



## SERVICE PARTS LIST

BULLETIN NO.  
54-40-9030

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
MX FUEL 14" CUT-OFF SAW			July 2024
CATALOG NO. MXF315	SERIAL NO. N39A	WIRING INSTRUCTION See Pages 6-16	

EXPLODED VIEW - One of two

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EXPLODED VIEW - Two of two

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SERVICE BOM LISTING

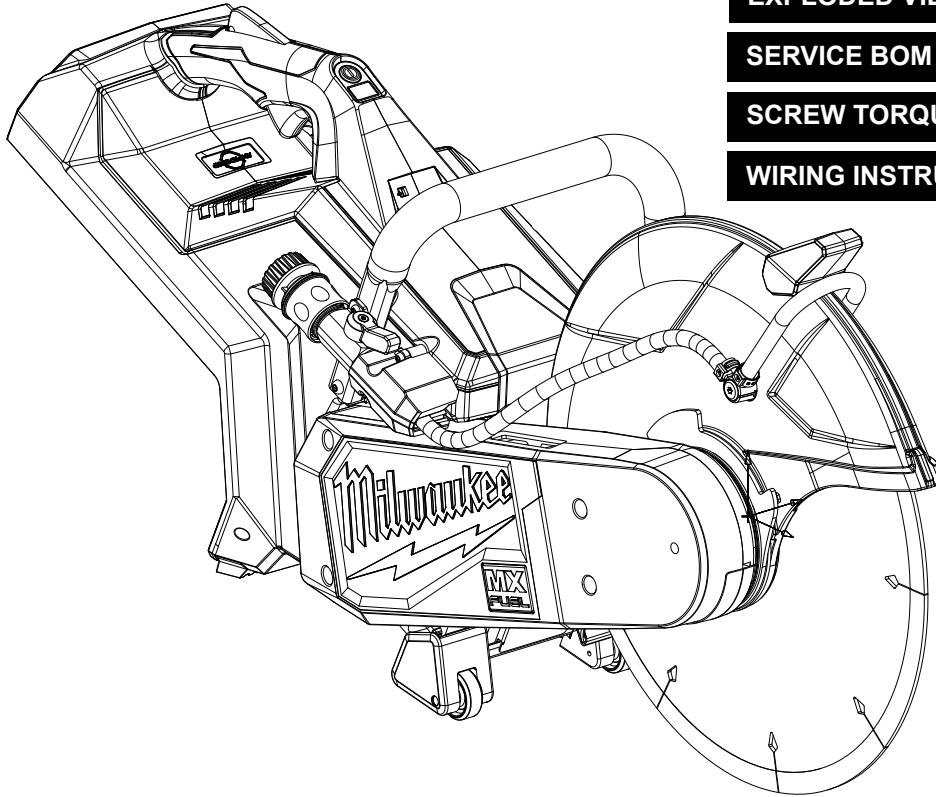
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SCREW TORQUE SPECIFICATIONS

PAGE 5

WIRING INSTRUCTIONS

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Only maintenance, service, repairs, and replacements of parts as defined in the Operator's Manual can be performed by the user.

All other repairs are to ONLY be performed by personnel authorized by MILWAUKEE TOOL. Do not attempt to install other parts; this COULD void your tool warranty.

### For service, parts, or inquiries, contact us:

- Customer Service at 1.800.SAWDUST (1.800.729.3878)
- E-Service tool repair at: [www.milwaukeetool.com/e-service](http://www.milwaukeetool.com/e-service)
- Find a local authorized MILWAUKEE service location at [Milwaukeetool.com](http://Milwaukeetool.com)
- Find a MILWAUKEE *factory* Service Center Location or MILWAUKEE *factory* Central Repair Center at [Milwaukeetool.com](http://Milwaukeetool.com). Send the following, posted paid and insured:
  - Your name, address, and phone number
  - Description of the issues
  - Copy of the proof of purchase
  - Tool, charger, and batteries involved with the issues

### MILWAUKEE *factory* Central Repair Centers:

MILWAUKEE TOOL  
Central Repair  
1401 Sycamore Avenue  
Greenwood, MS 38930

MILWAUKEE TOOL  
Central Repair  
2198 Southtech Drive  
Greenwood, IN 46143

**See page four for a complete BOM  
(Bill of Material) listing**

201	66	78	79	80	81	82	83	94	95	96	97
	98	99	100	101	102	103	104	105	106	107	

209	66	70	71	72	74	76
	114	123	127	155	156	157

217	66	143
	144	145

219	64	77	89	113	116	118	124	125
	126	134	146	147	148	149	150	158

218	89	108	109
	110	111	112

203	115	117
	133	

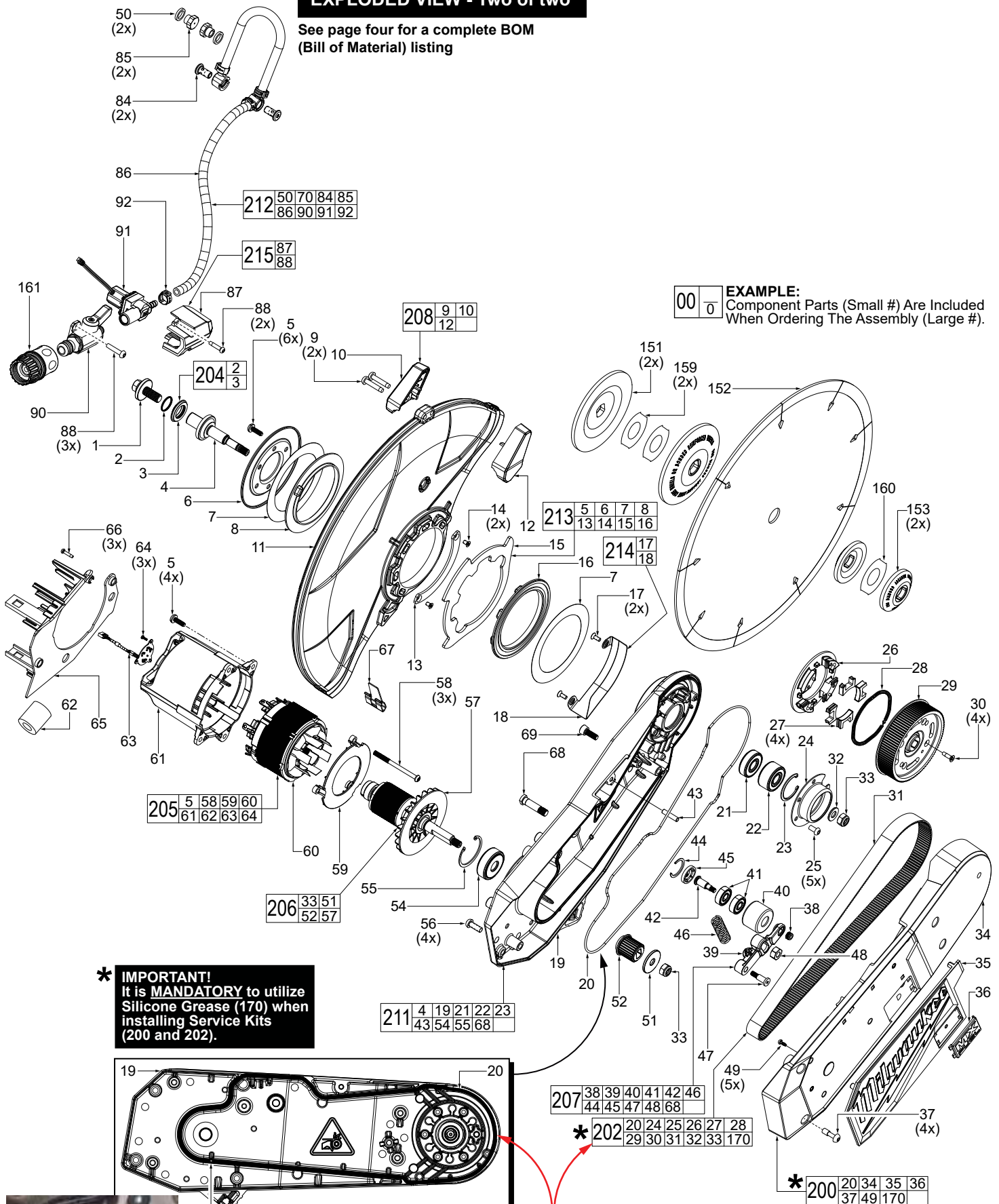
220	116	120
	121	122

216	38	49	53	70	137
	138	139	140	142	

**Do not reuse screws (147).  
Always use new screws  
(Containing a fresh thread  
locking patch).  
Torque screws to  
39±2 lb-in / 45±3 kgf-cm**

## EXPLODED VIEW - Two of two

See page four for a complete BOM  
(Bill of Material) listing



Rubber Seal (20) should start and end at this position.

For ease of installation of Rubber Seal (20) into Arm (19), place silicone grease (170), No. 44-22-0075, into Arm channel prior to installing the Rubber Seal.

# SERVICE BILL OF MATERIAL (BOM) LISTING

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.	FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	06-14-0013	M10 Hex Hd. Mach. Screw w/ Washer	(1)	92	-----	Clamp	(1)
2	-----	O-Ring	(1)	94	-----	Rear Metal Rail	(2)
3	-----	Arbor Adapter	(1)	95	-----	Pivot Bushing	(2)
4	38-50-5385	Output Shaft	(1)	96	-----	Lock Off Lever Pin	(1)
5	06-82-9805	M5 x 15mm Pan Hd. PT T-25 Screw	(10)	97	-----	Lock Off Lever Torsion Spring	(1)
6	-----	Output Cover	(1)	98	-----	Lever Lock Out	(1)
7	-----	Pivot Shim	(2)	99	-----	Release Lever	(1)
8	-----	Rubber Gasket-1	(1)	100	-----	Pivot Latch Spring Holder	(1)
9	06-82-2250	M5 x 25 Pan Hd. PT T-25 Screw	(2)	101	-----	M5 x 16mm Pan Hd. T-25 ST Screw	(2)
10	-----	Guard Handle Cover	(1)	102	-----	Latch	(1)
11	43-54-4015	Blade Guard	(1)	103	-----	Spring	(2)
12	-----	Guard Handle Support	(1)	104	-----	Battery Ejector	(1)
13	44-66-7320	Plate Guard	(1)	105	-----	Spring	(2)
14	05-81-0592	M4 x 6.5mm Flat Hd. T-15 Machine Screw	(2)	106	-----	Spring	(1)
15	-----	Guard Stop Plate	(1)	107	-----	Pivot Shaft	(2)
16	-----	Rubber Gasket-2	(1)	108	-----	Trigger	(1)
17	-----	M4 x 10mm Flat Hd. T-20 Machine Screw	(2)	109	-----	Trigger Spring	(1)
18	-----	Wear Proof Plate	(1)	110	-----	Torsion Spring	(1)
19	-----	Arm	(1)	111	-----	Trigger Pin	(1)
20	45-06-5470	Rubber Seal	(1)	112	-----	Shark Fin	(1)
21	-----	Ball Bearing	(1)	113	22-80-0305	Program Board Cover	(1)
22	-----	Double Row Bearing	(1)	114	06-54-0355	Control Nut	(2)
23	-----	Internal Bevel Retaining Ring	(1)	115	-----	Rear Rubber Boot - Left	(1)
24	-----	Inner Hub	(1)	116	06-82-9280	Drop Off Screw	(2)
25	-----	M5 x 10mm Pan Hd. T-25 Machine Screw	(5)	117	-----	M5 x 20mm Pan Hd. T-25 Screw w/Washer	(2)
26	-----	Mechanical Brake Cage	(1)	118	-----	Coin Cell Board	(1)
27	-----	Mechanical Brake Fly Weight	(4)	119	-----	3V Coin Cell (CR2032) (Not Shown)	(1)
28	-----	Garner Spring	(1)	120	-----	Anti-Static Seal	(1)
29	-----	Driver Pulley with Mods	(1)	121	-----	Coin Cell Cover	(1)
30	05-81-0594	M4 x 14mm Flat Hd. T-20 ST Screw	(4)	122	-----	C Ring - E Type	(1)
31	-----	Belt 729-3MR-18	(1)	123	45-72-0165	Panel Connector Cover	(1)
32	45-88-0103	Washer	(1)	124	22-80-0310	Arm Board	(1)
33	05-55-0025	M8 LH Hex Nut	(2)	125	-----	Rubber Arm Button	(1)
34	-----	Arm Cover	(1)	126	-----	Arm Button Housing	(1)
35	-----	Arm Cover Logo Plate	(1)	127	44-66-7340	Rapid Stop Plate	(1)
36	-----	MX Badge	(1)	128	43-74-0735	Rear Insert	(1)
37	06-82-9815	M6 x 18.5mm Pan Hd. T-25 Capt. Mach. Scr.	(4)	129	06-82-0032	M4 x 12mm Pan Hd. T-20 ST Screw	(2)
38	-----	Nylon Insert Nut	(3)	130	45-96-2545	Hex Key Retaining Cover	(1)
39	-----	Tensioner Arm	(1)	131	44-86-3215	Wrench Retainer	(1)
40	-----	Tensioner Wheel	(1)	132	34-40-4480	O-Ring	(1)
41	-----	Deep Groove Ball Bearing	(2)	133	-----	Rear Rubber Boot - Right	(1)
42	-----	Tensioner Wheel Shaft	(1)	134	22-80-0315	Brake Board	(1)
43	06-65-7345	5mm x 22mm Nickel Plated Pin	(2)	135	49-96-0021	Hex Key	(1)
44	-----	Retaining Ring	(1)	136	49-96-0031	Scwrench	(1)
45	-----	Tensioner Wheel Cover	(1)	137	-----	Wheel Shaft	(2)
46	-----	Tensioner Spring	(1)	138	-----	Bushing	(2)
47	-----	M5 x 21-75mm Cap Hd. Hex Drive Screw	(1)	139	-----	Wheel	(2)
48	-----	M8 x 1.25mm Hex Nut	(1)	140	-----	Wheel Foot - Left	(1)
49	-----	M3 x 8mm Pan Hd. T-10 PT Screw	(7)	141	-----	Bale Handle	(1)
50	45-88-9090	Flat Washer	(2)	142	-----	Wheel Foot - Right	(1)
51	-----	Driver Rim	(1)	143	-----	Resistor Mounting Bracket	(1)
52	-----	Driver Pulley	(1)	144	05-78-0135	M4 x 12mm Flat Hd. ST Philips Screw	(2)
53	-----	M5 x 17mm Pan Hd. T-25 Machine Screw	(2)	145	-----	Resistor Holder	(1)
54	-----	Deep Groove Ball Bearing	(1)	146	22-80-0307	Control Board	(1)
55	-----	Beveled Retaining Ring	(1)	147	06-82-9820	M6 x 7mm Cap Hd. Hex Drive Mach. Screw	(5)
56	05-74-0246	M6 x 16mm Pan Hd. T-30 Machine Screw	(4)	148	22-38-0365	Wire Trap Cover	(1)
57	-----	Rotor	(1)	149	22-80-0325	BLE Board	(1)
58	05-88-5927	CH K50 Pan Hd. T-20 PT Screw	(3)	150	22-80-0330	IMU Board	(1)
59	-----	Baffle Insert	(1)	151	43-34-2735	Large Saw Flange	(2)
60	-----	Stator	(1)	152	49-93-7540	Diamond Ultra Blade (Accessory)	(1)
61	-----	Motor Housing	(1)	153	43-34-2745	Blade Flange	(2)
62	-----	Ferrite Bead	(1)	154	23-56-0055	Panel Connector	(1)
63	-----	Hall Board	(1)	155	-----	B-Side Logo Cover	(1)
64	05-88-0083	M2.2 x 6mm Pan Hd. T-8 ST Screw	(9)	156	12-20-9930	Service Nameplate	(1)
65	31-05-7065	Motor Housing Baffle	(1)	157	10-22-0589	One Key Bluetooth Label	(1)
66	06-82-1080	M3 x 14mm Pan Hd. T-10 ST Screw	(12)	158	10-20-3237	MX Fuel Label	(1)
67	40-50-8910	Blade Guard Trim Spring Plate	(1)	159	10-20-3654	Reversible Arbor Adapter Label	(2)
68	-----	Tensioner Arm Lock Pin	(1)	160	10-22-0590	Reversible Arbor Adapter Label	(1)
69	06-14-0380	Special Head Located Bolt	(1)	161	43-33-0130	Quick Hose Connector Assembly	(1)
70	06-82-0152	M5 x 22mm Pan Hd. T-25 ST Screw	(13)	170	44-22-0075	Silicone Grease, 5ml tube (Not Shown)	(1)
71	05-88-0087	M5 x 115mm Pan Hd. T-25 PT Screw	(5)	200	14-46-9602	Arm Cover Service Kit	(1)
72	-----	Housing Cover	(1)	201	14-46-9604	Battery Rail Service Assembly	(1)
73	43-54-0935	Spark Guard	(1)	202	14-46-9606	Belt Train Service Kit	(1)
74	-----	Bottom Piece	(1)	203	14-46-9657	Rear Foot Kit	(1)
75	14-20-0935	Load LED and OneKey LED	(1)	204	14-46-9608	Arbor Adaptor Service Kit	(1)
76	-----	Housing Support	(1)	205	14-46-9612	Motor Stator Service Kit	(1)
77	45-72-0145	Switch Assembly	(1)	206	14-46-9614	Rotor Service Kit	(1)
78	-----	Battery Rail Cover	(1)	207	14-46-9616	Tensioner Service Kit	(1)
79	-----	Front Metal Rail	(2)	208	14-46-9618	Guard Handle Service Kit	(1)
80	-----	M3 x 16mm Pan Hd. ST Tamperproof Scr.	(8)	209	14-46-9622	Housing Service Kit	(1)
81	-----	Ejection Spring Holder	(1)	210	14-46-9624	Bale Handle Service Kit	(1)
82	-----	Battery Terminal Block	(1)	211	14-46-9627	Arm Assembly Service Kit	(1)
83	-----	Battery Rail Support	(1)	212	14-46-9629	Water Delivery System Service Kit	(1)
84	05-74-7140	Banjo Bolt	(2)	213	14-46-9632	Guard Service Kit	(1)
85	31-01-2145	Nozzle	(2)	214	14-46-9634	Wearing Proof Plate Service Kit	(1)
86	-----	Water Valve Assembly-II	(1)	215	14-46-9636	Valve Shell Service Kit	(1)
87	-----	Water Valve Shell	(1)	216	14-46-9638	Wheel Foot Service Kit	(1)
88	06-82-0044	M4 x 18mm Pan Hd. T-20 ST Screw	(5)	217	14-46-9643	Brake Resistance Holding Service Kit	(1)
89	06-82-4003	M4 x 16mm Pan Hd. T-20 ST Screw	(3)	218	14-46-9647	Trigger Service Kit	(1)
90	-----	Valve Body Assembly	(1)	219	14-20-9503	PCBA Service Kit	(1)
91	-----	Electrical Water Valve	(1)	220	22-09-6615	Coin Cell Cover Service Kit	(1)



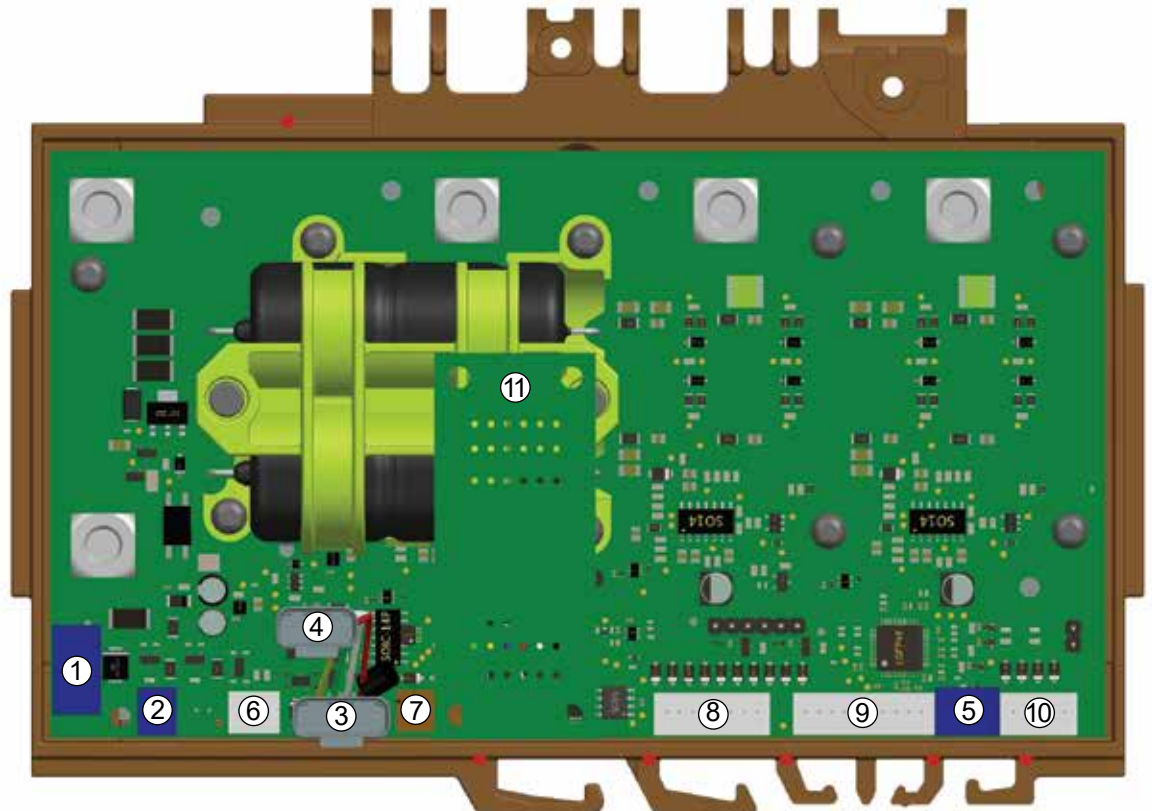
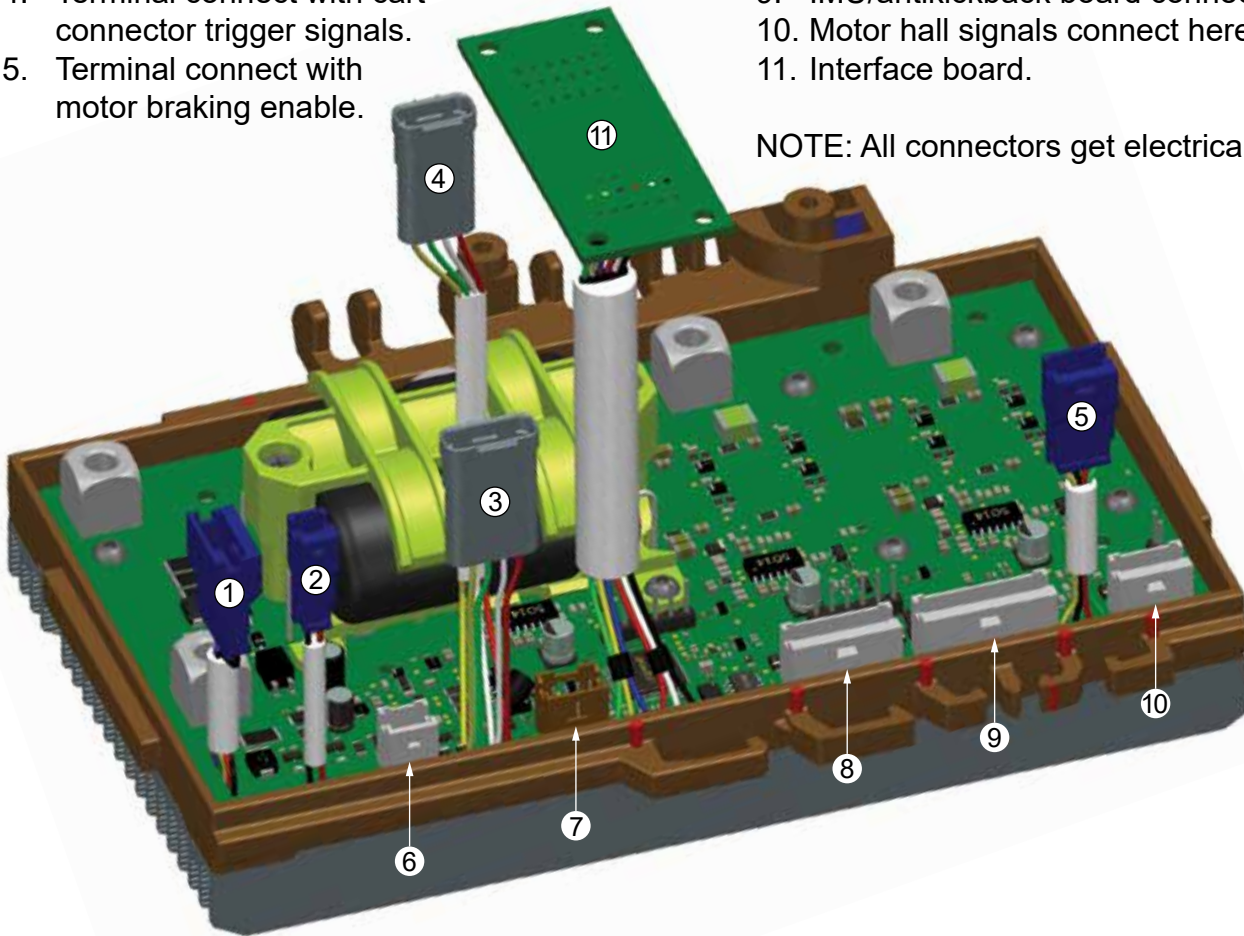
# SCREW TORQUE SPECIFICATIONS

FIG.	PART NO.	DESCRIPTION OF FASTENER	WHERE USED	SEAT TORQUE	
				(LBS.IN)	(KGF.CM)
5	06-82-9805	M5 x 15mm Pan Hd. PT T-25 Screw	Motor Housing	52±4	60±5
5	06-82-9805	M5 x 15mm Pan Hd. PT T-25 Screw	Output Cover	52±4	60±5
9	06-82-2250	M5 x 25 Pan Hd. PT T-25 Screw	Guard Handle Cover	21±1	25±2
14	05-81-0592	M4 x 6.5mm Flat Hd. T-15 Machine Screw	Plate Guard / Blade Guard	8±1	10±1
17	-----	M4 x 10mm Flat Hd. T-20 Machine Screw	Wear Proof Plate	13±1	15±1
25	-----	M5 x 10mm Pan Hd. T-25 Machine Screw	Inner Hub	26±2	30±3
30	05-81-0594	M4 x 14mm Flat Hd. T-20 ST Screw	Driver Pulley with Mods	13±1	15±1
33	05-55-0025	M8 LH Hex Nut	Threaded End of Rotor	86±8	100±10
33	05-55-0025	M8 LH Hex Nut	Threaded End of Output Shaft	260±8	300±10
37	06-82-9815	M6 x 18.5mm Pan Hd. T-25 Capt. Mach. Scr.	Arm Cover	21±1	25±2
38	-----	Nylon Insert Nut	End of Tensioner Wheel Shaft	13±1	15±2
47	-----	M5 x 21-75mm Cap Hd. Hex Drive Screw	Tensioner Arm	26±2	30±2
48	-----	M8 x 1.25mm Hex Nut	End of Tensioner Arm Lock Pin	86±8	100±10
49	-----	M3 x 8mm Pan Hd. T-10 PT Screw	Arm Cover	3.0±1	3.5±1
53	-----	M5 x 17mm Pan Hd. T-25 Machine Screw	Wheel Foot - Right	21±1	25±2
56	05-74-0246	M6 x 16mm Pan Hd. T-30 Machine Screw	Arm	30±2	35±3
58	05-88-5927	CH K50 Pan Hd. T-20 PT Screw	Baffle Insert / Motor Housing	21±1	25±2
64	05-88-0083	M2.2 x 6mm Pan Hd. T-8 ST Screw	Hall Board	1.7±0.5	2±0.5
64	05-88-0083	M2.2 x 6mm Pan Hd. T-8 ST Screw	Arm Board	1.7±0.5	2±0.5
64	05-88-0083	M2.2 x 6mm Pan Hd. T-8 ST Screw	BLE Board / IMU Board	1.7±0.5	2±0.5
66	06-82-1080	M3 x 14mm Pan Hd. T-10 ST Screw	Motor Housing Baffle	3.4±1	4±1
66	06-82-1080	M3 x 14mm Pan Hd. T-10 ST Screw	Battery Rail Cover	4.3±1	5±1
66	06-82-1080	M3 x 14mm Pan Hd. T-10 ST Screw	Resistor Mounting Bracket	10±1	12±1
66	06-82-1080	M3 x 14mm Pan Hd. T-10 ST Screw	Housing Cover / B-Side Logo Cover	6±1	7±1
69	06-14-0380	Special Head Located Bolt	Arm	17±1	20±2
70	06-82-0152	M5 x 22mm Pan Hd. T-25 ST Screw	Housing Cover	15.6±1	18±1.5
70	06-82-0152	M5 x 22mm Pan Hd. T-25 ST Screw	Bale Handle	21±1	25±2
70	06-82-0152	M5 x 22mm Pan Hd. T-25 ST Screw	Wheel Foot - Left	21±1	25±2
70	06-82-0152	M5 x 22mm Pan Hd. T-25 ST Screw	Valve Body Assembly	21±1	25±2
71	05-88-0087	M5 x 115mm Pan Hd. T-25 PT Screw	Housing Cover	15.6±1	18±1.5
80	06-82-9630	M3 x 16mm Pan Hd. ST Tamperproof Scr.	Front & Rear Metal Rails	4.3±1	5±1
84	05-74-7140	Banjo Bolt	Water Valve Assembly-II	34±2	40±3
88	06-82-0044	M4 x 18mm Pan Hd. T-20 ST Screw	Water Valve Shell	11.7±1	13.5±1
89	06-82-4003	M4 x 16mm Pan Hd. T-20 ST Screw	Wire Trap Cover	13±1	15±1
89	06-82-4003	M4 x 16mm Pan Hd. T-20 ST Screw	Shark Fin	7.8±1	9±1
101	06-82-0029	M5 x 16mm Pan Hd. T-25 ST Screw	Pivot Bushing	13±1	15±1
116	06-82-9280	Drop Off Screw	Program Board Cover	3±1	3.5±1
117	-----	M5 x 20mm Pan Hd. T-25 Screw w/Washer	Rear Rubber Boot - Right & Left	13±1	15±1
129	06-82-0032	M4 x 12mm Pan Hd. T-20 ST Screw	Hex Key Retaining Cover	9.5±1	11±1
144	05-78-0135	M4 x 12mm Flat Hd. ST Philips Screw	Resistor Holder	6.9±1	8±1
147	06-82-9820	M6 x 7mm Cap Hd. Hex Drive Mach. Screw	Control Board	39±2	45±3
154	23-56-0055	Panel Connector	Housing Support	8±1	10±1

## WIRING INSTRUCTIONS - Control Board Detail

1. Terminal connect with battery communications.
2. Terminal connect with watervalue.
3. Terminal connect with saw trigger.
4. Terminal connect with cart connector trigger signals.
5. Terminal connect with motor braking enable.
6. Load light connects here.
7. Arm button/LED connects here.
8. Bluetooth board connects here.
9. IMU/antikickback board connects here.
10. Motor hall signals connect here.
11. Interface board.

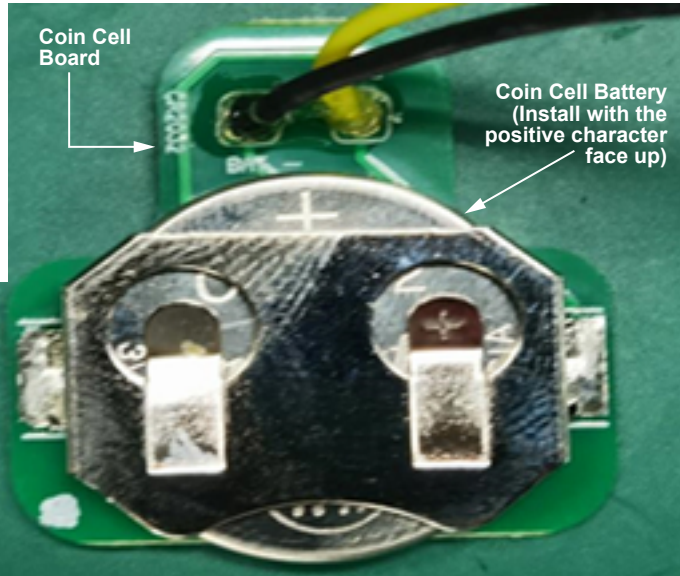
NOTE: All connectors get electrical grease.







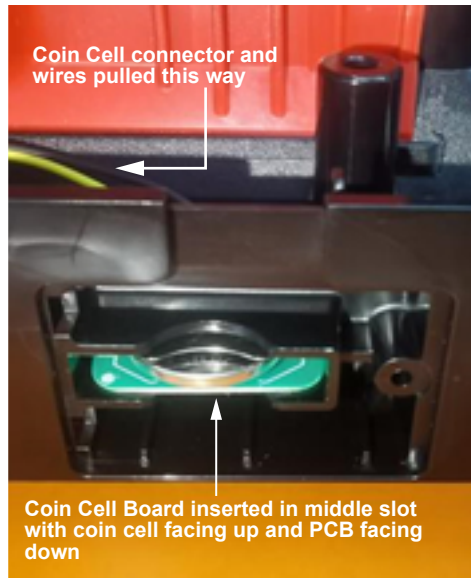
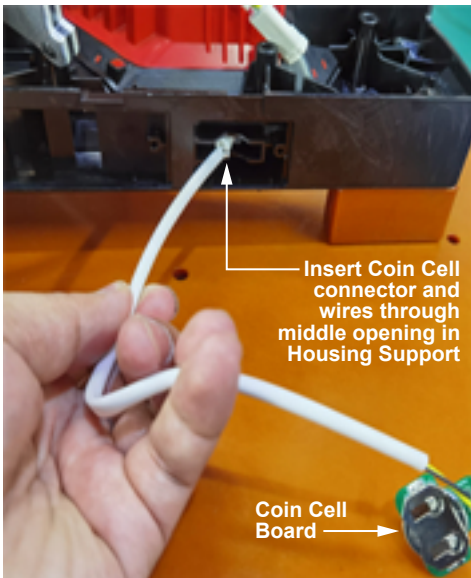
3V Coin Cell Battery



NOTE: 3V coin cell batteries (CR2032) are available at most hardware or retail stores.

Install the coin cell battery onto the coin cell PCB assembly as shown.

Be sure that the coin cell is oriented with the '+' symbol facing upward.

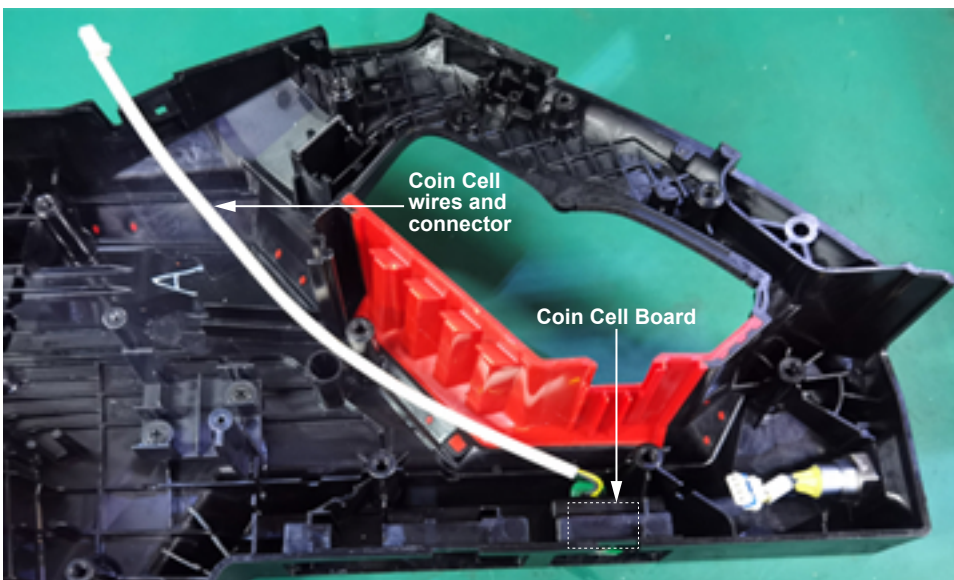


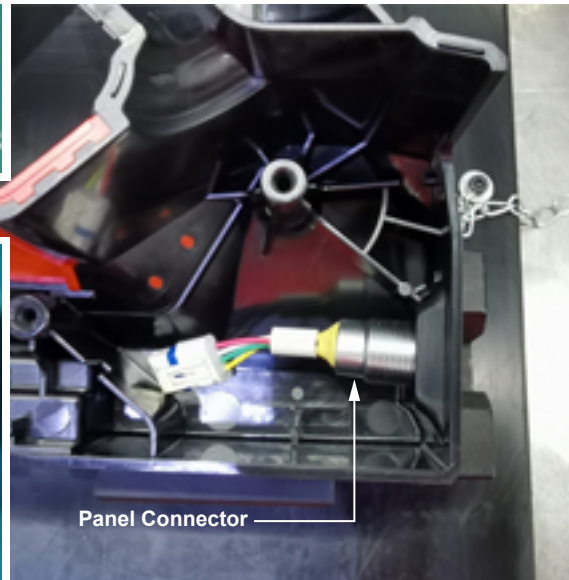
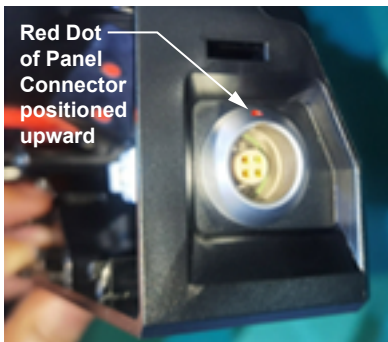
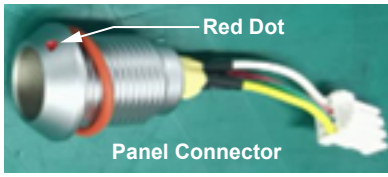
Install the coin cell PCB assembly into the housing support.

Feed the coin cell connector and wires through the middle opening located on the bottom of the housing support.

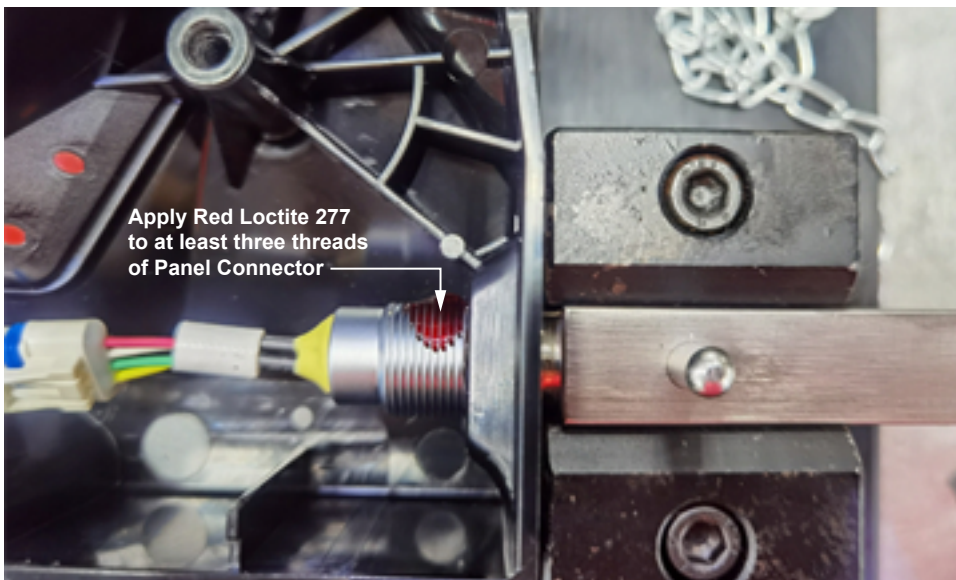
Pull the connector and wires taut, while seating the coin cell PCBA in that middle slot. Be sure that the PCBA is firmly and squarely seated in the cavity.

Be sure the PCBA is oriented with the coin cell facing up and the PCB facing down as shown.

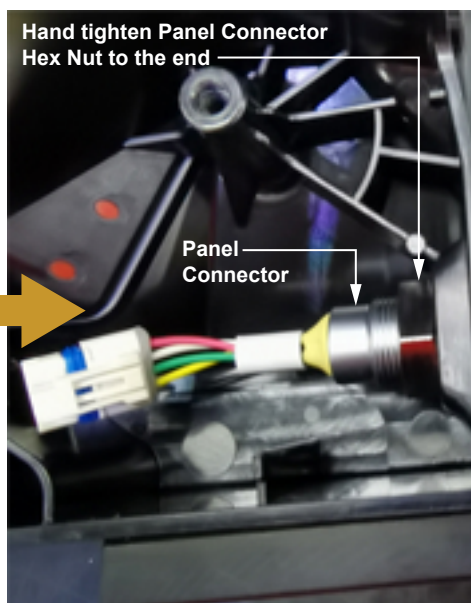
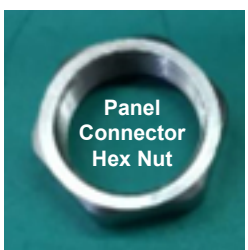




When installing the panel connector into the housing support be sure that the red dot is facing upward at the 12:00 position.

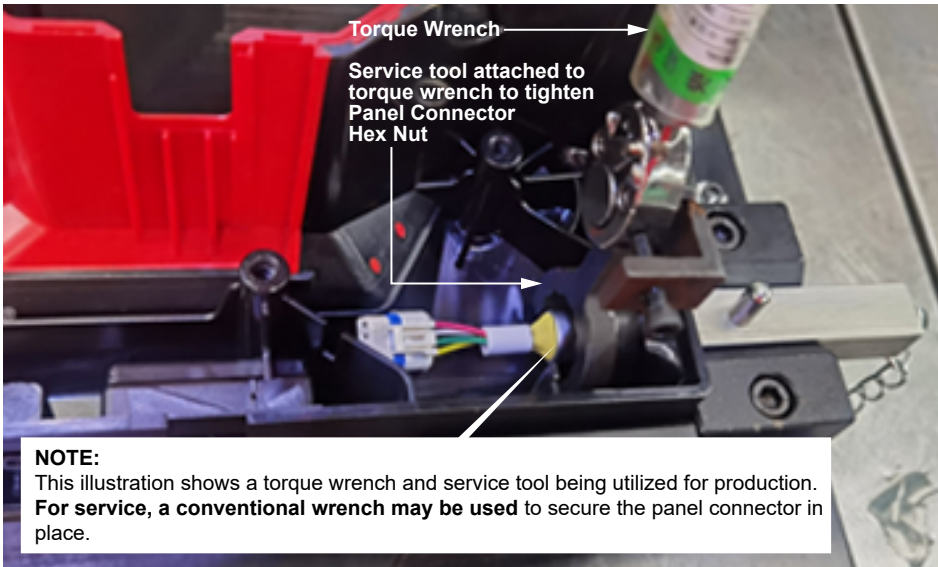


Apply a drop of Red Loctite 277 to at least 3 threads of the panel connector.



Feed hex nut over panel connector wires and onto the threaded portion of the panel connector. Screw the hex nut clockwise by hand until nut is snug at the end.

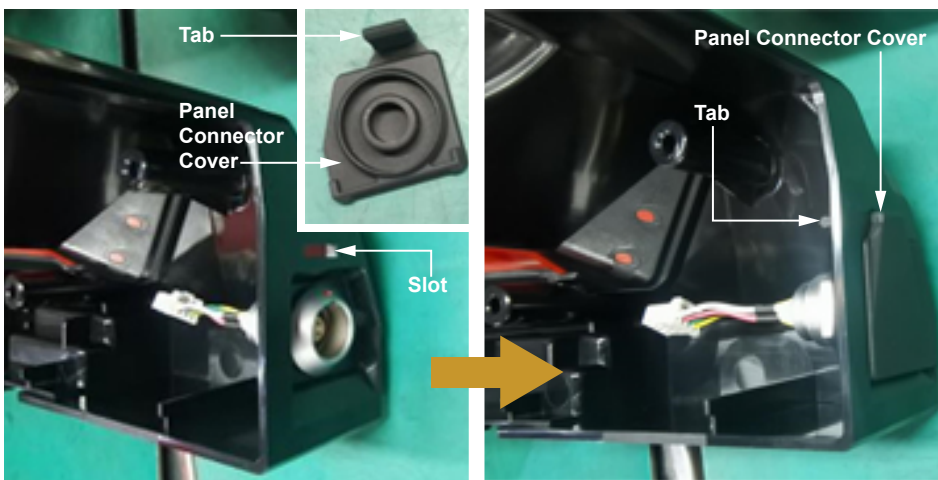




**NOTE:**

This illustration shows a torque wrench and service tool being utilized for production. **For service, a conventional wrench may be used.**

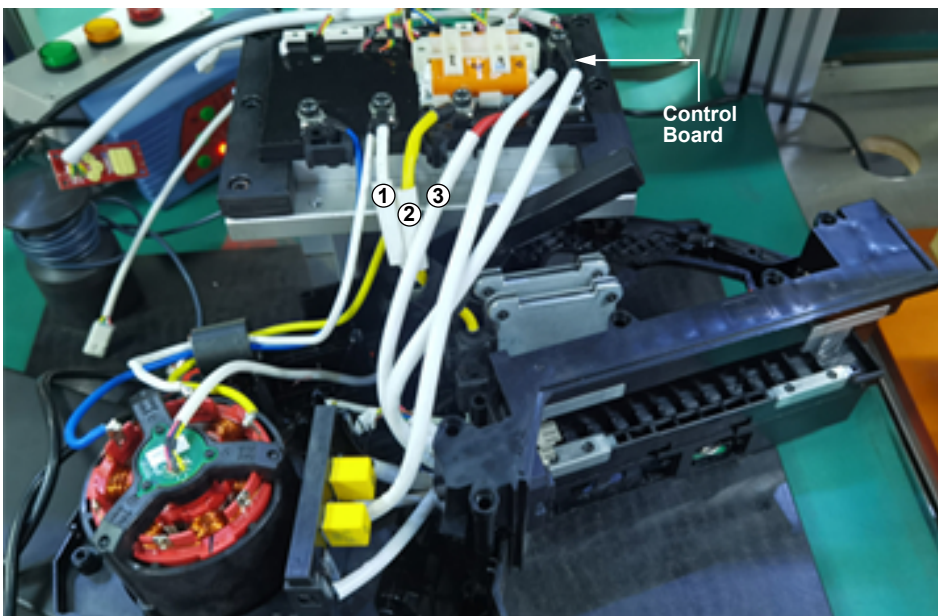
Place a drop of Red Loctite 277 on threads of panel connector. Use a wrench to secure the panel connector hex nut in place. Hand tighten clockwise until snug.



Install the panel connector cover onto the support housing by locating the tab on the top of the panel connector cover.

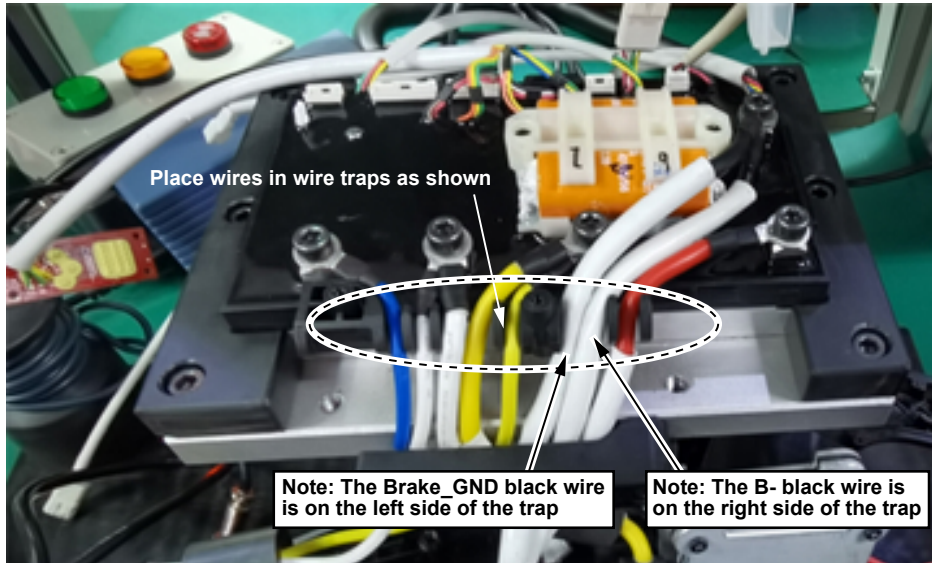
Insert the tab through the slot in the support housing. on the other side of the support housing, pull the tab by hand to assure the complete tab is through the slot.

Press the panel connector cover to the support housing to seal the opening that protects the panel connector.

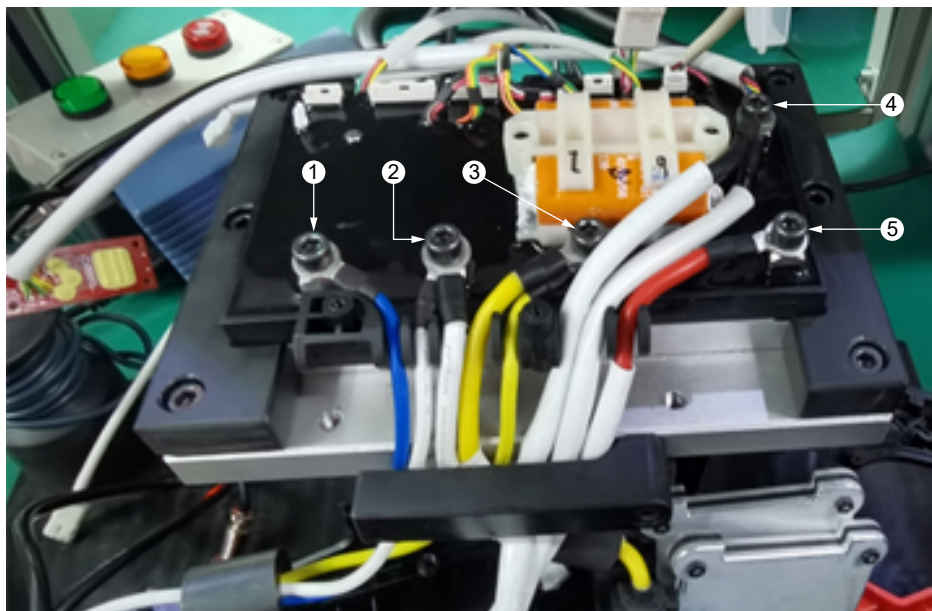


Insert the brake board with resistors in the tool and rest the control board near the tool. This must be done prior to any placement of the fiberglass sleeves.

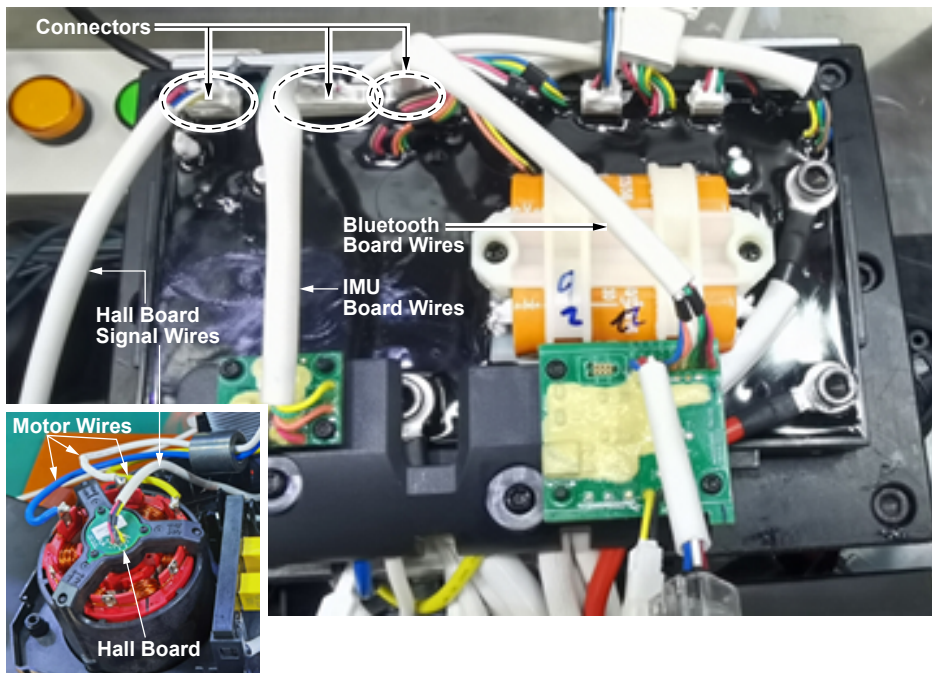
Pull the three fiberglass wire sleeves to keep them as far away from the control board as possible.



Route wires and place in wire traps as shown.



With wires placed down firmly in wire traps, secure by tightening screws.



Before connecting the hall board and other boards to the control board, the ring terminal cover needs to be screwed down and the Bluetooth Board and the IMU board need to be screwed to the ring terminal cover.

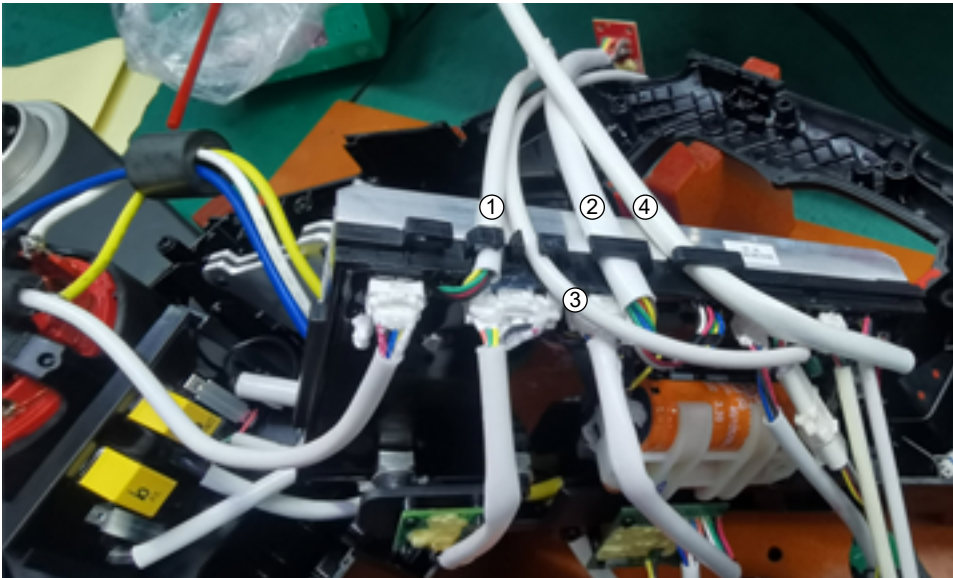
Apply electrical grease to hall board signal connector prior to attaching to control board. Be sure the hall board wires are routed below the three motor phase wires.

Apply electrical grease to IMU board connector prior to attaching to control board.

Apply electrical grease to bluetooth board connector prior to attaching to control board.

Before connecting the hall board and other boards to the control board, the ring terminal cover needs to be screwed down and the Bluetooth Board and the IMU board need to be screwed to the ring terminal cover.



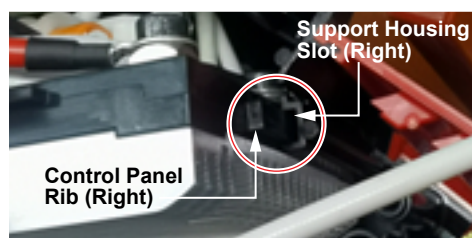
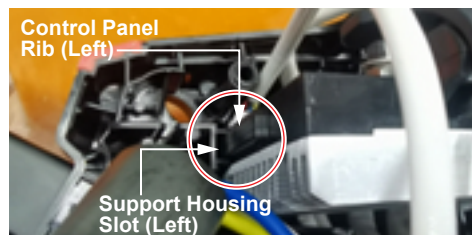
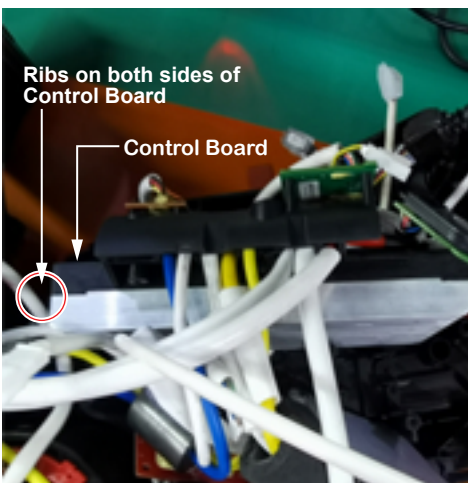


Route wires and place in wire traps as shown.

Note that the sleeved wires are routed downward towards the housing half and the phase wires go up.

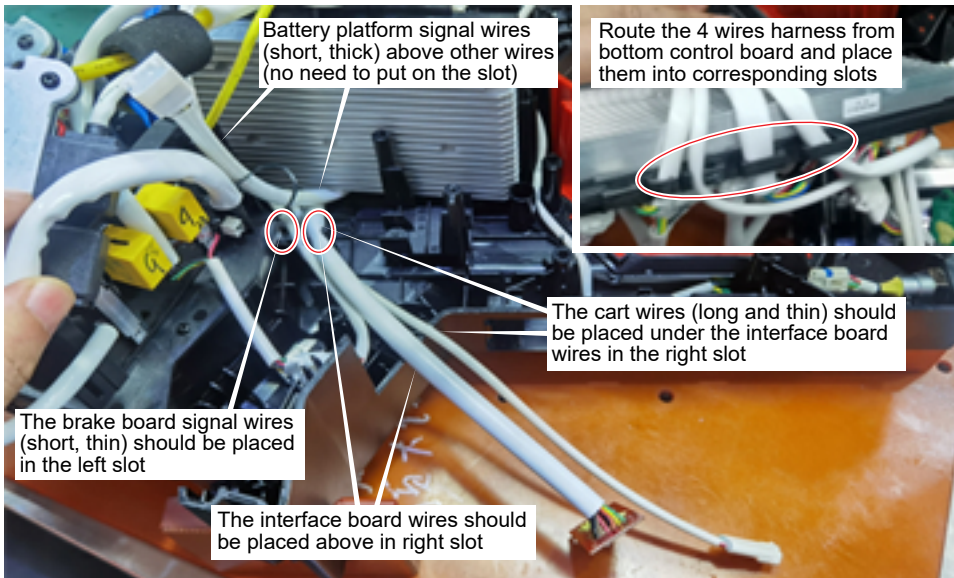


Press the four sleeved wires into slot with your hand.



Install the control board into the support housing by lining up the side ribs of the control board with the corresponding slots in the support housing. Insert the control board assembly firmly and squarely until it bottoms out.



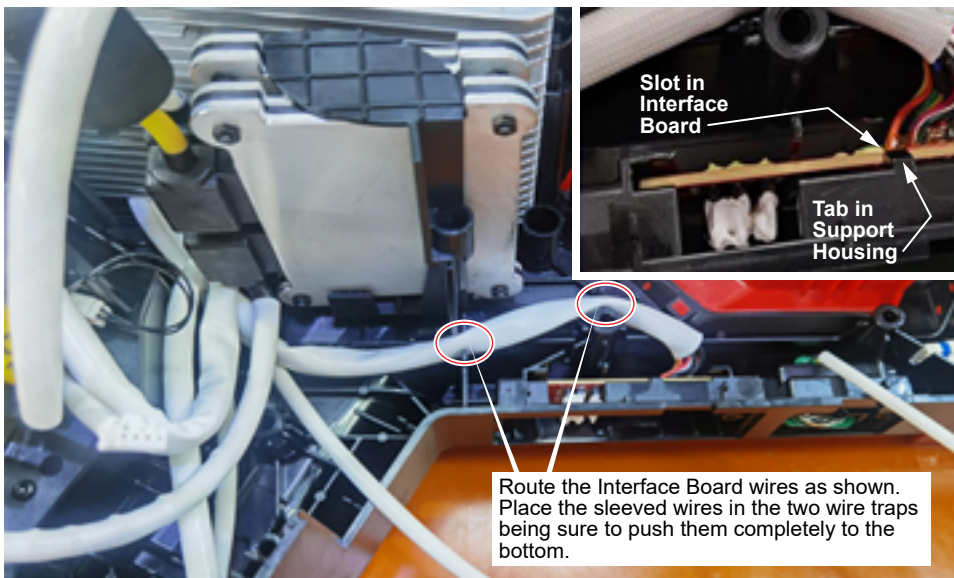


As shown in the illustrated detail, route the four wire assemblies from the bottom of the control board upward and into the wire traps as shown.

Place cart wire assembly in bottom of right wire trap.

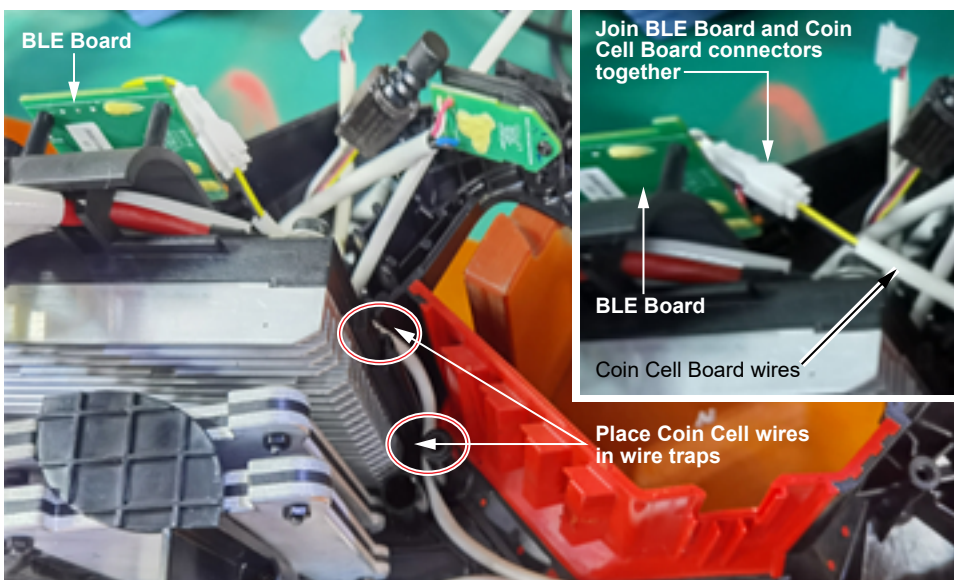
Place interface board wire assembly in right wire trap over the cart wire assembly. Press both wire assemblies down firmly in trap.

Route the brake board signal wire assembly in the left wire trap. Be sure to press wire assembly down firmly.



Install interface board onto the support housing as shown in detail. Slide interface board into cavity of support housing and secure by placing the slot in the board onto the tab in the support housing.

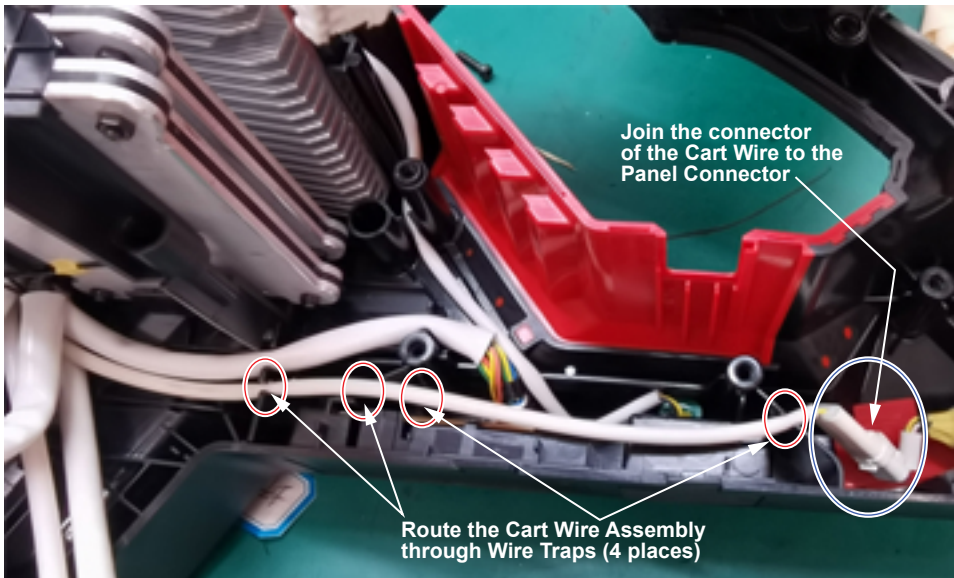
Route the interface board wires as shown, tucking the wire assembly into the wire traps of the support housing. Push wires completely down in traps.



Join together the connectors from the BLE board and the coin cell board. Prior to installation, apply electrical grease to the connectors.

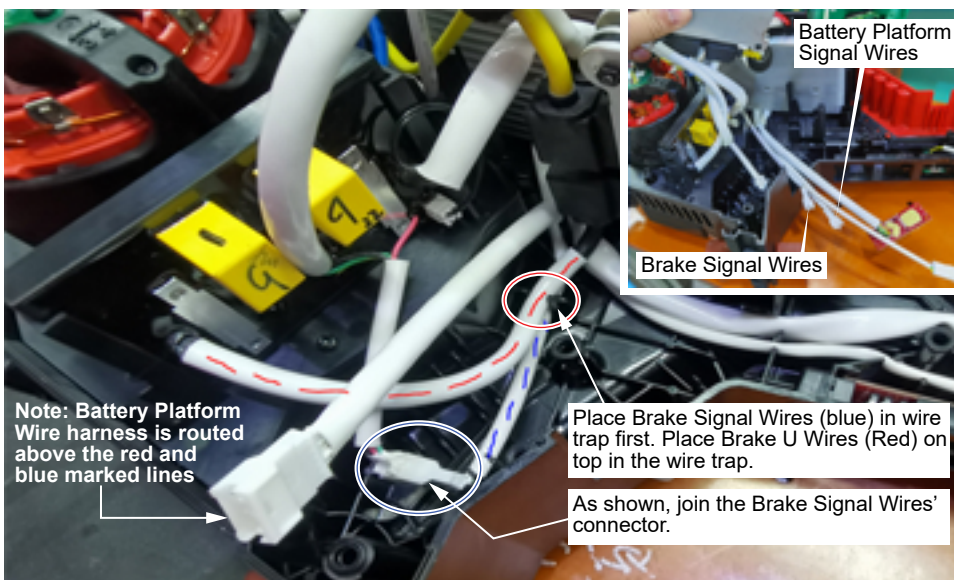
Route coin cell wires from the top and route downward. Place wires in traps while taking the slack from the wire assembly. This is done to allow the maximum amount of wire at the end for ease of coin cell replacement.





Route the sleeved cart wires as shown, being sure that the wires are placed in the four wire traps. Be sure the sleeved wires are pushed down as far as possible in each trap.

Join the connector of the cart wire assembly with the connector of the panel connector. Prior to installation, apply electrical grease to the connectors.

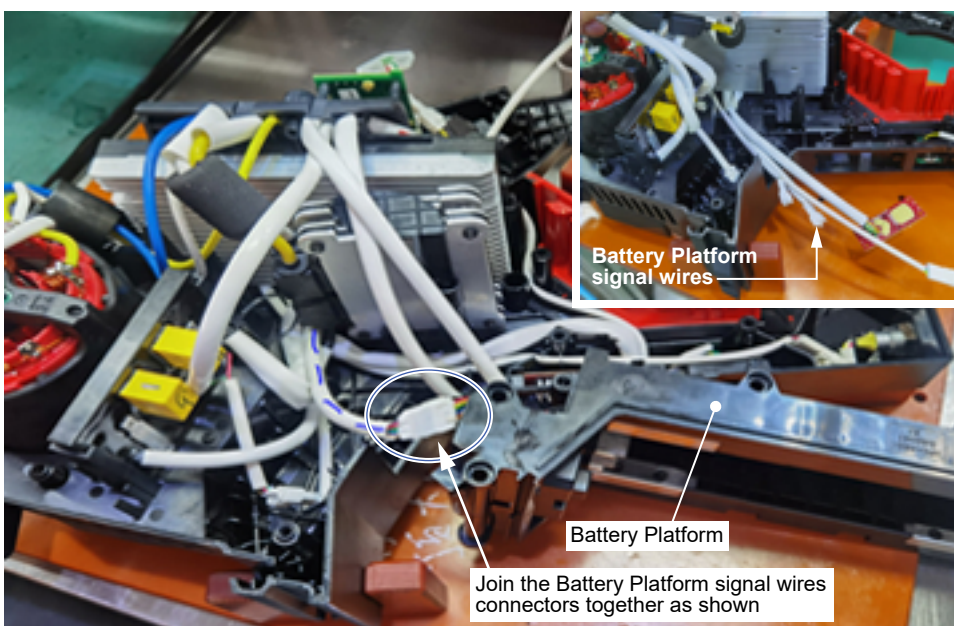


Place the sleeved brake signal wires (blue) in the bottom of the wire trap as shown.

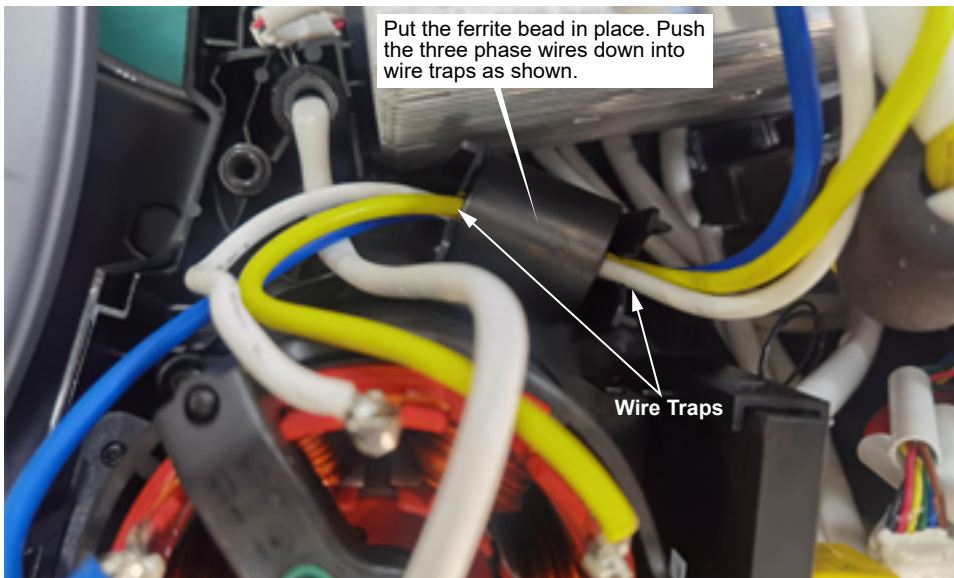
Place the sleeved brake U wires (red) in the wire trap on top.

Attach the brake signal wire connector as shown. Prior to joining, apply electrical grease to the connectors.

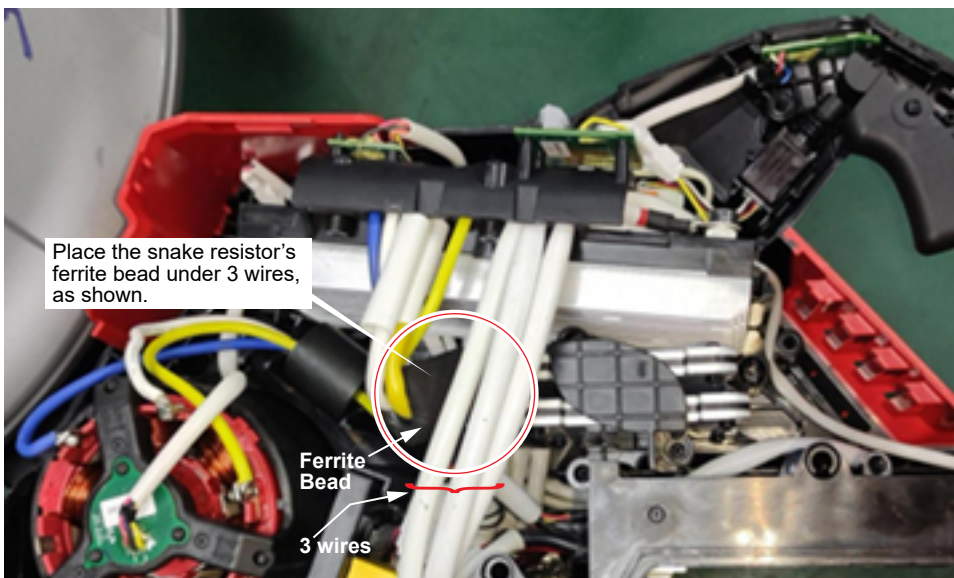
Be sure the battery platform signal wire harness is routed above the red and blue marked lines.



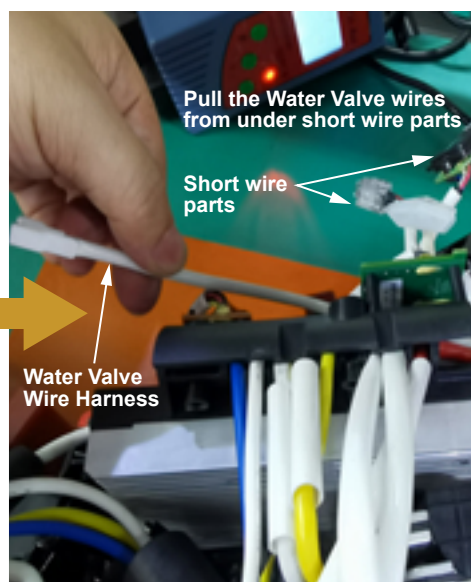
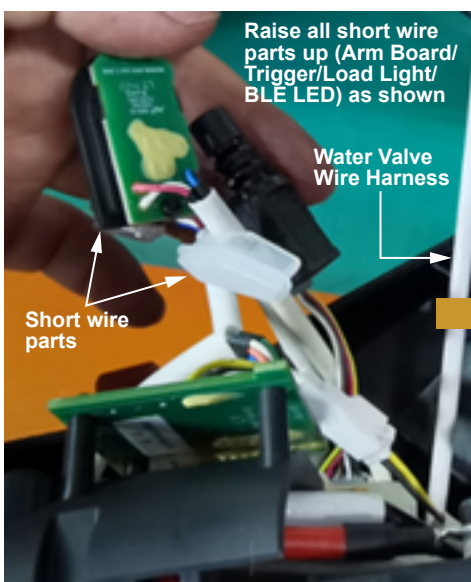
Attach the battery platform signal wire connector as shown. Prior to joining, apply electrical grease to the connectors.



Install ferrite bead into support housing cavity as shown. Secure the ferrite bead by pushing the corresponding blue, yellow and white motor phase wires down in the traps located on both sides of the cavity.



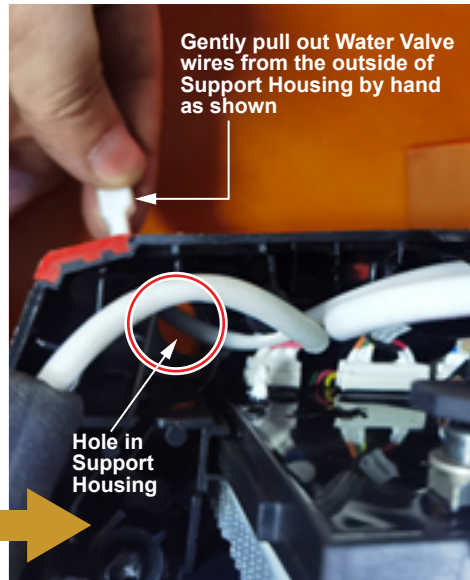
Tuck the snake resistor ferrite bead under the three sleeved wires as shown.



Raise all short wire parts upward (arm board assembly, trigger assembly, load light assembly and BLE LED).

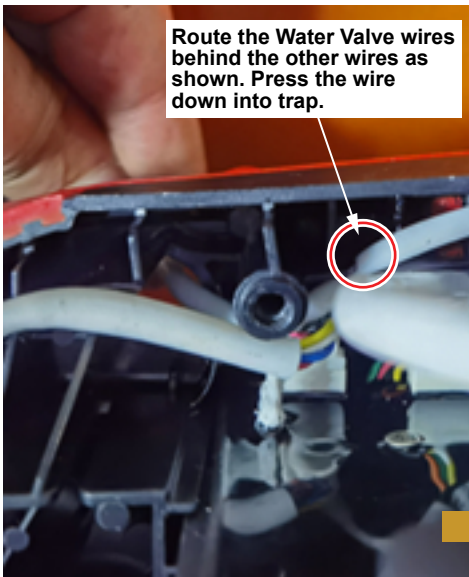
As shown, pull the water valve wires from under the short wire parts.



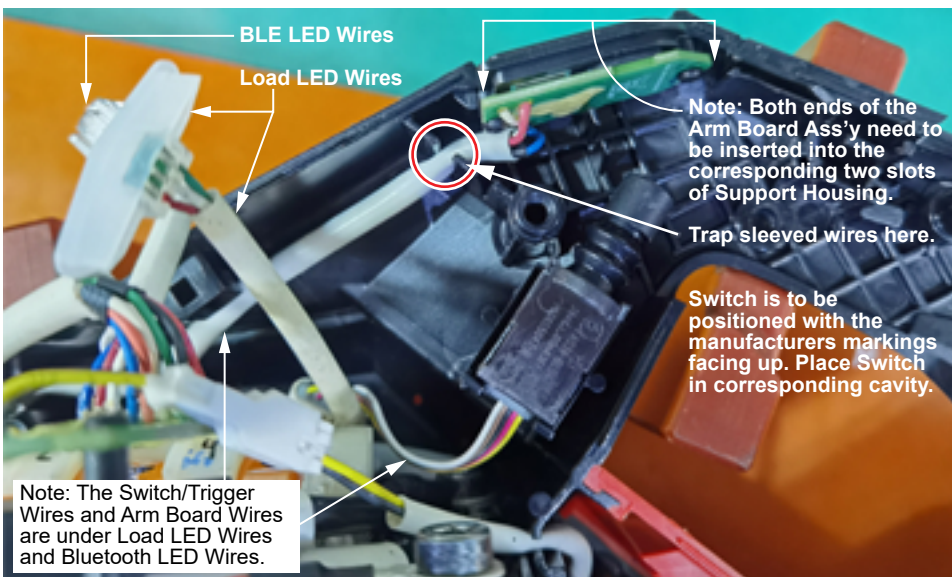


Route water valve wires and connector through the hole in the support housing.

From the outside of the support housing, gently pull the water valve connector and wires.



Route the water valve wires behind the other wires shown in the illustration. Place the wires in wire traps (3 total).

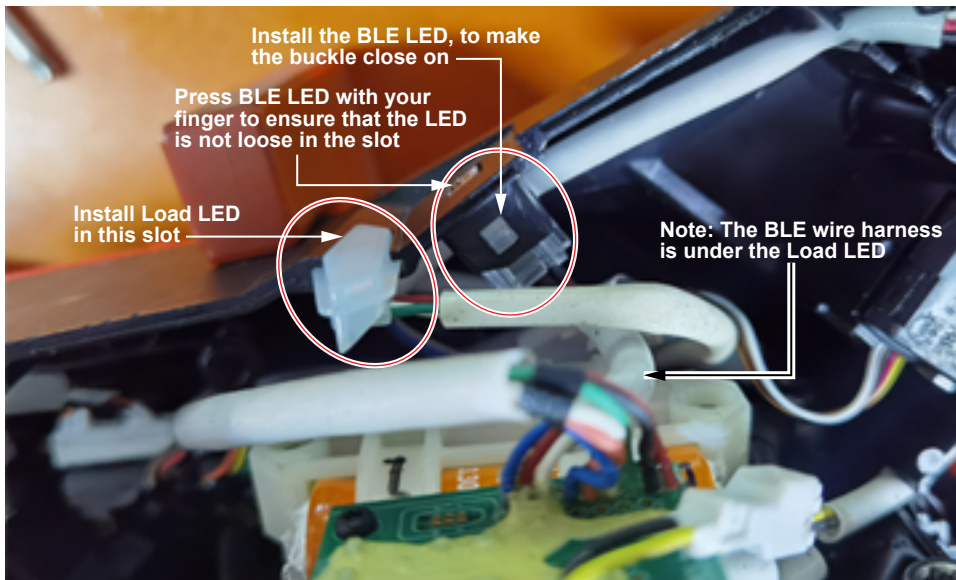


Carefully place arm board assembly into slot of support housing. Be sure both ends of the board are captured in the slots.

Place arm board wires into wire trap and route under the load LED wires and bluetooth LED wires.

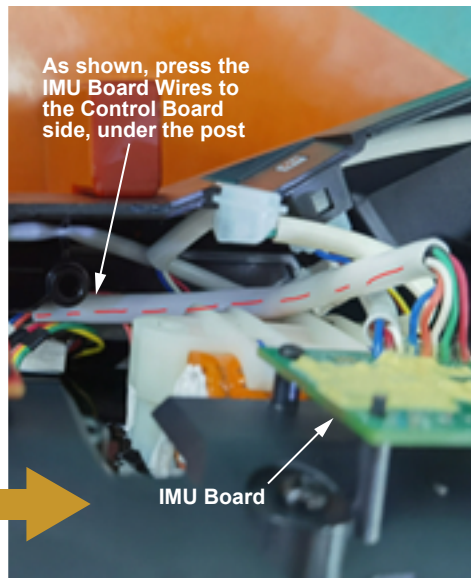
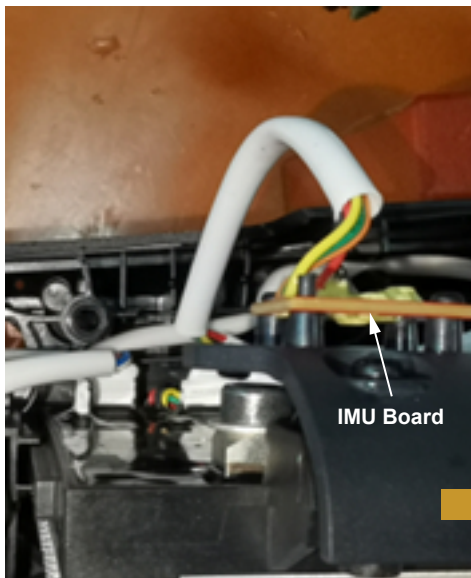
Note: The Switch wires are also positioned behind the load LED wires and bluetooth LED wires.

Position the switch body in the switch cavity with markings on switch facing upward.

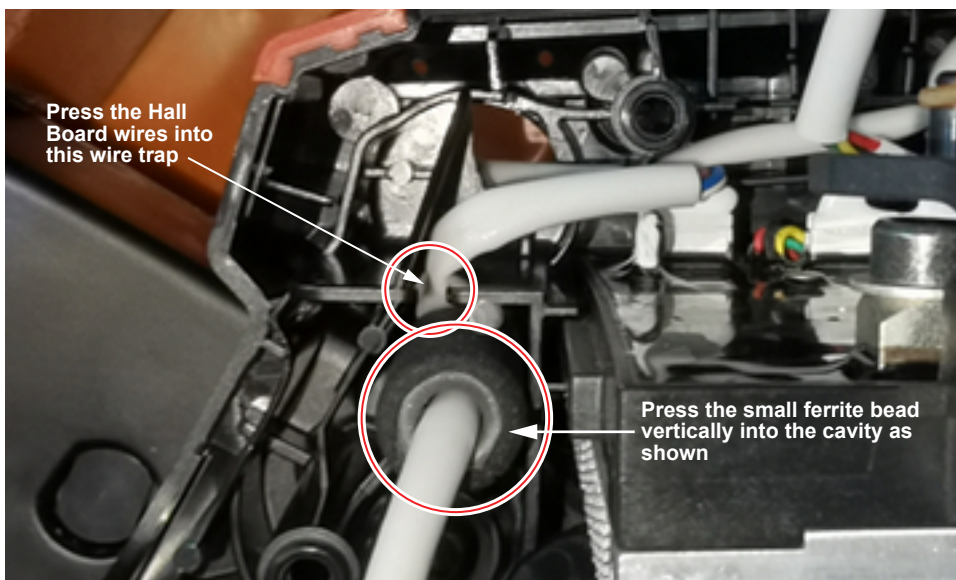


Route the BLE wire harness under the load LED and install the BLE LED as shown.

Install the load LED as shown.



Route the IMU board wires under the post in the support housing as illustrated.



Secure the sleeved hall board wires in wire trap of support housing.

Insert the small ferrite bead vertically into the cavity of the support housing.