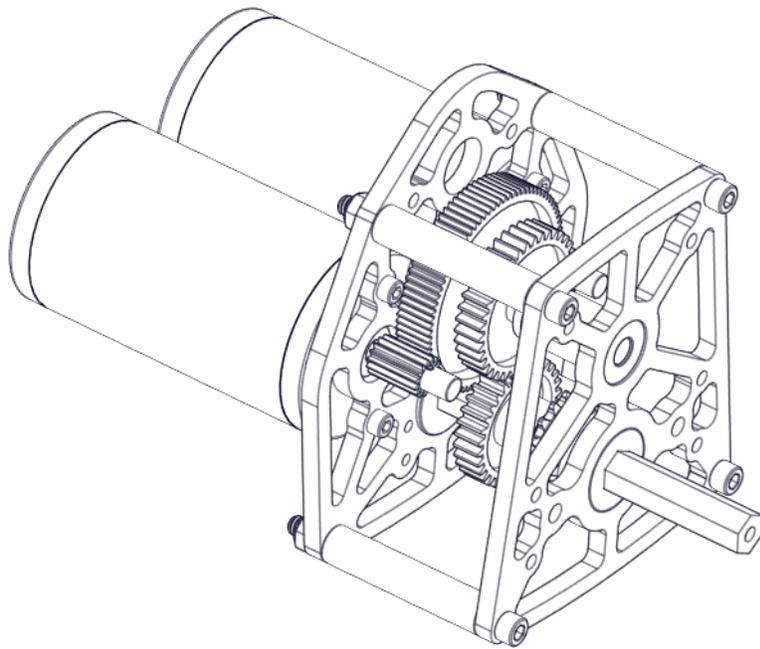


AndyMark[®]

EVO Slim for WCD

(am-4891)
Assembly Guide



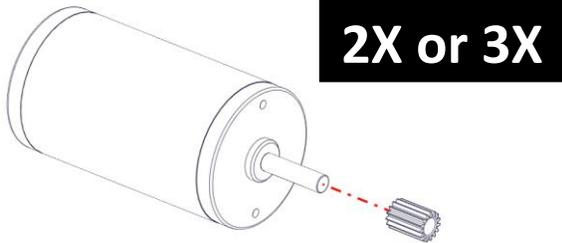
Revision #	Date	Author	Purpose
0	11/28/2022	Ethan Scime	Original Document

N. Massouda	12/12/2022
Reviewer Name	Date Reviewed

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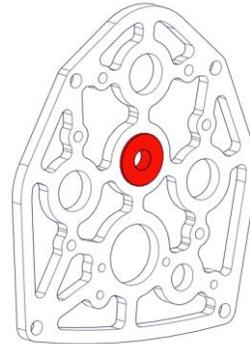
Step 1

Carefully press the 15T pinion gears (am-3482) onto the CIM-style motors. Leave a small gap between the pinion and the output shaft bushing using the spacer (am-3552) to check for proper distance. Loctite 271 may be required to hold the pinion in place.



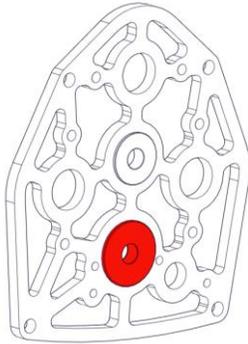
Step 2

Press a FR6ZZ bearing (am-0028) into the center hole of the EVO 2 Stage 3 Motor Plate (am-3527a)



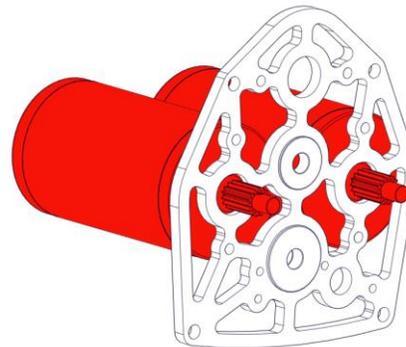
Step 3

Press a FR6ZZ-L bearing (am-0573) into the center hole of the EVO 2 Stage 3 Motor Plate (am-3527a), the flange should be on the same side as the other bearing.



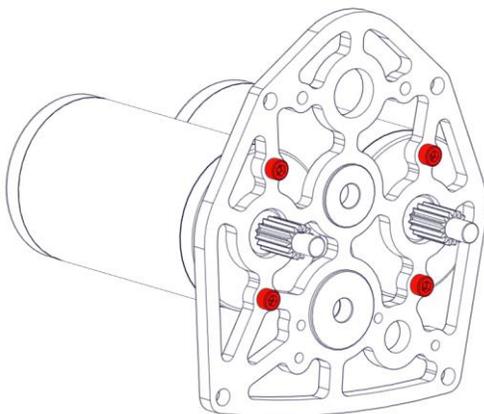
Step 4

Insert the CIM-style motors into the plate. The motors go on the opposite side of the bearing flanges.



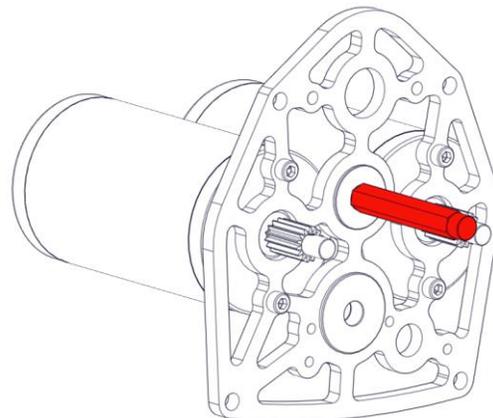
Step 5

Mount the two or three motors with four or six SHCS 10-32 0.625" (am-1120)



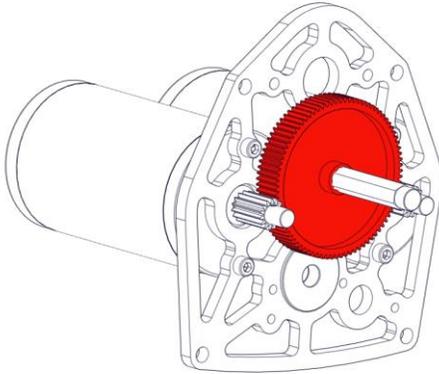
Step 6

Place the cluster shaft for 2 stage EVO Shifter (am-3497) into the FR6ZZ bearing.



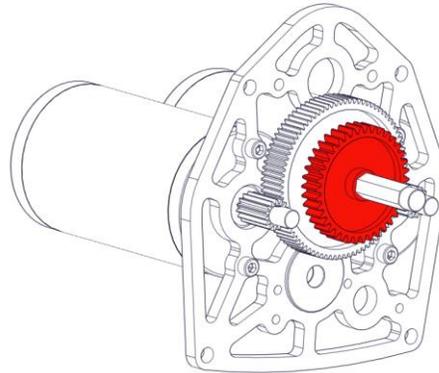
Step 7

Slide the 85T gear (am-3533) onto the cluster shaft.



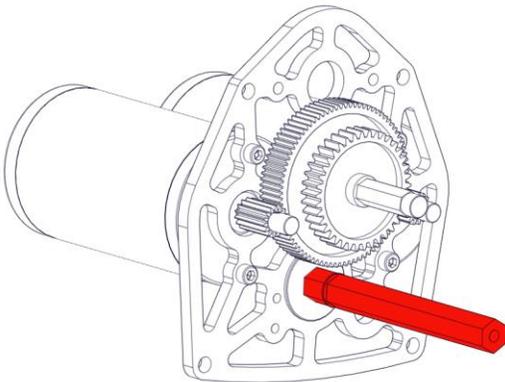
Step 8

Place remaining 3/8" hex gear onto the cluster shaft.



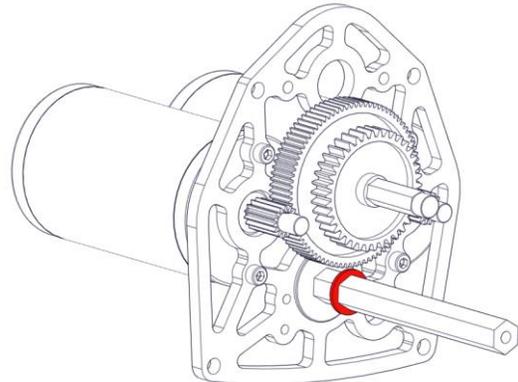
Step 9

Place the 1/2" hex output shaft with retaining ring (am-4889) into the FR6ZZ-L bearing.



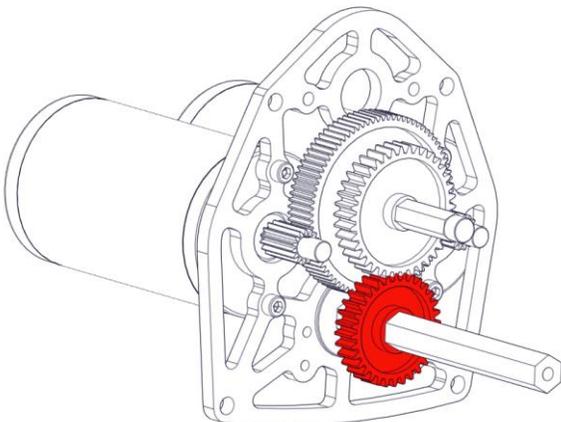
Step 10

Slide a 0.063" long 1/2" hex spacer (am-3948-063) onto the output shaft.



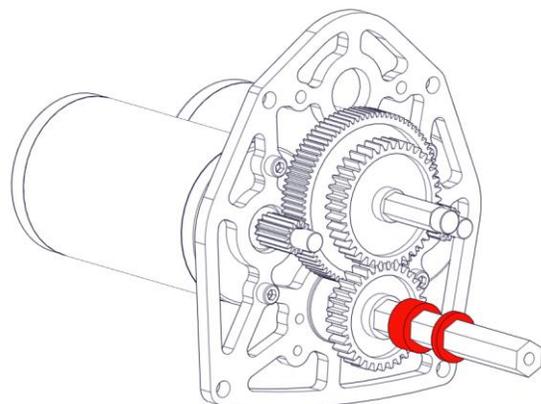
Step 11

Slide the 1/2" hex gear onto the output shaft.



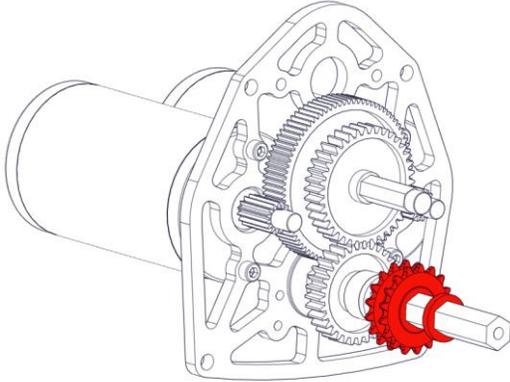
Step 12

Slide a 0.375" long (am-3948-375) and 0.125" long (am-3948-125) 1/2" hex spacer onto the output shaft.



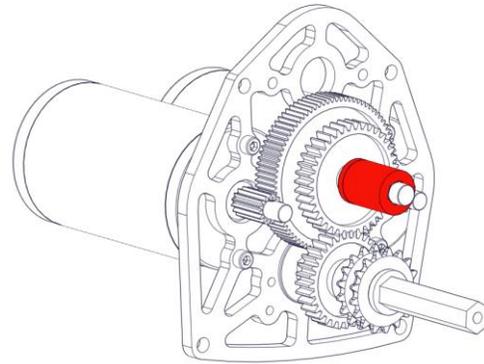
Step 13

Slide a 17T double sprocket (am-3999) onto the output shaft, followed by another 0.125" long 1/2" hex spacer (am-3948-125).



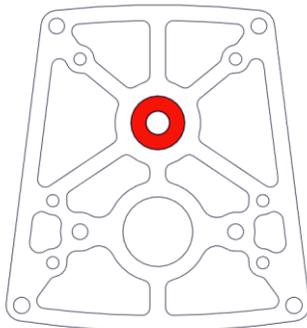
Step 14

Slide a 0.125" long (am-3948-125) and 1" long (am-3948-1000) 3/8" hex spacer onto the output shaft.



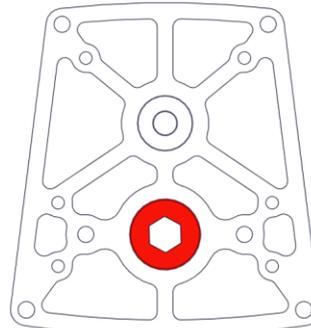
Step 15

Press an FR6ZZ bearing (am-0028) into the top hole of the EVO 2 stage output plate (am-3528)



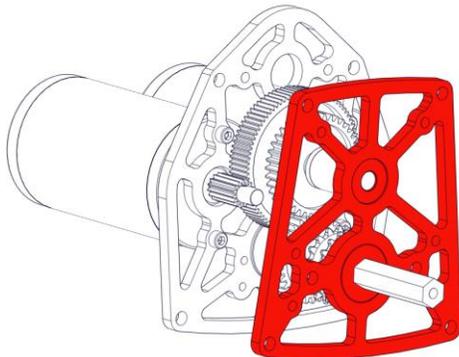
Step 16

Press an FR8ZZ Hex bearing (am-2986) into the bottom hole of the EVO 2 stage output plate with the flange on the same side as the other bearing's flange.



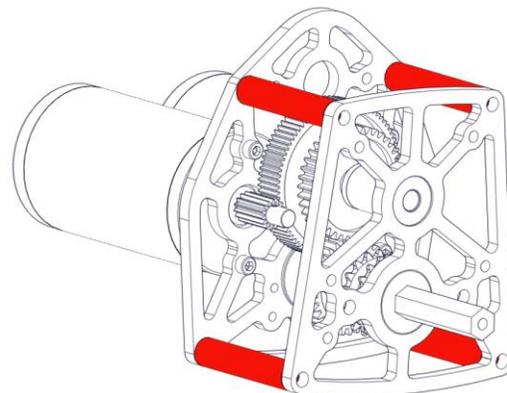
Step 17

Slide the output plate over the hex and cluster shafts. The bearing flanges should face toward the gears.



Step 18

Place four spacers (am-3546) between the two gearbox plates.



Step 19

Secure spacers in place with four ¼-20 3.25" long SHCS (am-3338) and four ¼-20 locknuts (am-1015.) The EVO Slim for WCD Gearbox is now complete.

