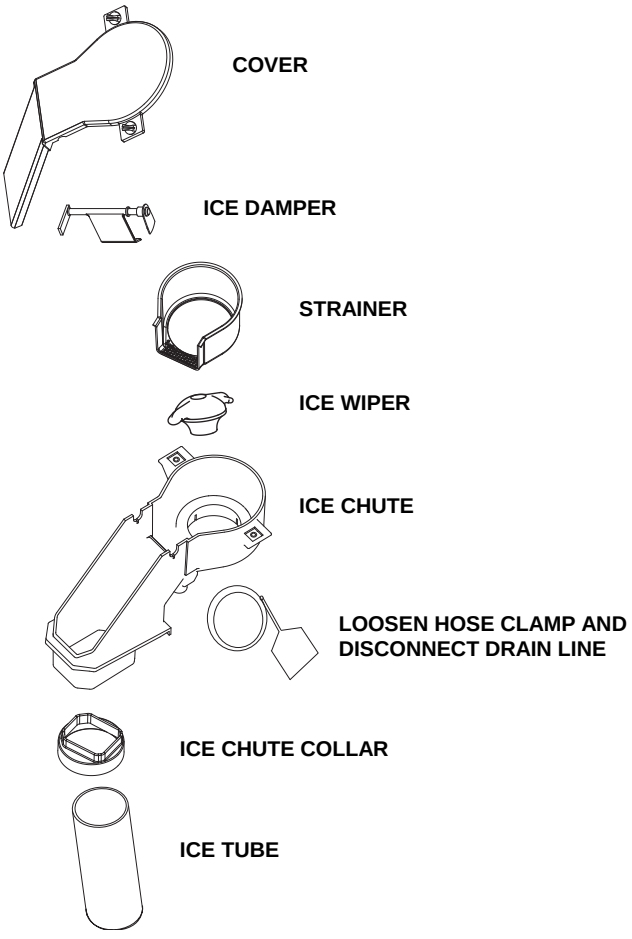
Flake/Nugget Ice Machine Splined Hub Replacement

Installation Instructions

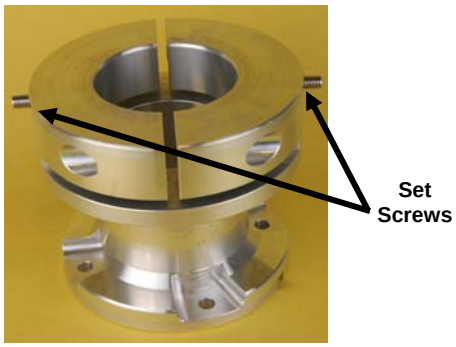
1. Disconnect water supply.
2. Remove front panel.
3. Move toggle switch to CLEAN position after the 5 minute delay expires the evaporator and float chamber will drain.

> **⚠ WARNING**
> Disconnect power to the ice machine at the electrical disconnect, moving the toggle switch to the off position will not disconnect line voltage.

4. Disconnect power at electrical disconnect.
5. Remove top and right side panels.
6. Remove ice chute assembly.
   NOTE; Gearbox has a clutch that insures correct rotation – If the ice wiper can not be hand removed; place the handle end of a screwdriver against the ice wiper, then tap the screwdriver (counterclockwise) with a hammer to loosen the ice wiper from the auger.



7. Loosen foundation set screws if your machine is equipped with them.



8. Remove bolts for evaporator foundation with 1/4” Allen wrench.



9. Secure evaporator to broom handle or other suitable object with wire, raise enough to clear spline hub.





10. Loosen Allen set screw - use a puller to remove the spline hub from gearbox and evaporator.



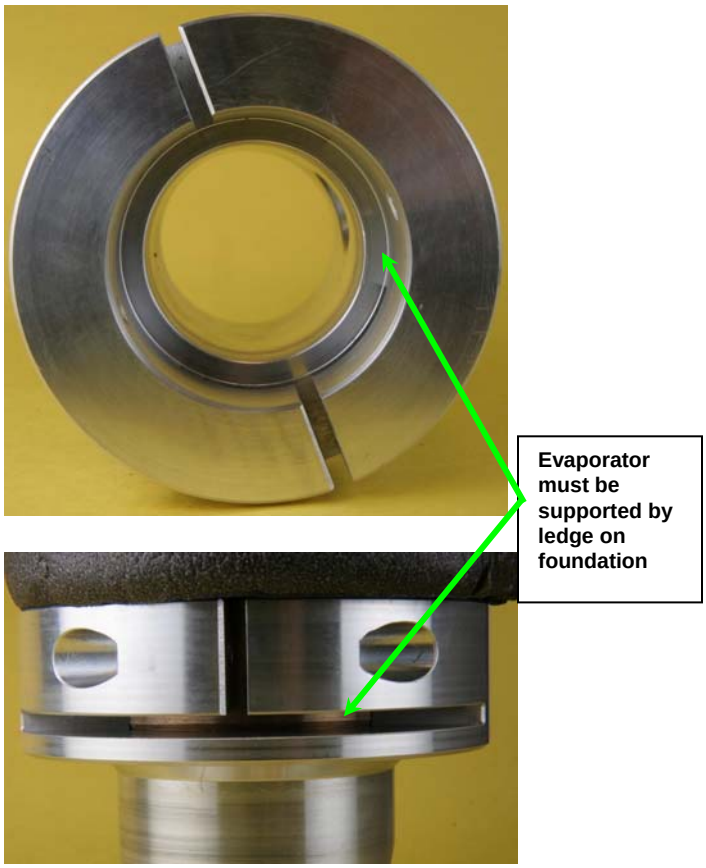
11. Refer to chart for your model ice machine to determine the correct distance between the bottom of the splined hub and the top of the gear box. Use an Allen wrench or drill bit to properly space the splined hub on the gear box.

Model	**Gearbox Splined Hub Distance Allen wrench or drill bit size**
QF400	7/64”
SF400	3/16”
SN450	3/16”
SF600	3/16”
SN650	3/16”
SF900	1/4"
SN950	1/4"
SF1200	1/4"
SN1250	1/4"
SF2000	1/16”
SN2050	1/16”

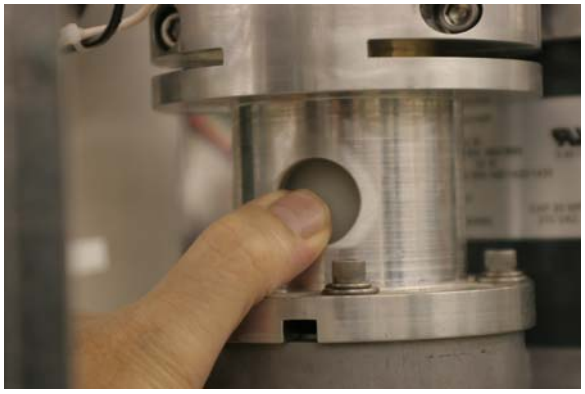
12. Reinstalling the splined hub on the gearbox shaft:
    A. Install new key stock
    B. Slide new splined hub on shaft – do not force, remove burrs if required
    C. Place the Allen wrench or drill bit between the gear motor and spline hub
    D. Press down on spline hub until it contacts the Allen wrench or drill bit
    E. Tighten set screw and remove Allen wrench or drill bit



13. Reinstall spline hub on the evaporator shaft:
    A. Install new key stock
    B. Slide new splined hub on shaft – do not force, remove burrs if required
    C. Align the evaporator spline hub flush with the end of the shaft
    D. Tighten set screw
14. Install coupler on gearbox splined hub.



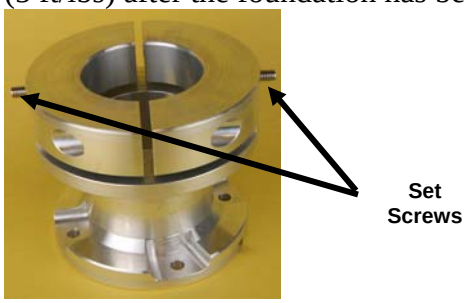
15. Temporarily install ice wiper, lower the evaporator onto the gearbox and turn auger until the spline hub engages the coupler. Do not allow the coupler to support the weight of the evaporator. Verify the evaporator rests on and is supported by the foundation..
16. Install base screws and secure the foundation to the gearbox – tighten bolts in an alternating pattern (front, back, left, right) torque foundation bolts until split washer flattens out.
17. Tighten the two foundation bolts: Torque the foundation bolts evenly alternating left, right, left, right to apply even pressure. Torque the bolts to 200 in/lbs (±5 in lbs) Note: 200 in/lbs = 17 ft/lbs
18. Verify the coupler moves up and down freely and is not bound and incapable of moving.



19. If you can not slide the coupler up and down:
    A. Loosen foundation mounting bolts (3/16” Allen wrench).
    B. Move evaporator forward, backward and side to side until the coupling moves freely.
    C. Torque the foundation bolts evenly alternating left, right, left, right to apply even pressure. Torque the bolts to 200 in/lbs (±5 in lbs) Note: 200 in/lbs = 17 ft/lbs.



NOTE: Your foundation may have set screws attached that need to be tightened to 60 in/lbs (5 ft/lbs) after the foundation has been torqued.



20. Torque the two set screws to 60 in/lbs (5 ft/lbs)
21. Reinstall ice wiper and components removed in step 6.
22. Restore power and water, then test run the ice machine for 10 minutes.