1. INSTALLATION

Required tools:

— support block with clearance for threaded post of guide pin

— arbor press (capable of supplying a downward force of 445 N [100 lbf])

— nut that matches threaded post of guide pin; and socket wrench

— printed circuit (pc) board support

— socket head cap screw 1410946-1 (for 2.5-mm thick pc board) or 1410946-2 (for 2.5- to 5-mm thick pc board); and 1.5-mm hex wrench

1.1. Guide Pin (See Figure 1)

1. Insert the threaded post of the guide pin (aligning the key) into the guide pin hole of the pc board until it stops.

2. Place the pc board over the support block so that the threaded post enters the hole in the block.

3. Place the guide module onto the guide pin.

4. Using the arbor press and guide module, seat the guide pin onto the pc board. Then, remove the guide module.

5. Using the socket wrench, install a nut to secure the guide pin to the pc board.
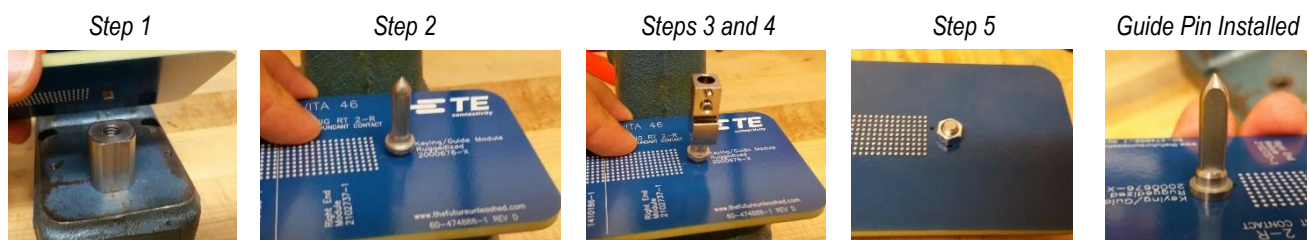
Step 1	Step 2	Steps 3 and 4	Step 5	Guide Pin Installed

Figure 1

1.2. Guide Module (See Figure 2)

1. Position the pc board support onto the lower tooling of the arbor press.

2. Place the pc board onto the pc board support so that the edges align.

3. Insert the splined post of the guide module into the guide module hole of the pc board until it stops.

4. Using the arbor press, seat the guide module onto the pc board.

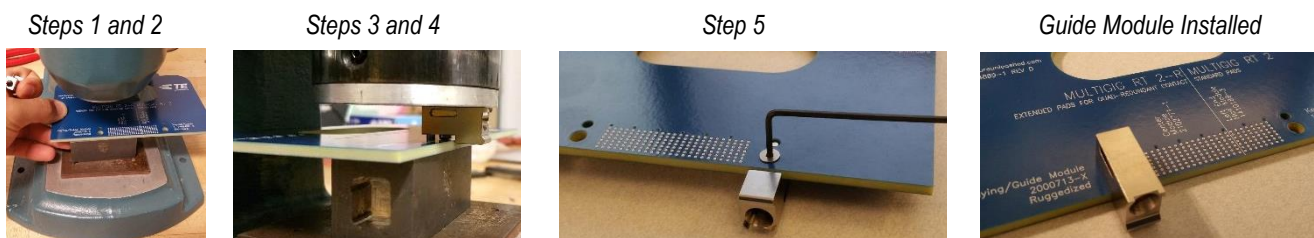5. Using the hex wrench, install the screw to secure the guide module to the pc board.

Steps 1 and 2	Steps 3 and 4	Step 5	Guide Module Installed

Figure 2

2. REVISION SUMMARY

Initial release of instruction sheet

PRODUCT INFORMATION 1-800-522-6752

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