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## D200 Y-Axis Lead Screw Assembly Replacement Procedure

**Gerber FastFact #** 5038

**Supplied by:** Gerber Service

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**Summary:** This document provides the procedure for replacing the D200 Y-Axis Lead Screw Assembly.

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***Please read this Guide in its entirety before replacement. When re-installing screws a medium strength thread locking compound is recommended.***

- 1) Position the beam about eight inches from the front of the table then turn off the main power switch and disconnect the power cord from the a/c outlet.
- 2) Disconnect the y-motor cable and dismount the y-motor by removing the four (4) cap screws that secure the motor and motor plate to the rear mounting block.
- 3) Remove the Phillips screw, stop washer, cup washers and compression spring from the front of the lead screw. Keep these pieces in the correct order for re-assembly.
- 4) Gently push back on the beam to slide the lead screw out of the front bearing block and to expose the coupler at the rear of the lead screw. If the front bearing came out with the lead screw, transfer it back to the front bearing block at this time being careful to keep it in the same orientation.
- 5) Remove the coupler, cir-clip, spacer and bearing from the rear of the lead screw. If the "centering pad" is on the lead screw half of the coupler, transfer it to the motor half at this time.
- 6) Remove the damper assembly from the lead screw in the following manner: remove the cap screws holding the aluminum plate to the plastic split-blocks riding on the lead screw, then remove the screws holding the split-block halves together and the blocks will disengage from the lead screw. *Hint: loosely reassemble the split-block and plate and set aside for re-installation.*
- 7) Remove the four (4) cap screws that secure the lead screw nut block to the front of the tie-beam. Slowly push the beam to the rear of the table while supporting the lead screw. The lead screw can now be lowered at the front and moved forward and out of the table assembly.
- 8) Position the nut block on the replacement lead screw assembly so it is about 12" from the front end of the screw. Slide the replacement lead screw assembly through the tie-beam and into the rear bearing block. **Be careful!! Do not drag the lead screw across the metal surfaces - damage will occur!**

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- 9) Line up the nut block to its mounting holes in the tie-beam and install the four (4) attaching screws, but do not completely tighten at this time. Slide the beam backwards until enough lead screw is protruding through the rear mounting block to allow installation of the rear bearing, spacer, cir-clip and motor coupler. Install these parts.
  - 10) Carefully move the beam forward and insert the front of the lead screw into the front bearing making sure the rear bearing is properly seated back into the rear bearing block. Install the cup washers, compression spring, stop washer and Phillips screw onto the front of the lead screw.
  - 11) Turn the lead screw so as to move the beam to within about a ½” of the front travel stops. Tighten the lower nut block cap screws and then move the beam to the rear far enough to gain access and tighten the upper nut block cap screws. *Hint: a power screwdriver used on the front Phillips screw makes turning the lead screw for positioning the beam much easier.*
  - 12) Move the beam to approximately the center of the table and install the damper assembly. When properly installed the damper slides smoothly on the lead screw with just enough pressure against the fabric strip at the bottom of the tie beam so as not to be “sloppy”.
  - 13) Turn the lead screw to move the beam within about a ½” of the rear travel stops. Look into the rear bearing block and note the position of the motor coupler on the lead screw. Orient the coupler on the y-motor so that the centering pad of the coupler assembly will seat into the notch of the coupler on the lead screw. Insert the y-motor plate and motor into the bearing block, seat the coupler and re-install the four (4) cap screws that secure the motor assembly to the block. Re-connect the y-axis motor cable.
  - 14) Re-connect the main power cord to the a/c outlet, turn the unit on and slew the beam front-to-back while checking for smooth operation of the lead screw and proper adjustment of the damper assembly. Perform a test cut before resuming production jobs.

Contact Gerber Service at 800-828-5406 or 860-644-6971 should any questions or problems arise during this procedure.