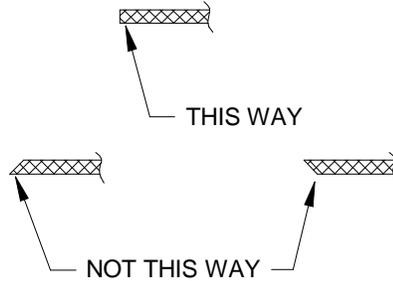
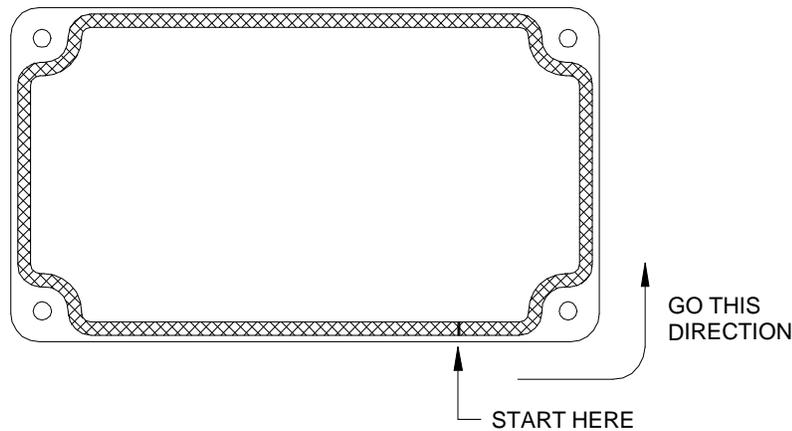


Procedure for Assembly of Sealing Gasket For AN & PN series boxes

1. Cut one end square and perpendicular to length:



2. Start laying the gasket in the cover groove approximately 1" from a corner on the longer side as shown below:



3. Lay down the gasket in the groove of the cover and go in the direction shown. Without stretching or twisting the gasket, press the gasket down into the groove.
4. Continue laying down the gasket without stretching it until you reach the starting end.
5. Mark the end of the gasket by overlapping the starting end by the amount shown below:

<u>Center distance between screws on both sides of the starting point</u>	<u>Overlap length</u>
Up to 4"	1/8"
Over 4"	3/16"

6. Cut the other end at the marked point square and perpendicular to the length as shown in step 1.
7. Butt the cut end against the starting end in the groove, press against the starting end and then press the gasket end down into the groove while keeping the pressure against the starting end. This procedure ensures that there is some compression pressure between the two ends of the gasket.

Procedure for Assembly of Cover For AN & PN series boxes

1. Cover screws on the PN series are captive screws, so assemble the screws on the cover first by threading them through the cover holes. Skip this step for AN series.
2. Place the cover over the body and align the screws or cover holes with corresponding holes in the body.
3. Loosely assemble cover screws in sequence shown in figures 1 and 2 below and do not tighten completely.

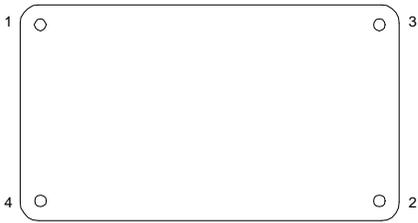


Fig. 1

Screw Tightening Sequence For 4-Holes

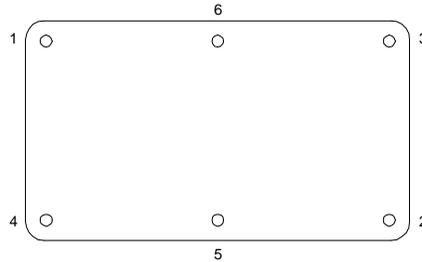


Fig. 2

Screw Tightening Sequence For 6-Holes

4. Once all screws have been loosely assembled, tighten all screws to a torque as shown in the table below using a torque screw driver. Follow the sequence shown above.

Type of Gasket	Torque in Inch-Pounds
EPDM (yellowish opaque)	6-7
Solid Silicone (translucent white)	8
Sponge Silicone (off-white opaque)	8

5. Inspect the sealed joint and ensure that the gasket track in cover is properly aligned with the lip in the body. For 4-hole covers, squeeze hard in the middle of the cover against the body. Sometimes on larger PN series boxes with 4 holes, you may hear a snap noise. This is normal and indicates that the sealing lip in body is now fully seated and aligned with the gasket.
6. Re-tighten the screws again to the proper torque as shown in paragraph 4.
7. On some sizes, there may be a gap between the cover and body. This is normal. Over-tightening of screws to close the gap is not recommended.