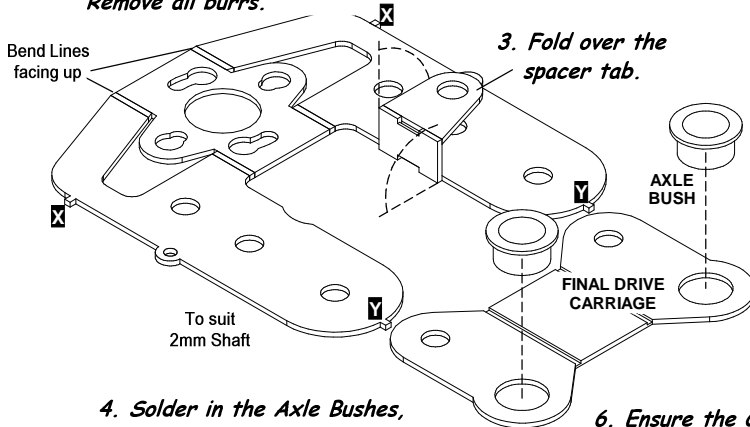
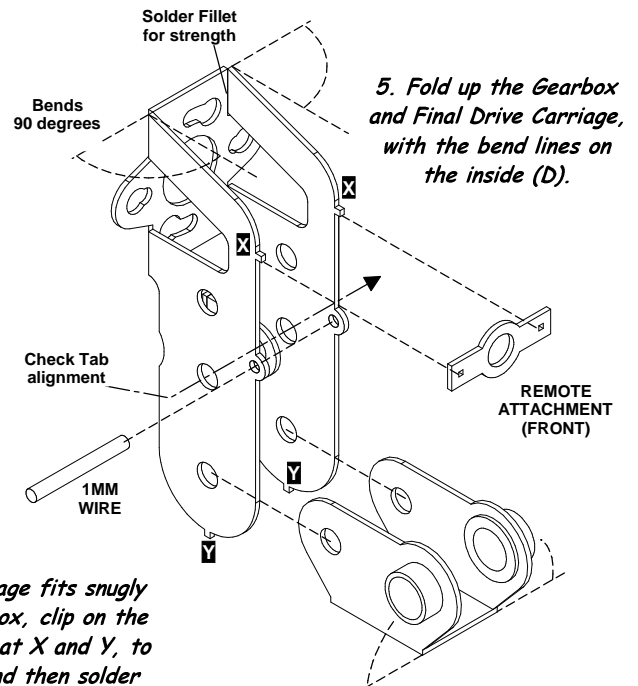


## HiFlier+ 34/45/60:1

These instructions cover the basic gearbox assembly sequence.  
For additional information, hints and tips you can refer to our Guidance Section (see brackets).  
Note: If this is your first High Level Gearbox we recommend you read all notes thoroughly.

1. While the etches are still in the fret, progressively open out the holes to suit the components, so they're a push-fit (see A & B).  
Remove all burrs.

2. Cut the etches from the fret. Take care not to accidentally remove any of the locators 'X and Y'.



3. Fold over the spacer tab.

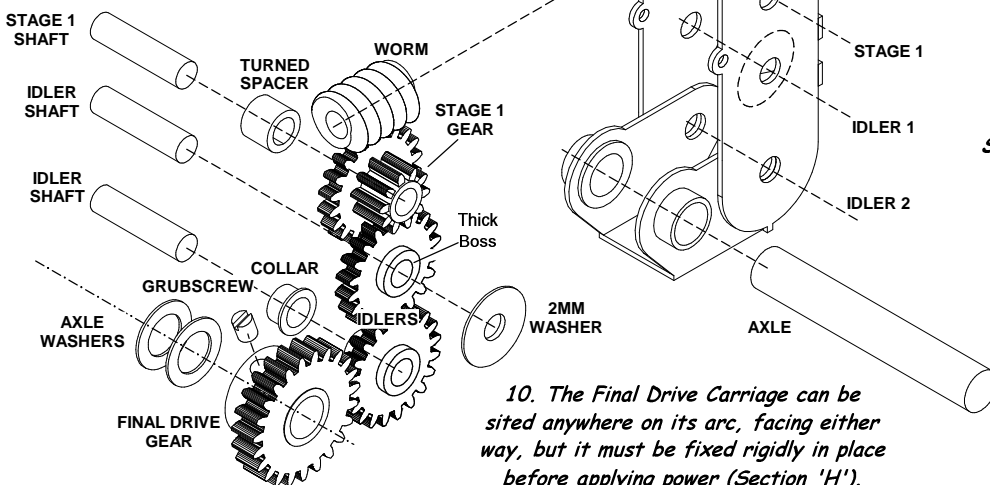
4. Solder in the Axle Bushes, making sure they're fully home. File the bushes to size (see C).

6. Ensure the Carriage fits snugly inside of the main box, clip on the Remote Attachment at X and Y, to check the width, and then solder a length of wire across the box.

7. Use a piece of shaft to confirm alignment of the spacer tab, then strengthen all bends with solder. Remove the Remote Attachment and clean up the etches.

8. Cut the Gearshafts to length (E) then fit the Stage 1 Shaft, Gear and Spacer (F). After checking the gear revolves freely (G) secure the ends of the shaft using a small amount of adhesive. Be careful the glue doesn't stray into the gear itself.

9. Fit the first Idler Gear, 2MM Washer and shaft, noting the position of the boss. Check the gear runs freely, with only minimal side clearance (G) and secure the shaft.



11. Slot the second Idler Shaft through its locations in both the Main Gearbox and Carriage. Include the thin Idler Gear and Fixing Collar.

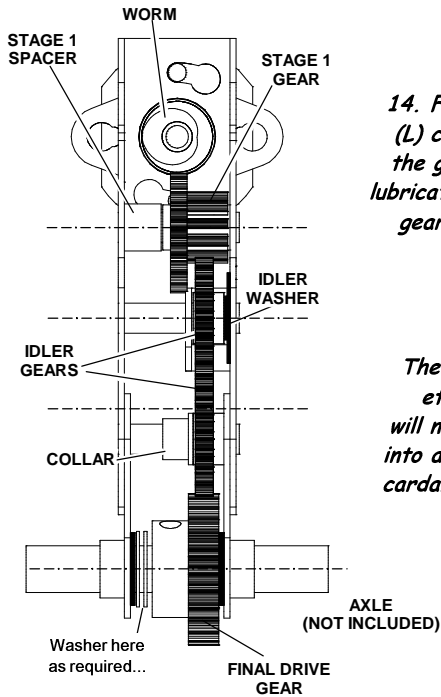
12. Fit the Axle, 23T Gear and Spacer into the Carriage, and washer as required (read 'J'). Tighten the Grubscrew and check all the gears revolve smoothly.

13. When the Carriage is secured in its final position, fix the second Idler shaft in place then move the collar up to the gear, so there is running clearance only. Add a tiny drop of glue to keep the collar in place.

10. The Final Drive Carriage can be sited anywhere on its arc, facing either way, but it must be fixed rigidly in place before applying power (Section 'H').

14. After testing the Motor, push the worm onto the motor shaft (K) so its rear face is 3mm from the Motor face. Secure with Loctite or similar adhesive.

## HiFlier+ 34/45/60:1 Gearbox



14. Fit the motor/worm assembly, (L) check the mesh (M) and test the gearbox under power. Lightly lubricate the mechanism (N) then the gearbox is ready to fit (C & J).

The kit includes the additional etched components (P) you will need to convert the gearbox into a remote-drive system, using cardan shafts linked to the motor by universal joints.

