



TSB-X-motor-sleeve-reattachment

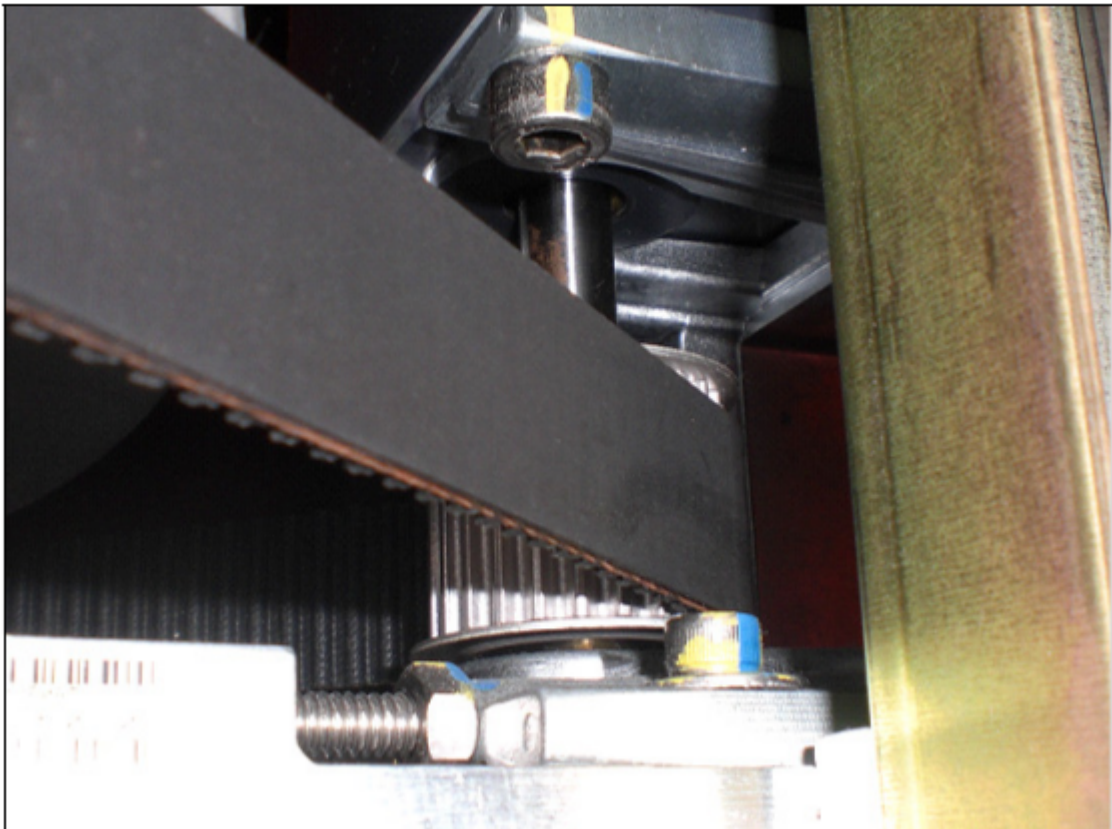


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Description: This TSB explains how to reattach the X-motor sleeve.



1.Remove the X-motor

On the early R501s the X-motor shaft has a sleeve on it to make the shaft long enough to reach the lower bearing in its bracket. This sleeve is attached to the X-motor using Loctite. If this Loctite starts to break down, the machine will have a problem with slot data and drum spinning easily by hand while the machine is on.

Remove the motor from the bracket by removing four 7/32" Allen screws that attach it.

If the sleeve has truly broken free from the motor shaft, you should be able to take the two pieces apart. Clean off the brown corroded Loctite from the shaft and from inside the sleeve using acetone (clear nail polish remover), cotton swabs, and paper towels.

2.Reattach the sleeve

The sleeve can be reattached using "JB weld" epoxy or Loctite. Follow manufacturer's instructions to mix the epoxy and apply it to the inside of the cleaned sleeve. Use the epoxy on the inside of the sleeve and only the very tip of the motor shaft to avoid the risk of the epoxy getting into the motor and seizing it up.

Reassemble everything and make sure that the sleeve is correctly positioned vertically before the epoxy cures. You will know it is positioned properly when the pulley that is attached to the sleeve is level and aligned with the drum pulley; the belt should run straight and level from the bottom of the drum to the pulley on the sleeve. If the pulley is too high or low, the belt will try to ride off the pulley. Leave the machine off and unmoving for the cure time of the JB weld.

<i>Tools/Parts Needed:</i>	
7/32'Allen wrench	1
JB Weld	1

Associated TSB's: TSB – X-motor Replacement

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Created by: William Martinka		Engineering
Published by: Joanna Krawczyk		Machine Support
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1.0.0	10/11/11	Original release

1.0.1	2/21/12	Wording revised
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