

## Procedure for Securing the Connector Board to the ACS Drive Assembly

**STATIC CAUTION!** Avoid making contact with the circuits or components of the ACS Drive.

1. Make sure that the ACS Drive has been without power for 1 minute and completely unwired.
2. Remove the four #4 locking nuts from your ACS Drive. Do not discard nuts, save hardware for step 6.
3. Screw down the four M/F hex standoffs (supplied with Connector board) onto the threads of the ACS Drive where the nuts were removed.
4. Make sure that the standoffs are screwed down firmly against the circuit board. Apply no more than 4in/lbs of torque or just until standoffs make contact with the circuit board then another 1/6<sup>th</sup> turn (about the rotation of one side of the standoff).
5. Install Connector board onto the assembly making sure that the sockets of the Connector Board align with the connectors of the ACS Drive, see diagram below.
6. Fully press down onto the Connector Board making sure Connector board is fully seated.
7. Install the four #4 locking nuts that originally came with the ASC Drive.
8. Apply no more than 4in/lbs of torque or just until nuts make contact with the circuit board then another 1/6<sup>th</sup> turn (about the rotation of one side of the nut).

