

# REMOVING THE GEARBOX FROM THE GN1324 & GN1339

To remove the gearbox, it is necessary to first disconnect the leadscrew and remove the gear cluster from the left end of the gearbox. Have the owner's manual available when doing any machine maintenance. The items referenced in these instructions can be found in the parts section of the owner's manual. MAKE SURE THE MACHINE IS UNPLUGGED BEFORE ANY DISASSEMBLY IS STARTED.

## DISCONNECTING THE LEADSCREW

If the leadscrew is already removed from the machine, skip this section.

1. Disengage the half nut and place all powerfeed controls on neutral.
2. Position the carriage close to the center of the machine bed.
3. Remove the two screws (G01-016) from the right hand leadscrew support (G01-022).
4. Drive the taper pin out of the left end of the leadscrew. This pin is larger on one end than it is on the other, be sure to drive it out from the small end toward the large end.
5. Pull the leadscrew out of the coupler and move it to the right about six inches. There is no need to remove the leadscrew from the apron just to remove the gearbox.

## REMOVING THE GEAR CLUSTER AND BRACKET

1. Open the pulley box door.
2. Remove the nut (G10-027) and washer from the shaft holding the gear (G10-009) on the shaft. Pull the gear assembly off the shaft.
3. Remove the bolt (G10-015) and spacer (G10-020) from the gear bracket (G10-018).
4. Loosen the small screw on the bottom side of the bracket and slide the bracket off the machine.
5. Remove the screws that hold the pulley box to the end of the machine so it can be moved slightly to allow the gearbox to be removed easily.

## REMOVING THE GEARBOX

1. Remove the handle (G10-055) from the selector lever on the gearbox.
2. Remove the five small screws (G10-082) screws from the gearbox front plate (G10-083) and remove the plate from the machine.
3. There are four cap screws securing the gearbox to the machine. Two are at the top front of the box and two are at the bottom rear of the box. Once these screws are removed, the box can be separated from the front of the machine.

## INSTALLATION

Installation is a reversal of the removal instructions above.