

PAINTING AND ASSEMBLY INSTRUCTIONS

Enclosure P/N 410 112 458 and P/N 410 112 341

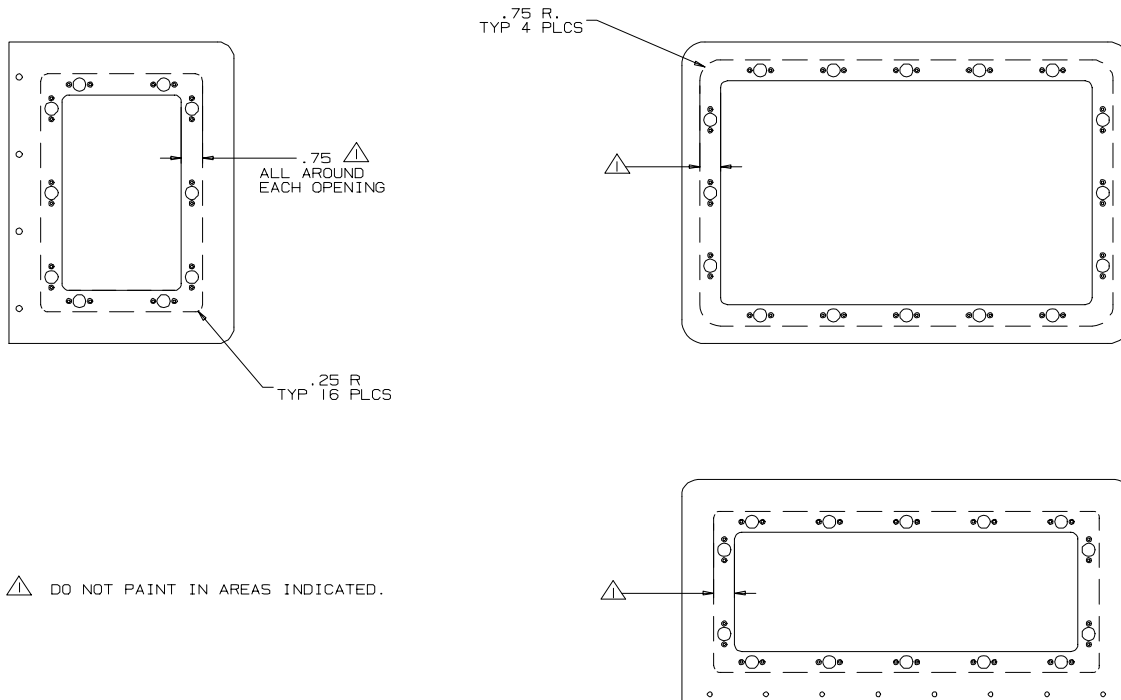
PARTS REQUIRED:

Part Number	Description	Quantity
000225	GLUE, CHOBOND 1030 (4 OZ.)	1
254597	HANDLE	2
254237	GROMMET, DZUS	64
254598	STUD, DZUS	64
435902101	ACCESS PLATE, FRONT	1
410112349	ACCESS PLATE, SIDE	2
435900108	ACCESS PLATE, TOP	1
410112350	ACCESS PLATE, BOTTOM	1
410112351	DEEP-DRAWN HOUSING ASSY	1
410112352	GASKET, FRONT	1
410112353	GASKET, SIDE	2
410112354	GASKET, TOP/BOTTOM	2
690401	WASHER, FLAT, 10/32, SST	4
899997	WASHER, LOCK, SPLIT, #10	4
908307	SCREW, PH PHL, 10-32X.3125, SST	8
908400	SCREW, PH PHL, 10-32X.500, SST	4
909814	SCREW, PH PHL, 6-32X.3125, SST	16

INSTRUCTIONS:

Painting:

1. Modify cover plates as needed.
2. Using tape or another masking material, cover the areas on the enclosure <MU>not<D> to be painted as indicated by the drawing below to ensure conductivity between surfaces.
3. Paint Housing and Cover plates (Exterior surfaces only).



Hardware and Gasketing:

4. Remove masking material.
5. To mount each handle to the cover plates, seat each end into a guide ferrule, then attach the handle to the outside face of the cover using two 10-32 x 3/8 mounting screws, two lock washers and two flat washers.
6. Working on a flat surface, apply a thin layer of Chobond to a single gasket. Smooth with a putty knife or razor blade so that there is a very thin, even layer (.003-.005, or paper thickness) on the gasket. Make sure the Chobond covers out to all edges. (Avoid allowing a build-up of excess Chobond to gather in the gasket holes.)
7. Immediately affix the gasket to the housing, first aligning the inside of the gasket with the inside edge of the enclosure opening. Check for proper alignment of the gasket and housing holes and adjust as necessary. Once all holes are aligned, immediately attach the cover plate and lock down for at least 20 minutes to allow the Chobond to properly set.
8. Repeat steps 6 & 7 for each cover.
9. Insert one 1/4-turn fastener at a time through the front of a cover plate. Lay cover plate face-down with 1/4-turn fastener sticking up. Slide retaining washer over the fastener such that the outer area of the washer is furthest away from the cover plate (like a soup-bowl with a hole in the middle of it). Slide a tube (.375 dia. with .220 inside dia.) over the retaining washer and strike firmly with a mallet with cover plate on a solid surface. Ensure that the fastener is retained by washer.