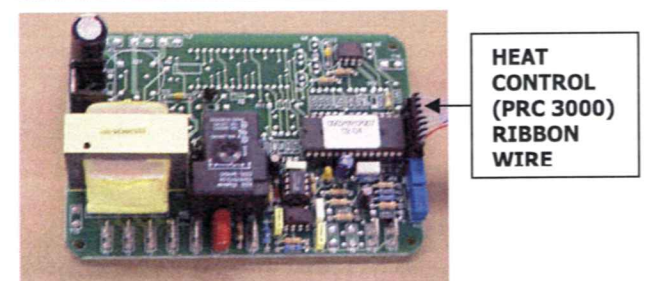
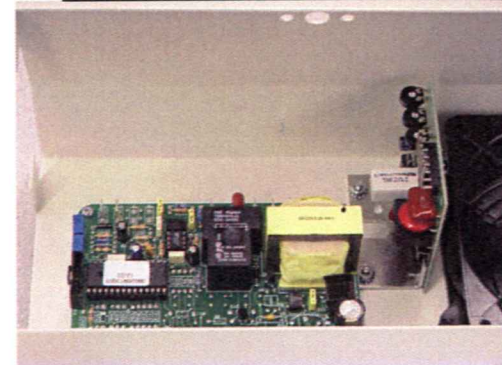
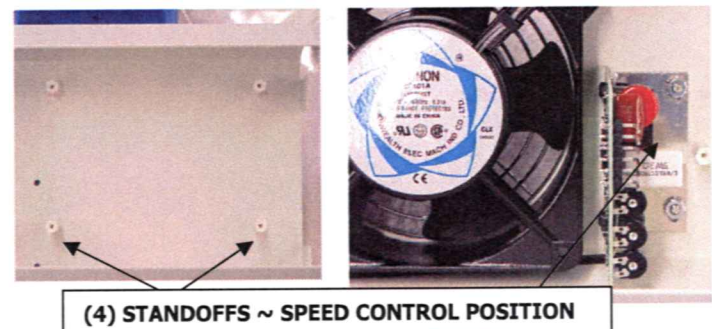
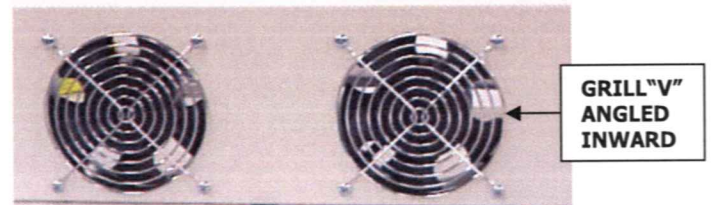
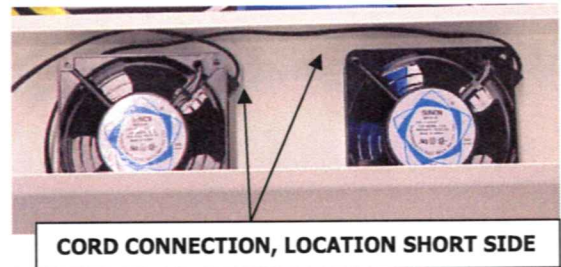


PLC 27

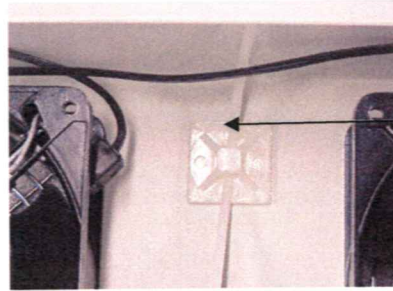
BOTTOM MOTOR COVER ASSEMBLY

- 1) FROM **LD04** ATTACH (2) FAN CORD SETS (PRF116) ONTO (2) AXIAL FANS FOR EDUCTOR 120V (PRF133).
- 2) PLACE BOTTOM MOTOR COVER (PL27 093.4) **AS04** ON WORKTABLE, SHORTER SIDE UPWARD AND TO REAR. ALIGN (2) FAN GUARD SMALL (PRF120) **AS07** ON OUTER MOTOR COVER, WITH METAL RING CONNECTING "V" ON FAN GUARD POINTING INWARD FROM SIDES. ATTACH FAN GUARDS TO FANS ON INSIDE USING (4) 10 X 1/2 PH SMS. FAN CORDS SHOULD BE FACING REAR, SHORTER SIDE OF COVER, TOWARD BOARD POSITIONS. *AIR FLOW ARROW FACES UPWARD.*
- 3) SECURE (4) STANDOFF, NYLON 5/8 X 1/4 HEX (LC25 010.4) **LD01** TO INSIDE BOTTOM MOTOR COVER USING (4) 4-40 X 3/8 PH.
- 4) THREAD (2) 6-32 X 3/8 THMS INTO HOLES BETWEEN STANDOFFS AND FAN, FROM OUTSIDE.
- 5) REMOVE MOLEX WIRES FROM MINARIK SPEED CONTROL (PRM219) **AS08** AND TAKE WIRES TO WIRING LOCATION. PLACE SPEED CONTROL BRACKET HOLES ON TRUSSHEAD SCREW THREADS WITH BOARD BY FAN, POSTS FACING UPWARD. SECURE WITH (2) 6-32 KEPS HEX NUTS ON INSIDE. TIGHTEN HEX NUTS WITH NUT DRIVER.
- 6) ATTACH SPECIFIC HEAT CONTROLLER (PRC 3000) **AS04** TO HEX STANDOFFS, RIBBON WIRE CONNECTION SHOULD FACE OUTWARD TOWARD SIDE PANEL. USE (4) 4-40 X 3/8 PH TO SECURE. BE CERTAIN YOU ARE USING THE CORRECT HEAT CONTROLLER, AS ONLY THE PRC 3000 ACCEPTS THE THERMAL COUPLING FROM THE SENSOR USED IN



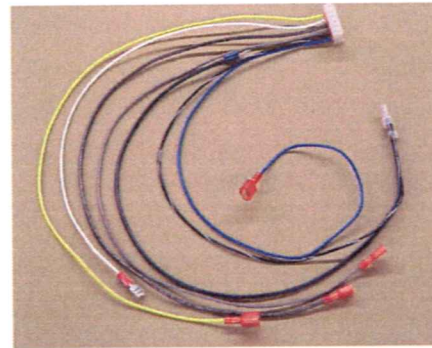
THE PLC 27. SNAP RIBBON WIRE INTO HEAT BOARD, SET SLAVE DISPLAY ASIDE, TO BE USED LATER.

- 7) FROM **AS07** CENTER AND ADHERE BRADY PRESS CLIP (PRC081) WITH INSERTED OPEN CABLE TIE 5 ¼ (PRC 082A) BETWEEN AXIAL FANS, ON SAME HORIZONTAL PLAIN.

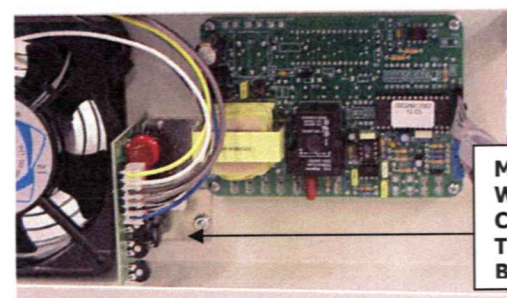


PRESS CLIP BETWEEN FANS ON CORD SIDE

- 8) FROM WIRING HARNESS (PRW355) **RACK 7** YOU WILL FIND THE FOLLOWING TERMINAL CONNECTIONS ON THE MOLEX WIRE ASSEMBLY: BLUE AND YELLOW WIRES ARE TERMINATED WITH FI MALES (PRT330), BROWN AND GRAY WIRES ARE TERMINATED WITH FI FEMALES (PRT331). APPROXIMATELY 3 ½ INCHES TRIMMED OFF THE WHITE WIRE AND TERMINATED WITH A FEMALE (PRT302). THE UNITED BLACK AND WHITE STRIPED WIRE WITH A BLACK 18 GAUGE USING A CLEAR CAP (PRT289). THE BLACK WIRE HAS A RED SPADE CONNECTION ON THE REMAINING END. A SMALL CABLE TIE ABOUT 1 INCH FROM CLEAR CAPPED CONNECTION.

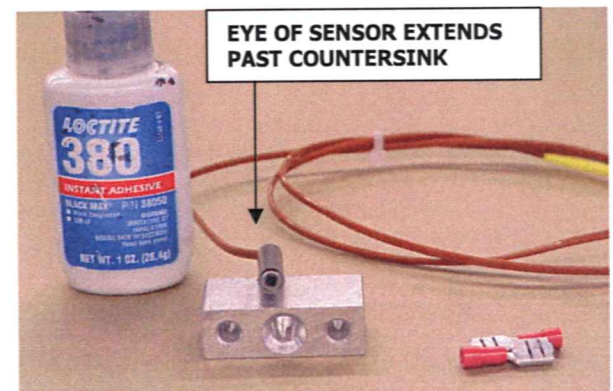


- 9) CONNECT MOLEX WIRES WITH TERMINALS ON SPEED BOARD. WIRES SHOULD BE FACING HEAT BOARD WITH BLUE WIRE CLOSER TO SENSOR OPENING. DO NOT TIE THESE YET.

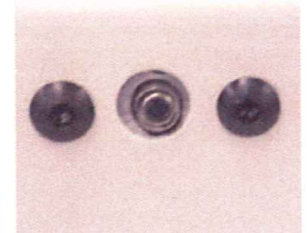
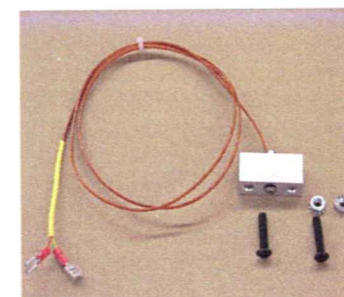


MOLEX WIRES CONNECTED TO SPEED BOARD

- 10) TO PREPARE SENSOR ASSEMBLY PLACE A DROP OF BLACK LOCTITE 380 INSTANT ADHESIVE CENTERED ON THE MIDDLE TOP AND BOTTOM OF THE INFRA-RED SENSOR (PRC300S) **AS07**. SLIDE THE SENSOR THROUGH THE MIDDLE HOLE ON THE SENSOR BRACKET (PL27 055.4) **RACK 7** SO THE SENSOR "EYE" IS SLIGHTLY EXTENDED PAST THE COUNTERSUNK SIDE OF THE BRACKET. THE COUNTERSINKING ALLOWS MORE LIGHT TO REACH THE "EYE." ONCE LOCTITE IS DRY, CONNECT (2) FEMALE FASTONS (PRT302) TO THE RED AND YELLOW WIRES ATTACHED TO THE INFRA-RED SENSOR.

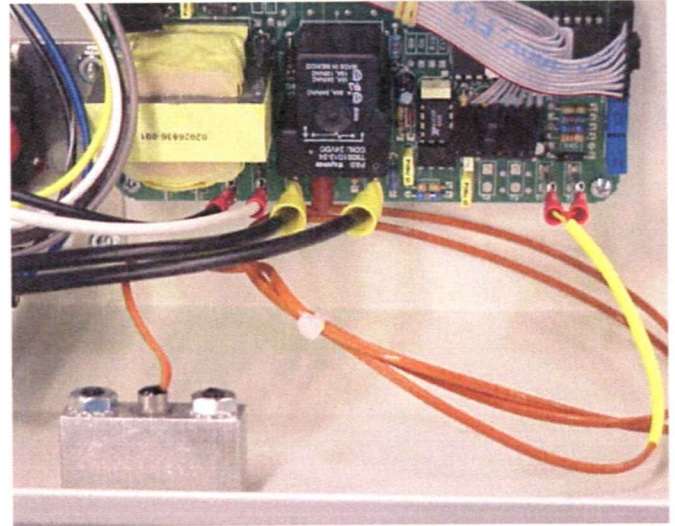


- 11) PLACE SENSOR AND SENSOR BRACKET INTO SIDE HOLES ON BOTTOM MOTOR

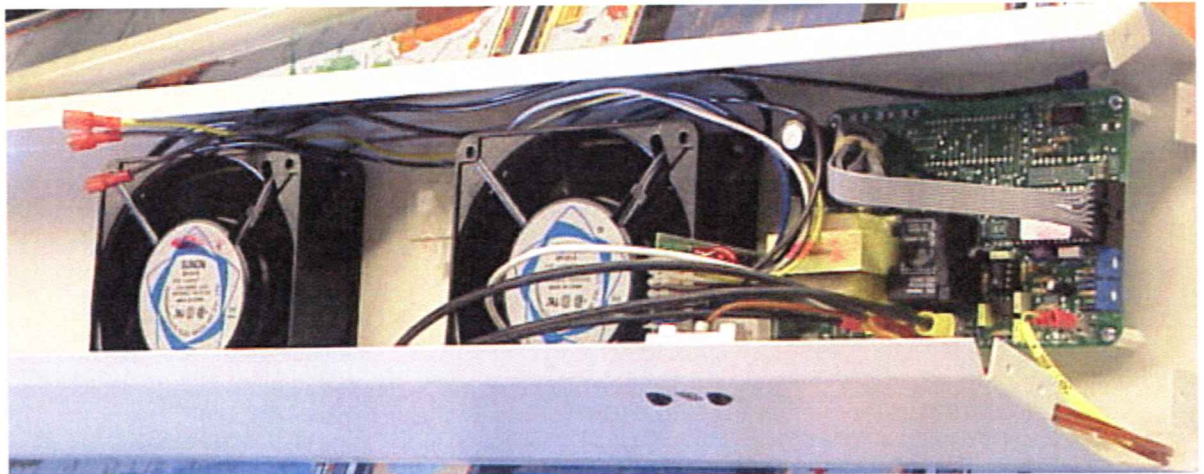


COVER AND SECURE WITH (2) 10-32 X 1 BHCS AND (2) 10-32 KEPS HEX NUTS ON INSIDE. TIGHTEN WITH NUT DRIVER.

- 12) FROM HARNESS BAG WIRE HEAT BOARD AS FOLLOWS: **T3** = 18 GAUGE, 14" BLACK, **T4** = 18 GAUGE, 10" WHITE **T6 & T7** = 12 GAUGE, 12" BLACK ON EACH. **T10** = YELLOW SENSOR WIRE, AND **T11** = RED SENSOR WIRE.
- 13) STORE COMPLETED BOTTOM HOUSING ASSEMBLY UNTIL YOU ARE READY TO USE.



INFRA-RED SENSOR AND HEAT BOARD WIRED



COMPLETED BOTTOM MOTOR COVER ASSEMBLY