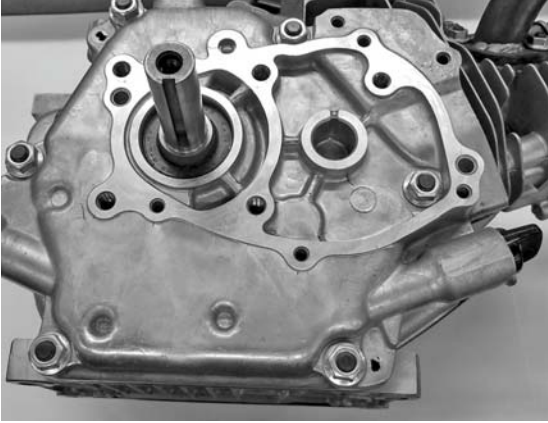
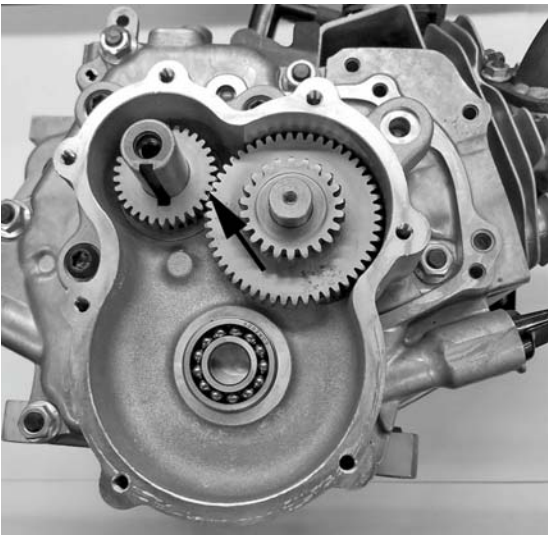


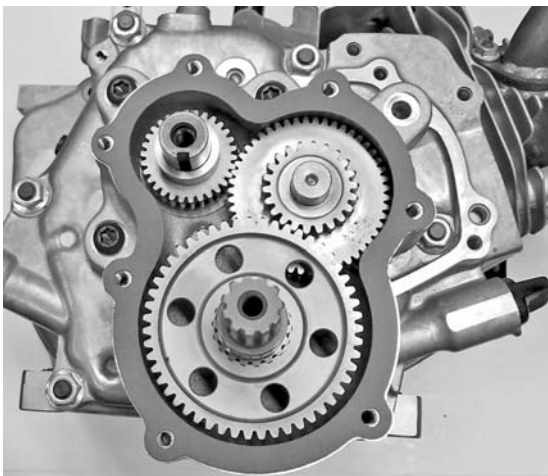
QBX-1000 Gear Box Assembly and Installation Instructions V 1.0 08/17



Step 1. Prep mounting surface and make sure the .75 dia crankshaft PTO is free of burrs and nicks and the gear and key are a sliding fit to accommodate assembly and disassembly. This is necessary on ALL shaft to bearing fits when assembling the gearbox! All machined mating surfaces require assembly lube or light grease during assembly.



Step 2. Install housing (#1) and tighten the (4) 5/16-24 Torx (T40) Button Head screws (#16) 170 in/lbs. (**Note, these may need to be swapped for M8-1.25 bolts if the engine is a Honda "Clone" or a Predator**) Slide the .750x1.125 (#6w) (.062" wide for Briggs and .125" on all other brands). shaft spacer washer and the crank input gear (#6) followed by the Spacer (#7) on to the .750 dia. of the crankshaft. Drop in the idler gear (#5) to mesh with the input gear and make sure their installed height where the gears mesh is similar. (see arrows)

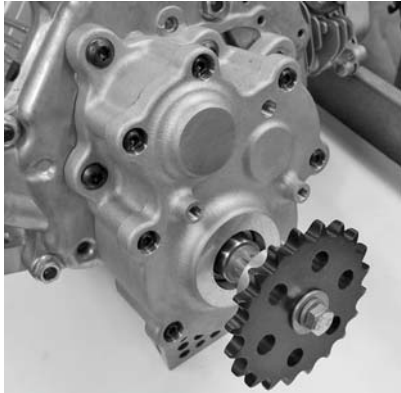


Step 3. Install the output gear (#4) to the output shaft (#3) and install the shaft/gear assembly into the housing making sure that the idler gear and the output gear mesh and line up properly. (Prior to installing the cover, take this opportunity to add 2.5 oz or 75cc of our Burris Gear oil in the gear case and on the bearings.) Prep the gasket (#12) with a light coating of WD 40 or light oil so it doesn't stick during disassembly and lay it on the gear housing/cover mating surface.



Step 4. Install the gearcase cover (#2) by sliding it over the output shaft being careful not to damage the shaft seal. In the process of sliding it over the crankshaft and idler shafts gently apply force from different sides to help keep them aligned. Be sure the cover is seating on the gasket and install the (#17) 7ea 14-20 Torx button head screws (T27 bit) and alternately

Step 5. Slide on the 3/4" split collar and then slide on the splined sprocket either hub first, or vice versa, and then screw in the retaining bolt and washer. Slide the split collar up against the sprocket for the desired endplay. You can also use two of the split collars to locate the sprocket. You should be ready to go!



Output Shaft
Rear Sprocket

	15	16	17	18	19	20	21	22
23	5.92	5.55	5.22	4.93	4.67	4.44	4.23	4.04
24	6.18	5.79	5.45	5.15	4.88	4.63	4.41	4.21
25	6.43	6.03	5.68	5.36	5.08	4.83	4.60	4.39
26	6.69	6.27	5.90	5.58	5.28	5.02	4.78	4.56
27	6.95	6.51	6.13	5.79	5.49	5.21	4.96	4.74
28	7.21	6.76	6.36	6.00	5.69	5.40	5.15	4.91
29	7.46	7.00	6.58	6.22	5.89	5.60	5.33	5.09
30	7.72	7.24	6.81	6.43	6.09	5.79	5.51	5.26
31	7.98	7.48	7.04	6.65	6.30	5.98	5.70	5.44
32	8.23	7.72	7.27	6.86	6.50	6.18	5.88	5.61
33	8.49	7.96	7.49	7.08	6.70	6.37	6.07	5.79
34	8.75	8.20	7.72	7.29	6.91	6.56	6.25	5.97
35	9.01	8.44	7.95	7.51	7.11	6.76	6.43	6.14
36	9.26	8.69	8.17	7.72	7.31	6.95	6.62	6.32
37	9.52	8.93	8.40	7.93	7.52	7.14	6.80	6.49