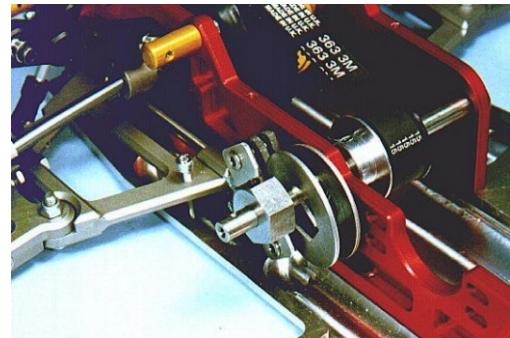
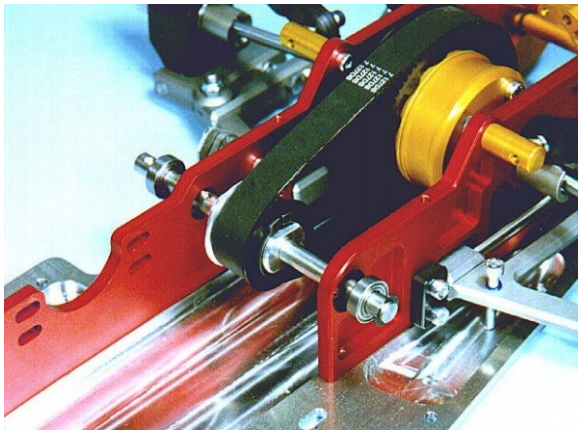


## 73/103 Gear Layshaft, Brake & Belt Assembly Instructions - Sheet 12

73/231	Drive Belt
73/232	Drive Pulley Small 32T
73/233	Pulley Carrier Small
73/234	Brake Hexagon
73/235	Gear Carrier Large
73/236	Gear Main Drive 50T
73/237	Gear Main Drive 52T
73/238	Gear Main Drive 54T
73/239	Layshaft 8mm
73/240	Gear Retaining Washer
91/208	'E' Clip 8mm Shaft
91/220	Circlip 20mm Shaft
94/208	M4 x 8mm Socket Cap Screw
95/206	M5 x 6mm Grub Screw

- 4). Pull back layshaft to put ball race in L.H. side plate.
- 5). Approximately align front pulley with rear and whilst rotating the pulleys tension the shaft forwards and engage R.H. side ball race in side plate.
- 6). Place brake disks in place between the shoes and slide the brake hexagon through them to the ballrace.
- 7). Locate screw detent and using thread locking compound tighten the grub screw.
- 8). Slide front pulley into alignment with the fixing detent and fix, using thread locking compound and grub screw.
- 9). Slide large gear carrier on to shaft and locate on screw detent fix with grub screw.
- 10). Retain gear on carrier with washer and cap head screw.



- 1). Fit small drive pulley to carrier and secure with circlip.
- 2). Place ball race on lay shaft and pass through R.H. side plate, picking up small pulley assembly and belt and exit the L.H. side plate.
- 3). Place ball race on L.H. end of lay shaft, and fit circlip.

