

# Install Carriage (Y) Transmission on I/S-300-350HF-CrystalPress

Kits for # 109280, 109637 & 109635; Procedure # 111115 Rev 1



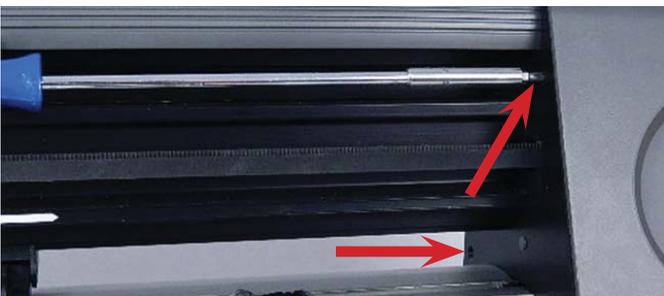
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Step 1: Tools needed: An 11/32" socket wrench & 6" extension, Phillips screwdriver and 9/64" hex wrench.



Step 2: Turn off, then unplug the power cord and the communication cable.



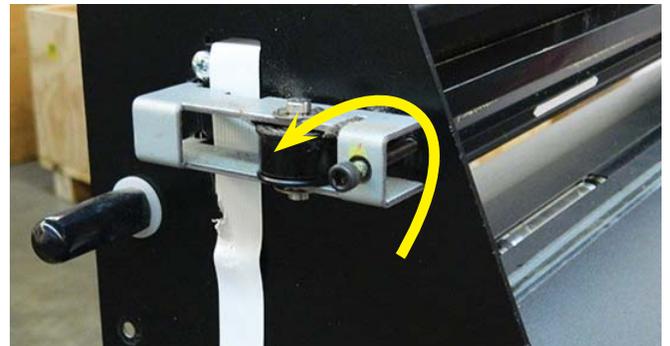
Step 3: Remove the right end cover by unscrewing the (2) screws (red arrows) and the (1) silver screw on the bottom. This gives access to the transmission.



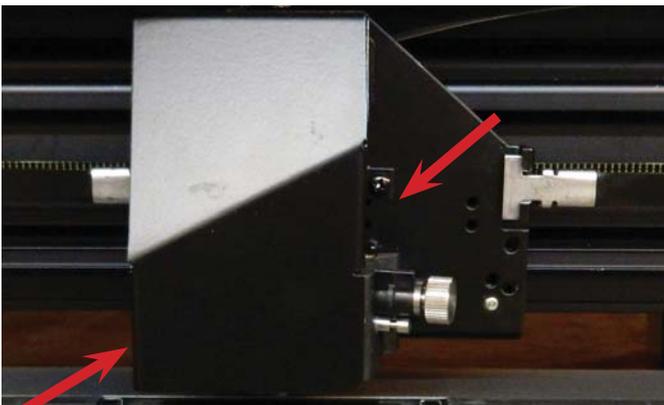
Step 4: Pull the right cover away from machine then rotate it toward the front of the machine to avoid the keypad adjustment knobs.



Step 5: Remove the left end cover by unscrewing the (2) screws (red arrows). This will give you access to the carriage (Y) belt tensioner.



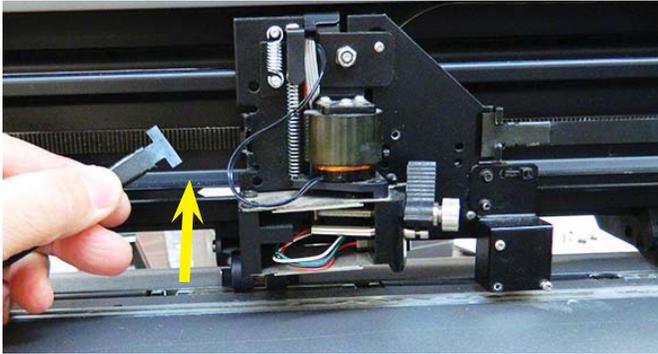
Step 6: Turn the Y belt tensioner counterclockwise 2 full turns with the hex wrench. This loosens the Y belt.



Step 7: (**Sign Cutter**): Remove the **carriage cover** by removing two black screws at red arrows and pulling straight off. CrystalPress carriage not shown.



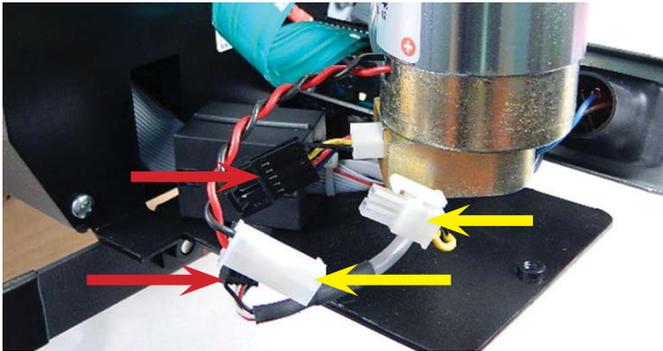
Step 7: (**300/350HF**): Remove the **carriage cover** by gently pulling the edges (red arrows) of the cover away from base then rotating up.



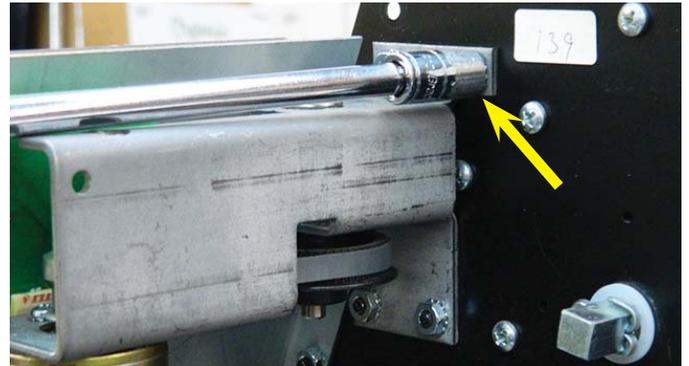
Step 8: (**Sign Cutter**) Hold carriage with the RIGHT hand and pull the belt (yellow arrow) toward the carriage to remove it. Repeat on other side. **NOTE: Do not remove the carriage.** CrystalPress carriage not shown.



Step 8: (**300-350HF**) Hold carriage with the LEFT hand and pull the belt (yellow arrow) toward the carriage to remove it. Repeat on other side making sure not to tangle in wires. **NOTE: Do not remove the carriage.**



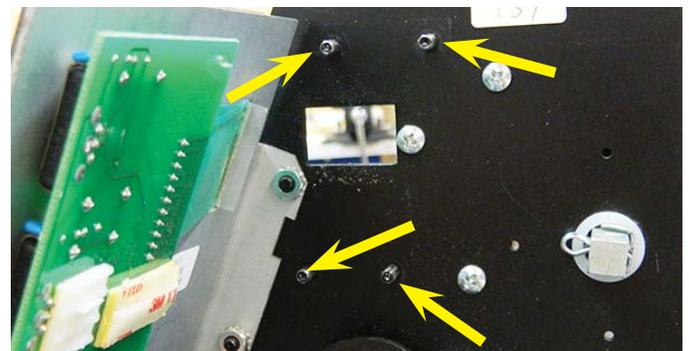
Step 9: Separate both the power plug (yellow arrows), and the communication plug (red arrows). Both have small latches to press before they will release.



Step 10: Remove all 4 silver nuts with the 11/32" socket wrench and extension.



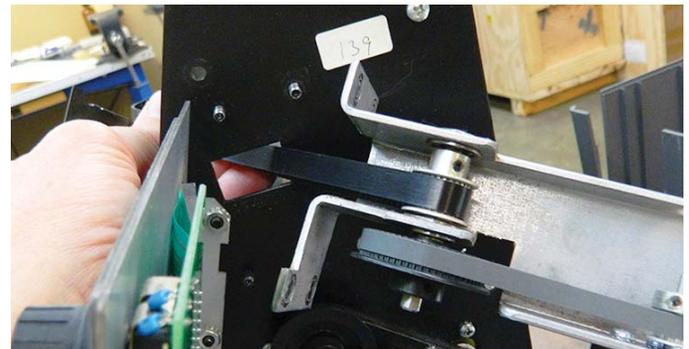
Step 11: Remove the old Y transmission and place to the side.



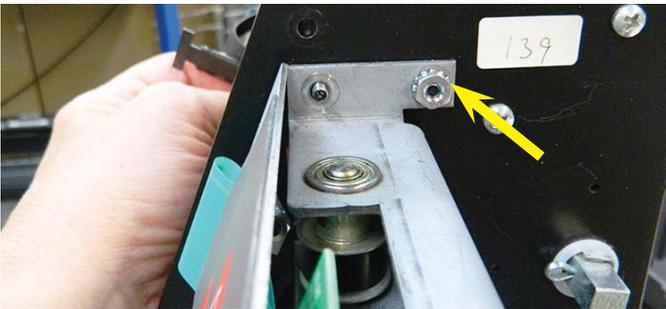
Step 12: Arrows point to the threaded studs that the new transmission will be placed on.



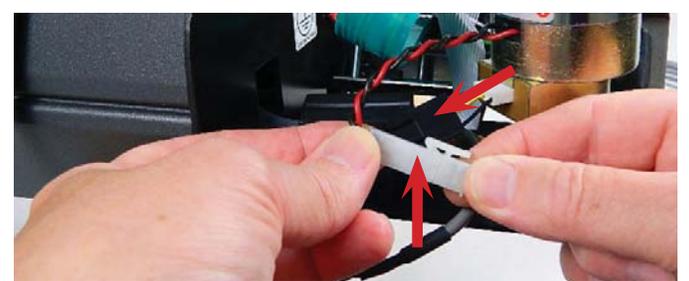
Step 13: Before placing the new Y transmission on the machine, thread the Y belt behind and around the pulley.



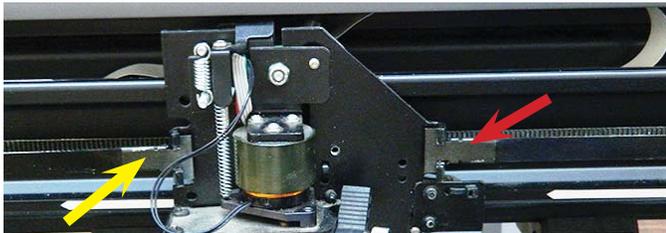
Step 14: Thread the Y belt through the hole in the end plate. With the left hand, grab the end of the Y belt and begin to pull it towards the carriage as shown.



Step 15: Pull the Y belt tight, place the new transmission over the studs and thread one of the nuts onto a stud as shown to hold the transmission. Attach and tighten the other 3 nuts then tighten the 'hold' nut.



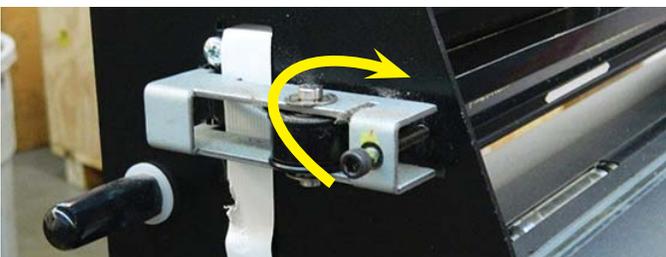
Step 16: Connect the white power plug and the black communication plug together (arrows). Make sure the plugs lock together with a slight 'click' sound.



Step 17: (**Sign Cutter**) Align the Y belt in the tensioner then get the belt ends near the carriage. Hook the tensioner end of the belt (yellow arrow) onto the carriage then hold the carriage while pulling the keypad end of the belt to hook it into the right side of the carriage (red arrow).



Step 17: (**300-350HF**) Align the Y belt in the tensioner then get the belt ends near the carriage. Hook the tensioner end of the belt (yellow arrow) onto the carriage then hold the carriage while pulling the keypad end of the belt to hook it into the right side of the carriage (red arrow).



Step 18: Once both ends of the Y belt are attached to the carriage base plate **ensure that the two (2) tabs and screw tip rest in the three (3) indents on the end plate.** Turn the tensioner set screw with the 9/64" Allen wrench 2 full turns clockwise to re-tighten.

Step 19: Place both end covers back on in the reverse order of removal. Test the machine to confirm all operations are OK. Contact Ioline Customer Service if anything is not working properly. Visit <http://www.ioline.com/support> for help.

**...FINISHED**