

# System 852-017

## Special Assembly Instructions

1. Remove the rotary assembly (rotor) from the base. (Fig. 1)
2. Keep nylon washers with screws and do not misplace. If they are, they MUST be replaced to help keep liquids from RTD connection area.
3. There is a # 36 Buna-N O-ring at the point where the rotor mates with the base, it is important not to lose this. If it becomes misplaced it MUST be replaced to help keep liquids from RTD connection area.
4. The rotor base is shipped with a # 17 Buna O-ring installed at the bottom of the base where the motor shaft should stop. This O-ring is held in place by pre-installed dielectric grease to keep it in place. Should the O-ring become dislodged or misplaced it MUST be reinstalled with more dielectric grease.
5. Feed RTD wires through the hole in the rotor base. (Fig. 2)
6. Press the rotor base onto the shaft and hold tight to shaft while alternating the tightening of the three set screws. Set screws are shipped with removable, reusable thread locker. Re-apply thread locker as needed. Reapply Vibra-Tite: VC-3 THREADMATE.
7. Attach RTD ring lugs to terminals on rotor and tighten securely.
8. Re-attach rotor to base with the provided M4 screws with nylon washers. These screws are shipped with removable, reusable thread locker already applied. (Thread lock used on these screws is also important for resisting liquids travelling the screw threads and getting into RTD connection area.) Reapply Vibra-Tite: VC-3 THREADMATE.

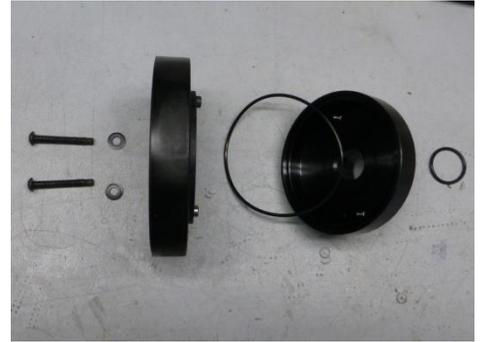


Fig. 1 - Rotary Assembly (Rotor)

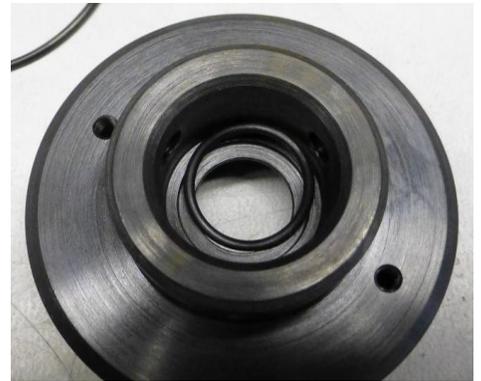
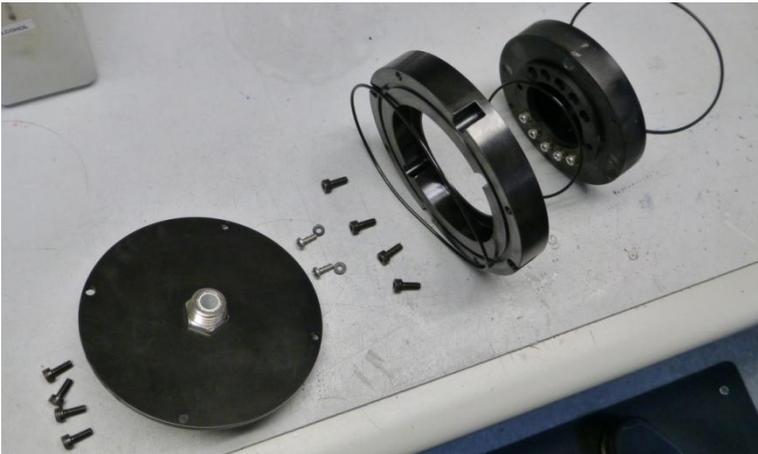


Fig. 2 - Rotor Base



RT351 (852-017) Modifications  
without Customer Supplied Housing

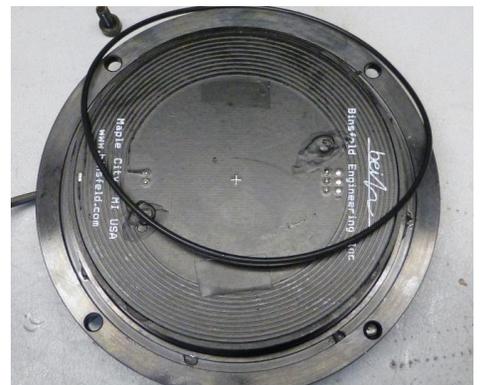


Fig. 3 - Stator Plate with Electronics

9. Install customer's stationary assembly (stator) housing if not already installed. (Fig. 3)

10. Stator is shipped attached to adaptor plate and this plate should not be removed unless there is a problem and it needs to be replaced. If it should have to be removed, there are rubber washers under the fixing screws that **MUST** be saved and re-used. There is also a # 36 Buna-N O-ring attached where the stator mates to the adaptor plate and it **MUST** be re-installed to maintain resistance to liquids entering electrical connection area.
11. Adaptor plate is shipped with a # 44 Buna O-ring attached to the face which mates with the stator housing. This is held in place for installation with dielectric grease. If the O-ring becomes dislodged or misplaced it **MUST** be replaced with more dielectric grease.
12. Attach adaptor plate to customer's stator housing with the provided M4 screws. Alternate tightening screws so the O-ring is evenly compressed. These screws are shipped with reusable thread lock and thread lock should be re-applied as needed. Reapply Vibra-Tite: VC-3 THREADMATE.
13. Remove top nut from wire gland and feed supply wires through the nut, the inner rubber grommet and then through the top of the gland itself.
14. The adaptor plate is shipped with a # 44 Buna-N O-ring attached to the face where the adaptor plate and top cover mate. This is held in place for installation with dielectric grease. If the O-ring becomes dislodged or misplaced it **MUST** be replaced with more dielectric grease.
15. Securely attach wires to stator terminals with the wires routed toward the center of the stator assembly. (Fig. 5)
16. While gently pulling on the wire harness making sure wires are not caught on anything, set top plate onto adaptor plate. Secure with provided M4 screws alternating the tightening to ensure the O-ring is evenly compressed. These screws are shipped with reusable thread lock and thread lock should be re-applied as needed. Reapply Vibra-Tite: VC-3 THREADMATE.
17. When cover plate is securely in place tighten wire gland. Use a wrench on both nuts to prevent twisting of the gland base. Tighten completely so a liquid resistant termination is created.

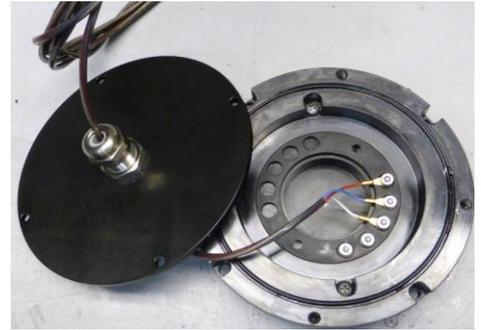


Fig. 5 – Stator Terminals



Fig. 6 – Stator Top Plate with Gland