

1. Disconnect power to stop arm/crossing arm. Remove cover by unscrewing the two #10 sheet metal screws.
2. Using hog ring pliers, loosen the top spring (#5030) and place it on top of the metal clutch driver (#5002). Do the same with the bottom spring so that both springs are resting on top of the clutch, yet still around the shaft.
3. Loosen the two ¼ -20 nuts holding the motor bracket to the base, but do not remove. Slide the motor and plastic clutch downward to free it from the metal portion of the clutch.
4. Remove the old plastic clutch from the motor shaft. If it is tight, use a screwdriver or similar tool to pry it off.
5. Place the new plastic clutch on the motor shaft, and position the motor back in the unit. Tighten the two ¼ -20 nuts holding the motor bracket to the base.
6. Using hog ring pliers, reinstall each of the two springs back in place. Both springs must be down as far as possible on the toothed portion of the plastic clutch to prevent them from popping off.
7. Replace the cover and reinstall the two #10 sheet metal screws. Cycle the unit several times to insure proper operation.