

APPENDIX - TORQUE FOR LID SCREWS

For RC3000 Embedded Controller

This appendix describes the appropriate procedures and torque recommendations for installing the RC3000 Embedded controller lid in order to ensure that it is securely fastened and water-tight against moisture.

Please observe the following steps with installing the controller lids:

1. Place the lid on the controller, making sure that it is square with the chassis.
2. Start threading all four screws and hand-tighten ONLY until the washers touch the lid. DO NOT OVERTIGHTEN.
3. Set the torque screwdriver to 2 in-lbs. and tighten the screws in a cross pattern.
4. Adjust the torque screwdriver to 4 in-lbs. and tighten the screws two turns at a time, repeating the cross pattern, until the torque is reached.
5. Set the torque screwdriver to 6 in-lbs. and tighten the screws two turns at a time, again repeating the cross pattern, until the torque is reached.

The above procedure has consistently resulted in securely fastened lids that are water tight against moisture.