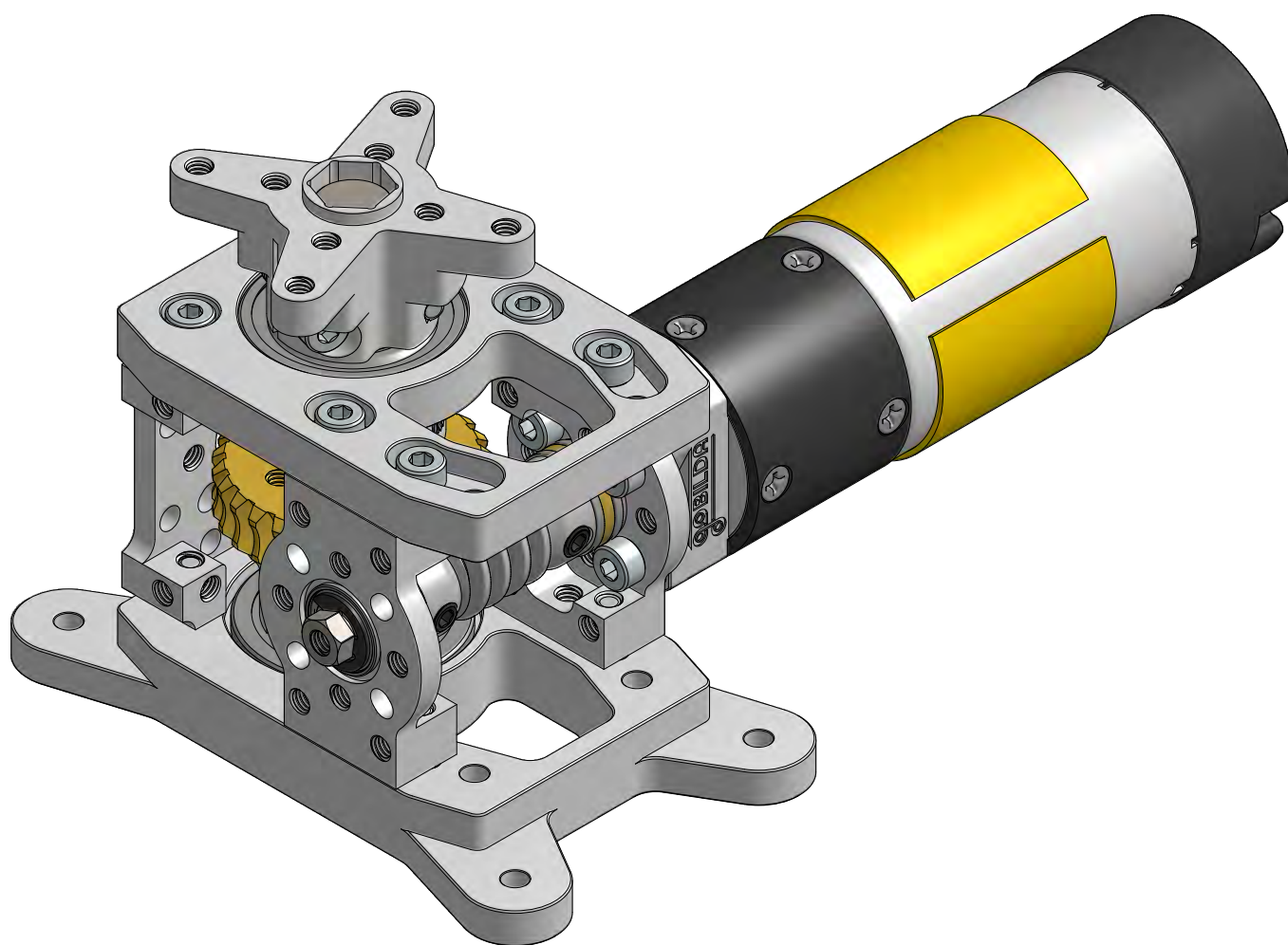


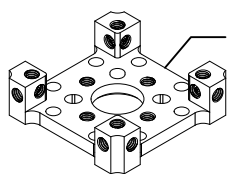
Assembly Instructions for **Super Duty Worm Drive Pan Kit (28:1 Ratio)**

SKU: 3208-0001-0028

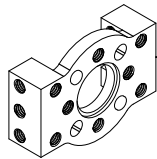


Motor Not Included

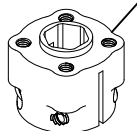
Kit Contents:



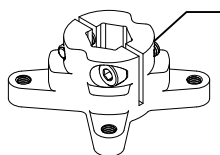
43-2 Quad Block Pattern Mount
SKU: 1201-0043-0002
QTY: 1



43-3 Quad Block Pattern Mount
SKU: 1201-0043-0003
QTY: 2



1310 Series Hyper Hub (12mm REX Bore)
SKU: 1310-0016-4012
QTY: 1



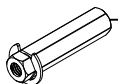
1313 Series Hyper Hub (12mm REX Bore)
SKU: 1313-1632-4012
QTY: 1



8mm REX Bore Flanged Ball Bearing
SKU: 1611-0514-4008
QTY: 2 (one 2 pack)



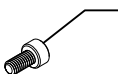
8mm Bore Thrust Bearing
SKU: 1613-0516-0008
QTY: 2



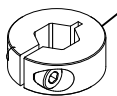
32mm Length 8mm REX Shaft
SKU: 2106-4008-0320
QTY: 1



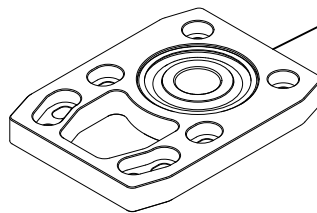
80mm Length 12mm REX Shaft
SKU: 2102-0012-0080
QTY: 1



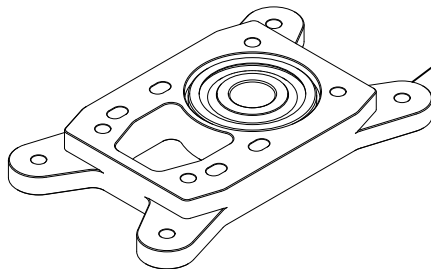
12mm Length M4 Screw
SKU: 2800-0004-0012
QTY: 25 (one 25 pack)



12mm REX Bore Clamping Collar
SKU: 2910-1026-4012
QTY: 1



Top Plate
SKU: 1115-0008-0001
QTY: 1
(with 1601-1032-0012 12mm
Bore Bearing pressed in)



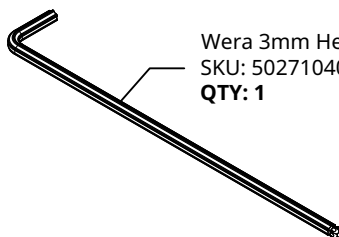
Bottom Plate
SKU: 1115-0012-0001
QTY: 1
(with 1601-1032-0012 12mm
Bore Bearing pressed in)



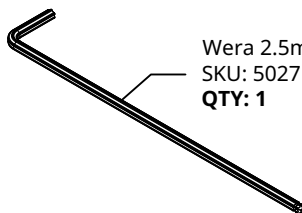
Worm
SKU: 2313-4008-0033
QTY: 1



Worm Gear
SKU: 2314-0014-0028
QTY: 1



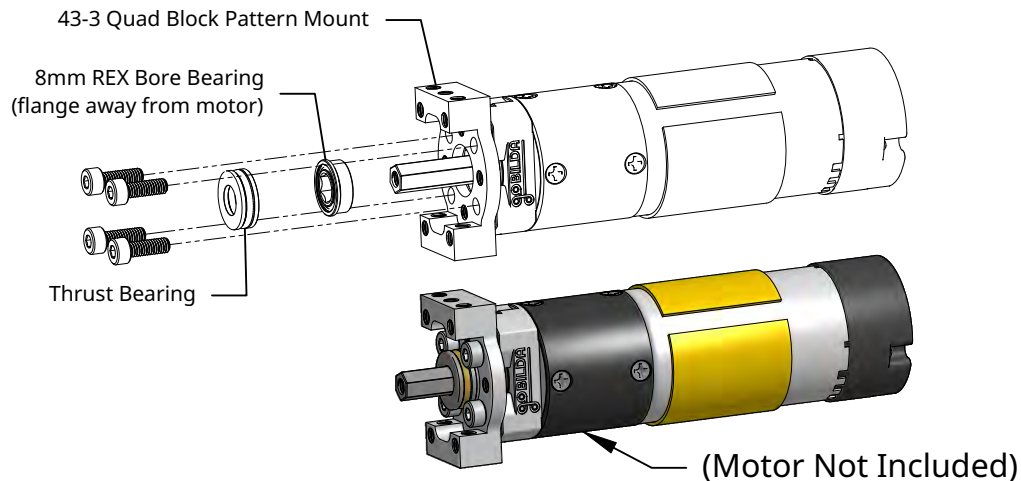
Wera 3mm Hex-Plus L-Key
SKU: 5027104001
QTY: 1



Wera 2.5mm Hex-Plus L-Key
SKU: 5027103001
QTY: 1

Step 1

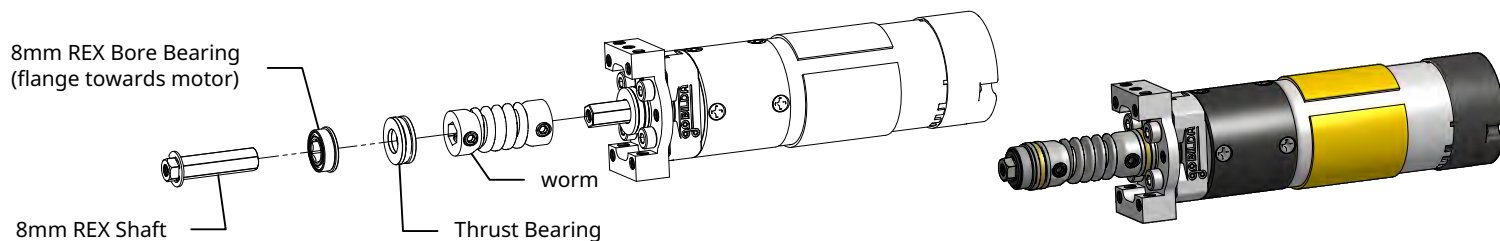
Use four screws to attach a 43-3 Quad Block Pattern Mount to a 5203 Series Yellow Jacket Planetary Gear Motor (not included). Keep the screws a little loose and insert an 8mm REX bore bearing followed by a thrust bearing. Now tighten the screws.



Step 2

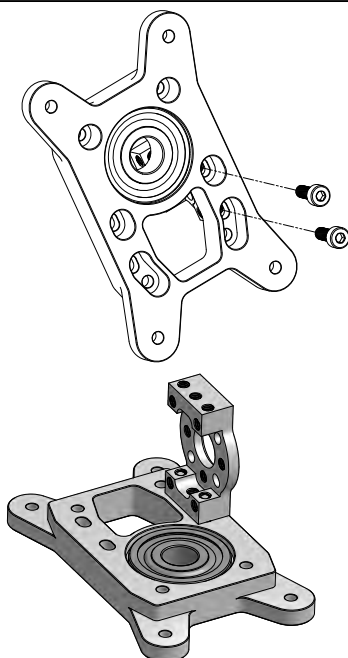
Add the worm to the Yellow Jacket's output shaft and tighten the set-screws closest to the motor.

Then slide the 8mm REX bearing onto the 8mm REX shaft, followed by the 8mm bore thrust bearing. Then slide the shaft into the open end of the worm and tighten the last two set-screws.



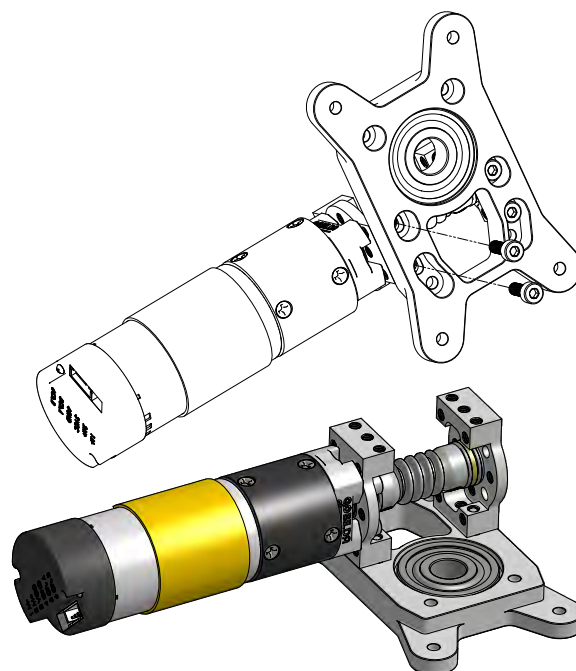
Step 3-A

Using 2 screws, bolt a 43-3 Quad Block Pattern Mount to the Bottom Plate. Keep the screws just a little loose for mesh adjustment later.



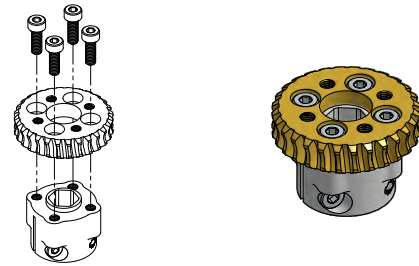
Step 3-B

Using 2 more screws, attach the assembly from Step 2 as shown. Also keep these screws a little loose for now.



Step 4

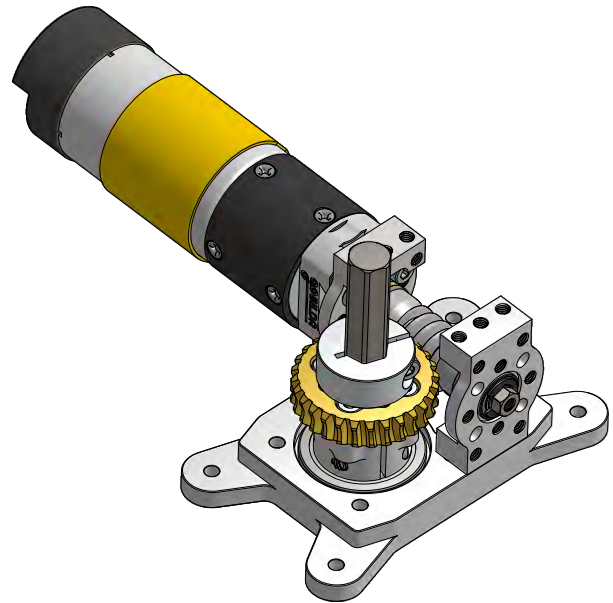
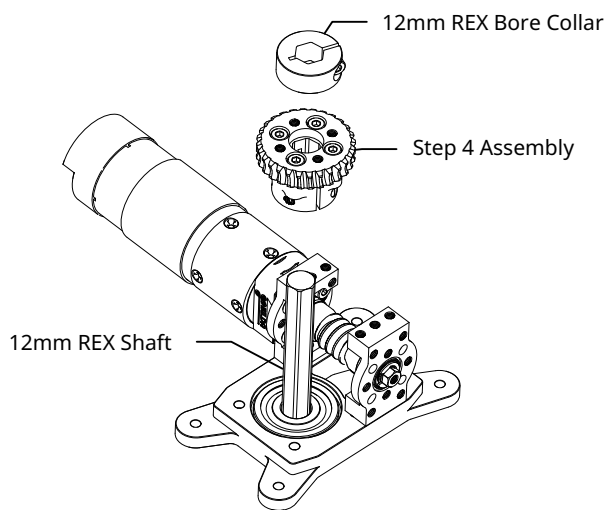
Use four screws to fasten the Worm Gear to the 1310 Series Hyper Hub. Put all four screw in loosely and then tighten them, going diagonally from one screw to the next.



Step 5

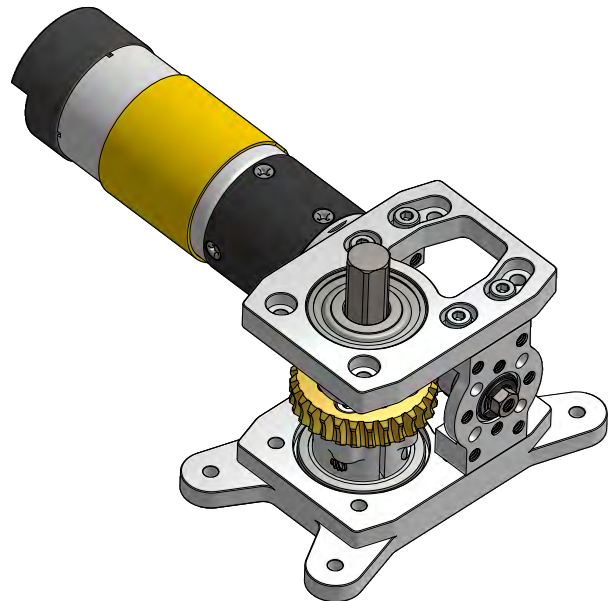
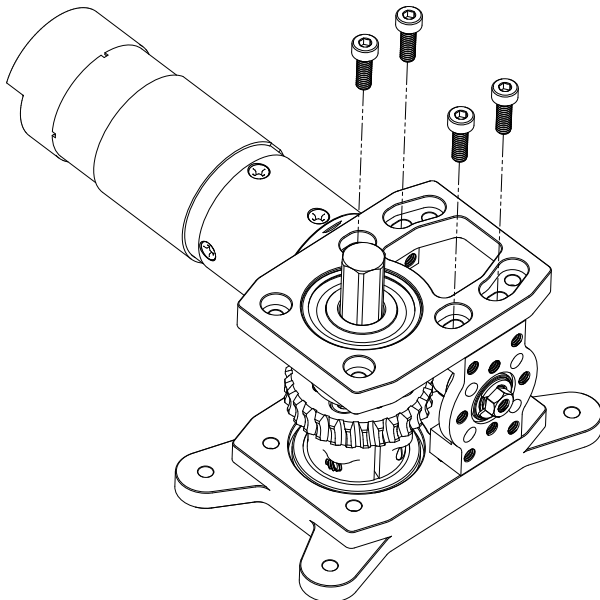
Stand the 12mm REX Shaft up in the bearing of the bottom plate. Slide the Step 4 Assembly onto the shaft followed by the 12mm REX Bore Collar. Ensure the bottom plate is flat on the table, hold the collar and pull the shaft up slightly (about 1-2mm). This prevents the shaft from rubbing on the surface that the kit is sitting on. While holding the shaft in this position, tighten the Hyper Hub's pinch bolts.

Pro Tip: Orient the collar such that the pinch bolt can be easily accessed from the front or back of the kit, this will make Step 8 easier.



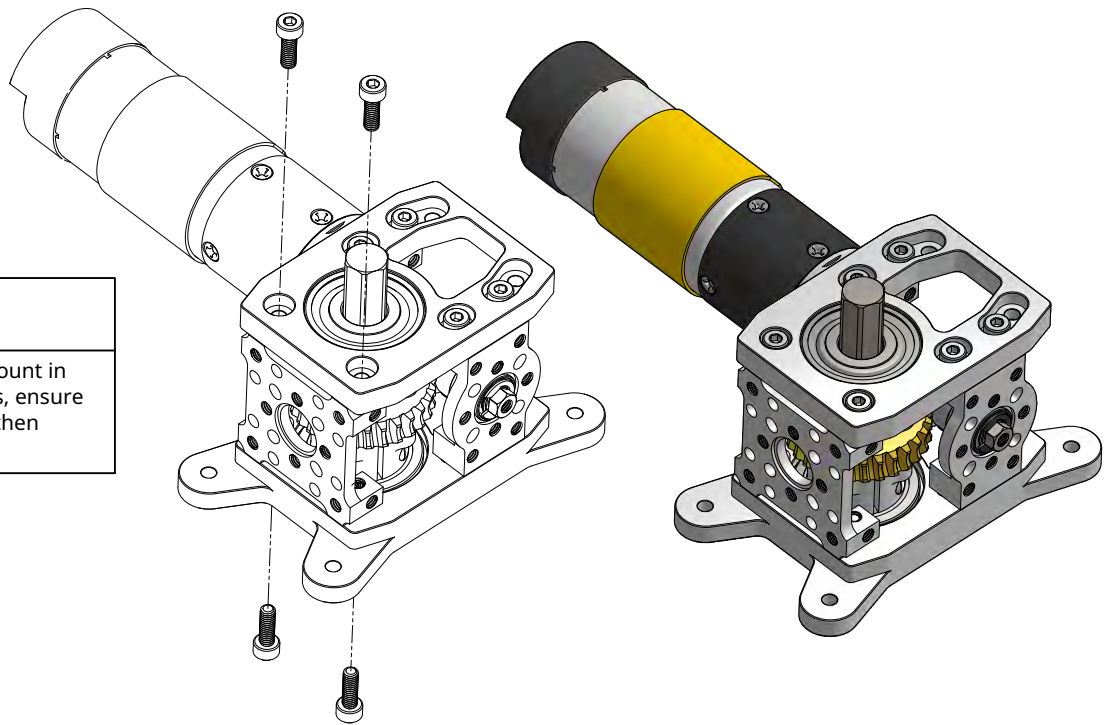
Step 6

Add the top plate to your assembly and fasten it with four screws. Leave the screws slightly loose for now.



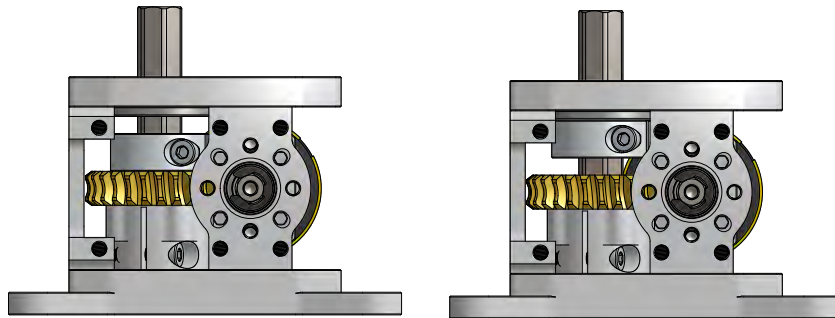
Step 7

Add the 43-2 Quad Block Pattern Mount in the side. Loosely add all four screws, ensure everything is aligned correctly and then tighten those four screws.



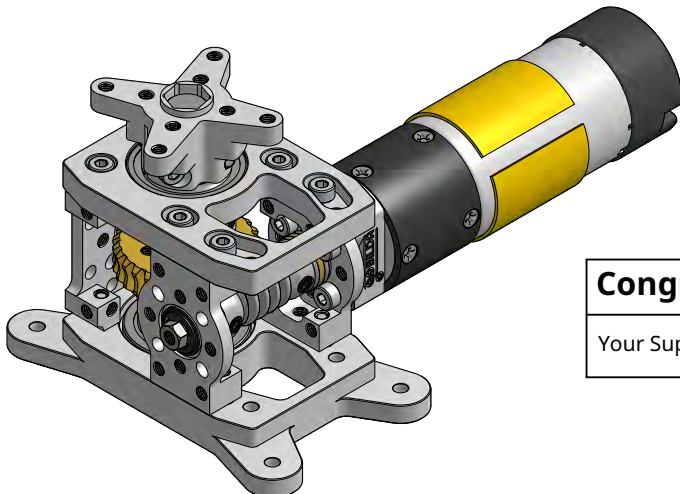
Step 8

Reach in and pull the 12mm REX Bore Clamping Coupler as far up as it will go. While holding it up, tighten the pinch bolt on the clamping collar. Now is the time to adjust the gear mesh. Once the mesh is as desired, tighten the screws that had previously been left loose.



Step 9

The last step is to add the 1313 Series Hyper Hub to the output shaft. Slide it down and tighten the pinch bolts.



Congratulations!

Your Super Duty Worm Drive Pan Kit is now ready to test out!