



Planetary Gears for MK2 ST4000 Gearbox

You will find your 9 gears inside what is called a sinter cage. The gears have been 3D laser printed directly inside this cage (how's that for amazing?!) Open the sinter cage by snipping the plastic on one corner until you can shake the gears out the hole.

The gears are an exact fit for the originals and will mesh with the original gears perfectly.

IMPORTANT: The shaft hole of the gears may still have some of the 3D printing plastic powder residue inside them. If the gears are a little bit tight on the shafts, **DO NOT DRILL THEM OUT WITH A POWER DRILL - that will damage them!** Using your fingers only, twist a .161" (5/32" or 4mm is close enough) drill bit in the hole to clear it out.

When installing the gears apply a small amount of lithium or silicon grease to each layer of gears. This will increase the lifetime of your gears. If you are only replacing some of the gears, use the original gears on the top gear layers (closest to the electric motor) as these have the highest speed.

It works best to insert each gear carrier into the housing and then insert the gears on each pin. Apply grease generously to each layer of gears. If you have the white spacer disks, insert one on top of each set of gears, but don't worry if you don't have them, they're really not necessary.

If you have any problems, please contact me.

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