



Lay out all the parts



Fully thread the holes in the bearing retainer base. Using the M3 x 200mm screws as a guide, glue the bearing retainer bases to the third member housing.



Clean and tap all the holes in the ring gear.



Install the ring gear on to the Center Carrier Plate



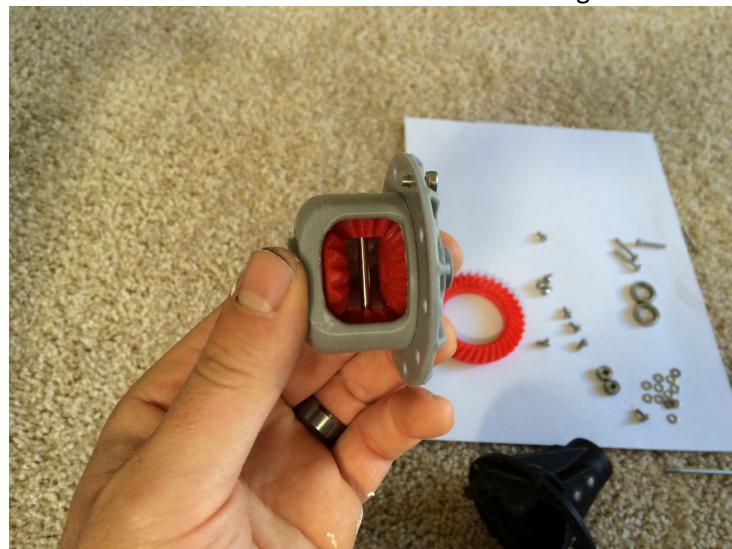
Using the ring gear as a guide, glue the center carrier housing to the center carrier plate. Being careful not to get any glue on the ring gear.



Install the two 623zz bearings onto the spider gears.



Install into the center carrier housing.



Install the two smaller spider gears and pin. You may need to remove the ring gear to install the pin.





Install shaft onto pinion gear and add washers. The number of washers will vary depending on the thickness of your washer and your final parts. I used 15 here.



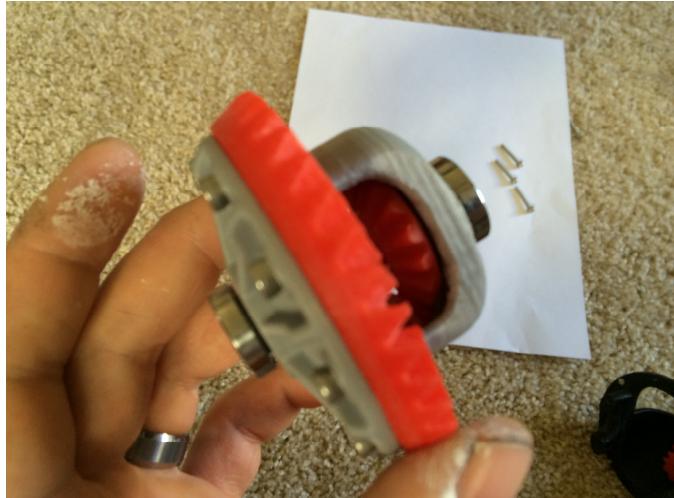
Install 623zz bearing into third member housing.



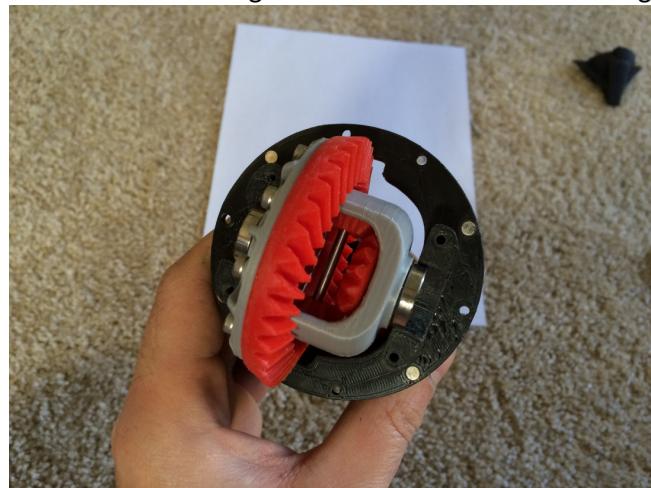
Install pinion shaft and bearing/washer.



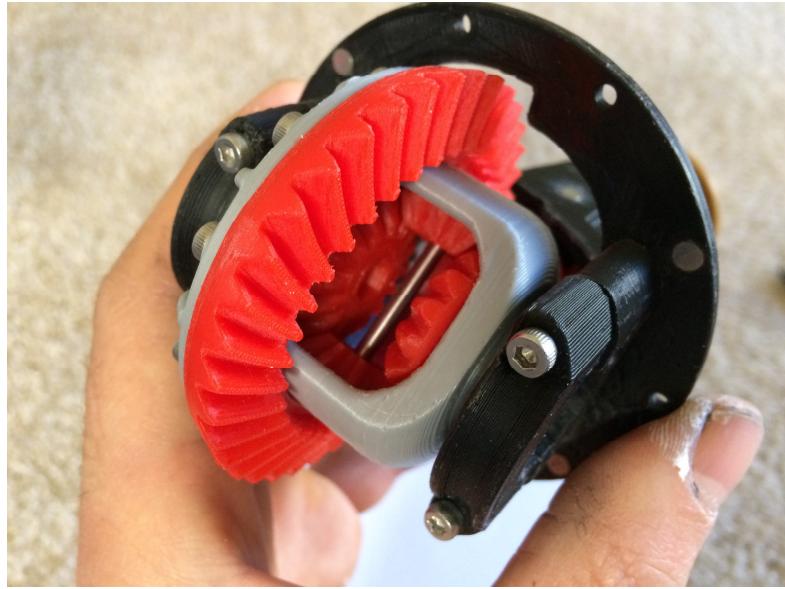
Install drive flange.



Install 6701zz bearings onto the center carrier housing.



Install center carrier housing into third member housing.



Install bearing caps and align carrier housing so that the ring and pinion gear have minimal friction when rotated.