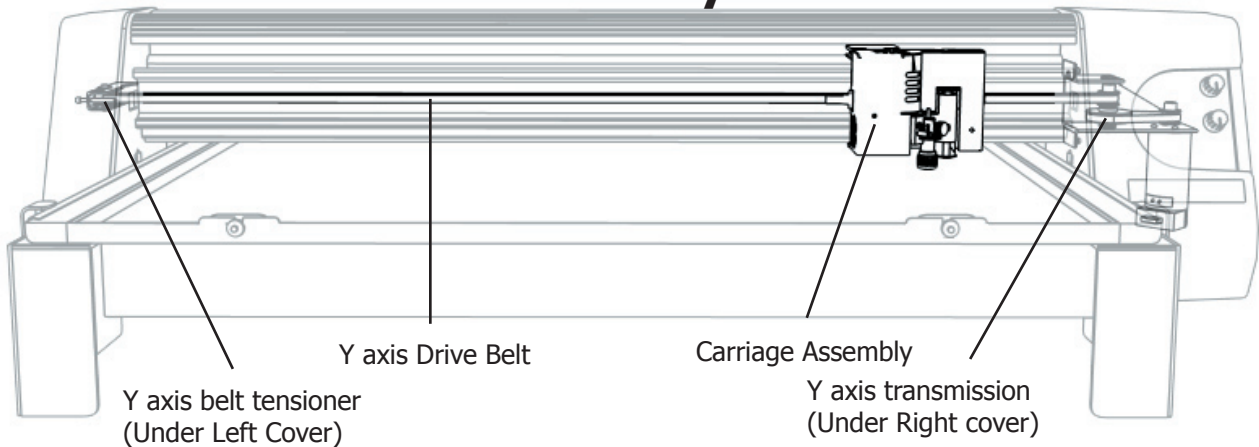


Y Axis Subsystem



CARRIAGE REPLACEMENT 200/300/350HF (350 HF shown)

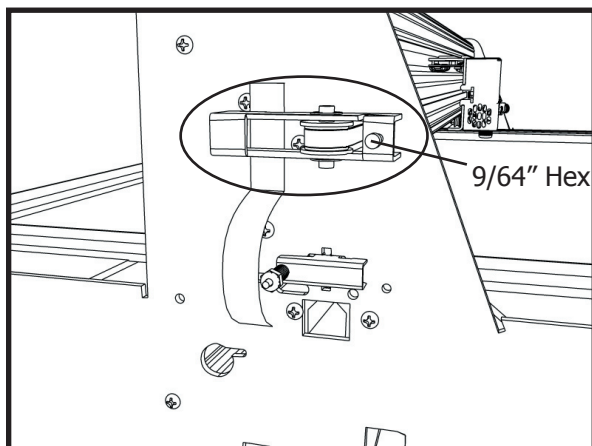
Step 1. - Removing the Covers

1. Shut off the cutter and remove the power and computer data cables.
2. Remove the left (2 screws) end cover. See *Removing the End Covers in the 300 service manual* available for download on www.ioline.com

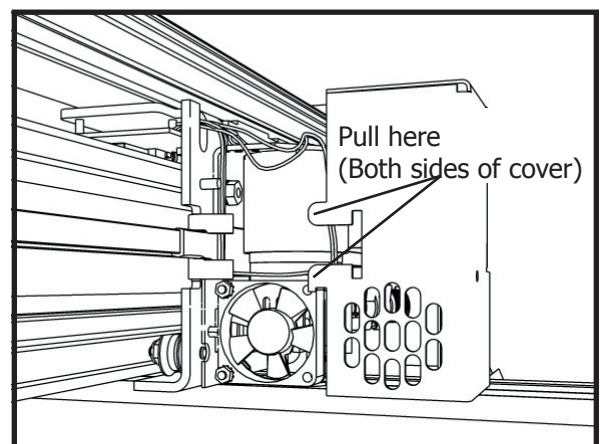
Step 2. - Removing the Carriage

1. Mark the screw on the Y axis belt tensioner with “White-Out” to mark the position of the screw before you loosen it. Loosen the allen screw on the belt tensioner until the the bracket is flat against the end plate. Do not remove the screw.
2. Remove the cover of the carriage by pulling out on both sides of the cover.

Note: It is not necessary to remove the cover on a 200/300 System cutter.

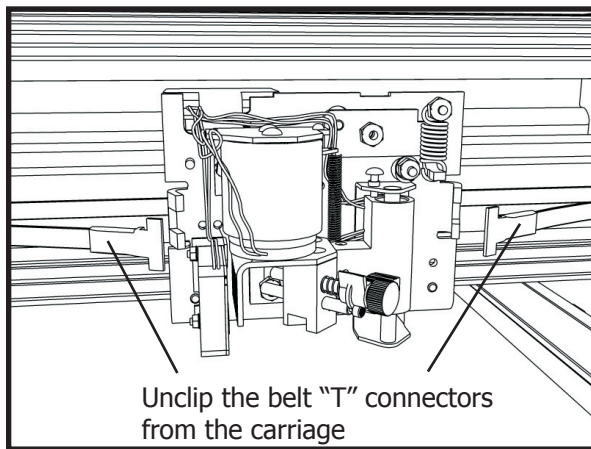


Y Axis Belt Tensioner



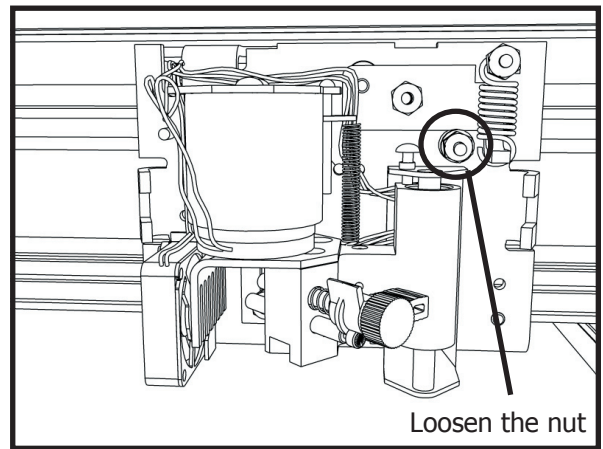
Removing the cover

3. Grasp one of the metal “T”-connectors on the end of the Y Axis belt and pull it toward the center of the carriage until it pops free. Make sure that the tensioner assembly is not tangled in the belt. Remove the other end of the belt from the carriage.



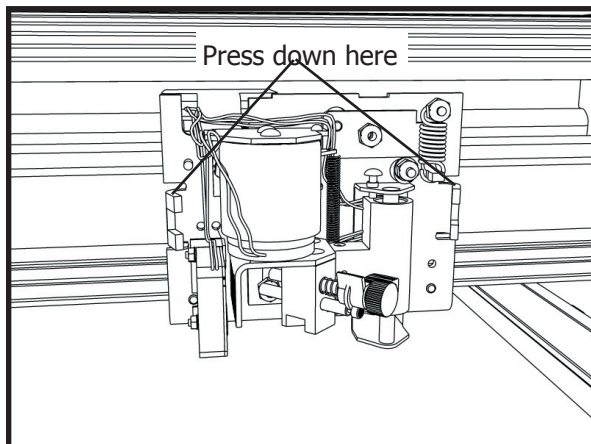
Removing the "Y" axis belt clips

4. **350HF ONLY:** Loosen the Top wheel locking nut on the carriage. This dis-engages the top spring wheel so the carriage can be removed from the machine.



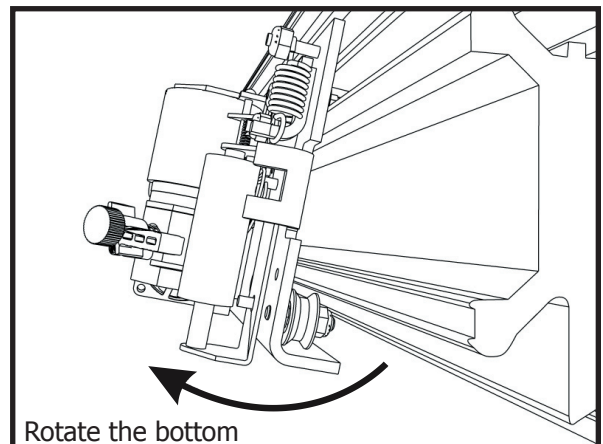
Top wheel "Lock"

5. Remove the carriage from the machine by pushing down on the belt attachment fingers.

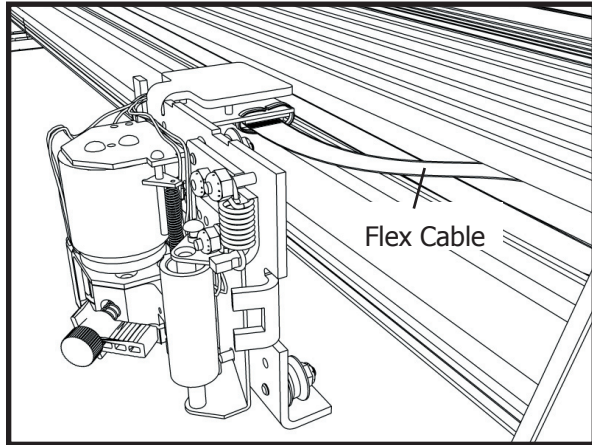


Carriage assembly removal

6. While pushing down, pull the bottom of the carriage assembly toward the front of the machine.

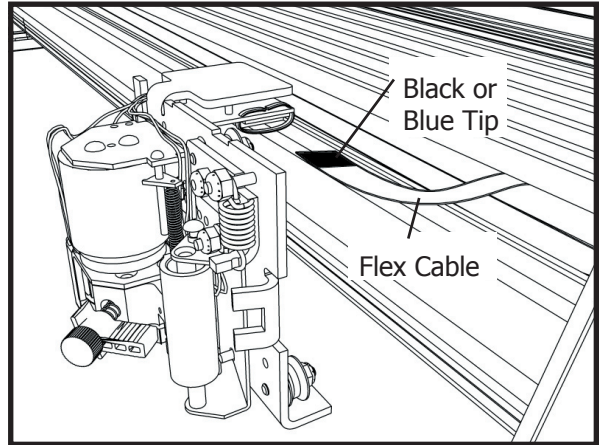


7. Pull the carriage slowly toward the front of the machine being sure not to damage the flex cable.



Flex Cable (Plugged in)

8. Carefully pull the flex cable from the socket on the carriage.

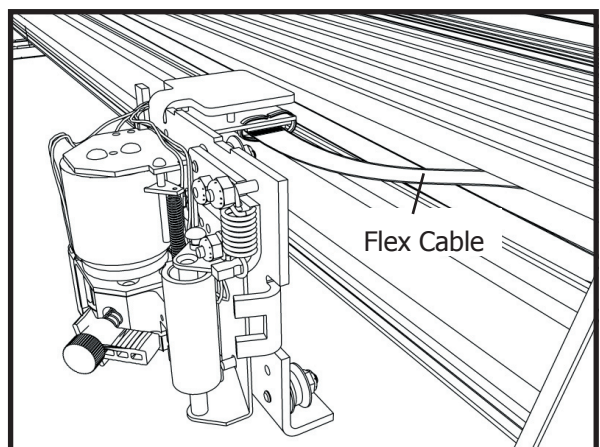
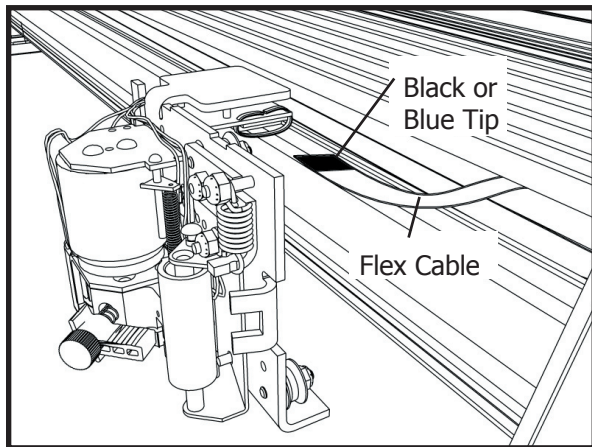


Flex Cable (Unplugged)

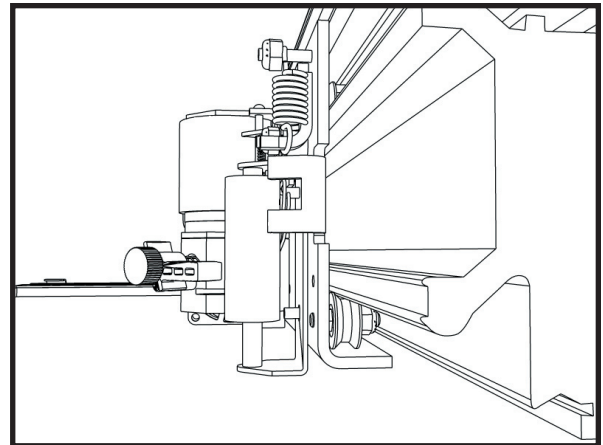
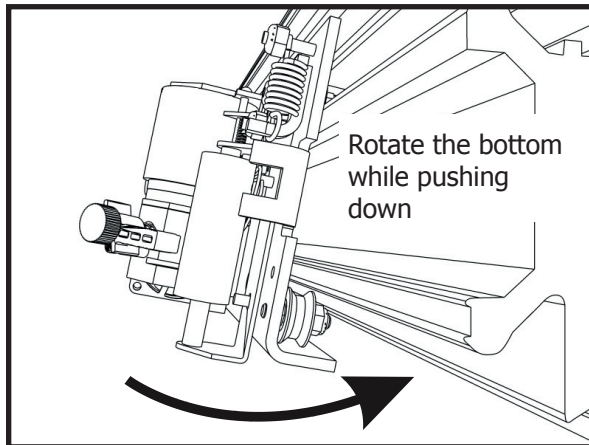
Note: If you are replacing the Flex cable, move on to Page 68 "Removing the flex cable"

Step 3. - Install the new Carriage

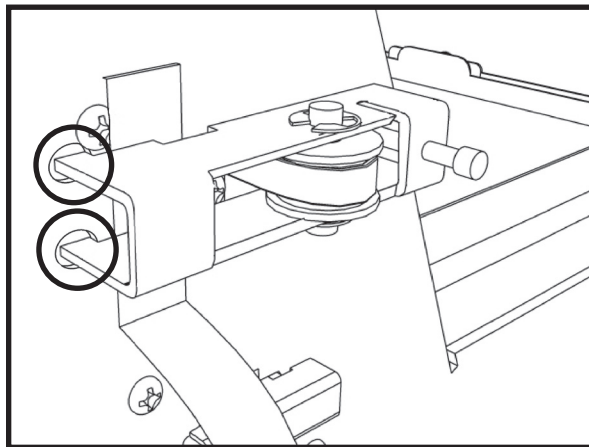
1. Plug the Flex cable into the socket on the new carriage. Thread the cable through the Tyrap being sure to fully plug the cable in. Be sure the colored end (Black or Blue) is facing "UP" when it's connected.



2. Mount the new carriage by aligning the upper wheel with the upper rail, push down on the belt attachment fingers, then slip the lower wheels onto the bottom rail and let the carriage rest.

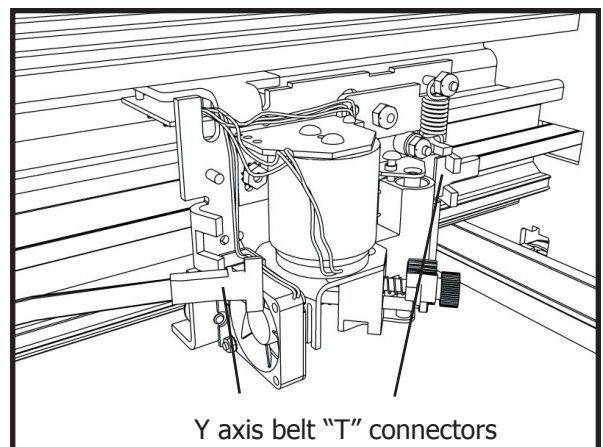


3. Align the tensioner assembly with the indentations on the left end plate



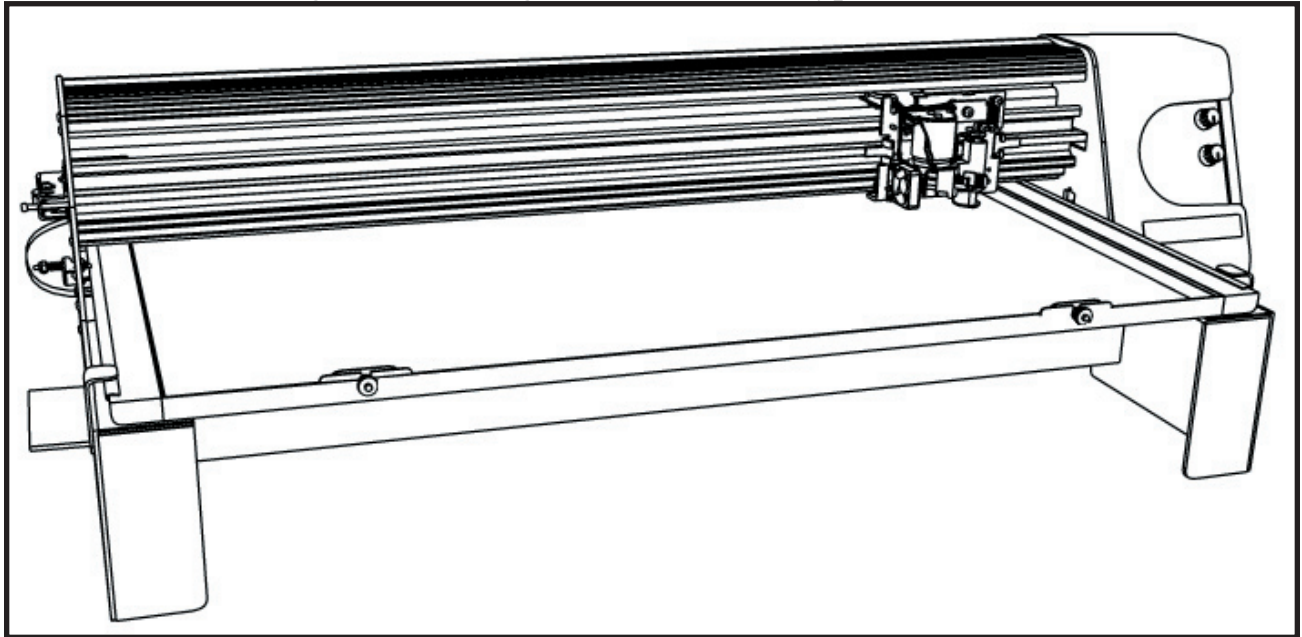
Indentations in the left plate

4. Hook the metal "T" connectors into the "Fingers" on the front of the carriage body.

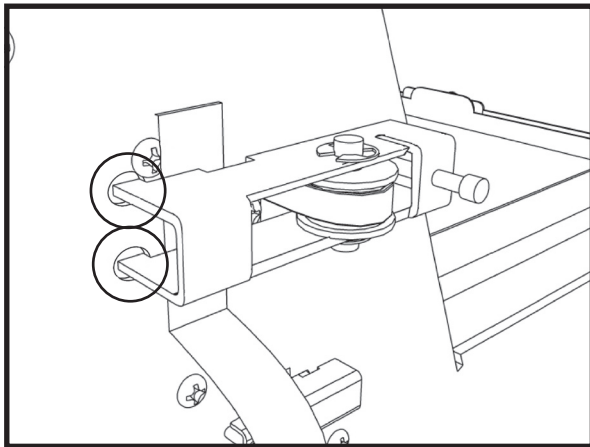


Re-attach the Y axis belt clips

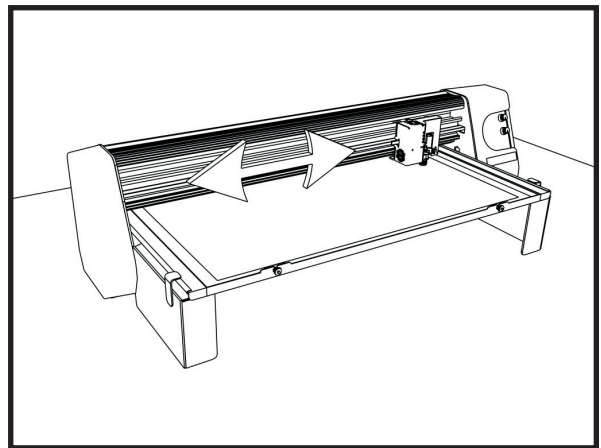
5. Move the carriage to the far right closest to the keypad.



6. Make sure all three points of the belt tensioner are in the indentations correctly as you tighten the 9/64" hex screw on the belt tensioner. Tighten the screw until you reach the "White-Out" mark on the screw.



7. Move the carriage assembly back and forth (by hand) to make sure there is free movement. The carriage should move back and forth very smoothly, and the belt should have a moderate amount of tension.



8. Plug the power cord into the machine and perform test cuts. If problems arise, contact Ioline Customer Service.