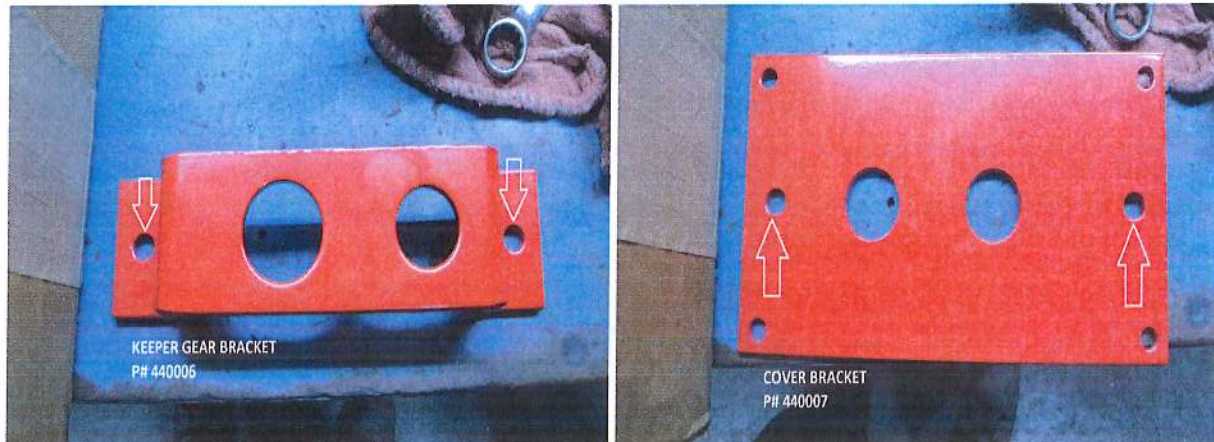# GRP GEARBOX ASSEMBLY #500092

Step 1. Drill out these bracket holes with 3/8" drill bit. (**Note...If necessary use 13/32 drill bit**)

KEEPER GEAR BRACKET
P# 440006

COVER BRACKET
P# 440007

Step 2. Grab brackets and bushings (p#'s 500154, 500155) insert bushings into brackets with rubber mallet. (See pic) Once the 1" ID bushing is inserted you will need to sand down the bushing roughly ¼" (**Note...Make sure bushings are flush on top of the bracket.**)
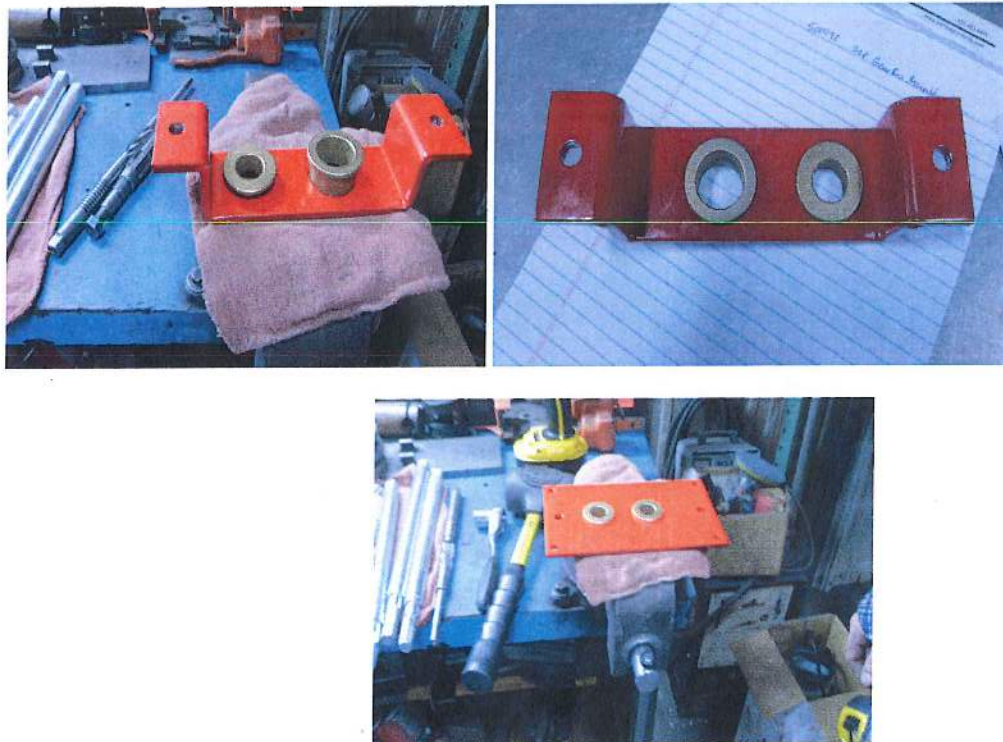
Step 3. Hone out ¾" ID bushing with honing drill bit. Make sure to keep honing drill bit level. Drill honing bit all the way through bushing (pushing lightly). Then push/pull drill bit 4-6 times slowly through bushing. (**Never put drill in reverse to pull drill bit out. Always keeps drill in forward and pull out**)

Step 4. Hone out 1" ID bushing with manual honing bit and socket ratchet. Make sure to keep honing drill bit level, and ratchet honing bit all the way through bushing. Do not push bit, allow the bit to work its way through. Then wrench honing bit 1 more time through bushing. (**Never put socket ratchet in reverse to back out bit, keep socket ratchet in forward and back out bit by hand.**)

Step 5. Remove 3/32 set screw with Allen wrench in 24 teeth gear spur (p/n 500156) slide short shaft (p/n 440010) into gear spur. Make sure holes line up. Then screw in set screw. Repeat this process for long shaft (p# 440009) 48 teeth gear spur (p# 500148), you will need 1/8" Allen wrench for that set screw. (Note...use rubber mallet to insert long shaft into gear spur)
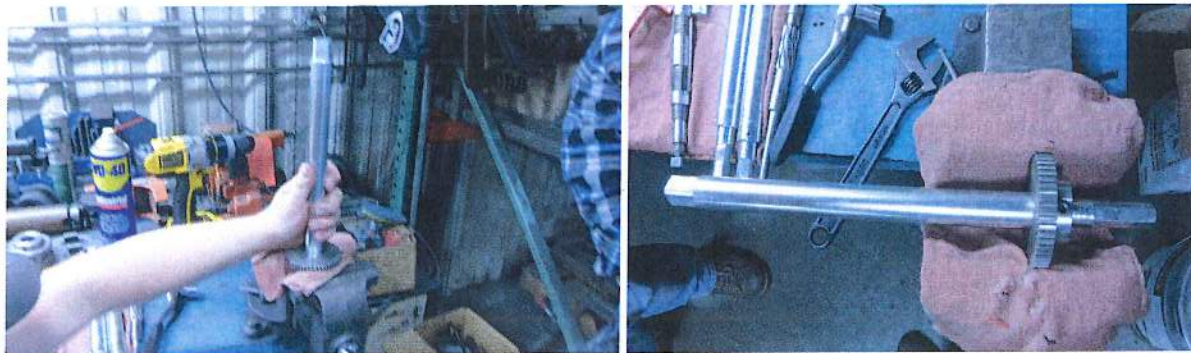
Step 6. Insert shafts into bracket as shown. Then grab cover bracket and place on top.
(Note...cover bracket can only go on one way, and make sure gears move freely)

Step 7. Take (2) 3/8 x 1" bolt and (2) 3/8 nylon locknuts and tighten brackets. (See Photo)
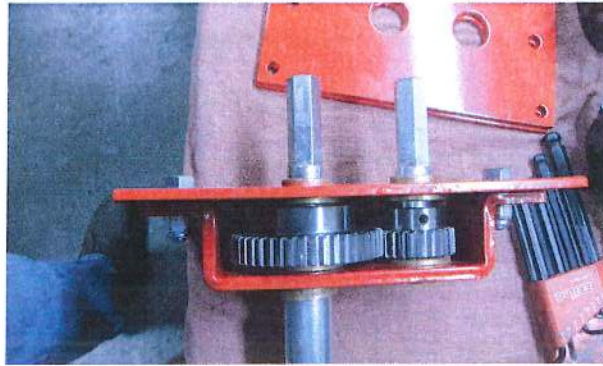
Step 8.

Grab gear box assembly and (4) BH-Soc ¼-20 x ½ SS screws and insert assembly into weldment. Then tighten screws. (**Note...after assembly is inserted in gear box, again make sure gears move freely, and long shaft is centered.**)