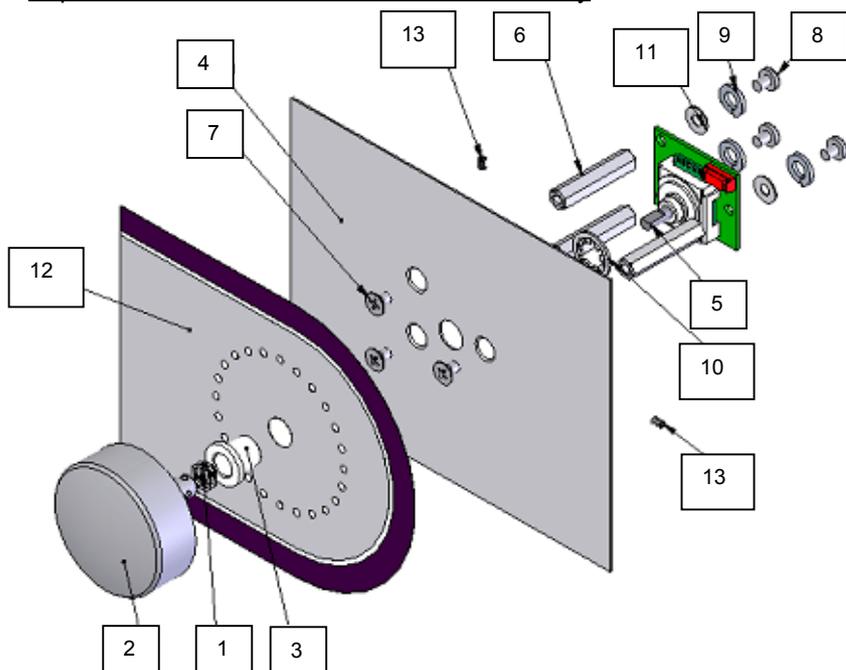


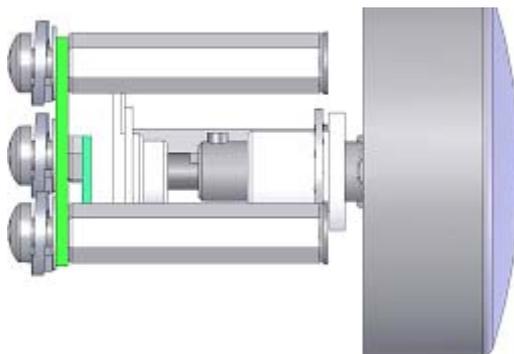
## Dial Shaft Encoder Assembly Instruction

Exploded View of Dial Shaft Encoder Assembly



Item No	Qty	Description
1	1	Wave Spring
2	1	Controller Dial
3	1	Nylon Bush
4	1	Unit Cover
5	1	Dial Encoder
6	3	Stand Off Post
7	3	M4 Screw 6mm
8	3	Pan Head M4 Screw
9	3	Sprung Washer
10	1	Toothed Washer
11	3	M4 Penny Washer
12	1	Membrane
13	2	M4 Grub Screw

Detail Shown with Sheet metal and membrane removed



### Replacement instruction for the Dial Shaft Encoder part number 00-555396

1. Release the tension on both of the grub screws locking the aluminium knob to the encoder shaft using a 1.5mm hexagonal wrench. (Note: on early models only one grub screw was fitted).
2. Remove the three retaining screws securing the encoder to the stand off posts (Note: on early models these were assembled using nuts on to threaded rod with nylon spacers).
3. Remove the encoder from the assembly and unplug the ribbon cable.
4. Offer the replacement encoder to the assembly and slide the black shaft into the sleeve of the aluminium knob ensuring that the flat portions of the black shaft lines up with the grub screw nearest the end of the sleeve.
5. Secure the encoder to the stand off posts / threaded rod taking care not to over tighten the screws / nuts.  
**Note:** do not press the knob when assembling, as this will reduce the amount of travel into the encoder.
6. Tighten the grub screw nearest the end of the shaft on to the flat portion taking care not to over tighten. For earlier models with only one grub screw tighten it to the flat portion of the shaft taking care not to over tighten. For models with grub screws side by side align one of the screws against the flat portion and tighten taking care not to overtighten.
7. Tighten the second screw, if fitted, securing the shaft firmly to the knob.
8. Depress the knob from the front and check that the shaft passes into the encoder, release the knob and check that the knob and shaft return to the open position.
9. If there is no movement release the tension on the grub screws allowing the shaft to exit the sleeve, retighten the grub screw/s and check the movement.
10. If there is satisfactory movement continue if not repeat 9.
11. Plug the ribbon cable it to the socket of the encoder.
12. Switch the unit on and check that the machine is working correctly, if not repeat 9.