

- Title** Torque Specifications for Electrical Connections
- Date** October 2019
- Scope** This bulletin applies to current Ionpure CEDI modules and power accessories.
- Purpose** Failure to properly tighten an electrical connection of a wire with a terminal strip or electrode post can result in a loose wire, which can lead to arcing, overheating of the electrical connection, and damage to the CEDI module or power supply as well as nearby equipment. This bulletin provides proper torque values for various electrical connections in Ionpure CEDI modules and power accessories.
- Tools:** Torque wrench or torque screwdriver in an appropriate range for the fastener being tightened.

Introduction

Overheating and damage has been observed at field wiring interface points due to insufficient tightening of the applicable connector. This can occur at any reversible (not soldered) wiring connection regardless of connection type. It is important to apply the recommended amount of tightening force to ensure secure connection of the wire while avoiding possible damage due to overtightening.

Terminals and Torque Values

The table below provides recommended torque values for the various wire connections in Ionpure CEDI modules and power accessories. This only covers customer-made (OEM) connections, not the Ionpure factory-made connections.

Electrical Connection	Torque value, US units	Torque value, SI units
VNX junction box terminal strip	14 lb _f -inch	1.6 N-m
LX module junction box terminal strip	7 lb _f -inch	0.8 N-m
MX module junction box electrode post	20 lb _f -inch	2.3 N-m
DCR 8-screw and 10-screw terminal strips	3 lb _f -inch	0.34 N-m
DCR AC in, DC out terminal strips	24 lb _f -inch	2.7 N-m
DC3 8-screw and 10-screw terminal strips	3 lb _f -inch	0.34 N-m
DC3 AC in, DC out terminal strips	24 lb _f -inch	2.7 N-m