

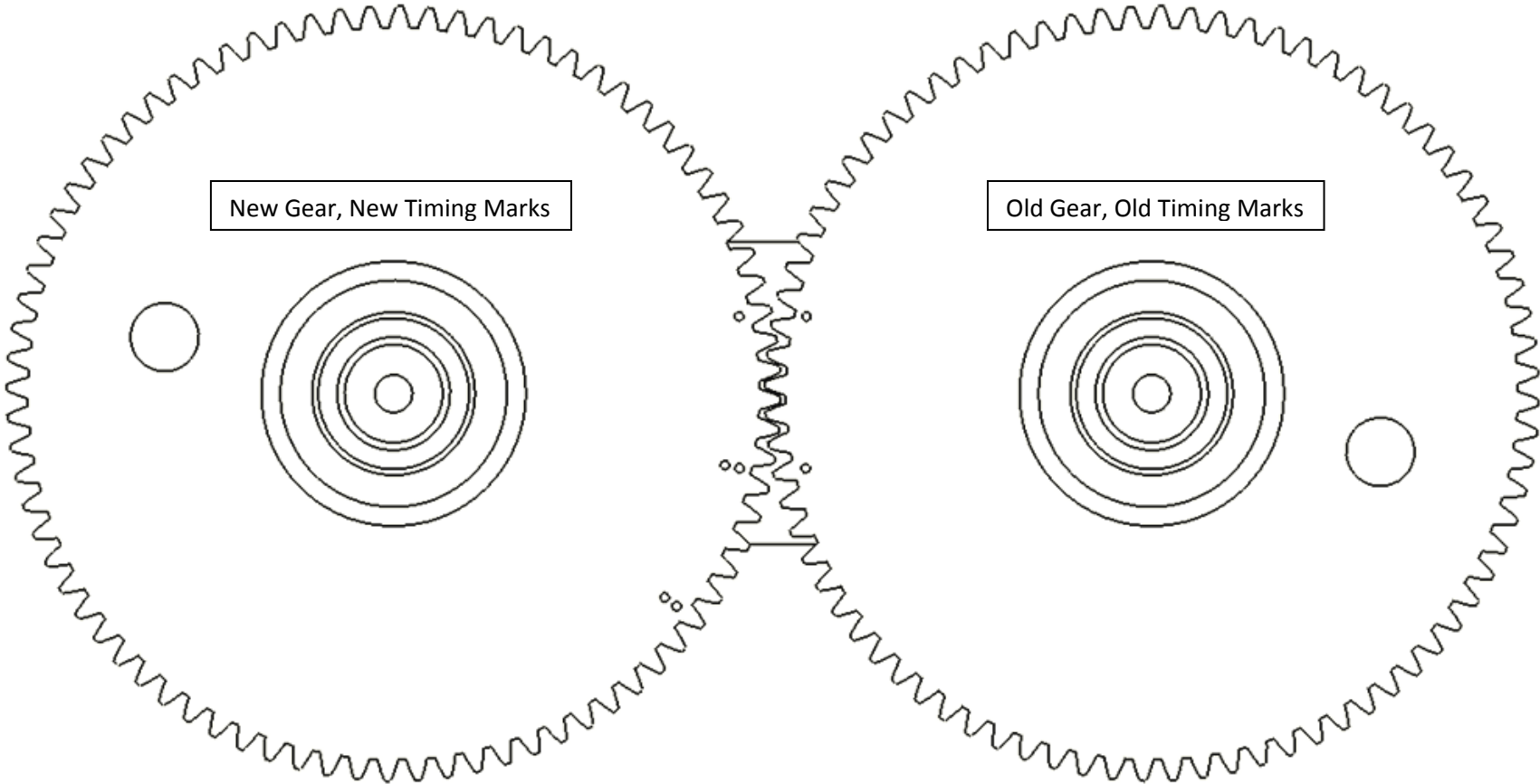


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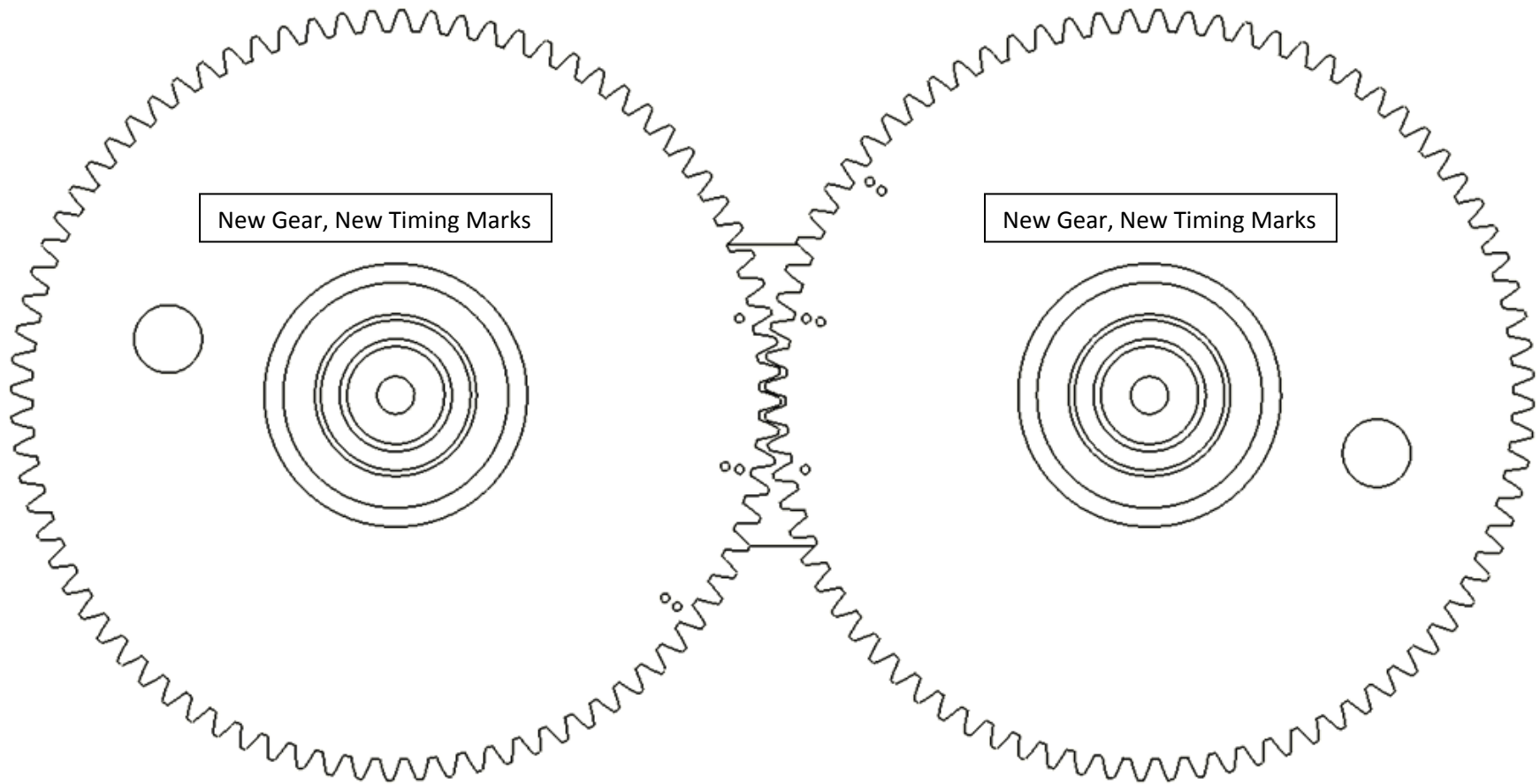
Forward Gear Replacement

1. Remove the three 1/4" bolts attaching the motor to its motor mount.
2. Open door to full position.
3. Release Emergency Release Lever.
4. Remove forward door push-pull rod at the gear attach point.
5. Remove the 1/4" bolts attaching the gear stabilizer to the gear pins. Units with the heavy-duty stabilizer remove the 1/4" Allen head bolts mounted to the inside flange of the header base plate. Remove the stabilizer.
6. Remove forward gear.
7. Close aft door to full closed position.
8. Grease forward gear pin.
9. Clean top of aft gear for clear view of the gear timing marks.
10. Grease forward gear pin using white lithium grease. We recommend Lubriplate™ 630-AA grease.
11. Apply grease to tooth area of new forward gear and insert onto gear mounting pin.
12. Align all four timing marks, two on each gear (see attachment for correct timing mark usage).
13. Reinstall the push-pull rod attachment bolt but do not tighten.
14. Reinstall the stabilizer and tighten the bolts to 84 inch pounds. Apply thread locking compound to threads and reinstall the 1/4" bolts on the inside base plate flange if required.
15. Rotate the doors to the full open position and tighten the gear end push-pull rod attachment bolt to 50 foot pounds.
16. Reinstall drive motor and tighten bolts to 50 inch pounds.
17. Re-engage emergency release lever and operate door system.
18. Inspect for correct rigging and re-rig as required.

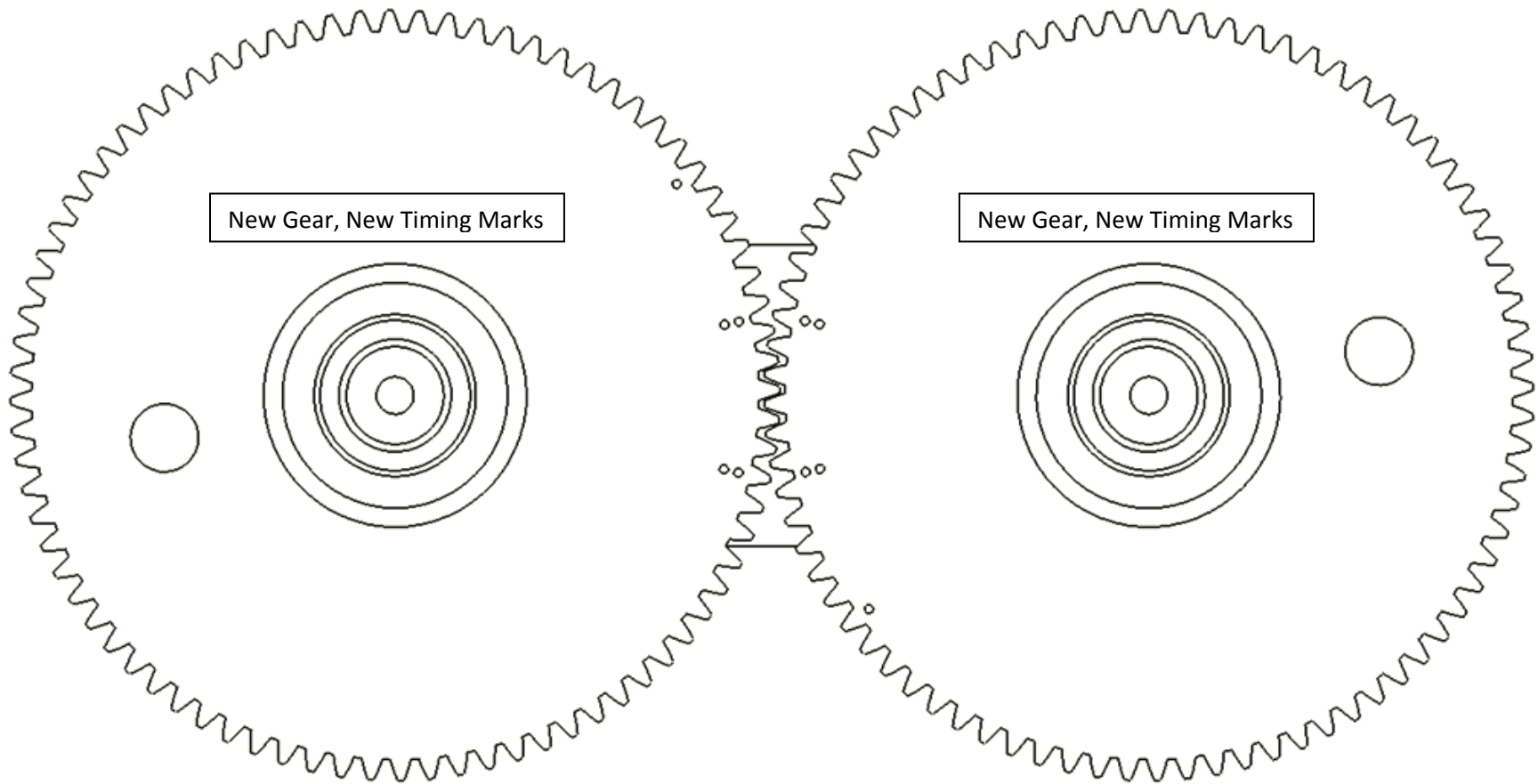
A&M Systems Gear Timing Marks, Old AFT with New FWD Standard Actuator

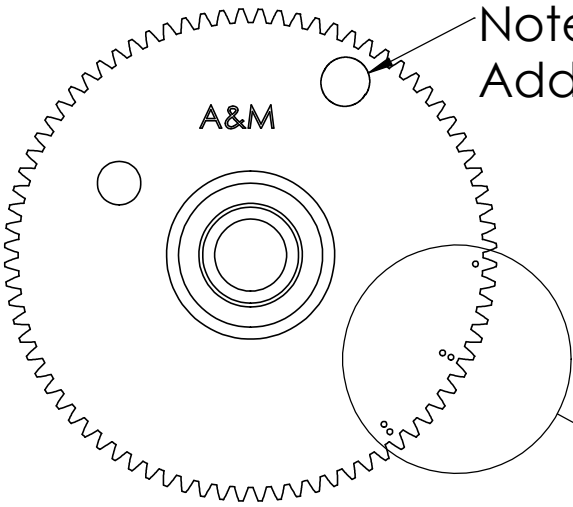


A&M Systems Gear Timing Marks, New AFT with New FWD Standard Actuator

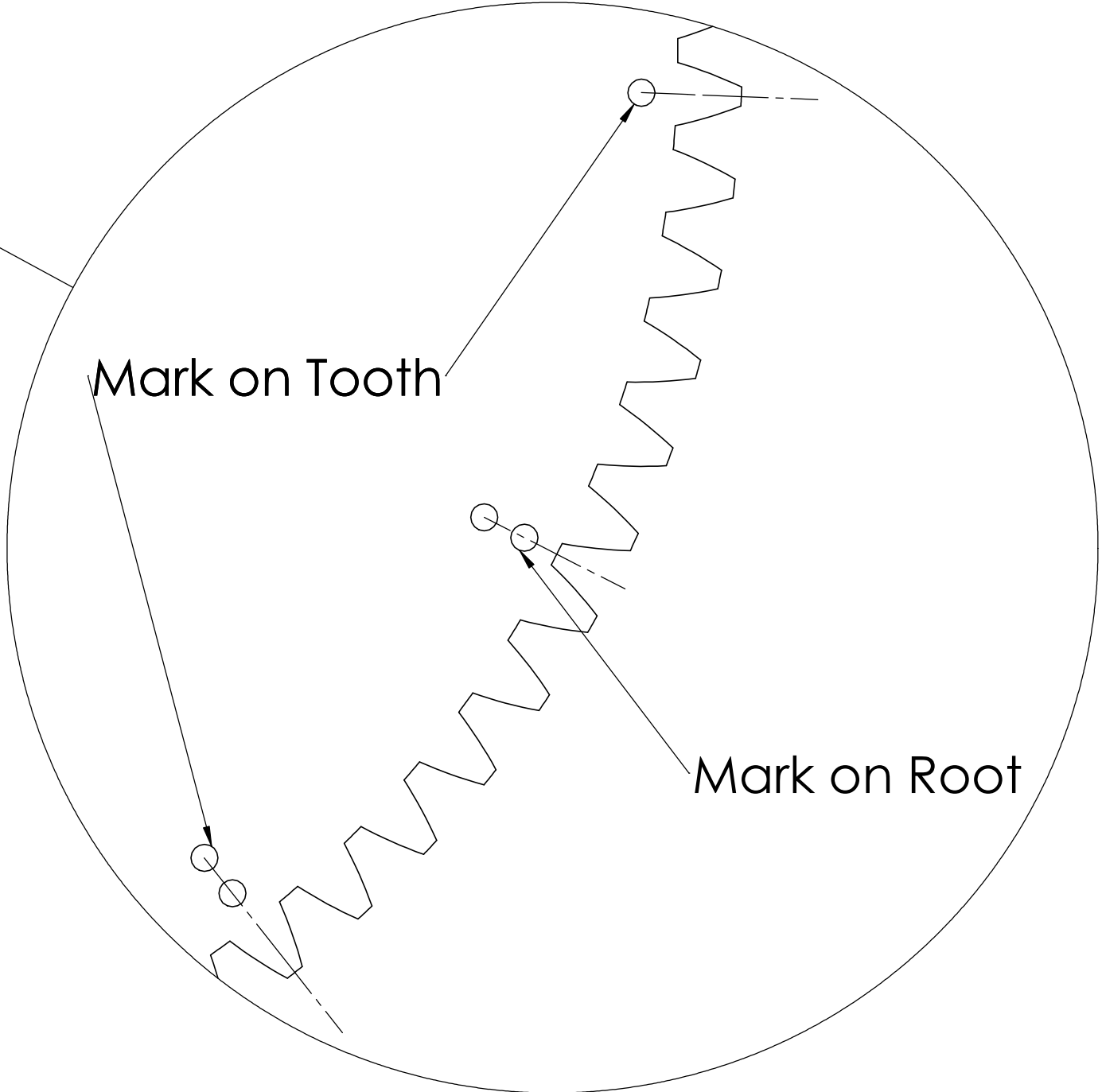


A&M Systems Gear Timing Marks, New AFT with New FWD Left-Handed and Vertical Actuator





Note:
Additional Holes May be Present But Do Not Affect The Gear Timing



Note:
Marks May Not Be
Centered on Actual
Root or Tooth. FWD and
AFT Gears are Identical.