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.