EVO Slim for WCD
(am-4891)
Assembly Guide
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Reviewer Name

12/12/2022

Date Reviewed

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Step 1
Carefully press the 1ST pinion gears (am-3482) onto the CIM-style motors. Leave a small gap between the pinion and the output shaft bushing using the spacer (am-3552) to check for proper distance. Loctite 271 may be required to hold the pinion in place.

Step 2
Press a FR6ZZ bearing (am-0028) into the center hole of the EVO 2 Stage 3 Motor Plate (am-3527a)

2X or 3X

Step 3
Press a FR6ZZ-L bearing (am-0573) into the center hole of the EVO 2 Stage 3 Motor Plate (am-3527a), the flange should be on the same side as the other bearing.

Step 4
Insert the CIM-style motors into the plate. The motors go on the opposite side of the bearing flanges.

Step 5
Mount the two or three motors with four or six SHCS 10-32 0.625” (am-1120)

Step 6
Place the cluster shaft for 2 stage EVO Shifter (am-3497) into the FR6ZZ bearing.
Step 7
Slide the 85T gear (am-3533) onto the cluster shaft.

Step 8
Place remaining 3/8" hex gear onto the cluster shaft.

Step 9
Place the ½" hex output shaft with retaining ring (am-4889) into the FR6ZZ-L bearing.

Step 10
Slide a 0.063" long ½" hex spacer (am-3948-063) onto the output shaft.

Step 11
Slide the ½" hex gear onto the output shaft.

Step 12
Slide a 0.375" long (am-3948-375) and 0.125" long (am-3948-125) ½" hex spacer onto the output shaft.
Step 13
Slide a 17T double sprocket (am-3999) onto the output shaft, followed by another 0.125” long ½” hex spacer (am-3948-125).

Step 14
Slide a 0.125” long (am-3948-125) and 1” long (am-3948-1000) 3/8” hex spacer onto the output shaft.

Step 15
Press an FR6ZZ bearing (am-0028) into the top hole of the EVO 2 stage output plate (am-3528)

Step 16
Press an FR8ZZ Hex bearing (am-2986) into the bottom hole of the EVO 2 stage output plate with the flange on the same side as the other bearing’s flange.

Step 17
Slide the output plate over the hex and cluster shafts. The bearing flanges should face toward the gears.

Step 18
Place four spacers (am-3546) between the two gearbox plates.
Step 19
Secure spacers in place with four ¼-20 3.25” long SHCS (am-3338) and four ¼-20 locknuts (am-1015.) The EVO Slim for WCD Gearbox is now complete.