



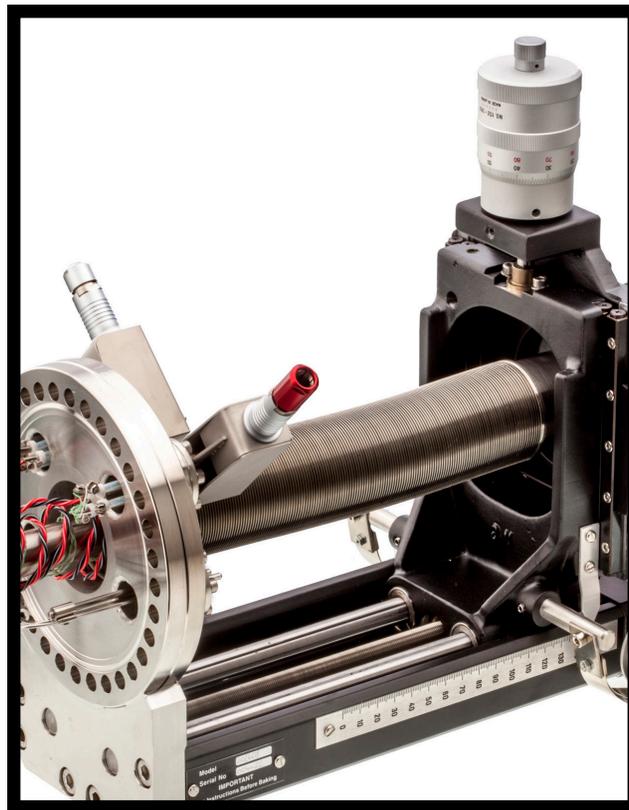
VACGEN

# Assembly Guide

## Replacing a Drive Nut on HPT-RX

### AS0014

### VGS03-02T14



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## Replacing the Drive Nut on HPT-RX

With great care, the 150mm and 250mm can be done while under vacuum with the following procedure.

To support the X&Y the easy way is to put a support between the underside of the X&Y to the base flange. Do this with either two lengths of angle or "U" shaped box section, which is placed on the guide rods, then hold in place with a tie wrap. Now lower the X&Y onto the supports.

GREAT CARE MUST BE TAKEN, as the bellows assembly will collapse causing injury if this support was to fail.

1. Support X&Y (If under Vacuum)
2. Remove Index Drive knob.
3. Remove the circlip in OD of the hole that is holding the bearing in place.
4. On the X&Y Table, remove the grub screw (10)
5. On the X&Y Table, remove circlip (12)
6. Wind the drive screw out by hand by about 30mm and gentle tap to remove the nut from the hole.
7. Once the nut is free, wind the nut off the drive screw, until the drive nut is off the shaft.
8. Remove ALL the grease and try the new nut on the drive shaft before fitting.
9. Re-fit the new nut into the location on the X&Y, locating the flat with the grub screw hole.
10. Refit circlip and tighten grub screw.
11. Re-lubricate drive screw with CarboFlo and refit in reverse.

