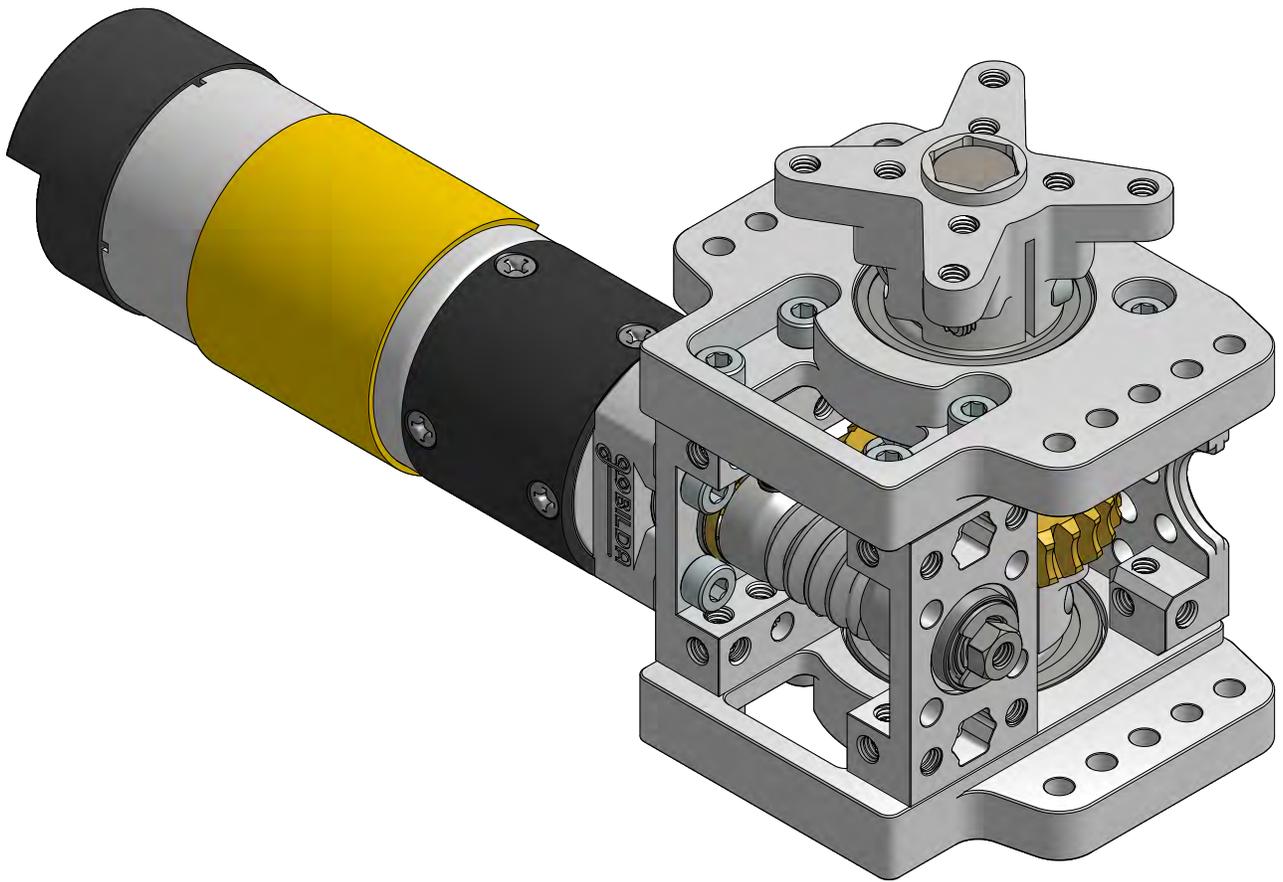
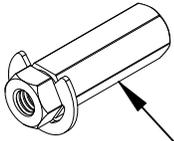


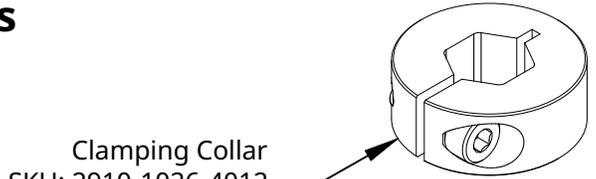
Assembly Instructions for  
**Super-Duty Worm Drive Gearbox**  
SKU: 3208-0002-0028



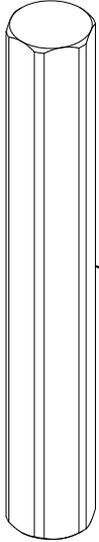
# Kit Contents



8mm REX Shaft  
SKU: 2106-4008-0240  
QTY: 1



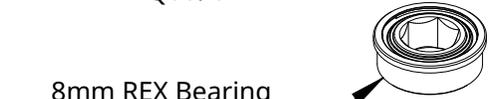
Clamping Collar  
SKU: 2910-1026-4012  
QTY: 1



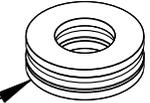
12mm REX Shaft  
SKU: 1202-0012-0080  
QTY: 1



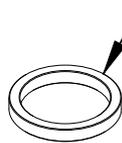
10mm Screw  
SKU: 2800-0004-0010  
QTY Included: 25 (1 Pack)  
QTY Used: 20



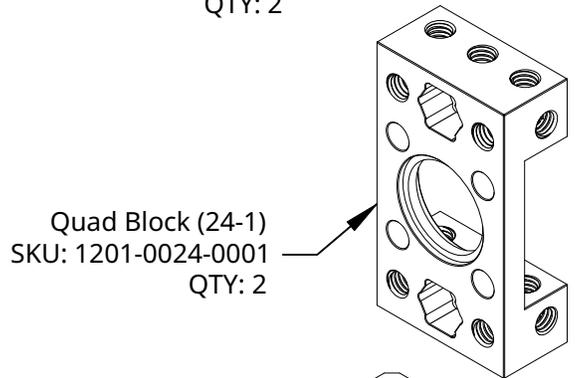
8mm REX Bearing  
SKU: 1611-0514-4008  
QTY: 2 (1 Pack)



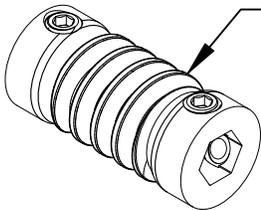
8mm Thrust Bearing  
SKU: 1613-0516-0008  
QTY: 2



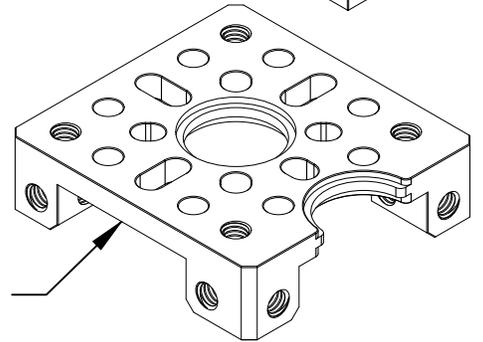
2mm Spacer  
SKU: 1515-0015-0020  
QTY Included: 4 (1 Pack)  
QTY Used: 1



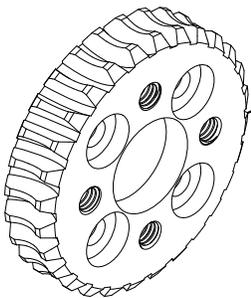
Quad Block (24-1)  
SKU: 1201-0024-0001  
QTY: 2



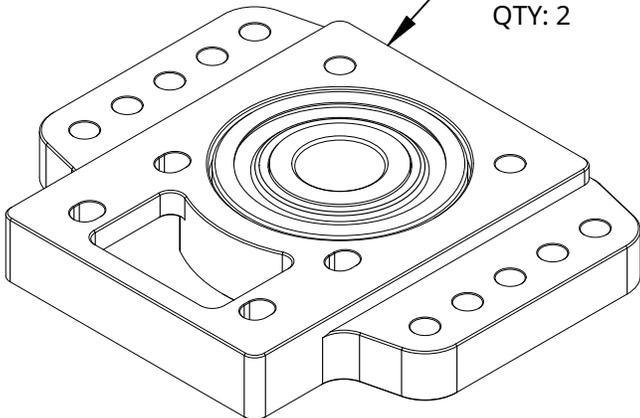
Worm  
SKU: 2313-4008-0033  
QTY: 1



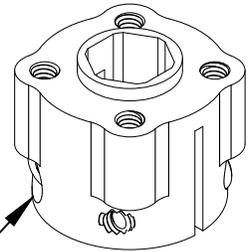
Quad Block (43-5)  
SKU: 1201-0043-0005  
QTY: 1



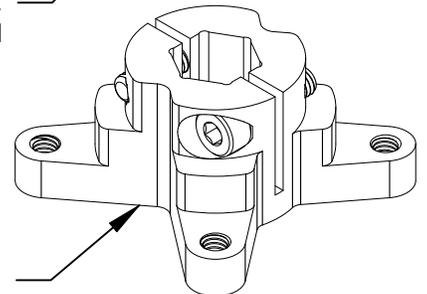
Worm Gear  
SKU: 2314-0014-0028  
QTY: 1



Gearbox Plate  
SKU: 1115-0105-0001  
QTY: 2



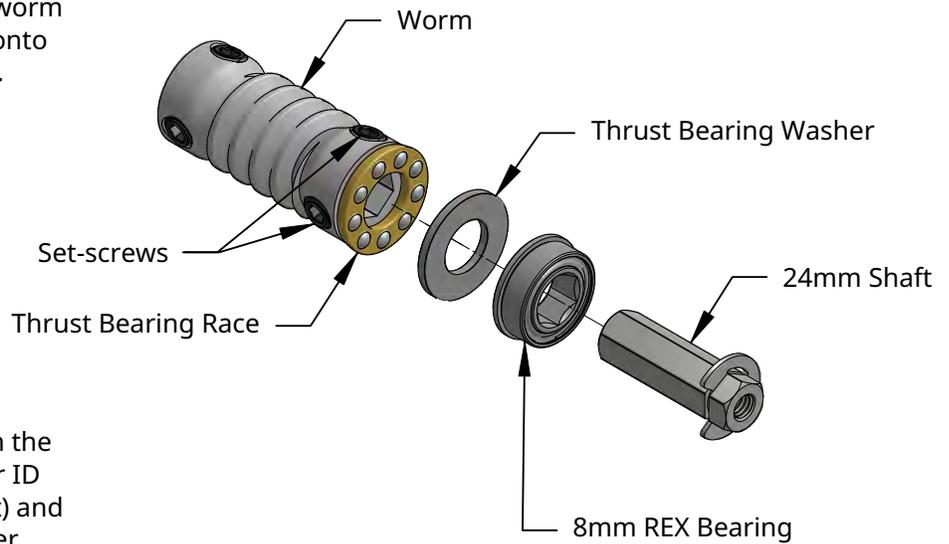
1310 Series Hyper Hub  
SKU: 1310-0016-4012  
QTY: 1



1313 Series Hyper Hub  
SKU: 1313-1632-4012  
QTY: 1

**Step 1:**

Install a bearing support assembly in one end of the Worm from your worm gear set. Tighten the set-screws onto the 24mm shaft after installation.

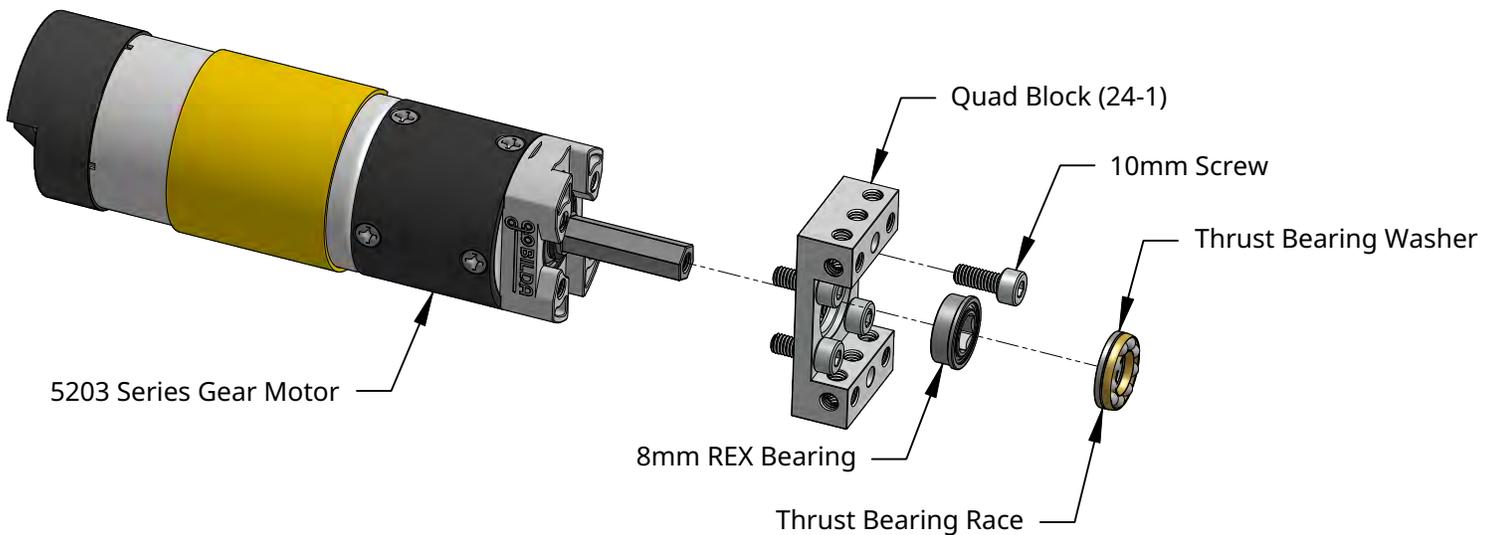


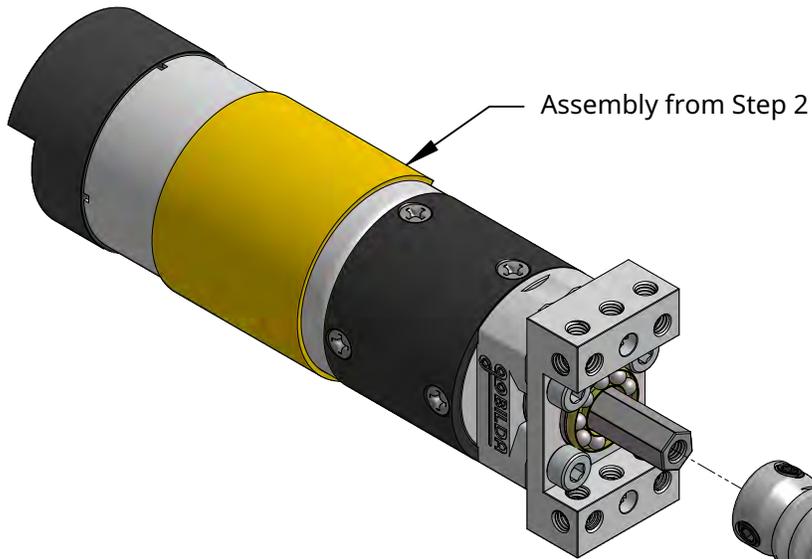
**Tech Tip:**

There are two washers included in the Thrust Bearing, one with a smaller ID (that should fit tightly on the shaft) and one with a looser ID. Use the looser washer in these two steps.

**Step 2:**

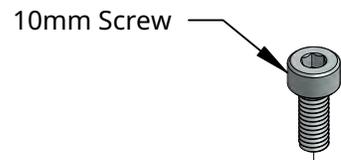
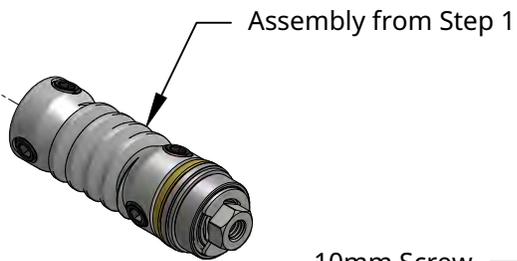
Bolt a Quad Block Mount (24-1) to the face of a 5203 Series Motor, then install an 8mm REX bearing, and 2/3rds of a Thrust Bearing.





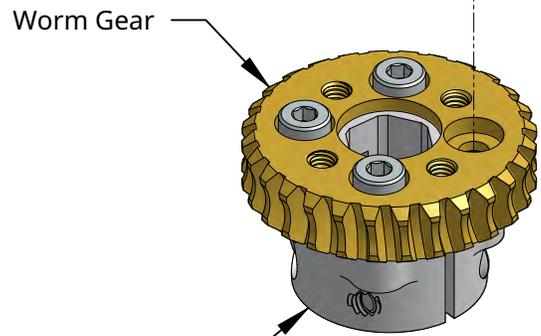
**Step 3:**

Install the assembly you made in step 1 onto the motor shaft. Push the Worm on the motor shaft as far as it will go and tighten the set-screws. Rotate the motor shaft as-needed to access the set-screws.



**Step 4:**

Bolt the Worm Gear to the 1310 Series Hyper Hub using 10mm screws. Make sure to put the hub on the side of the gear with a large counterbore.

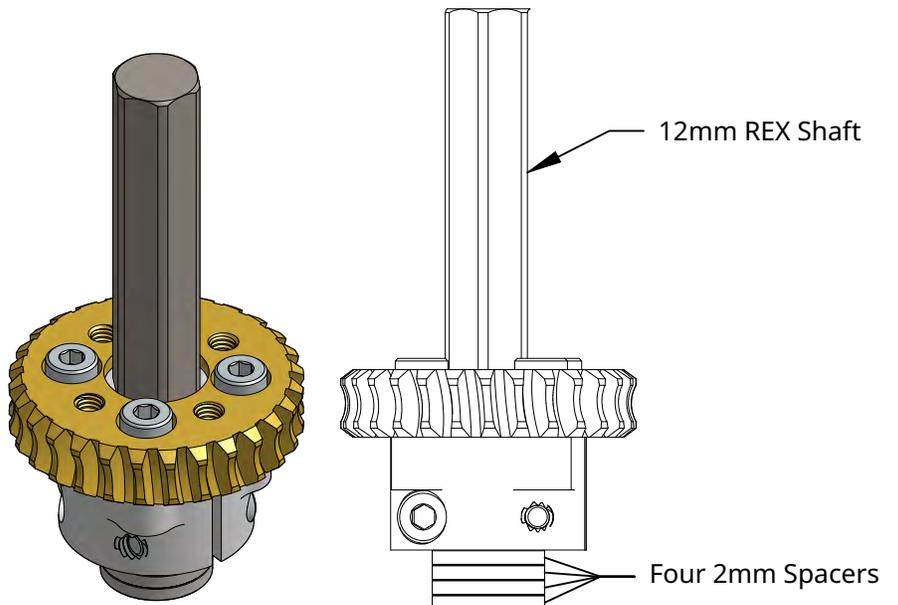


1310 Series Hyper Hub

**Step 5:**

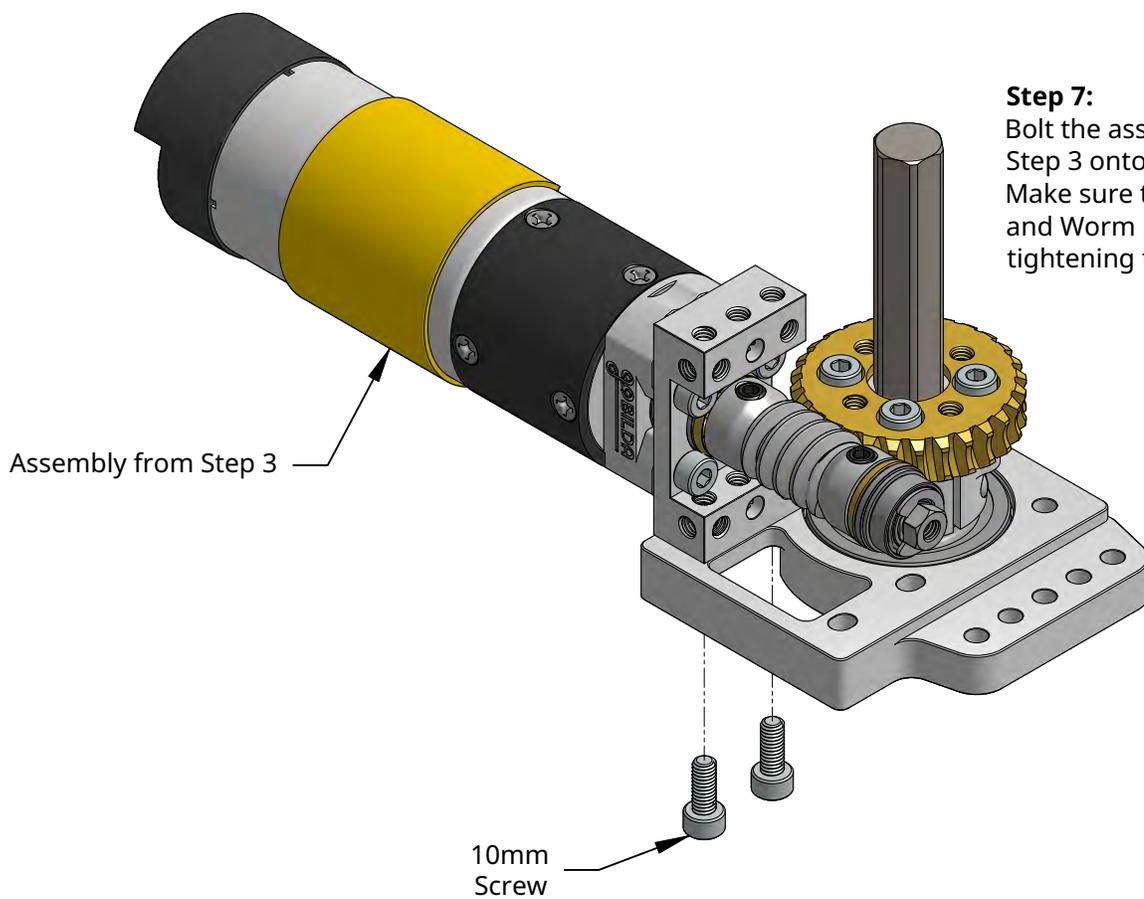
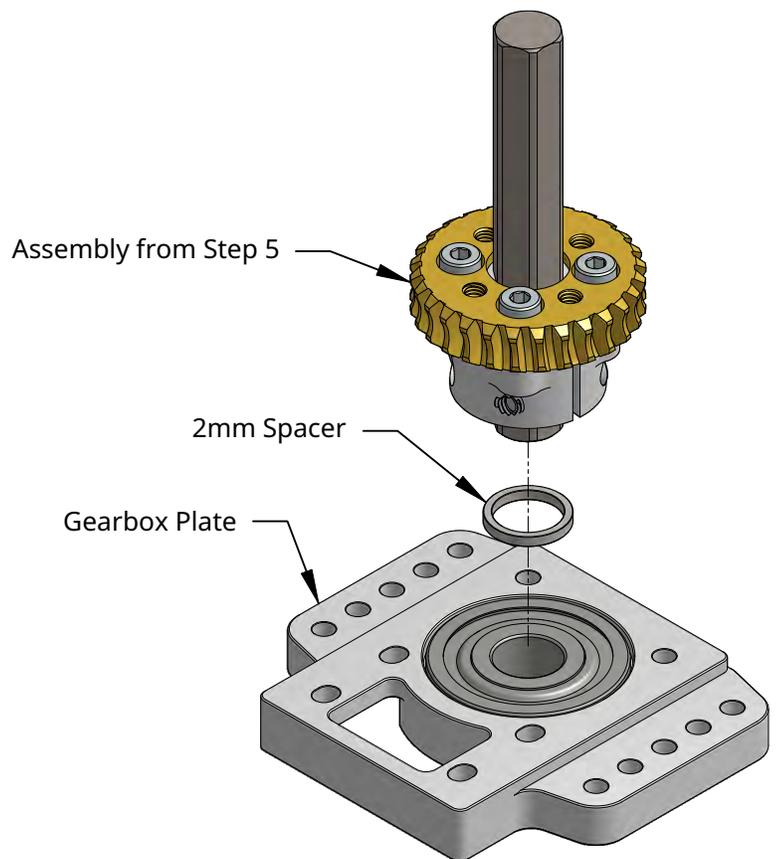
Insert the 12mm REX Shaft into the 1310 Series Hyper Hub.

The shaft needs to extend 8mm below the bottom of the hub. Use all 4 of the 2mm spacers as a measuring tool. Stack the spacers under the hub and make the shaft flush with the bottom of the last spacer, then tighten the pinch bolts on the Hyper Hub to lock the shaft in place.



**Step 6:**

Insert the assembly you created in Step 5 into the bearing on the Gearbox Plate, with only one 2mm spacer between the Hyper Hub and the Bearing.



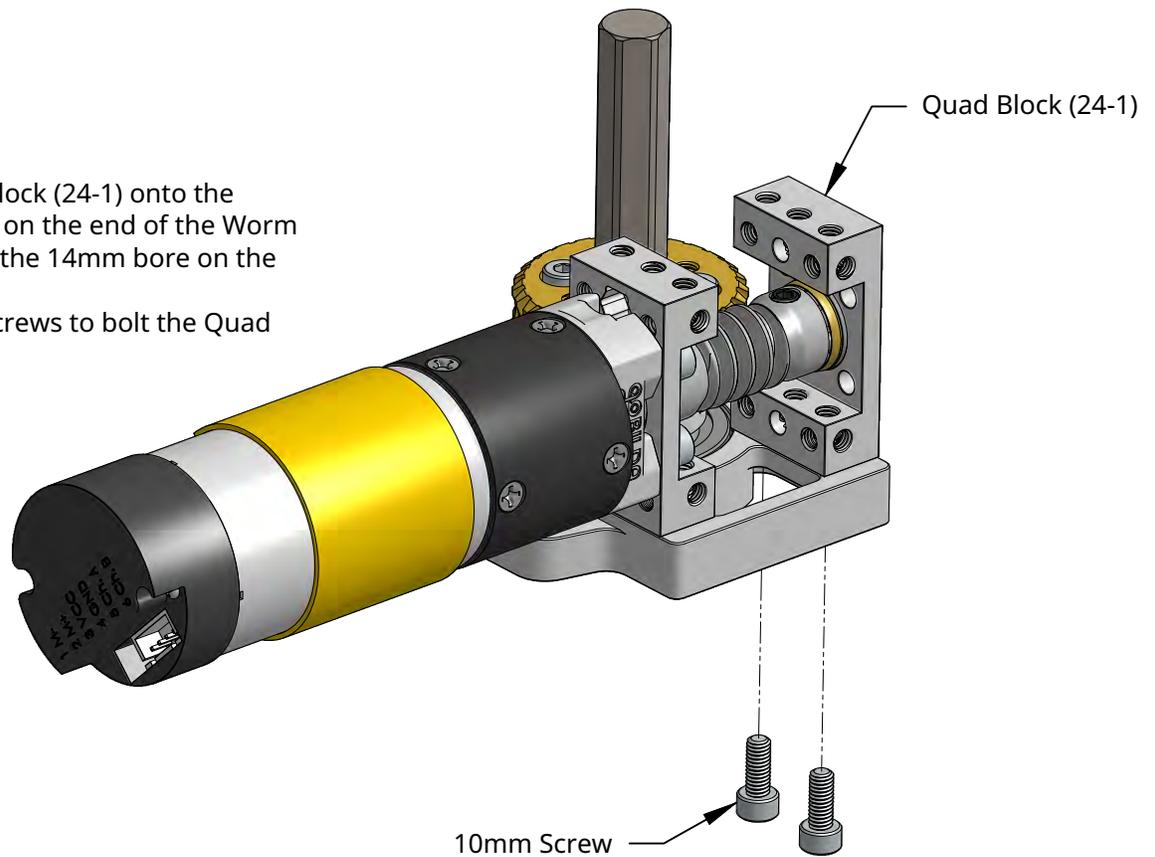
**Step 7:**

Bolt the assembly you made in Step 3 onto the Gearbox Plate. Make sure that the Worm Gear and Worm mesh before tightening the screws.

**Step 8:**

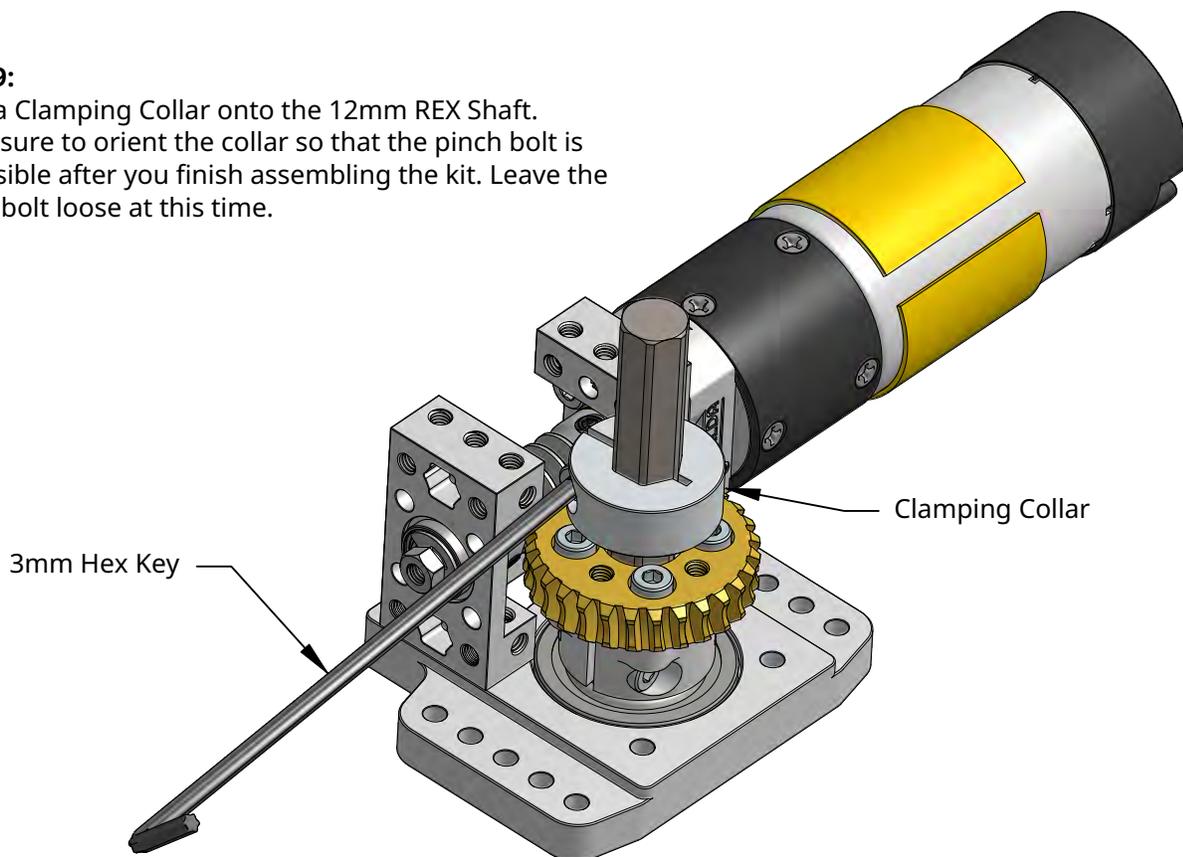
Slide a second Quad Block (24-1) onto the assembly, the bearing on the end of the Worm Gear should slide into the 14mm bore on the Quad Block (24-1).

Next use two 10mm Screws to bolt the Quad Block (24-1) in place.



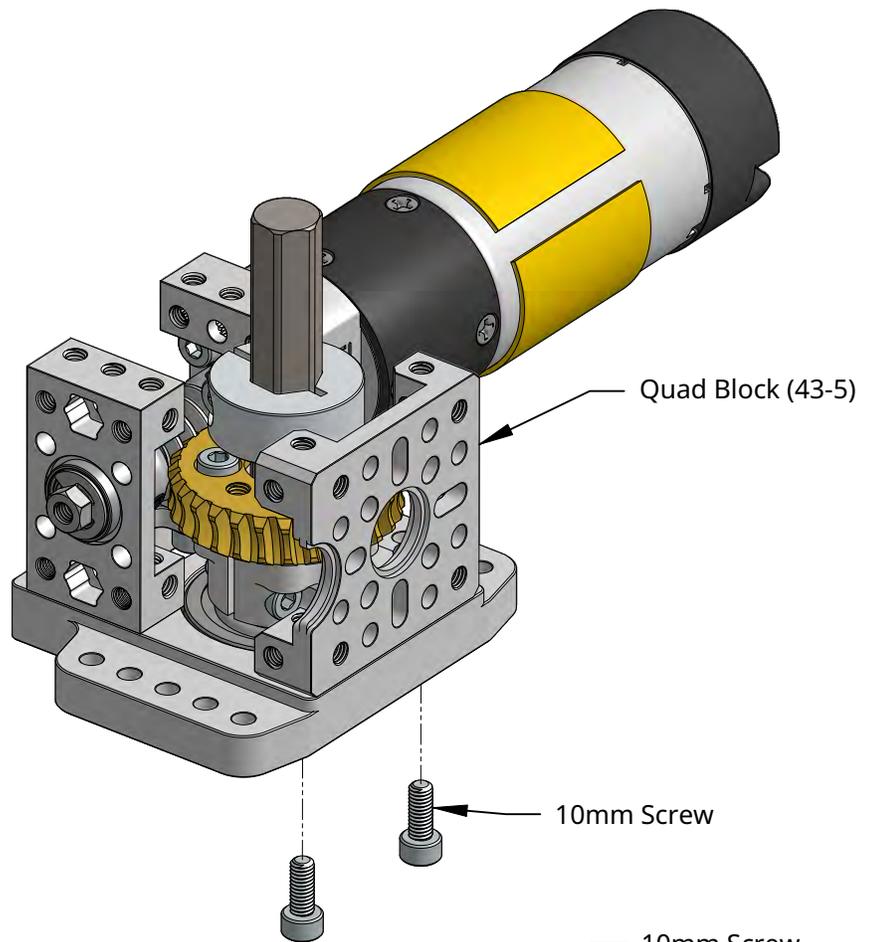
**Step 9:**

Slide a Clamping Collar onto the 12mm REX Shaft. Make sure to orient the collar so that the pinch bolt is accessible after you finish assembling the kit. Leave the pinch bolt loose at this time.



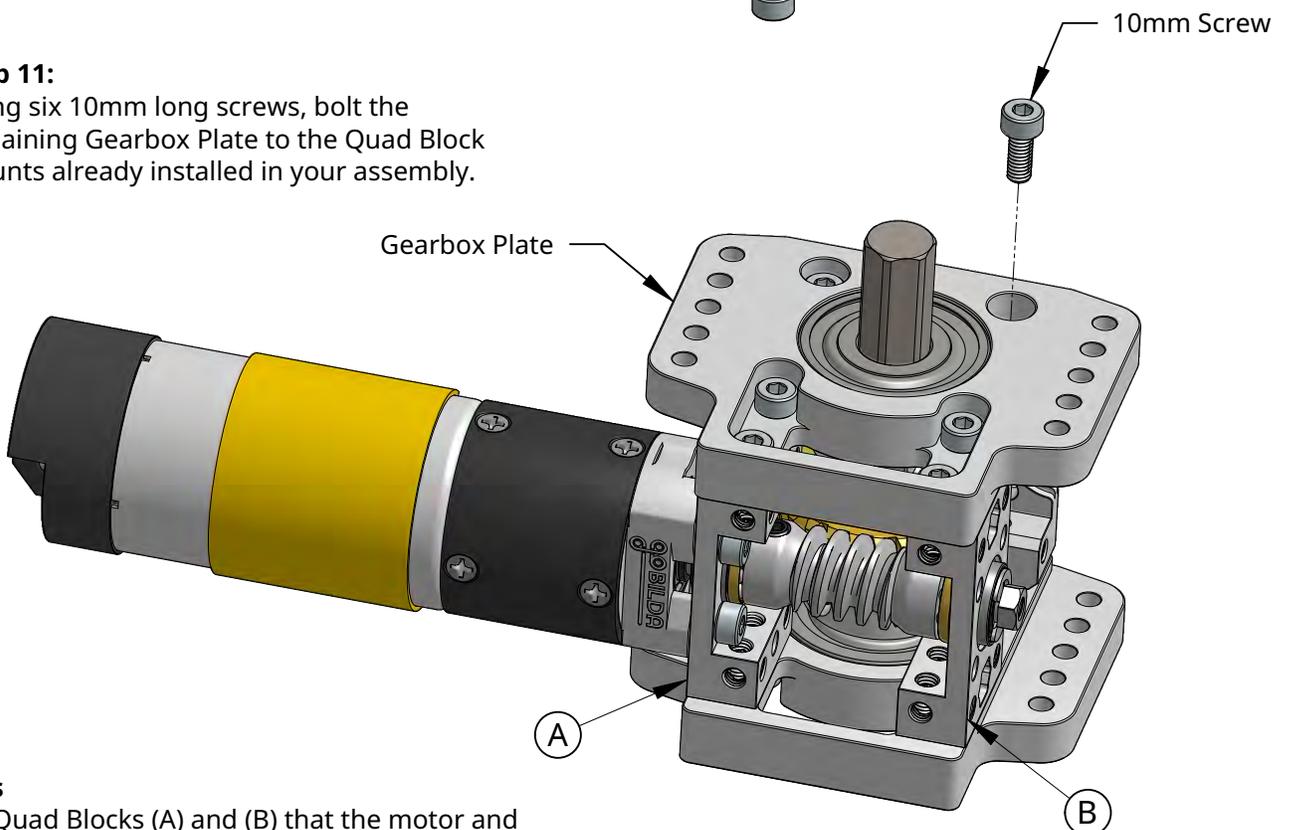
**Step 10:**

Install the Quad Block (43-5) onto the Gearbox Plate using 10mm screws. Take note of the orientation of the "1/2 hole". It should face away from the motor.



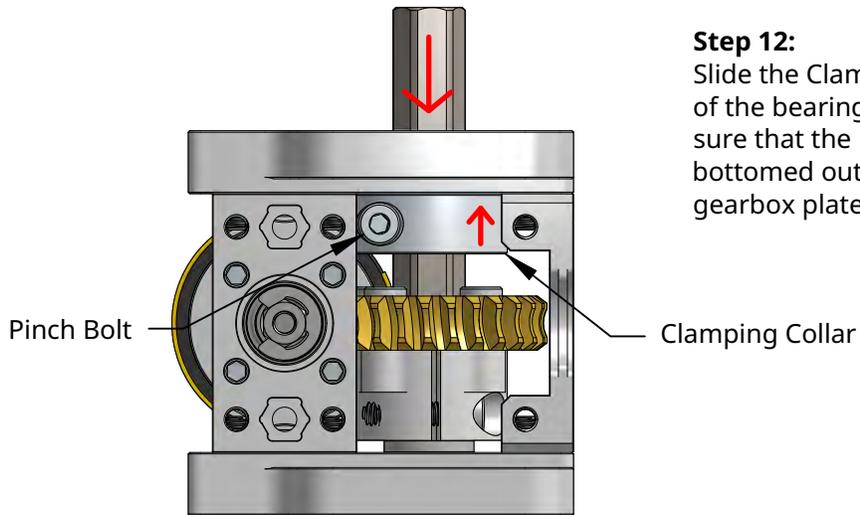
**Step 11:**

Using six 10mm long screws, bolt the remaining Gearbox Plate to the Quad Block Mounts already installed in your assembly.

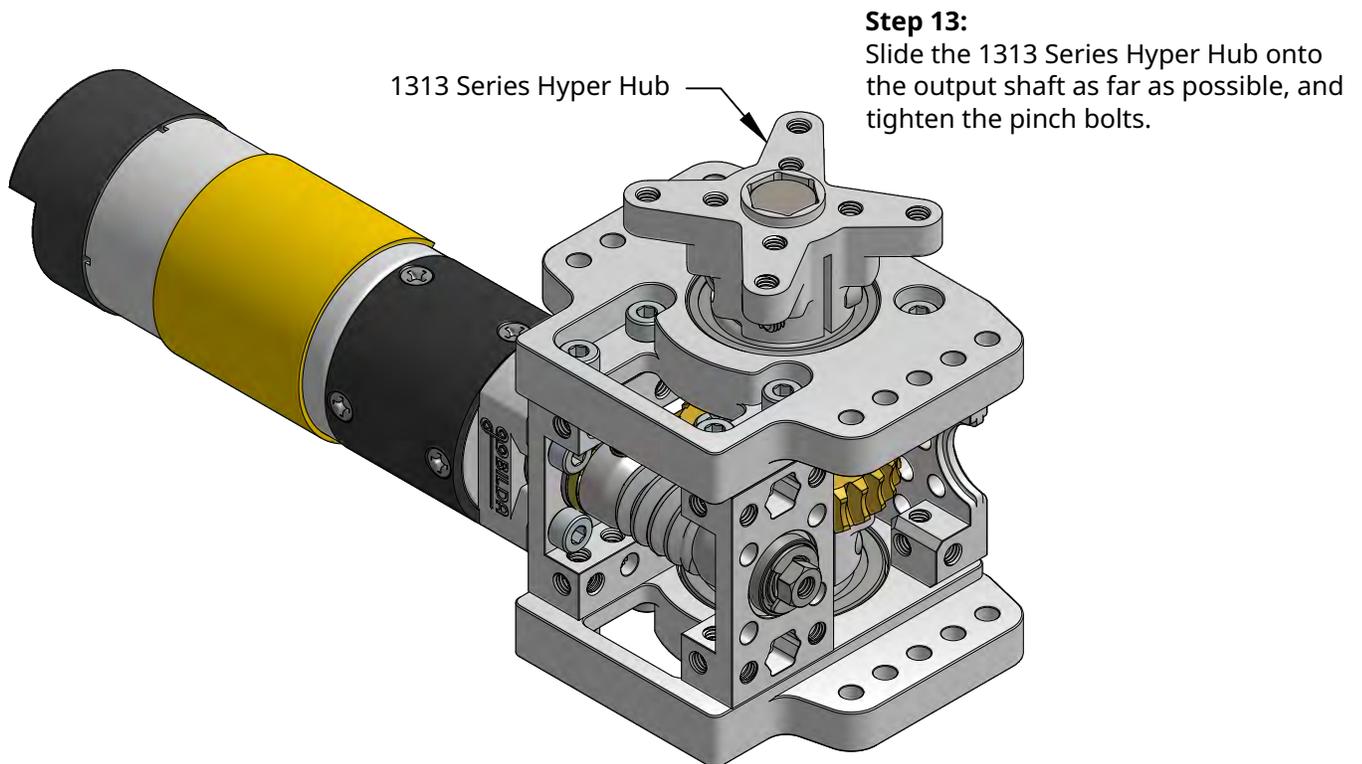


**Tech Tips**

- The Quad Blocks (A) and (B) that the motor and bearing support use are mounted in slots. This allows you to adjust the gear mesh by moving the motor further away, or closer to the Worm Gear. Loosen all 8 bolts in the Quad Blocks (A) and (B) to allow the motor assembly to slide.
- Reduce backlash and shock load by erring on the side of a tighter gear mesh."



**Step 12:**  
Slide the Clamping Collar up against the face of the bearing in the top plate, and make sure that the Hyper Hub and shaft are bottomed out in the bearing of the lower gearbox plate. Then tighten the pinch bolt.



**Step 13:**  
Slide the 1313 Series Hyper Hub onto the output shaft as far as possible, and tighten the pinch bolts.

**Congratulations! Your kit is fully assembled.**