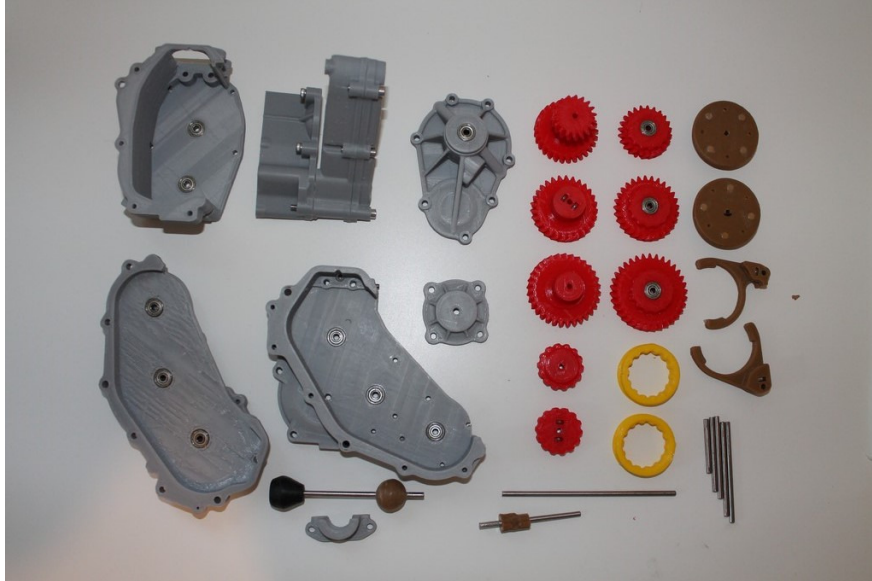


Assembling 4WD transfer case

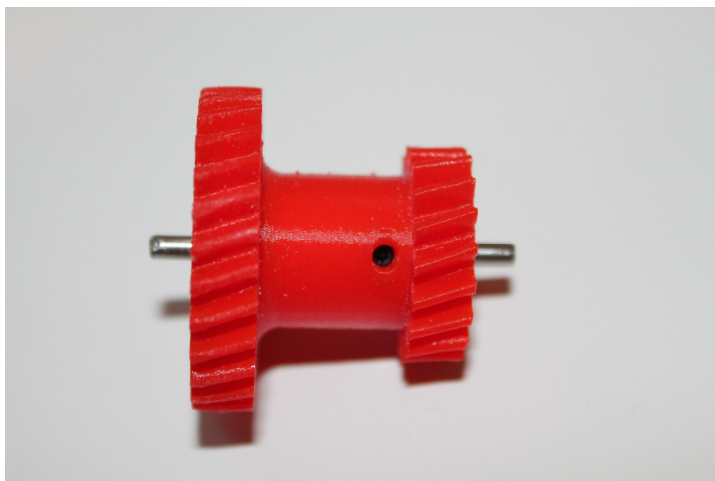
Step 1:



Prepare individual pieces after printing. When reaming holes for bearings and shafts, make sure to keep the hole as concentric and straight as possible. This will eliminate any wobble of the gears while in operation. Keep all holes for shafts as small as possible. You want the 3mm shaft to fit tightly but not too tight to where you can't pull it out by hand.

Install all bearing, M2.5 nuts, and set screws.

Step 2:



Glue the Low Range Gear Counter Shaft 1 and Low Range Gear Counter Shaft 2, using the Low Range Counter Shaft to align the them. Tighten set screws.

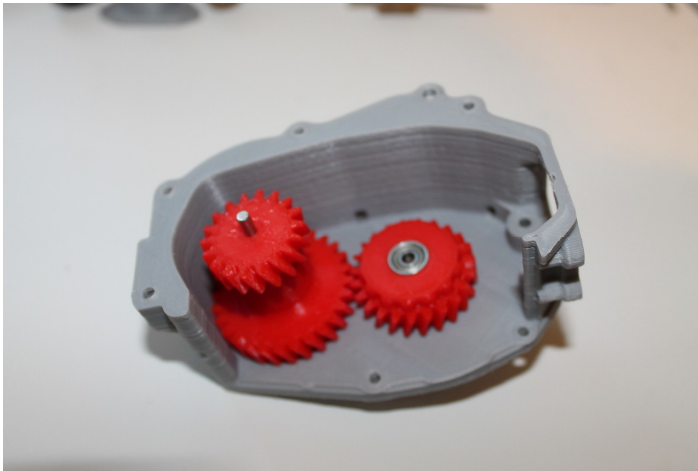
Step 3:



Using a file or sand paper, roughen up the 3mm Input Shaft.

Using super glue, apply a few drops to the inside of the Transfer case Input shaft and slide onto the input shaft.

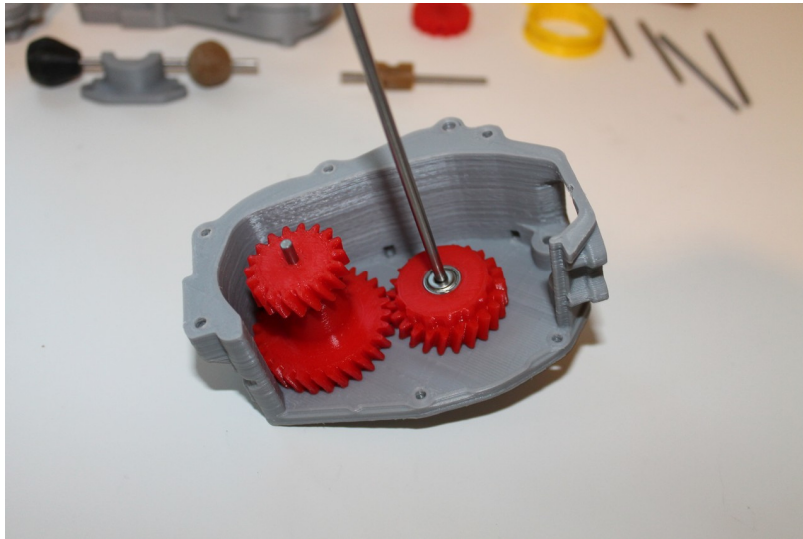
Step 4:



Insert the input shaft into Low Range Gear 1. Shaft should only be inserted into the plastic section. It should not protrude into the bearing. Tighten set screws.

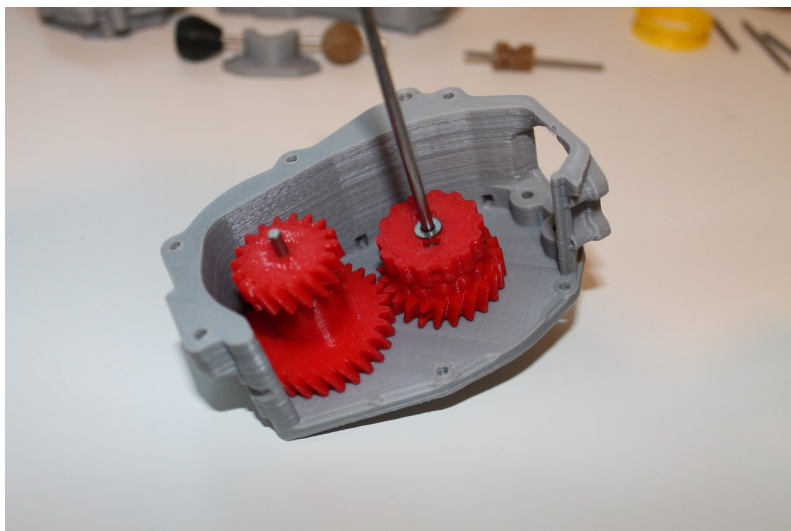
Note: When assembling, all rotating parts should be spaced apart with a 3mm washer. Depending on your printed parts you may need to use more or less washers.

Step 5:



Insert 4WD output Shaft into Low Range Gear.

Step 6:



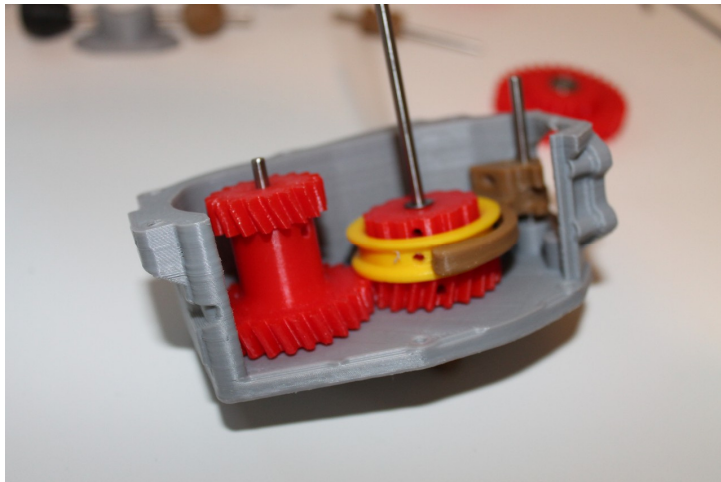
Slide on Low Range Shift Collar Gear, tighten set screws.

Step 7:



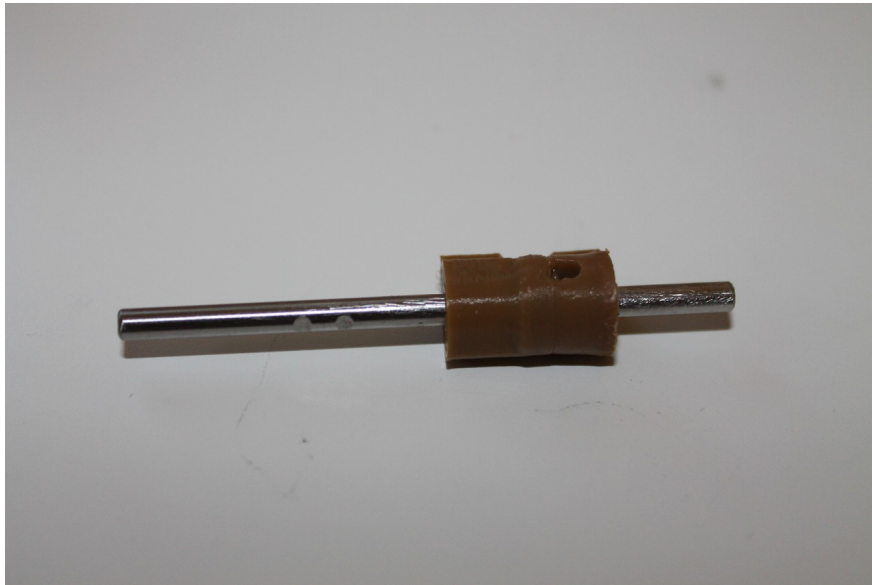
Insert Low Range Shift Rail into Low Range Shifter Fork, Shaft should protrude roughly 0.79" from surface shown.

Step 8:



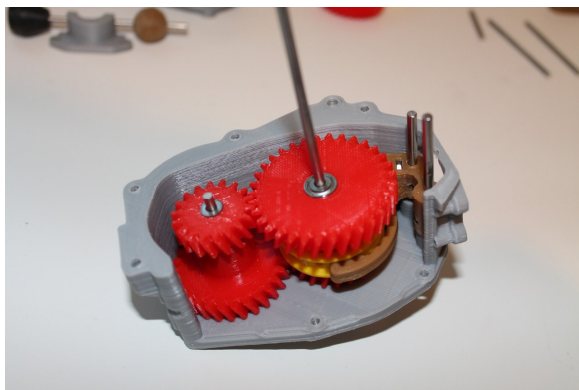
Insert Low Range Shift Collar into Low Range Shift Fork. Install, making sure to align set screw holes on the Low Range Shift Collar to the Low Range Shift Collar Gear. Low Range Shift Collar should spin freely inside Low Range Shift Fork .

Step 9:

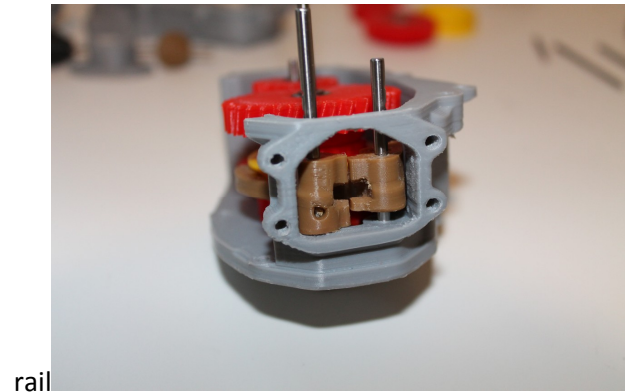


Using sand paper or a file, roughen up the 4WD shift rail. Using super glue install 4wd selector onto the 4WD shift rail. Shift rail should protrude 0.45" on the right side. Refer to picture above.

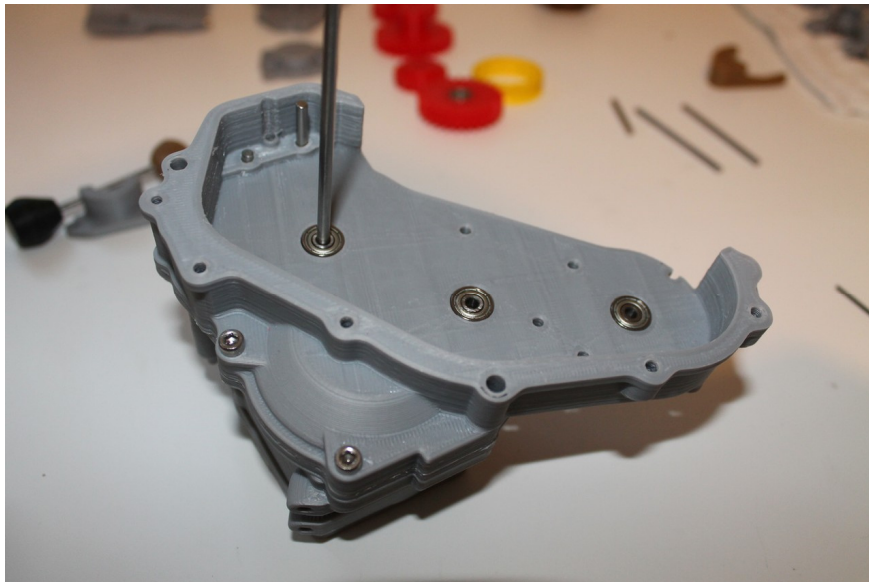
Step 10:



Slide Low Range Gear 2 onto output shaft. Install 4WD shift

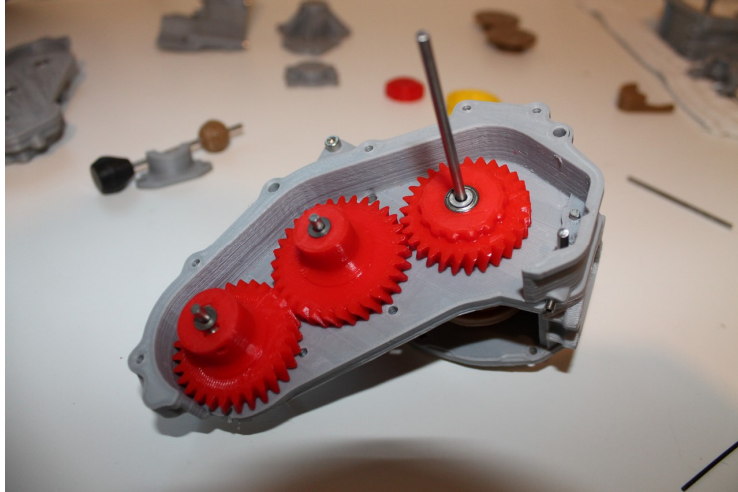


Step 11:



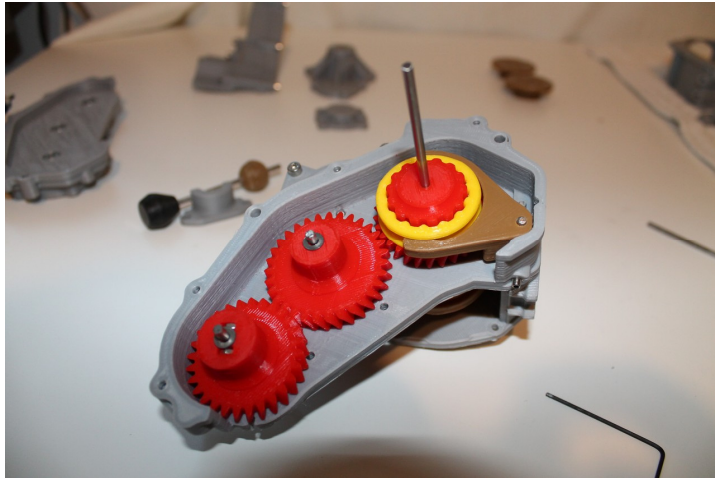
Install transfer case housing 2.

Step 12:



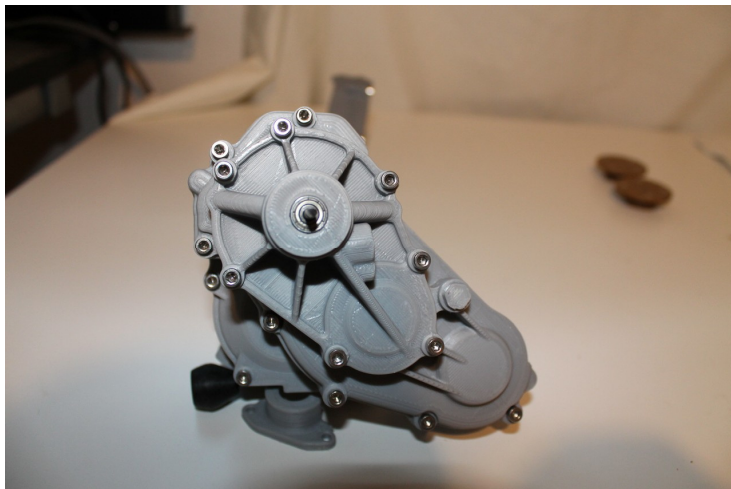
Install 4WD output Shaft into 4wd Final Gear.
Install 4WD idler shaft into 4wd Idler.
Slide 3WD Gear onto output shaft.

Step 13:



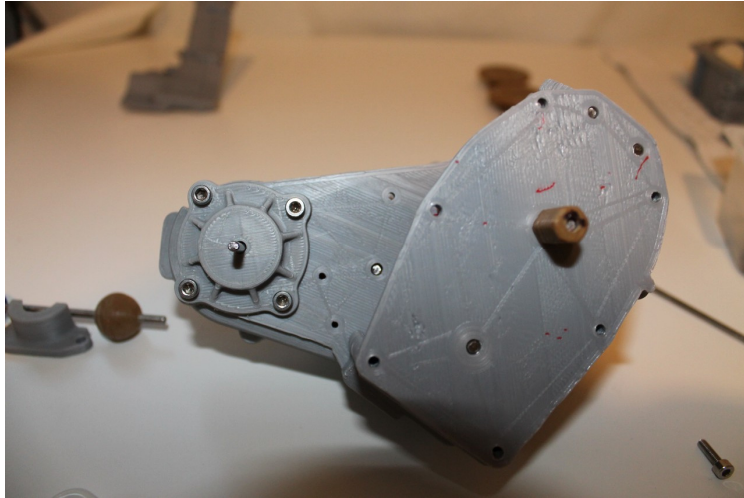
Slide Transfer Case Shift Collar Gear onto output shaft. Assemble 4WD shift collar onto 4WD Shift Fork and slide onto shift rail.

Step 14:



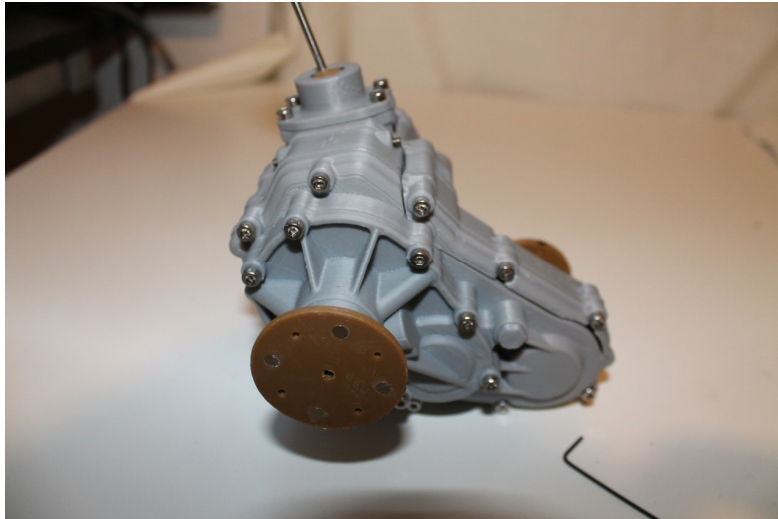
Install Transfer Case Housing 3

Step 15:



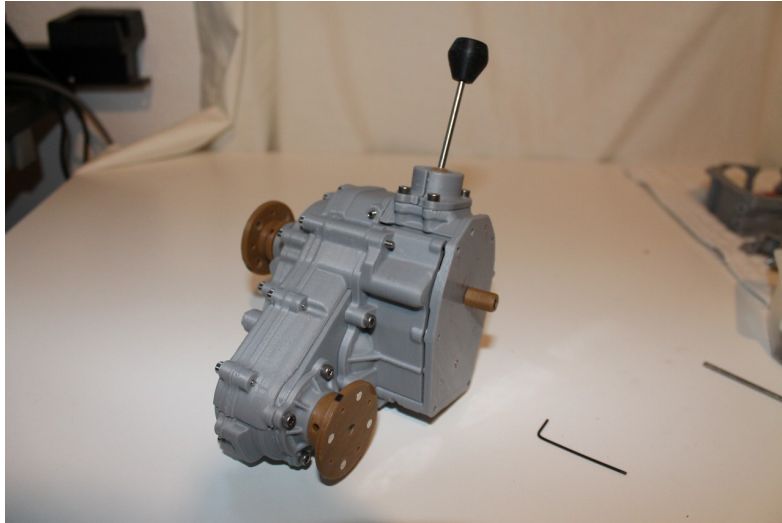
Install Transfer Case Housing 5

Step 16:



Install output flanges.

Step 17:



Using the Shifter shaft, glue the two Shifter Ball Tops together.
The 3mm shaft should protrude 0.375" from ball.

Assemble Transfer Case Covers as shown.