

## 6.5 Assembly procedure

*\* Photos are related to ProfiNet version – differences with respect to TCP version are highlighted when needed.*

1. Peel the label to expose the adhesive tape and glue it on the top of the box. The flat cable shall be inserted in the milling of the top of the box cover.

TCP version: use the specific label (11A24 vs 12A24) and the box with two millings in place of three on the bottom (as TCP version hosts a single Ethernet port).

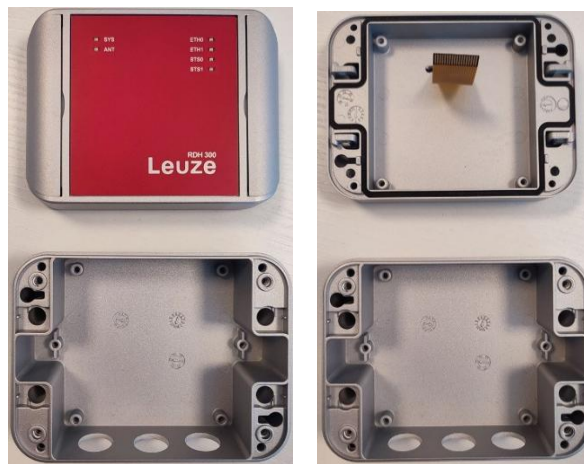


Figure 1: Apply the label on the top part of the box.

2. Insert the 8W flat cables on the power connection board (15C24) and the two 8W flat cables on the ETH connection board (17B24) in the milled holes (power to the left, ETH to the right).

TCP version: 17B24 PCB hosts two ETH connectors and can be separated in two parts by breaking the milling in the middle. Any of the resulting PCBs can be used for the single Ethernet port required in the TCP version, so that a single connector + cable are present.

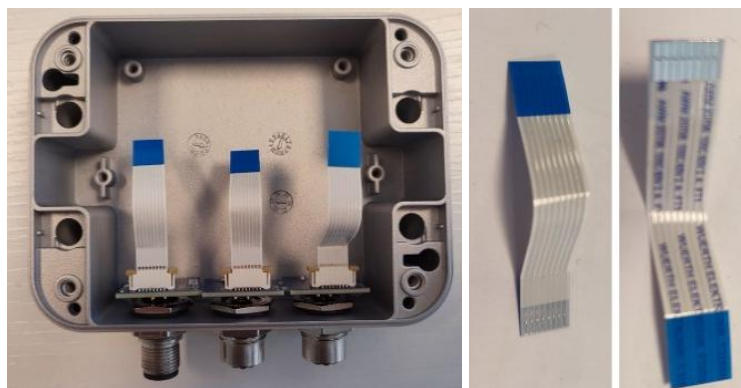
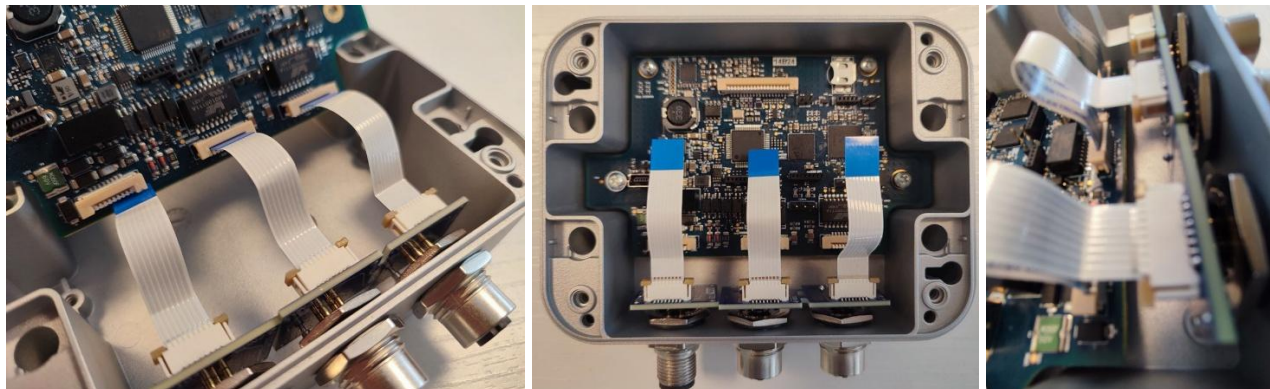


Figure 2: Insert the connector PCBs in the milled holes and the FPCs as shown.

Note: each connector lock shall be lifted perpendicularly to the PCB plane, before inserting the FPC and, then, pressed along the same axis.

3. Connect the main board 14B24 to the FPCs and insert it into the box, by aligning the millings for the 4xM3 screws near the edges. Screw them with standard tightening torque.



*Figure 3: 14B24 to connectors and box fitting.*

4. Connect the label flexible cable to the 14B24 PCB, place the lid on the box and lock the 4 screws on the corners, as shown below.



*Figure 4: label to main board FPC connection and box cover screws.*