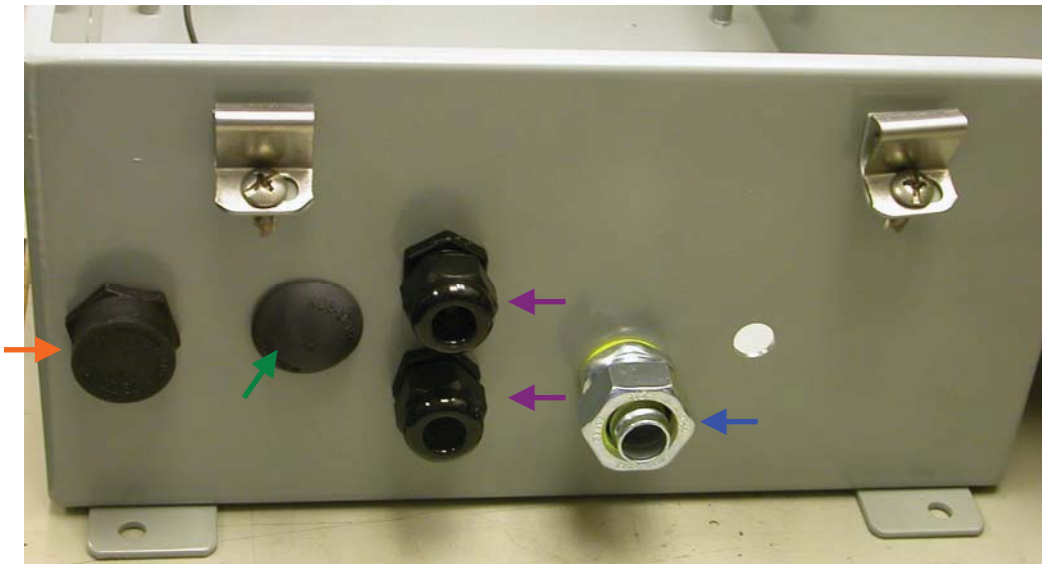




Figure 6 - Control Box Side View

The circuit board is held by two screws on the exterior of the box, plus other screws shown in the following photographs.

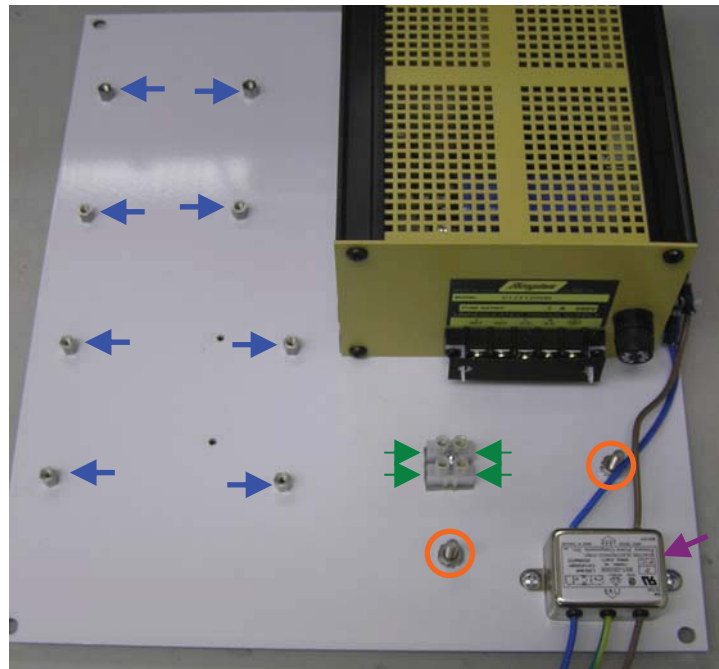
2.1 Control Box Bottom



- 1) Install one pc of **31-100303-00 Drain** with **37-100004-00 Loctite 425**.
- 2) Install one pc of **31-100286-00 Santoprene Plug**.

- 3) Apply **37-100009-00 RTV** to sealing surface on two pcs of **31-100284-00 Nylon Cordgrips**. Install and tighten with **Loctite 425** and **31-100285-00 Nylon Locknut** – *install bottom one first and tighten then install top one.*
- 4) Apply **RTV** to yellow sealing surface and install one pc of **31-100305-00 Steel Cordgrip** with **Loctite 425**.

2.2 Plate - Component Installation



TORQUE=24 in/lbs (Ingersall Rand set to 12)

- 1) Install two of **32-100027-19 #10 screws** from back of panel with **33-100120-00 LockNut** on topside.

TORQUE=6 in/lbs ((Ingersall Rand set to 2)

Prep: Remove ribs from bottom of **29-100600-00 Terminal Block** and install 0.75" x 0.75" piece of **37-100035-00 PSA** to bottom with 3/16" punched hole for screw.

- 2) Use #1 Driver to install and tighten **29-100600-00 Terminal Block** with **37-100019-00 Loctite 222** and one pc of **32-100170-00 #6 x 0.625" Thread-Rolling Screw**. Wire entry indicated with **arrows** above.

TORQUE=12 in/lbs (Ingersall Rand set to 6)

- 3) EMI Filter screws are self-threading. Use #2 Driver to install and tighten **43-100213-00 EMI Filter / 22-100055-00 Switch** with **Loctite 222** and two pcs of **32-100164-00 #8 x 1/4" Thread-Rolling Screw**.
- 4) Install and tighten eight pcs of **34-100064-00 4-40 Standoff** with **37-100004-00 Loctite 425** plus **33-100130-00 4-40 Nut w/tooth Washer** on backside.

TORQUE=16 in/lbs ((Ingersall Rand set to 8)

Note: Center **24-100093-00 Power Supply** over matching hole pattern in plate. *Loosen power supply to align holes if necessary.*

- 5) Use #2 Philips Driver to install and tighten with four pcs of **32-100167-00 8-32 x 0.3125" Screw** and **33-100124-00 #8 Lock Washer**.

2.3 Plate into Control Box

- 1) Place panel assembly in box.
- 2) Start four screws and #10 lock washers (that come with panel), attach Plate to Control Box. **Do not tighten.**
- 3) Install **31-100290-00 Switch Seal** on **Switch** and set switch into cutout in **Control Box**. Install and tighten Lock Washer (comes with Switch) and **31-100289-00 Boot**.



Installed Power Switch

Control Box - PCB

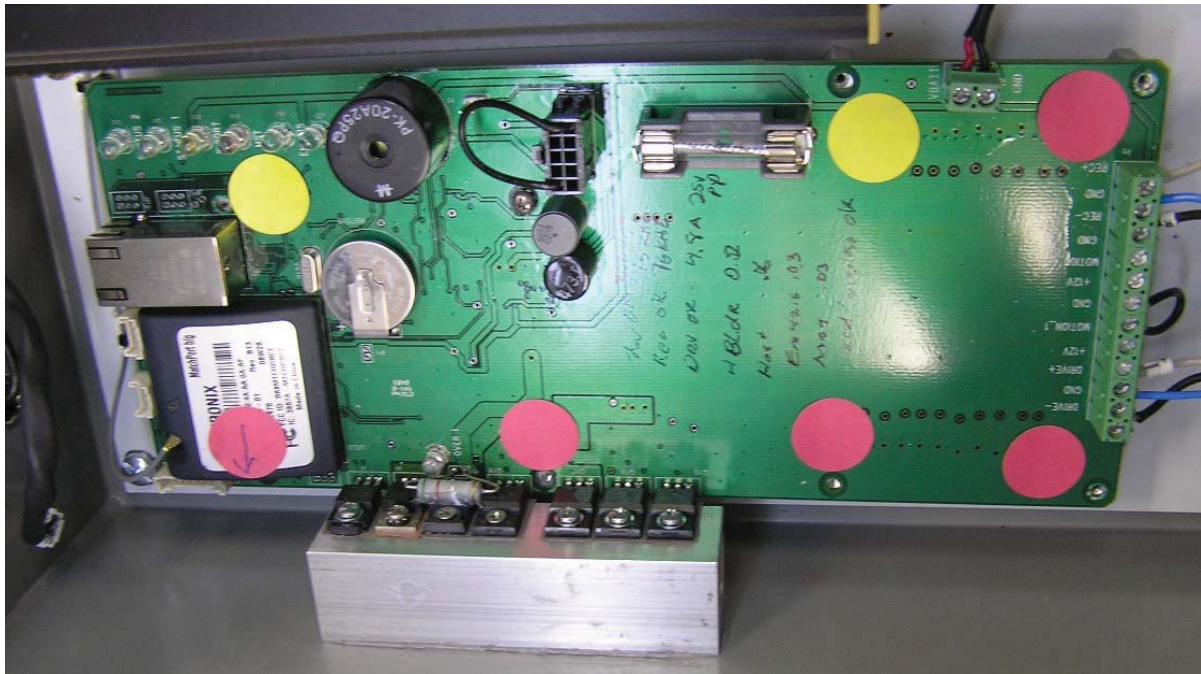


Figure 7 - Control Box - PCB Top View

Internal mounting screw holes indicated by colored stickers.

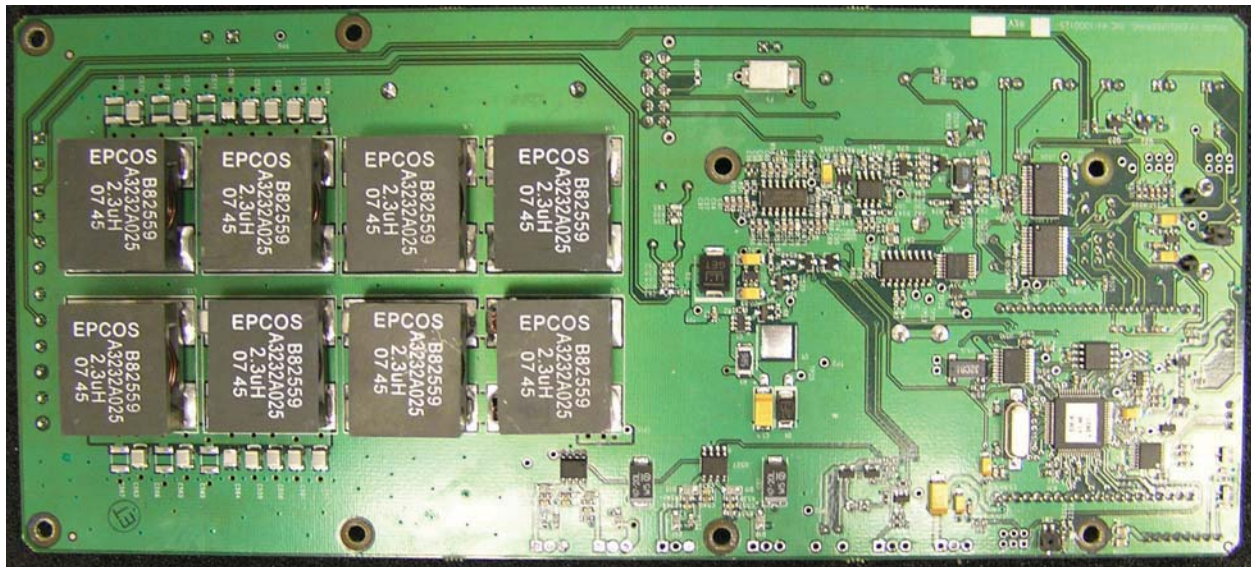


Figure 8 -Control Box PCB Bottom View

This side is mounted face-down in the electronic enclosure box.