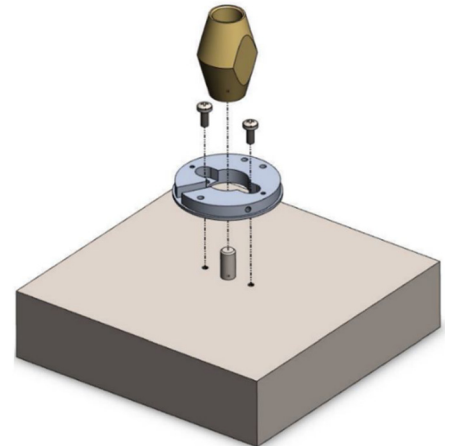


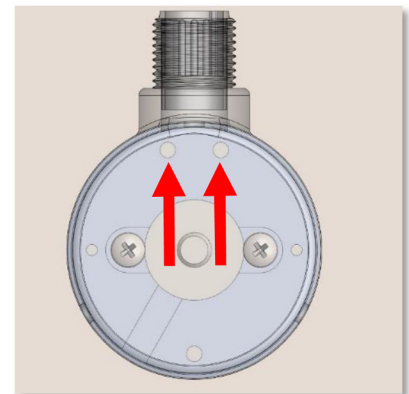
**Note:** Each ENC-KCD-BCB kit encoder ships with assembly tools, free of charge.

## Step 1: Base Mounting

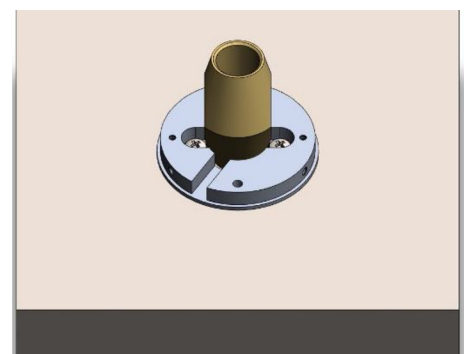
Slip adapter plate over shaft and use 2 screws to secure. Slip centering tool over shaft to center adapter plate to the shaft centerline.



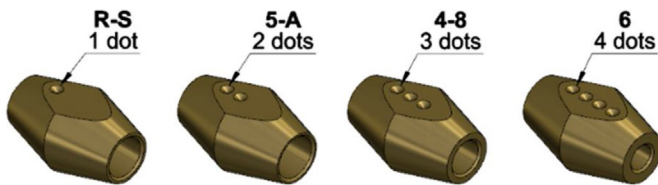
For a correct flange orientation, notice the two holes shown in the image. The connector location should be always assembled relative to these two holes.



Tighten mounting screws while pushing down on the centering tool and remove centering tool. Tighten screw to a typical of 56.6 oz-in (Actual torque value may change due to machine screw selected and base mounting material).



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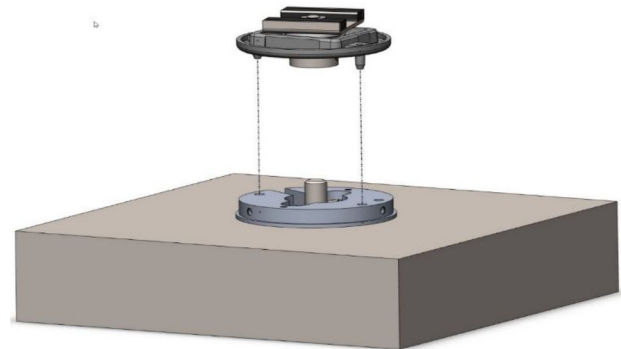


Article No.	Article Name	D1	D2	Mark
10044699	Kit-Centering-Tool-R-S	1/4"	3/8"	1 dot
10043221	Kit-Centering-Tool-5-A	5 mm	10 mm	2 dots
10046250	Kit-Centering-Tool-4-8	4 mm	8 mm	3 dots
10046251	Kit-Centering-Tool-6	6 mm	-	4 dots

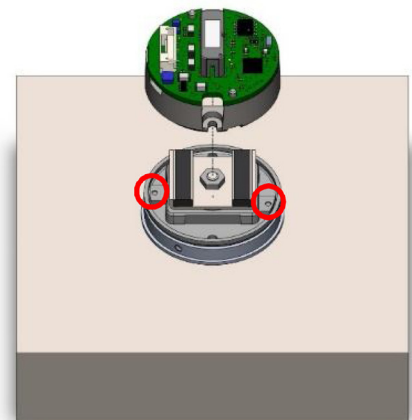
Each Centering Tool is compatible with two shaft diameters and is identified by the number of dots machined into the side of the tool.

### Step 2: Magnet Installation

Slide bottom shield / magnet assembly over shaft and lock alignment pins into adapter plate. Push down bottom shield all the way so it lies flat on the adapter plate.

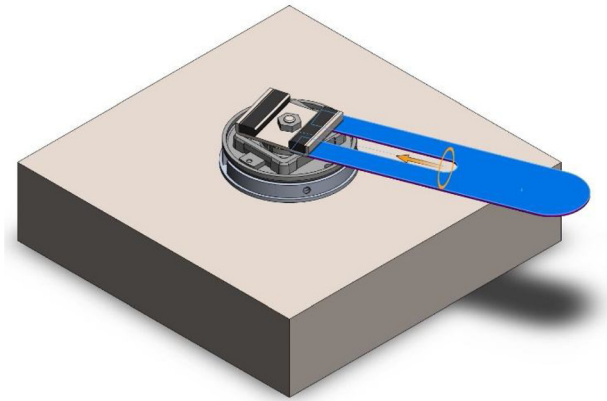


The alignment pin geometry is not symmetrical as shown by the red circles. Take care not to damage the pins during installation onto the adapter plate.



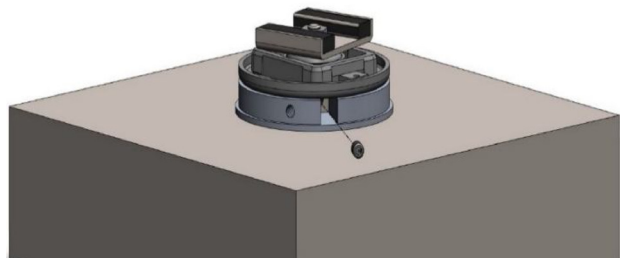
### Step 3: Spacer Tool Installation

Slide spacer tool (Required thickness of 0.0275") between magnet and bottom shield. Push magnet down.



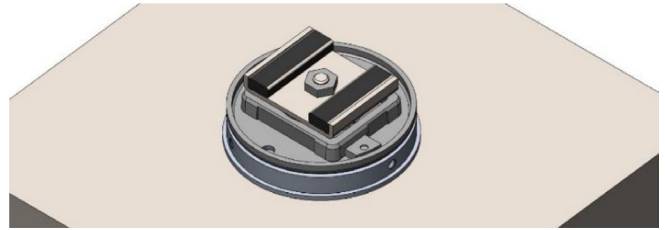
### Step 4: Tighten Screws

Tighten both set screws with a 0.05" hex key, using the channel hole in the adapter plate with a torque of 70.8 oz-in.

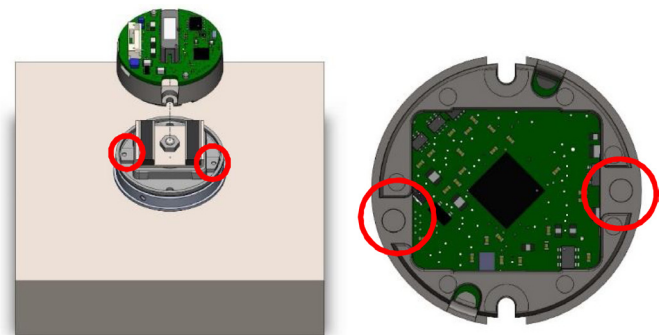


### Step 5: Align with Frame

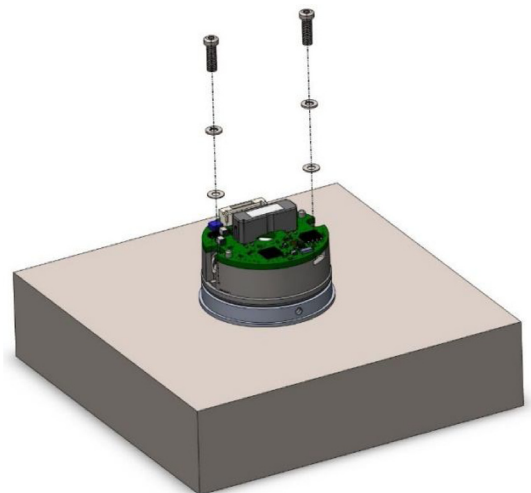
Align magnet with plastic frame on the bottom shield.



Align PCB with carrier to frame (two different keys) and push down until it locks into place.

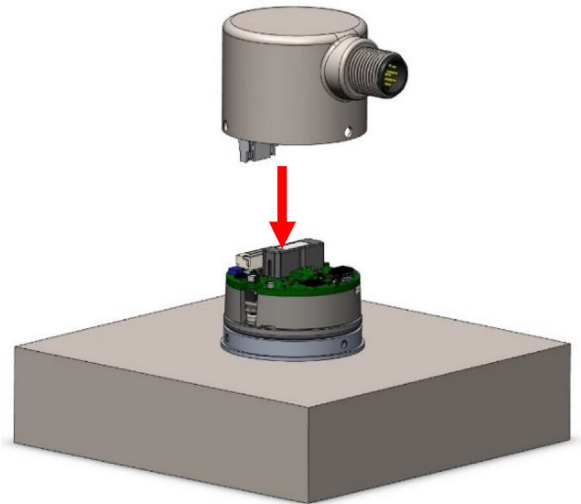


Insert two M2 screws with washers and lock washers and tighten using a Torx T6 key with a torque of 35.4 oz-in.



### Step 6: Housing Assembly

Connect housing cable assembly to the PCB by plugging the connector into the PCB.



Slide housing over adapter plate. Be careful to not pinch cable. Secure housing by tightening the three M2.5 screws using a Philips screw driver with a torque of 56.6 oz-in.

