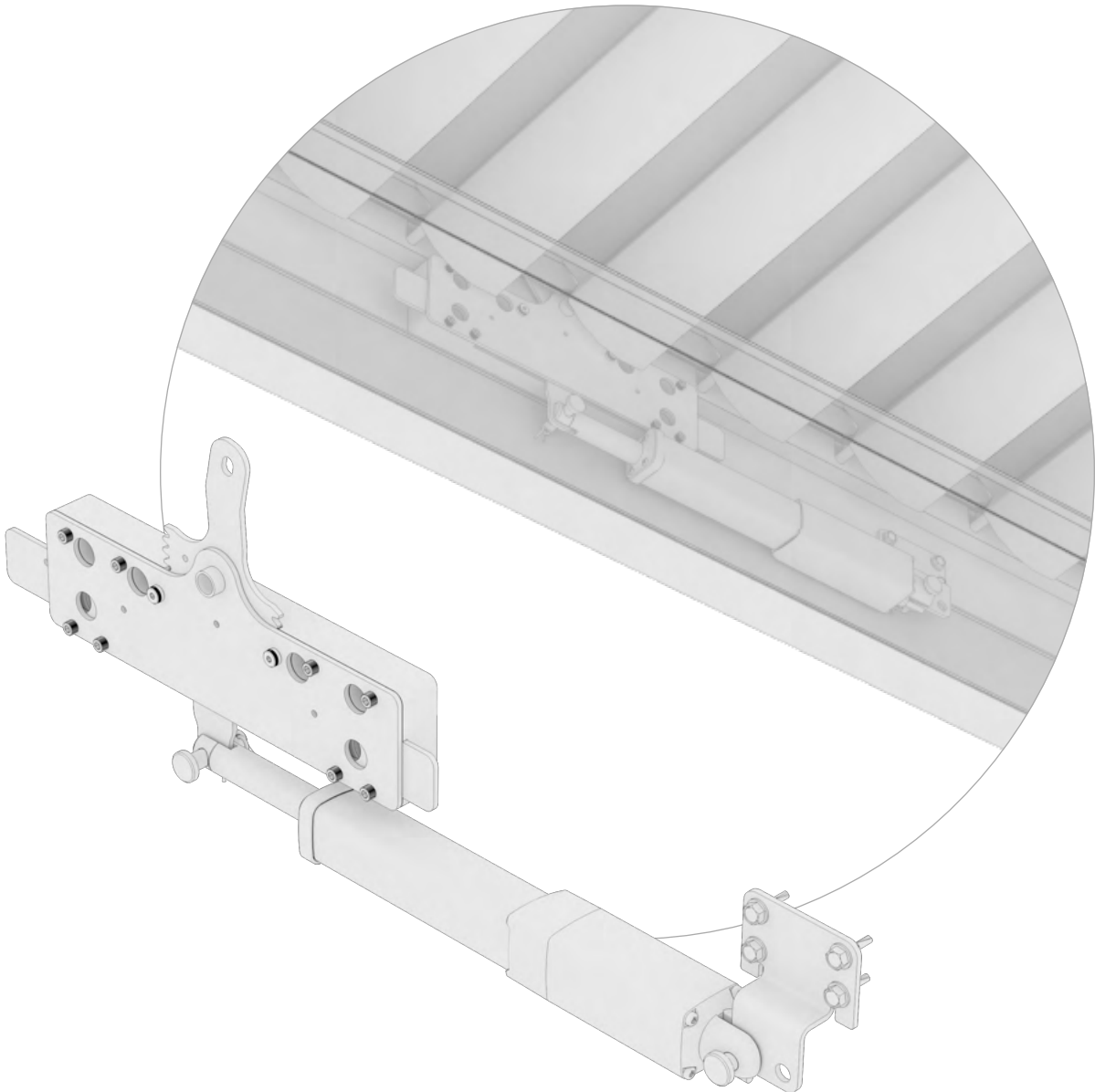


# X Drive

Assembly Instructions



The following sequence of instruction is the recommend process to assemble your X Drive successfully.

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<b>04</b>	——	Before You Begin	<b>13</b>	——	Louvers Installation
<b>05</b>	——	X Drive Overview	<b>14</b>	——	Cap/Bar Lock Assembly
<b>06</b>	——	Identifying Pins	<b>15</b>	——	Actuator Installation
<b>07</b>	——	Drive Louver Assembly	<b>16</b>	——	Securing X Drive
<b>08</b>	——	X Drive Assembly	<b>17</b>	——	Extending Actuator
<b>11</b>	——	Housing Arrangement			
<b>12</b>	——	Pinon Arm Positioning			

# Before You Begin.

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Tools you need.



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**Ladder**

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**Drill**

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**Mallet**

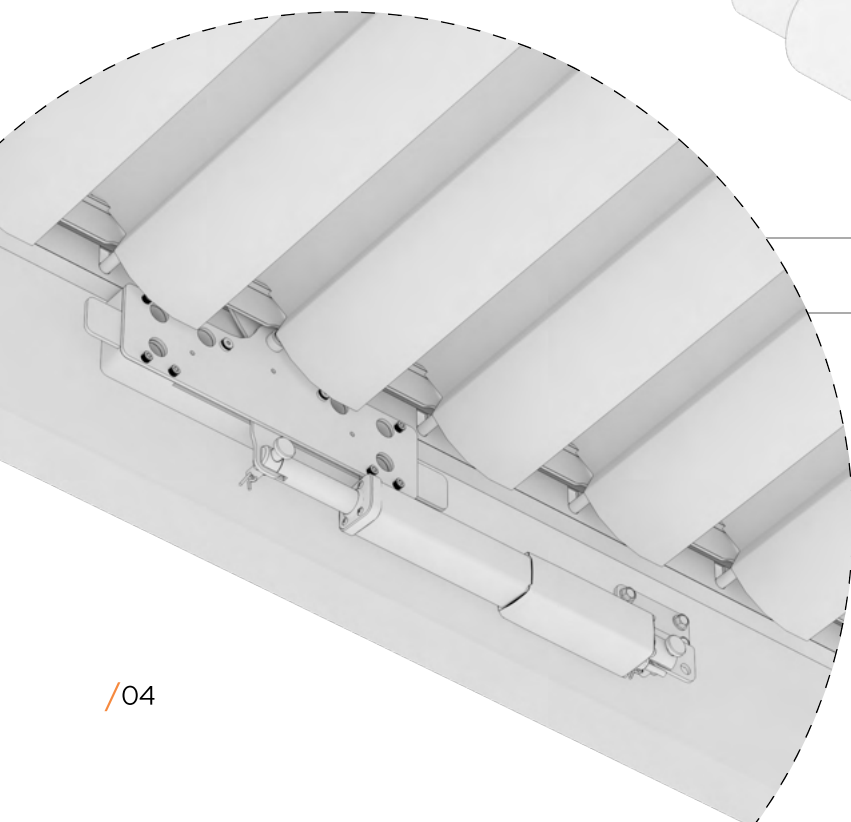
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**Hanger Bolt Driver (Size #14)**

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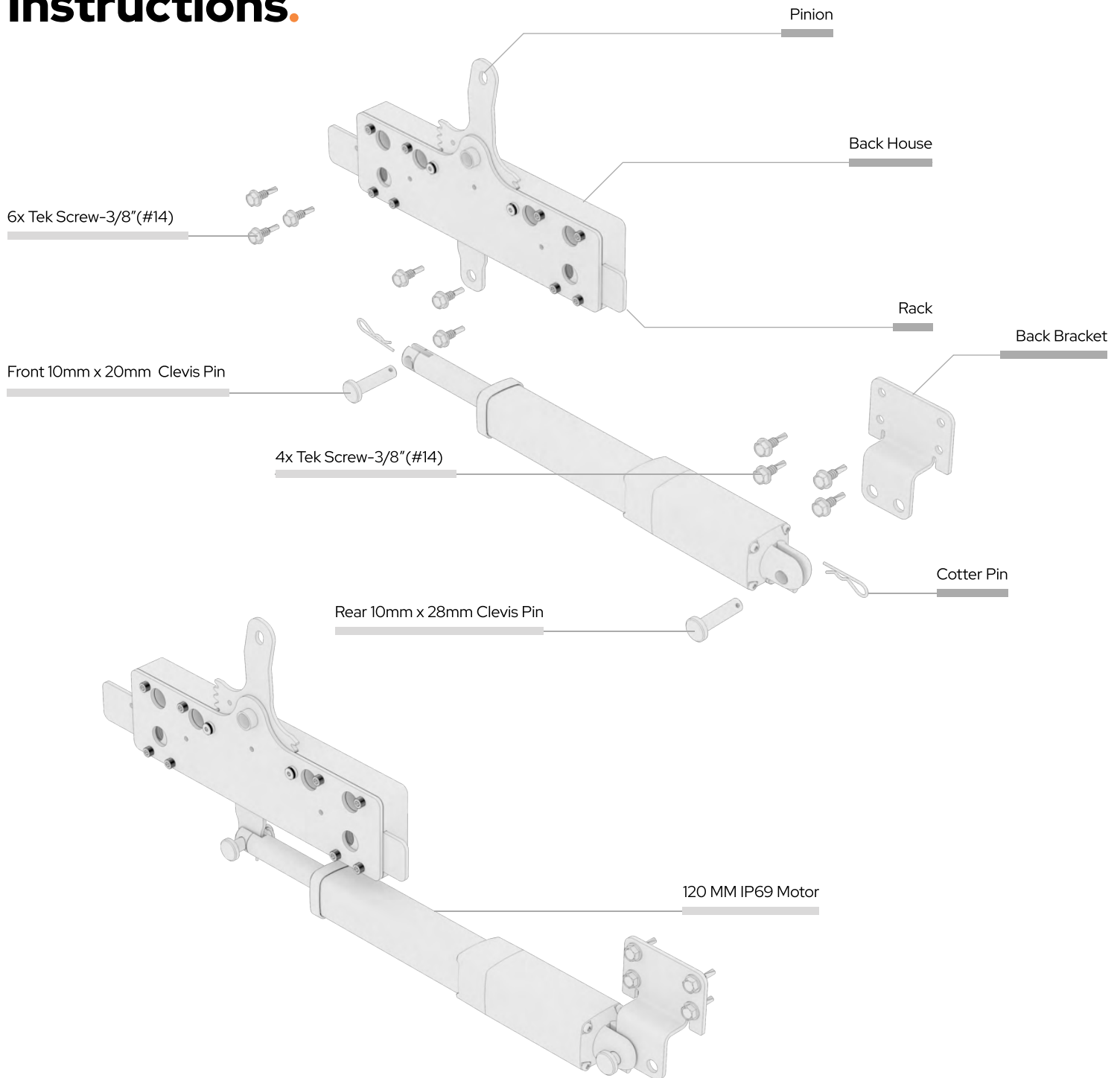
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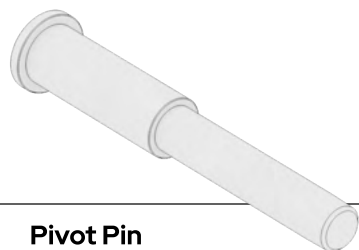
**Installed X Drive System**

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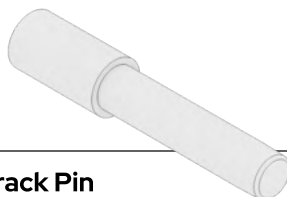
The gutter is removed throughout instruction for ease of understanding. Please have gutter installed prior to installing your X Drive.

# Assembly Instructions.

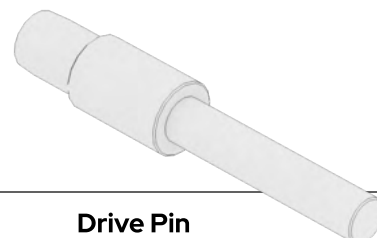




Pivot Pin



Track Pin



Drive Pin

## STEP 01

A

**Assemble** the drive louver being careful to identify which side is to receive the X Drive (high side).

**Identify** the unique drive pin, remove from X Drive assembly, and mount to the drive louver.

Be sure to assemble the unique drive pin on the X Drive end of the louver, and the standard pivot pin on the opposite end.

Louver

Track Pin

Drive Pin

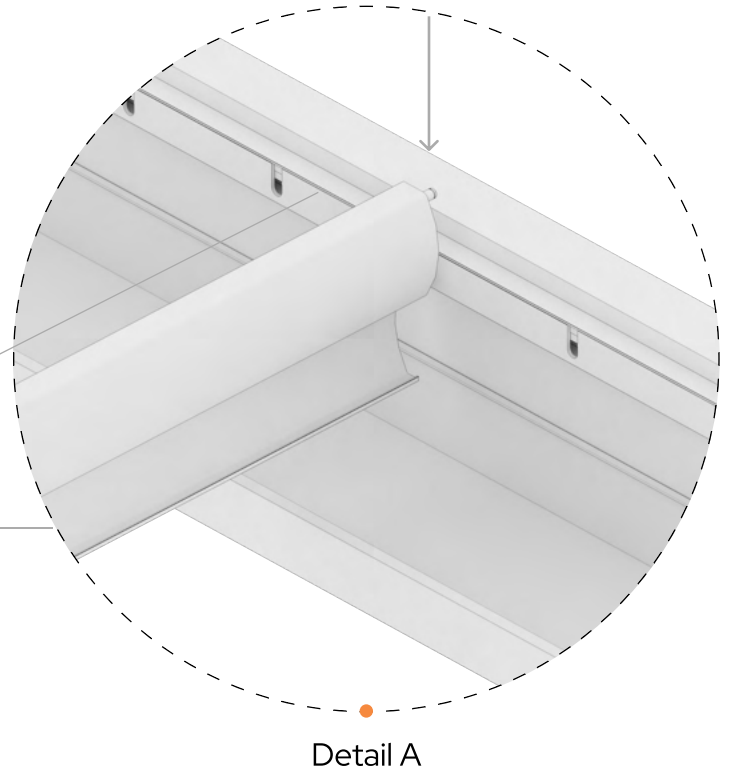
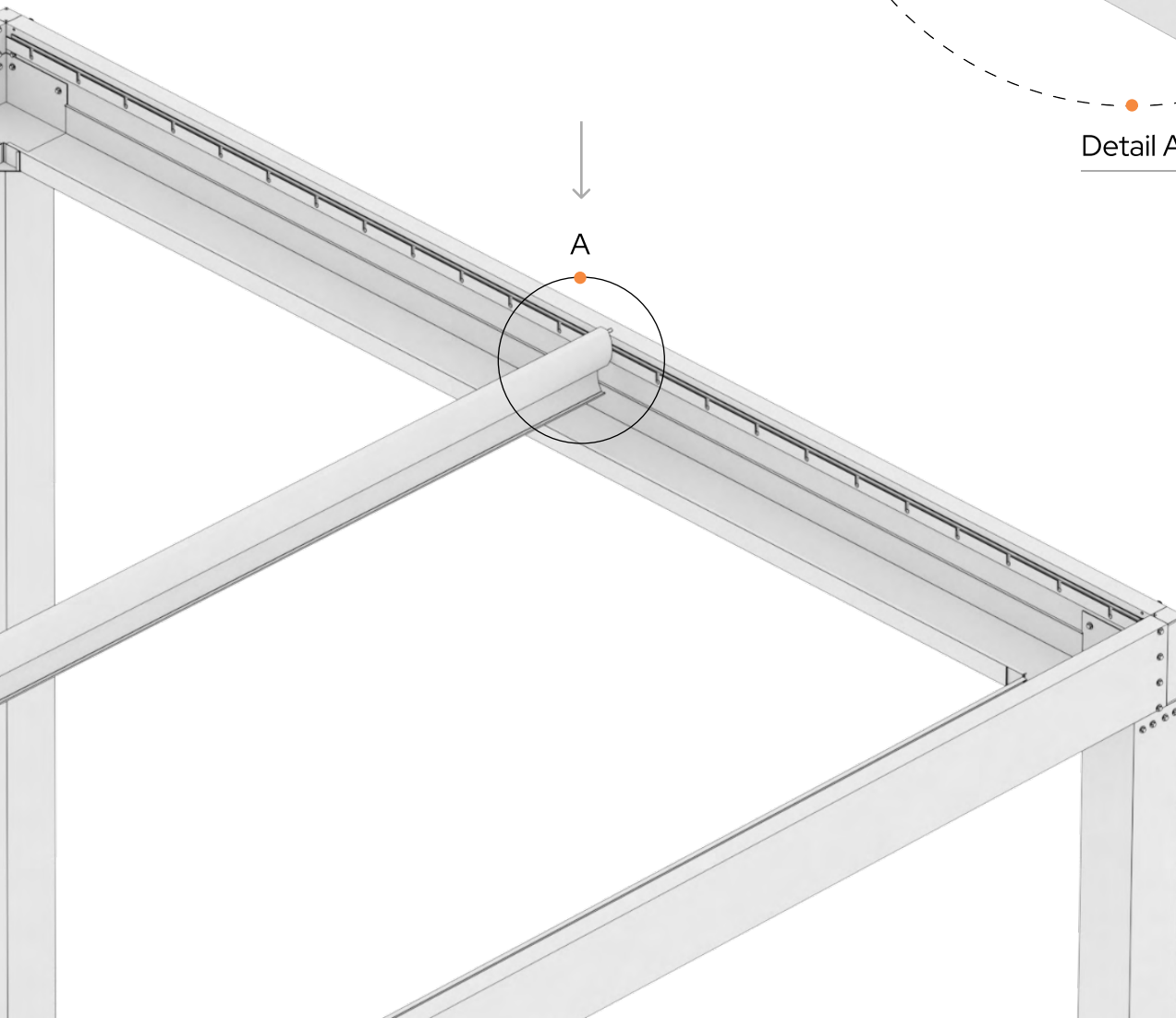
Track Pin

Pivot Pin

**STEP 02****A****Place** Drive Louver in desired (center) location

Track Bar

Louver

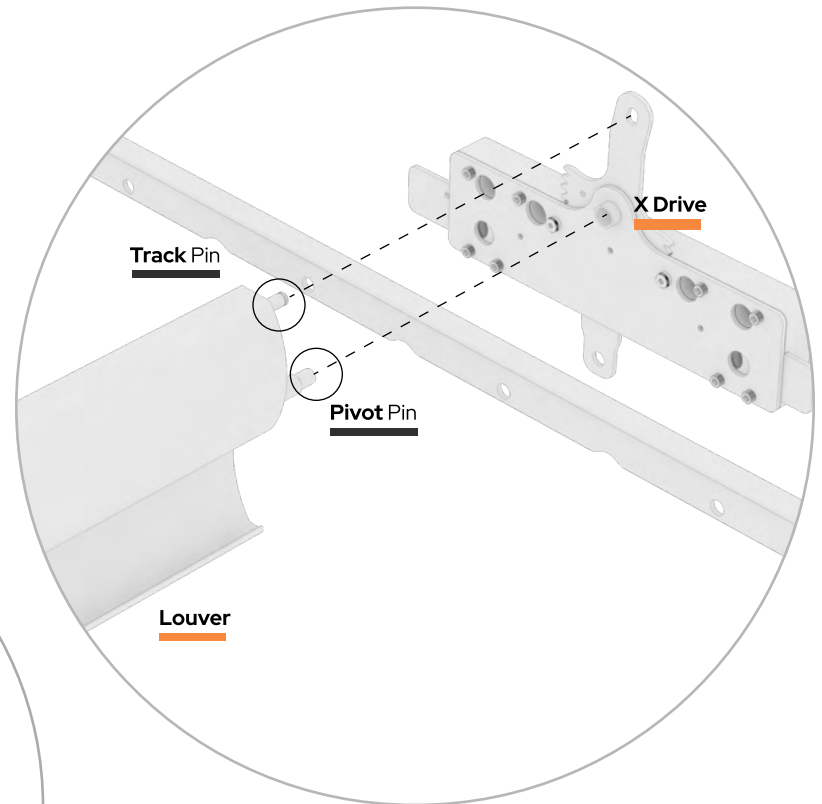
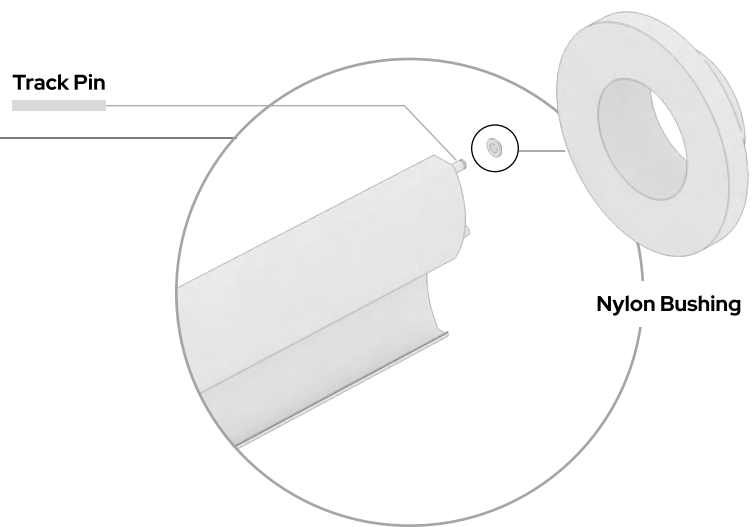
Detail A

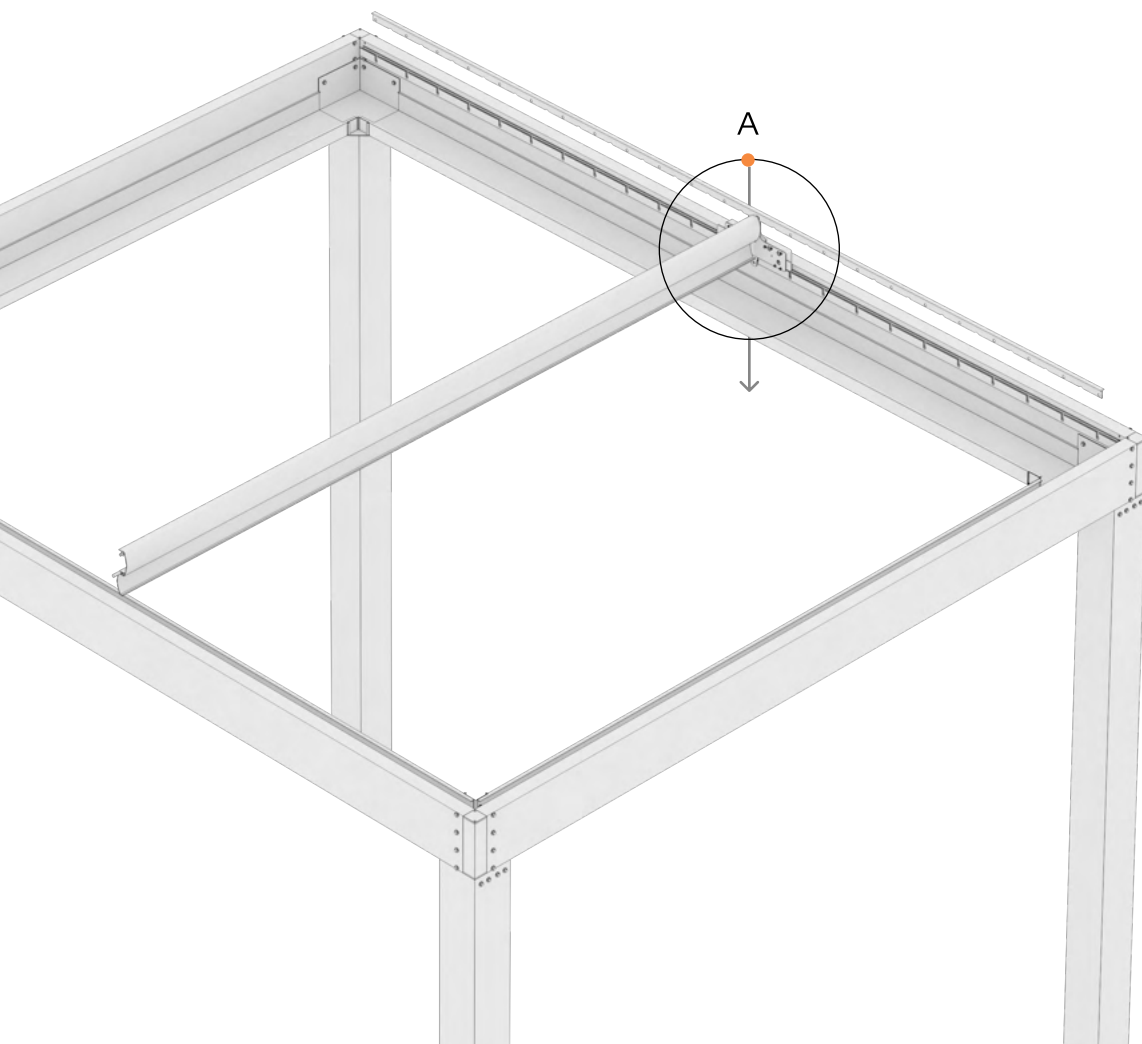
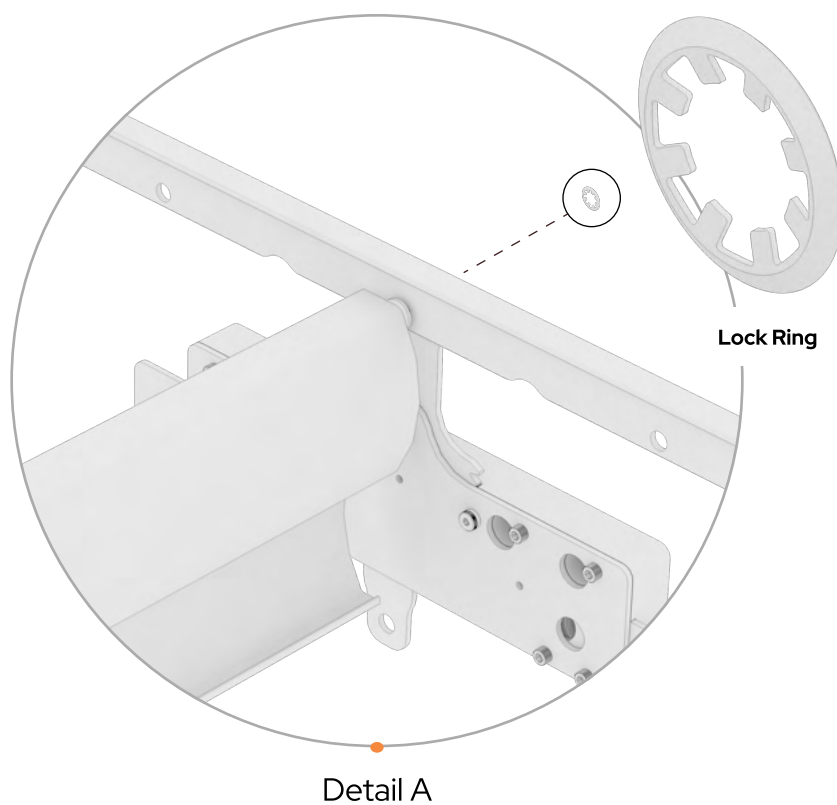
**STEP 03****A****Install** the Nylon Bushing to Track Pin**Place/Mount**

X Drive to Louver

**B****Assemble** X Drive to the Drive Louver:

Lift louver at drive location and slide  
X Drive on **Pivot Pin** and **Track Pin**.

Leave Loose**C****Integrate** track bar to the Driver Louver

**D****Install** the Lock Ring in the Track Pin



## STEP 04

A

**Lift** opposing end of louver and pivot up and out in order to place the X Drive end into space between pivot bar and gutter.

**Drop** opposing end back into place

Pivot Bar

Drive Louver

X Drive

Detail A

01

02

## STEP 05

A

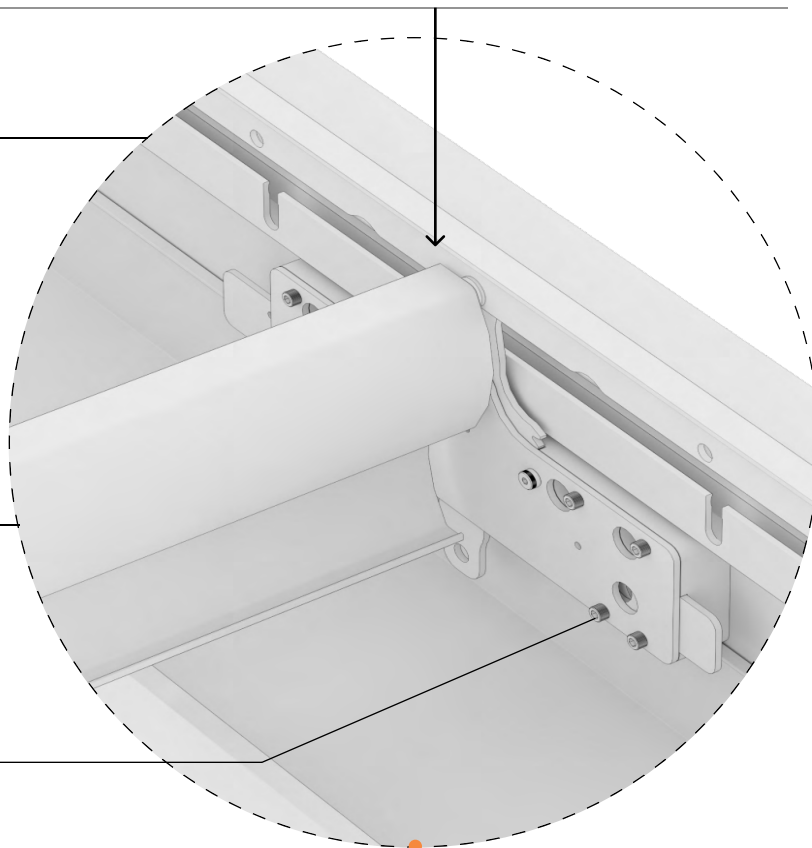
**Fasten housing to beam:**

Allow assembly to rest on pivot bar, and Drive Pin.

Pivot Bar

Drive Louver

X Drive



Detail A

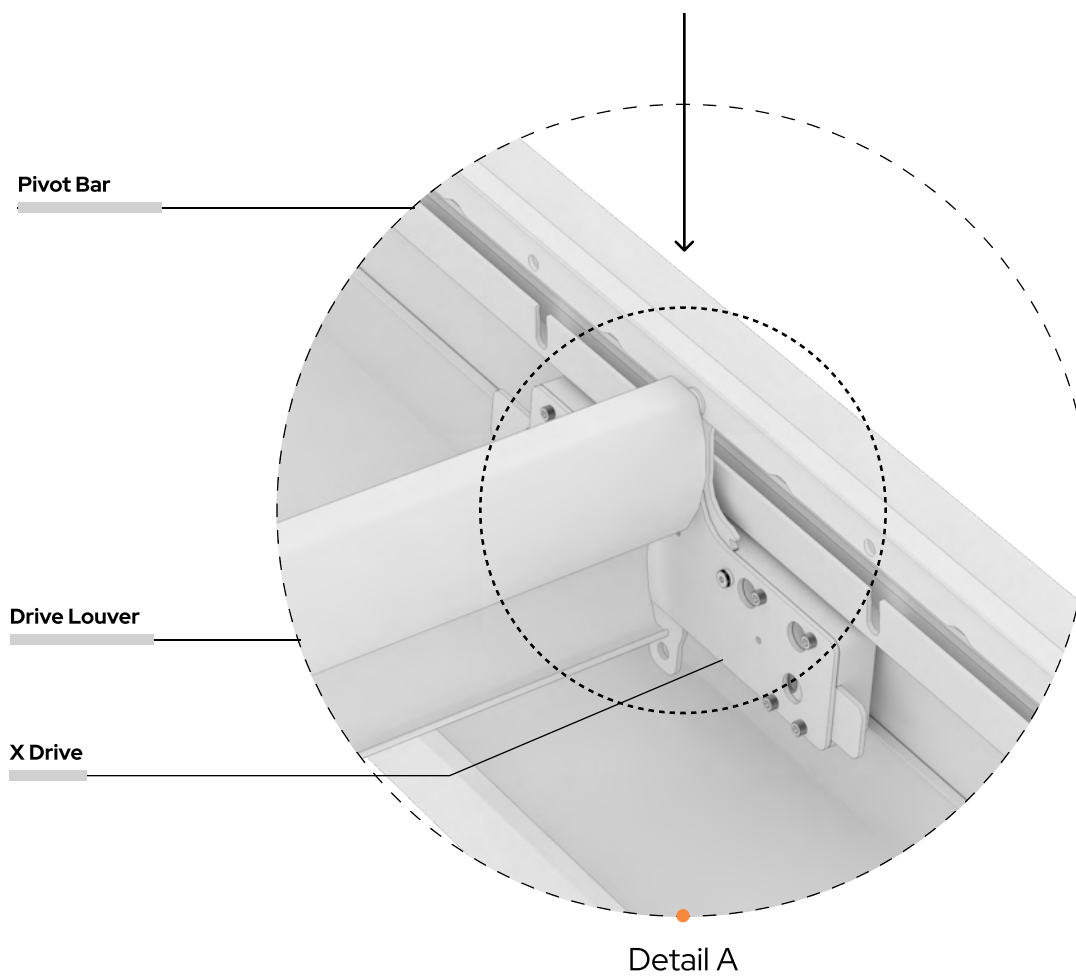
A

B

**Arrange** housing parallel to pivot bar and fasten with provided tech screens

**STEP 06****A**

**Align** the pinon arm vertically and use provided alignment hole to fix in place.

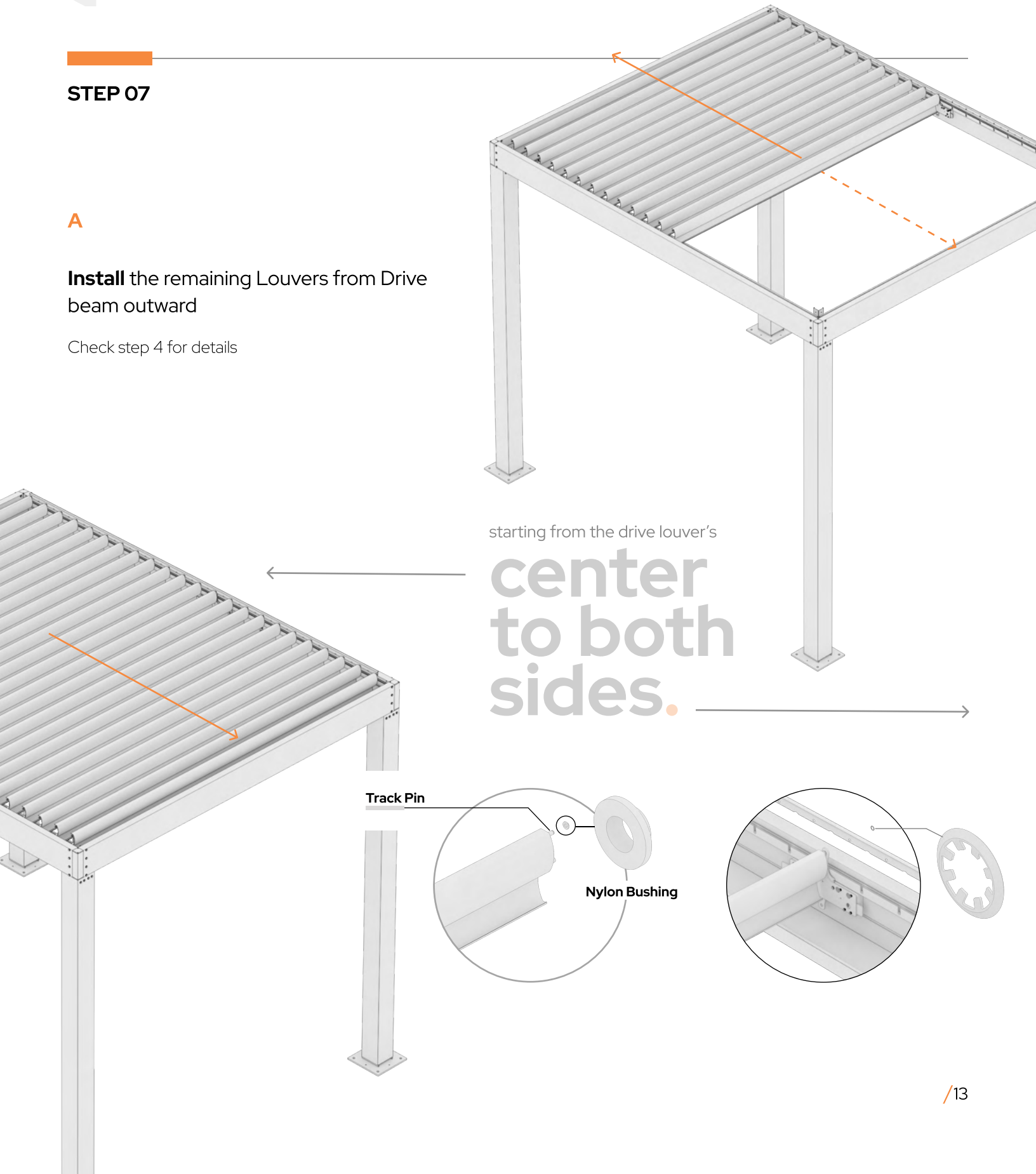
**B**

**Fix** Louver to vertical position using an 1/8" steel pin (or 1/8" drill bit)

**STEP 07****A**

**Install** the remaining Louvers from Drive beam outward

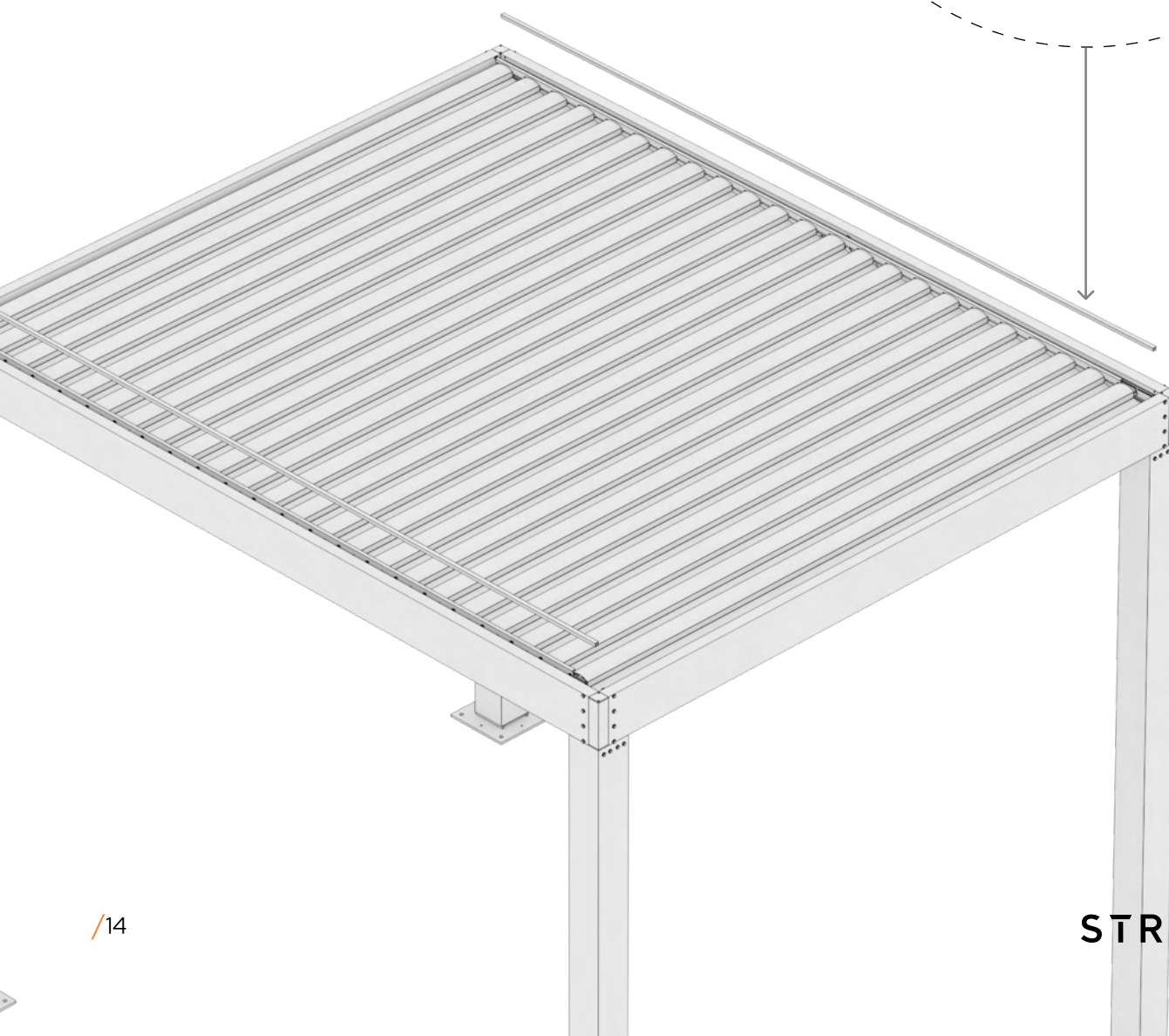
Check step 4 for details



**STEP 08****A****Finish** assembly of Cap/Lock Bar

Look at closeup on the right

Cap/Lock Bar



## STEP 09

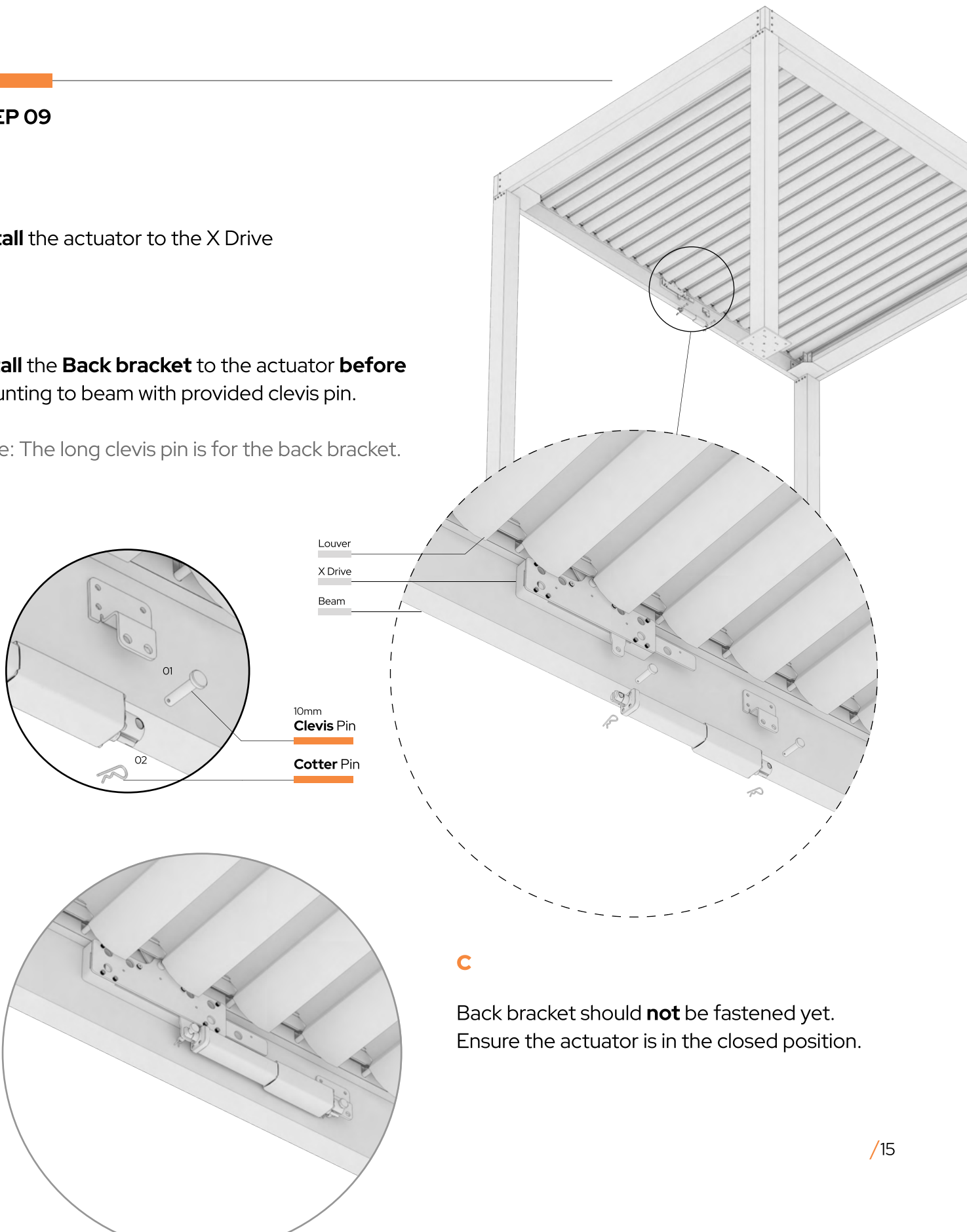
**A**

**Install** the actuator to the X Drive

**B**

**Install** the **Back bracket** to the actuator **before** mounting to beam with provided clevis pin.

Note: The long clevis pin is for the back bracket.



**C**

Back bracket should **not** be fastened yet.  
Ensure the actuator is in the closed position.

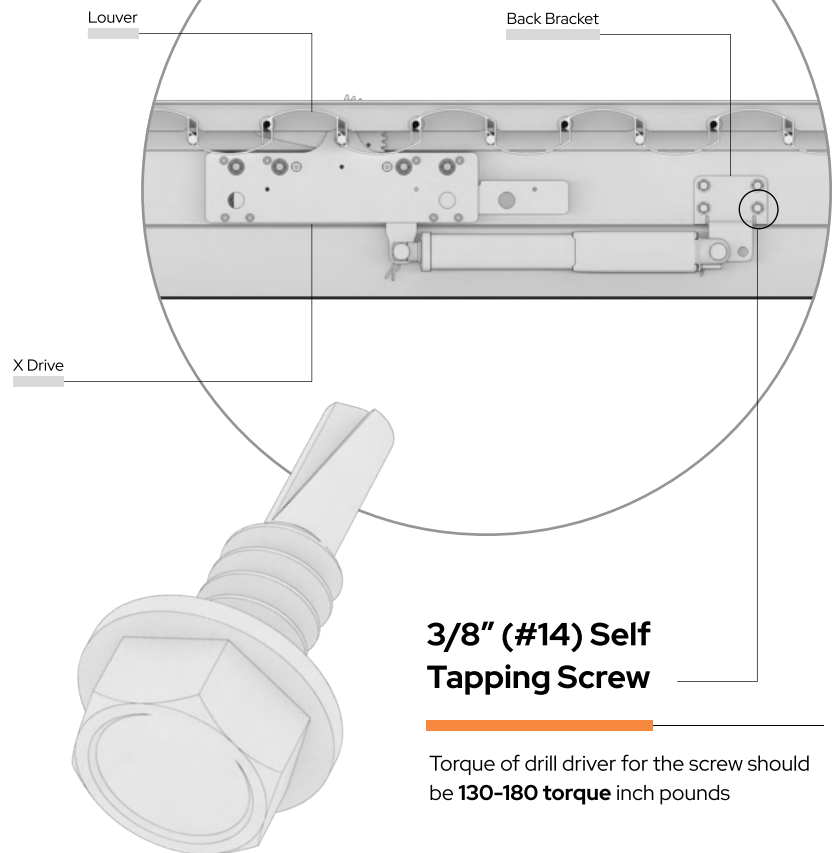


**D**

**Close** Louver assembly (by removing 1/8" pin/bit)

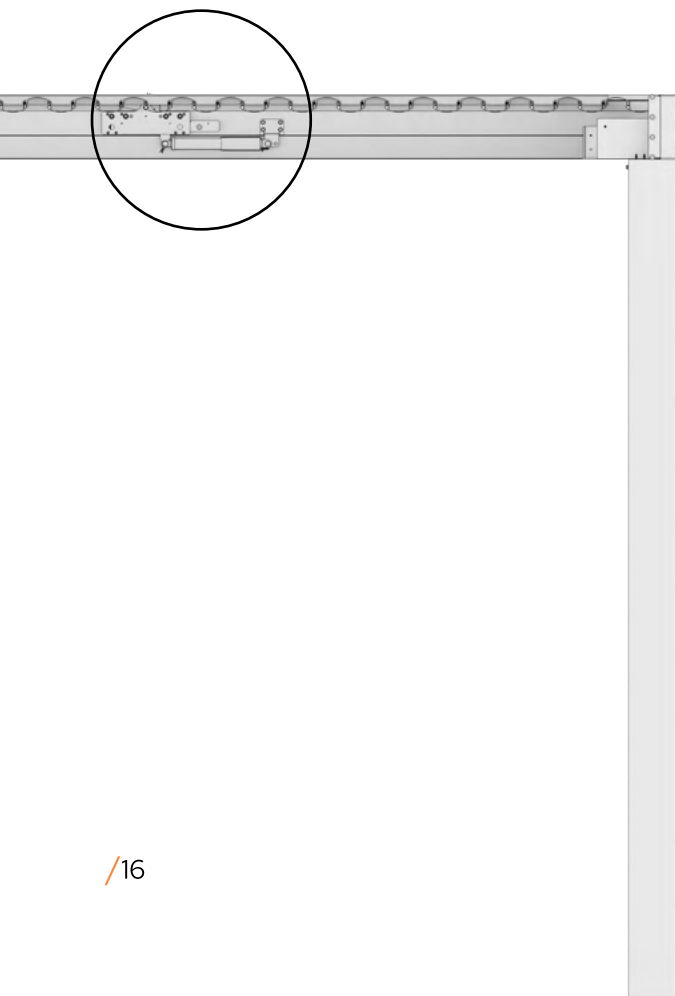
*with Louver Assembly closed, and with actuator in closed position.*

**Bring back** bracket to tension and fasten to beam with arms tight to gather as shown.



**3/8" (#14) Self Tapping Screw**

Torque of drill driver for the screw should be **130-180 torque** inch pounds



**E**

**Close** the louvers, and verify the actuator is in the closed position.

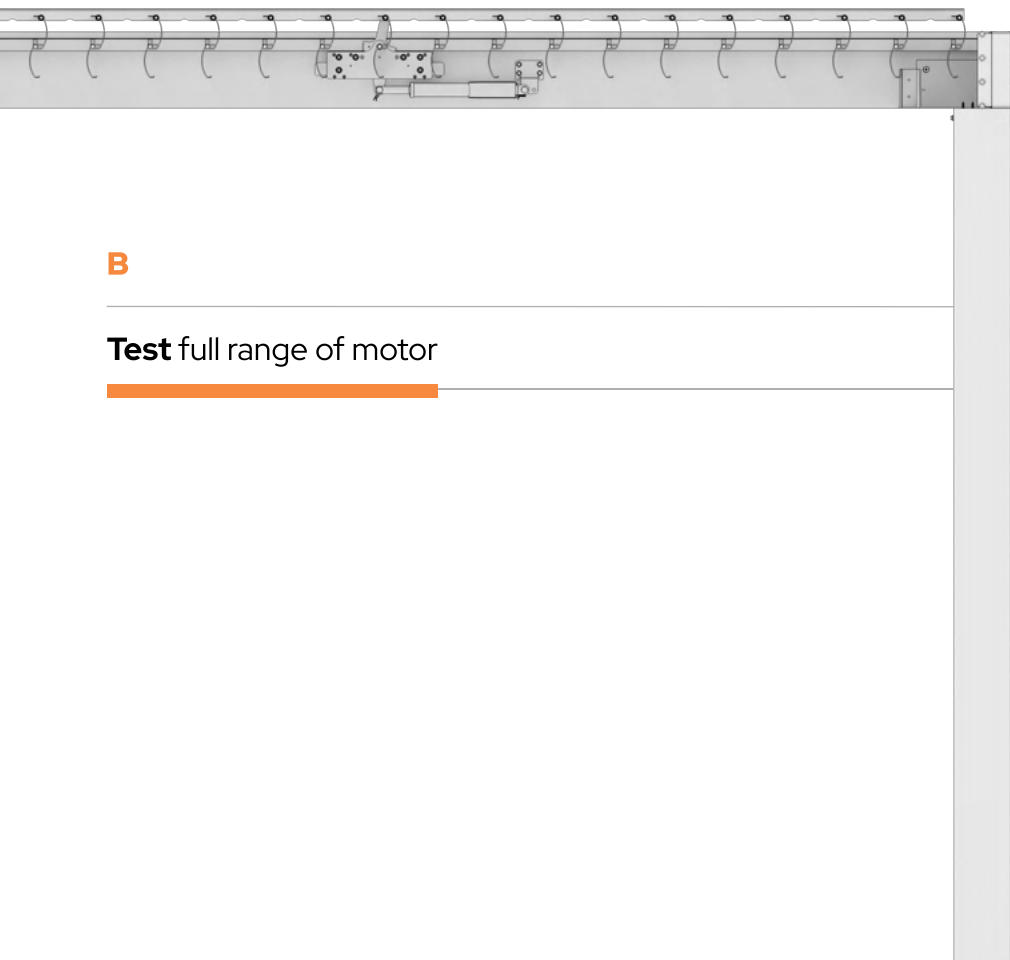
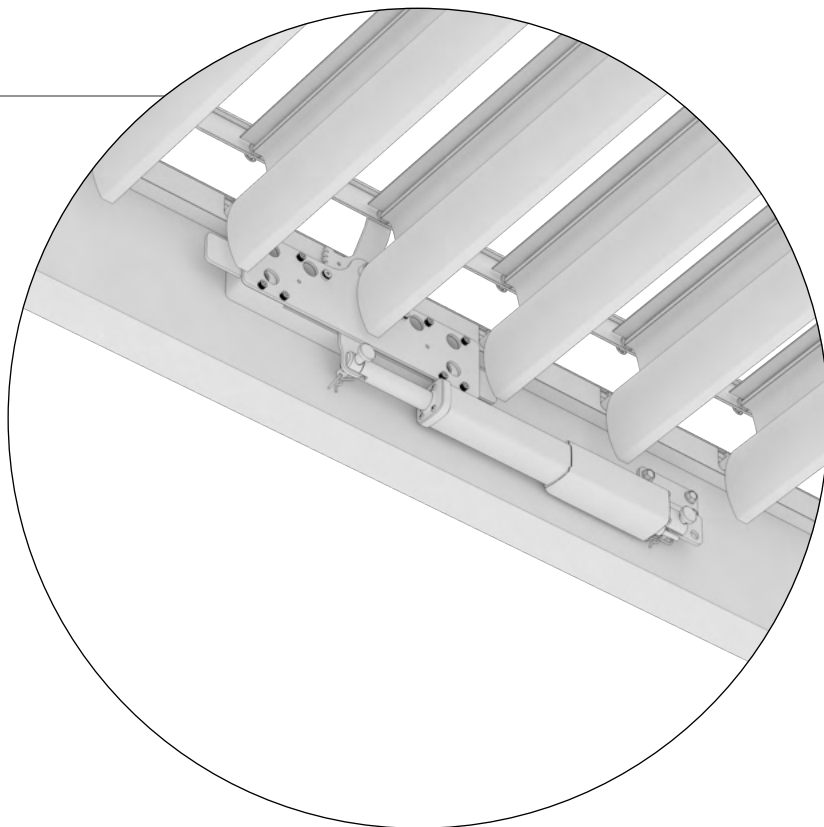
**F**

**Rest** Back Bracket against gutter lip and fasten tight to beam with the provided screws

## STEP 10

**A**

**Extend** the actuator: fasten the two bottom screws of housing.



**B**

**Test** full range of motor

& ready  
to go.





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