

SUBJECT: RETRO-FIT INSTALLATION OF STEERING WHEEL FOR MODEL 50

Follow this procedure to replace the steering motor on the Model 50 AGVs.

1. Disconnect battery cables.
2. Disconnect magnetic sensor plug.
3. Disconnect drive motor and brake wires.
4. Disconnect steering motor wires.
5. Remove four (4) assembly mounting bolts
6. Remove coupling through-bolt.
7. Remove coupling set screws (4 = 2 x 2)
8. Remove drive assembly from front of vehicle.
9. Remove steering motor and mounting bracket and discard.
10. Remove coupling and discard.
11. Verify wheel shaft orientation as shown in Figure 1.



FIGURE 1: WHEEL SHAFT ORIENTATION

12. Verify coupling orientation as shown in Figure 2.



FIGURE 2: COUPLING ORIENTATION

13. Verify drive pinion alignment.
14. Drop steering assembly onto wheel shaft. Slight racking correction may be required.
15. Install roll pin into coupling/shaft.
16. Position assembly to front of vehicle body.
17. Install four (4) mounting bolts. Snug bolts for the time being.
18. Verify dimension to bottom bolt from the floor. Block or support vehicle body to obtain 10" dimension from bottom bolt center to finish floor line.
19. Tighten four (4) mounting bolts to 30 ft/lbs.
20. Connect steering motor wires.
21. Connect drive motor wires.
22. Connect steering pot wires (if applicable).
23. Connect brake wires.

24. Plug in magnetic sensor.
25. Remove manual charge connector from top of vehicle chassis by removing two (2) #6-32 screws.
26. Place steering cover in position. Match mark two (2) holes and verify dimensions on drawing.
27. Drill and tap two (2) holes for #10-32 screws.
28. Re-position cover and bolt into place.
29. Position manual charge connector as indicated on drawing on following page.
30. Drill and tap two (2) #6-32 holes for mounting charge connector.
31. Mount charge connector.
32. Connect battery cables.
33. Position vehicle on the floor.
34. Power up vehicle.
35. Perform magnetic calibration as described in your owner's manual.