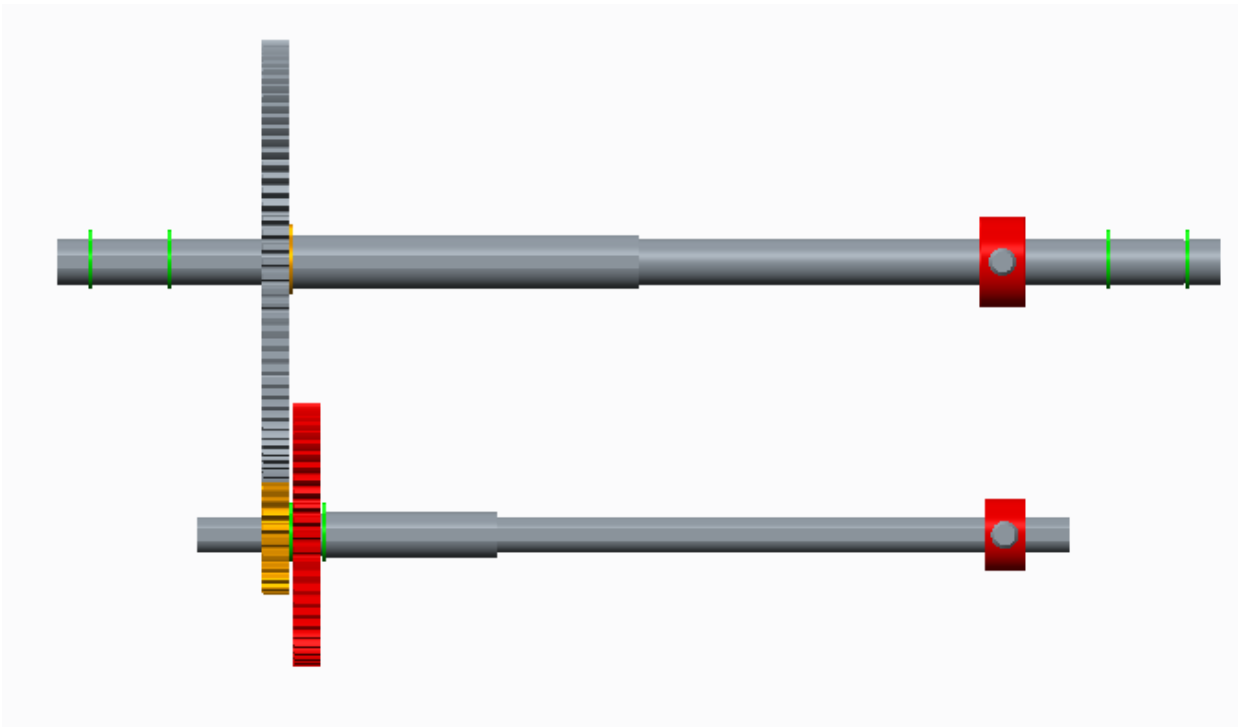


## Gearbox Assembly Procedure

1. Machine all components.
2. Press  $\frac{1}{4}$ " bearing into side of tubing opposing the motor mount.
3. Press  $\frac{5}{16}$ " bearing into side of tubing opposing the motor mount.
4. Insert intermediate shaft with  $\frac{1}{4}$ " shaft collar unfastened to it.
5. Push shaft through to step on shaft allowing for opening.
6. Installing both shafts in parallel, insert drive shaft and slide up to step on shaft.
7. Press other  $\frac{1}{4}$ " bearing in on motor mount side of tubing
8. Slide motor mount (MM) assembly into place.
9. Add retaining ring (RR) to shaft.
10. Slide on 56 tooth gear onto intermediate shaft.



11. Add opposite RR to shaft on other side of 56 tooth gear.
12. Slide on 24 tooth gear to intermediate shaft.
13. Install  $\frac{5}{16}$ " RR on Drive shaft.
14. Slide 96 tooth gear on drive shaft.
15. Place shafts into position and set screw the collars for both.
16. Line up standoffs and use #10-32 screws to affix MM to casing.
17. Add retaining rings for inside the crank arms onto the drive shaft.
18. Attach pedals to crank arms and affix them to drive shaft with keys.
19. Add outside retaining rings.
20. Attach wiring for motors to side of casing with adhesive.
21. Lubricate gears as necessary.
22. Attach bottom to gearbox.
23. Attach top to gearbox.