

# Assembly Instruction For AN-1323-A , -AB

To insure proper function of the gasket and seal the enclosure to submersion condition, the following instruction need to be followed.



1-Captive screws must be screwed in the **cover first** (screw should drop once past the threaded area)

2- Make sure that the **Gray Silicon gasket is properly installed** in the cover (not twisted, loose or kinked).

Lay cover on top of body with screws lined up with holes in the body



3- When dealing with a painted box, there may be some powder in the threads; this requires over torquing the screws (can get to 28 in\*lb). It is best to move in and out a couple of times with each screw to release friction.

At normal conditions with proper assembly process the screws need to be torqued at 12 in\*lb minimum, leaving a minimal gap (<0.5mm) between the cover and body.



4- The screws need to be **gradually** tightened in a **diagonal pattern**.

When the cover is at the proper compression the gap between the body and cover need to be 0.017" or smaller.