**Work Instructions: Sprocket Rotation & Replacement**

**Parts Needed:**

* 10 Sprockets (P-C2262)
* 4 Bearings (P-C2119)
* 2 Chain Couplers (P-C2123)
* Set of Alignment Clips

**Sprocket Rotation Procedure:**

1. Remove the chain couplers.
2. Loosen the drive shaft bearings
3. Remove the Flag Proximity Target Collar.
4. Drop the Belt into Pit.
5. Remove Drive-side Drive Shaft Assembly and set it aside.
6. Remove Passenger-side Drive Shaft Assembly and set it aside.
7. Align the drive shaft with bearing set screws and use shims if needed for bearing height.
8. Align and install the Chain Couplers.
9. Tighten the bearings.
10. Line P.S. and D.S. belt up with sprockets using handlebars.
11. On the iPad, put the belt in reverse with a negative speed of 10. Using 2 technicians on each side of the belt, pull on the belt to keep the belt and sprocket together. Keep pulling until you have enough slack to attach to the other end of the belt.
12. Re-connect the belt ends.
13. On the iPad, put the belt in reverse at a positive speed of 10 and run the belt.
14. Check that the bearings are spinning. Run the belt at a slow speed (25 to start). Be on alert and ready to stop the belt if needed.
15. If everything is ok. put the belt back to the speed it was originally at.

**Instructional Videos**

* **Video #1:** [Sprocket Rotation on Vimeo](https://vimeo.com/530859930)
* **Video #2:** [Belt Rotation - Sprocket Rotation on Vimeo](https://vimeo.com/561947507)