

1. Power system down, disconnect the power cord from outlet.
2. Remove the cover from the Focus Carriage (refer to **XL Operations Manual Section 4-2 Figure 2**).
3. Lower Left Side Panel (refer **XL Operations Manual Section 4-4 Figure 8**).
4. Pull X Axis Arm toward the front of the system.
5. Remove the 2 3/32 SHCS from the Air Wing. (**Figure 1**)

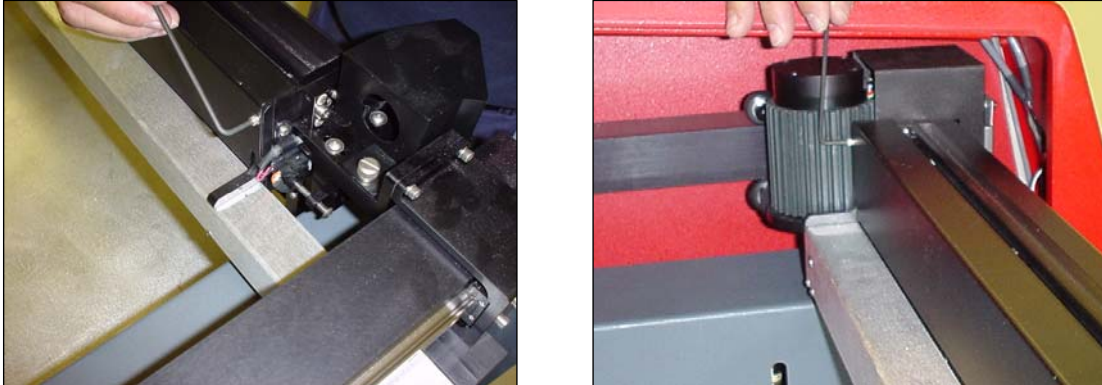


Figure 1

6. Observe tension of the belt before proceeding to step 7.
7. Loosen 5/64 BHS Belt Tension locking screw. (**Figure 2**)

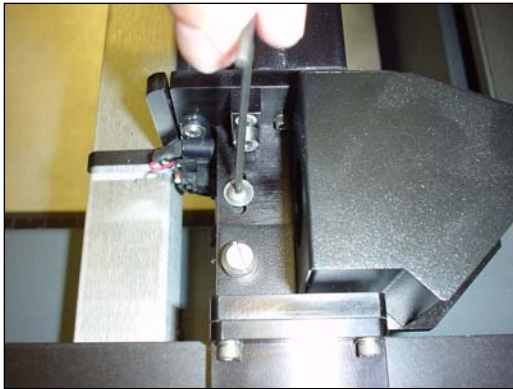


Figure 2

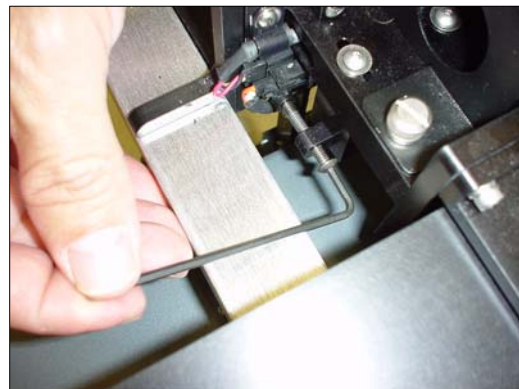


Figure 3

8. Remove tension from the belt by turning 3/32 Belt Tension Screw Counter Clockwise. (**Figure 3**)

9. Remove the 2 5/64 tapered screws. These 2 screws hold the Belt Clamp to the Focus Carriage. **(Figure 4)**



Figure 4



Figure 5

10. Remove only the bottom 7/64 SHCS. **(Figure 5)**
11. Using some force, lift up while pushing back on Focus Carriage causing the top 2 Guide Wheels out of rail tracks. **(Figure 6)**



Figure 6



Figure 7

12. While holding the Focus Carriage with your left hand, using your right hand gently pull the belt to the right until Belt Clamp is exposed. **(Figure 7)**
13. Remove the 1 remaining 7/64 SHCS from Belt Clamp, doing so will cause the belt to separate. **(Figure 8)**



Figure 8

14. Staple the end of new belt to the old belt, using the old belt as fish tape, pull new belt through X Axis Arm.
15. Reinstall the Belt Clamp, using only the top 7/64 SHCS, utilize entire portion on clamp. Reverse of step 13.
16. Gently move Belt Clamp to the back of the Focus Carriage Mounting Plate. The top 7/64 SHCS should fit perfectly into the hole. Reverse of step 12.
17. Walk the Focus Carriage back onto the rail reverse of step 11.
18. Install the bottom 7/64 SHCS and tighten. Fasten the Belt Clamp to the rear of the Focus Carriage Mounting Plate by installing the 2 5/64 tapered screws removed in step 9.
19. Match Belt Tension from step 6 by turning 3/32 Belt Tension Screw Clockwise.
20. Tighten 5/64 BHS Belt Tension locking screw loosened in step 7.
21. Reinstall Air Wing.
22. Connect power to system and test is simple raster file.