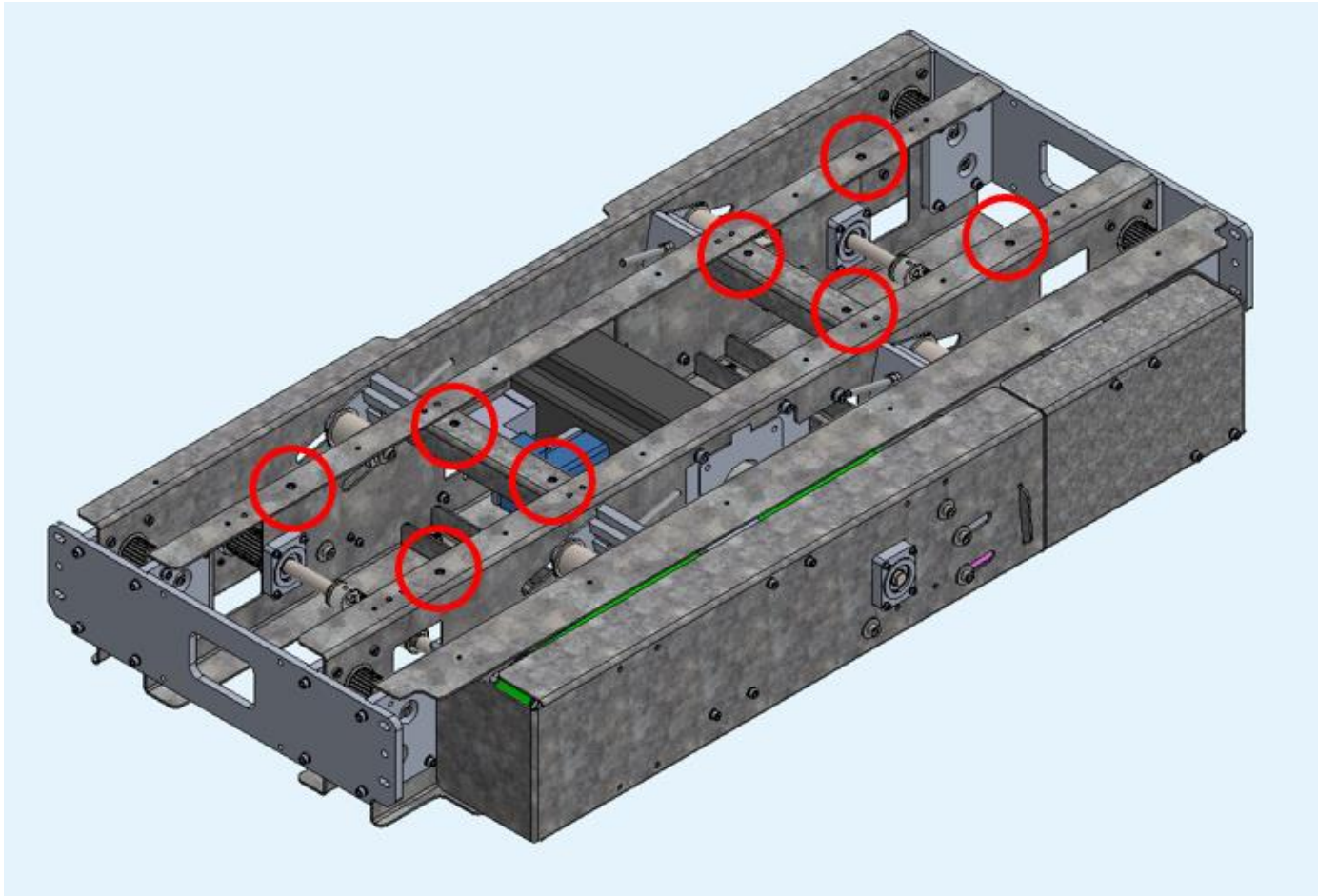


Description

- Stack motorboxes onto pallet

4.1 2-200-2768 – Shipping Assembly**Qty to Build: 1****Danger: Heavy Lift**

Tools	DESCRIPTION		
	Metric Allen Keys, Drill and bits, Wrench Set, Loctite, Torque Wrench		
BOM for Qty 1	PART NUMBER	DESCRIPTION	QTY.
	2-200-2767	FINALIZED STRUCTURE, SHIPPING, NO COVER	5
	MECHANISM PALLET	VLS MIDDLE WALL PALLET	1
	2-500-3194	MOTORBOX SHIPPING BRACKET	16
	2-500-3215	MOTORBOX SHIPPING BRACKET, BOTTOM BASE	2
	91292A147	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M8 X 1.25mm, 20mm	36
Final Assembly			
Notes	• It is acceptable to build less than 5 high. It is NOT ACCEPTABLE to build more than 5 high. Damage may occur to bottom most component in shipping if that is done • Very Heavy, wear steel toe shoes. • 1 Motorbox = 83kg • 1 Pallet of Motorbox = 913 kg • Use lifting points with hoist rings for lifting. Minimum of 4 lifting points must be used, at the locations with components similar to below. The lifting interface nut is an M8x1.25		



Forged Steel Hoist Ring for Lifting
 M8 x 1.25 Thread Size, 98mm Overall Height



Forged Black-Oxide Steel



180° Pivot



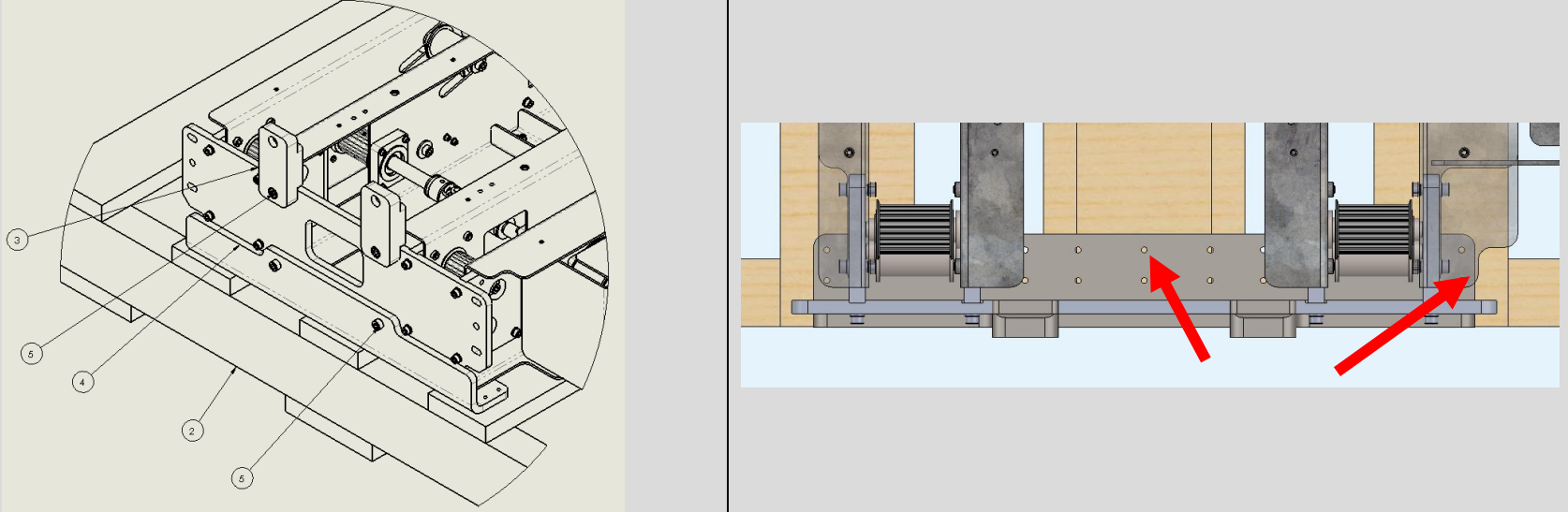
360° Swivel



30° Lift Angle

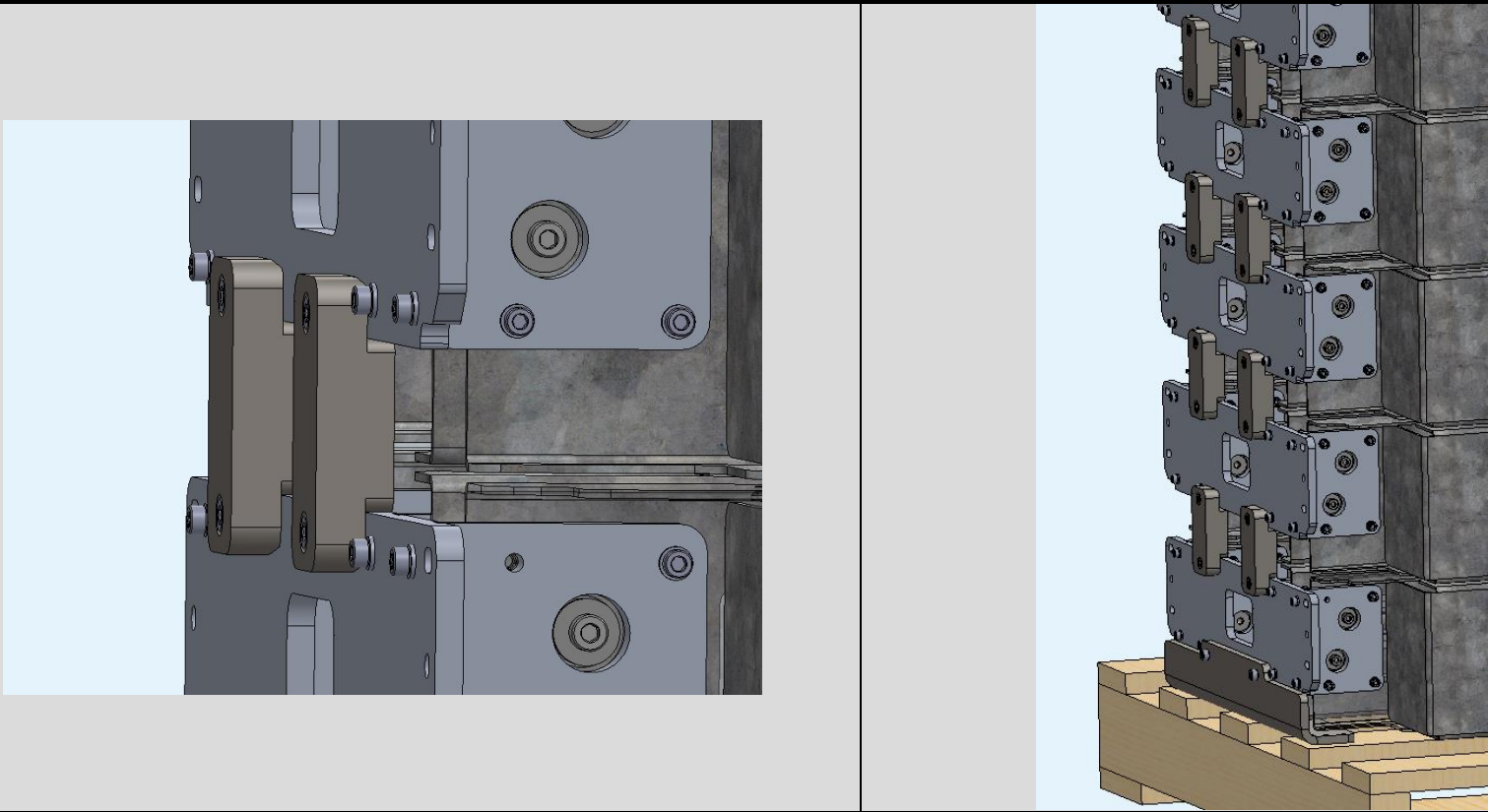
4.2 2-200-2768 – Shipping Assembly

Qty to Build: 1 **Danger:** Heavy Lift

Tools	DESCRIPTION			
	Metric Allen Keys, Wood Screws, Hoist Ring			
BOM on this Step	Item Number	PART NUMBER	DESCRIPTION	QTY.
	1	2-200-2767	FINALIZED STRUCTURE, SHIPPING, NO COVER	1
	2	MECHANISM PALLET	VLS MIDDLE WALL PALLET	1
	3	2-500-3194	MOTORBOX SHIPPING BRACKET	4
	4	2-500-3215	MOTORBOX SHIPPING BRACKET, BOTTOM BASE	2
	5	91292A147	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M8 X 1.25mm, 20mm	8
Step Image				
Notes	• Attach the 2-500-3215 Bottom Base Bracket to a Motorbox assembly on both sides • Place centered on a pallet in both directions • Insert wood screws through the Bottom Base Bracket in as many locations as possible • Attach QTY 4 2-500-3194 Shipping Brackets to the Motorbox assembly as shown			

4.3 2-200-2768 – Shipping Assembly

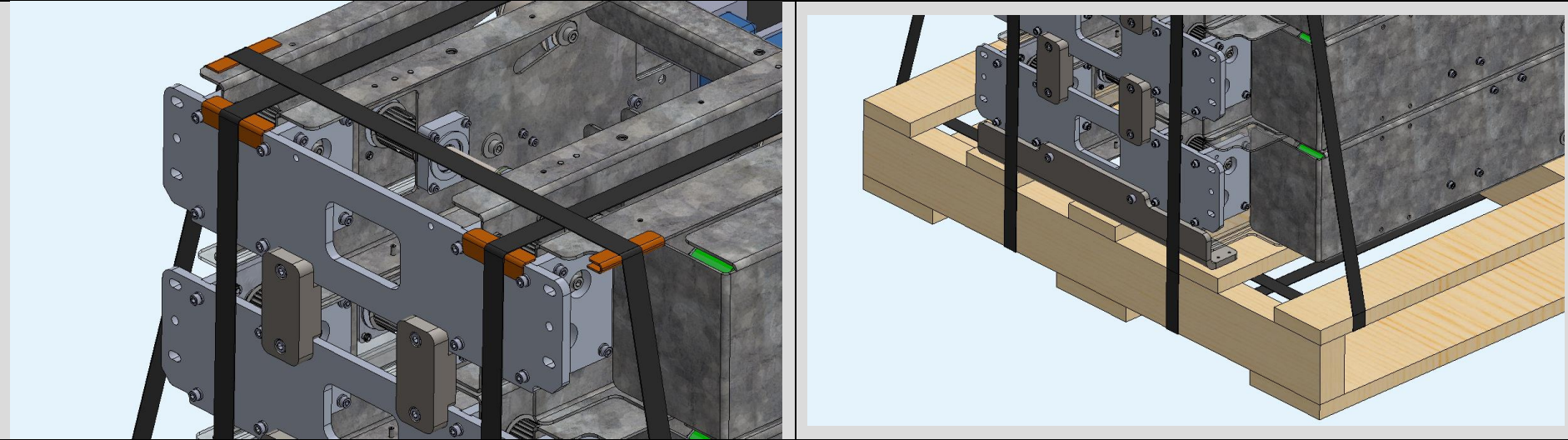
Qty to Build: 1 **Danger:** Heavy Lift

Tools	DESCRIPTION			
	Metric Allen Keys, Hoist Ring			
BOM on this Step	Item Number	PART NUMBER	DESCRIPTION	QTY.
	1	2-200-2767	FINALIZED STRUCTURE, SHIPPING, NO COVER	4
	2			
	3	2-500-3194	MOTORBOX SHIPPING BRACKET	12
	4			
	5	91292A147	18-8 STAINLESS STEEL SOCKET HEAD SCREW, M8 X 1.25mm, 20mm	28
Step Image				
Notes	- Set the next motorbox down on top of the first set of shipping brackets and bolt all 4 bolts into the motorbox - Attach another set of 4 shipping brackets on top of the 2nd motorbox - Continue until you have a stack of 5 motorboxes			

4.4 2-200-2768 – Shipping Assembly

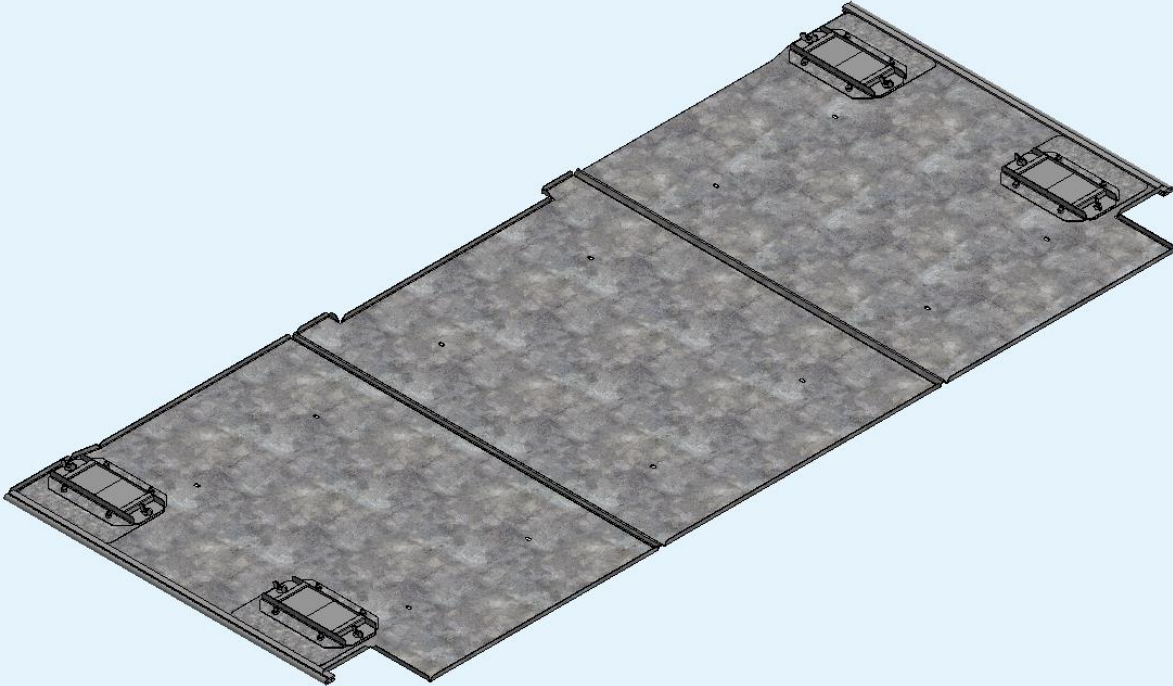
Qty to Build: 1

Danger: Heavy Lift

Tools	DESCRIPTION			
	Packing Materials			
BOM on this Step	Item Number	PART NUMBER	DESCRIPTION	QTY.
	1			
Step Image				
Notes	• Add Cardboard corners to the locations as shown, both sides • Wrap entire stack in cardboard sheet and secure with tape, including the top side • Include an additional features as it makes sense for this shipment. • Add pallet straps as shown, both sides. Do not overtighten straps.			

4.5 Shipping Covers and Cover Assemblies

Qty to Build: 1 Danger: None

Tools	DESCRIPTION			
	Packing Materials			
BOM on this Step	Item Number	PART NUMBER	DESCRIPTION	QTY.
	1	2-200-2765	Right Cover Assembly	
	2	2-200-2766	Left Cover Assembly	
	3	2-300-2730	Middle Cover	
Step Image				
Notes	Ship these components wrapped in foam as the vendor sees acceptable			

Congratulations Build Finished!

Overview



Description

- Great Job.

5 Tool Table

DESCRIPTION	IMAGE
Metric Allen Keys	
Snap ring pliers	
Wrench Set	
Loctite	
Impact drill	
Drill	
Ratchet Set	
Hammer	
Screwdriver set	
Small Arbor Press	
Torque Wrench	

[illegible]

7 PPE Table

DESCRIPTION	IMAGE
	
Hearing Protection	
Gloves	
Face Mask	
Steel Toe	

8 BOM Subassemblies

PART NUMBER	DESCRIPTION	QTY.
2-200-2691	ELEVATOR BELT TENSIONER SUBASSEMBLY	4
2-200-2697	BEARING BLOCK SUBASSEMBLY	10
2-200-2699	IDLER, FLAT BELT, 60MM DIAM, SUBASSY	13
2-200-2701	IDLER, 24 TEETH, 55MM WIDE, SUBASSY	7
2-200-2717	DRIVE BELT TENSIONER SUBASSEMBLY	1
2-200-2724	END WALL PLATE SUBASSY	2
2-200-2752	IDLER ON SHAFT, 24 TEETH	4
2-200-2753	IDLER ON SHAFT, FLAT	12
2-200-2754	MOTOR WALL SUBASSEMBLY	2
2-200-2757	DRIVE WALL SUBASSEMBLY	1
2-200-2758	IDLER ON SHAFT, LONG, 24 TEETH, OUTSIDE	1
2-200-2759	MOTOR WALL SUBASSEMBLY	1
2-200-2760	DRIVE I BEAM SUBASSEMBLY	1
2-200-2761	DRIVE BELT DRIVE SHAFT SUBASSEMBLY	1
2-200-2762	ELEVATOR DRIVE SHAFT SUBASSEMBLY	2
2-200-2763	DRIVEN SIDE SUBASSEMBLY	1
2-200-2764	ELEVATOR DRIVE SHAFT SUBASSEMBLY, DRIVEN SIDE	2
2-200-2765	RIGHT COVER SUBASSEMBLY	1
2-200-2766	LEFT COVER SUBASSEMBLY	1
2-200-2767	FINALIZED STRUCTURE, SHIPPING, NO COVER	1
2-200-2769	IDLER ON SHAFT, LONG, 24 TEETH, OUTSIDE	1
2-200-2770	DRIVE BELT TENSIONER SUBASSEMBLY, SMOOTH IDLER	1
2-200-2771	IDLER ON SHAFT, LONG, SMOOTH, OUTSIDE	1