

CONVERSION INSTRUCTIONS
MANUAL FLANGE TO MOTORISED FLANGE



1. Remove the four SCM12X30 cap screws using a 10mm Allen key.



2. Remove the flange from the gearcase.



3. Remove the key from the shaft – to allow the extraction of the shaft, 2 bearings and 1 spacer.

4. To remove the shaft – place upright on a fly press – and support the flange face. A reasonable amount of force will be needed to pass the shaft through the two bearings

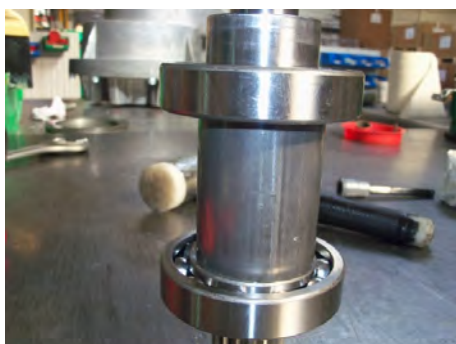


5. Remove the outer bearing by hand. In the event that the bearing is tight – use a suitable drift and tap the bearing through the front face of the flange. Then remove the spacer and clean out the flange cavity of residual grease. This will then reveal the inner bearing which can also be removed in the same manner as the outer one.





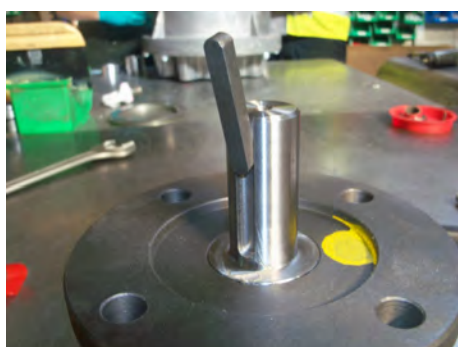
6. Place the replacement shaft onto a suitable bench with the geared end facing down. Press the new bearing over the shaft – up to the collar. Place the spacer on top of the bearing and then fit the second bearing. Smear grease onto the spacer and blend it flush with the bearings.



7. Ensure that the O ring on the flange face and the flange seat are intact – and smear a small amount of grease on the surface. This will allow the shaft to pass through the O ring without damaging it – and will help the flange to fit back into the gearcase.



8. Leaving the shaft in a vertical position – gently lower the flange over the bearings. The flange face will need tapping using a plastic mallet at alternate corners - to assemble over the bearings. Ensure that the lower bearing is fully engaged into its recess.



9. Re-fit the new key onto the shaft and gently tap into position wiping away any excess grease from the base of the shaft.

10. Place the flange back onto the gearcase, tap into position and tighten up the four cap screws.

