



## ACHV cable Reuse

ALFG-061-BB

ALFG-063-BB

ALFG-067-BB

ALFG-069-BB

For applications where the cable is removed from the motor interface and needs to be reinstalled.

# Materials needed

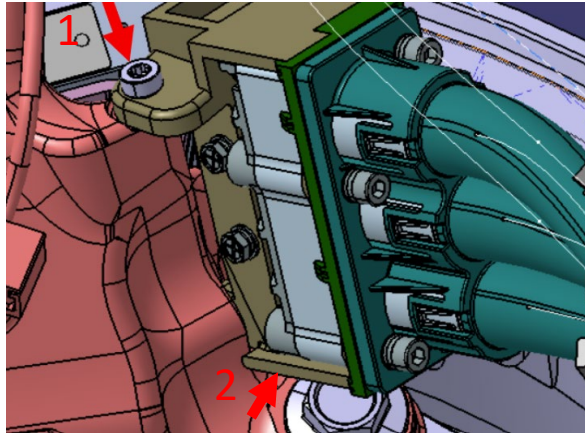
- Paint/Calk scraper tool
- Goo Gone Adhesive Remover Spray Gel
- Scotch Brite Scrub Sponge
- Isopropanol Alcohol
- Replacement o-rings
  - ABJA-062-AA x3
  - ABJA-063-AA x3



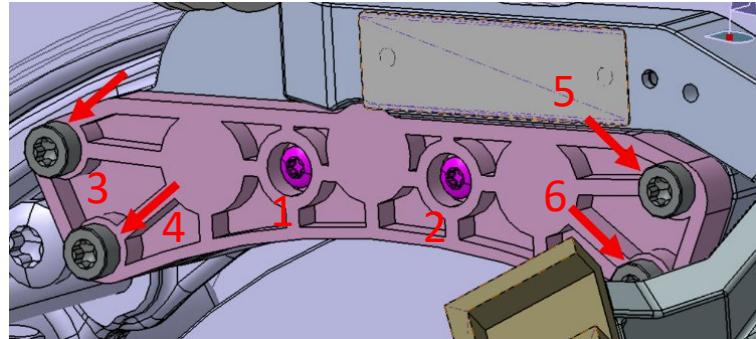
## Removal of Busbar

*On front cables only:*  
Remove two screws  
attaching to the  
knuckle.

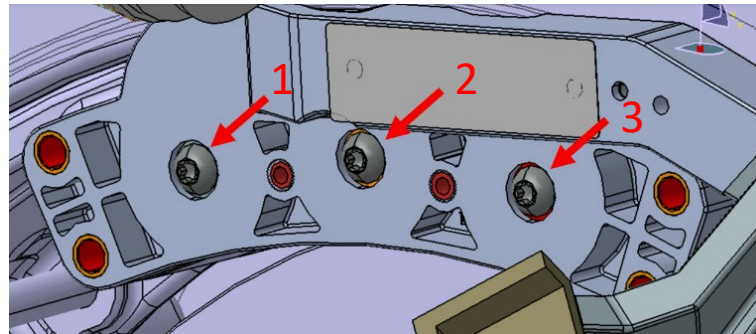
*Rear cables skip to next  
step.*



Remove 6 screws and  
cover plate



Remove 3 screws and  
remove busbar from  
motor

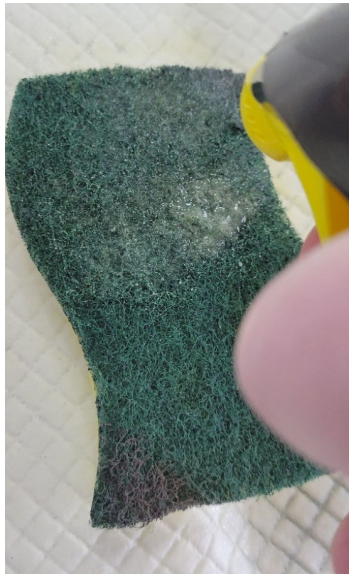


# Removal of Loctite from Busbar and Cover

Scrape off excess  
Loctite



Wet Pad with Goo  
Gone Adhesive  
Remover Spray Gel



Scrub



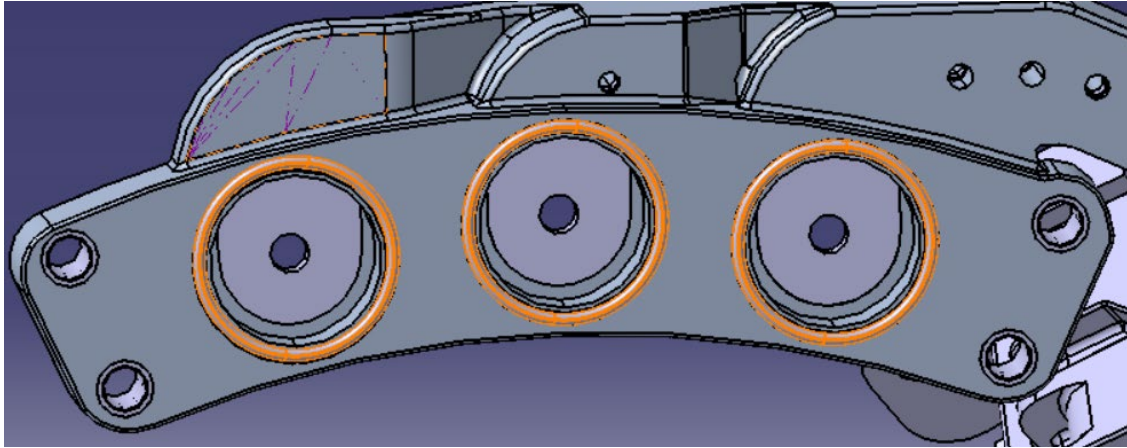
Clean off Goo Gone and residue with alcohol



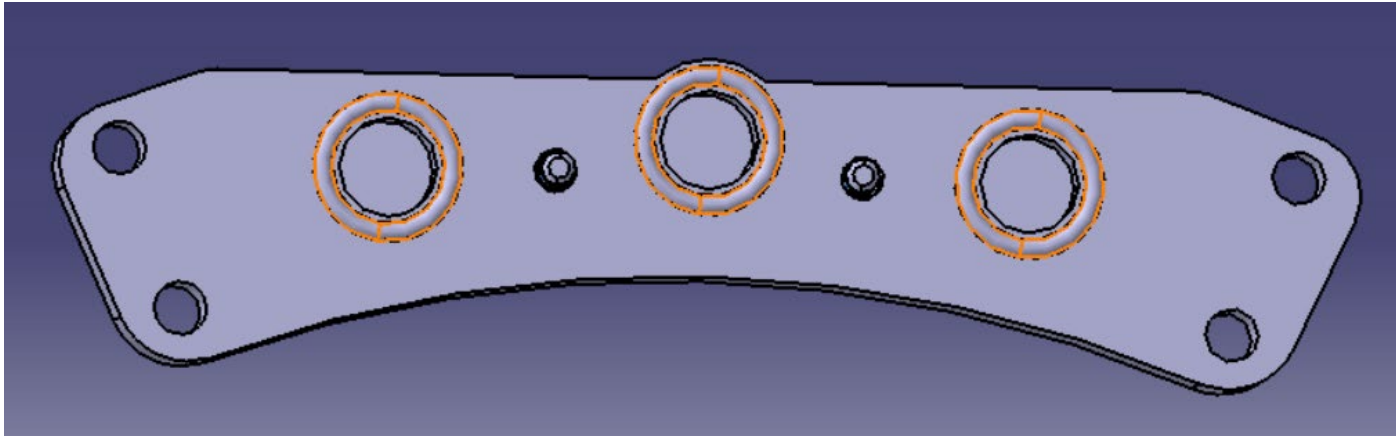
Make sure o-ring channels  
are clear and metal  
mushroomhead  
connections are clean of all  
contaminates.

# Replacing Cables- Replacing O-rings

Add new o-rings  
ABJA-062-AA to busbar



Add new o-rings  
ABJA-063-AA to cover

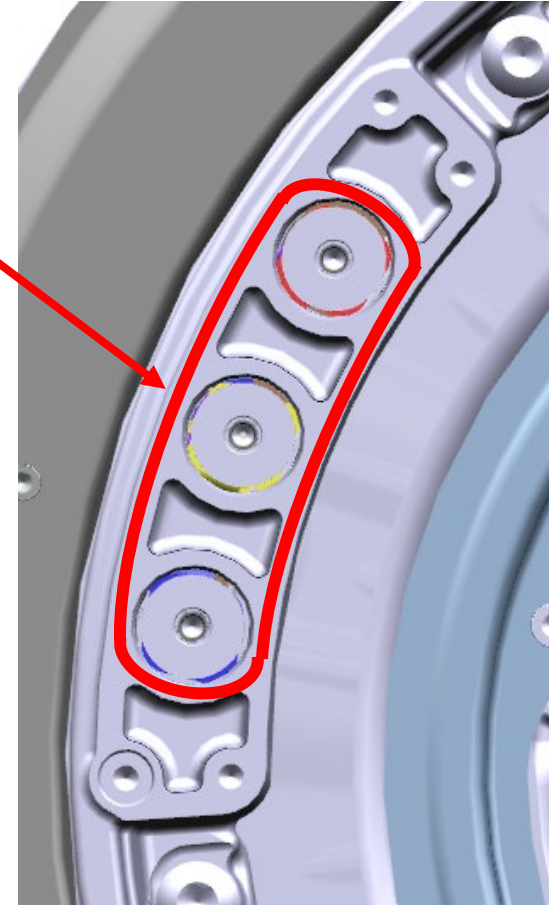
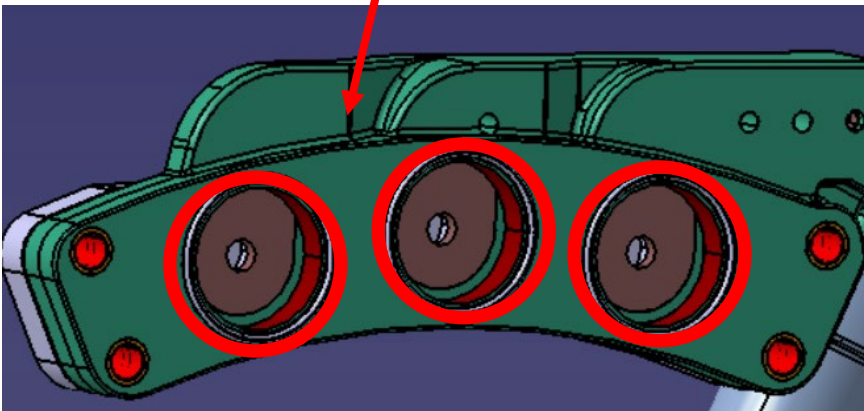


# Instructions of Liquid Gasket

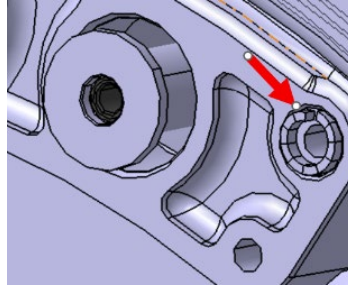
ABJA-077-AA Liquid Gasket Loctite SI 5900 (mfg p/n: 40478) used as a secondary seal for water intrusion.

1. Clean motor surface, including top of mushroom head, with Isopropanol and let dry.
2. Apply 2-3 mm bead as shown in red on either motor or busbar.

Caution: No Liquid Gasket on top of mushroom head  
Any excess liquid gasket remove with Isopropanol

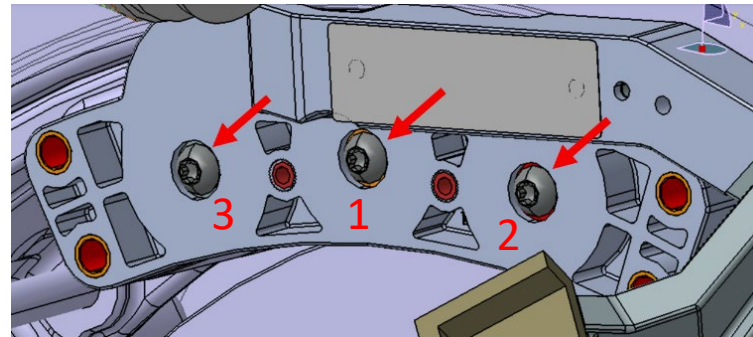


Add ABBE-035-AA 6.6x9.22x1.98 split washer to the cavity on the motor



Use two ABBB-120-AA M6x1.0x30 screw in each corner of the busbar to hold it steady before adding the mushroom head screws.

Add the mushroom head screws, ABBB-119-AA M5x.8x14 screw and ABBE-023-AA 5x9x.6 Belleville washer, using the torque sequence shown and torque to:  
Dynamic = 7 +/-1 Nm  
Static = 6 +/-2 Nm

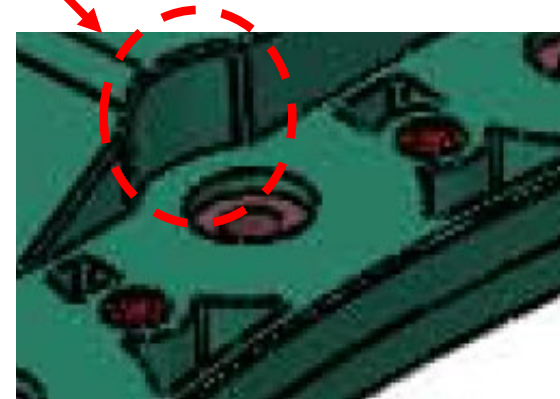
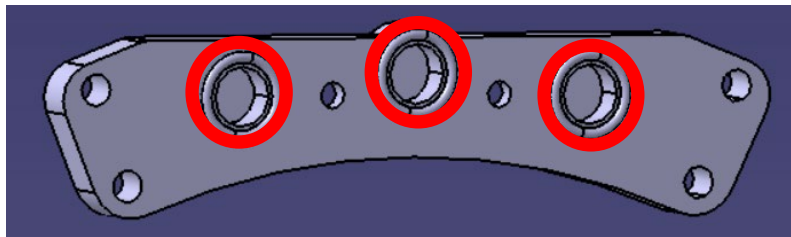
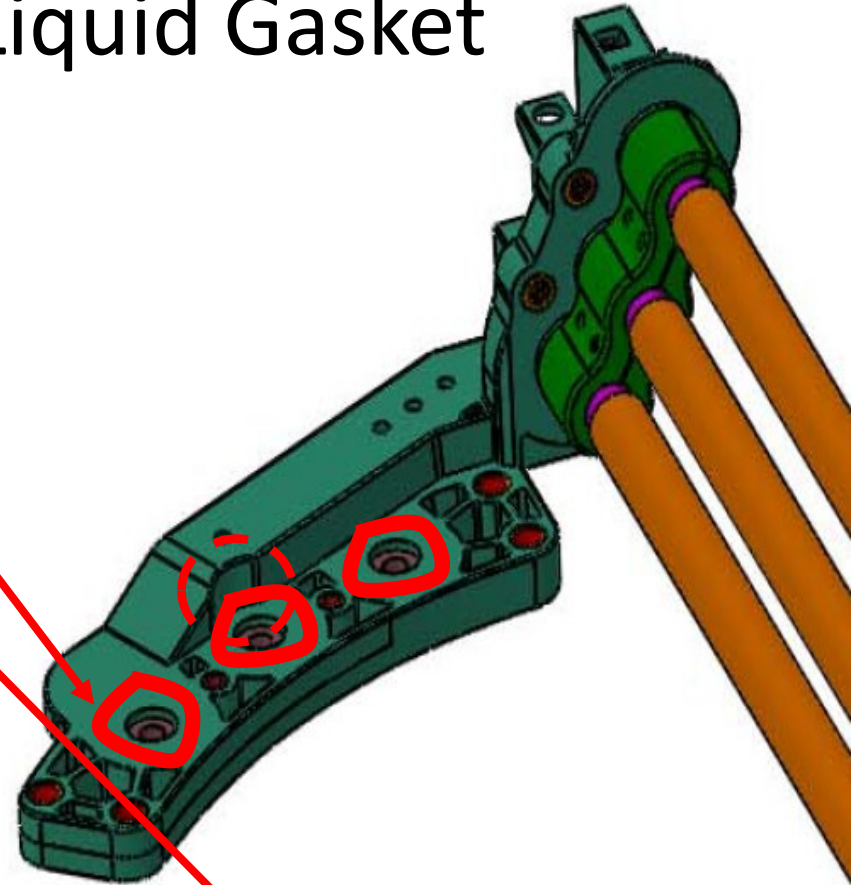
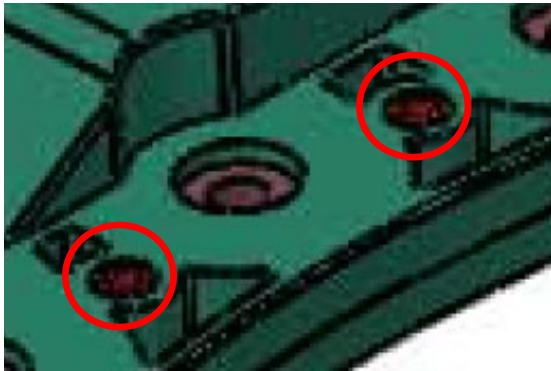


Remove the two ABBB-120-AA M6x1.0x30 screws from the corners.

# Instructions of Liquid Gasket

4. Clean surface of Bus bar and Cover with Isopropanol and let dry.
5. Apply 2-3 mm bead as shown in red.  
**Caution: Liquid Gasket must not cover 2 fastener holes**
6. Add extra Liquid Gasket to back of middle phase

**Caution: Liquid Gasket must not cover 2 fastner holes.**



On a vertical install, Loctite can be added to the cover instead of busbar.



Place cover and add the four corner screws, ABBB-120-AA M6x1.0x30 with ABBE-024-AA 6x9.5x.7 Belleville washer. Don't torque yet.

Add the two middle screws, ABBB-110-AA SCRW M4 X 0.7 X 8.0 BUTTON HEAD. Torque in the sequence show to:

Dynamic = 3.5 +/-0.3 Nm

Static = 3 +/-1 Nm

Torque the corner screws, ABBB-120-AA, in the sequence shown to:

Dynamic = 11 +/-1 Nm

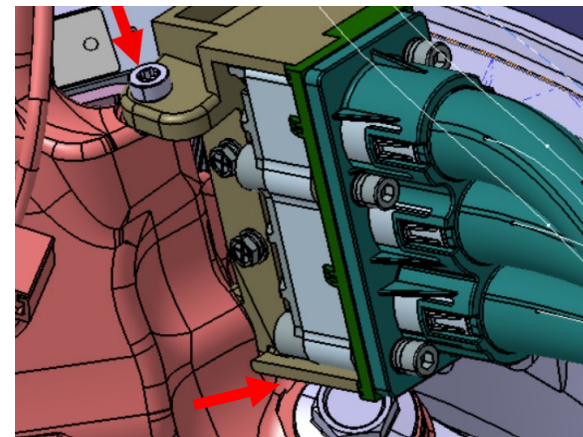
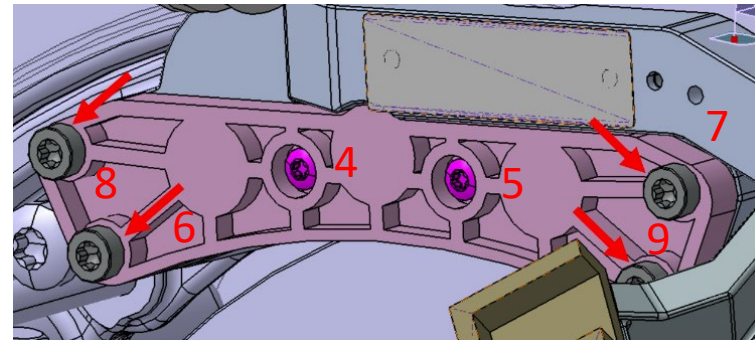
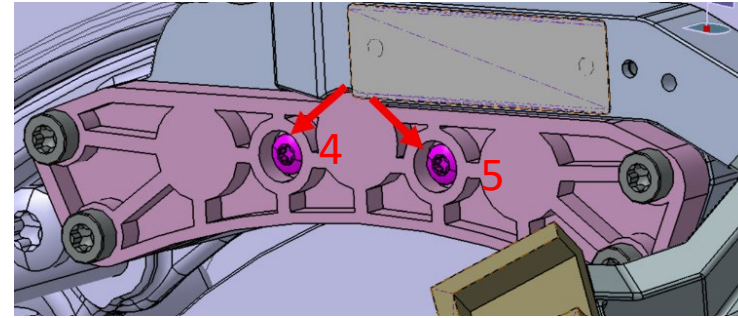
Static = 10 +/-2 Nm

On the front cables only:

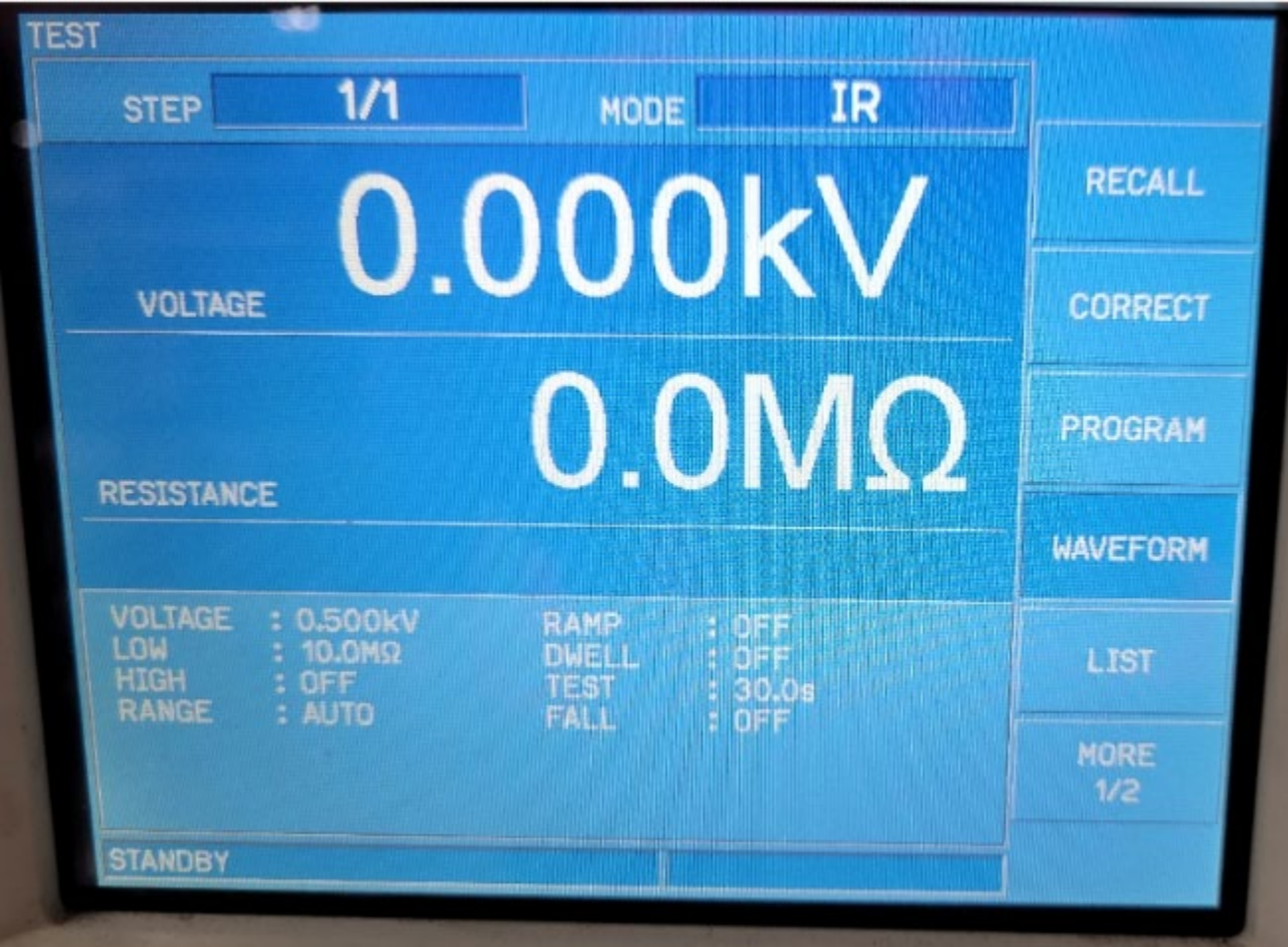
Add the two knuckle screws, ABBB-012-AA M6x1.0x20, with ABBE-024-AA 6x9.5x.7 Belleville washer. Torque to:

Dynamic = 11 +/-1 Nm

Static = 10 +/-2 Nm



Insulation resistance (IR) test performed at 500V  
Pass at >10M ohm.



Phase to phase resistance.

**Reference** value approximately between 97mohms and 89.5mohms

Record value

\*Measured value may vary based on precision level of equipment, temperature, and humidity levels at the time of measurement.

