



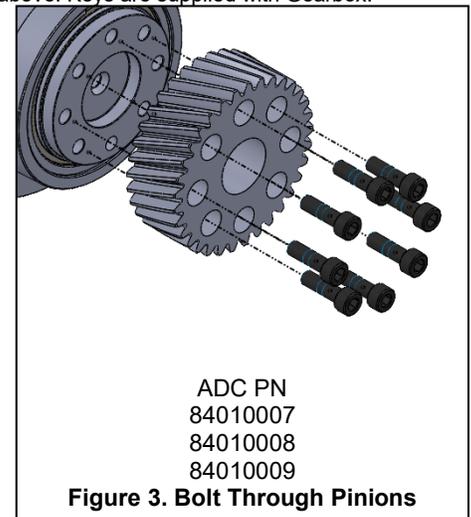
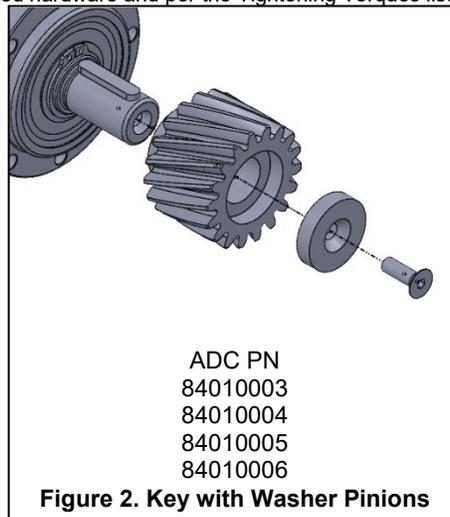
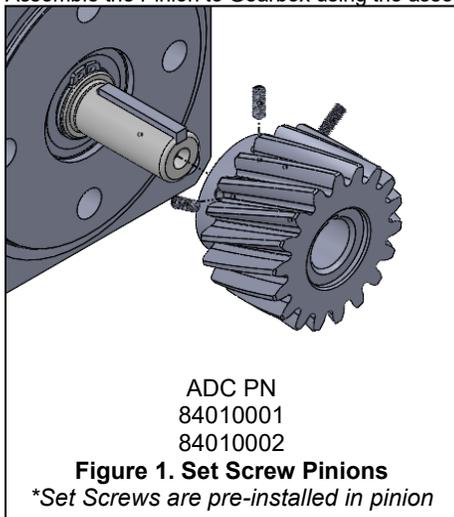
Rack & Pinion Installation

By part number

What's in the Box and Tightening Torques					
ADC PN	Pinion GAM PN	Washer GAM PN	Gauge Pin GAM PN (for rack installation)	Retaining Screw(s)	Tightening Torque (Nm)
84010001	1x 74010023	na	1x 50010007	*3x SHSS M3-.5 x 8mm long	0.9
84010002	1x 74010024	na	1x 50010038	*3x SHSS M3-.5 x 8mm long	0.9
84010003	1x 74010002	1x 47010030	1x 50010038	1x FHCS M5-.8 x 14mm long	6.1
84010004	1x 74010003	1x 47010031	1x 50010038	1x FHCS M8-1.25 x 20mm long	26
84010005	1x 74010004	1x 47010032	1x 50010038	1x FHCS M12-1.75 x 30mm long	90
84010006	1x 74010005	1x 47010033	1x 50010039	1x FHCS M16-2 x 35mm long	230
84010007	1x 74010011	na	1x 50010038	8x SHCS M5-.8 x 20mm long	7.7
84010008	1x 74010012	na	1x 50010038	8x SHCS M6-1 x 20mm long	13
84010009	1x 74010013	na	1x 50010038	8x SHCS M6-1 x 20mm long	13

PINION INSTALLATION

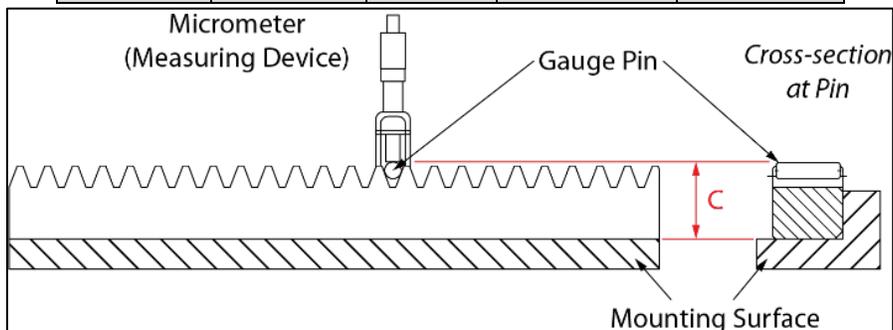
Assemble the Pinion to Gearbox using the associated hardware and per the Tightening Torques listed above. Keys are supplied with Gearbox.



RACK INSTALLATION – GAUGE PINS

The supplied gauge pins are used to ensure proper installation of the rack. Use the gauge pins to measure the location of the rack teeth. Ensure the values are the same across the rack (Height "C"). Tighten the C-clamps as necessary.

Rack Installation Table				
ADC PN	Rack Module	Gauge Pin GAM PN	Gauge Pin dia. (mm)	Height "C" (mm)
74020012	1.5	50010007	3	18.149
74020004	2	50010038	4	25.532
74020005	3	50010039	6	31.298



**Gauge pin is included with pinion*