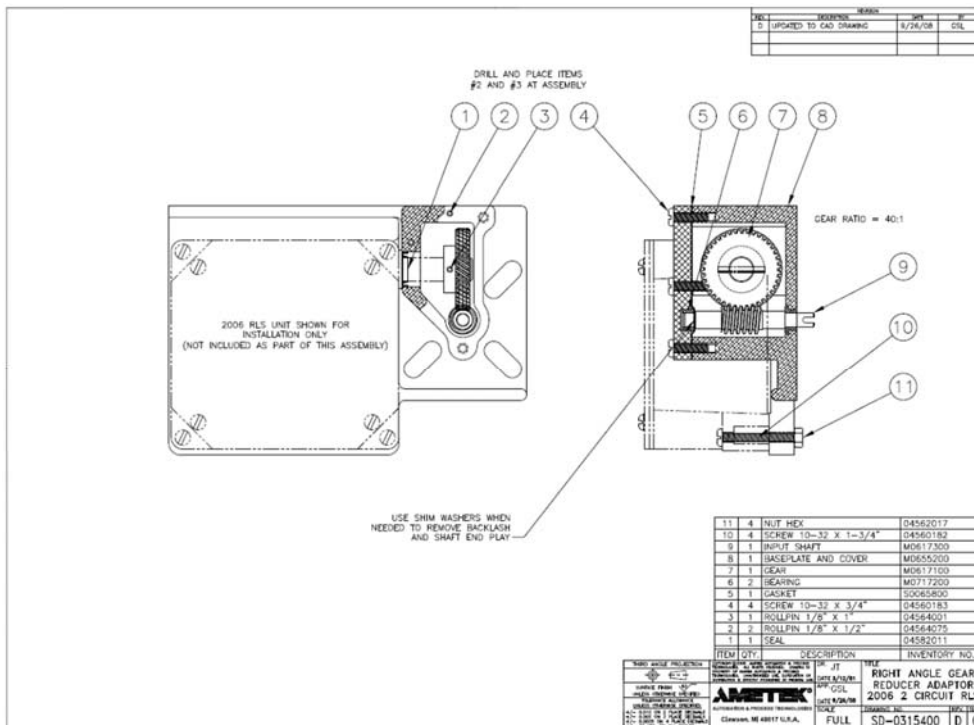


# 2006 Right Angle Gear Reducer Adaptor

## Replacing SD0315100 & SD0315400 Right Angle Baseplate on existing units

1. Remove screws item #4 and cover from Right Angle Baseplate gear box.
2. Remove Roll Pin item #3 from existing gear.
3. Remove 4 mounting screws #10 & 11 that hold RLS unit to existing baseplate.
4. Carefully slide RLS unit to the left off of gear, item #7 and out of seal #1.  
⚠ **CAUTION: DO NOT DAMAGE SEAL.**
5. Remove the key from the input shaft on the new RLS unit and slide into place through seal, item #1, Sliding gear item #7 onto the shaft as the shaft begins to enter the gear box area.
6. Mount RLS unit and align gears for proper mesh, checking for backlash. Gearbox cover will need to be put in place to help in gear alignment. Remove cover after alignment.
7. Drill 1/8" diameter hole through the gear hub and RLS input shaft as shown in drawing below. Remove all drill shavings.
8. Replace roll pin. Re-lubricate gears with a good general gear lube.
9. Validate alignment as needed. The RLS unit can be shifted to assist in gear alignment.
10. When proper gear alignment and backlash are confirmed, tighten down RLS unit.
11. Replace Right Angle Baseplate cover, cover screws and roll pin #2.



NOTE:  
2 Circuit  
RLS Unit  
Shown in  
Drawing.