

PowerFlex 755 AC Drives Floor Mount Frames 8 and Larger, Hardware Service Manual

Catalog Numbers 755, 20G, 21G



Important User Information

Read this document and the documents listed in the additional resources section about installation, configuration, and operation of this equipment before you install, configure, operate, or maintain this product. Users are required to familiarize themselves with installation and wiring instructions in addition to requirements of all applicable codes, laws, and standards.

Activities including installation, adjustments, putting into service, use, assembly, disassembly, and maintenance are required to be carried out by suitably trained personnel in accordance with applicable code of practice.

If this equipment is used in a manner not specified by the manufacturer, the protection provided by the equipment may be impaired.

In no event will Rockwell Automation, Inc. be responsible or liable for indirect or consequential damages resulting from the use or application of this equipment.

The examples and diagrams in this manual are included solely for illustrative purposes. Because of the many variables and requirements associated with any particular installation, Rockwell Automation, Inc. cannot assume responsibility or liability for actual use based on the examples and diagrams.

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Throughout this manual, when necessary, we use notes to make you aware of safety considerations.



WARNING: Identifies information about practices or circumstances that can cause an explosion in a hazardous environment, which may lead to personal injury or death, property damage, or economic loss.



ATTENTION: Identifies information about practices or circumstances that can lead to personal injury or death, property damage, or economic loss. Attentions help you identify a hazard, avoid a hazard, and recognize the consequence.

IMPORTANT Identifies information that is critical for successful application and understanding of the product.

Labels may also be on or inside the equipment to provide specific precautions.



SHOCK HAZARD: Labels may be on or inside the equipment, for example, a drive or motor, to alert people that dangerous voltage may be present.



BURN HAZARD: Labels may be on or inside the equipment, for example, a drive or motor, to alert people that surfaces may reach dangerous temperatures.



ARC FLASH HAZARD: Labels may be on or inside the equipment, for example, a motor control center, to alert people to potential Arc Flash. Arc Flash will cause severe injury or death. Wear proper Personal Protective Equipment (PPE). Follow ALL Regulatory requirements for safe work practices and for Personal Protective Equipment (PPE).

This manual revision contains the following new and updated information.

Topic	Page
All: Replaced spare parts link http://www.ab.com/support/abdrives/powerflex70/PF7ReleasedParts.pdf with PFLEX-SB002-EN-P .	
Chapter 2: Updated Recommended Preventive Maintenance : includes page number links to topics, consistent naming to topics, complete list of included items, and adjusted maintenance intervals were appropriate.	39
Chapter 3: Added Tip for Table 5 about IGBT readings.	52
Chapter 5: Added link to reference removal of Converter from the Inverter.	152
Chapter 6: Replaced image -- access panel has been removed.	222
Chapter 7: Added footnote to Table 13 about P6 connector access.	228
Chapter 7: Added IMPORTANT statement above Table 13 that IGBT replacement assemblies are not available.	228
Chapter 7: Removed Series A for the 20-750-I1B-xxxxxxx and the 20-750-I2B-xxxxxxx Invert Unit replacement kits in Table 13 .	228
Chapter 7: Replaced image -- access panel has been removed.	239
Chapter 7: Added IMPORTANT statement to Rating Plug / Removal Installation.	255
Chapter 7: Updated IMPORTANT statement to Inverter Backplane Circuit Board Removal / Installation.	265
Chapter 7: Replaced image -- access panel has been removed.	298
Chapter 8: Added IP54, NEMA 12 Cabinet Blower Assembly and Exhaust Hood Removal/Installation.	307
Chapter 8: Added link to reference install and removal of IP54, NEMA/UL Type 12 Cabinet Blower Exhaust	314

Notes:

	Preface	
	Who Should Use This Manual	21
	Additional Resources	21
	Chapter 1	
Before You Begin Tests, Maintenance, or Repairs	General Precautions	24
	Qualified Personnel	24
	Personal Safety	24
	Product Safety	24
	Class 1 Status Indicator Products	24
	Remove Power from the Drive	25
	Common DC Input Drives	27
	Drive Input Power Configurations	28
	Drive Series Components Compatibility	30
	Spare Part Compatibility with Series A and Series B Drives	30
	Firmware Revision Compatibility with Series A and B Circuit Boards	31
	Series A, B, and C Converter Components and Drive Input Power Compatibility	31
	Commonly Used Tools	32
	Service Tools	32
	Software Tools	32
	Fastener/Tool/Torque Information	33
	Fastener Torque Sequences	34
	Chapter 2	
Periodic Maintenance	Recommended Preventive Maintenance	37
	Schedule Codes Explanations	38
	Maintenance of Industrial Control Equipment	39
	Chapter 3	
Component Inspection and Test Procedures	Component Inspection and Maintenance	48
	Forward and Reverse Biased SCR/Diode Tests	49
	Converter Fuse Tests	53
	Converter Gate-lead Resistance Measurements	53
	DC Precharge Assembly Fuse Tests	55
	Chapter 4	
Control Pod Component Replacement Procedures	Control Pod Components Identification	57
	Control Pod Cover Removal/Installation	59
	Remove the Control Pod Cover	59
	Install the Control Pod Cover	59

Control Pod Cables Removal/Installation 60
 Remove the Control Pod Cables 60
 Install the Control Pod Cables 60
 Fiber-optic Cable Removal/Installation (Frame 8) 61
 Remove the Fiber-optic Cable (Frame 8) 61
 Install the Fiber-optic Cable (Frame 8) 64
 Main Control Board Removal/Installation 65
 Remove the Main Control Board
 (Control Pod in Drive Enclosure) 65
 Install the Main Control Board 68
 Control Pod Removal/Installation 68
 Remove the Control Pod 68
 Install the Control Pod 72
 Fiber Interface Board Removal/Installation 73
 Remove the Fiber Interface Board 73
 Install the Fiber Interface Board 79

Chapter 5

Converter Component Replacement Procedures

Converter Components Identification 82
 Converter Left Cover Removal/Installation 87
 Remove the Converter Left Cover 87
 Install the Converter Left Cover 87
 Converter Right Cover
 (No Control Pod) Removal/Installation 88
 Remove the Converter Right Cover (No Control Pod) 88
 Install the Converter Right Cover (No Control Pod) 88
 Control Pod Rotation 88
 Rotate the Control Pod Forward 88
 Return the Control Pod to the Service Position 91
 Control Transformer Primary Fuses Removal/Installation 91
 Remove the Control Transformer Primary Fuses (FU4 and FU5) 91
 Install the Control Transformer Primary Fuse (FU4 and FU5) ... 91
 Control Transformer Secondary Fuse Removal/Installation 92
 Remove the Control Transformer Secondary Fuse (FU6) 92
 Install the Control Transformer Secondary Fuse (FU6) 92
 Converter EMC Filter Circuit Board Removal/Installation 93
 Remove the Converter EMC Filter Circuit Board 93
 Install the Converter EMC Filter Circuit Board 94
 Converter Input Fuse Stirring Fan Removal/Installation 95
 Remove the Converter Input Fuse Stirring Fan 95
 Install the Converter Input Fuse Stirring Fan 97
 AC Line Fuse Sense Wire Harness Removal/Installation 97
 Remove the AC Line Fuse Sense Wire Harness 97
 Install the AC Line Fuse Sense Wire Harness 98
 AC Line Fuse Removal/Installation 99
 Remove the AC Line Fuses (FU1, FU2, and FU3) 99
 Install AC Line Fuse (FU1, FU2, and FU3) 101

DC Bus Sense Wire Harness Removal/Installation.....	101
Remove the DC Bus Sense Wire Harness.....	101
Install the DC Bus Sense Wire Harness	103
Converter Current Sensor Wire Harness Removal/Installation	103
Remove the Converter Current Sensor Wire Harness	103
Install the Converter Current Sensor Wire Harness	104
Converter Current Sensors Removal/Installation.....	105
Remove the Converter Current Sensors	105
Install the Converter Current Sensors.....	109
Converter SCR Gate Wire Harness Removal/Installation	109
Remove the Converter SCR Gate Wire Harness	109
Install the Converter SCR Gate Wire Harness	110
Converter SCR Assembly Removal/Installation	111
Remove the Converter SCR Assembly	111
Install the Converter SCR Assembly	120
Converter Heat Sink Gasket Replacement	120
Remove the Converter Heat Sink Gasket.....	120
Install the Converter Heat Sink Gasket.....	121
Inverter Power-supply Wire Harness Removal/Installation.....	121
Remove the Inverter Power-supply Wire Harness	121
Install the Inverter Power-supply Wire Harness.....	122
AC Line Wire Harness Removal/Installation.....	123
Remove the AC Line Wire Harness.....	123
Install the AC Line Wire Harness.....	124
Surge-suppressor Sense Wire Harness Removal/Installation	125
Remove the Surge-suppressor Sense Wire Harness	125
Install the Surge-suppressor Sense Wire Harness	125
Surge Suppressor Removal/Installation	126
Remove the Surge Suppressor.....	126
Install the Surge Suppressor	127
Surge Suppressor Assembly Removal/Installation.....	127
Remove the Surge Suppressor Assembly	127
Install the Surge Suppressor Assembly.....	130
Converter Gate Board Stirring Fan Removal/Installation.....	131
Remove the Converter Gate Board Stirring Fan	131
Install the Converter Gate Board Stirring Fan.....	132
24V/240V Power Wire Harness Removal/Installation	132
Remove the 24V/240V Power Wire Harness	132
Install the 24V/240V Power Wire Harness	137
Control-transformer Primary Wire Harness Removal/Installation ..	138
Remove the Control-transformer Primary Wire Harness	138
Install the Control-transformer Primary Wire Harness	140
Control Transformer Removal/Installation	140
Remove the Control Transformer	140
Install the Control Transformer	142

No DC Bus Fuse Wire Harness Removal/Installation
 (Frame 8 Drives Only) 143
 Remove the No DC Bus Fuse Wire Harness 143
 Install the No DC Bus Fuse Wire Harness 143
 DC Bus Fuse Wire Harness Removal/Installation
 (Frame 9 and Larger Drives Only) 144
 Remove the DC Bus Fuse Wire Harness..... 144
 Install the DC Bus Fuse Wire Harness..... 145
 Control Power Isolator Board 24V Wire Harness
 Removal/Installation (600/690V AC Input Drives Only) 146
 Remove the Control Power Isolator Board 24V Wire Harness... 146
 Install the Control Power Isolator Board 24V Wire Harness 147
 Control Power Isolator Board Removal/Installation
 (600/690V AC Input Drives Only) 148
 Remove the Control Power Isolator Board..... 148
 Install the Control Power Isolator Board 149
 Converter Gate Circuit Board Removal/Installation 149
 Remove the Converter Gate Circuit Board..... 149
 Install the Converter Gate Circuit Board 151
 Converter Removal/Installation 152
 Remove the Converter from the Inverter Assembly..... 152
 Install the Converter on the Inverter Assembly..... 155
 Converter Duct Gasket Replacement 155
 Remove the Converter Duct Gasket..... 155
 Install the Converter Duct Gasket 156

Chapter 6

**DC Input with Precharge Assembly
 Component Replacement Procedures**

DC Input with Precharge Assembly Components Identification 158
 DC Input with Precharge Assembly Left Cover, Top Guard, and
 Left Guard Removal/Installation 163
 Remove the DC Input with Precharge Assembly Left Cover,
 Top Guard, and Left Guard 163
 Install the DC Input with Precharge Assembly Left Cover,
 Top Guard, and Left Guard 163
 DC Input with Precharge Assembly Left Cover and
 Interlock Assembly Replacement 164
 Remove the DC Input with Precharge Assembly Left Cover,
 Top Guard, and Left Guard and Disconnect Handle..... 164
 Install the New Disconnect Switch Interlock and
 Front Cover Assemblies 166
 DC Input with Precharge Assembly Right Cover
 (No Control Pod) Removal/Installation 172
 Remove the DC Input with Precharge Assembly Right Cover
 (No Control Pod) 172
 Install the DC Input with Precharge Assembly Right Cover
 (No Control Pod) 172

Control Transformer Secondary Fuses Removal/Installation	172
Remove the Control Transformer Secondary Fuses (FU5 and FU6)	172
Install the Control Transformer Secondary Fuses (FU5 and FU6)	173
DC Bus Output/Sense Wire Harness Removal/Installation	174
Remove the DC Bus Output/Sense Wire Harness	174
Install the DC Bus Output/Sense Wire Harness	177
Precharge Resistor Assembly Removal/Installation	178
Remove the Precharge Resistor Assembly	178
Install the Precharge Resistor Assembly	179
Precharge Resistor Jumper Wires Removal/Installation	179
Remove the Precharge Resistor Jumper Wires	179
Install the Precharge Resistor Jumper Wires	179
DC Line Fuses and Fuse Indicators Removal/Installation	180
Remove the DC Line Fuses (FU1 and FU2) and Fuse Indicators (SW3 and SW4)	180
Install the DC Line Fuses (FU1 and FU2) and Fuse Indicators (SW3 and SW4)	181
Precharge Circuit Fuses Removal/Installation	182
Remove the Precharge Circuit Fuses (FU3 and FU4)	182
Install the Precharge Circuit Fuses (FU3 and FU4)	182
DC Bus Input Wire Harness Removal/Installation	183
Remove the DC Bus Input Wire Harness	183
Install the DC Bus Input Wire Harness	184
Left Wall Removal/Installation	184
Remove the Left Wall	184
Install the Left Wall	185
Molded Case Switch Wire Terminal Support Removal/Installation ..	186
Remove the Molded Case Switch Wire Terminal Support	186
Install the Molded Case Switch Wire Terminal Support	186
24V Control Wire Harness Removal/Installation	187
Remove the 24V Control Wire Harness	187
Install 24V Control Wire Harness	189
Molded-case Switch Control Wire Harness Removal/Installation ...	190
Remove the Molded-case Switch Control Wire Harness	190
Install the Molded-case Switch Control Wire Harness	192
Transformer Primary Wire Harness Removal/Installation	193
Remove the Transformer Primary Wire Harness	193
Installing the Transformer Primary Wire Harness	194
24V/120V/240V Wire Harness Removal/Installation	195
Remove the 24V/120V/240V Wire Harness	195
Install the 24V/120V/240V Wire Harness	200
Disconnect Switch Jumper Wires Removal/Installation	201
Remove the Disconnect Switch Jumper Wires	201
Install the Disconnect Switch Jumper Wires	202

Disconnect Switch (SW2), Auxiliary Contact, and Handle Shaft Removal/Installation	202
Remove the Disconnect Switch, Auxiliary Contact and Handle Shaft	202
Install the Disconnect Switch, Auxiliary Contact and Handle Shaft	203
Disconnect Switch Handle Removal/Installation	203
Remove the Disconnect Switch Handle.....	203
Install the Disconnect Switch Handle	203
Control Transformer Removal/Installation	204
Remove the Control Transformer.....	204
Install the Control Transformer	207
Control Power Isolator Board 24V Wire Harness Removal/Installation (810/932V DC Input Drives Only)	207
Remove the Control Power Isolator Board 24V Wire Harness...	207
Install the Control Power Isolator Board 24V Wire Harness	208
Control Power Isolator Board Removal/Installation (810/932V DC Input Drives Only).....	208
Remove the Control Power Isolator Board.....	208
Install the Control Power Isolator Board	209
Undervoltage Delay Bracket Removal/Installation	210
Remove the Undervoltage Delay Bracket	210
Install the Undervoltage Delay Bracket	212
Undervoltage Delay Wire Harness Removal/Installation	213
Remove the Undervoltage Delay Wire Harness.....	213
Install the Undervoltage Delay Wire Harness	213
Undervoltage Delay Removal/Installation	214
Remove the Undervoltage Delay	214
Install the Undervoltage Delay.....	215
DC Precharge Control Board Stirring Fan Removal/Installation	215
Remove the DC Precharge Control Board Stirring Fan	215
Install the DC Precharge Control Board Stirring Fan	216
Door-interlock Wire Harness Removal/Installation.....	216
Removing the Door Interlock Wire Harness	216
Install the Door Interlock Wire Harness.....	218
Digital I/O Wire Harness Removal/Installation	218
Remove the Digital I/O Wire Harness.....	218
Install the Digital I/O Wire Harness	219
DC Precharge Control Circuit Board Removal/Installation.....	220
Remove the DC Precharge Control Circuit Board.....	220
Install the DC Precharge Control Circuit Board	221
DC Input with Precharge Assembly Removal/Installation	222
Remove the DC Input with Precharge Assembly	222
Install the DC Input with Precharge Assembly	225
DC Input with Precharge Assembly Duct Gasket Replacement.....	225
Remove the DC Input with Precharge Assembly Duct Gasket ...	225
Install the DC Input with Precharge Assembly Duct Gasket.....	225

Inverter Component Replacement Procedures	Chapter 7	
	Inverter Components Identification	228
	Common-mode Core Assembly Removal/Installation	233
	Remove the Common Mode Core Assembly	233
	Install the Common Mode Core Assembly	233
	Internal Stirring Fan Tray Removal/Installation	234
	Remove the Internal Stirring Fan Tray	234
	Install the Internal Stirring Fan Tray	234
	Heatsink Fan Inlet Screen Removal/Installation	235
	Remove the Heatsink Fan Inlet Screen	235
	Install the Heatsink Fan Inlet Screen	235
	Heatsink Fan Assembly Removal/Installation	236
	Remove the Heatsink Fan Assembly	236
	Install the Heatsink Fan Assembly	237
	Inverter Circuit Board Connections Cover Removal/Installation	238
	Remove the Inverter Circuit Board Connections Cover	238
	Install the Inverter Circuit Board Connections Cover	238
	Inverter Front Cover Removal/Installation	239
	Remove the Inverter Front Cover	239
	Install the Inverter Front Cover	240
	Inverter Current Sensors Removal/Installation	240
	Remove the Inverter Current Sensors	240
	Install the Inverter Current Sensors	242
	Inverter Current Sensor Wire Harness Removal/Installation	243
	Remove the Inverter Current Sensor Wire Harness	243
	Install the Inverter Current Sensor Wire Harness	245
	Inverter Capacitor Bank Assembly Removal/Installation	246
	Remove the Inverter Capacitor Bank Assembly	246
	Install the Inverter Capacitor Bank	248
	Capacitor Balance Resistor Assembly Removal/Installation	248
	Remove the Capacitor Balance Resistor Assembly	248
	Install the Capacitor Balance Resistors	249
	IGBT Flexbus Bars Removal/Installation	250
	Remove the IGBT Flexbus Bars	250
	Install the IGBT Flexbus Bars	251
	Inverter Gate Board Connection Ribbon Cables Removal/Installation	251
	Remove the Inverter Gate Board Connection Ribbon Cables	251
	Install the Inverter Gate Board Connection Ribbon Cables	253
	Inverter Gate Circuit Board Removal/Installation	253
	Remove the Inverter Gate Circuit Board	253
	Install the Inverter Gate Circuit Board	254
	Rating Plug Removal/Installation	255
	Remove the Rating Plug	255
	Install the Rating Plug	256

Power Layer Interface Circuit Board Removal/Installation.....	256
Remove the Power-layer Interface Circuit Board	256
Install the Power-layer Interface Circuit Board	258
Power Supply Circuit Board Removal/Installation	258
Remove the Power Supply Circuit Board	258
Install the Power Supply Circuit Board	261
Power Control Circuit Board Removal/Installation	262
Remove the Power Control Circuit Board	262
Install the Power Control Circuit Board.....	264
Inverter Backplane Circuit Board Removal/Installation	265
Remove the Inverter Backplane Circuit Board.....	265
Install the Inverter Backplane Circuit Board	267
Inverter EMC Capacitor Removal/Installation (AC Input Drive Only)	268
Remove the Inverter EMC Capacitors (AC Input Drive Only) ..	268
Install the Inverter EMC Capacitors (AC Input Drive Only)....	271
Inverter Side DC Bus Bar Removal/Installation (AC Input Drive Only)	272
Remove the Inverter Side DC Bus Bars (AC Input Drive Only) .	272
Install the Inverter Side DC Bus Bars (AC Input Drive Only) ...	279
Inverter Top DC Bus Bar Removal/Installation (Common DC Input Drive Only)	280
Remove the Inverter Top DC Bus Bars (Common DC Input Drive Only)	280
Install the Inverter Top DC Bus Bars (Common DC Input Drive Only)	284
DC Choke Removal/Installation (AC Input Drives Only).....	285
Remove the DC Choke (AC Input Drives Only).....	285
Install the DC Choke (AC Input Drives Only).....	287
Inverter Wire Harness Removal/Installation.....	287
Remove the Inverter Wire Harness.....	287
Install the Inverter Wire Harness	290
Discharge Resistor Assembly Removal/Installation	291
Remove the Discharge Resistor Assembly	291
Install the Discharge Resistor Assembly.....	297
Inverter Heatsink Fan Inlet Bottom Cover Removal/Installation....	298
Remove the Inverter Heatsink Fan Inlet Bottom Cover.....	298
Install the Inverter Heatsink Fan Inlet Bottom Cover.....	298
Inlet Bottom Cover Gasket Replacement	299
Remove the Inlet Bottom Cover Gasket	299
Install the Inlet Bottom Cover Gasket.....	299

Chapter 8	
AC Input Drive Enclosure Component Replacement Procedures	AC Input Drive Enclosure Components Identification..... 302
	IP20, NEMA/UL Type 1 Debris Screen Removal/Installation..... 303
	Remove the Debris Screen..... 303
	Install the Debris Screen..... 303
	Exhaust Hood Removal/Installation..... 304
	Remove the Exhaust Hood..... 304
	Install the Exhaust Hood..... 304
	Top Conduit Plate Removal/Installation..... 305
	Remove the Top Conduit Plate..... 305
	Install the Top Conduit Plate..... 305
	IP20, NEMA/UL Type 1 Enclosure Door Fan Removal/Installation..... 306
	Remove the Enclosure Door Fan..... 306
	IP54, NEMA 12 Cabinet Blower Assembly and Exhaust Hood Removal/Installation..... 307
	Install the Enclosure Door Fan..... 308
	IP20, NEMA/UL Type 1 Enclosure Door Fan Harness Removal/Installation..... 309
	Remove the Enclosure Door Fan Wire Harness..... 309
	Install the Enclosure Door Fan Wire Harness..... 310
	IP54, NEMA/UL Type 12 Cabinet Blower Wire Harness Removal/Installation..... 310
	Remove the Cabinet Blower Wire Harness..... 310
	Install the Cabinet Blower Wire Harness..... 311
	IP54, NEMA/UL Type 12 Cabinet Blower Exhaust Filters Removal/Installation..... 312
	Remove the Cabinet Blower Exhaust Filters..... 312
	Install the Cabinet Blower Exhaust Filters..... 312
	IP20, NEMA/UL Type 1 Door Filter Removal/Installation..... 313
	Remove the IP20 Door Filter..... 313
	Install the Door Filter..... 313
	IP54, NEMA/UL Type 12 Cabinet Door Filters Removal/Installation..... 314
	Remove the Cabinet Door Filters..... 314
	Install the Cabinet Door Filters..... 315
	IP54, NEMA/UL Type 12 Cabinet-door Filter Cassette Removal/Installation..... 316
	Remove the Cabinet Door Filter Cassette..... 316
Install the Cabinet Door Filter Cassette..... 316	
IP54, NEMA/UL Type 12 Cabinet Door Gasket Removal/Installation..... 317	
Remove the Cabinet Door Gasket..... 317	
Install the Cabinet Door Gasket..... 317	

DC Bus Fuse Wire Harness Removal/Installation (Frame 9 and Larger Drives Only)	318
Remove the DC Bus Fuse Wire Harness.....	318
Install the DC Bus Fuse Wire Harness.....	319
DC Bus Fuses and Fuse Indicators Removal/Installation (Frame 9 and Larger Drives Only)	320
Remove the DC Bus Fuses and Fuse Indicators.....	320
Install the DC Bus Fuses and Fuse Indicators.....	322
Input Common-mode Core Removal/Installation (Frame 9 and Larger, Common DC Input Drives Only)	323
Remove the Input Common Mode Core	323
Install the Input Common Mode Core	325
Cabinet L Bus Bars Removal/Installation.....	326
Remove the Cabinet L Bus Bars.....	326
Install the Cabinet L Bus Bars.....	327
Cabinet Door EMC Shield Removal/Installation (Frame 10 Drives Only).....	327
Remove the Cabinet Door EMC Shield	327
Install the Cabinet Door EMC Shield	329

Chapter 9

Common DC Input Drive Enclosure Component Replacement Procedures

Common DC Input Drive Enclosure Components Identification ...	332
Enclosure Door Fan Removal/Installation.....	333
Remove the Enclosure Door Fan.....	333
Install the Enclosure Door Fan.....	334
Enclosure Door Fan Wire Harness Removal/Installation	334
Remove the Enclosure Door Fan Wire Harness	334
Install the Enclosure Door Fan Wire Harness	336
DC Back Bus Guards Removal/Installation.....	336
Remove the DC Back Bus Guards.....	336
Install the DC Back Bus Guards.....	337
120/240V Control Power Input Wire Harness Removal/Installation	338
Remove the 120/240V Control Power Input Wire Harness	338
Install the 120/240V Control Power Input Wire Harness.....	339
120/240V Control Power Output Wire Harness Removal/Installation	339
Remove the 120/240V Control Power Output Wire Harness ...	339
Install the 120/240V Control Power Output Wire Harness....	340
120/240V Circuit Breaker Removal/Installation.....	340
Remove the 120/240V Circuit Breaker.....	340
Install the 120/240V Circuit Breaker.....	341
120V UPS Power Input Wire Harness Removal/Installation.....	342
Remove the 120V UPS Power Input Wire Harness.....	342
Install the 120V UPS Power Input Wire Harness.....	343

Option-bay Enclosure Component Replacement Procedures

Input Common-mode Core Removal/Installation (Common DC Input Drives)	343
Remove the Input Common Mode Core	343
Install the Input Common Mode Core.....	344
Chapter 10	
Option-bay Enclosure Components Identification.....	346
Frame 8 Circuit Breaker Disconnect Handle Panel Removal/Installation.....	348
Remove the Frame 8 Circuit Breaker Disconnect Handle Panel .	348
Install the Frame 8 Circuit Breaker Disconnect Handle Panel ...	350
IP20, NEMA/UL Type 1 Door Fan Removal/Installation (Frame 8 Only).....	351
Remove the IP20, NEMA/UL Type 1 Door Fan (Frame 8 Only)	351
Install the IP20, NEMA/UL Type 1 Door Fan (Frame 8 Only) .	352
IP20, NEMA/UL Type 1 Door Fan Harness Removal/Installation (Frame 8 Only).....	353
Remove the IP20, NEMA/UL Type 1 Door Fan Harness (Frame 8).....	353
Install the IP20, NEMA/UL Type 1 Door Fan Harness (Frame 8 Only).....	354
IP54, NEMA/UL Type 12 Cabinet Exhaust Blower Filter Removal/Installation.....	355
Remove the IP54, NEMA/UL Type 12 Cabinet Exhaust Blower Filter	355
Install the IP54, NEMA/UL Type 12 Cabinet Exhaust Blower Filter	355
IP54, NEMA/UL Type 12 Cabinet Door-inlet Filters Removal/Installation.....	355
IP54, NEMA/UL Type 12 Cabinet Door-inlet Filter Cassette Removal/Installation.....	355
IP54, NEMA/UL Type 12 Cabinet Door Gasket Removal/Installation.....	356
Frame 8 Option Bay Guard Removal/Installation.....	356
Remove the Frame 8 Option Bay Guard.....	356
Install the Frame 8 Option Bay Guard.....	356
Frame 9 Series B Option Bay Guards Removal/Installation	357
Remove the Frame 9 Series B Option Bay Guards	357
Install the Frame 9 Series B Option Bay Guards	358
Frame 9 Series C Option Bay Guards Removal/Installation.....	359
Remove the Frame 9 Series C Option Bay Guards.....	359
Install the Frame 9 Series C Option Bay Guards.....	360
Control Transformer Fuses Removal/Installation.....	361
Remove the Control Transformer Fuses.....	361
Install the Control Transformer Fuses	361

Frame 8 IP54, NEMA/UL Type 12 Cabinet Blower Assembly	
Removal/Installation	362
Remove the Frame 8 IP54, NEMA/UL Type 12	
Cabinet Blower Assembly	362
Install the Frame 8 IP54, NEMA/UL Type 12	
Cabinet Blower Assembly	362
Frame 8 IP54, NEMA/UL Type 12 Cabinet Blower Wire Harness	
Removal/Installation	363
Remove the Frame 8 IP54, NEMA/UL Type 12	
Cabinet Blower Wire Harness	363
Install the Frame 8 IP54, NEMA/UL Type 12	
Cabinet Blower Wire Harness	364
Frame 8 Control Transformer Removal/Installation	364
Remove the Frame 8 Control Transformer	364
Install the Frame 8 Control Transformer	366
Frame 8 Control Transformer Wire Harness Removal/Installation..	366
Remove the Frame 8 Control Transformer Wire Harness	366
Install the Frame 8 Control Transformer Wire Harness.....	370
Frame 8 Contactor Wire Harness Removal/Installation	371
Remove the Frame 8 Contactor Wire Harness	371
Install the Frame 8 Contactor Wire Harness	372
Frame 8 Thermostat and Wire Harness Removal/Installation.....	372
Remove the Frame 8 Thermostat and Wire Harness	372
Install the Frame 8 Thermostat and Wire Harness.....	373
Frame 9 Cabinet Blower Assembly Removal/Installation	374
Remove the Frame 9 Cabinet Blower Assembly	374
Install the Frame 9 Cabinet Blower Assembly	374
Frame 9 Cabinet Blower Wire Harness Removal/Installation	375
Remove the Frame 9 Cabinet Blower Wire Harness	375
Install the Frame 9 Cabinet Blower Wire Harness	376
Frame 9 Circuit Breaker Disconnect Handle Panel (Series A)	
Removal/Installation	377
Remove the Frame 9 Circuit Breaker Disconnect Handle Panel	
(Series A)	377
Install the Frame 9 Circuit Breaker Disconnect Handle Panel	
(Series A)	378
Frame 9 Thermostat and Wire Harness Removal/Installation.....	378
Remove the Frame 9 Thermostat and Wire Harness	378
Install the Frame 9 Thermostat and Wire Harness.....	379
Frame 9 Control Transformer Removal/Installation	380
Remove the Frame 9 Control Transformer	380
Install the Frame 9 Control Transformer	381
Frame 9 Main Control-panel Wire Harness Removal/Installation...	381
Remove the Frame 9 Main Control-panel Wire Harness	381
Install the Frame 9 Main Control-panel Wire Harness.....	385

Frame 9 Reactor Fan Tray Removal/Installation	386
Remove the Frame 9 Reactor Fan Tray	386
Install the Frame 9 Reactor Fan Tray	387
Frame 9 Reactor Fan Tray Wire Harness Removal/Installation	387
Remove the Frame 9 Reactor Fan Tray Wire Harness	387
Install the Frame 9 Reactor Fan Tray Wire Harness	388
Frame 9 Reactor Fans Wire Harness Removal/Installation	389
Remove the Frame 9 Reactor Fans Wire Harness	389
Install the Frame 9 Reactor Fans Wire Harness	391
Frame 9 Cabinet Blower Relay Removal/Installation	391
Remove the Frame 9 Cabinet Blower Relay	391
Install the Frame 9 Cabinet Blower Relay	391
Frame 9 Control Panel Thermostat Harness Removal/Installation ..	392
Remove the Frame 9 Control-panel Thermostat Wire Harness ..	392
Install the Frame 9 Control-panel Thermostat Wire Harness ...	393
Top Conduit Plate Removal/Installation	394
Remove the Top Conduit Plate	394
Install the Top Conduit Plate	394
Bottom Conduit Plate Removal/Installation	395
Remove the Bottom Conduit Plate	395
Install the Bottom Conduit Plate	395

Chapter 11

Enclosure Cable Components Replacement Procedures (Frame 9 and Larger Drives)

Enclosure Cable Components and Part Numbers	397
24V Wire Harness Removal/Installation (Frame 9 and Larger Drives)	398
Removing the 24V Wire Harness (Frame 9 and Larger Drives) ..	398
Installing the 24V Wire Harness (Frame 9 and Larger Drives) ...	402
First Inverter (INV1) Fiber-optic Cable Removal/Installation	403
Removing the First Inverter (INV1) Fiber-optic Cable	403
Installing the First Inverter (INV1) Fiber-optic Cable	406
Second Inverter (INV2) Fiber-optic Cable Removal/Installation ...	407
Removing the Second Inverter (INV2) Fiber-optic Cable	407
Installing the Second Inverter (INV2) Fiber-optic Cable	411
Third Inverter (INV3) Fiber-optic Cable Removal/Installation	412
Removing the Third Inverter (INV3) Fiber-optic Cable	412
Installing the Third Inverter (INV3) Fiber-optic Cable	416
Fiber-optic Spool Removal/Installation	416
Removing the Fiber-optic Spool	416
Installing the Fiber-optic Spool	418

Chapter 12

Drive Startup after Repairs

Before You Apply Power to the Drive	419
Testing with the Motor without a Mechanical Load	421

Schematics

Appendix A

Frame 8 AC Input Drive Schematic Diagram
(400VAC and 600VAC Classes) 424

Frame 9 AC Input Drive Schematic Diagram
(400VAC and 600VAC Classes) 425

Frame 10 AC Input Drive Schematic Diagram
(400VAC and 600VAC Classes) 426

Frame 8 Common DC Input Drive Schematic Diagram
(540V DC, 650V DC, 810V DC, and 932V DC Classes) 427

Frame 9 Common DC Input Drive Schematic Diagram
(540V DC, 650V DC, 810V DC, and 932V DC Classes) 428

Frame 10 Common DC Input Drive Schematic Diagram
(540V DC, 650V DC, 810V DC, and 932V DC Classes) 429

Frame 8 AC Input IP20 Option Bay without a Control Transformer
Schematic Diagram 430

Frame 8 AC Input IP20 Option Bay with a Control Transformer
Schematic Diagram 431

Frame 8 AC Input IP54 Option Bay Schematic Diagram 432

Frame 9 AC Input Option Bay Schematic Diagram 433

Control Pod Schematic Diagram 434

Converter Schematic Diagram (400VAC and 600VAC
Classes AC Input Drive) 435

Frame 8 Control Power Isolator Board Wiring Diagrams
(600V AC Class AC Input Drive, and 810V DC and 932V DC Classes
Common DC Input Drive) 436

Frame 9 Control Power Isolator Board Wiring Diagrams
(600V AC Class AC Input Drive, and 810V DC and 932V DC Classes
Common DC Input Drive) 436

Frame 10 Control Power Isolator Board Wiring Diagrams
(600V AC Class AC Input Drive, and 810V DC and 932V DC Classes
Common DC Input Drive) 437

DC Input with Precharge Assembly Schematic Diagram
(540V DC, 650V DC, 810V DC, and 932V DC Classes
Common DC Input Drives) 438

DC Input with Precharge Devices Schematic Diagrams 439

Inverter Circuit Board Schematic Diagram
(All Drive Configurations) 440

Inverter Power Layer Schematic Diagram
(All Drive Configurations) 441

AC Input Drive Control Transformer Schematic Diagram 442

DC Input with Precharge Assembly Control Transformer
Schematic Diagram 442

Inverter Main Blower and Capacitor Bank Cooling Fan
Wire Harness Diagram 443

Cabinet Cooling Wiring Diagrams 443

Circuit Board Interconnections	Appendix B
	Inverter Board Interconnections Diagram 1 446
	Inverter Board Interconnections Diagram 2 447
	Control Board Interconnections Diagram 1 448
	Control Board Interconnections Diagram 2 449
Drive-compatible Circuit Breakers, Molded Case Switches, Contactors, and Line Reactors	Appendix C
History of Changes	Replacement Part Catalog Numbers, Ratings, and Settings..... 451
	Appendix D
	750-TG001F-EN-P, December 2017 465
	750-TG001E-EN-P, July 2012 465
	750-TG001D-EN-P, April 2012 466
	750-TG001C-EN-P, January 2012 467
	750-TG001B-EN-P, October 2011..... 467
	Index
	Index.....469

Notes:

This manual provides a recommended preventive maintenance schedule, major component test and hardware replacement procedures, and schematic diagrams for floor mount frame 8 and larger PowerFlex® 750-Series AC drives. See Drive Input Power Configurations on page 28 for information on drive input power configurations and frame sizes.

It is highly recommended that you obtain a copy of the PowerFlex 750-Series AC Drives Programming Manual, publication 750-PM001. This publication contains fault, alarm, and programming information that can help you troubleshoot drive errors and determine if repairs are necessary.

Who Should Use This Manual

This manual is intended for qualified service personnel responsible for frame 8 and larger PowerFlex 750-Series AC drive repairs. You must have previous experience with, and an understanding of, electrical terminology, procedures, required equipment, equipment protection procedures and methods, and safety precautions. See safety-related practices that are contained in publication NFPA 70E, Standard for Electrical Safety in the Work Place.

Additional Resources

Additional drive services and software/firmware support information are available on the Allen-Bradley Drives Service and Support website: <http://www.ab.com/support/abdrives/>.

See PowerFlex Architecture Class Low Voltage Drives Spare Parts Options, publication PFLEX-SB002 for a complete list of spare parts for PowerFlex 755 floor mount frame 8 and larger drives.

The following table lists publications that provide general drive-related information.

Resource	Description
Wiring and Grounding Guidelines for Pulse Width Modulated (PWM) AC Drives, publication DRIVES-IN001	Provides basic information that is required to properly wire and ground PWM AC drives.
Safety Guidelines for the Application, Installation, and Maintenance of Solid-State Control, publication SGI-1.1	Provides general guidelines for the application, installation, and maintenance of solid-state control.
Guarding Against Electrostatic Damage, publication 8000-4.5.2	Provides practices for guarding against Electrostatic damage (ESD)
Product Certifications that are provided on the Allen-Bradley website: http://ab.rockwellautomation.com/	Provides declarations of conformity, certificates, and other certification details.

The following table lists publications that provide information about PowerFlex 750-Series drives.

Resource	Description
PowerFlex 750-Series AC Drives Programming Manual, publication 750-PM001	Provides information that is required to start-up, program, and troubleshoot PowerFlex 750-Series AC drives.
PowerFlex 755 Drive Embedded EtherNet/IP Adapter User Manual, publication 750COM-UM001	Provides information on how to install, configure, and troubleshoot the Embedded EtherNet/IP Adapter for PowerFlex 755 AC drives.
Safe Speed Monitor Option Module for PowerFlex 750-Series AC Drives Safety Reference Manual, publication 750-RM001	Describes how to use PowerFlex 750-Series AC drives in Safety Integrity Level (SIL) CL3, Performance Level [PL(e)], or Category (CAT) 4 applications. This manual provides information on how to install, configure, and troubleshoot the PowerFlex Safe Speed Monitor Option module.
PowerFlex 750-Series AC Drives Technical Data, publication 750-TD001	Provides information on product features and benefits, options, and technical specifications information.
PowerFlex 750-Series AC Drives Installation Instructions, publication 750-IN001	Explains the basic steps for mechanical installation, and provides instructions on how to connect incoming power, the motor, and basic I/O to the PowerFlex 750-Series Adjustable Frequency AC drive.
PowerFlex 755 IP00, NEMA/UL Open Type Drive Frames 8-10 Installation Instructions, publication 750-IN020	This document provides instructions for the installation of an IP00, Open Type PowerFlex 755 drive (Frames 8...10) in a user supplied enclosure. The information provided in this publication supplements the PowerFlex 750-Series AC Drives Installation Instructions, publication 750-IN001, and is intended for qualified drive service personnel only.
PowerFlex 750-Series AC Drives Hardware Service Manual – Frame 8 and Larger, publication 750-TG001	Provides a recommended preventative maintenance schedule, major component test and hardware replacement procedures, and schematic diagrams for floor mount frame 8 and larger PowerFlex 750-Series AC drives.
PowerFlex 750-Series Service Cart High-power Conversion Kit, publication 750-IN017	Provides instructions to convert the multi-drive 750-Series Service Cart to a high-power (frame 8...10) service cart.
PowerFlex 750-Series Spare Parts Installation Instructions, publication 750-IN013	Provides additional information to acquire spare parts for the PowerFlex 750-Series.
PowerFlex Architecture Class Low Voltage Drives Spare Parts Options, publication PFLEX-SB002	Includes spare part lists and part numbers for PowerFlex low voltage drives.

You can view or download publications at <http://www.rockwellautomation.com/literature/>. To order paper copies of technical documentation, contact your local Rockwell Automation distributor or sales representative.

Before You Begin Tests, Maintenance, or Repairs

Topic	Page
General Precautions	24
Remove Power from the Drive	25
Drive Input Power Configurations	28
Drive Series Components Compatibility	30
Commonly Used Tools	32
Fastener/Tool/Torque Information	33
Fastener Torque Sequences	34

Read the information in this chapter before you begin tests, maintenance, or repairs on drive components.

General Precautions

Read the following precautions before you begin to test components, perform maintenance, or repair the drive.

Qualified Personnel



ATTENTION: Only qualified personnel familiar with adjustable frequency AC drives and associated machinery should plan or implement the installation, startup, and subsequent maintenance of the system. Failure to comply can result in personal injury and/or equipment damage.

Personal Safety



ATTENTION: To avoid an electric shock hazard, verify that the voltage on the bus capacitors has discharged completely before servicing. Measure the DC bus voltage at the -DC and +DC TESTPOINT sockets on the front of the power module (see Remove Power from the Drive on page 25 for location).



ATTENTION: Potentially fatal voltages can result from improper usage of an oscilloscope and other test equipment. The oscilloscope chassis can be at a potentially fatal voltage if not properly grounded. If an oscilloscope is used to measure high-voltage waveforms, use only a dual channel oscilloscope in the differential mode with X 100 probes. It is recommended that the oscilloscope is used in the A minus B Quasi-differential mode with the chassis of the oscilloscope that is correctly grounded to an earth ground.

Product Safety



ATTENTION: This drive contains ESD (Electrostatic Discharge) sensitive parts and assemblies. Static control precautions are required when installing, testing, servicing, or repairing this assembly. Component damage can result if ESD control procedures are not followed. If you are not familiar with static control procedures, reference Guarding Against Electrostatic Damage, publication 8000-4.5.2 or any other applicable ESD protection handbook.

Class 1 Status Indicator Products



ATTENTION: Hazard of permanent eye damage exists when using optical transmission equipment. This product emits intense light and invisible radiation. Do not look into module ports or fiber-optic cable connectors.

Remove Power from the Drive



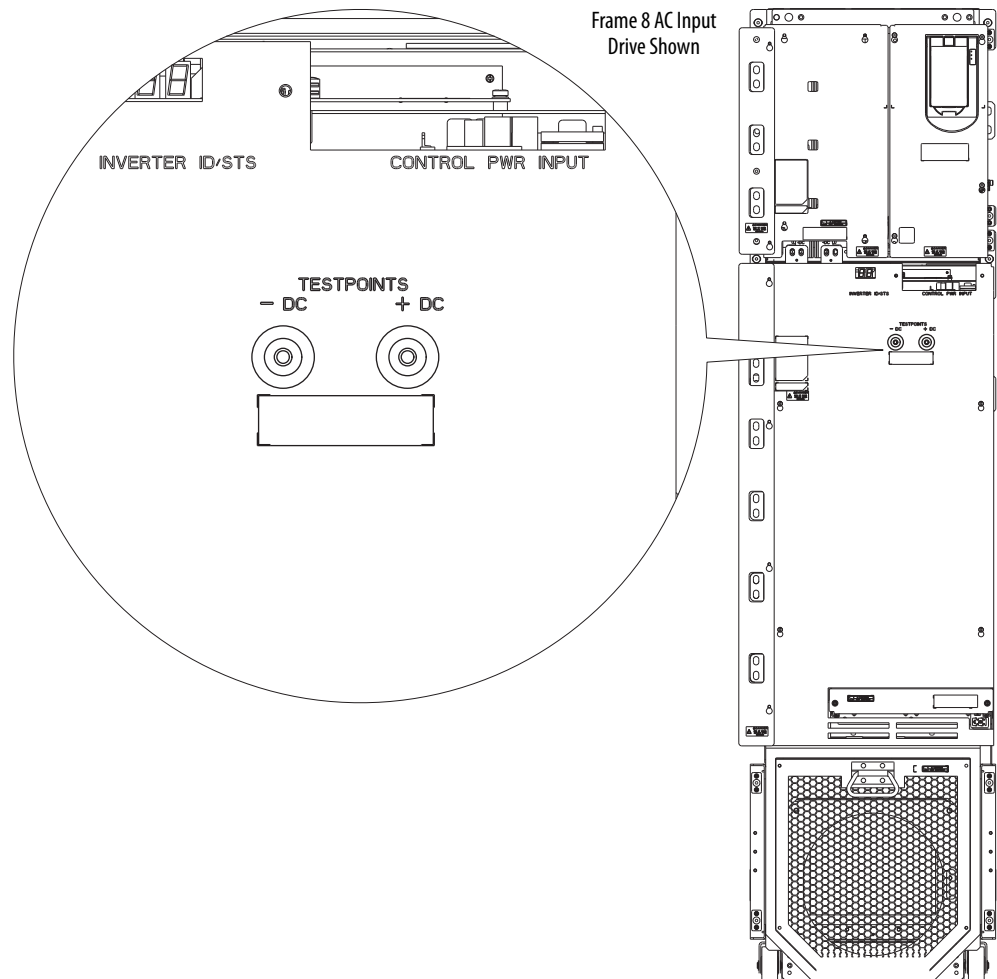
WARNING: To avoid an electric shock hazard, verify that the voltage on the bus capacitors has discharged completely before servicing. Measure the DC bus voltage at the -DC and +DC TESTPOINT sockets on the front of the power module.

Remove power before you remove or make cable connections. When you remove or insert a cable connector with power applied, an electric arc can occur. An electric arc can cause personal injury or property damage in these ways:

- An electric arc can send an erroneous signal to system field devices, which can cause unintended machine motion
- An electric arc can cause an explosion in a hazardous environment

Electric arcs cause excessive wear to contacts on both the module and its mating connector. Worn contacts can create electrical resistance.

1. Turn off and lockout all input power, including any external power sources (such as a regenerative power supply or other DC power source).
2. Wait 15 minutes and verify that there is no voltage at the drive input power terminals.
3. Measure the DC bus voltage at the -DC and +DC TESTPOINT sockets on the front of the power module.

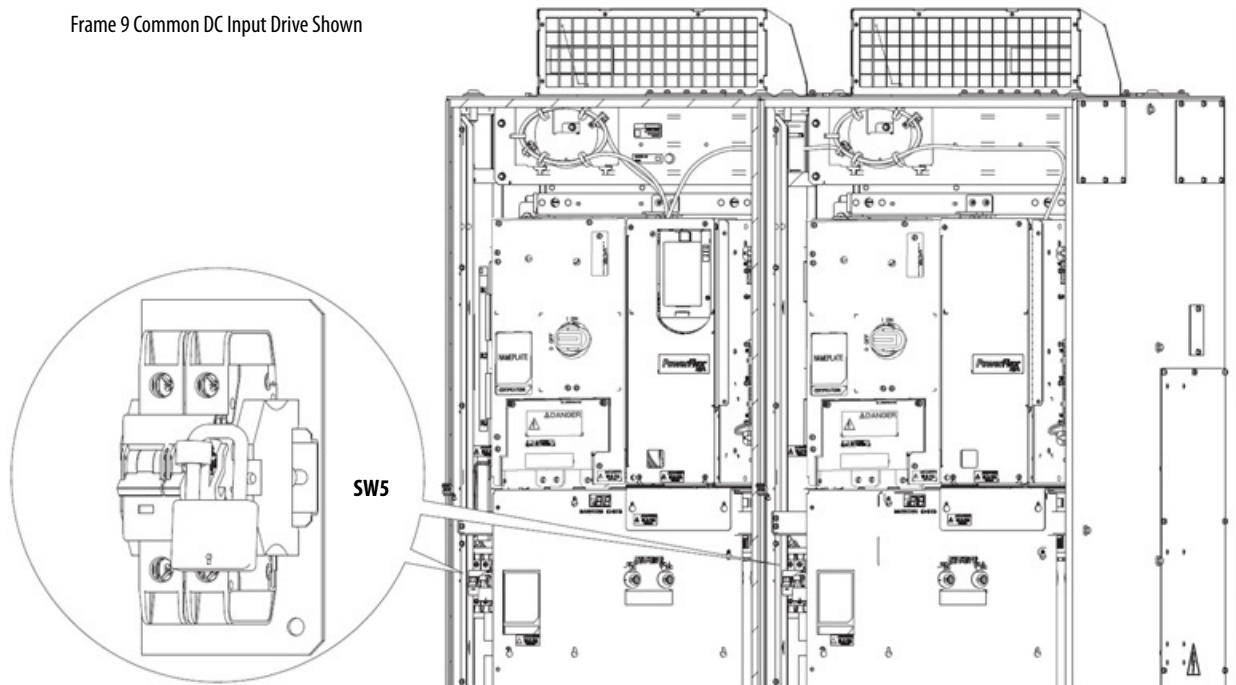




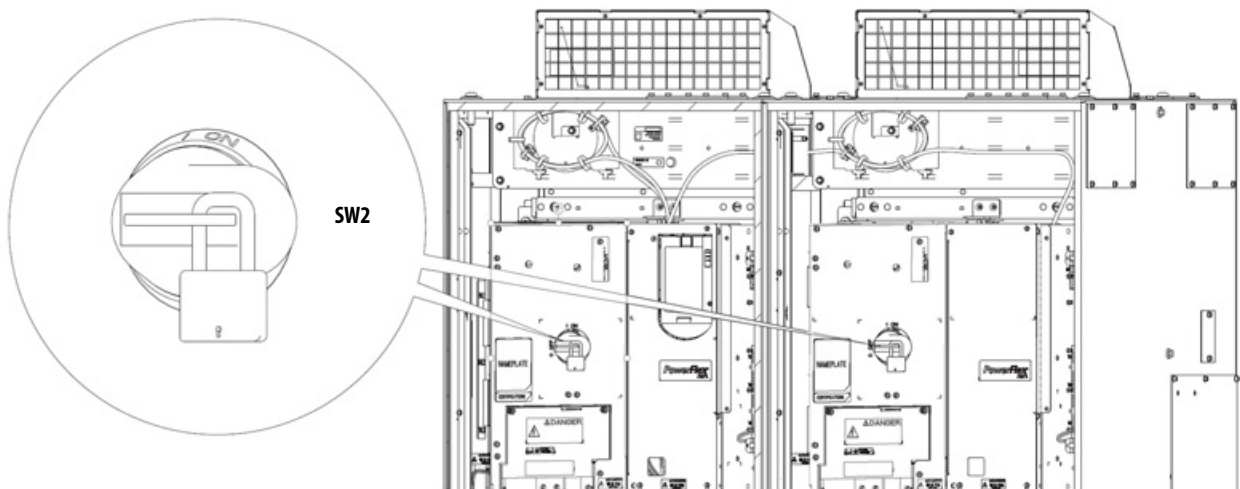
ATTENTION: To avoid an electric shock hazard when servicing the drive, a means for lockout/tagout of the external power supply source must be. The single-phase 120/240V power source and, if present, the external 120V uninterruptible both apply.

4. For common DC input drives only, follow steps a...e to turn off and lockout additional input power sources.
 - a. Turn off and lock the drive circuit breaker SW5 (if used).

Frame 9 Common DC Input Drive Shown

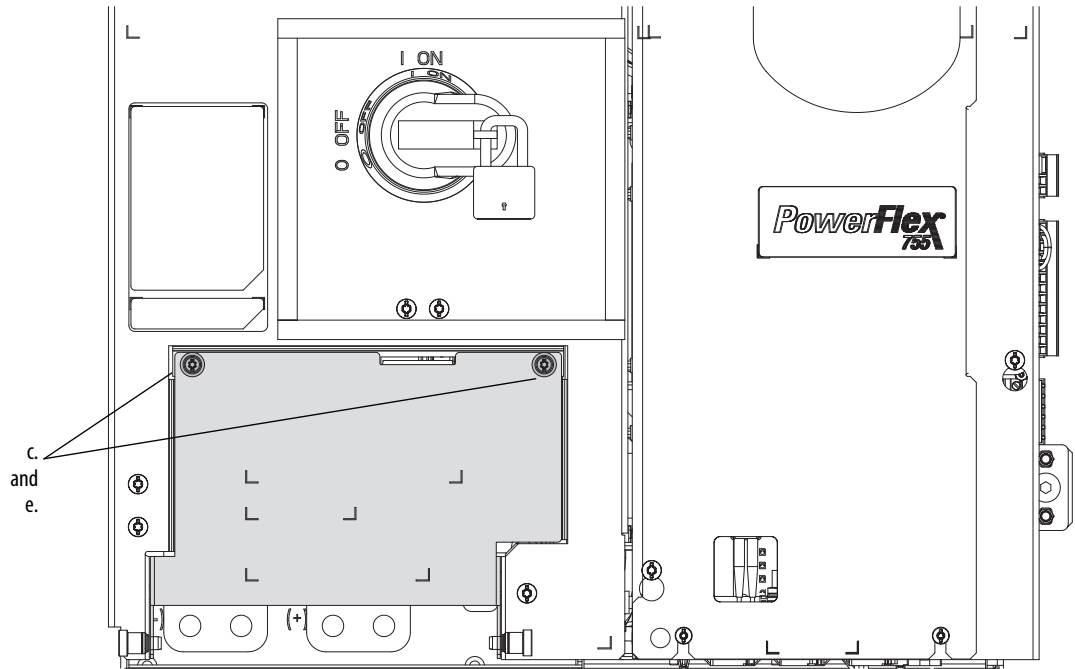


- b. Turn off and lock the drive disconnect switch SW2.

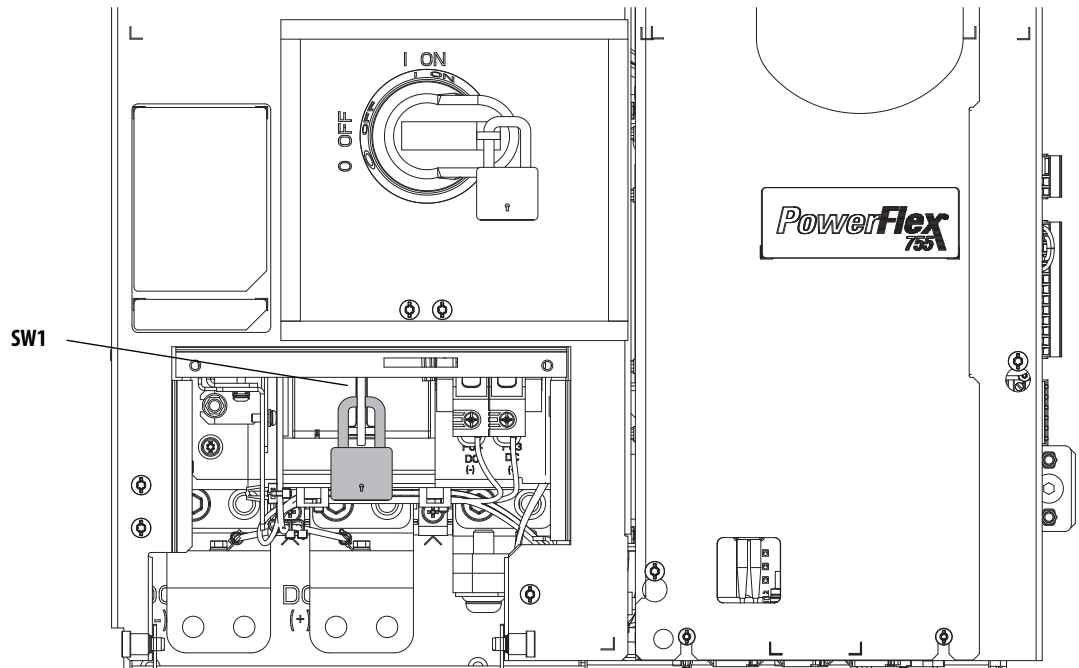


Common DC Input Drives

- c. For common DC input drives with a circuit breaker access door (DC input with precharge units 20-750-P6-*xnmnxnmn* and later), loosen the two hexalobular screws that secure the circuit breaker access door to the door panel and lower the door.



- d. Close and lock the hasp on the molded case switch SW1.



- e. If you must remove the drive from the cabinet, close and secure the circuit breaker access door before removal.

Drive Input Power Configurations

The PowerFlex 750-Series drives discussed in this manual are available as floor-mount frame 8, 9, and 10 drives with either AC or common DC input. See [Figure 1](#) and [Figure 2](#) on page 29 to familiarize yourself with AC versus DC input drive configurations and the main drive sections each configuration contains.

Figure 1 - AC Input Drives

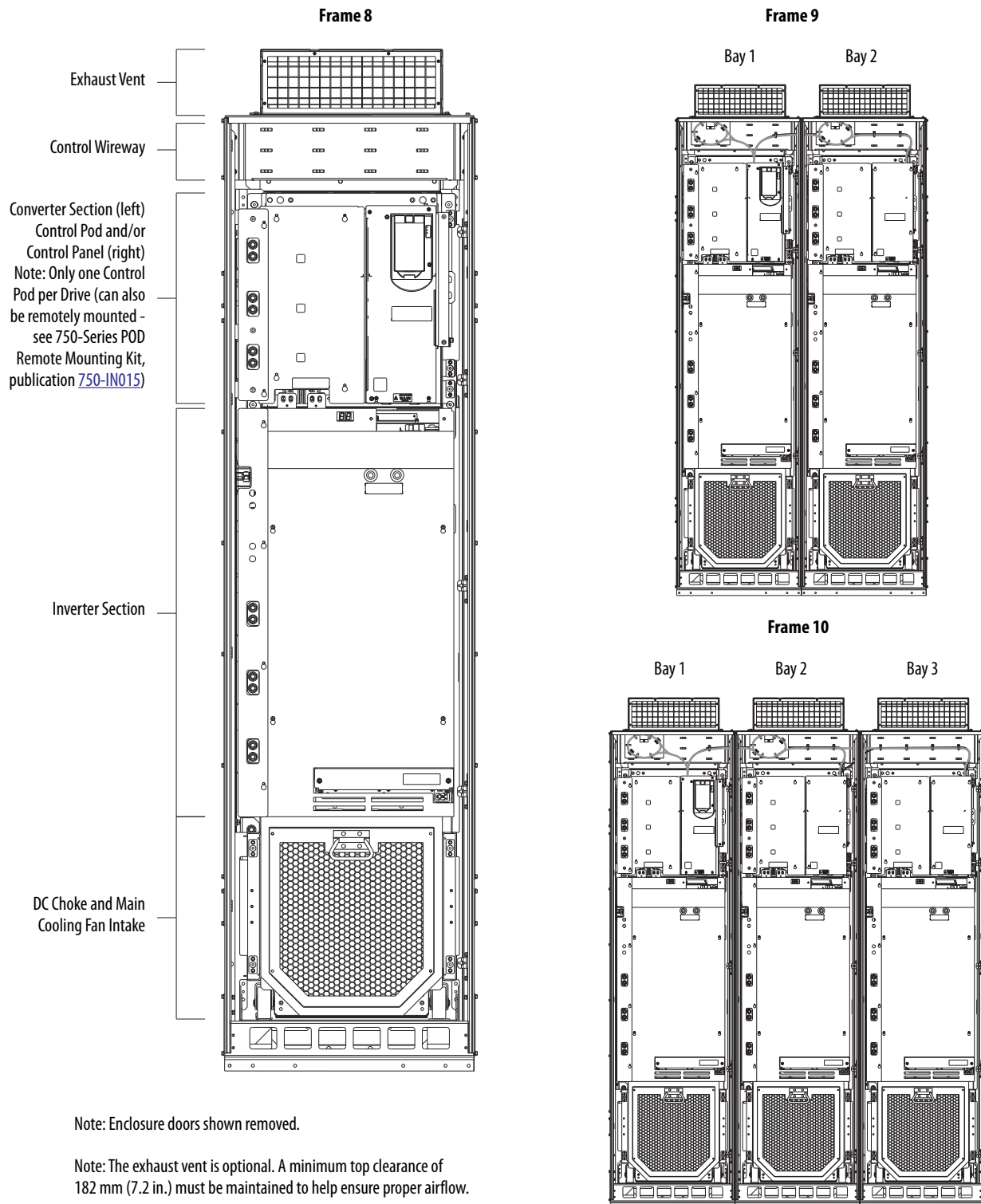
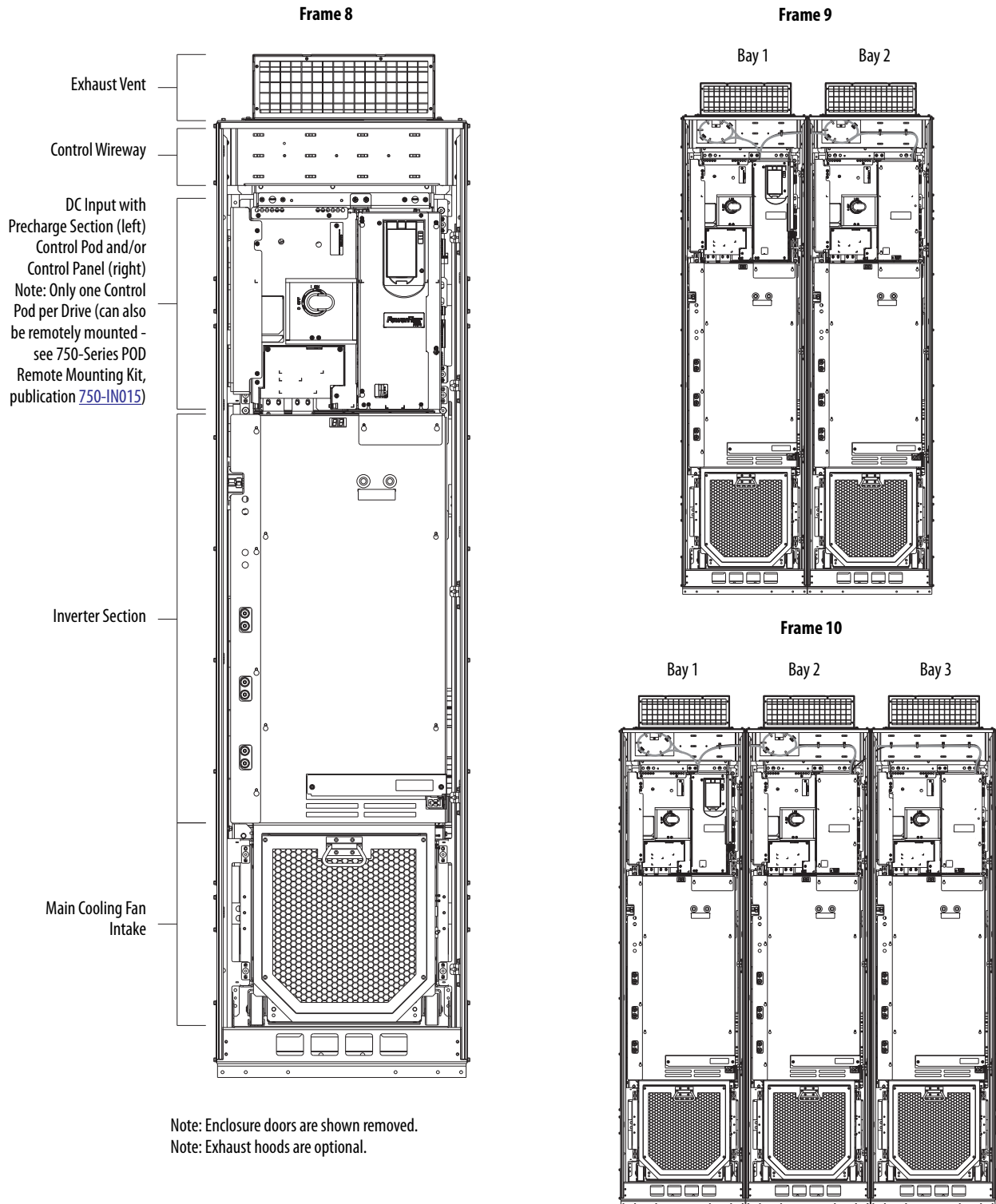


Figure 2 - Common DC Input Drives



Drive Series Components Compatibility

The drive frame size, date of manufacture, and firmware revision determine if series A or B components are installed. The following tables identify the drive components that are series-specific and the catalog numbers that can be used based on frame size and firmware revision. To avoid improper drive operation, verify the frame size, component series, and firmware revision before you purchase and replace any of these components.

Spare Part Compatibility with Series A and Series B Drives

Series A and series B power core components are not compatible with each other and cannot be combined.

TIP Safety cards are not allowed for use in Series A power core components.

- All frame 8 drives that are manufactured before August 31, 2011 contain series A components.
- All frame 8, 9, and 10 drives that are manufactured after August 31, 2011 contain series B and C components.

IMPORTANT Safety cards cannot be used on series A power core components.

Series Specific Component	Frame 8 - Series A Drives Compatible Component Part Cat. No.	Frame 8...10 - Series B and C Drives Compatible Component Part Cat. No.
Converter Unit, AC Input 770 A, 400V / 740 A, 480V	20-750-C1-C770D740	20-750-C6-C770D740
Converter Unit, AC Input 510 A, 600V / 500 A, 690V	–	20-750-C6-E510F500
Inverter Unit, AC Input 460 A, 400V / 430 A, 480V	20-750-I1-C460D430	20-750-I1B-C460-D430
Inverter Unit, AC Input 540 A, 400V / 485 A, 480V	20-750-I1-C540D485	20-750-I1B-C540D485
Inverter Unit, AC Input 567 A, 400V / 545 A, 480V	20-750-I1-C567D545	20-750-I1B-C567D545
Inverter Unit, AC Input 650 A, 400V / 617 A, 480V	20-750-I1-C650D617	20-750-I1B-C650D617
Inverter Unit, AC Input 750 A, 400V / 710 A, 480V	20-750-I1-C750D710	20-750-I1B-C750D710
Inverter Unit, AC Input 770 A, 400V / 740 A, 480V	20-750-I1-C770D740	20-750-I1B-C770D740
Converter Gate Board 400V/480V AC Input ⁽¹⁾	SK-R1-CGDB1-CD-F8	SK-R1-CGDB4-CD-F8
Converter Gate Board 600V/690V AC Input ⁽¹⁾	–	SK-R1-CGDB4-EF-F8
Inverter Power Layer, Interface Board ⁽²⁾	SK-R1-PINT1-F8	SK-R1-PINT2-F8

(1) This board is included with a replacement converter unit.

(2) This board is included with a replacement inverter unit.

Firmware Revision Compatibility with Series A and B Circuit Boards

Firmware Revision	Drive Series	Frame Size	Converter Gate Board SK-R1-CGDB1-CD-F8	Inverter Power Layer, Interface Board SK-R1-PINT1-F8	Converter Gate Board SK-R1-CGDB2-CD-F8 SK-R1-CGDB2-EF-F8	Converter Gate Board SK-R1-CGDB4-CD-F8 SK-R1-CGDB4-EF-F8	Inverter Power Layer, Interface Board SK-R1-PINT2-F8
2.xxx	A	8	Compatible	Compatible	NOT Compatible	NOT Compatible	NOT Compatible
3.xxx . . . 5.xxx	B	8 and 9	NOT Compatible	NOT Compatible	Compatible	Compatible	Compatible
6.xxx or later	B	10	NOT Compatible	NOT Compatible	NOT Compatible	Compatible	Compatible

Series A, B, and C Converter Components and Drive Input Power Compatibility

Series Specific Component	Compatible with 400/480VAC Input Drives	Compatible with 600/690VAC Input Drives
Converter EMC Filter Board SK-R1-EMCFLT1-F8 (Series A)	Yes	No
Converter EMC Filter Board SK-R1-EMCFLT2-F8 (Series B and C)	Yes	Yes
Converter Current Sensor SK-R1-CNVIFB1-F8 (Series A)	Yes	No
Converter Current Sensor SK-R1-CNVIFB2-F8 (Series B and C)	Yes	Yes

Commonly Used Tools

Service Tools

IMPORTANT Care must be taken to be sure that tools and/or hardware components do not fall into open drive assemblies. Do not energize the drive unless all loose tools and/or hardware components have been removed from the drive assemblies and enclosure.

This list includes the tools that are needed for test measurements, basic maintenance, and service repairs.

Tool Description	Details
Allen socket wrench	4 mm, 5 mm (with long extension)
Allen socket wrench extension	254 mm (10 in.)
Box wrench	7 mm, 8 mm, 10 mm, 13 mm, 17 mm, 19 mm, 22 mm
Crimping tools	For cable terminals, crimp per the tool manufactures specifications.
Current clamp	1000 A (AC, rms), signal output
ESD-protected place of work	Work surface, Floor cover, seat, and ground connections
ESD-protective clothing	Wrist wrap, shoes, overall clothing (coat)
Flash light	–
Flat-nose screwdriver	3 mm (0.12 in.), 5 mm (0.19 in.), 6.4 mm (0.25 in.)
Fuse puller	–
Hexalobular screw driver/bit	#15, #20, #25, #30, #40, #45
Hexagonal socket wrench	2.5 mm, 7 mm, 8 mm, 10 mm, 12 mm, 13 mm, 17 mm, 18 mm
Insulation tester	1000V DC
Lifting strap	8 mm (5/16 in.) J-hook style, 609 mm(24 in.) long, 454 kg (1000 lb.) Minimum
Multi-meter	Digital multi-meter, capable of AC and DC voltage, continuity, resistance, capacitance measurements, and forward diode bias tests. Fluke model 87 III or equivalent.
Nose pliers	–
Oscilloscope	Portable, digitizing, dual channel scope, with isolation
Phillips screwdriver/bit	#1, #2
Roll-out cart	20-750-CART1-F8. Note: The roll-out cart is required to remove the drive assembly from the enclosure.
Torque wrench	1...12 N·m (8.8... 106 lb·in)
Torque wrench	6...50 N·m (53... 443 lb·in)
Wire cutter	–


Software Tools









Connected Components Workbench™ software and DriveTools™ SP software are applications that can be used to upload and download parameter configuration and monitor and trend system parameters. Connected Components Workbench version 1.02 and DriveTools SP version 5.3 are required for use with PowerFlex® 750-Series floor mount frame 8 and larger drives and option modules.

Fastener/Tool/Torque Information

The disassembly illustrations in the following chapters identify the type of fastener, tool, and torque that is used for disassembly/assembly of components in the drive.

Fastener/Tool/Torque Information

	T20 or F - 6.4 mm (0.25 in.) 1.8 N·m (16 lb-in)	← Tool Type and Size
		F Flat-nose screwdriver
		Px Phillips screwdriver/bit and size
		PZx Pozidriv screwdriver/bit and size
		Txx Hexalobular screwdriver/bit and size
		xx mm Hexagonal socket wrench

	Flat-head screw
	Hexagonal bolt
	Hexagonal nut or standoff
	Hexagonal screw
	Hexalobular screw
	Phillips screw
	Pozidriv screw
	Slotted Hexalobular screw

Fastener Torque Sequences



ATTENTION: When mounting components to a drive heat sink, component fastener torque sequences and tolerances are crucial to component-to-heat sink heat dissipation.

Components can be damaged if the initial tightening procedure is not performed to specification.

The following illustrates the initial and final tightening sequences for components that are fastened to a heat sink by using two, four, and six screws. Initial torque is 1/3 (33%) of final torque, except six-point mountings, which require 0.7 N•m (6 lb•in) initial torque. The numeric illustration labels are for your assistance. Drive components do not contain these labels.

Figure 3 - Two-point Mounting

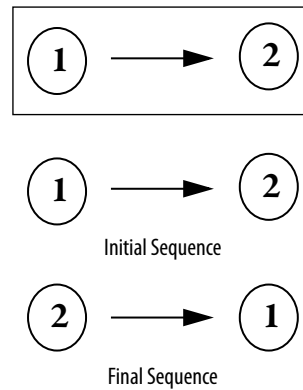


Figure 4 - Four-point Mounting

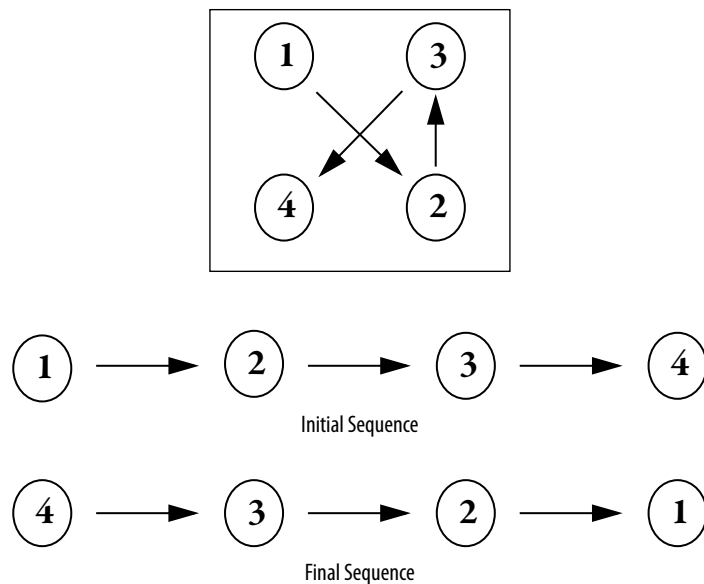
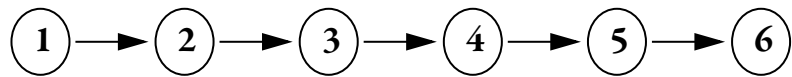
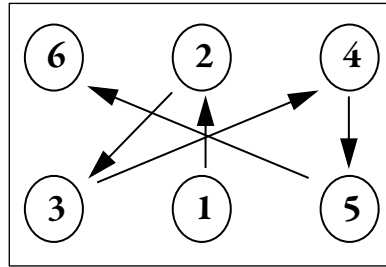
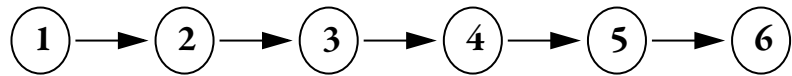


Figure 5 - Six-point Mounting



Initial Sequence

Do not exceed 0.7 N·m (6 lb-in) on initial torque of all six screws.



Final Sequence

Notes:

Periodic Maintenance

Topic	Page
Recommended Preventive Maintenance	37
Maintenance of Industrial Control Equipment	39

This chapter provides information on how to perform preventive maintenance on drive and option bay components that can affect the life and operability of the drive.

Recommended Preventive Maintenance

Rockwell Automation recognizes that following a defined maintenance schedule delivers the maximum product availability. By strictly following the maintenance schedule that is provided, you can expect the highest possible uptime.

This annual preventive maintenance program includes the following primary tasks:

- A visual inspection of all drive components visible from the front of the unit
- Resistance checks on the power components
- Power-supply voltage level checks
- General cleaning and maintenance
- Tightness checks on all accessible power connections

See Chapter 3 - Component Inspection and Test Procedures on page [47](#) for additional information on how to perform these procedures and tests.

The recommended maintenance tasks and schedule for a drive are contained in [Maintenance of Industrial Control Equipment](#) on page [39](#). The recommended maintenance tasks and schedule for an option bay are contained in [Table 4](#) on page [45](#). The Schedule Codes Explanations section on page [38](#) contains an explanation of the codes that are contained in the recommended maintenance tasks and schedule tables.

IMPORTANT Duty cycle, load profile, temperature, altitude, incoming line conditions, and other operating/environmental conditions greatly affect reliability of a drive.

Schedule Codes Explanations

The following codes are used to indicate the tasks that are associated with the components that are identified in the recommended tasks and maintenance schedule tables on pages [39...45](#).



ATTENTION: Servicing energized industrial control equipment can be hazardous. Severe injury or death can result from electrical shock, burn, or unintended actuation of controlled equipment.

Recommended practice is to disconnect and lockout control equipment from power sources, and discharge stored energy in capacitors, if present. If it is necessary to work in the vicinity of energized equipment, only qualified personnel are permitted to perform such work. Adhere to all applicable safety practices and wear protective equipment.

IMPORTANT Review product manuals for detailed maintenance information relevant a particular model.

Code	Task	Description
I	Inspect	Inspect the component for signs of excessive accumulation of dust, dirt, or external damage. For example, inspect the filter capacitors for bulges in the case, inspect the filters/fan inlet screens for debris that can block the airflow path.
C	Clean	Clean the components that can be reused, specifically the door-mounted air filters and fan inlet screens.
M	Maintain	This type of maintenance task can include an inductance test of line reactors/DC links, or a full test of an isolation transformer, and so on.
R	Replace	This component has reached its mean operational life. Replace the component to decrease the chance of failure. It is likely that components can exceed the designed life in the drive, but component life is dependent on many factors such as usage and heat.
RFB/R	Refurbish/Replace	The parts can be refurbished, at lower cost, or replaced with new ones.
Rv	Review	A discussion with Rockwell Automation personnel is recommended to help determine whether any of the enhancements/changes made to the drive hardware and control could benefit the application.

Maintenance of Industrial Control Equipment



ATTENTION: Performing service on energized Industrial Control Equipment can be hazardous. Severe injury or death can result from electrical shock, bump, or unintended actuation of controlled equipment. Recommended practice is to disconnect and lockout control equipment from power sources, and release stored energy, if present. See National Fire Protection Association Standard No. NFPA 70E, Part II (as applicable) OSHA rules for Control of Hazardous Energy Sources (lockout/tagout), and OSHA Electrical Safety Related Work Practices for safety-related work practices. These publications include procedural requirements for lockout/tagout, appropriate work practices, personnel qualifications, and training requirements where it is not feasible to de-energize and lockout or tagout electric circuits and equipment before working on or near exposed circuit parts.

Periodic Inspection — Industrial control equipment must be inspected periodically. Inspection intervals are based on environmental/operating conditions, and adjusted as indicated by experience. We recommend an initial inspection within 3...4 months after installation. We recommend an annual inspection after initial inspection on an ongoing basis.

Contamination — If inspection reveals that dust, dirt, moisture, or other contamination has reached the control equipment, the cause must be eliminated. This contamination can indicate an incorrect or ineffective enclosure, unsealed enclosure openings (conduit or other), or incorrect operating procedures. Dirty, wet, or contaminated parts must be replaced unless they can be cleaned effectively by vacuuming or wiping.



ATTENTION: Do not use compressed air or similar to clear dust or debris.

Cooling Devices — Inspect blowers and fans that are used for forced air cooling. Replace any that have bent, chipped, missing blades or if the shaft does not turn freely. Apply power momentarily to check operation. If unit does not operate, check and replace wiring, fuse, blower, or fan motor as appropriate. Clean or change air filters as recommended.

Inspect and clean the power section components (IGBTs, SCRs, and capacitors) as part of the annual clean and inspection cycle (as access allows). Do not remove the whole drive assembly to gain access to the components. The life expectancies of the power section components are designed to last for the life of the drive for wall-mounted drives. The actual life is dependent on ambient and environmental conditions, load, variation of load, power system configuration, output and carrier frequency configuration, cooling system, and other application-related factors.

The design life expectancy of the overall components normally exceeds 10 years (in some cases it can last 20 years or more) in normal operating environments.

Bus Capacitors — For drives that are in storage and do not have a voltage applied, maintenance of the capacitors in a drive product can also be required (see [Figure 6](#)). For drives that are stored under one year, there is no additional maintenance required. For storage greater than one year, see [Table 1](#) for bus capacitor reforming requirements.

Table 1 - Drive Storage Duration and Reforming Recommendations⁽¹⁾⁽²⁾

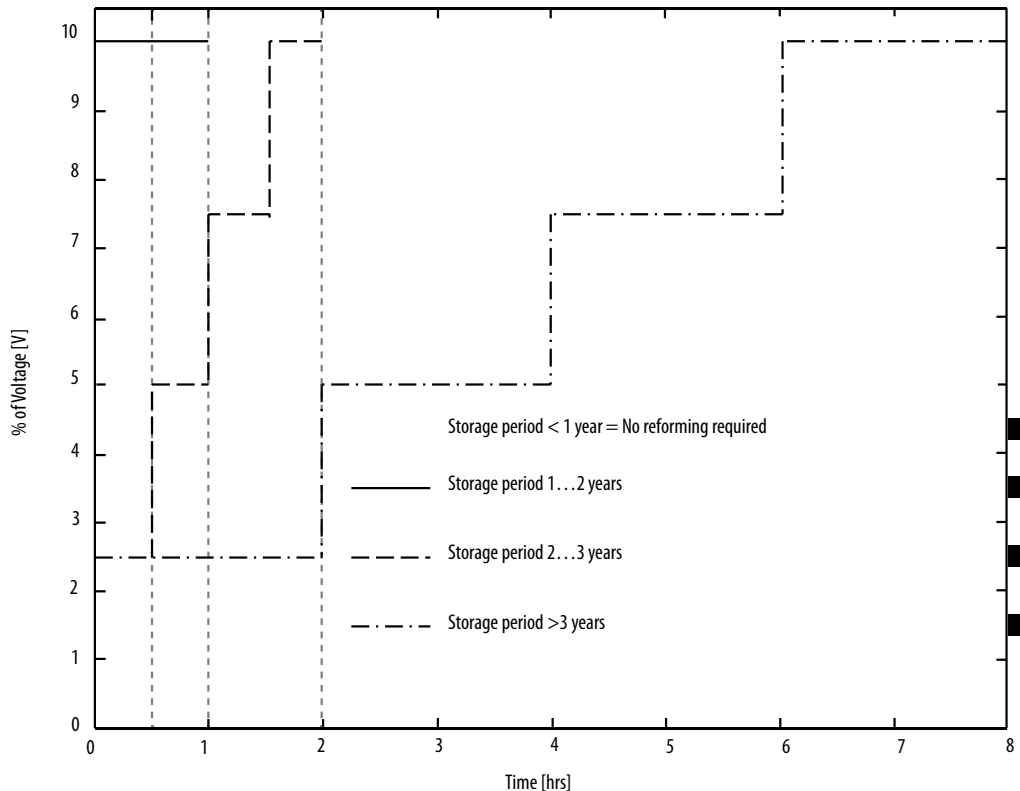
Duration	Guideline
Under 1 year	No reforming required.
1...2 years	Apply rated voltage, per the normal method, for 60 minutes under no load.
2...3 years	Using a DC power supply that is connected directly to the DC terminals of the product, ramp-up voltage from 0...100% of DV bus voltage (see Table 2) in steps of 25% Dwell at 25%, 50%, and 75% steps for 30 minutes each. At 100% voltage, dwell for 60 minutes, all under no load.
Over 3 years	Using DC power supply connect directly to the DC terminals of the product, ramp-up voltage from 0...100% of DC bus voltage (see Table 2) in steps of 25%. Dwell at each stem for 120 minutes.

- (1) The forming voltage must be 1.35...1.45 times the rated AC system voltage.
- (2) The power supply current draw must not exceed 50 mA.

Table 2 - DC Bus Voltage Ramp-up Values

AC Input Voltage	Voltage Across the DC Bus
230V	325V DC
400/480V	680V DC
600V	848V DC
600/690V	976V DC

Figure 6 - Bus Capacitor Reforming Guidelines



Operating Mechanisms — Check for proper functioning and freedom from sticking or binding. Replace any broken, deformed, or badly worn parts or assemblies according to individual product renewal parts lists. Check and securely retighten (if necessary) any loose fasteners. Lubricate (if specified) per individual product instructions.

IMPORTANT Allen-Bradley® magnetic starters, contactors, and relays are designed to operate without lubrication - do not lubricate these devices. Oil or grease on the pole faces (mating surfaces) of the operating magnet can cause the device to malfunction. Some parts of other devices are lubricated at the factory. If lubrication during use or maintenance of these devices is needed, it is specified in their individual instructions. If in doubt, consult the nearest Rockwell Automation sales office for information

Contacts — Check contacts for excessive wear and dirt accumulations. Discoloration and slight pitting are acceptable. Do not file contacts. Do not use contact spray cleaners as residues can cause sticking or interfere with electrical continuity. Replace the contacts only after the silver has become badly worn. Always replace contacts in complete sets to avoid misalignment and uneven contact pressure.

Terminals — Loose connections can cause overheating that can lead to equipment malfunction or failure. Check the tightness of all terminals and bus bar connections – securely tighten any loose connections. Replace any parts or wiring that is damaged by overheating. Also check ground connection integrity.

Coils—If a coil exhibits evidence of overheating (cracked, melted, or burned insulation), it must be replaced. In that event, check for and correct overvoltage or undervoltage conditions, which can cause coil failure. Be sure to clean any residues of melted coil insulation from other parts of the device or replace such parts.

Batteries — Replace batteries periodically as specified in product manual or if a battery shows signs of electrolyte leakage. Use tools to handle batteries that have leaked electrolyte; most electrolytes are corrosive and can cause burns. Dispose of the old battery in accordance with instructions that are supplied with the new battery or as specified in the manual for the product.

Pilot Lights — Replace any burned out lamps or damaged lenses.

Solid-state Devices — Solid-state devices require little more than a periodic visual inspection. Inspect the printed circuit boards to determine whether they are properly seated in the edge connectors. Board locking tabs must be in place. Necessary replacements must be made only at the personal computer board or plug-in component level. Do not use solvents on printed circuit boards. When blowers are used, air filters must be cleaned or changed periodically depending on the specific environmental conditions encountered.



ATTENTION: Use of other than factory recommended test equipment for solid-state controls can result in damage to the control or test equipment or unintended actuation of the controlled equipment.

High-Voltage Testing — Do not perform high-voltage insulation resistance (IR) and dielectric withstanding voltage (DWV) tests to check solid-state control equipment. When measuring IR or DWV of electrical equipment such as transformers or motors, a solid-state device that is used for control or monitoring must be disconnected before performing the test. Even though no damage is readily apparent after an IR or DWV test, the solid-state devices are degraded and repeated application of high voltage can lead to failure.

Locking and Interlocking Devices — Check these devices for proper working condition and capability of performing their intended functions.

Maintenance After a Fault Condition — An open short circuit protective device (such as a fuse or circuit breaker) in a properly coordinated motor branch circuit is an indication of a fault condition in excess of operating overload. Such conditions can damage control equipment. Before restoring power, the fault condition must be corrected and any necessary repairs or replacements must be made to restore the control equipment to good working order. Make sure that the parts are properly matched to the model, series, and revision level of the equipment.

Final Check Out — After maintenance or repair of industrial controls, always test the control system for proper functioning under controlled conditions that avoid hazards if a control malfunction occurs.

Keep Good Maintenance Records — This rule is most helpful to locate possible intermittent problems by pointing to a particular area of constant trouble within the overall system. Further, good maintenance records reduce major costly shutdowns by demanding the use of proper test equipment and an appropriate inventory of spare parts.

We recommend that a complete record of parameter settings be kept close to the drive for future reference. Some drives also incorporate an operator interface that can store a copy of the parameter setting.

IMPORTANT Duty cycle, load profile, temperature, altitude, incoming line conditions, and other operating/environmental conditions greatly affect reliability of a drive.

Table 3 - Recommended Drives Maintenance Tasks and Schedule

		Years >	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
Components and Activities																								
Air-cooling System	IP20 Door-mounted Air Filters ⁽¹⁾	pg. 313	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	
	IP54 Door-mounted Air Filters ⁽¹⁾	pg. 314	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R
	IP54 Roof-mounted Assembly Air Filters ⁽¹⁾	pg. 312	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R
	Main Heatsink Fan Assembly	pg. 236		I	I	I	I	R	I	I	I	I	R	I	I	I	I	R	I	I	I	I	I	R
	IP20 Door-mounted Cooling Fans	pg. 306		I	I	I	I	R	I	I	I	I	R	I	I	I	I	R	I	I	I	I	I	R
	IP54 Roof-mounted Cooling Fans	pg. 307		I	I	I	I	R	I	I	I	I	R	I	I	I	I	R	I	I	I	I	I	R
	Capacitor Bank Cooling Fans (Internal Stirring Fan)	pg. 234		I	I	I	I	R	I	I	I	I	R	I	I	I	I	R	I	I	I	I	I	R
	Converter Input Fuse Stirring Fan	pg. 95		I	I	I	I	R	I	I	I	I	R	I	I	I	I	R	I	I	I	I	I	R
	Converter Gate Board Stirring Fan	pg. 131		I	I	I	I	R	I	I	I	I	R	I	I	I	I	R	I	I	I	I	I	R
	DC Precharge Control Board Stirring Fan	pg. 215		I	I	I	I	R	I	I	I	I	R	I	I	I	I	R	I	I	I	I	I	R
Power Switching Components	Converter Power Devices (SCR)	pg. 111		I	I	I	I	I	I	I	I	I	I	I	R	I	I	I	I	I	I	I	I	I
	Inverter Power Devices (IGBT)	pg. 127-131		I	I	I	I	I	I	I	I	I	I	I	R	I	I	I	I	I	I	I	I	I
	Electronic Bus Capacitors (Inverter Capacitor Bank)	pg. 246		I	I	I	I	R	I	I	I	I	R	I	I	I	I	R	I	I	I	I	I	R
	Capacitor Balance Resistors	pg. 248		I	I	I	I	R	I	I	I	I	R	I	I	I	I	R	I	I	I	I	I	R
	Power Supply Circuit Board	pg. 258		I	I	I	I	RFB /R	I	I	I	I	RFB /R	I	I	I	I	RFB /R	I	I	I	I	I	RFB /R
	Precharge Resistors (Common DC Input Only)	pg. 178		I	I	I	I	I	I	I	I	I	R	I	I	I	I	I	I	I	I	I	I	R
	Molded Case Switch (Common DC Input Only)	pg. 222		I	I	I	I	I	I	I	I	I	R	I	I	I	I	I	I	I	I	I	I	R
	Undervoltage Delay Bracket (Common DC Input Only)	pg. 210		I	I	I	I	I	I	I	I	I	R	I	I	I	I	I	I	I	I	I	I	R

		Years >	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
Integral Magnetics/ Power Filters	Line Reactor ⁽²⁾	—		I	I	I	I	M	I	I	I	I	M	I	I	I	I	M	I	I	I	I	M
	DC Link/ Common-Mode Choke (AC Input Only)	pg. 285		I	I	I	I	M	I	I	I	I	M	I	I	I	I	M	I	I	I	I	M
Control Pod Components	Converter Gate Circuit Board Removal/ Installation	pg. 149		I	I	I	I	RFB /R	I	I	I	I	RFB /R	I	I	I	I	RFB /R	I	I	I	I	RFB /R
	Main Control Boards	pg. 65		I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I
	Fiber Interface Control Boards	pg. 73		I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I
	Batteries (DCBs and CIB) ⁽³⁾	pg. 73		I	I	R	I	I	R	I	I	R	I	I	R	I	I	R	I	I	R	I	I
	Fiber-optic Cables ⁽⁴⁾⁽⁵⁾⁽⁶⁾	pg. 57, 82, 158, 228		I	I	I	I	R	I	I	I	I	R	I	I	I	I	R	I	I	I	I	R
Enhancements	Firmware	—		-	-	Rv	-	-	Rv	-	-	Rv	-	-	Rv	-	-	Rv	-	-	Rv	-	-
	Hardware	pg. 32, 33		-	-	Rv	-	-	Rv	-	-	Rv	-	-	Rv	-	-	Rv	-	-	Rv	-	-
Operational Conditions	Parameters	pg. 32, 419		I	I	Rv	I	I	Rv	I	I	Rv	I	I	Rv	I	I	Rv	I	I	Rv	I	I
	Variables ⁽⁵⁾	—		I	I	Rv	I	I	Rv	I	I	Rv	I	I	Rv	I	I	Rv	I	I	Rv	I	I
	Application Concerns ⁽⁷⁾	—		I	I	Rv	I	I	Rv	I	I	Rv	I	I	Rv	I	I	Rv	I	I	Rv	I	I
Spare Parts	Spare Parts and Inventory/ Needs ⁽⁸⁾	—		I	I	Rv	I	I	Rv	I	I	Rv	I	I	Rv	I	I	Rv	I	I	Rv	I	I

- (1) Inspect and replace filters every 3 months or more frequently, depending on the environment.
- (2) Associated devices that are integrated into drive modules cannot be replaced individually. It is recommended to replace the entire module at the specified interval.
- (3) User installed CR1220 lithium coin cell battery provides power to the real-time clock (Optional, not supplied). Preserves the real-time clock setting in the event power to the drive is lost or cycled.
- (4) Hazard of permanent eye damage exists when using optical transmission equipment. This product emits intense light and invisible radiation. Do not look into module ports or fiber-optic cable connectors.
- (5) Evaluate, update, and verify compatibility when maintenance is performed.
- (6) See the listed page numbers and reference the corresponding call out: pg. 57 (#5), 82 (#21), 158 (#28), 228 (#12).
- (7) See Wiring and Grounding Guidelines for Pulse-width Modulated (PWM) AC Drives, publication DRIVES-IN001.
- (8) See the associated chapter or section for the list of parts.

IMPORTANT Duty cycle, load profile, temperature, altitude, incoming line conditions, and other operating/environmental conditions greatly affect reliability of a drive.

Table 4 - Recommended Option Bay Maintenance Tasks and Schedule

Years >		0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
Components and Activities																							
Air-cooling System	IP54 Door-mounted Air Filters ⁽¹⁾	pg. 355	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	C/R	
	IP54 Frame 8 Cabinet-mounted Cooling Fans	pg. 362		I	I	I	I	R	I	I	I	I	R	I	I	I	I	R	I	I	I	I	R
	IP54 Frame 9 Cabinet-mounted Cooling Fans	pg. 374		I	I	I	I	R	I	I	I	I	R	I	I	I	I	R	I	I	I	I	R
	IP20 Door-mounted Cooling Fans	pg. 351		I	I	I	I	R	I	I	I	I	R	I	I	I	I	R	I	I	I	I	R
	Reactor Fan Tray	pg. 386		I	I	I	I	R	I	I	I	I	R	I	I	I	I	R	I	I	I	I	R
Control Components	Frame 8 Control Transformer	pg. 364		I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I
	Frame 9 Control Transformer	pg. 380		I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I	I
	Frame 9 Fan Control Relay	pg. 391		I	I	I	I	R	I	I	I	I	R	I	I	I	I	R	I	I	I	I	R
Spare Parts	Inventory/Needs ⁽²⁾	—		I	I	Rv	I	I	Rv	I	I	Rv	I	I	Rv	I	I	Rv	I	I	Rv	I	I

- (1) Inspect and replace filters every 3 months or more frequently, depending on the environment.
- (2) See the associated chapter or section for the list of parts.

IMPORTANT Duty cycle, load profile, temperature, altitude, incoming line conditions, and other operating/environmental conditions greatly affect reliability of a drive.

Notes:

Component Inspection and Test Procedures

Topic	Page
Component Inspection and Maintenance	48
Forward and Reverse Biased SCR/Diode Tests	49
Converter Fuse Tests	53
Converter Gate-lead Resistance Measurements	53
DC Precharge Assembly Fuse Tests	55

This chapter provides details about how to inspect and test the major components of the drive and includes recommendations for repairs.

Component Inspection and Maintenance

Visually inspect the door filters, heatsink fan inlet screen, and major components on the control pod, converter or DC input with precharge assembly, and inverter for dirt and damage. Dirt build-up on some components can lead to component damage or failure. By replacing components and/or circuit boards with burn marks, breakage, or foil delamination, you can help prevent damage to the drive. Use this procedure with the Recommended Preventive Maintenance on page [37](#).

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Inspect the door fans for blockage and verify free rotation. Clean or replace as necessary.
 - For AC input drives, see IP20, NEMA/UL Type 1 Enclosure Door Fan Removal/Installation on page [306](#).
 - For common DC input drives, see Enclosure Door Fan Removal/Installation on page [333](#).
 - For option bays, see IP20, NEMA/UL Type 1 Door Fan Removal/Installation (Frame 8 Only) on page [351](#).
4. Remove the filters from the enclosure doors and inspect for blockage. For IP54, NEMA/UL Type 12 enclosures, remove the filters from the cabinet blower, and inspect for blockage. Clean or replace all filters as necessary. See IP20, NEMA/UL Type 1 Door Filter Removal/Installation on page [313](#), and/or IP54, NEMA/UL Type 12 Cabinet Blower Exhaust Filters Removal/Installation on page [312](#) and IP54, NEMA/UL Type 12 Cabinet Door Filters Removal/Installation on page [314](#).
5. Open the enclosure door.
6. Inspect the heatsink fan inlet screen for blockage and clean it, if necessary.
7. Inspect the heatsink fan blower for dirt build-up and/or damage and verify free rotation. Clean or replace as necessary. See Heatsink Fan Assembly Removal/Installation on page [236](#).
8. Remove the protective covers from the control pod, converter or DC input with precharge assembly, and inverter assemblies. See Control Pod Cover Removal/Installation on page [59](#), Converter Left Cover Removal/Installation on page [87](#) or DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard Removal/Installation on page [163](#), and Inverter Front Cover Removal/Installation on page [239](#).
9. Check all visible major components on the control pod, converter or DC input with precharge assembly, and inverter assemblies. Replace any of these components without further testing if they show evidence of burn marks or breakage.

10. Check all visible circuit boards, wires, and connectors on the control pod, converter or DC input with precharge assembly, and inverter assemblies. Replace any of these circuit boards and/or wires without further testing if they show evidence of burn marks, breakage, or foil delamination.
11. If the inspections performed in steps 3...7 resulted in heavy build-up of dirt and or debris, inspect the cooling tunnels and heatsink fins on the converter and inverter assemblies. Clean the cooling tunnels and heatsink fins, if necessary. To inspect the cooling tunnels and heatsink fins, you must remove the drive from the enclosure and remove the converter. See the PowerFlex® 750-Series AC Drive Installation Instructions, publication number [750-IN001](#). For instructions on how to remove the converter, refer to Converter Removal/Installation on page [152](#).

Forward and Reverse Biased SCR/Diode Tests

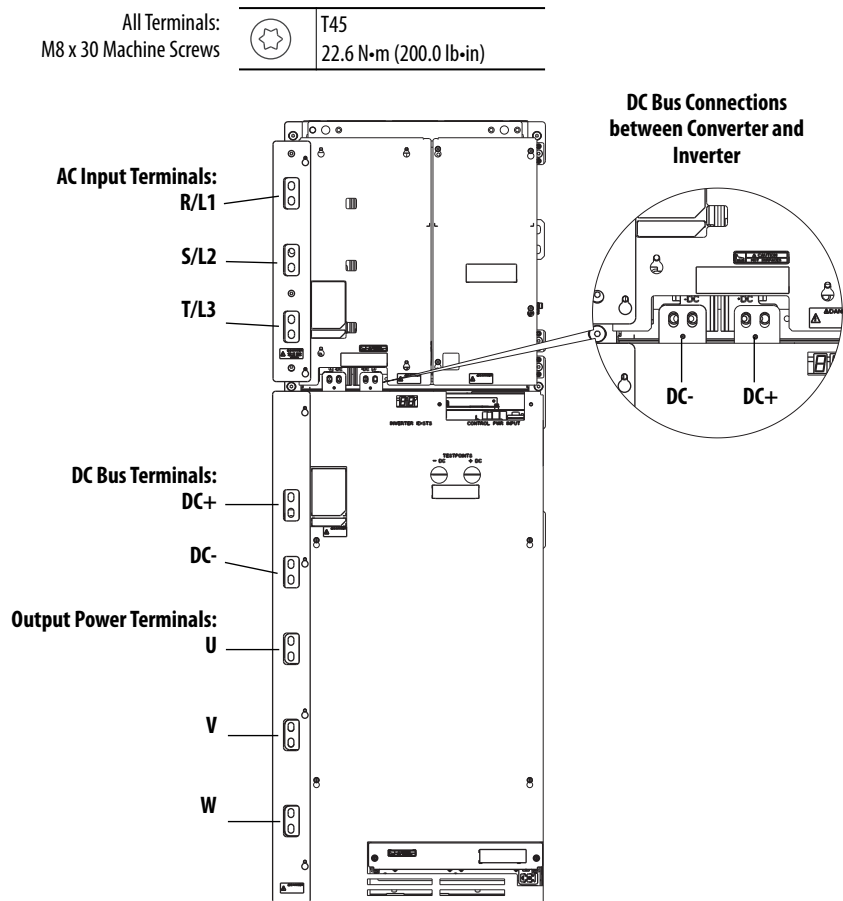
This section contains procedures for performing both forward and reverse biased SCR/diode tests on the major power components of the drive. A failed test indicates damage to the components in the converter or inverter and requires replacement.

IMPORTANT The actual voltage readings can vary depending upon your equipment. If your readings are not near the indicated values in [Table 5](#)...[Table 8](#), on pages [51](#)...[52](#), verify that the actual voltage that is measured is consistent for each phase of the converter and inverter.

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the control transformer primary fuses (FU4 and FU5). See Remove the Control Transformer Primary Fuses (FU4 and FU5) on page [91](#).

5. Remove the connection bolts from the output power terminals (U, V, W) and set them aside.
6. Insert an appropriate insulation material between the terminals (U, V, W) on the drive power unit and the enclosure. To receive accurate readings for these tests, the terminals must not make contact.

Figure 7 - Power Terminal Connections



7. Complete the forward biased SCR/diode tests on the converter assembly as identified in [Table 5](#).

Table 5 - Forward Biased SCR/Diode Tests on the Converter SCR Assembly

Meter Leads		Nominal Meter Reading
-	+	
DC+	R/L1	"0L" (open circuit) ⁽¹⁾
DC+	S/L2	
DC+	T/L3	
R/L1	DC-	The value should gradually rise to between 0.20V and 0.75V. If the value is outside this range, contact Technical Support. ⁽²⁾
S/L2	DC-	
T/L3	DC-	

(1) Residual voltage on the DC bus capacitors can affect this reading. If the capacitors are completely discharged (less than 1 volt), the meter initially shows a low voltage. This voltage reading is the residual bus voltage plus the drop through the low side diodes. The meter gradually charges the bus, and the voltage slowly increases, until eventually the meter switches to "0L". This increase can take several minutes to occur.

(2) The actual voltage reading can vary depending upon your equipment.

8. If performing the Reverse Biased Diode Tests on the Converter SCR Assembly identified [Table 6](#), remove the connection bolts from the DC bus terminals (DC-, DC+) between the converter and inverter assemblies, and set them aside. See [Figure 7](#) on page [50](#) for terminal locations.
9. Insert an appropriate insulation material between the DC bus terminals (DC-, DC+) between the converter and inverter. To receive accurate readings for these tests, the terminals must not make contact.
10. Complete the reverse biased SCR/diode tests on the converter as identified in [Table 6](#).

Table 6 - Reverse Biased Diode Tests on the Converter SCR Assembly

Meter Leads		Nominal Meter Reading
+	-	
R/L1	DC-	"0L" (open circuit) ⁽¹⁾
S/L2	DC-	
T/L3	DC-	
DC+	R/L1	
DC+	S/L2	
DC+	T/L3	

(1) Residual voltage on the DC bus capacitors can affect this reading. If the capacitors are completely discharged (less than 1 volt), the meter initially shows a low voltage. This voltage reading is the residual bus voltage plus the drop through the low side diodes. The meter gradually charges the bus, and the voltage slowly increases, until eventually the meter switches to "0L". This increase can take several minutes to occur.

11. Replace the converter section or converter SCR assembly if it fails these measurements. See Converter Removal/Installation on page [152](#), or Converter SCR Assembly Removal/Installation on page [111](#).
12. Install the control transformer primary fuses (FU4 and FU5). See Install the Control Transformer Primary Fuse (FU4 and FU5) on page [91](#).

13. Complete the forward and reverse biased diode tests on the inverter IGBT assembly as identified in [Table 7](#) and [Table 8](#).

TIP Reverse bias diode tests on the IGBT are for reference troubleshooting only and can result in readings other than 0.0V (or close to 0) or the OL. The readings can vary widely depending on the meter used, the amount of charge on the batteries in the meter, and the current temperature of the drive unit.

Table 7 - Forward Biased Diode Tests on the Inverter IGBT Assembly

Meter Leads		Nominal Meter Reading
+	-	
DC-	U	The value should gradually rise to between 0.20V and 0.75V. If the value is outside this range, contact Technical Support. ⁽¹⁾
DC-	V	
DC-	W	
U	DC+	
V	DC+	
W	DC+	

(1) The actual voltage reading can vary depending upon your equipment.

Table 8 - Reverse Biased Diode Tests on the Inverter IGBT Assembly

Meter Leads		Nominal Meter Reading
+	-	
U	DC-	"OL" (open circuit) ⁽¹⁾
V	DC-	
W	DC-	
DC+	U	
DC+	V	
DC+	W	

(1) Residual voltage on the DC bus capacitors can affect this reading. If the capacitors are completely discharged (less than 1 volt), the meter initially shows a low voltage. This voltage reading is the residual bus voltage plus the drop through the low side diodes. The meter gradually charges the bus, and the voltage slowly increases, until eventually the meter switches to "OL". This increase can take several minutes to occur.

14. Replace the inverter section if it fails these measurements. To remove the inverter, see the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#).
15. Complete the procedures in Chapter 12 Drive Startup after Repairs on page [419](#) before placing the drive back into service.

Converter Fuse Tests

Follow these steps to perform converter fuse tests.

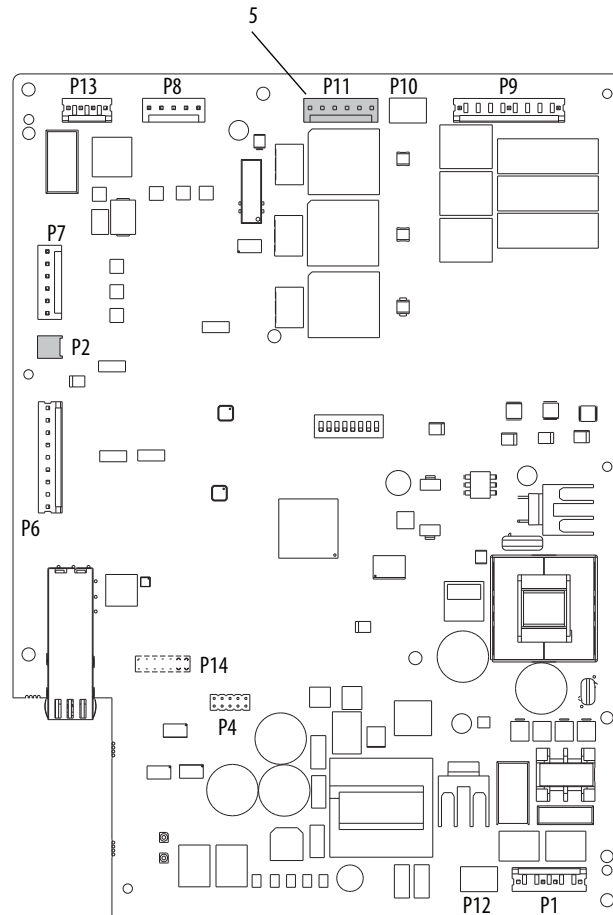
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Test the control transformer secondary fuse (FU6) by removing it from the fuse holder. Replace the fuse as necessary. See Control Transformer Secondary Fuse Removal/Installation on page [92](#).
5. Test the control transformer primary fuses (FU4 and FU5) by removing them from the fuse holder. See Remove the Control Transformer Primary Fuses (FU4 and FU5) on page [91](#).
6. Continuity test the AC line fuses (FU1, FU2, and FU3) in circuit. If fuses are blown, analyze to reveal the root cause. Replace a fuse as necessary. See AC Line Fuse Removal/Installation on page [99](#).
7. Replace the control transformer primary fuses (FU4 and FU5) as necessary. See Install the Control Transformer Primary Fuse (FU4 and FU5) on page [91](#).

Converter Gate-lead Resistance Measurements

Follow these steps to perform resistance measurements on the gate leads for the converter.

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. To provide access to the converter gate board, open the control pod. See Rotate the Control Pod Forward on page [88](#).

- Disconnect the SCR gate harness J11 from P11 on the converter gate board.



- Complete the gate circuit measurements on the J11 harness as identified in [Table 9](#).

Table 9 - Gate Circuit Measurements

Meter Lead +	Meter Lead -	Nominal Meter Reading
J11-1, SCR Gate L1	J11-2, SCR Cathode L1	12...30 ohms
J11-3, SCR Gate L2	J11-4, SCR Cathode L2	12...30 ohms
J11-5, SCR Gate L3	J11-6, SCR Cathode L3	12...30 ohms

- An “OL” reading can indicate an open wire harness or a disconnected intermediate connector. Verify the harness integrity by making a continuity measurement. Replace a faulty harness if indicated by these measurements.
- A “shorted” meter reading can indicate a failed SCR. Replace the converter SCR assembly if it fails these measurements. See Converter SCR Assembly Removal/Installation on page [111](#).

- Connect the SCR gate harness to P11 on the converter gate board.

8. Return the control pod to the service position. See Return the Control Pod to the Service Position on page [91](#).

DC Precharge Assembly Fuse Tests

Follow these steps to test the fuses on the DC precharge assembly.

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Test the control transformer 240V secondary fuse (FU5) by removing it from the fuse holder. Replace the fuse as necessary. See Control Transformer Secondary Fuses Removal/Installation on page [172](#).
5. Test the control transformer 120V secondary fuse (FU6) by removing it from the fuse holder. Replace the fuse as necessary. See Control Transformer Secondary Fuses Removal/Installation on page [172](#).
6. Test the DC line fuses (FU1 and FU2) in circuit. Replace a fuse as necessary. See DC Line Fuses and Fuse Indicators Removal/Installation on page [180](#).
7. Test the DC precharge fuses (FU3 and FU4) in circuit. Replace a fuse as necessary. See Precharge Circuit Fuses Removal/Installation on page [182](#).

Notes:

Control Pod Component Replacement Procedures

Topic	Page
Control Pod Components Identification	57
Control Pod Cover Removal/Installation	59
Control Pod Cables Removal/Installation	60
Fiber-optic Cable Removal/Installation (Frame 8)	61
Main Control Board Removal/Installation	65
Fiber Interface Board Removal/Installation	73

This chapter provides detailed procedures for how to remove and replace control pod components.

IMPORTANT Complete the procedures in Chapter 12 Drive Startup after Repairs that begin on page 419 before placing the drive back into service.

Control Pod Components Identification

[Table 10](#) contains the components that comprise the control pod and provides the following information for each component, if applicable:

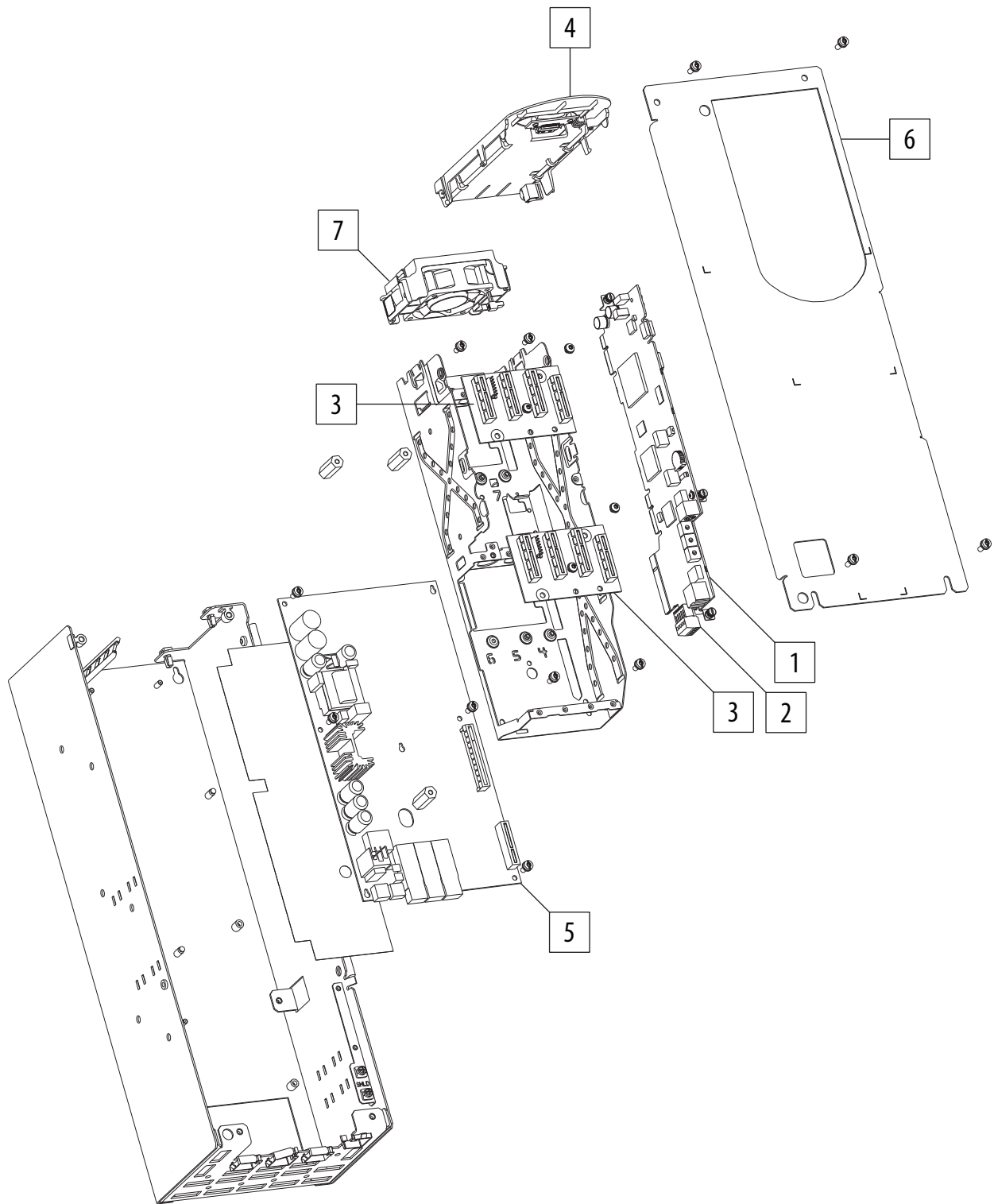
- Kit catalog number or part number
- Quantity that is contained in the kit
- Illustration figure and page number and identification number

See PowerFlex Architecture Class Low Voltage Drives Spare Parts Options, publication [PFLEX-SB002](#) for a complete list of spare parts for PowerFlex® 755 Frame 8...10 drives.

Table 10 - Control Pod Replacement Kits/Parts

Component Description	Replacement Kit Cat. No. or Part No.	Quantity	Figure and Page	ID No.
Control Pod	20-750-POD1-F8	1	Figure 8 on page 58	–
Frame 8 Main Control Board	SK-R1-MCB1-F8	1	Figure 8 on page 58	1
Main Control Board Terminal Block	SK-R1-TB-PF755	1	Figure 8 on page 58	2
Backplane Board	SK-R1-BP1	1	Figure 8 on page 58	3
Control Pod HIM Bezel	SK-R1-BZ1	1	Figure 8 on page 58	4
Fiber Interface Board (Includes a fiber-optic transceiver)	SK-R1-FIB1-F8	1	Figure 8 on page 58	5
Control Pod Cover	SK-R1-CVRP1-F8	1	Figure 8 on page 58	6
Internal Cooling Fan	SK-R9-FAN2-F23	1	Figure 8 on page 58	7
Remote Mount Control Pod Kit	20-750-RPD1-F8	1	See publication 750-IN015	–

Figure 8 - Control Pod Components

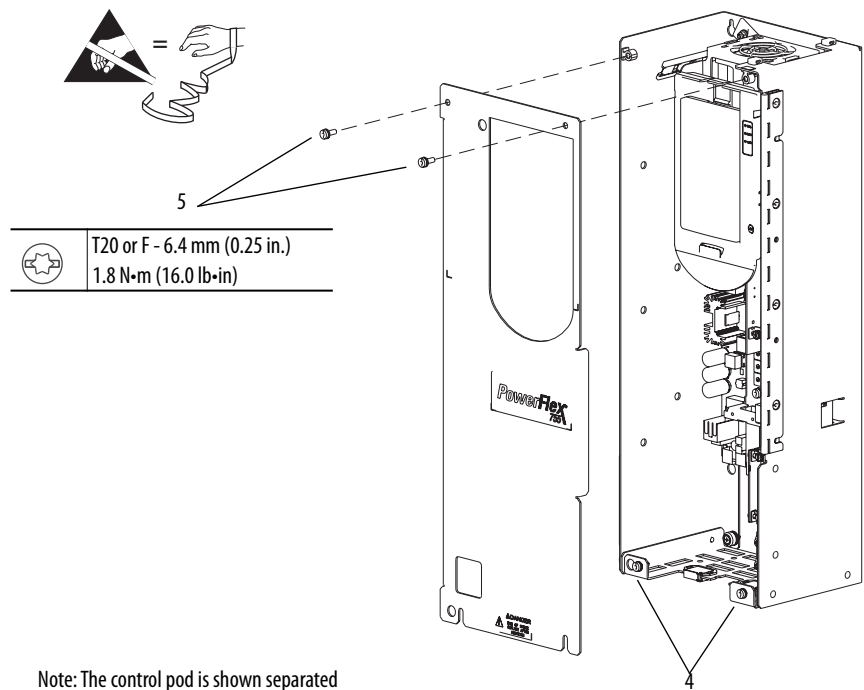


TIP See Fastener/Tool/Torque Information on page [33](#) for descriptions of the fasteners, tools, and torque figures that are used in the disassembly/assembly procedures in this chapter.

Control Pod Cover Removal/ Installation

Remove the Control Pod Cover

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Loosen, but do not remove, the bottom two M4 x 12 mm slotted hexalobular screws that secure the cover to the assembly.
5. Remove the top two M4 x 12 mm slotted hexalobular screws that secure the cover to the assembly and remove the cover.



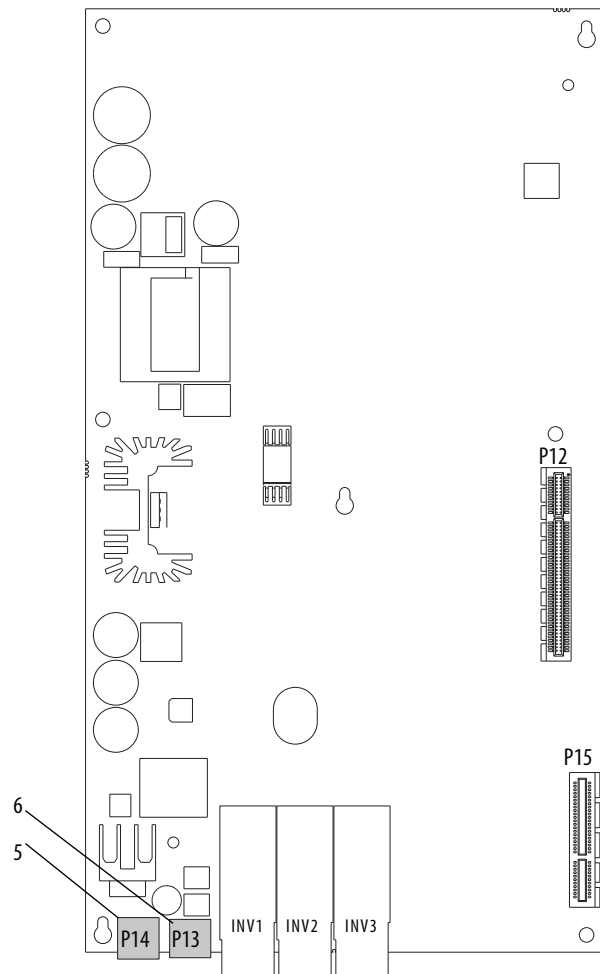
Install the Control Pod Cover

Install the control pod cover in the reverse order of removal. See Control Pod Cover Removal/Installation on page [59](#).

Control Pod Cables Removal/ Installation

Remove the Control Pod Cables

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the control pod cover. See Control Pod Cover Removal/ Installation on page [59](#).
5. Disconnect the drive internal 24V wire harness J14 connector from the fiber interface board P14 terminal.
6. If installed, disconnect the customer supplied 24V supply power wiring from the fiber interface board P13 terminal.



Install the Control Pod Cables

Install the control pod cable set in the reverse order of removal. See Remove the Control Pod Cables on page [60](#).

Fiber-optic Cable Removal/ Installation (Frame 8)

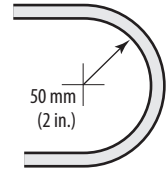
Remove the Fiber-optic Cable (Frame 8)

Note: For instructions on how to remove the fiber-optic cables on frame 9 and larger drives, see Chapter 11 - Enclosure Cable Components Replacement Procedures (Frame 9 and Larger Drives) that begin on page [397](#).

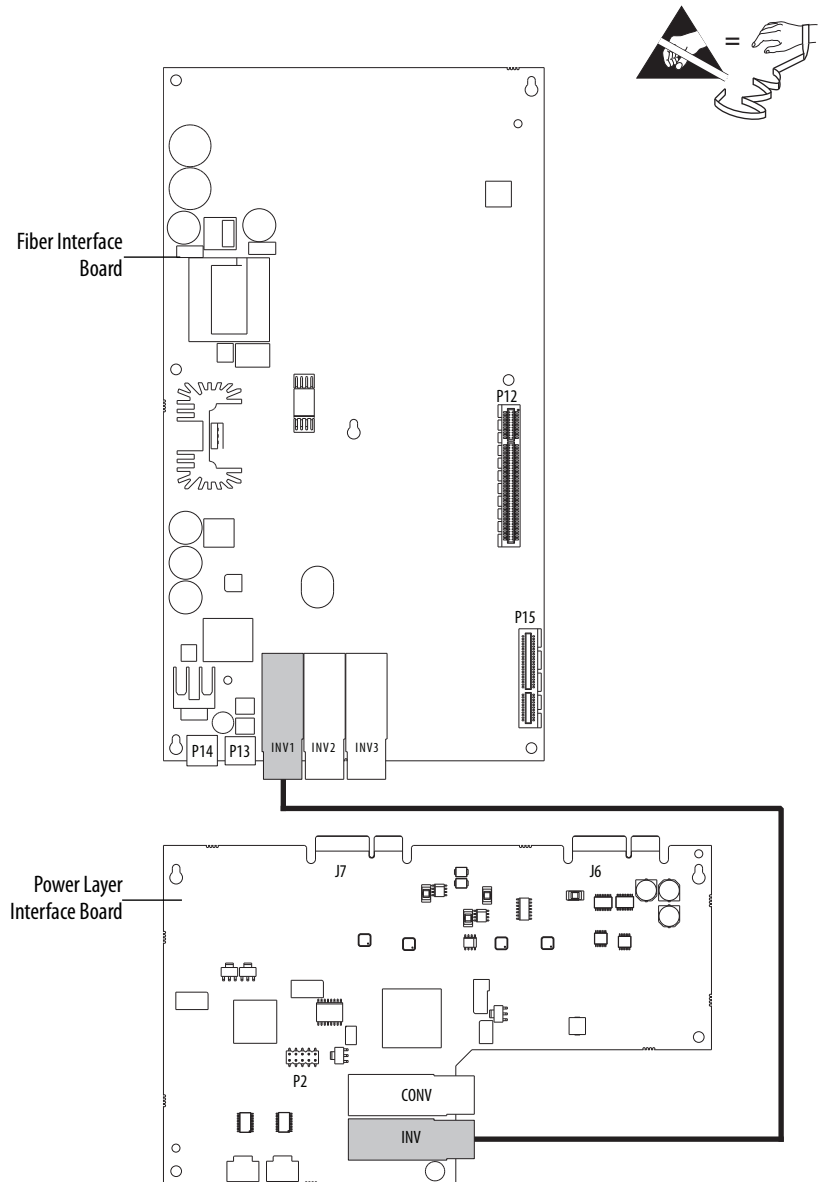
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the control pod cover. See Control Pod Cover Removal/Installation on page [59](#).
5. Remove the inverter circuit board connections cover from the inverter. See Inverter Circuit Board Connections Cover Removal/Installation on page [238](#).

IMPORTANT

Minimum inside bend radius for fiber-optic cable is 50 mm (2 in.). Any bends with a shorter inside radius can permanently damage the fiber-optic cable. Signal attenuation increases with decreased inside bend radii.

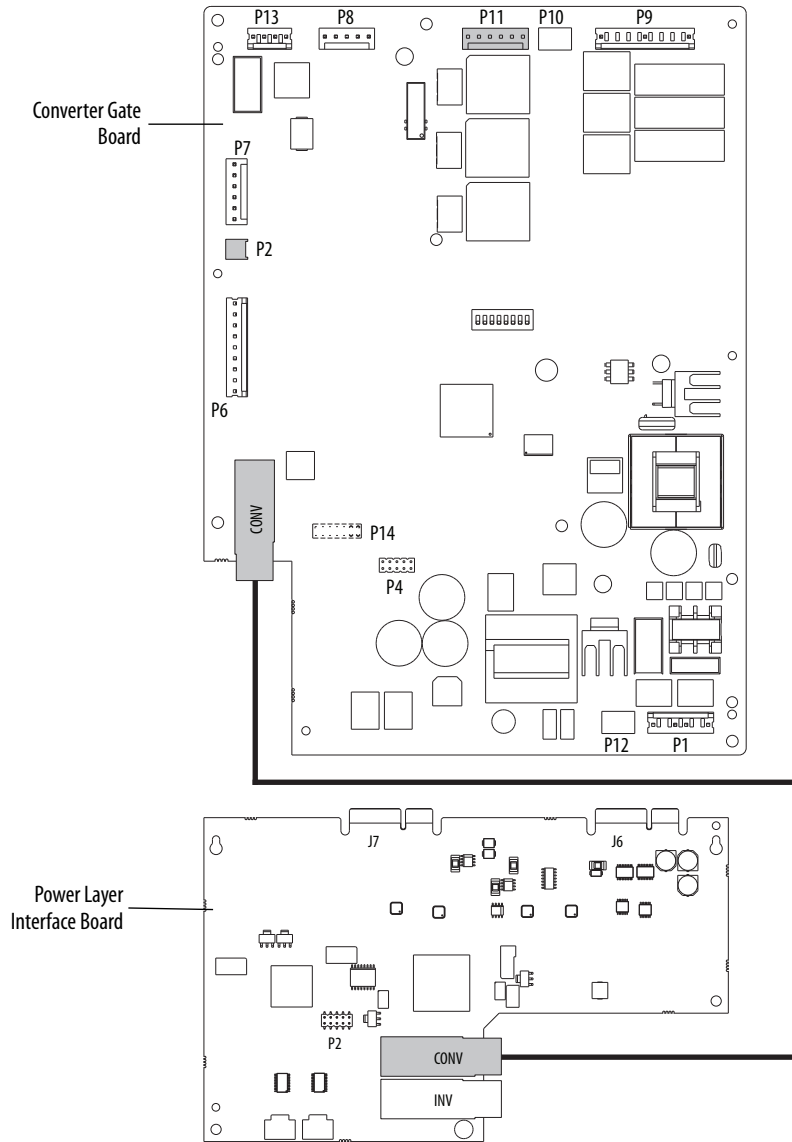


6. Disconnect the fiber-optic cable from INV1 on the fiber interface board and INV on the power layer interface board in the inverter card cage.



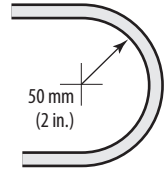
TIP Listed are the different circuit board locations:
Chapter 4 [Figure 8 on page 58](#) call-out #5
Chapter 5 [Figure 10 on page 86](#) call-out #21
Chapter 6 [Figure 12 on page 162](#) call-out #28
Chapter 7 [Figure 14 on page 232](#) call-out #7

7. Disconnect the fiber-optic cable from CONV on the converter gate board and CONV on the power layer interface board in the inverter card cage.



Install the Fiber-optic Cable (Frame 8)

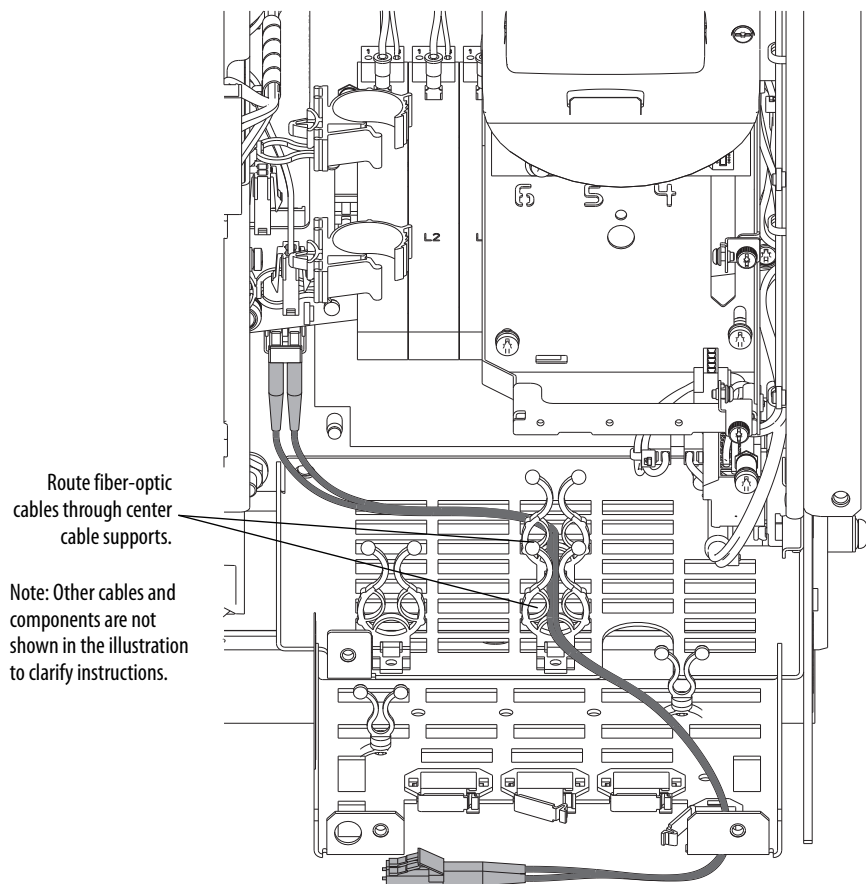
IMPORTANT Minimum inside bend radius for fiber-optic cable is 50 mm (2 in.). Any bends with a shorter inside radius can permanently damage the fiber-optic cable. Signal attenuation increases with decreased inside bend radii.



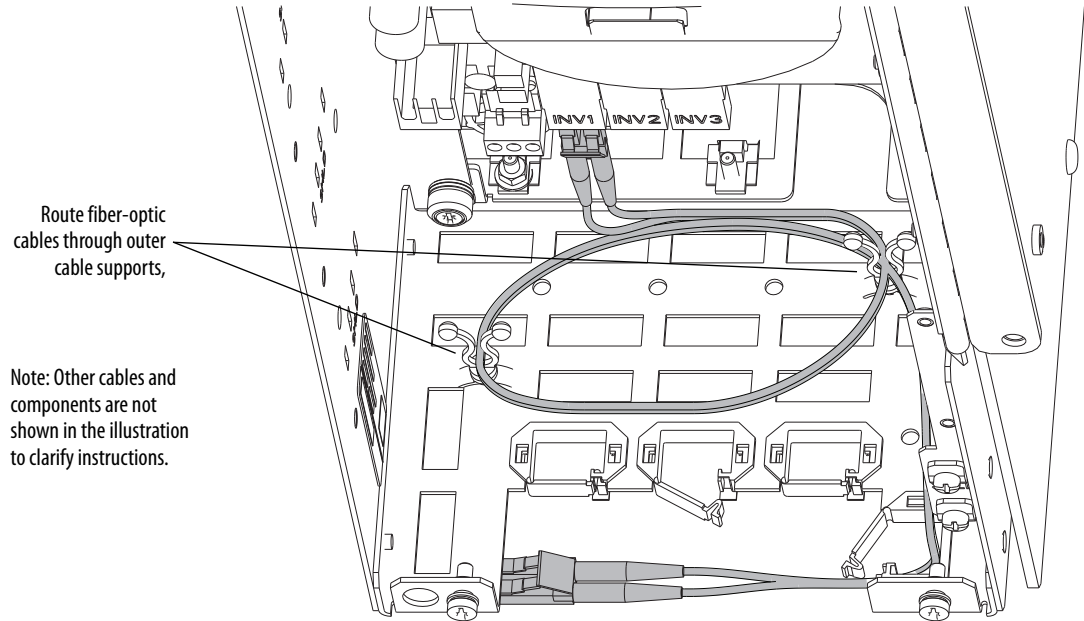
Install the fiber-optic cable set in the reverse order of removal. See Remove the Fiber-optic Cable (Frame 8) on page 61.

IMPORTANT Frame 8 fiber-optic cables that connect the fiber interface and converter gate boards to the power layer interface board must be the same length. Cables are 560 mm (22 in.) long to meet this requirement.

- Install the new fiber-optic cables from the converter gate board to the power layer interface board by using the two center cable supports provided, as shown in this illustration.



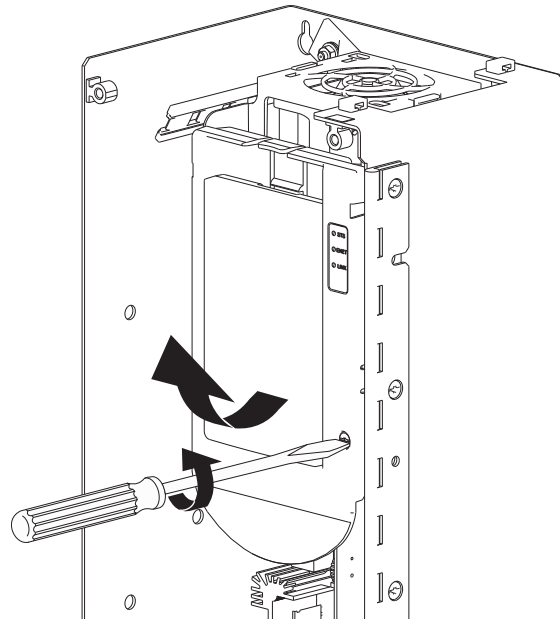
- Install the new fiber-optic cables from the fiber interface board to the power layer interface board by using the two, outer-most cable supports provided, as shown in this illustration.



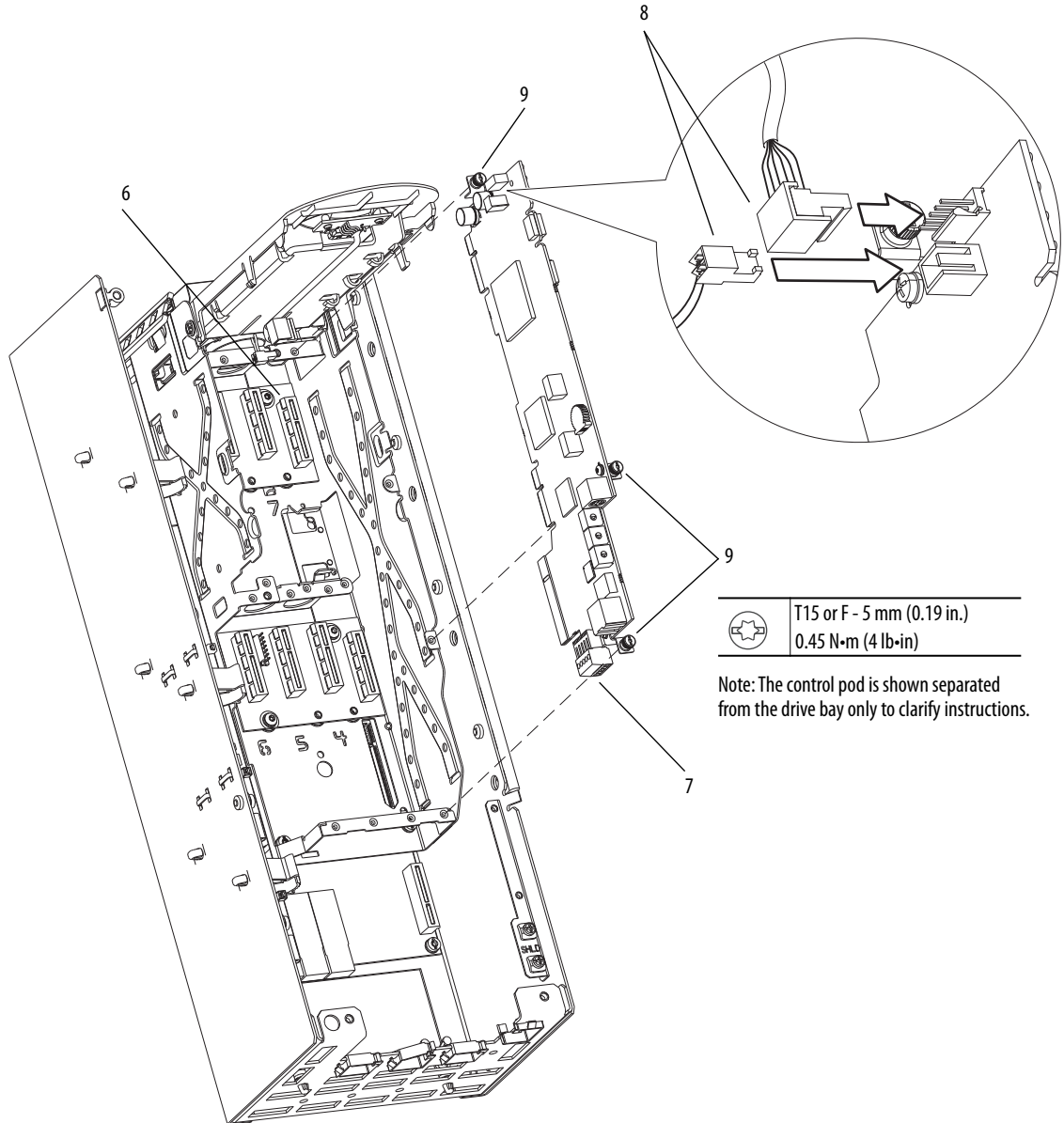
Main Control Board Removal/ Installation **Remove the Main Control Board (Control Pod in Drive Enclosure)**

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the control pod cover. See Control Pod Cover Removal/ Installation on page [59](#).

5. Loosen the retention screw that secures the HIM cradle to the control pod frame and swing the cradle upward until the latch engages.



6. If installed, remove the option module in slot 7, by loosening the two captive thumb screws on the module and by pulling the board out of the control pod. The torque requirement for installation is the same as for the main control board.
7. Disconnect the plug-in terminal block (TB1) on the main control board.
8. Disconnect the HIM and stirring fan power wire connectors from the main control board.
9. Loosen the three captive thumb screws and remove the board.



Install the Main Control Board

Install the Main Control board in the reverse order of removal. See Remove the Main Control Board (Control Pod in Drive Enclosure) on page [65](#).

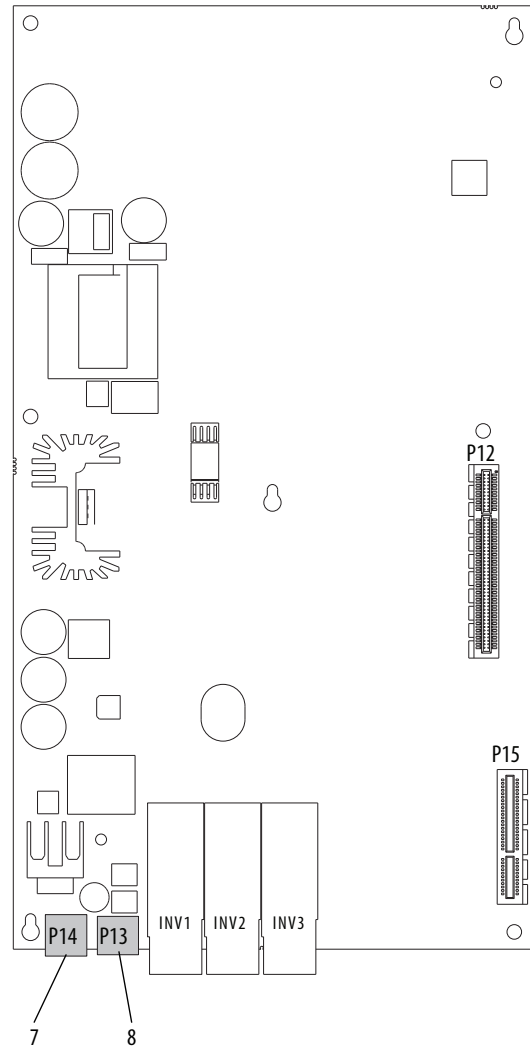
IMPORTANT Verify that the main control board seats properly into the connectors on the backplane and fiber interface boards when installing a new board.

Control Pod Removal/ Installation

Remove the Control Pod

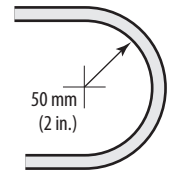
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the converter left cover. See Remove the Converter Left Cover on page [87](#).
5. Remove the control pod cover. See Control Pod Cover Removal/Installation on page [59](#).
6. Remove the inverter circuit board connections cover from the inverter. See Inverter Circuit Board Connections Cover Removal/Installation on page [238](#).

7. Disconnect the J14 connector from the fiber interface board P14 terminal.
8. If installed, disconnect the customer supplied 24V supply power wiring from the fiber interface board P13 terminal.

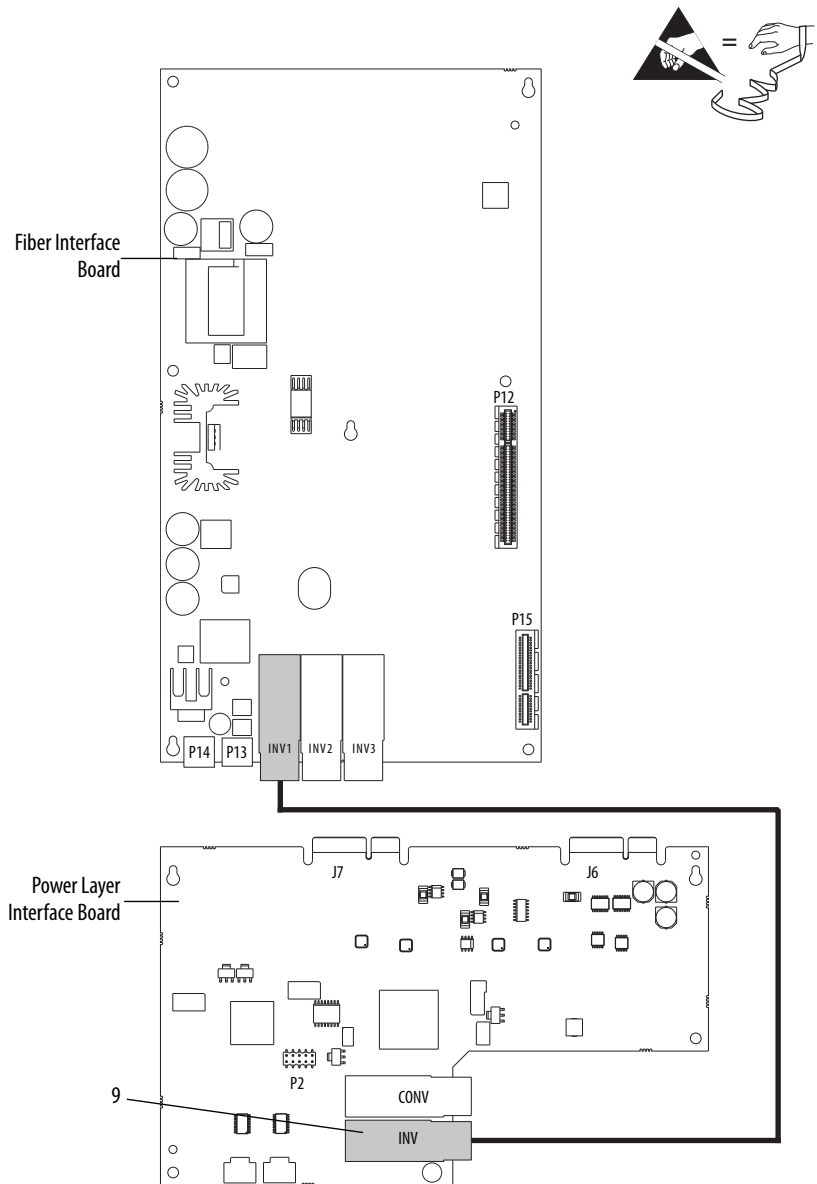


IMPORTANT

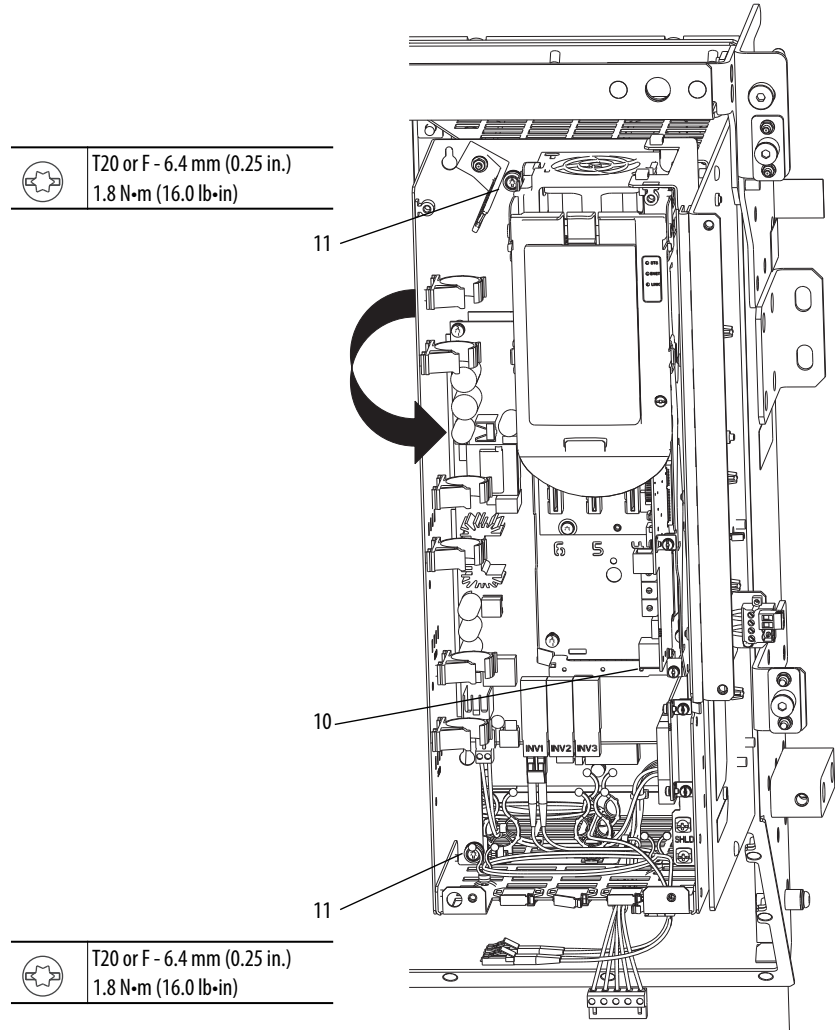
Minimum inside bend radius for fiber-optic cable is 50 mm (2 in.). Any bends with a shorter inside radius can permanently damage the fiber-optic cable. Signal attenuation increases with decreased inside bend radii.



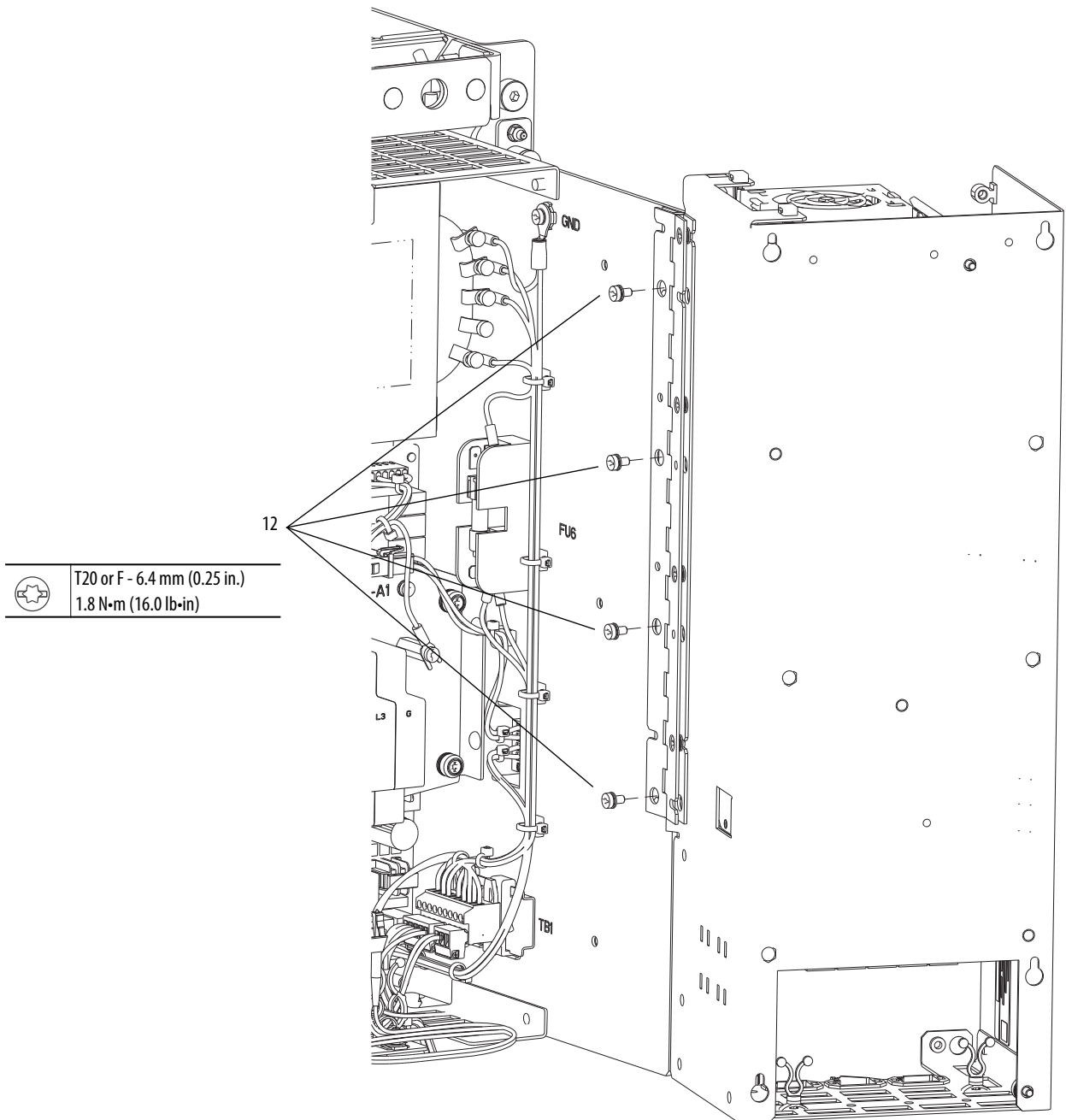
9. Disconnect the fiber-optic cable from INV on the power layer interface board in the inverter card cage. Place the cable ends on the bottom of the control pod and follow the minimum bend radius requirement



10. If installed, disconnect the plug-in terminal block (TB1) on the main control board.
11. Loosen the two M4 captive panel fasteners that secure the control pod to the converter control panel and rotate the assembly forward to the right.



12. Remove the four M4 x 12 mm screws that secure the control pod to the converter control panel, right-side wall and remove the control pod.



Install the Control Pod

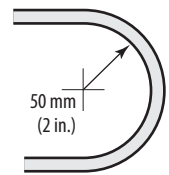
Install the control pod in the reverse order of removal. See Remove the Control Pod on page [68](#).

Fiber Interface Board Removal/Installation

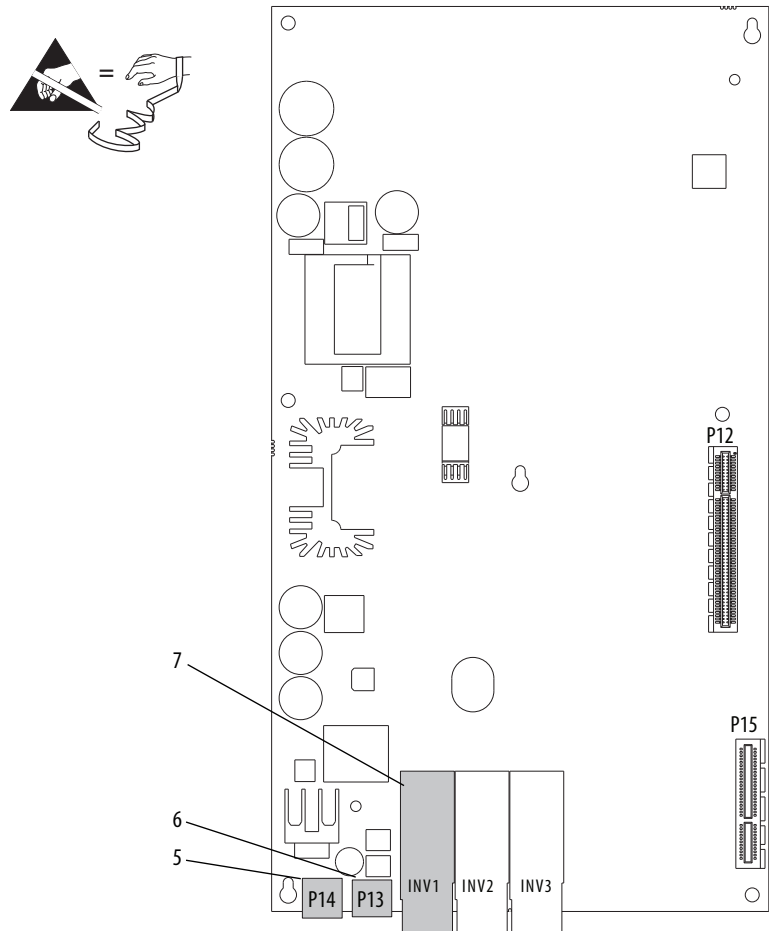
Remove the Fiber Interface Board

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the control pod cover. See Control Pod Cover Removal/Installation on page [59](#).
5. Disconnect the J14 connector from the fiber interface board P14 terminal.
6. If installed, disconnect the customer supplied 24V supply power wiring from the fiber interface board P13 terminal.

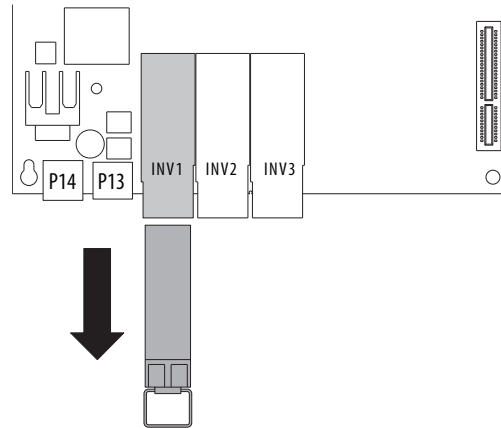
IMPORTANT Minimum inside bend radius for fiber-optic cable is 50 mm (2 in.). Any bends with a shorter inside radius can permanently damage the fiber-optic cable. Signal attenuation increases with decreased inside bend radii.



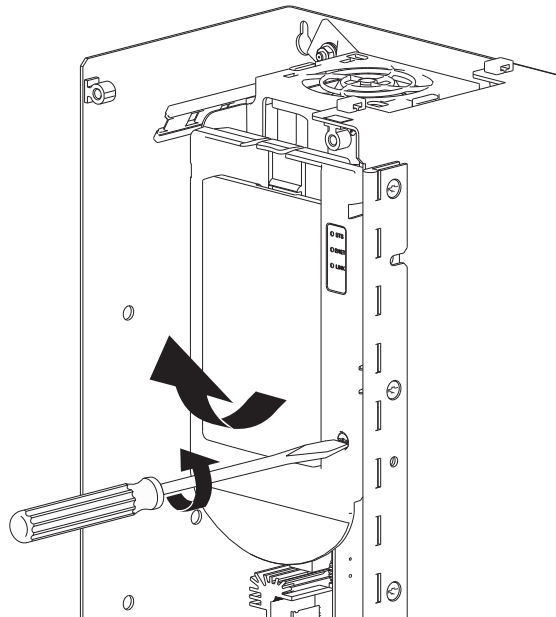
7. Disconnect the inverter fiber-optic cable from INV1 on the fiber interface board, carefully coil the fiber-optic cable, and place it in the bottom of the control pod. Follow the minimum bend radius requirement.



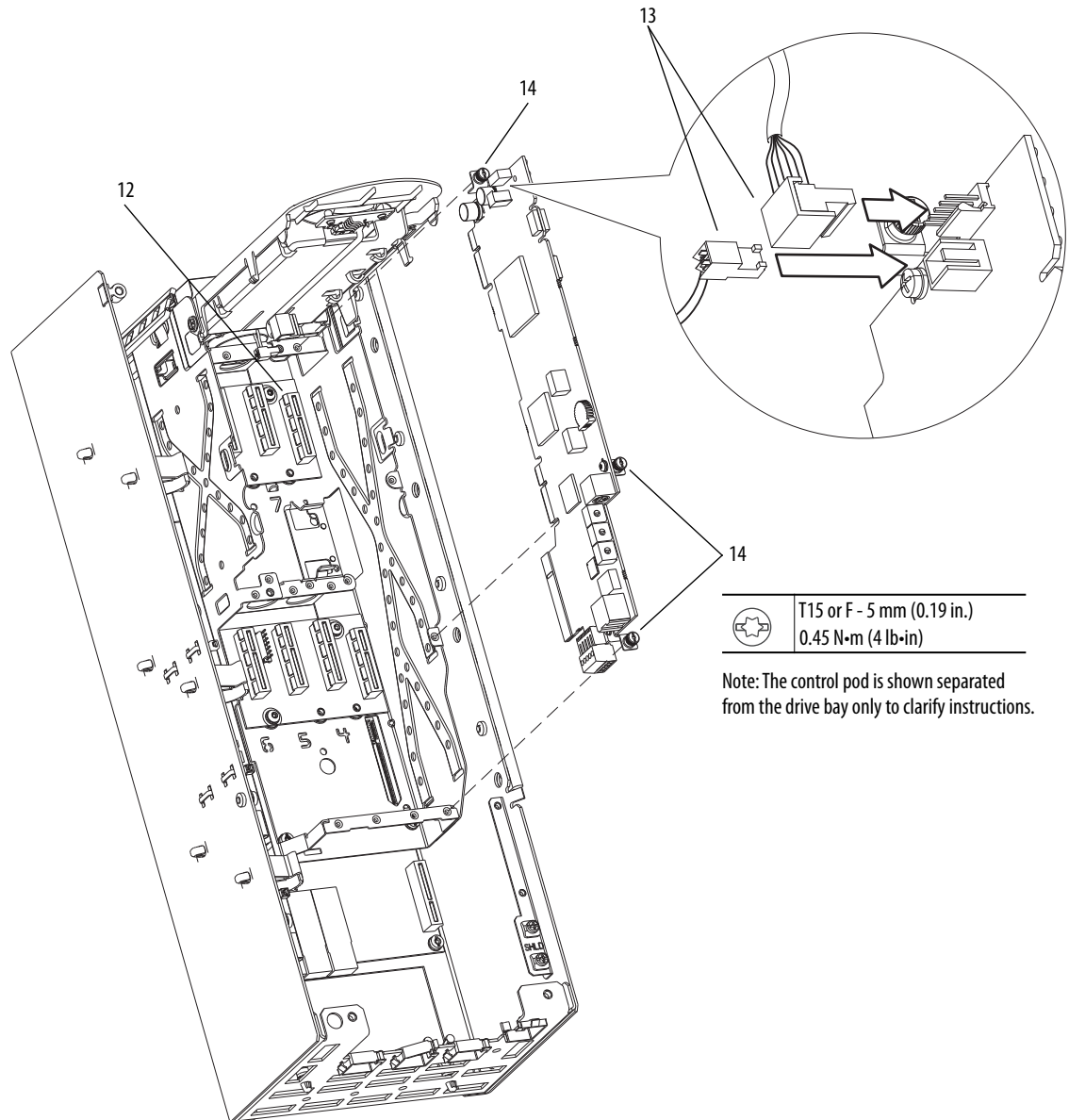
8. From fiber-optic cage INV1 on the fiber interface board, remove the transceiver by pulling its wire latch. Set the transceiver aside and save for reinstallation.



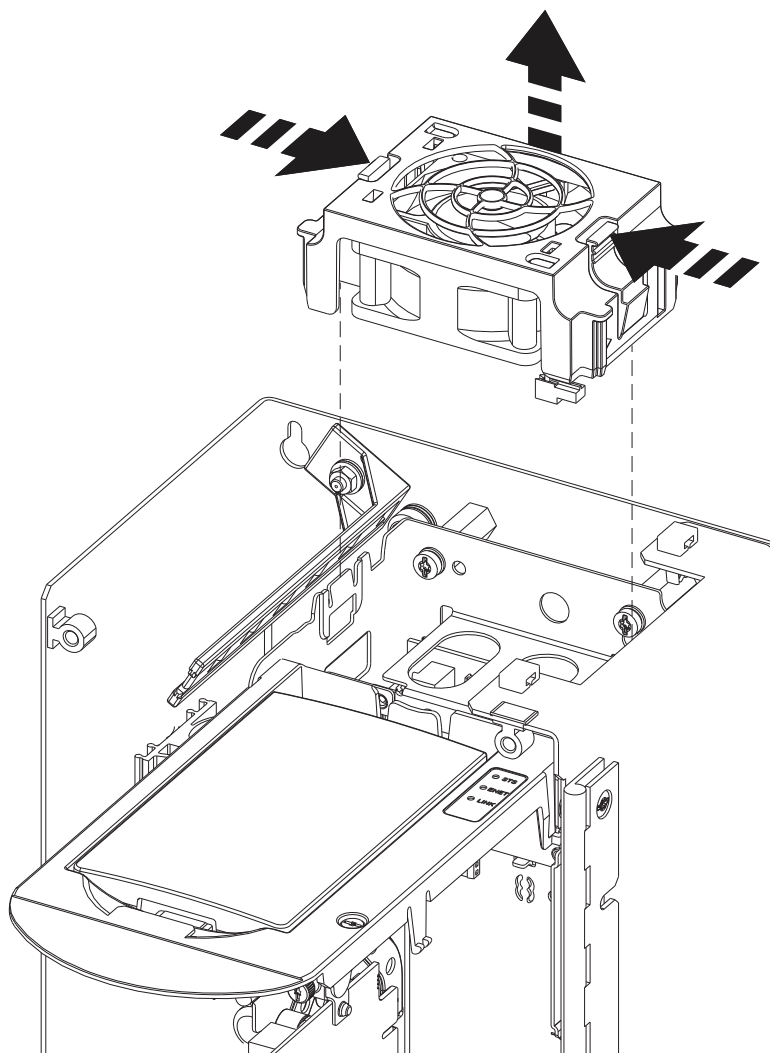
9. Loosen the retention screw that secures the HIM cradle to the control pod frame and swing the cradle upward until the latch engages.
10. Disconnect all wiring to the main control-board terminal block (TB1).
11. If installed, disconnect all wiring to all option module terminal blocks.



12. If installed, remove the option module in slot 7, by loosening the two captive thumb screws on the module and by pulling the board out of the control pod. The torque requirement for installation is the same as for the main control board.
13. Disconnect the HIM and stirring fan power wire connectors from the main control board.
14. Loosen the three captive thumb screws and remove the board.



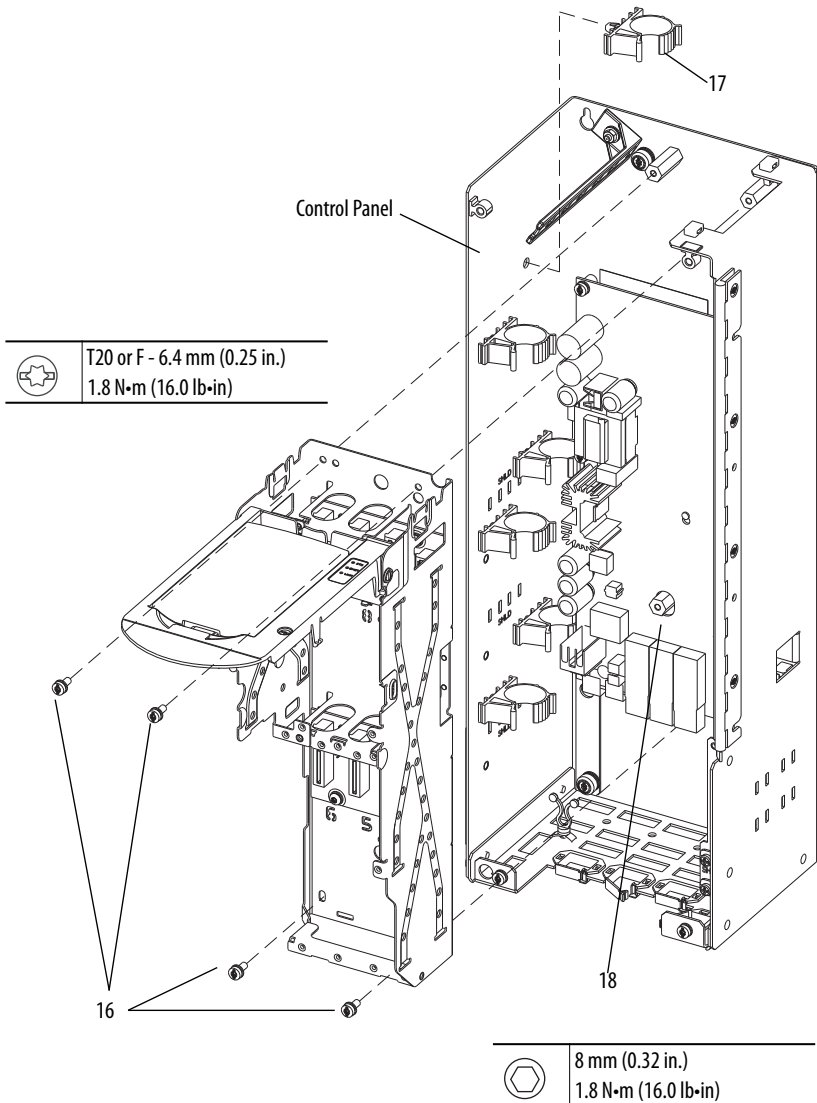
15. Press the two tabs on the sides of the fan housing inward, and remove the stirring fan assembly from the top of the control pod chassis.



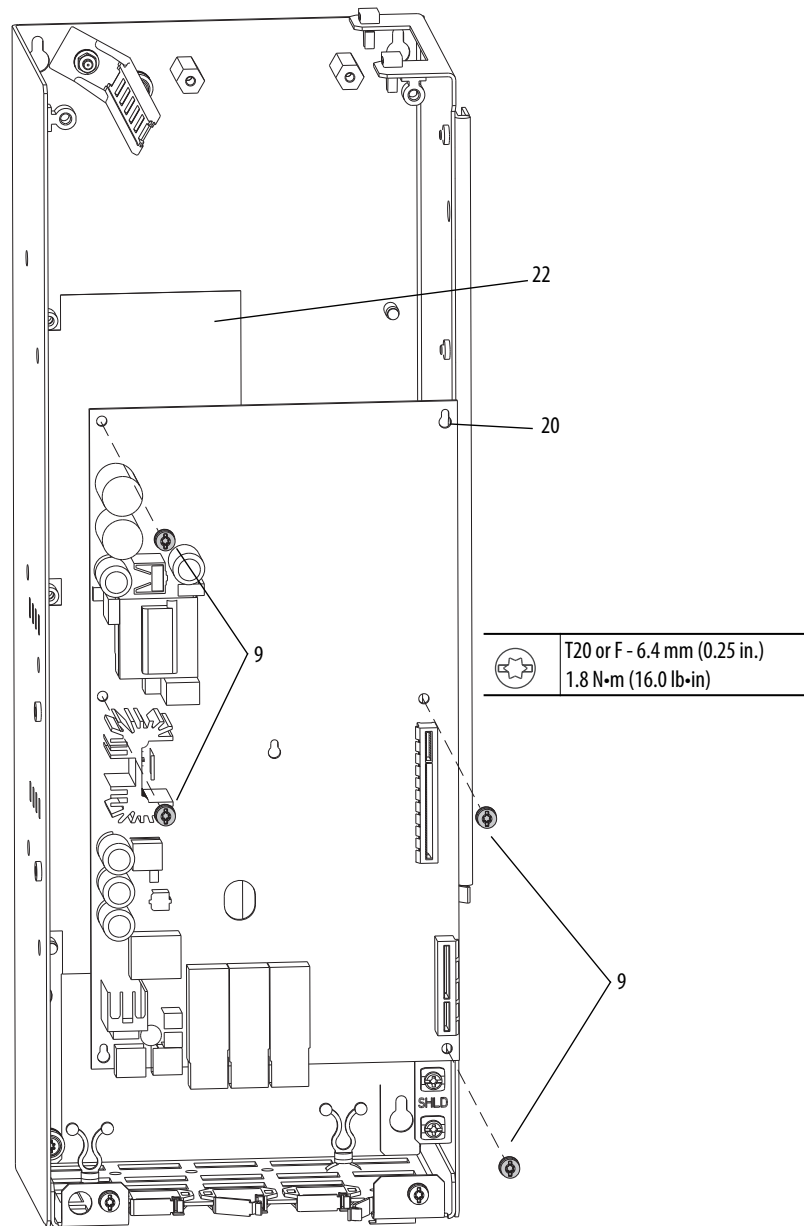
16. Remove the four M4 x 12 mm screws that secure the control pod chassis to the standoffs on the control panel, then remove control pod chassis.

IMPORTANT The four M4 x 12 mm screws that secure the control pod chassis to the control panel are not retentive. Take steps to be sure that the screws do not fall into the drive below.

17. Remove all routed wiring and six anchors from the left sidewall of the control panel and move the wiring to the outside of the control panel.
18. Remove the M4 hex stand from the center of the fiber interface circuit board.



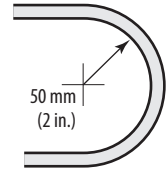
19. Remove the four M4 x 10 mm long screws that secure fiber interface board to the control pod.
20. Move the fiber interface board slightly upward toward top of the control pod, so that keyholes on board clear the mounting posts and lift off the board.



21. The right side of the board must clear the mounting tab in right sidewall of the control pod. Slowly rotate the left side of fiber interface board away from the control pod. Remove the board from the control pod.
22. Inspect the fiber interface board-insulator sheet and replace it if damaged.

Install the Fiber Interface Board

IMPORTANT Minimum inside bend radius for fiber-optic cable is 50 mm (2 in.). Any bends with a shorter inside radius can permanently damage the fiber-optic cable. Signal attenuation increases with decreased inside bend radii.



Install the fiber interface board in the reverse order of removal. See Remove the Fiber Interface Board on page [73](#).

IMPORTANT The insulator sheet must be installed behind the fiber interface board. When installing the fiber-optic cable, be sure that the wire latch is down.

Notes:

Converter Component Replacement Procedures

Topic	Page
Converter Components Identification	82
Converter Left Cover Removal/Installation	87
Converter Right Cover (No Control Pod) Removal/Installation	88
Control Pod Rotation	88
Control Transformer Primary Fuses Removal/Installation	91
Control Transformer Secondary Fuse Removal/Installation	92
Converter EMC Filter Circuit Board Removal/Installation	93
Converter Input Fuse Stirring Fan Removal/Installation	95
AC Line Fuse Sense Wire Harness Removal/Installation	97
AC Line Fuse Removal/Installation	99
DC Bus Sense Wire Harness Removal/Installation	101
Converter Current Sensor Wire Harness Removal/Installation	103
Converter Current Sensors Removal/Installation	105
Converter SCR Gate Wire Harness Removal/Installation	109
Converter SCR Assembly Removal/Installation	111
Converter Heat Sink Gasket Replacement	120
Inverter Power-supply Wire Harness Removal/Installation	121
AC Line Wire Harness Removal/Installation	123
Surge-suppressor Sense Wire Harness Removal/Installation	125
Surge Suppressor Removal/Installation	126
Surge Suppressor Assembly Removal/Installation	127
Converter Gate Board Stirring Fan Removal/Installation	131
24V/240V Power Wire Harness Removal/Installation	132
Control-transformer Primary Wire Harness Removal/Installation	138
Control Transformer Removal/Installation	140
No DC Bus Fuse Wire Harness Removal/Installation (Frame 8 Drives Only)	143
DC Bus Fuse Wire Harness Removal/Installation (Frame 9 and Larger Drives Only)	144
Control Power Isolator Board 24V Wire Harness Removal/Installation (600/690V AC Input Drives Only)	146
Control Power Isolator Board Removal/Installation (600/690V AC Input Drives Only)	148
Converter Gate Circuit Board Removal/Installation	149
Converter Removal/Installation	152
Converter Duct Gasket Replacement	155

This chapter provides detailed procedures for how to remove and replace converter components.

TIP In some illustrations in this chapter, the converter and/or control pod are shown removed from the drive to clarify the instructions only. Only remove the converter and/or control pod from the drive if directed to do so.

IMPORTANT Complete the procedures in Chapter 12 Drive Startup after Repairs that begin on page 419 before placing the drive back into service.

Converter Components Identification

Table 11 contains the components that comprise the converter assembly and provides the following information for each component, if applicable:

- Kit catalog number or part number
- Quantity that is contained in the kit
- Illustration figure and page number and identification number

See PowerFlex Architecture Class Low Voltage Drives Spare Parts Options, publication [PFLEX-SB002](#) for a complete list of spare parts for PowerFlex® 755 Frame 8...10 and larger drives.

Table 11 - Converter Replacement Kits/Parts

Component Description	Replacement Kit Cat. No. or Part No.	Quantity	Figure and Page	ID No.
AC Drive Converter Unit, 400V, 770 A / 480V, 740 A	20-750-C1-C770D740 (Series A) 20-750-C6-C770D740 (Series B)	1	–	
AC Drive Converter Unit, 600V, 510 A / 690V, 500 A	20-750-C6-E510F500 (Series B)	1	–	
Control Transformer Fuses for 400/480V AC Input Drives, with Converter Cat. No. 20-750-C1-C770D740...20-750-C5-C770D740	SK-R1-FUSE2-CD-F8	–		
Fuse, 8 A, 600V, IEC Class gG/gI, 14 x 51 mm (FU4 / FU5)		2	Figure 9 on page 85	1
Fuse, 5 A, 600V, Class CC, Time-Delay (FU6)		1	Figure 10 on page 86	2
Control Transformer Fuses for 400/480V AC Input Drives, with Converter Cat. No. 20-750-C6-C770D740	SK-R1-FUSE4-CD-F8	–		
Fuse, 6 A, 600V, IEC Class gG/gI, 14 x 51 mm (FU4 / FU5)		2	Figure 9 on page 85	1
Fuse, 5 A, 600V, Class CC, Time-Delay (FU6)		1	Figure 10 on page 86	2
Control Transformer Fuses Kit for 600/690V AC Input Drives with Converter Cat. No. 20-750-C2-E510F500...20-750-C5-E510F500	SK-R1-FUSE2-EF-F8	–		
Fuse, 6 A, 690V, IEC Class gG/gI, 14 x 51 mm (FU4 / FU5)		2	Figure 9 on page 85	1
Fuse, 5 A, 600V, Class CC, Time-Delay (FU6)		1	Figure 10 on page 86	2
Control Transformer Fuses Kit for 600/690V AC Input Drives with Converter Cat. No. 20-750-C6-E510F500	SK-R1-FUSE4-EF-F8	–		
Fuse, 8 A, 690V, IEC Class gG/gI, 14 x 51 mm (FU4 / FU5)		2	Figure 9 on page 85	1
Fuse, 5 A, 600V, Class CC, Time-Delay (FU6)		1	Figure 10 on page 86	2

Table 11 - Converter Replacement Kits/Parts (continued)

Component Description	Replacement Kit Cat. No. or Part No.	Quantity	Figure and Page	ID No.
AC Line Fuse Kit 1100 A, 400/480V AC Input Drives	SK-R1-FUSE1-CD-F8	–		
Fuse, 690/700V, 1100 A		1	Figure 9 on page 85	3
Fuse Indicator		1	Figure 9 on page 85	4
AC Line Fuse Kit 900 A, 600/690V AC Input Drives	SK-R1-FUSE1-EF-F8	–		
Fuse, 690/700V, 900 A		1	Figure 9 on page 85	4
Fuse Indicator		1	Figure 9 on page 85	3
Converter EMC Filter Board, 400/480V and 600/690V AC Input Drives	SK-R1-EMCFLT2-F8 (Series B)	1	Figure 9 on page 85	5
Frame 8 Converter Wire Harness Kit	SK-R1-CNVH1-F8	–		
AC Line Fuse Wire Harness		1	Figure 9 on page 85	6
Control Transformer Primary Wire Harness		1	Figure 9 on page 85	7
DC Bus Sense Wire Harness		1	Figure 9 on page 85	8
No DC Bus Fuse Wire Harness		1	Figure 10 on page 86	9
Surge Suppressor Sense Wire Harness		1	Figure 10 on page 86	10
24V/240V Power Wire Harness		1	Figure 10 on page 86	11
Inverter Power Supply Wire Harness		1	Figure 10 on page 86	12
Assembly, External NTC		1	Figure 9 on page 85	13
Converter SCR Gate Wire Harness		1	Figure 9 on page 85	14
Converter Current Sensor Wire Harness		1	Figure 9 on page 85	15
AC Line Wire Harness		1	Figure 10 on page 86	16
Converter SCR Assembly, 400/480V AC Input Drives	SK-R1-SCR1-CD-F8	1	Figure 9 on page 85	17
Converter SCR Assembly, 600/690V AC Input Drives	SK-R1-SCR1-EF-F8	1	Figure 9 on page 85	17
Converter Current Sensor, 400/480V and 600/690V AC Input Drives	SK-R1-CNVIFB2-F8 (Series B)	1	Figure 9 on page 85	18
Control Transformer	SK-R1-XFMR1-F8	1	Figure 10 on page 86	19
Converter Surge Suppressor, 400/480V AC Input Drives	SK-R1-MOV1-CD-F8	1	Figure 10 on page 86	20
Converter Surge Suppressor, 600/690V AC Input Drives	SK-R1-MOV1-EF-F8	1	Figure 10 on page 86	20
Converter Gate Board, 400/480V AC Input Drives (Includes a fiber-optic transceiver)	SK-R1-CGDB1-CD-F8 (Series A) SK-R1-CGDB4-CD-F8 (Series B)	1	Figure 10 on page 86	21
Converter Gate Board, 600/690V AC Input Drives (Includes a fiber-optic transceiver)	SK-R1-CGDB4-EF-F8	1	Figure 10 on page 86	21
Fiber-optic Cable, 560 mm (22 in.) Long Kit (Frame 8 Drives)	20-750-FCBL1-F8	–		
Fiber-optic Cable, 560 mm (22 in.) Long		2	Figure 10 on page 86	22
Cable Labels (CONV and INV)		2	–	
Fiber-optic Cable, 2.8 m (110 in.) Long Kit ⁽¹⁾	20-750-FCBL1-F10	–		
Fiber-optic Cable, 2.8 m (110 in) Long		1	(See page 397 for more information)	22
Cable Labels (INV1, INV2, INV3)		3	–	
Fiber-optic Transceiver	SK-R1-FTR1-F8	1	Figure 10 on page 86	23
Converter Left Front Cover with Side Shield	SK-R1-CCVR1-F8	1	Figure 9 on page 85	24

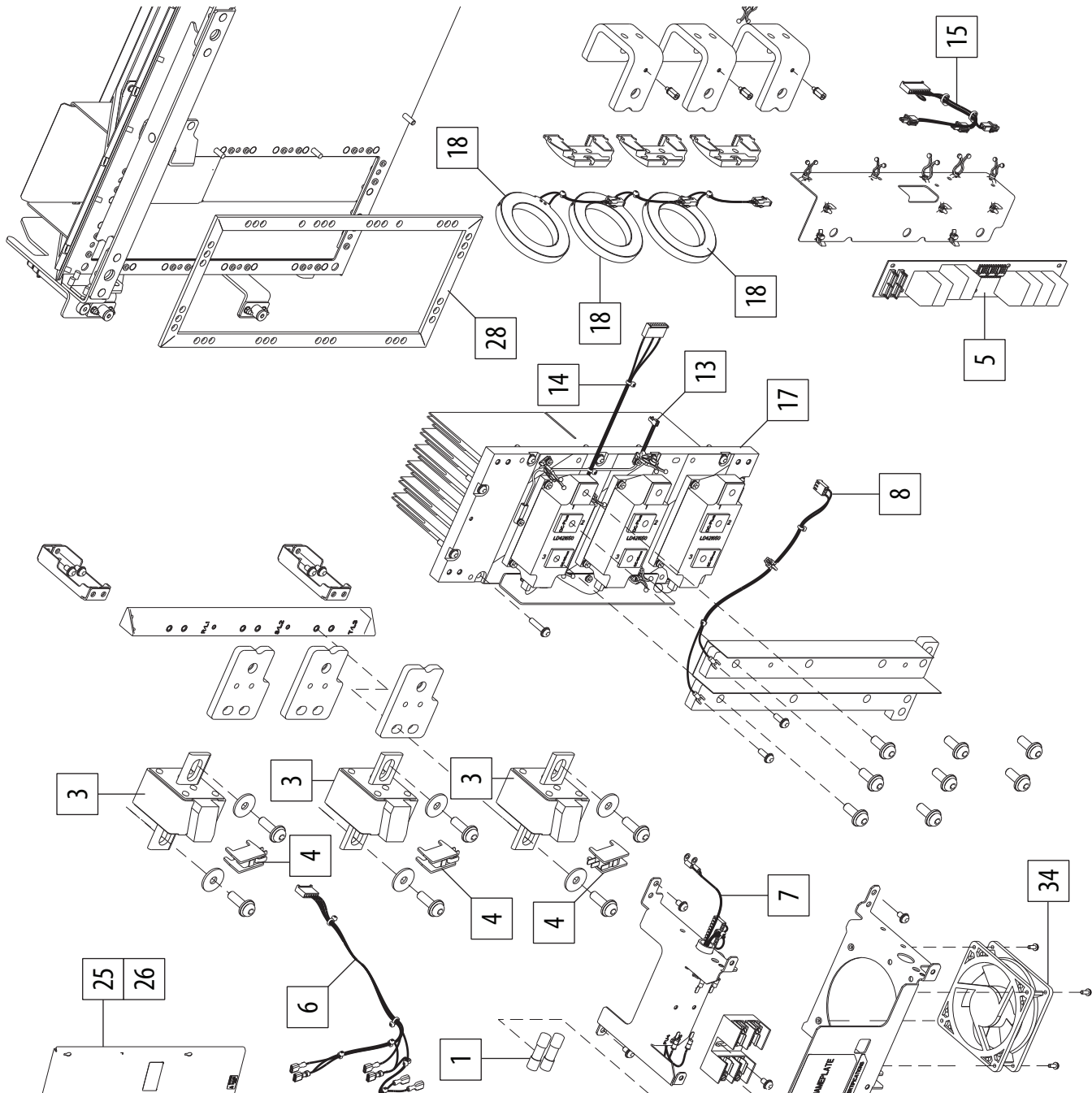
Table 11 - Converter Replacement Kits/Parts (continued)

Component Description	Replacement Kit Cat. No. or Part No.	Quantity	Figure and Page	ID No.
Converter Right Front Cover (No Control Pod) Kit	SK-R1-CCVR2-F8	–		
Right Front Cover		1	Figure 9 on page 85	25
Bracket Cover, 82 mm (3.2 in.) Long		2	Figure 9 on page 85	26
One Bay 24V Wire Harness Kit (Frame 8)	20-750-PH1-F8	1	Figure 10 on page 86	27
Two Bay 24V Wire Harness Kit (Frame 9)	20-750-PH2-F9	1	Figure 10 on page 86	27
Three Bay 24V Wire Harness Kit (Frame 10)	20-750-PH3 -F10	1	Figure 10 on page 86	27
Frame 8 Gasket Kit	20-750-G1-F8	–		
Gasket, Converter, Heatsink		1	Figure 9 on page 85	28
Gasket, Converter/DC Input with Precharge Assembly, Duct		1	Figure 10 on page 86	29
Gasket, Inverter, Heatsink		1	(2)	–
Gasket, Inverter, Door Interface		1	(1)	–
Gasket, Inverter, Exhaust Interface		1	(1)	–
Gasket, Inverter, Inlet Ring		1	(1)	–
Gasket, Inverter, No Choke		1	(1)	–
Gasket, Inverter, Blower Box Bottom		1	(1)	–
Gasket, Inverter, Choke		1	(1)	–
DC Bus Fuse Wire Harness Kit (Frame 9 AC Input Drives Only)	SK-R1-DCBUSH1-F9	1	Figure 10 on page 86	30
Control Power Isolator Board Kit, 600/690V AC Input Drives	SK-R1-CPIB1-F8	1	Figure 9 on page 85	31
Control Power Isolator 24V Wire Harness Kit, 600/690V AC Input Drives	SK-R1-CPIH1-F8	1	Figure 9 on page 85	32
Converter Gate Board Stirring Fan	20-750-CFANKIT-F8	1	Figure 10 on page 86	33
Converter Input Fuse Stirring Fan	SK-R1-FUSEFAN-F8	1	Figure 9 on page 85	34
Chassis mounting screw (4 captive screw sets, 4 long bolts)	SK-R1-PCSCREWS	1	Figure 10 on page 86	35

(1) Order 2 kits for frame 9 drives. Order 3 kits for frame 10 drives.

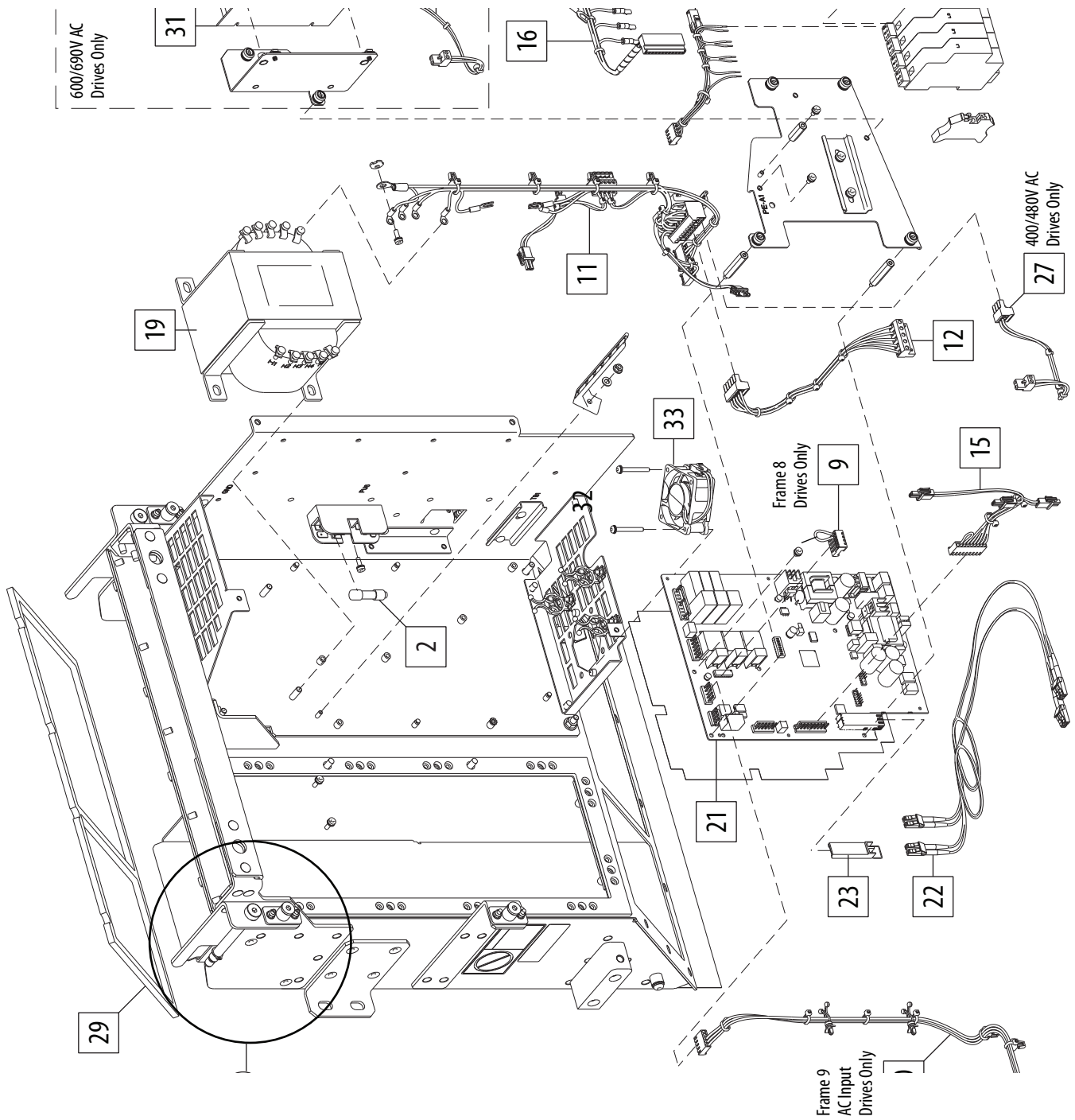
(2) This gasket is included in the Frame 8 Gasket Kit (20-750-G1-F8), but is identified in Chapter 7 - Inverter Component Replacement Procedures on page 81.

Figure 9 - Converter Assembly Components Diagram 1



Note: Covers shown at smaller scale than other components.

Figure 10 - Converter Assembly Components Diagram 2

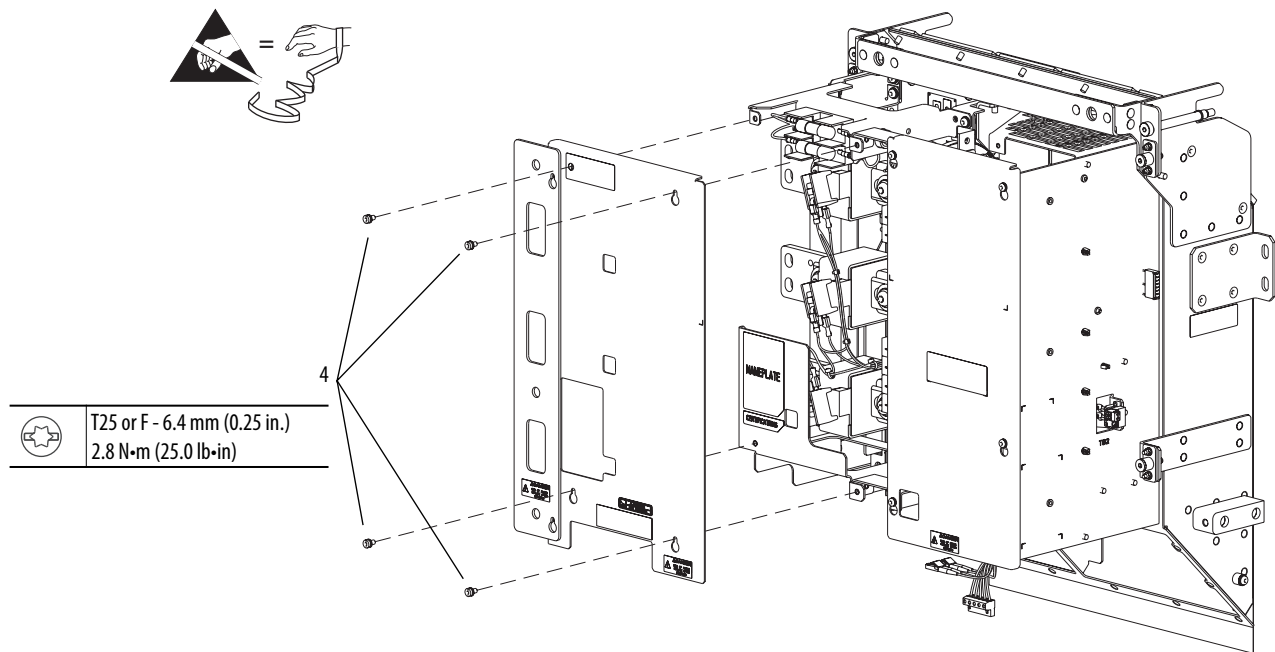


TIP See Fastener/Tool/Torque Information on page 33 for descriptions of the fasteners, tools, and torque figures that are used in the disassembly/assembly procedures in this chapter.

Converter Left Cover Removal/Installation

Remove the Converter Left Cover

1. Review the General Precautions on page 24.
2. Remove power from the drive. See Remove Power from the Drive on page 25.
3. Open the drive enclosure door.
4. Remove the four M5 x 14 mm screws that secure the cover to the assembly and remove the cover.



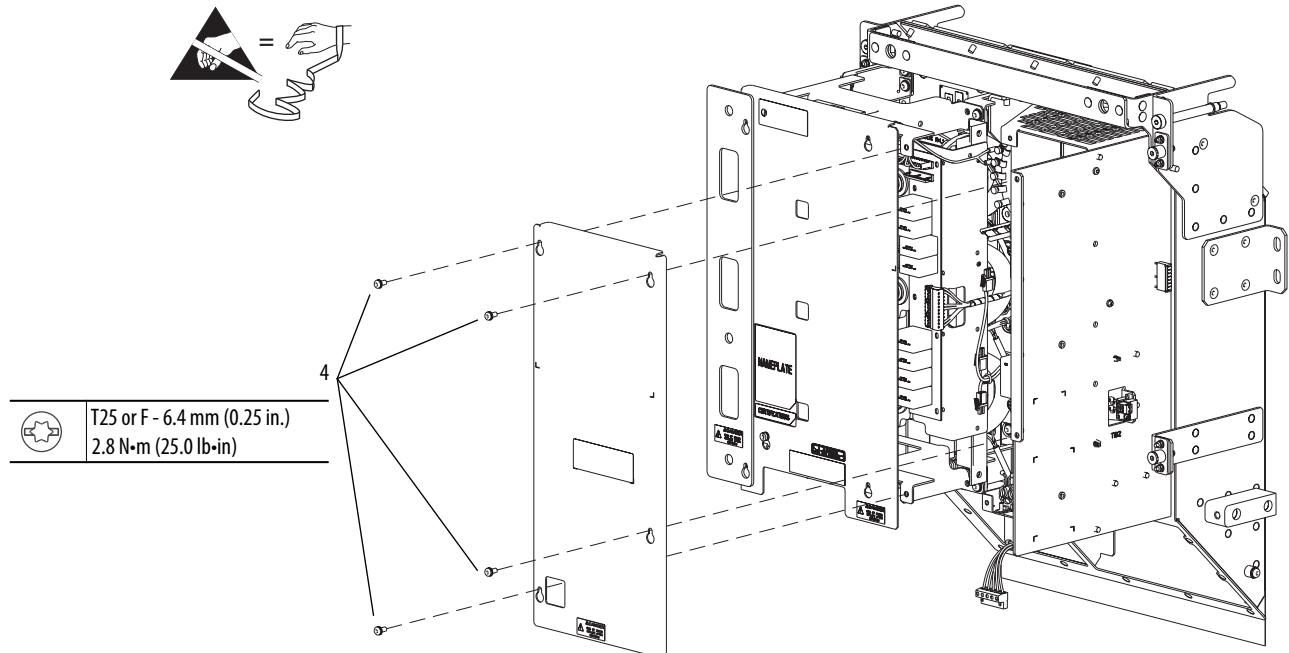
Install the Converter Left Cover

Install the converter cover in the reverse order of removal. See Remove the Converter Left Cover.

Converter Right Cover (No Control Pod) Removal/Installation

Remove the Converter Right Cover (No Control Pod)

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the four M5 x 14 mm screws that secure the cover to the assembly and remove the cover.



Install the Converter Right Cover (No Control Pod)

Install the converter cover (no control pod) in the reverse order of removal. See Remove the Converter Right Cover (No Control Pod).

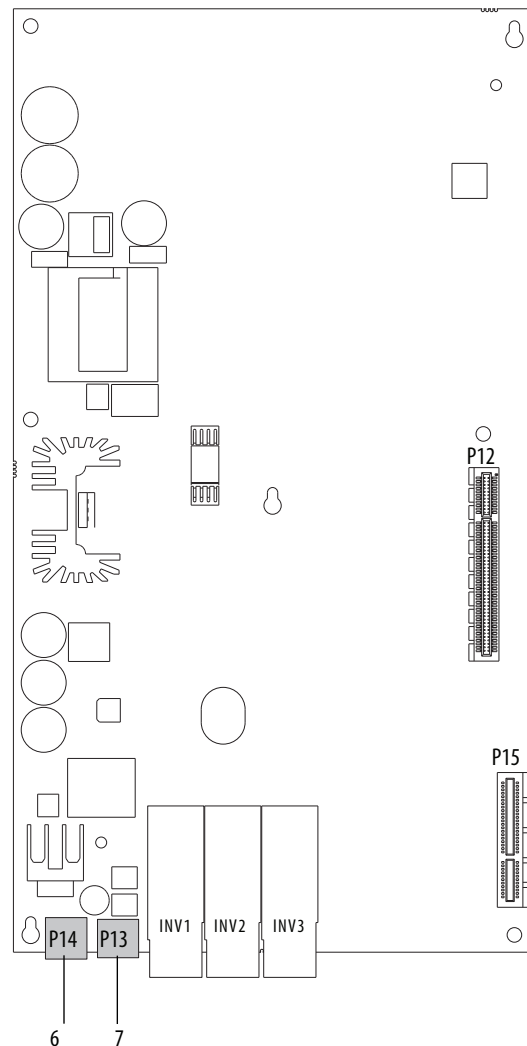
Control Pod Rotation

Rotate the Control Pod Forward

Use this procedure to move the control pod, when it is installed on the converter assembly, to access other components behind it.

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.

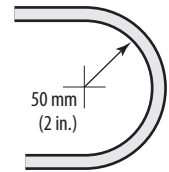
4. Remove the converter left cover or DC input with precharge assembly left cover, top guard, and left guard. See Remove the Converter Left Cover on page [87](#) or Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard on page [163](#).
5. Remove the control pod cover. See Remove the Control Pod Cover on page [59](#).
6. Disconnect the drive internal 24V wire harness J14 connector from the fiber interface board (in the control pod) P14 terminal.
7. If installed, disconnect the customer supplied 24V supply power wiring from the fiber interface board P13 terminal.



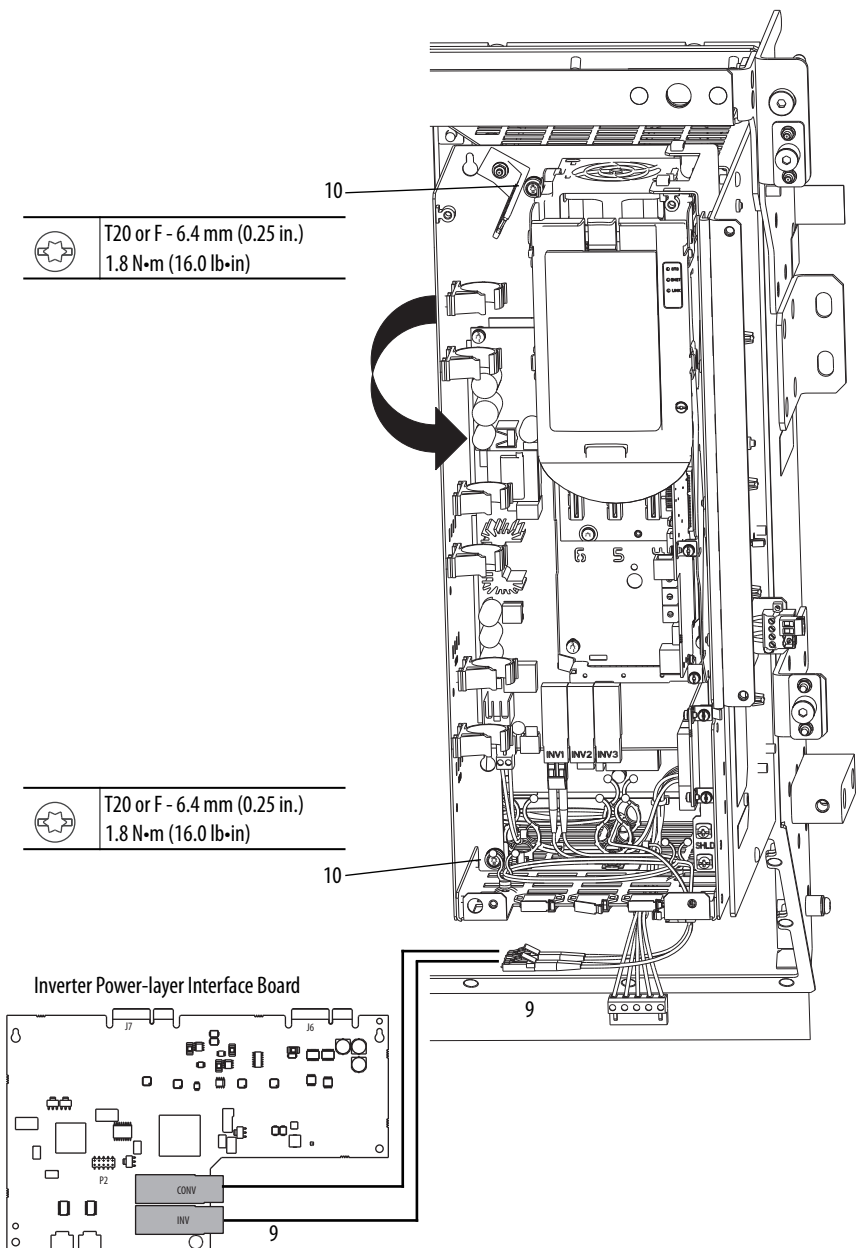
8. Remove the inverter circuit board connections cover from the inverter. See Inverter Circuit Board Connections Cover Removal/Installation on page [238](#).

IMPORTANT

Minimum inside bend radius for fiber-optic cable is 50 mm (2 in.). Any bends with a shorter inside radius can permanently damage the fiber-optic cable. Signal attenuation increases with decreased inside bend radii.



9. Disconnect the inverter fiber-optic cable from INV and the converter fiber-optic cable from CONV on the inverter power-layer interface board in the inverter card cage assembly. Place the cables on the bottom of the control pod and follow the minimum bend radius requirement. Verify that cable damage does not occur when moving the control pod.
10. Loosen the two M4 captive panel fasteners that secure the control pod to the converter control panel and rotate the control pod forward.



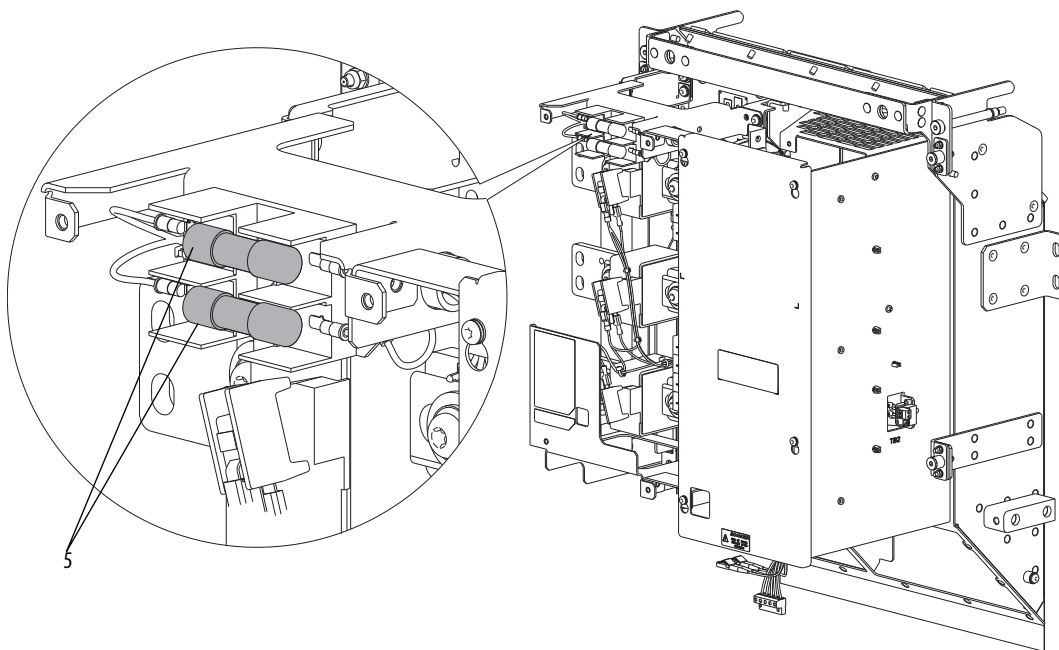
Return the Control Pod to the Service Position

Return the control pod to the service position in the reverse order. See Rotate the Control Pod Forward on page [88](#).

Control Transformer Primary Fuses Removal/Installation

Remove the Control Transformer Primary Fuses (FU4 and FU5)

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the converter left cover. See Remove the Converter Left Cover.
5. Remove the fuse from the two-position fuse holder by using a fuse puller.



Install the Control Transformer Primary Fuse (FU4 and FU5)

Install the control transformer primary fuse (FU4 and FU5) in the reverse order of removal. See Remove the Control Transformer Primary Fuses (FU4 and FU5).

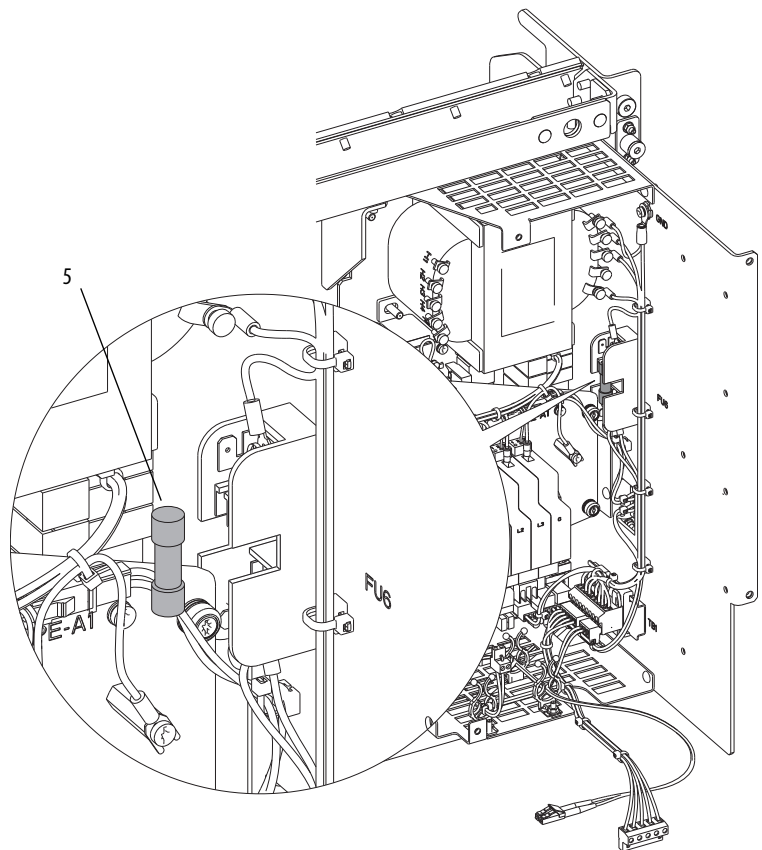
Control Transformer Secondary Fuse Removal/ Installation

Remove the Control Transformer Secondary Fuse (FU6)

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

5. Remove the fuse from the one-position fuse holder by using a fuse puller.



Install the Control Transformer Secondary Fuse (FU6)

Install the control transformer secondary fuse (FU6) in the reverse order of removal. See Remove the Control Transformer Secondary Fuse (FU6) on page [92](#).

Converter EMC Filter Circuit Board Removal/Installation

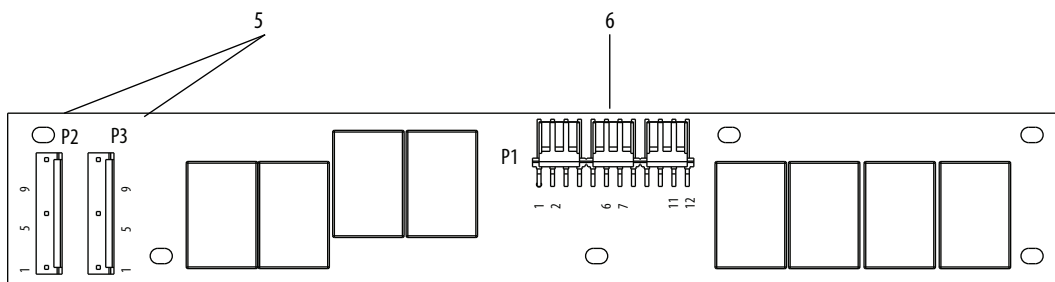
Remove the Converter EMC Filter Circuit Board

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left converter cover. See Remove the Converter Left Cover on page [87](#).

IMPORTANT Before you disconnect the J2/J3 connector from the EMC filter board, note the J2/J3 location. The P3 (PE-A2) terminal is grounded. The P2 terminal is not grounded.

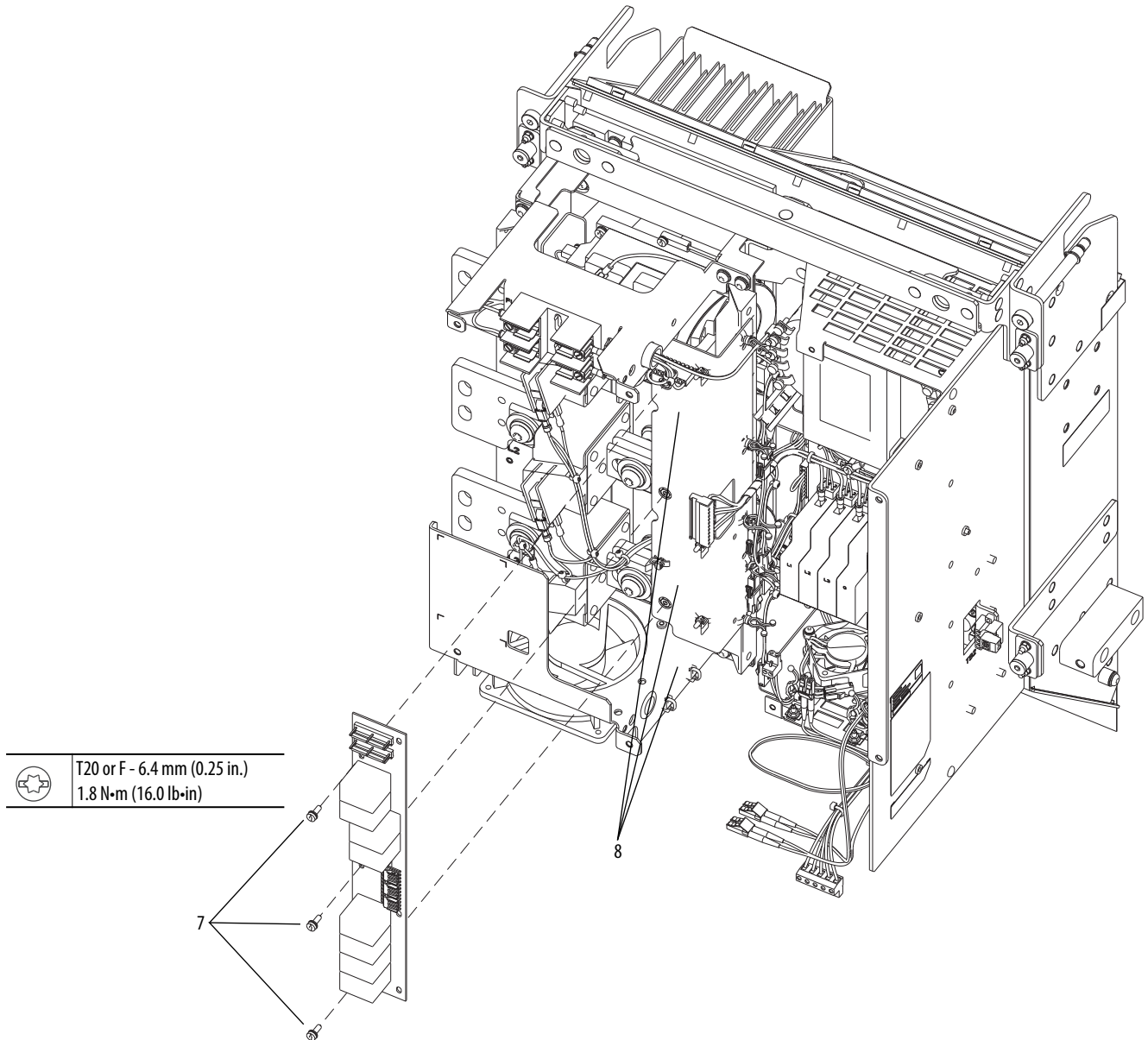
The jumper settings are provided in the PowerFlex 750-Series Power Jumpers Installation Instructions, publication [750-IN011](#), available at <http://www.rockwellautomation.com/literature/>.

5. Remove the J2/J3 connector from the P2 or P3 connector on the EMC filter board.
6. Remove the AC line wire harness J1 connector from the P1 connector on the EMC filter board P1 terminal.



Note: Board shown rotated 90° from actual installation position.

7. Remove the three M4 x 8 mm screws that secure the EMC filter board to the AC line bus bar.
8. Release the three board mounting clips along the right edge of the EMC filter board and remove the board.



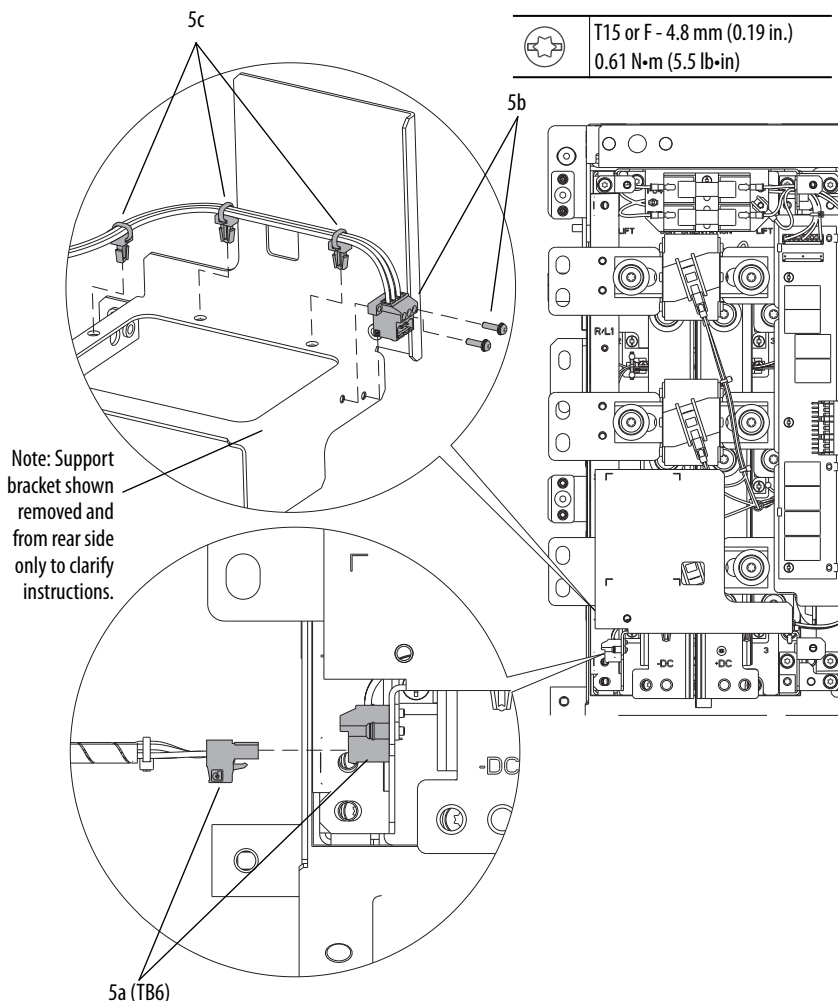
Install the Converter EMC Filter Circuit Board

Install the EMC filter board in the reverse order of removal. See Remove the Converter EMC Filter Circuit Board on page [93](#).

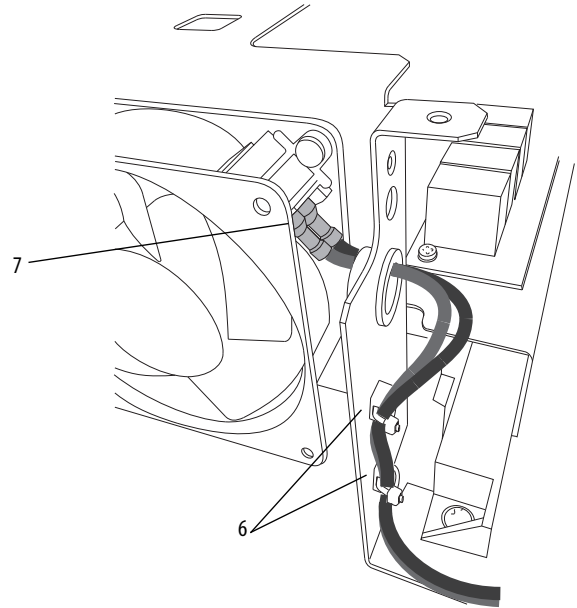
IMPORTANT Be sure that the J2/J3 connector is reassembled in the correct location (P2 or P3) on the EMC filter board.

Converter Input Fuse Stirring Fan Removal/Installation **Remove the Converter Input Fuse Stirring Fan**

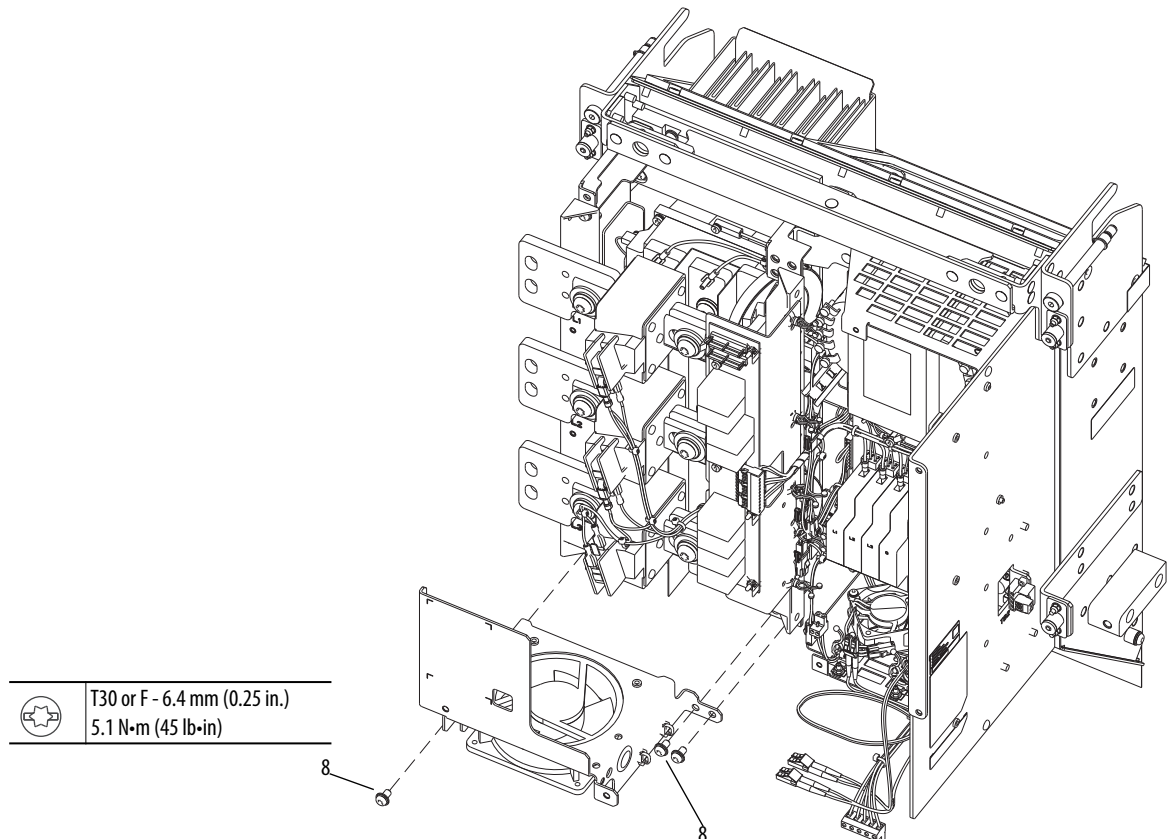
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left converter cover. See Remove the Converter Left Cover on page [87](#).
5. For frame 8 drives, continue with [step 6](#) on page [96](#). For frame 9 and larger drives only, complete these steps.
 - a. Disconnect the cabinet-side, three-position DC bus fuse wire harness connector from terminal block TB6 on the lower left side of the converter.
 - b. Remove the two M3 x 12 mm screws that secure the harness terminal block TB6 to the cover support bracket.
 - c. Disengage the three cable tie push mounts that secure the harness to the cover support bracket, and remove the harness.



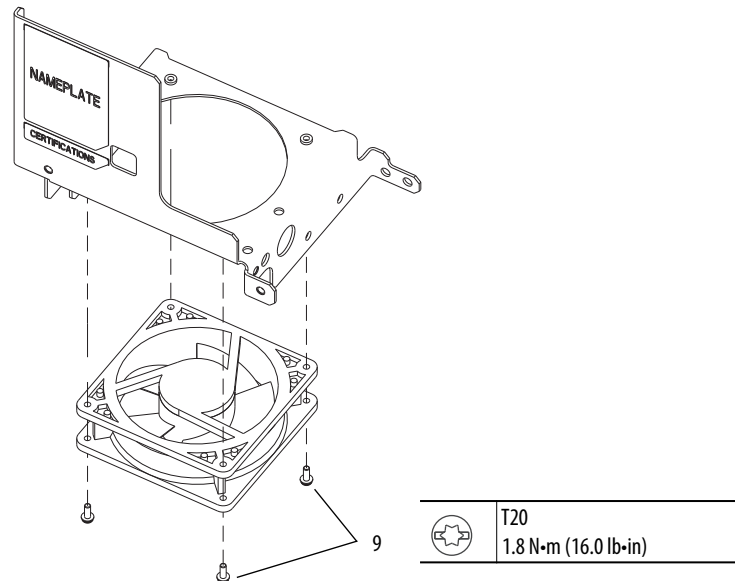
6. Disengage the two cable tie push mounts that secure the fan harness to the bracket.
7. Disconnect the Fan (+) and Fan (-) power wires from the fan terminals and pull the terminal wires through the hole in the bracket.



8. Remove the three M6 x 14 mm screws that secure the label bracket and stirring fan to the rail support and remove the bracket.



- Remove the four M4 x 12 mm hexalobular screws that secure the stirring fan to the support bracket and remove the stirring fan.



Install the Converter Input Fuse Stirring Fan

Install the stirring fan in the reverse order of removal. See Remove the Converter Input Fuse Stirring Fan on page [95](#).

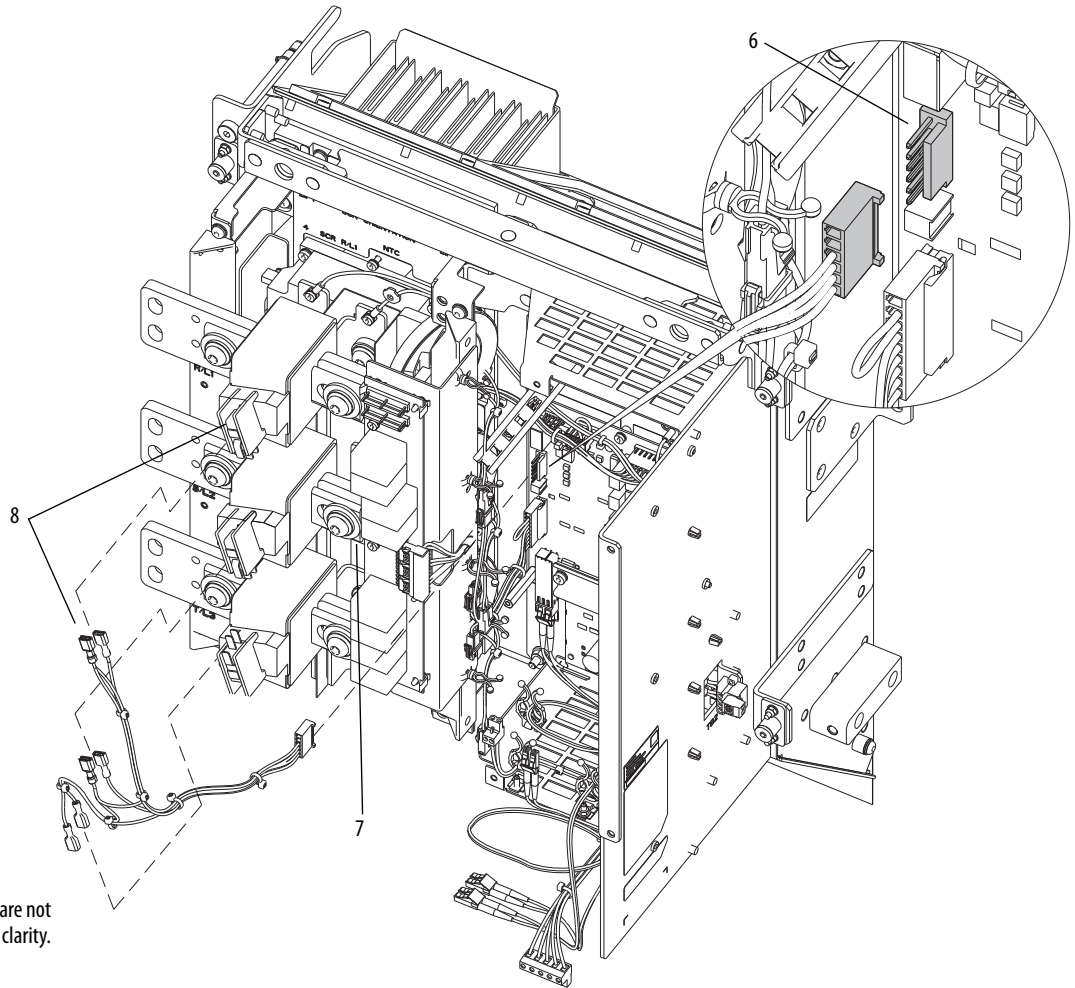
AC Line Fuse Sense Wire Harness Removal/ Installation

Remove the AC Line Fuse Sense Wire Harness

- Review the General Precautions on page [24](#).
- Remove power from the drive. See Remove Power from the Drive on page [25](#).
- Open the enclosure door.
- Remove the left converter cover. See Remove the Converter Left Cover on page [87](#).
- If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

6. Disconnect the AC line fuse sense wire harness J7 connector from the converter gate board P7 terminal.
7. Release the AC line fuse sense wire harness from the cable support on the left side of the bus bar support rail.
8. Disconnect the AC line fuse sense wire harness from the six AC line fuse indicator terminals and remove the AC line fuse sense wire harness.



Install the AC Line Fuse Sense Wire Harness

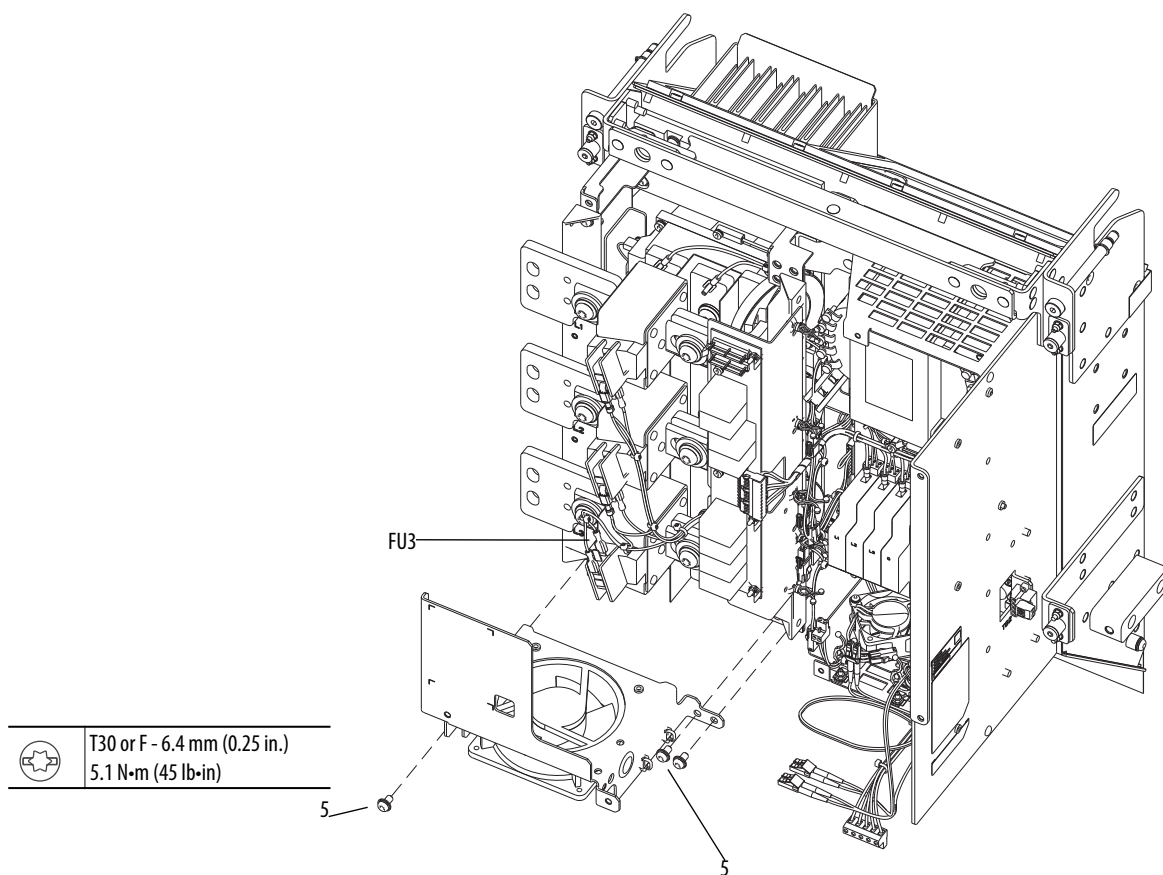
Install the AC line fuse sense harness in the reverse order of removal. See Remove the AC Line Fuse Sense Wire Harness on page [97](#).

AC Line Fuse Removal/ Installation

Remove the AC Line Fuses (FU1, FU2, and FU3)

IMPORTANT It is recommended that you replace all three AC line fuses.

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left converter cover. See Remove the Converter Left Cover on page [87](#).
5. If replacing FU3, remove the three M6 x 14 mm screws that secure the label bracket and input fuse stirring fan to the rail support and remove the bracket.




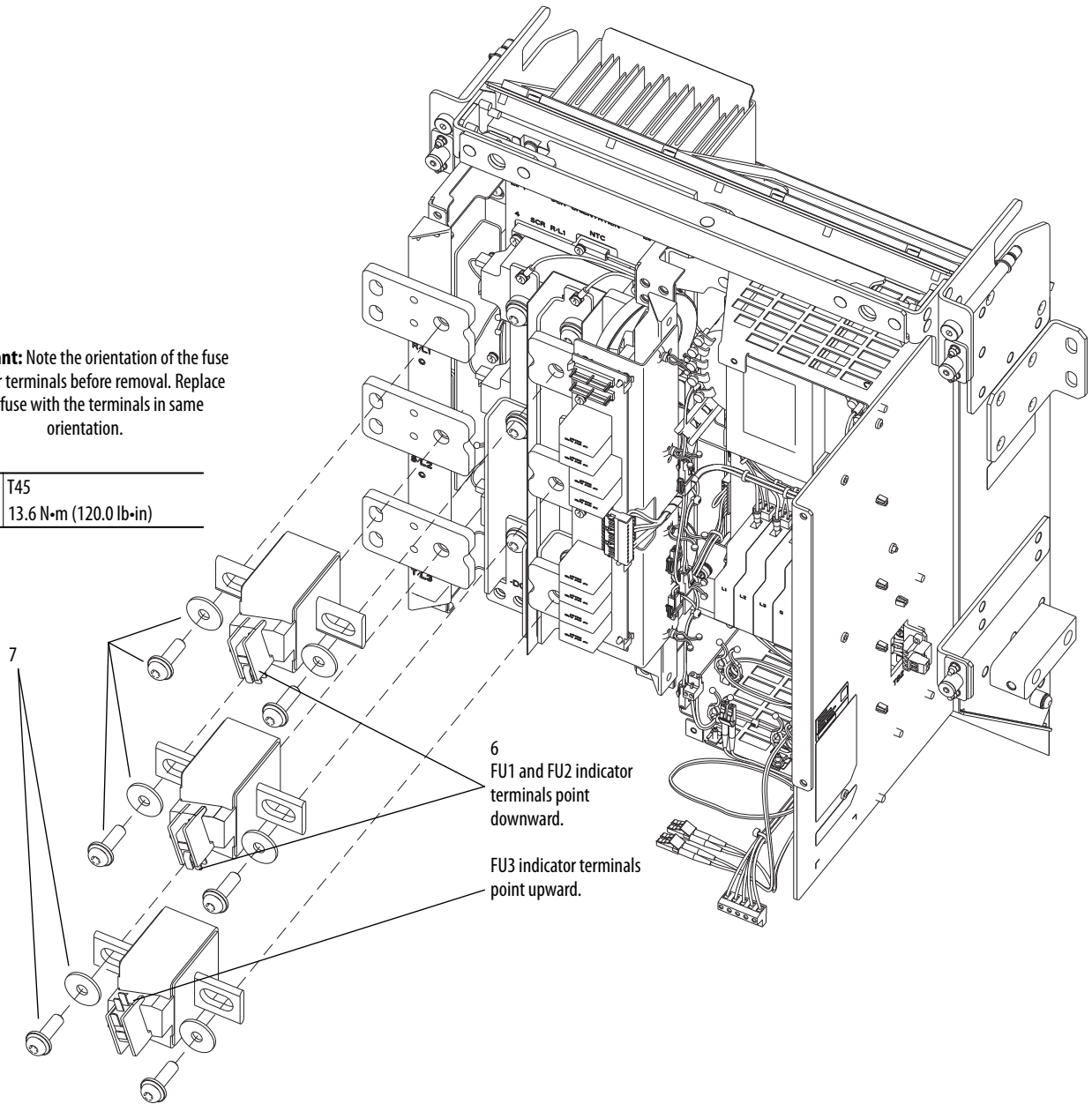
- Remove the AC line fuse sense wire harness leads from the fuse indicator terminals for the fuse being replaced. See Remove the AC Line Fuse Sense Wire Harness on page 97.

IMPORTANT Note the orientation of the fuse indicator terminals before removal. Replace each fuse with the terminals in same orientation.

- Remove the two M10 x 35 mm screws and two flat washers for the fuse being replaced and remove the AC line fuse. Remove the fuse indicator from the AC line fuse, if necessary.

Important: Note the orientation of the fuse indicator terminals before removal. Replace each fuse with the terminals in same orientation.

	T45 13.6 N·m (120.0 lb-in)
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Install AC Line Fuse (FU1, FU2, and FU3)

Install the AC line fuse in the reverse order of removal. See Install AC Line Fuse (FU1, FU2, and FU3) on page [101](#).

DC Bus Sense Wire Harness Removal/Installation

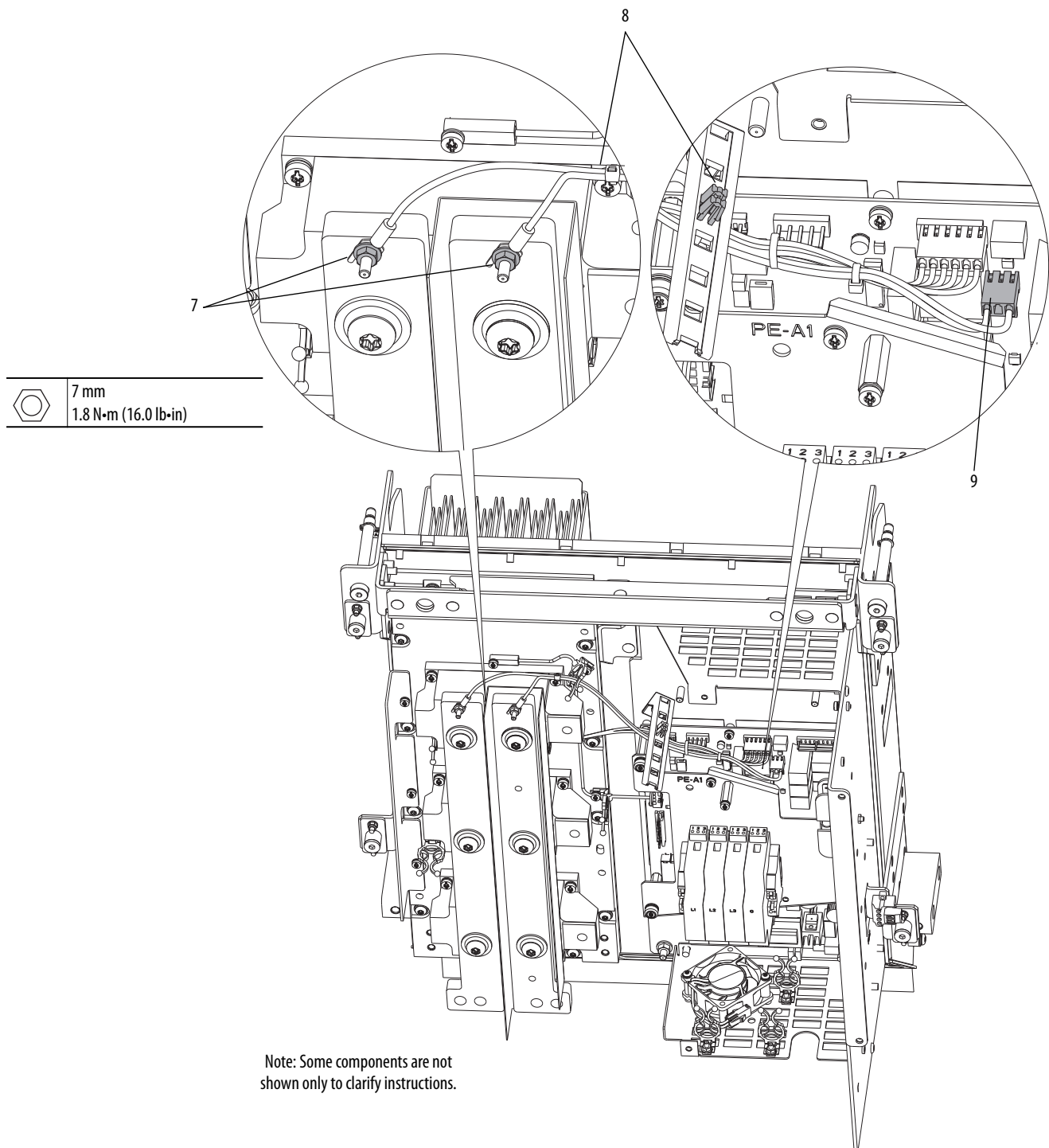
Remove the DC Bus Sense Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left converter cover. See Remove the Converter Left Cover on page [87](#).
5. If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

6. To gain access to the DC bus sense wire harness connections at the top of the -DC and +DC bus bars, remove the AC line fuse FU1 (from Phase R/L1). See Remove the AC Line Fuses (FU1, FU2, and FU3) on page [99](#).

7. Loosen, but do not remove, the two M4 hex nuts that secure the wire harness to the top of the -DC and +DC bus bars. Slide the wire harness fork terminals off the bus bars.
8. Release the cable supports that secure the DC bus sense wire harness to the converter SCR assembly and support bracket.
9. Disconnect the DC bus sense wire harness J10 connector from the converter gate board P10 terminal and remove the wire harness.



Install the DC Bus Sense Wire Harness

Install the DC bus sense wire harness in the reverse order of removal. See Remove the DC Bus Sense Wire Harness on page [101](#).

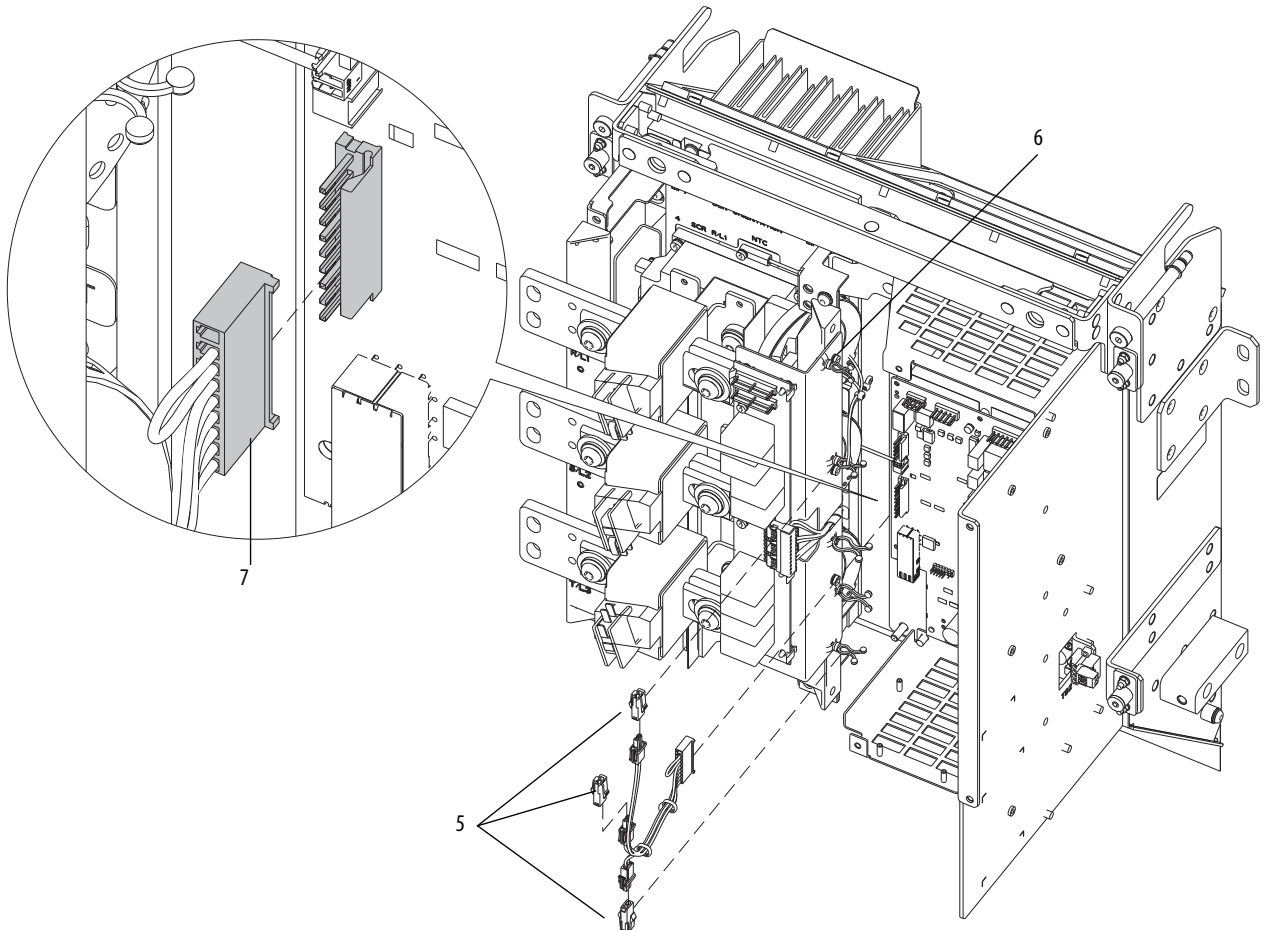
Converter Current Sensor Wire Harness Removal/Installation

Remove the Converter Current Sensor Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

5. Disconnect the converter current-sensor wire harness CT1, CT2, and CT3 connectors from the three converter current sensor connectors.
6. Release the cable supports from the right side of the bus bar support rail.
7. Disconnect the converter current-sensor wire harness J6 connector from the converter gate board P6 terminal and remove the converter current-sensor wire harness.



Install the Converter Current Sensor Wire Harness

Install the converter current-sensor wire harness in the reverse order of removal. See Remove the Converter Current Sensor Wire Harness on page [103](#).

Converter Current Sensors Removal/Installation

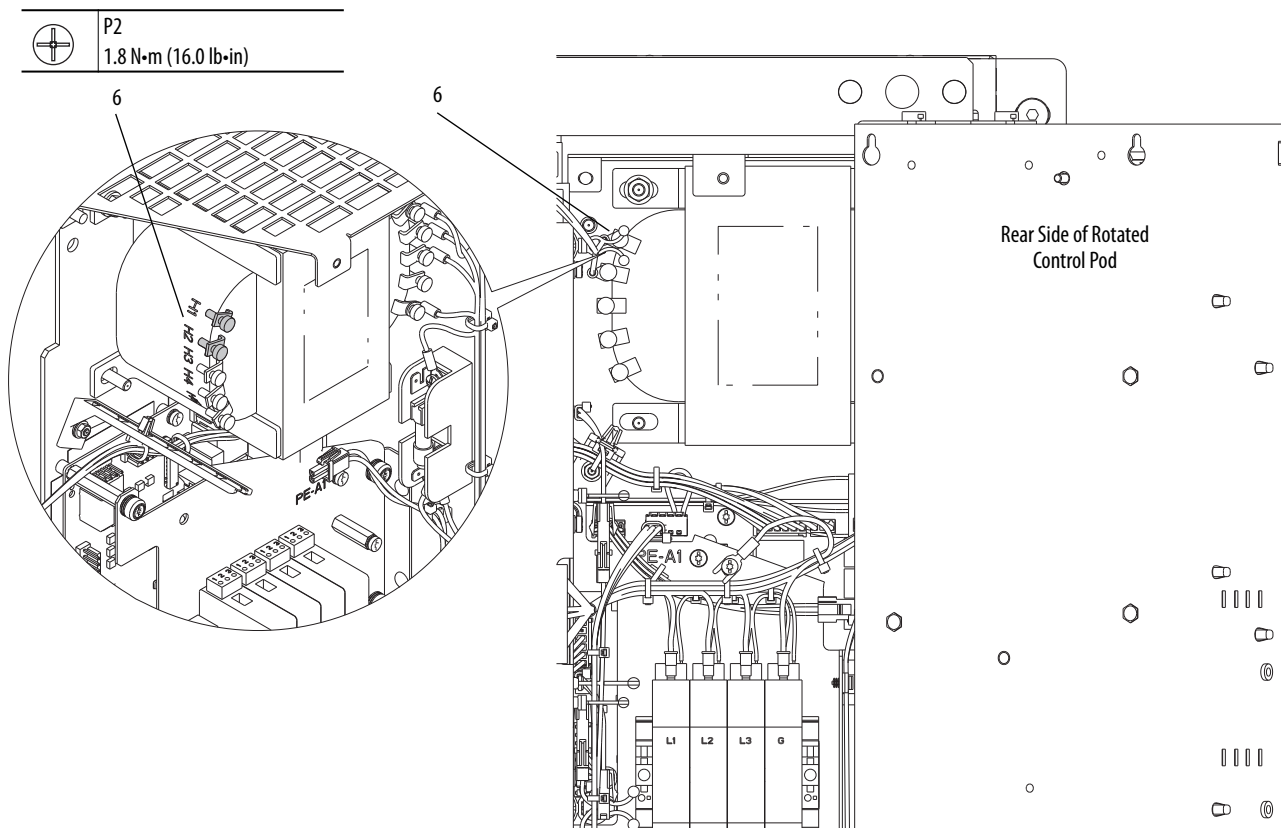
Remove the Converter Current Sensors

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left converter cover. See Remove the Converter Left Cover on page [87](#).
5. If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

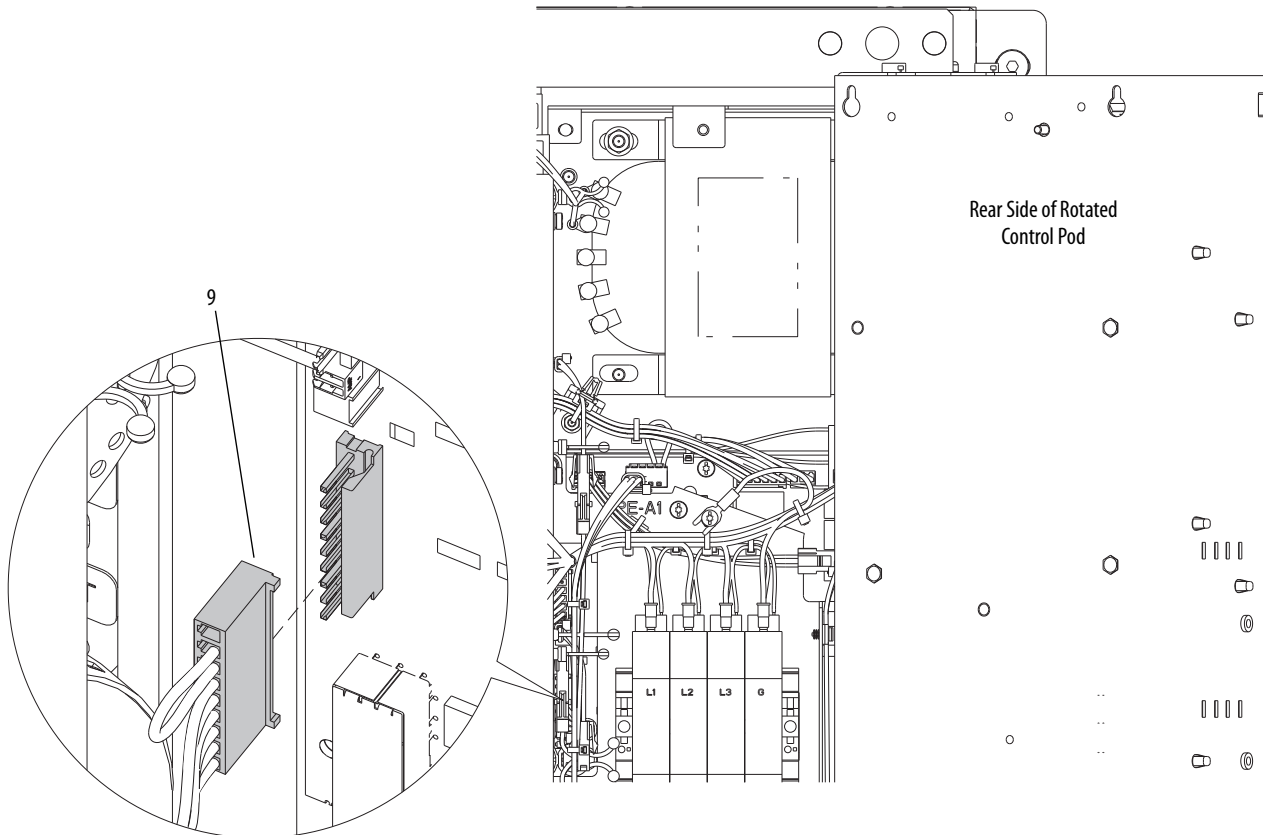
If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

IMPORTANT Before you disconnect the control-transformer primary wire harness, note the terminal connections. The control transformer has multiple input phase terminals. See the AC Input Drive Control Transformer Schematic Diagram on page [442](#) for more information.

6. Disconnect the control-transformer primary wire harness lead wires H1 and Hx from the control transformer input terminals. Release the cable support securing the harness to the EMC filter plastic support.



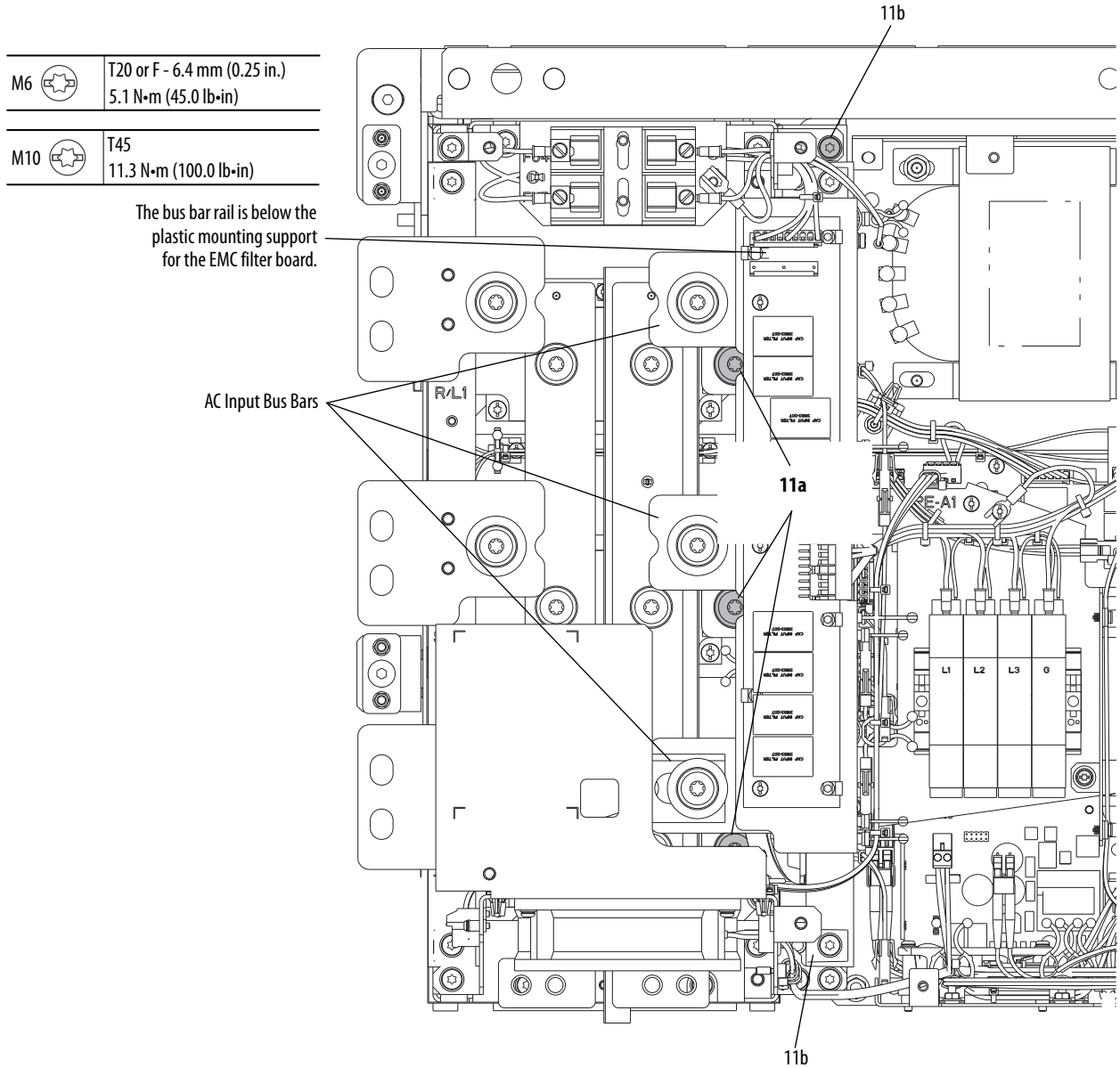
7. Remove the AC line fuse sense wire harness. See Remove the AC Line Fuse Sense Wire Harness on page [97](#).
8. Remove the three AC line fuses with fuse indicators. See Remove the AC Line Fuses (FU1, FU2, and FU3) on page [99](#).
9. Disconnect the converter current-sensor wire harness J6 connector from the converter gate board P6 terminal.



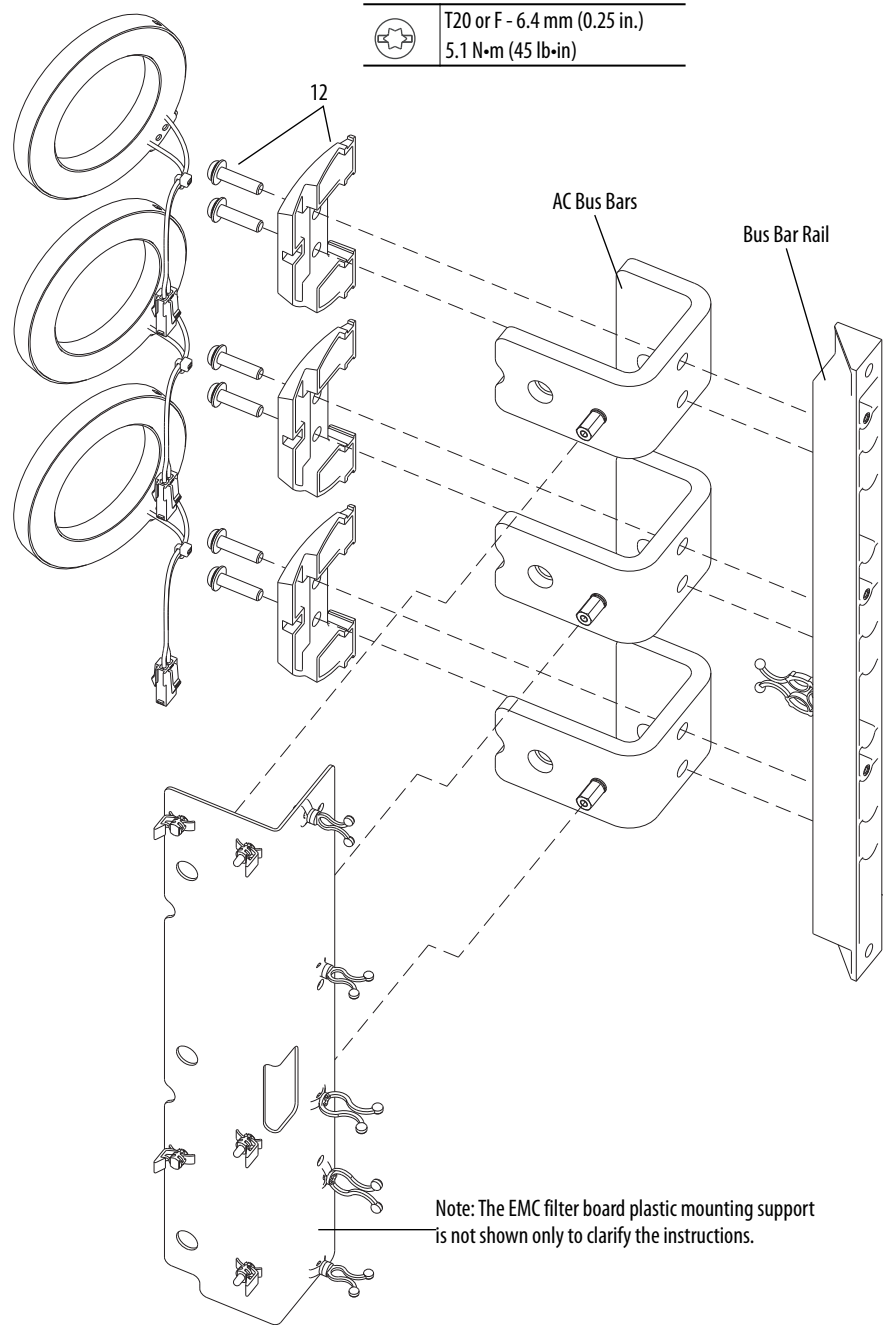
10. Remove the EMC filter board. See Remove the Converter EMC Filter Circuit Board on page [93](#).

11. Remove the right (DC+) bus bar rail:

- a. Remove the three M10 x 30 mm screws that secure the AC input bus bars to the SCR.
- b. Remove the two M6 x 14 mm screws that secure the right bus bar rail to the rail support. Remove the right bus bar rail with three AC input bus bars, three current sensors, current sensor wire harness, and EMC filter board plastic support attached.



12. For the phase being replaced, remove the two M6 x 25 mm screws that connect the AC bus bar to the right bus bar rail.
13. Cut the three cable ties that connect the current sensor to the plastic support and remove the current sensor.



Install the Converter Current Sensors

Install the current sensors in the reverse order of removal. See Remove the Converter Current Sensors on page [105](#).

IMPORTANT Verify that the control-transformer primary wire harness lead wires H1 and Hx are connected to the correct input terminals. The control transformer has multiple input phase terminals. See the AC Input Drive Control Transformer Schematic Diagram on page [442](#) for more information. If the wires are connected to the wrong terminals, drive damage can occur.

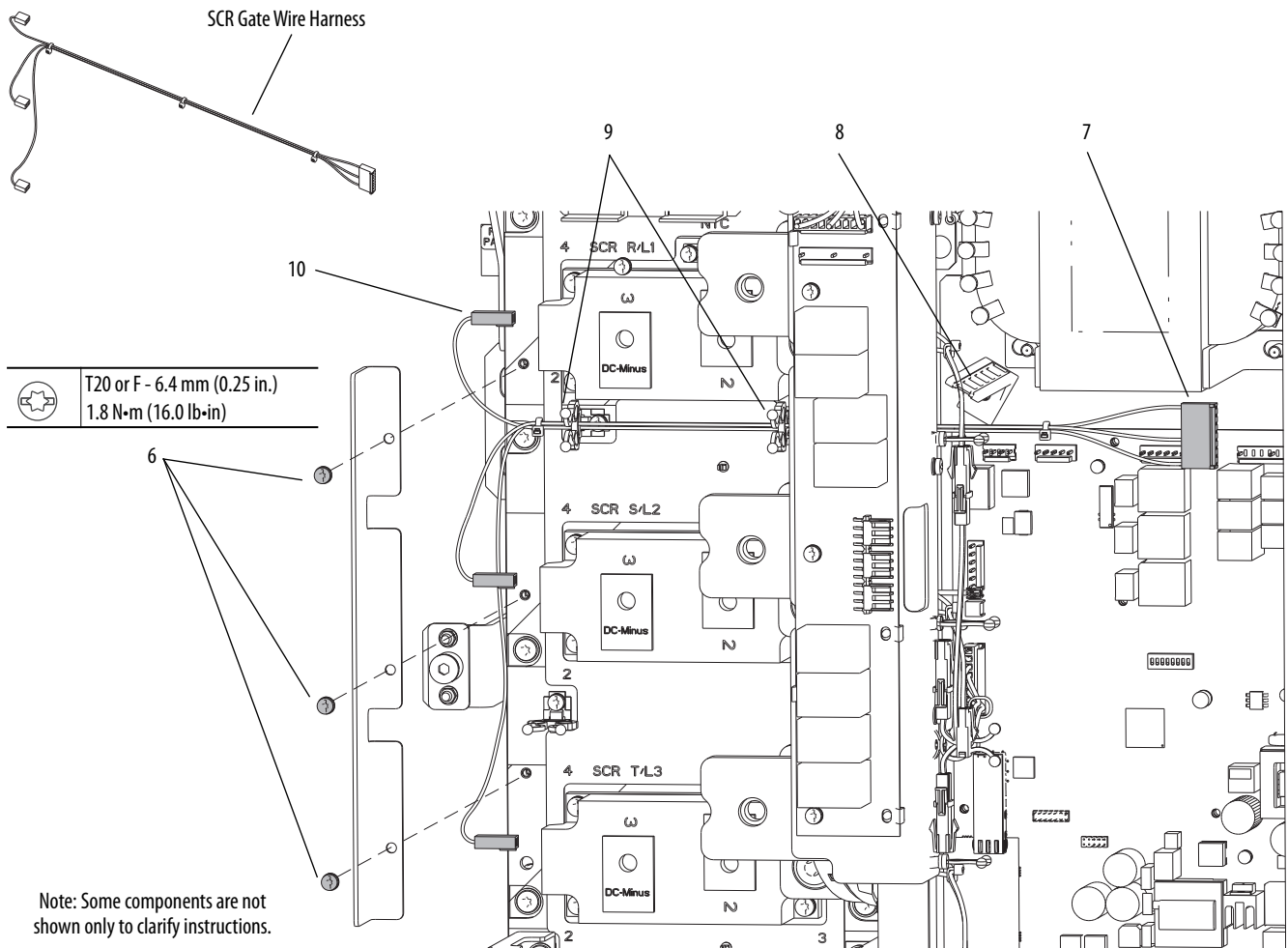
Converter SCR Gate Wire Harness Removal/ Installation

Remove the Converter SCR Gate Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left converter cover. See Remove the Converter Left Cover on page [87](#).
5. If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

6. Remove the three M4 x 12 mm screws that secure the shield to the converter heatsink and remove the shield.
7. Disconnect the SCR gate wire harness J11 connector from the converter gate board P11 terminal.
8. Disengage the cable tie from the cable tie mount on the wire harness ladder.
9. Release the wire harness from the two cable supports securing the harness to the converter heatsink.
10. Remove the three SCR gate connectors from the SCR modules and remove the SCR gate wire harness from the drive.



Install the Converter SCR Gate Wire Harness

Install the converter SCR gate wire harness in the reverse order of removal. See Remove the Converter SCR Gate Wire Harness on page [109](#).

Converter SCR Assembly Removal/Installation

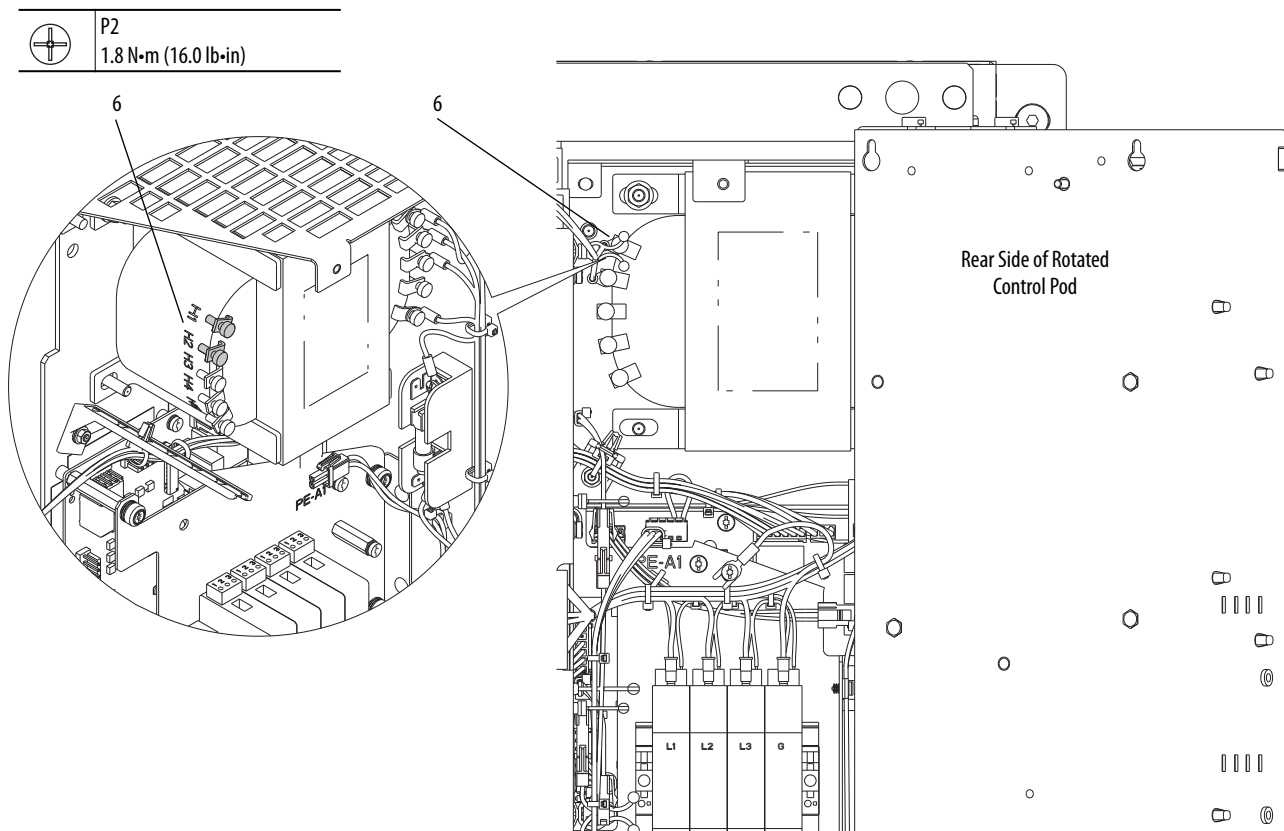
Remove the Converter SCR Assembly

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left converter cover. See Remove the Converter Left Cover on page [87](#).
5. If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

IMPORTANT Before you disconnect the control-transformer primary wire harness, note the terminal connections. The control transformer has multiple input phase terminals. See the AC Input Drive Control Transformer Schematic Diagram on page [442](#) for more information.

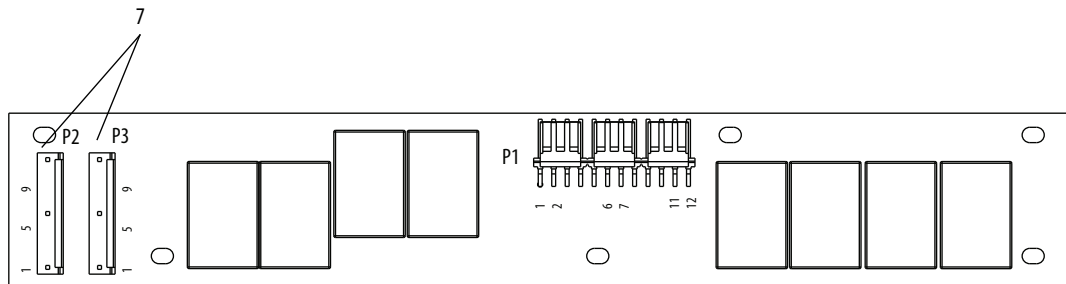
6. Disconnect the control-transformer primary wire harness lead wires H1 and Hx from the control transformer input terminals. Release the cable support securing the harness to the EMC filter plastic support.



IMPORTANT Before you disconnect the control-transformer primary wire harness J2/J3 connector from the EMC filter board, note the J2/J3 location. The P3 (PE-A2) terminal is grounded. The P2 terminal is not grounded.

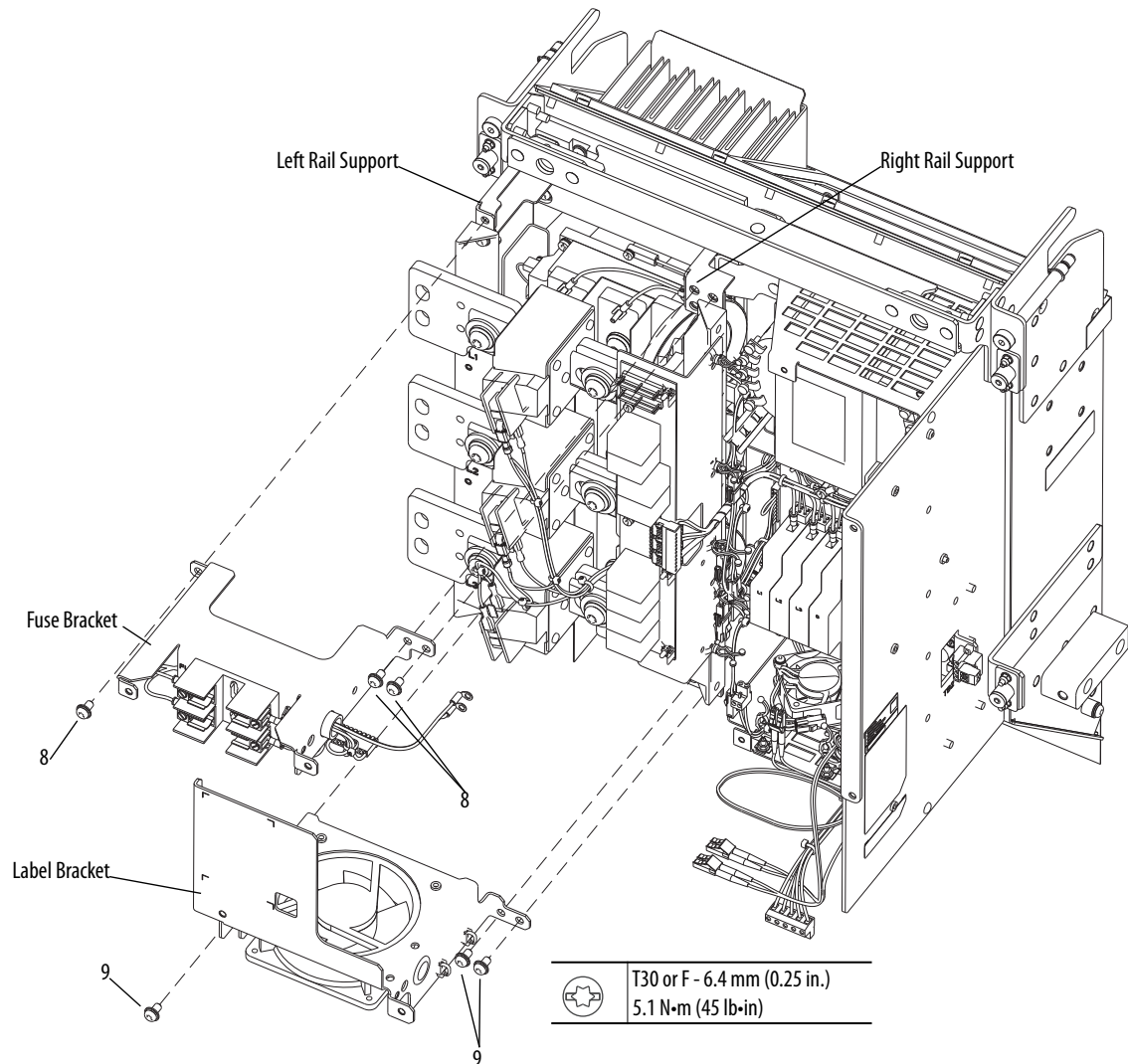
The jumper settings are provided in the PowerFlex 750-Series Power Jumpers Installation Instructions, publication [750-IN011](http://www.rockwellautomation.com/literature/750-IN011), available at <http://www.rockwellautomation.com/literature/>.

7. Remove the J2/J3 connector from connector P2 or P3 on the EMC filter board.



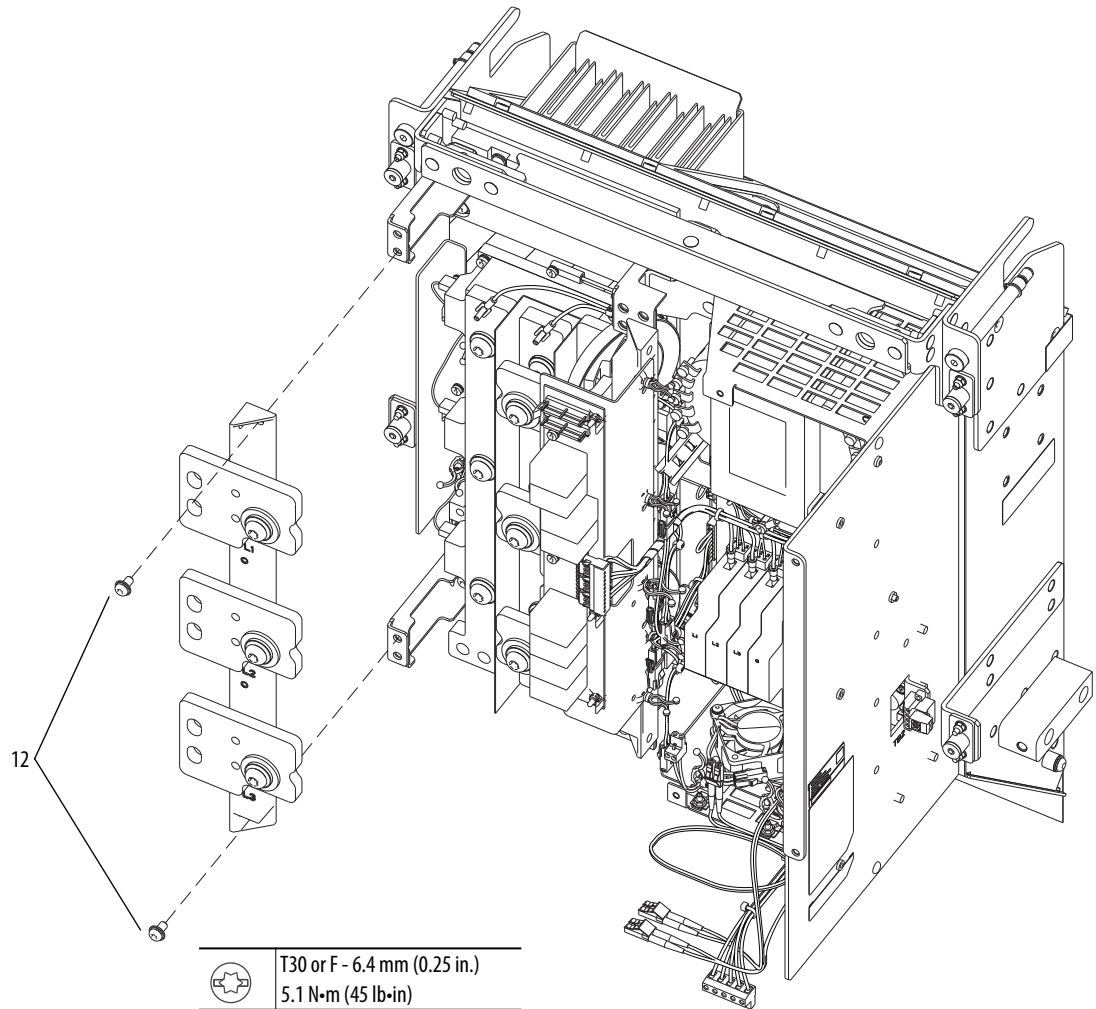
Note: Board shown rotated 90° from actual installation position.

8. Remove the three M6 x 14 mm screws that secure the fuse bracket to the left and right rail supports. Remove the fuse bracket with the control-transformer primary wire harness attached.
9. Remove the three M6 x 14 mm screws that secure the label bracket to the rail support and remove the label bracket.



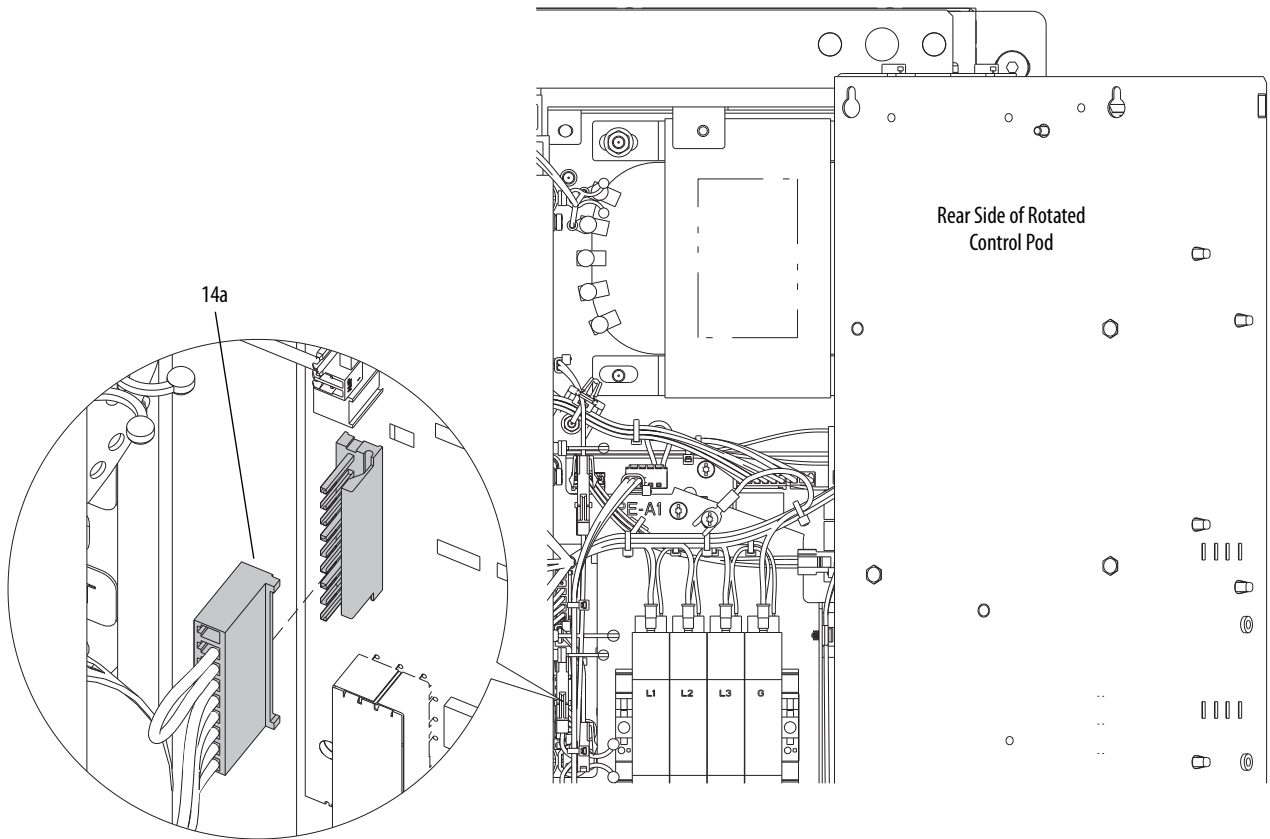
10. Remove the AC line fuse sense wire harness. See Remove the AC Line Fuse Sense Wire Harness on page [97](#).
11. Remove the three AC line fuses with fuse indicators. See Remove the AC Line Fuses (FU1, FU2, and FU3) on page [99](#).

12. Remove the two M6 x 14 mm screws that secure the left bus bar rail to the left rail supports. Remove the left rail with the three AC input bus bars attached.





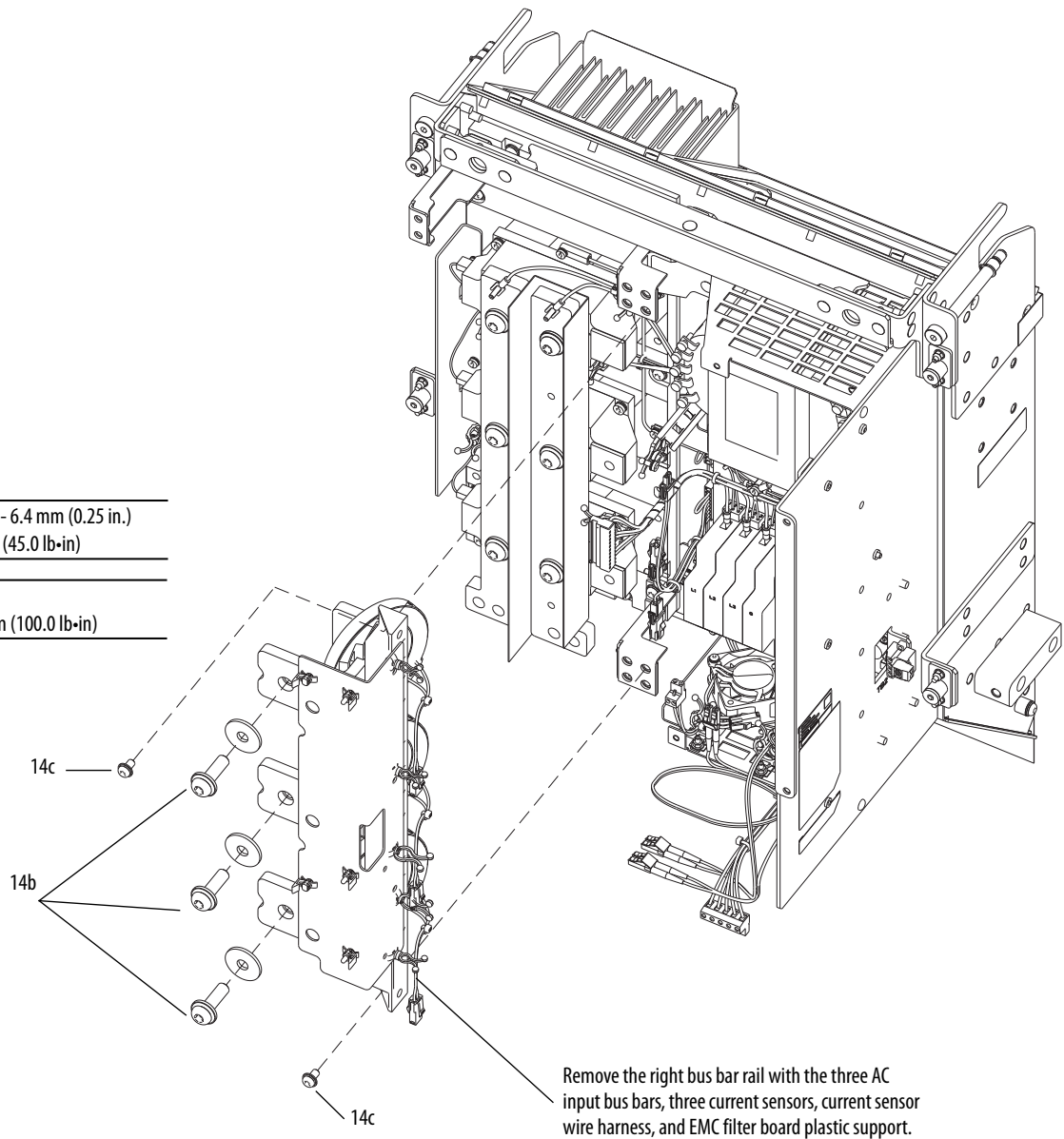
13. Remove the EMC filter board. See Remove the Converter EMC Filter Circuit Board on page [93](#).

14. For the right bus bar rail:
 - a. Disconnect the current sensor wire harness J6 connector from the converter gate board P6 terminal.



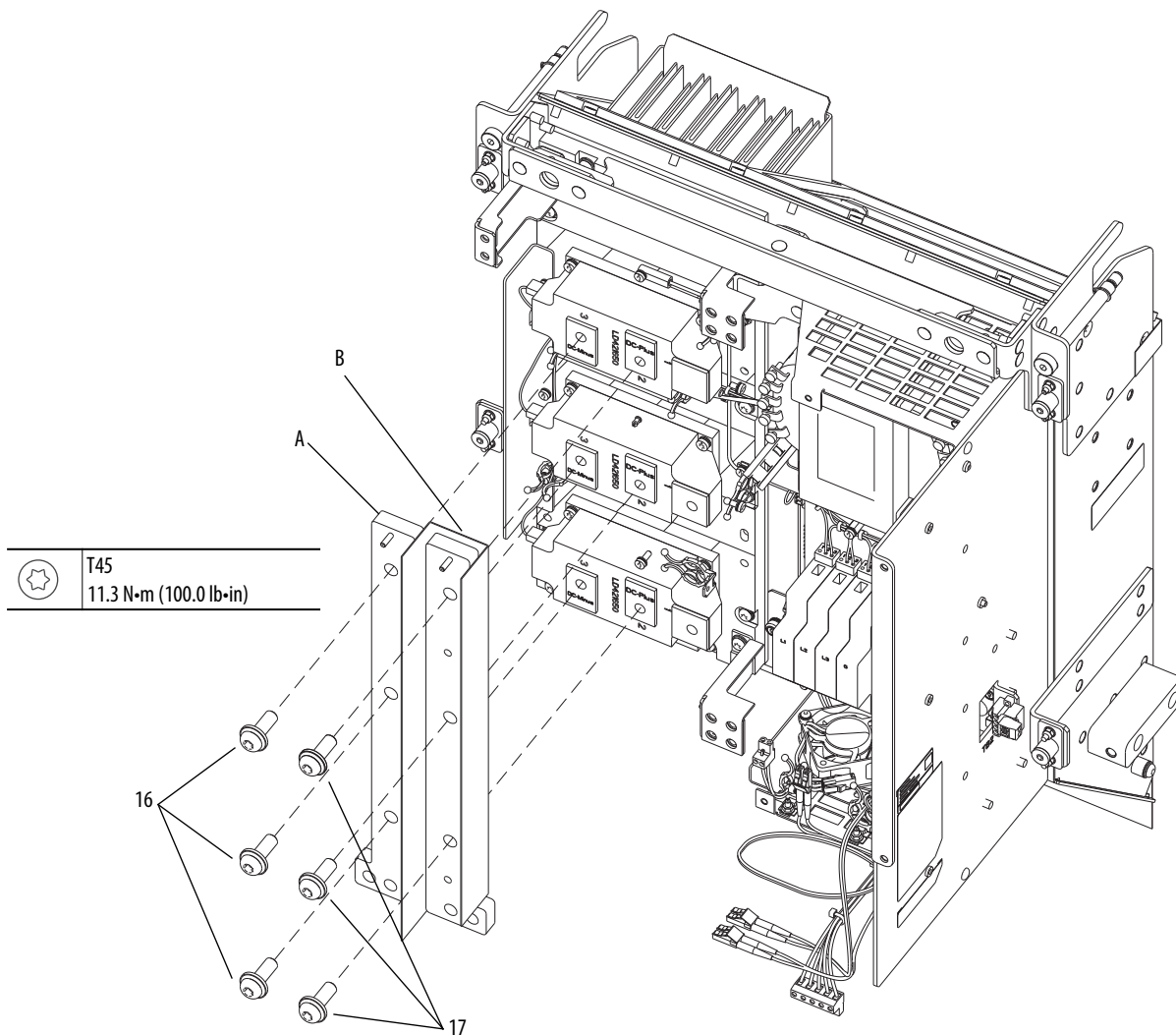
- b. Remove the three M10 x 30 mm screws and flat washers that secure the AC input bus bars to the SCRs.
- c. Remove the two M6 x 14 mm screws that secure the right bus bar rail to the right rail supports. Remove the right bus bar rail with three AC input bus bars, three current sensors, current sensor wire harness, and EMC filter board plastic support attached.

M6		T20 or F - 6.4 mm (0.25 in.) 5.1 N·m (45.0 lb·in)
M10		T45 11.3 N·m (100.0 lb·in)

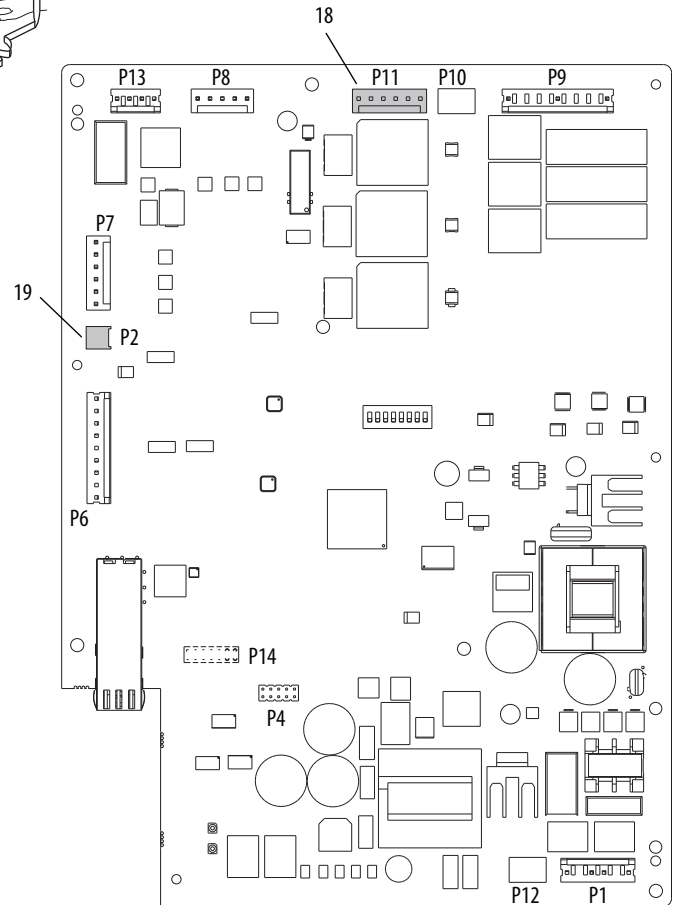


15. Remove the DC bus wire harness. See Remove the DC Bus Sense Wire Harness on page [101](#).

16. Remove the three M10 x 30 mm screws that secure the -DC bus bars (A) to the SCRs and remove the -DC bus bars.
17. Remove the three M10 x 30 mm screws that secure the +DC bus bars with insulation sheet attached (B) to the SCRs and remove the +DC bus bars and insulation sheet.

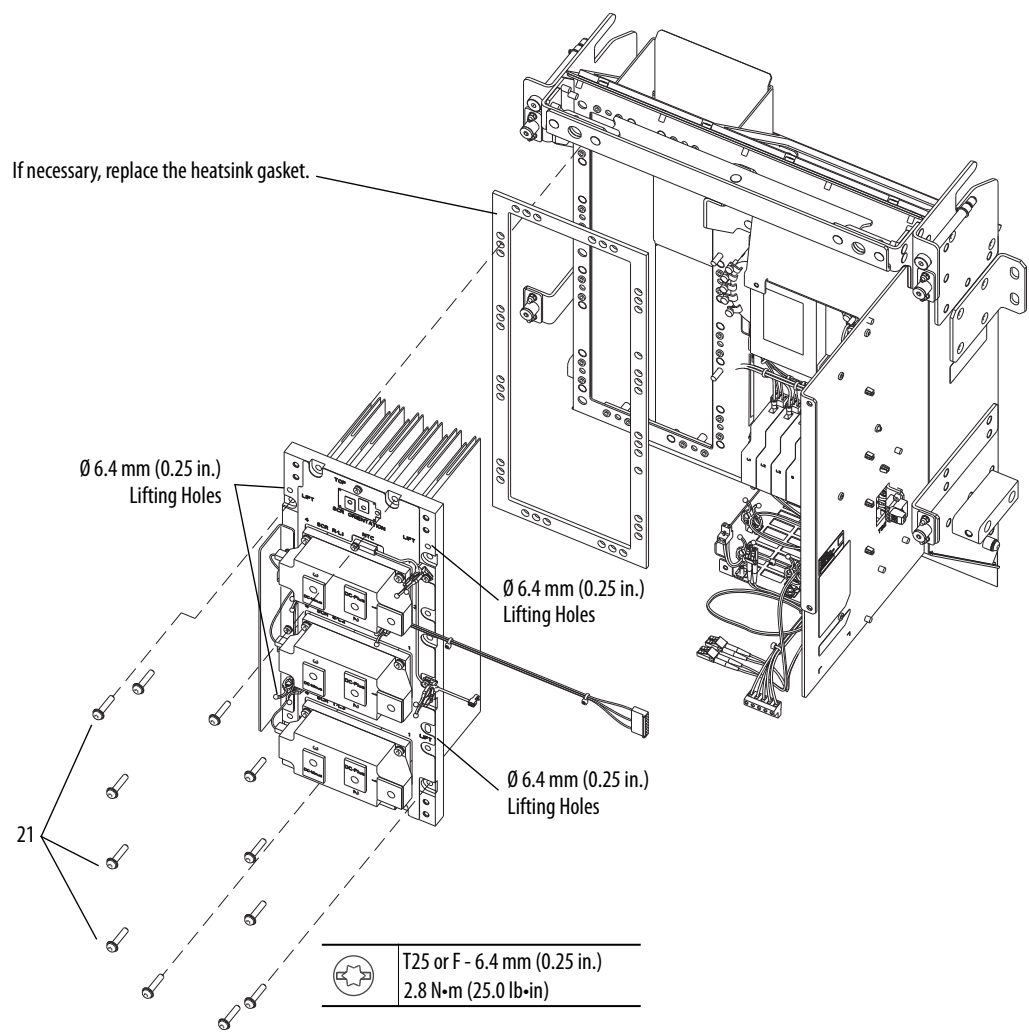


18. Disconnect the SCR wire harness J11 connector from the converter gate board P11 terminal.
19. Disconnect the NTC wire harness connector from the converter gate board P2 terminal.



20. Secure equipment and hardware capable of lifting 17 kg (37 lb) to the lifting holes identified on the SCR assembly.
21. Remove the 12 M5 x 20 mm screws that secure the assembly to the converter duct.
22. Remove the converter SCR assembly.

IMPORTANT Do NOT remove the SCRs from the assembly.



Install the Converter SCR Assembly

1. Inspect the converter heat sink gasket on the converter duct for damage and replace it if necessary. See Converter Heat Sink Gasket Replacement on page [120](#).
2. Install the converter SCR assembly in the reverse order of removal.

IMPORTANT Verify that the J2/J3 connector is reassembled in the appropriate location (P2 or P3) on the EMC filter board.

IMPORTANT Verify that the control-transformer primary wire harness lead wires H1 and Hx are connected to the correct input terminals. The control transformer has multiple input phase terminals. See the AC Input Drive Control Transformer Schematic Diagram on page [442](#) for more information. If the wires are connected to the wrong terminals, drive damage can occur.

IMPORTANT If you replace the external NTC, you must apply thermal grease to the bottom of the NTC before securing it to the SCR assembly heatsink.

Converter Heat Sink Gasket Replacement

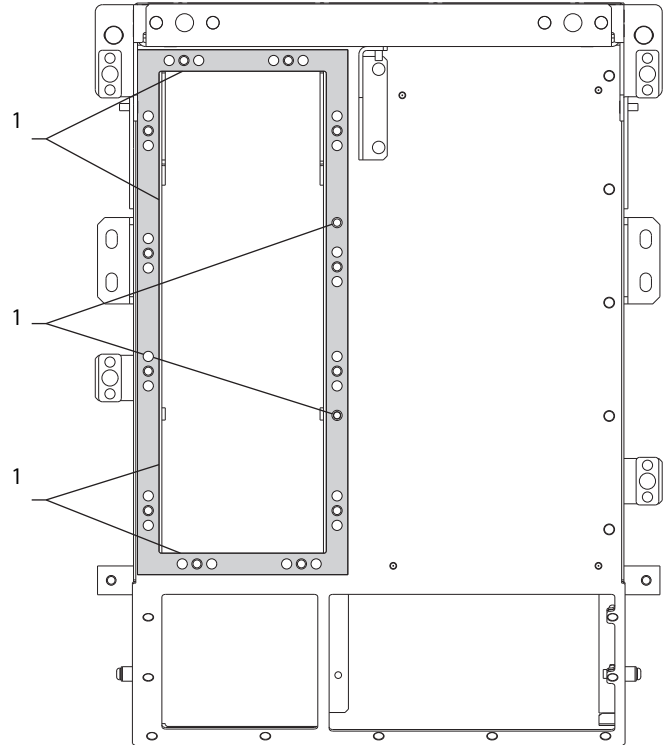
Remove the Converter Heat Sink Gasket

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the converter SCR assembly. Remove the Converter SCR Assembly on page [111](#).
5. Carefully remove the gasket and any gasket material that can be stuck to the sealing surface.
6. Clean the converter duct surface with a 50% isopropyl alcohol / 50% water mixture.

Install the Converter Heat Sink Gasket

Note: One side of the heat sink gasket is coated with an adhesive. Take care to align the gasket properly before fully removing the paper liner and exposing the adhesive.

1. Begin removing the paper liner as you align the replacement gasket with the duct edges and cutouts as shown here and press the gasket into place on the duct.



2. Install the converter SCR assembly in the reverse order of removal. See [Install the Converter SCR Assembly](#) on page [120](#).

Inverter Power-supply Wire Harness Removal/ Installation

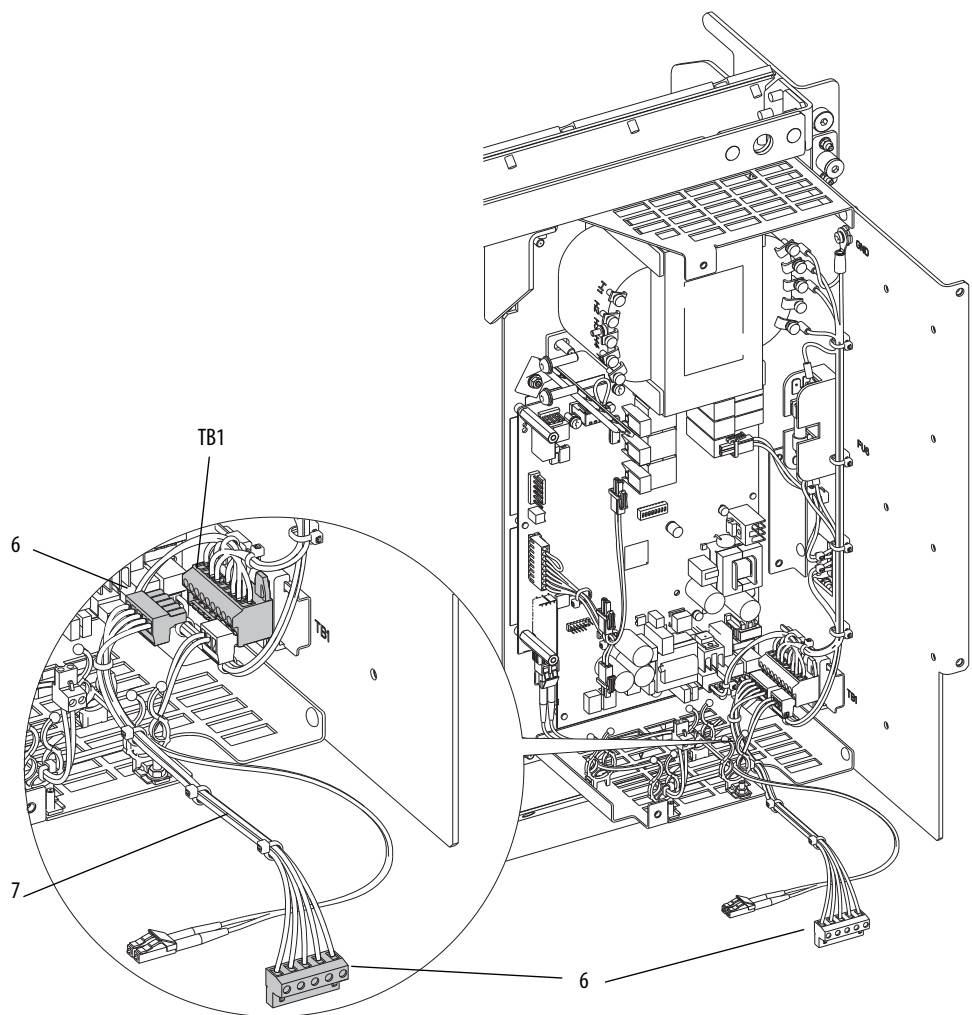
Remove the Inverter Power-supply Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See [Remove Power from the Drive](#) on page [25](#).
3. Open the enclosure door.

4. If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

5. Remove the inverter circuit board connections cover from the inverter. See Inverter Circuit Board Connections Cover Removal/Installation on page [238](#).
6. Disconnect the inverter power-supply wire harness from the inverter power supply board P6 terminal and converter terminal block TB1.
7. Remove the inverter power supply harness.



Install the Inverter Power-supply Wire Harness

Install the inverter power-supply wire harness in the reverse order of removal. See Remove the Inverter Power-supply Wire Harness.

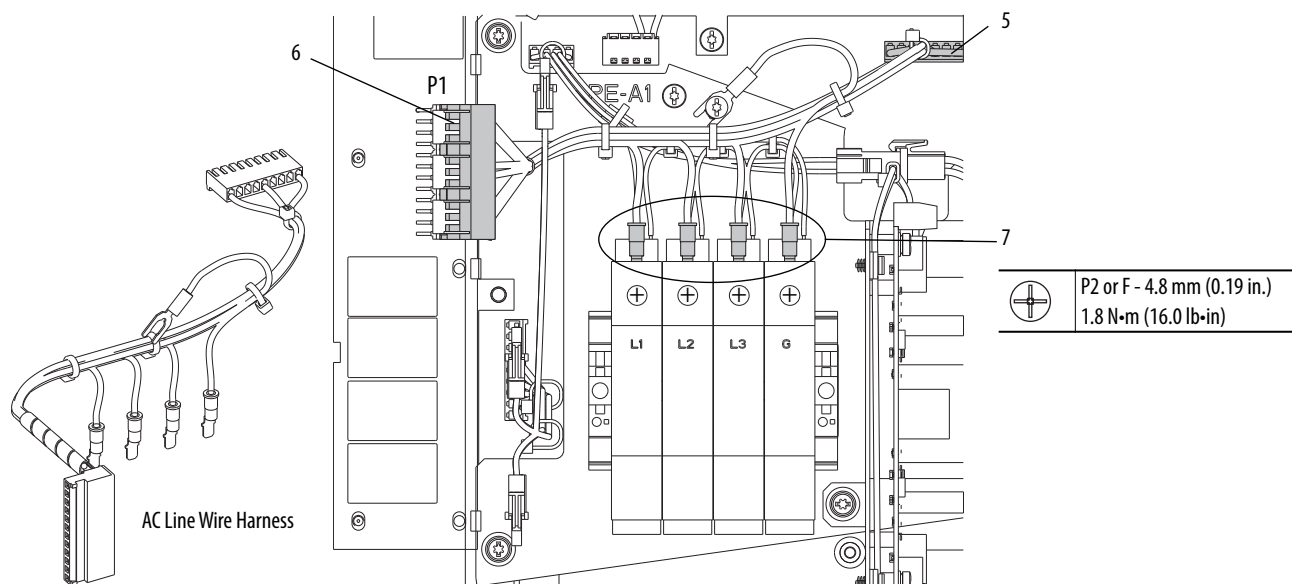
AC Line Wire Harness Removal/Installation

Remove the AC Line Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

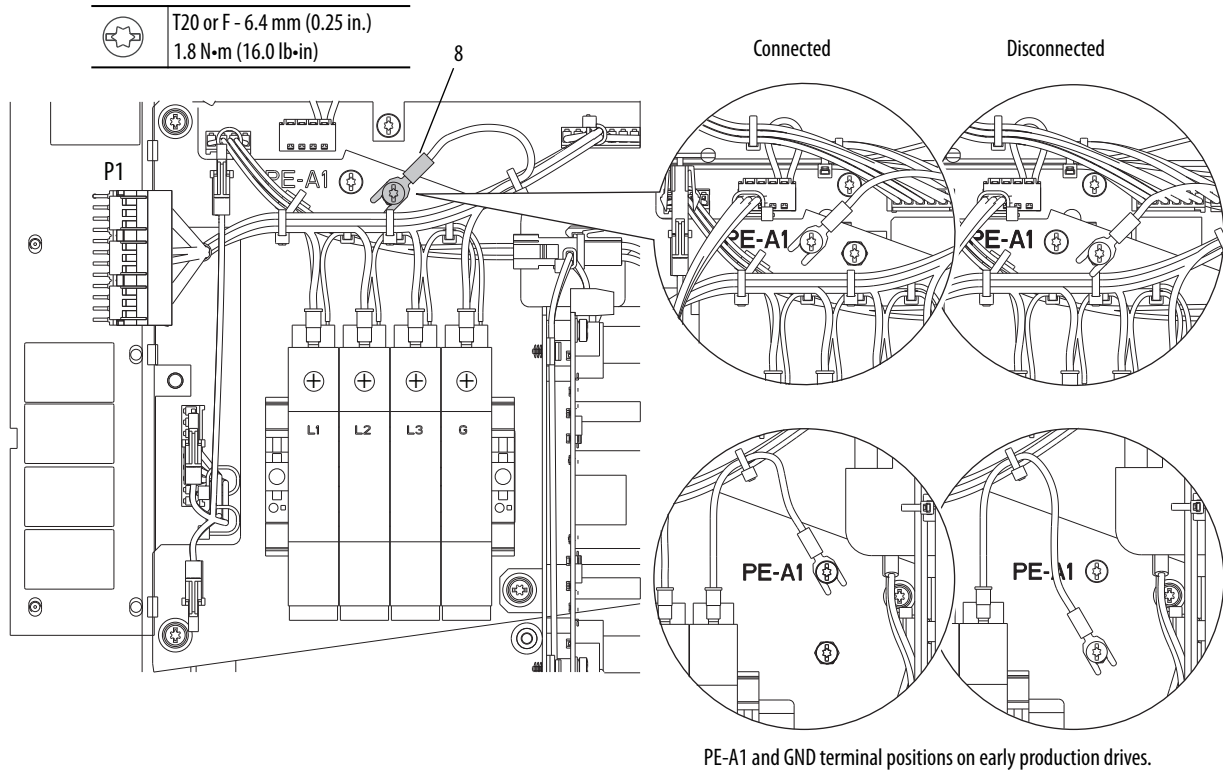
If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

5. Disconnect the J9 connector from P9 on the converter gate board.
6. Disconnect the J1 connector from P1 on the EMC filter board.
7. Loosen the Phillips head screws that secure the wires to the surge suppressor L1, L2, L3, and G terminals and remove the wires.



IMPORTANT Before you disconnect the jumper wire of the AC line wire harness, note the wire location (PE-A1 or GND terminal) on the surge suppressor mounting plate.

8. Loosen the screw that secures the jumper wire to the PE-A1 or GND terminal and remove the wire.
9. Remove the AC line wire harness.



Install the AC Line Wire Harness

Install the AC line wire harness in the reverse order of removal. See Remove the AC Line Wire Harness on page [123](#).

IMPORTANT Be sure that the jumper wire is reassembled in the appropriate location (PE-A1 or GND terminal) on the surge suppressor mounting plate.

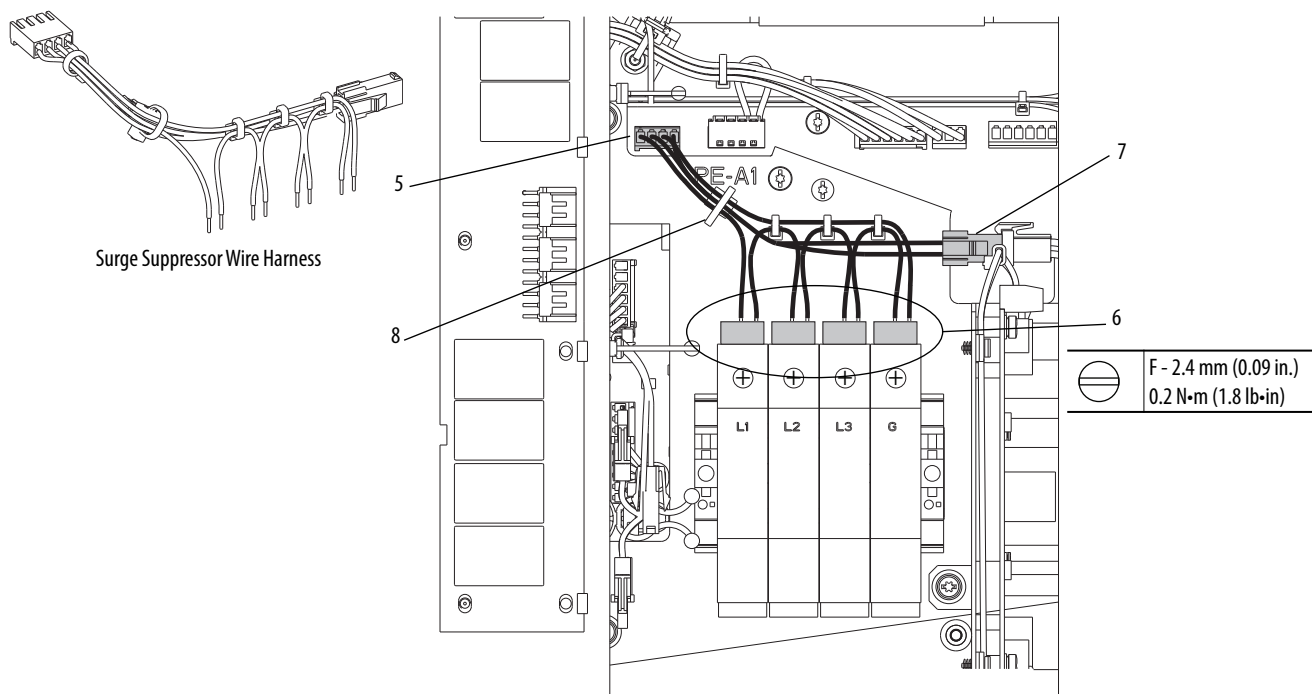
Surge-suppressor Sense Wire Harness Removal/Installation

Remove the Surge-suppressor Sense Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

5. Disconnect the J13 connector from P13 on the converter gate board.
6. Remove the four three-position surge suppressor sense wire terminal blocks from the surge suppressor.
7. Disconnect the connector from the shunt trip ST terminal.
8. Release the cable support on the surge suppressor mounting plate and remove the surge-suppressor sense wire harness.



Install the Surge-suppressor Sense Wire Harness

1. Remove the four three-position plug terminals from the original wire harness and install them on the replacement wire harness.
2. Install the surge-suppressor sense wire harness in the reverse order of removal. See Remove the Surge-suppressor Sense Wire Harness on page [125](#).

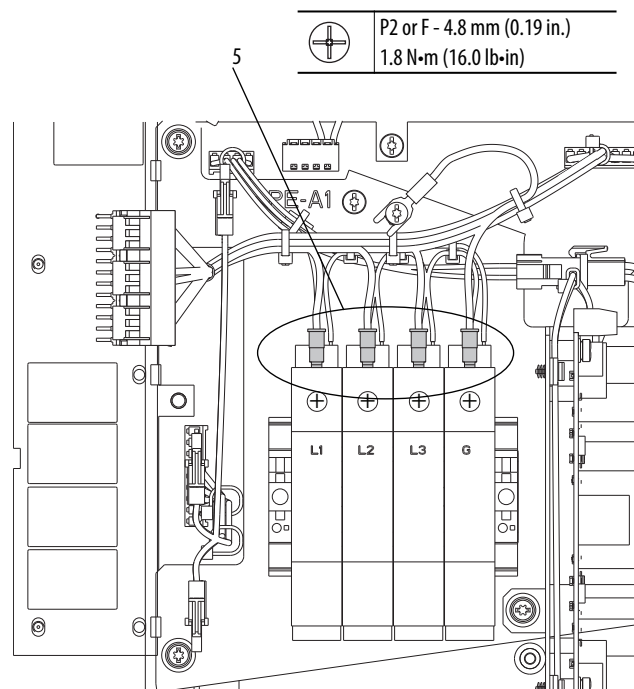
Surge Suppressor Removal/ Installation

Remove the Surge Suppressor

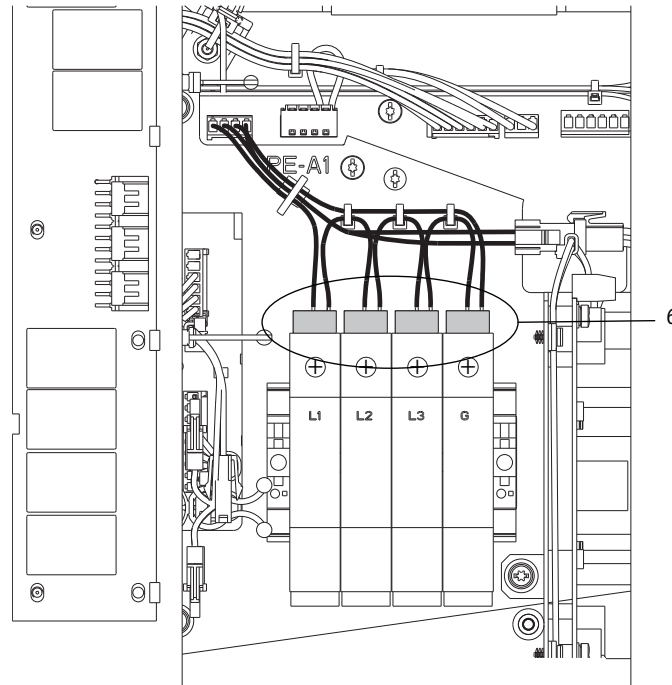
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

5. Loosen the Phillips head screws that secure the wires to the surge suppressor L1, L2, L3, and G terminals and remove the wires.



- Remove the four, three-position surge suppressor sense wire terminal blocks from the surge suppressor.



- Release the surge suppressor from the DIN rail and remove the surge suppressor.

Install the Surge Suppressor

Install the surge suppressor in the reverse order of removal. See Remove the Surge Suppressor on page [126](#).

Surge Suppressor Assembly Removal/Installation

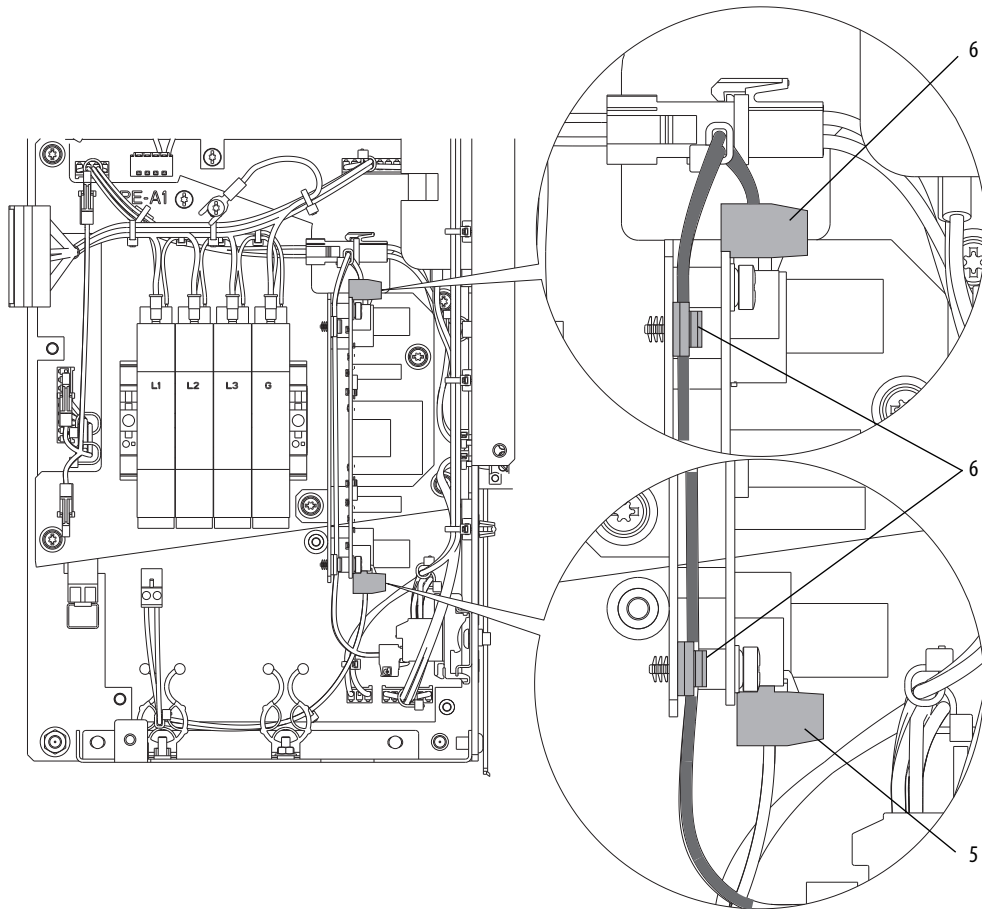
Remove the Surge Suppressor Assembly

Note: This procedure is used only to gain access to the converter gate board.

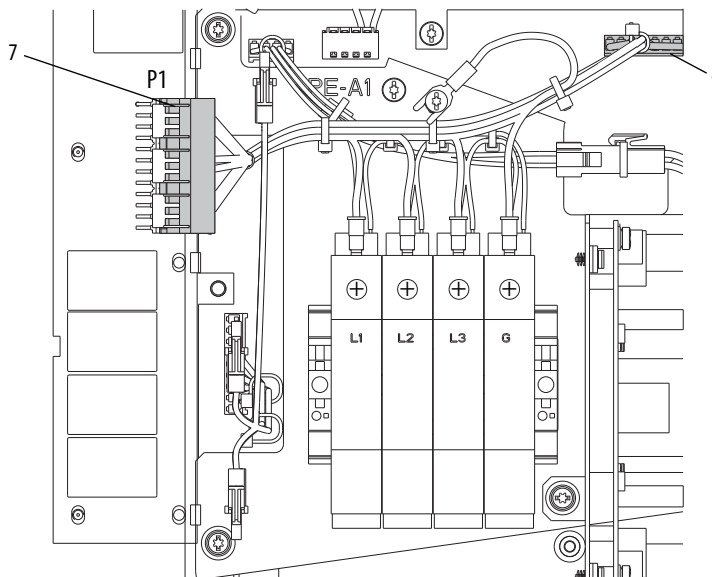
- Review the General Precautions on page [24](#).
- Remove power from the drive. See Remove Power from the Drive on page [25](#).
- Open the enclosure door.
- If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

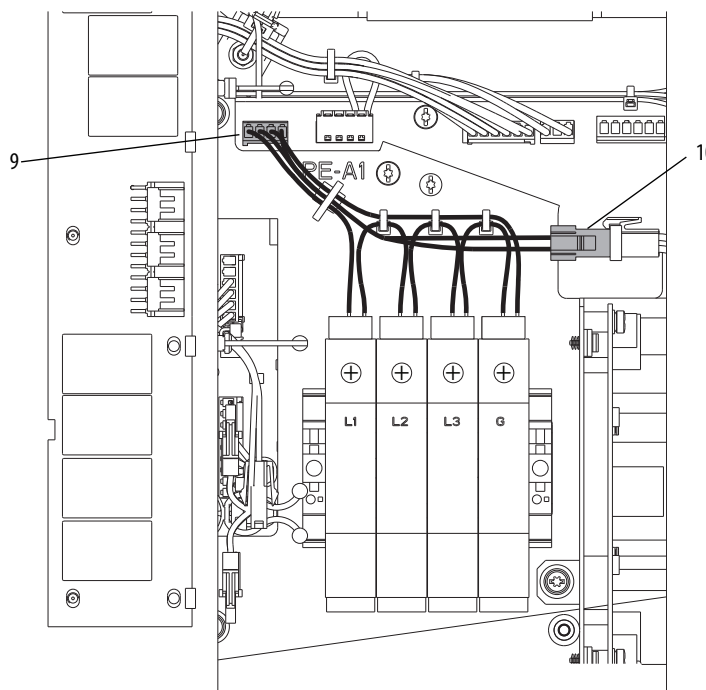
5. For 600/690V AC input drives only, disconnect the 24V wire harness two-position connector from the bottom of the control power isolator board.
6. For 600/690V AC input drives only, disconnect the upper 24V wire harness two-position connector from the top of the control power isolator board. Disengage the harness from the two side entry cable supports.



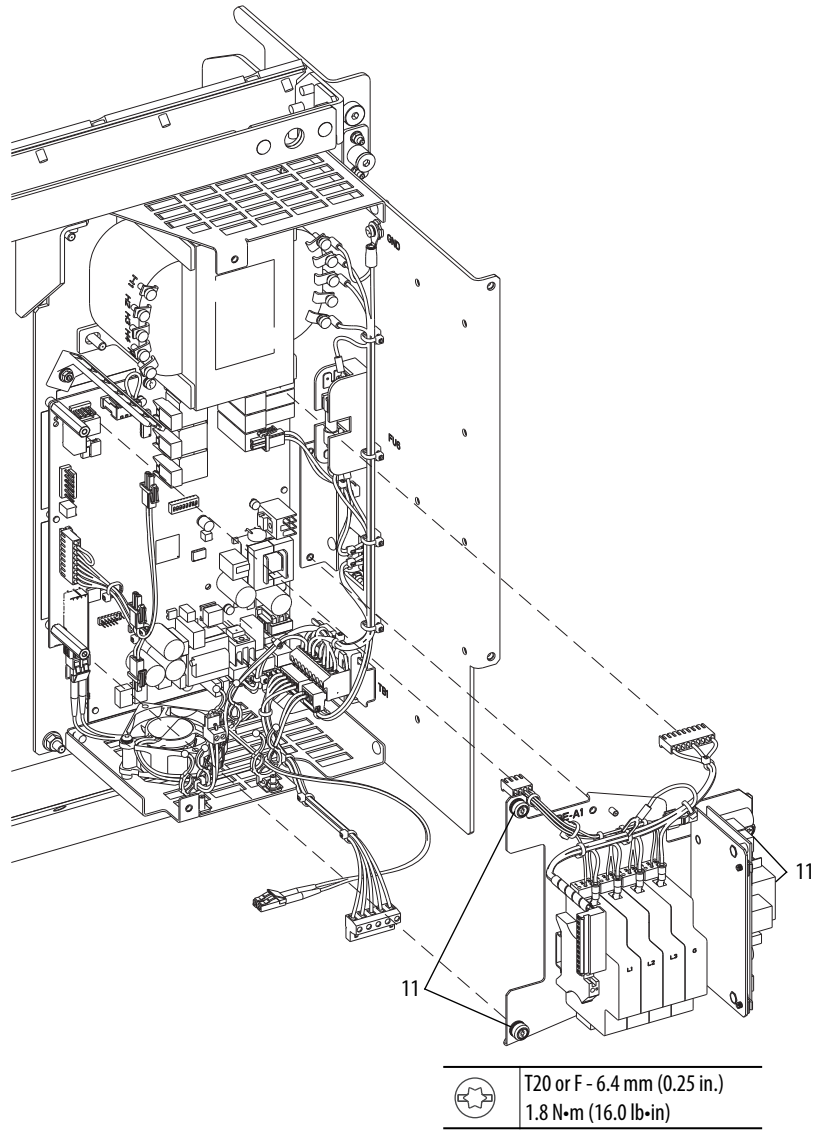
7. Disconnect the J1 connector from the P1 terminal on the EMC filter board.
8. Disconnect the J9 connector from the P9 terminal on the converter gate board.



9. Disconnect the J13 connector from the P13 terminal on the converter gate board.
10. Disconnect the connector from the ST connector on the 24V/240V wire harness.



11. Loosen the four, captive M4 panel fasteners on the surge suppressor mounting plate and remove the surge suppressor assembly.



Install the Surge Suppressor Assembly

Install the surge suppressor assembly in the reverse order of removal. See Remove the Surge Suppressor Assembly on page [127](#).

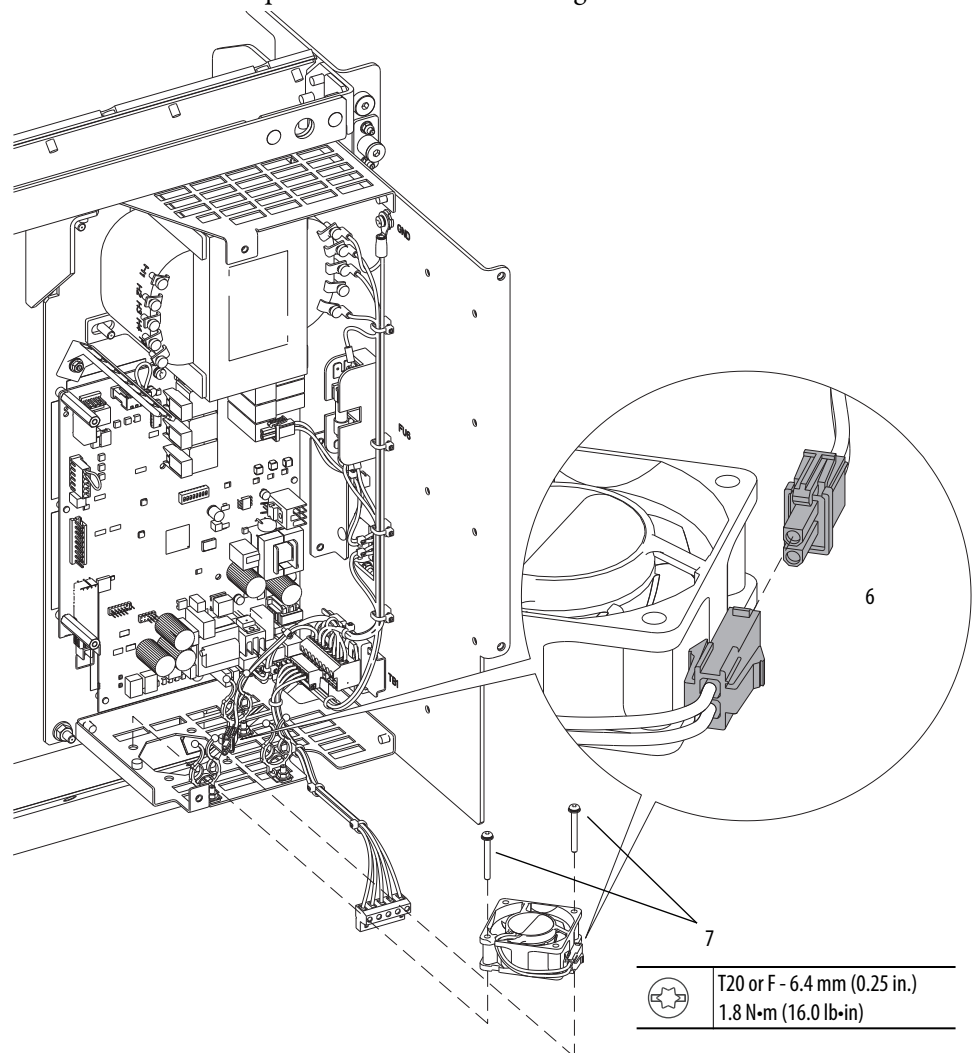
Converter Gate Board Stirring Fan Removal/ Installation

Remove the Converter Gate Board Stirring Fan

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

5. Remove the surge suppressor assembly. See Remove the Surge Suppressor Assembly on page [127](#).
6. Disconnect the two-position fan connector from the stirring fan to the 24V/240V wire harness.
7. Remove two M4 x 35 mm long screws that secure the stirring fan to the control panel and remove the stirring fan.



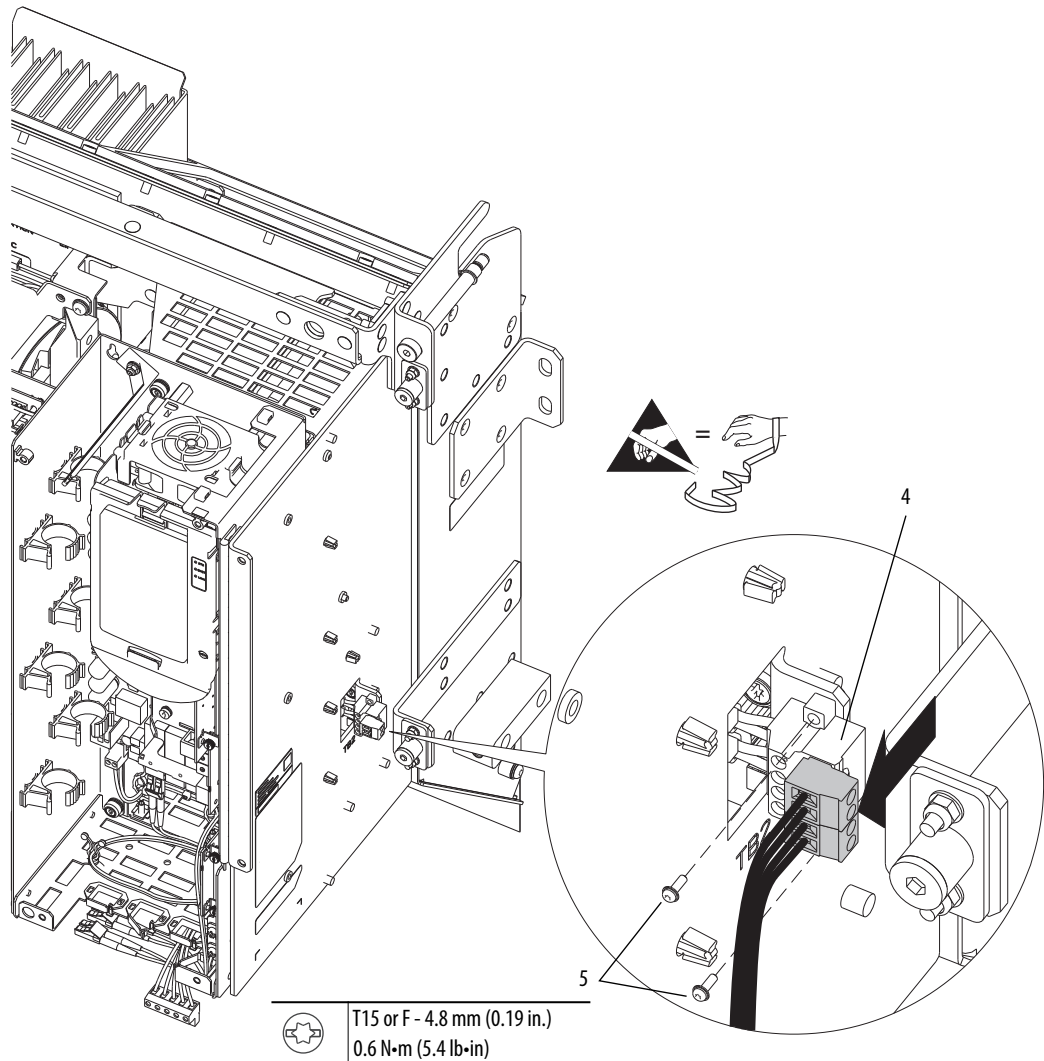
Install the Converter Gate Board Stirring Fan

Install the stirring fan in the reverse order of removal. See Remove the Converter Gate Board Stirring Fan on page [131](#).

24V/240V Power Wire Harness Removal/Installation

Remove the 24V/240V Power Wire Harness

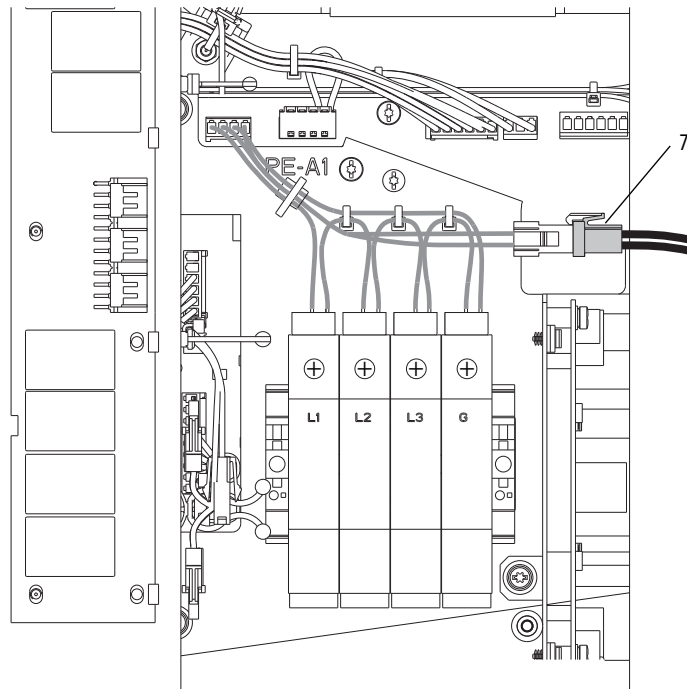
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Disconnect the enclosure fan harness and enclosure shunt trip harness from TB2.
5. Remove the two M3 screws from TB2.



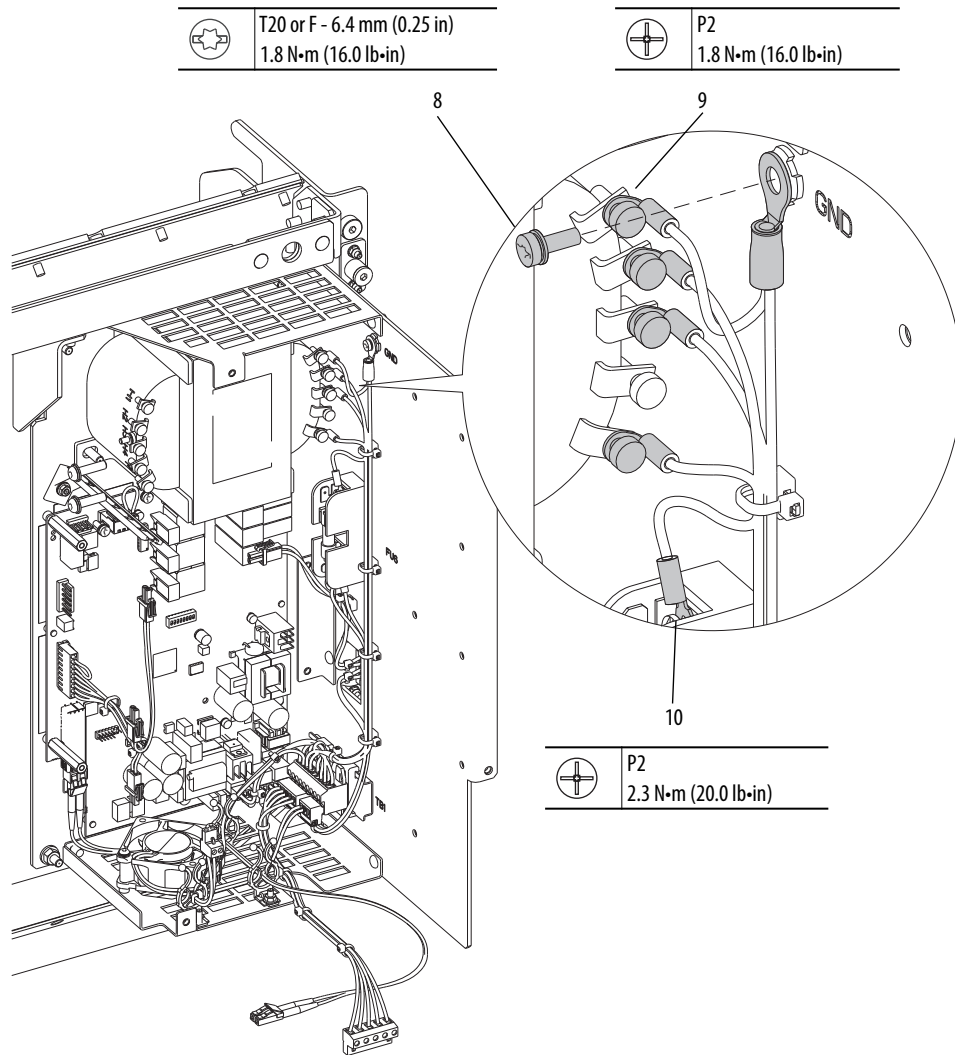
6. If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

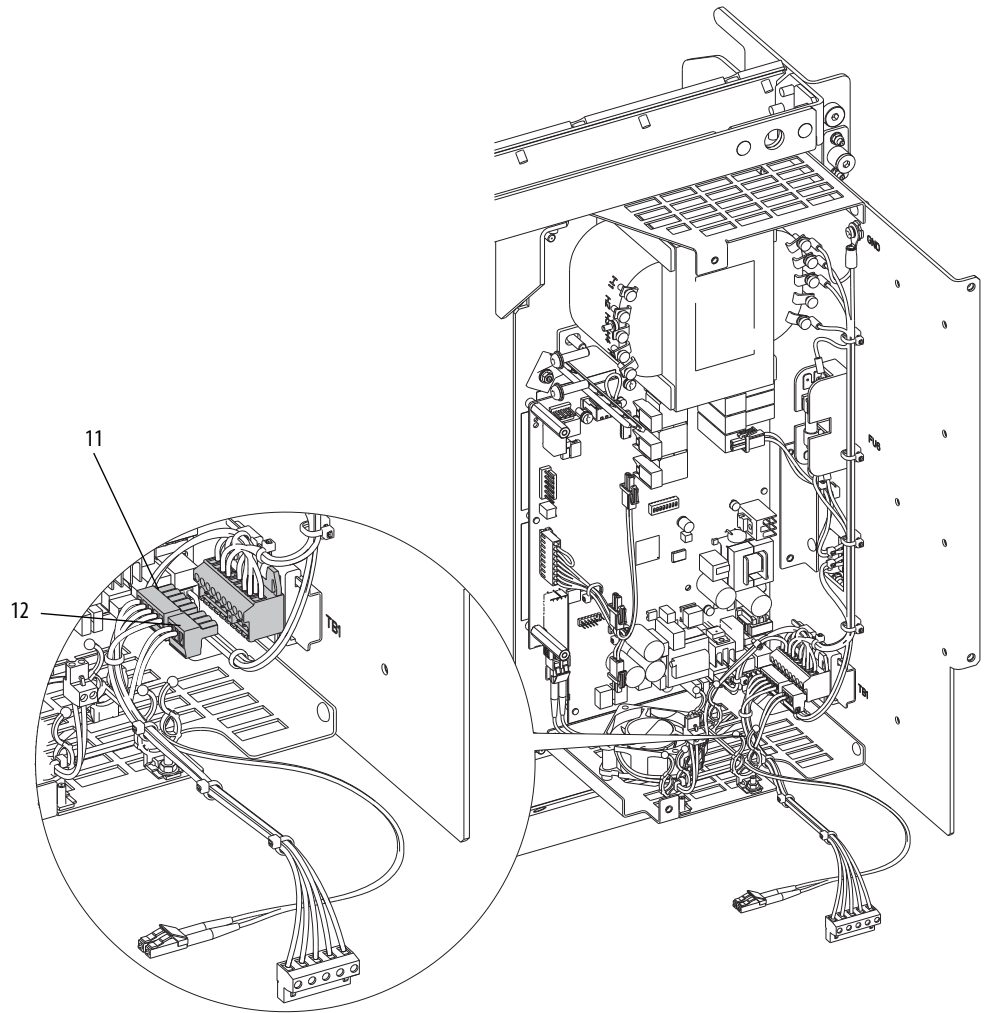
7. Disconnect the connector from the shunt trip ST terminal.



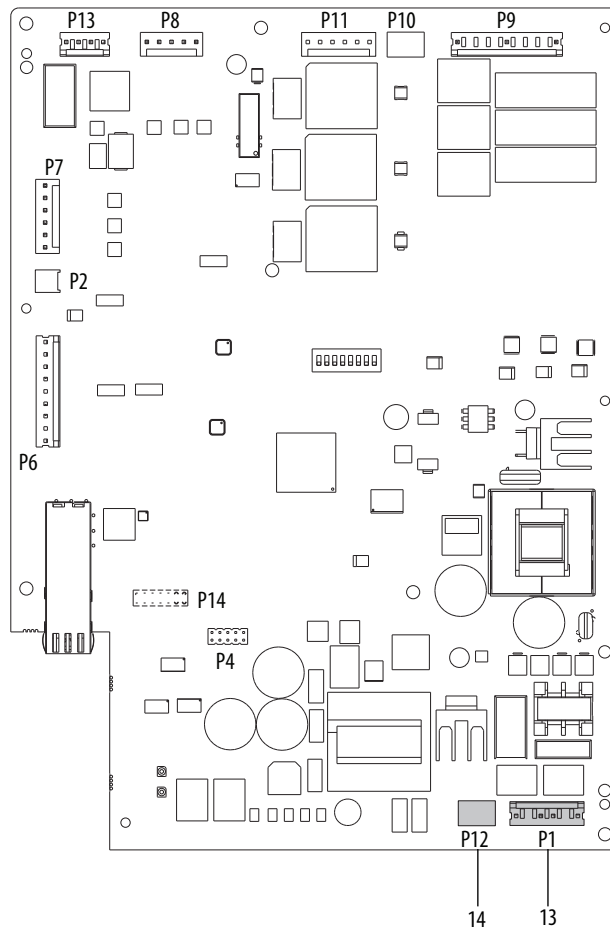
8. Remove the M4 screw that secures the ground wire lug to the converter control panel and remove the ground wire lug.
9. Loosen the M4 screws that secure the four X1 and X2 lead wires to the control transformer and remove the leads.
10. Loosen the captive screws that secure the two X2 lead wires from the FU6 fuse block and remove the leads.



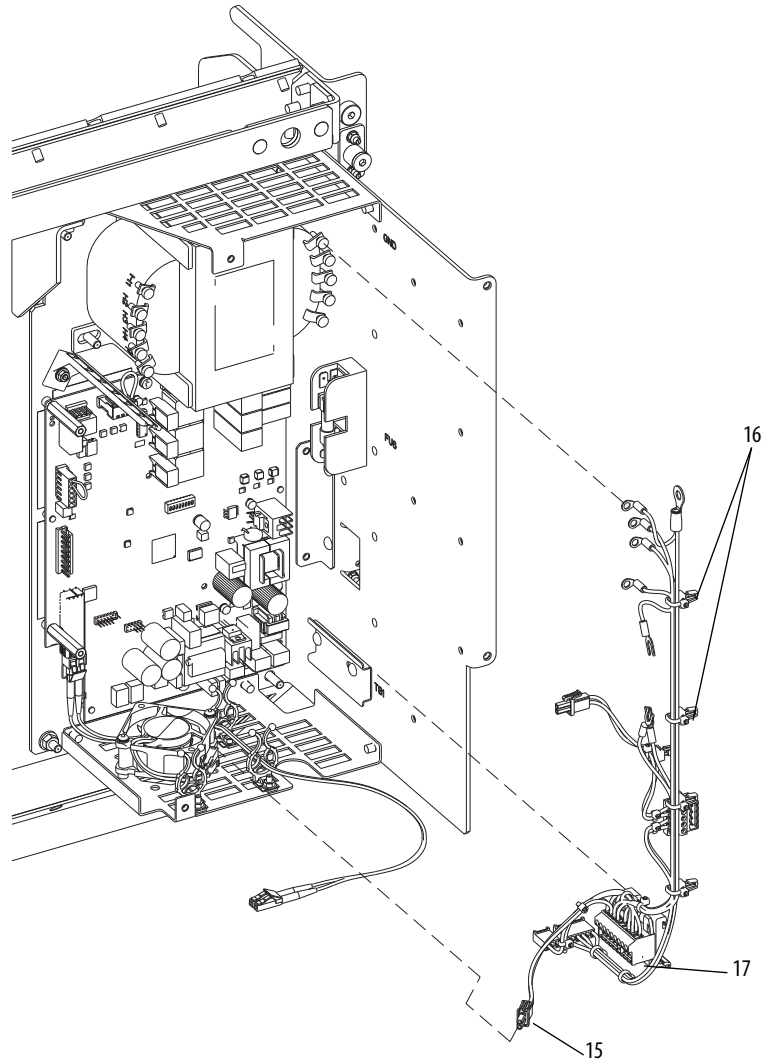
11. Disconnect the five-position inverter power supply wire harness connector from TB1.
12. Disconnect the three-position 24V wire harness connector from TB1.



13. Disconnect the enclosure fan six-position connector from converter gate board P1.
14. Disconnect the system 24V three-position connector from converter gate board P12.



15. Disconnect the two-position connector from the stirring fan.
16. Loosen the four cable tie mounts along the outside right surface of the converter control panel by using the pliers.
17. Release terminal block TB1 from the DIN rail and remove the 24V/240V power wire harness from the converter control panel.



Install the 24V/240V Power Wire Harness

Install the 24V/240V power wire harness in reverse order of removal. See Remove the 24V/240V Power Wire Harness on page [132](#).

Control-transformer Primary Wire Harness Removal/Installation

Remove the Control-transformer Primary Wire Harness

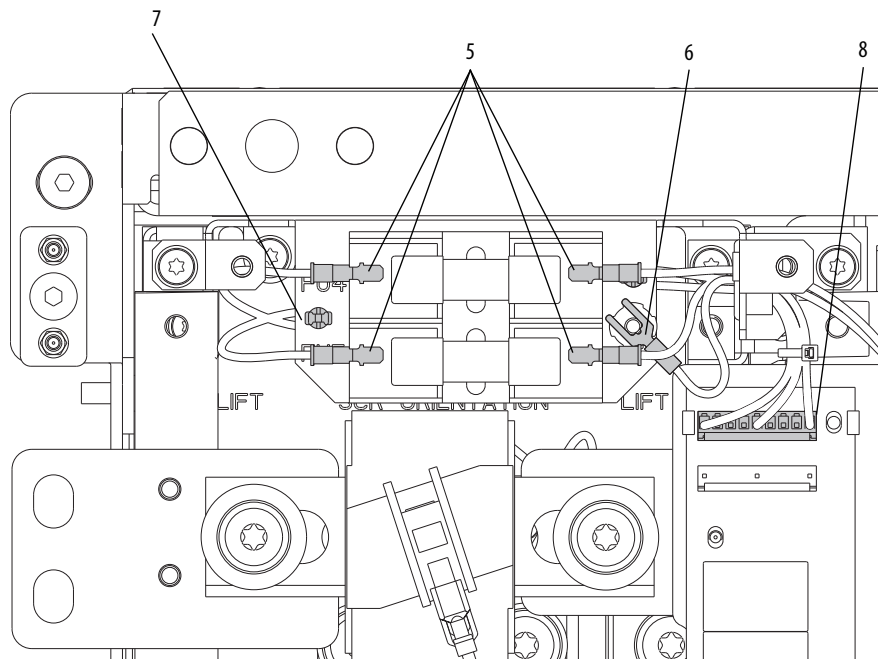
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

5. Disconnect the wire harness FU4-1, FU4-2, FU5-1, and FU5-2 connectors from the FU4/FU5 fuse block.
6. Disconnect the ground wire from the fuse bracket by loosening the screw.
7. Release the two cable tie supports from the fuse bracket.

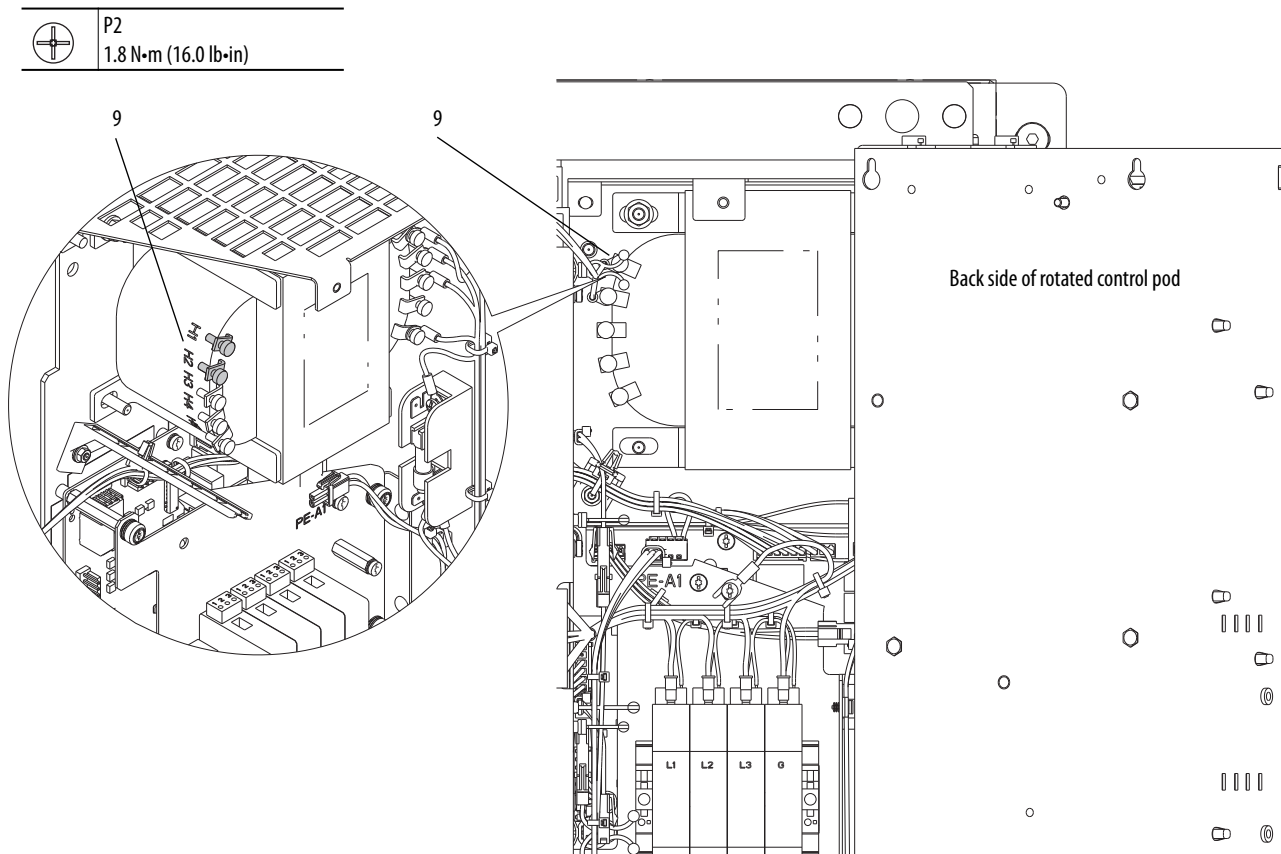
IMPORTANT Before you disconnect the control-transformer primary wire harness J2/J3 connector from the EMC filter board, note the J2/J3 location. The P3 (PE-A2) terminal is grounded. The P2 terminal is not grounded. The jumper settings are provided in the PowerFlex 750-Series Power Jumpers Installation Instructions, publication [750-IN011](#), available at <http://www.rockwellautomation.com/literature/>.

8. Remove the J2/J3 connector from the P2 or P3 connector on the EMC filter board.



IMPORTANT Before you disconnect the control-transformer primary wire harness, note the terminal connections. The control transformer has multiple input phase terminals. See the AC Input Drive Control Transformer Schematic Diagram on page 442 for more information.

9. Disconnect the control-transformer primary wire harness lead wires H1 and Hx from the control transformer input terminals. Release the cable support securing the harness to the EMC filter plastic support.



10. Slide one end of the wire harness through the fuse bracket and remove the control-transformer primary wire harness.

Install the Control-transformer Primary Wire Harness

Install the control-transformer primary wire harness in the reverse order of removal. See Remove the Control-transformer Primary Wire Harness on page [138](#).

IMPORTANT Verify that the PE-A2 connector is reassembled in the appropriate location (P2 or P3) on the EMC filter board.

IMPORTANT Verify that the control-transformer primary wire harness lead wires H1 and Hx are connected to the correct input terminals. The control transformer has multiple input phase terminals. See the AC Input Drive Control Transformer Schematic Diagram on page [442](#) for more information. If the wire are connected to the wrong terminals, drive damage can occur.

Control Transformer Removal/Installation

Remove the Control Transformer

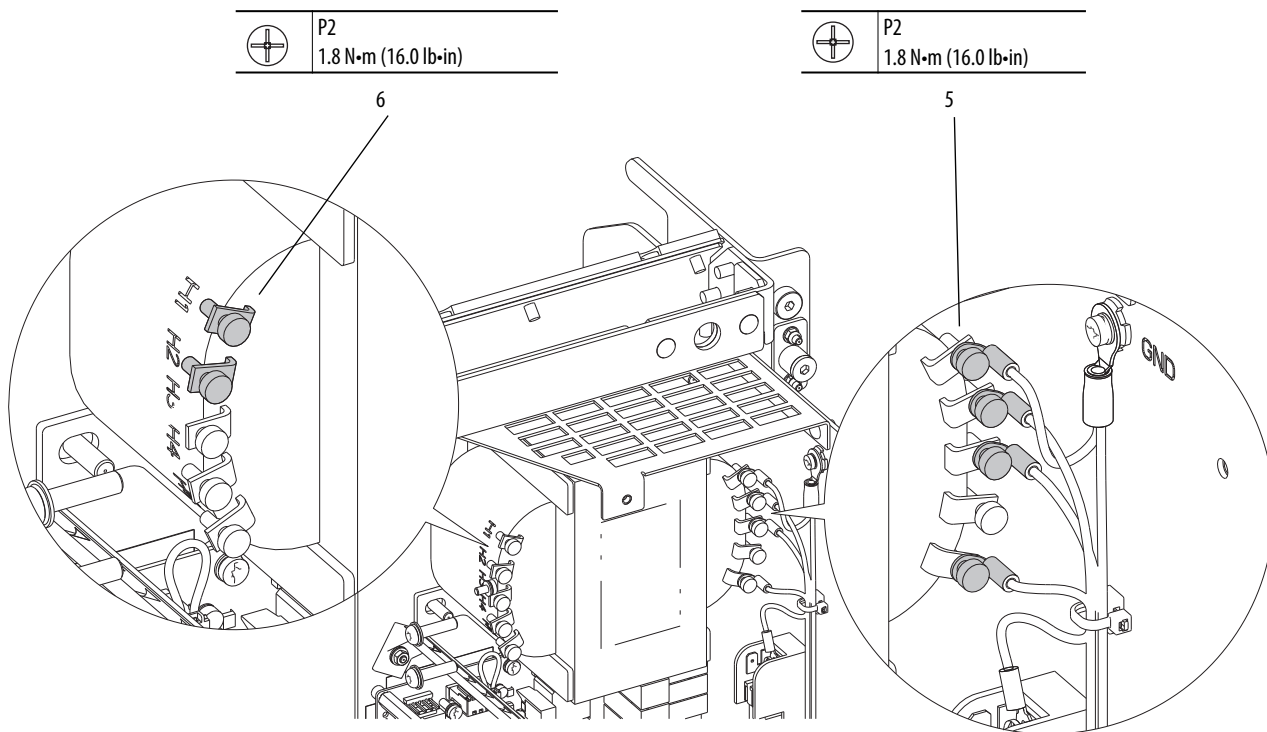
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

- Loosen the M4 screws that secure the four X1 and X2 lead wires to the control transformer and remove the leads.

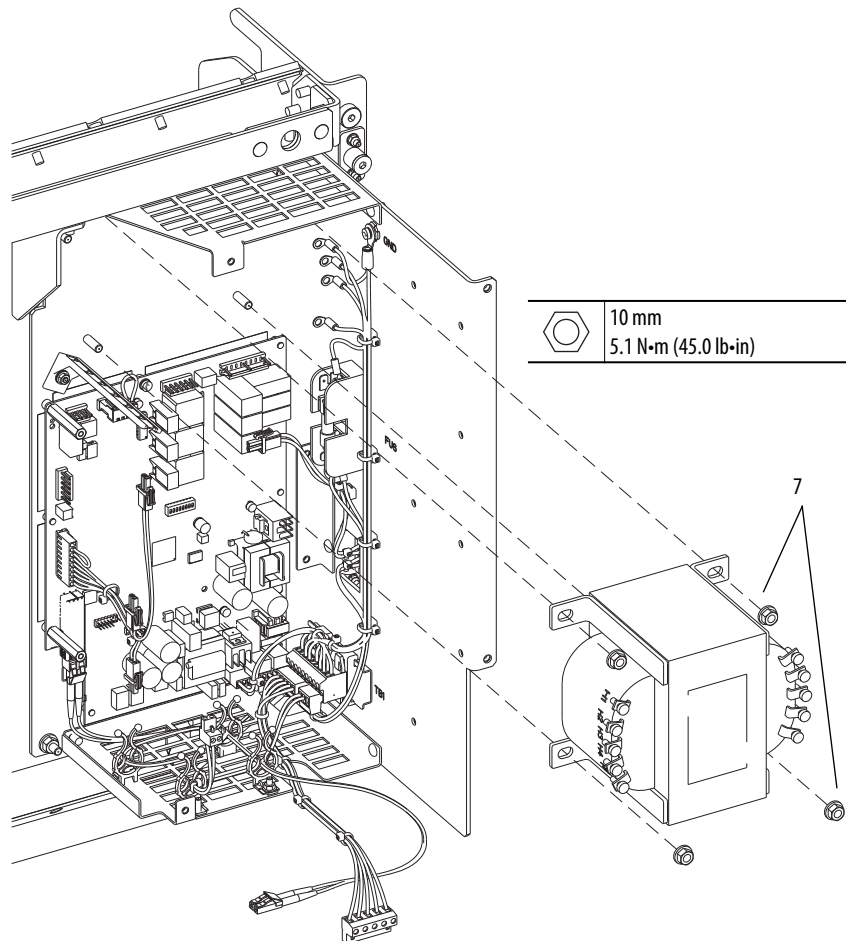
IMPORTANT Before you disconnect the control-transformer primary wire harness, note the terminal connections. The control transformer has multiple input phase terminals. See the AC Input Drive Control Transformer Schematic Diagram on page [442](#) for more information.

- Disconnect the control-transformer primary wire harness lead wires H1 and Hx from the control transformer input terminals. Release the cable support securing the harness to the EMC filter plastic support.



IMPORTANT The control transformer is heavy. Be sure to support it as you remove the screws, so it does not fall and damage other components.

7. Remove four M6 hex nuts that secure the control transformer to the chassis and slide the control transformer forward off the control panel mounting studs.



Install the Control Transformer

Install the control transformer in the reverse order of removal. See Remove the Control Transformer. See AC Input Drive Control Transformer Schematic Diagram on page [442](#) for more information.

IMPORTANT Verify that the control-transformer primary wire harness lead wires H1 and Hx are connected to the correct input terminals. The control transformer has multiple input phase terminals. See the AC Input Drive Control Transformer Schematic Diagram on page [442](#) for more information. If the wires are connected to the wrong terminals, drive damage can occur.

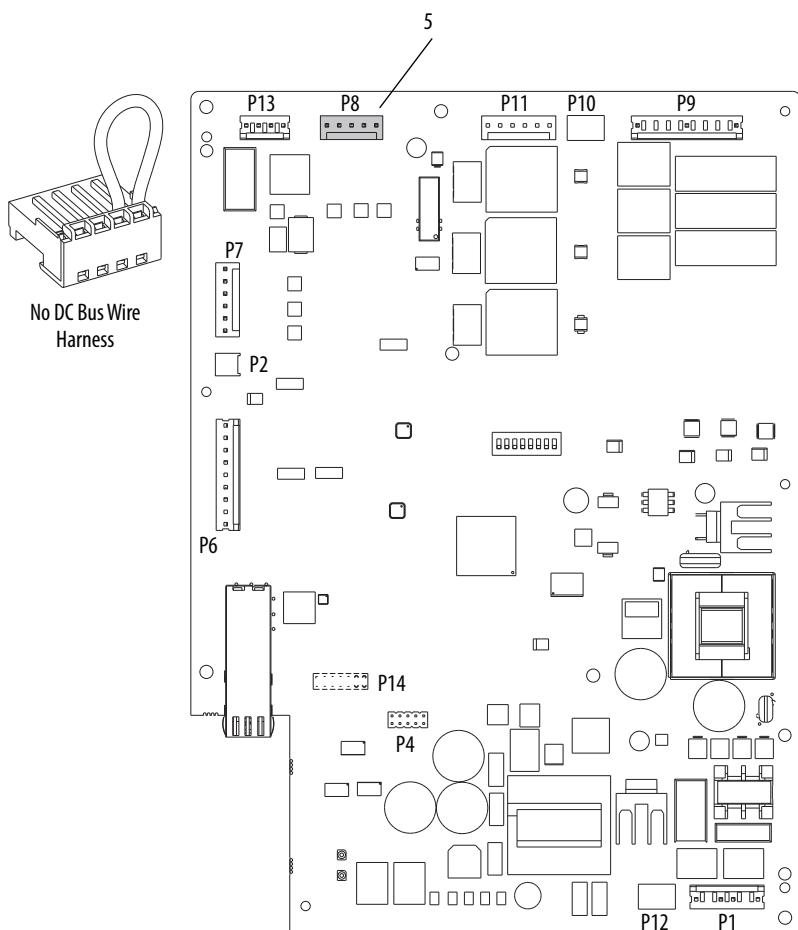
No DC Bus Fuse Wire Harness Removal/Installation (Frame 8 Drives Only)

Remove the No DC Bus Fuse Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

5. Remove the no DC bus fuse wire harness from the converter gate board P8 terminal.



Install the No DC Bus Fuse Wire Harness

Install the No DC bus fuse wire harness in the reverse order of removal. See Remove the No DC Bus Fuse Wire Harness on page [143](#).

DC Bus Fuse Wire Harness Removal/Installation (Frame 9 and Larger Drives Only)

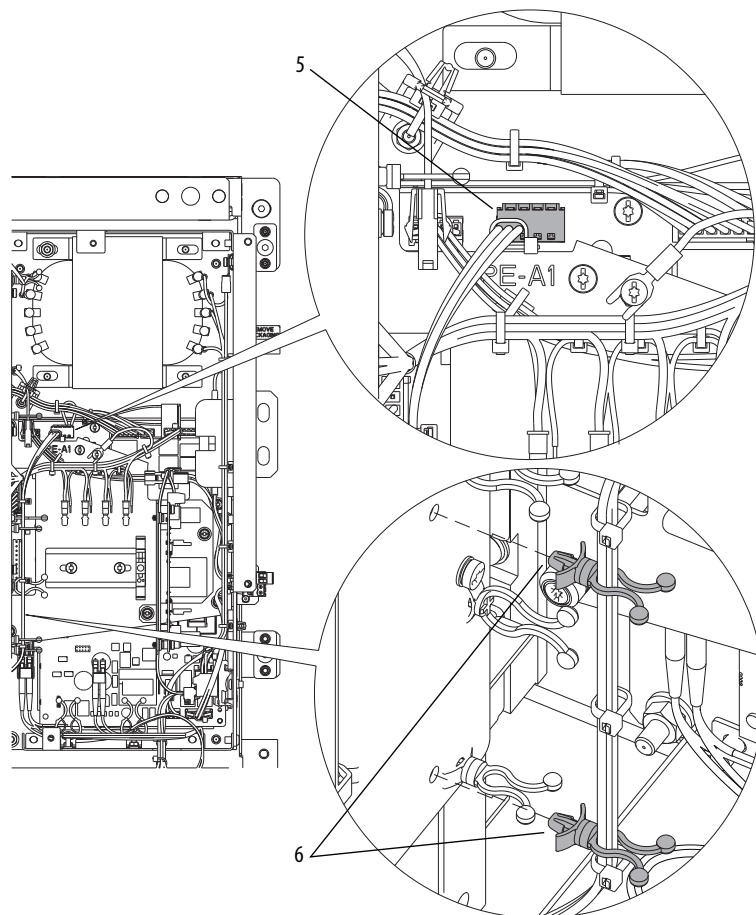
Remove the DC Bus Fuse Wire Harness

Note: This procedure is applicable to frame 9 and larger drives only.

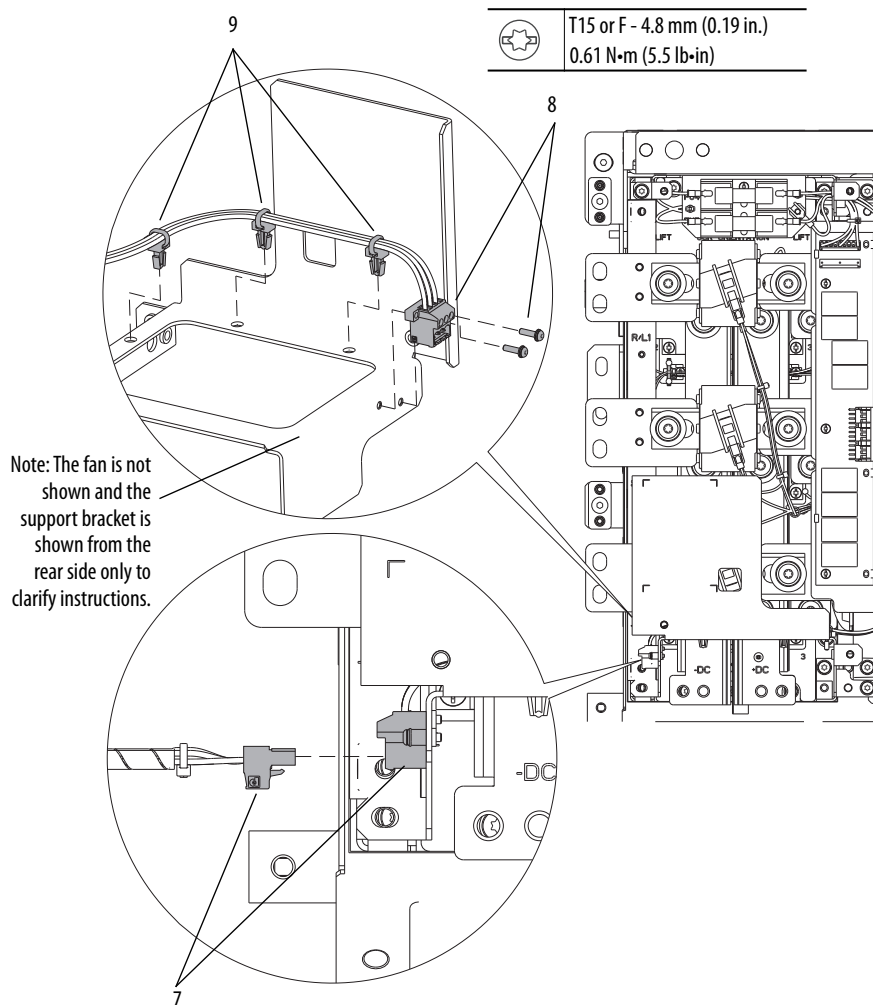
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

5. Disconnect the four-position DC bus fuse wire harness connector J8 from P8 on the converter gate board.
6. Unlatch the two twist-lock cable supports on the AC line filter board support.



7. Disconnect the cabinet-side, three-position DC bus fuse wire harness connector from terminal block TB6 on the lower left side of the converter.
8. Remove the two M3 x 12 mm screws that secure the harness terminal block TB6 to the cover support bracket.
9. Disengage the three cable tie push mounts that secure the harness to the cover support bracket, and remove the harness.



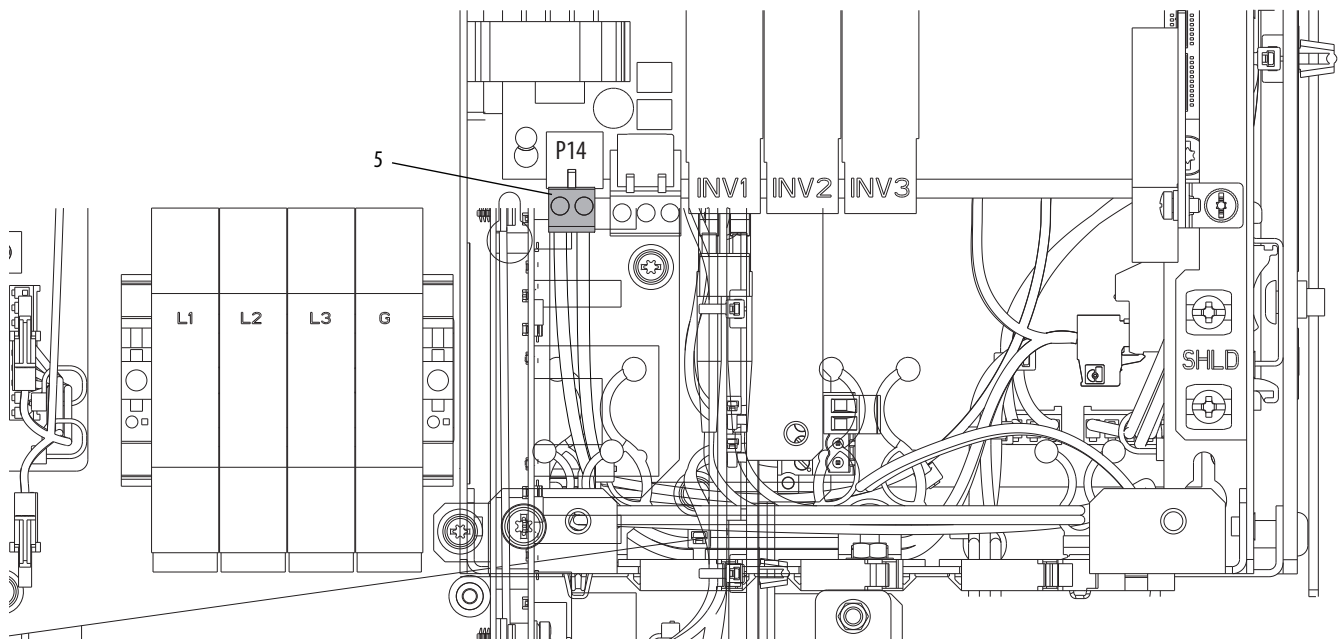
Install the DC Bus Fuse Wire Harness

Install the DC bus fuse wire harness in the reverse order of removal. See Remove the DC Bus Fuse Wire Harness on page [144](#).

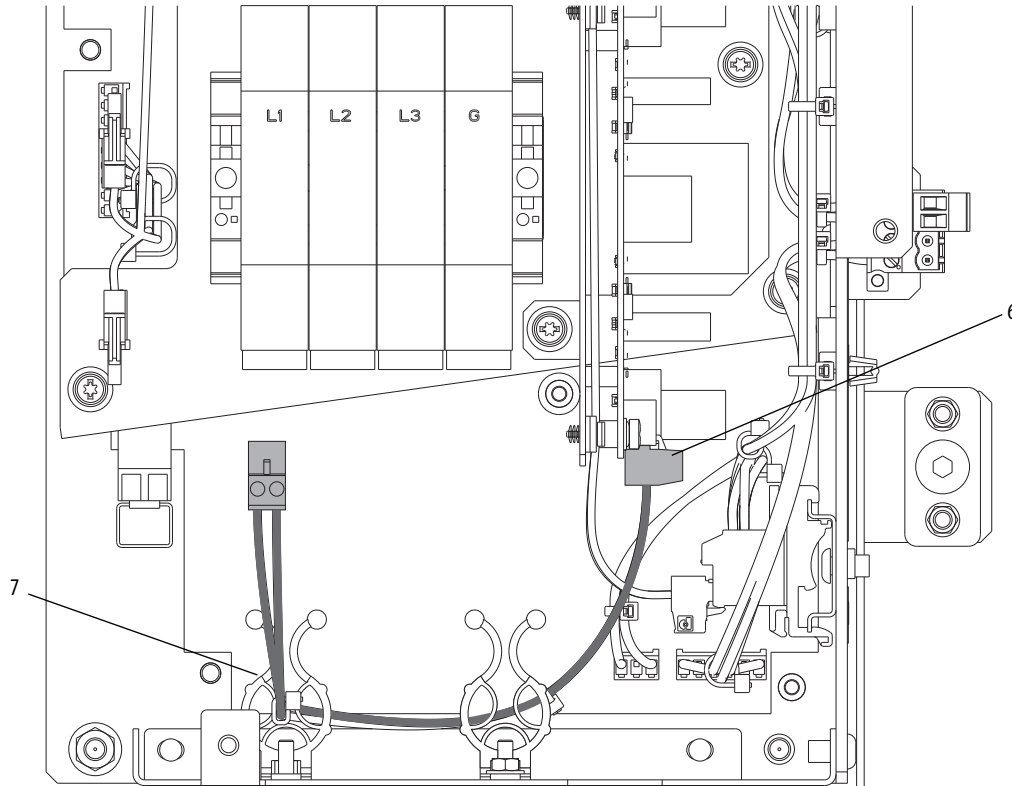
Control Power Isolator Board 24V Wire Harness Removal/ Installation (600/690V AC Input Drives Only)

Remove the Control Power Isolator Board 24V Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the door of the enclosure that contains the control pod.
4. To gain access to the converter control panel, rotate the control pod. See Rotate the Control Pod Forward on page [88](#).
5. If necessary, disconnect the 24V wire harness two-position connector from P14 on the fiber interface board in the control pod.



6. Disconnect the 24V wire harness two-position connector from the terminal block on the bottom of the control power isolator board.
7. Open the twist-lock cable support that secures the wire harness to the bottom of the control frame and remove the wire harness.



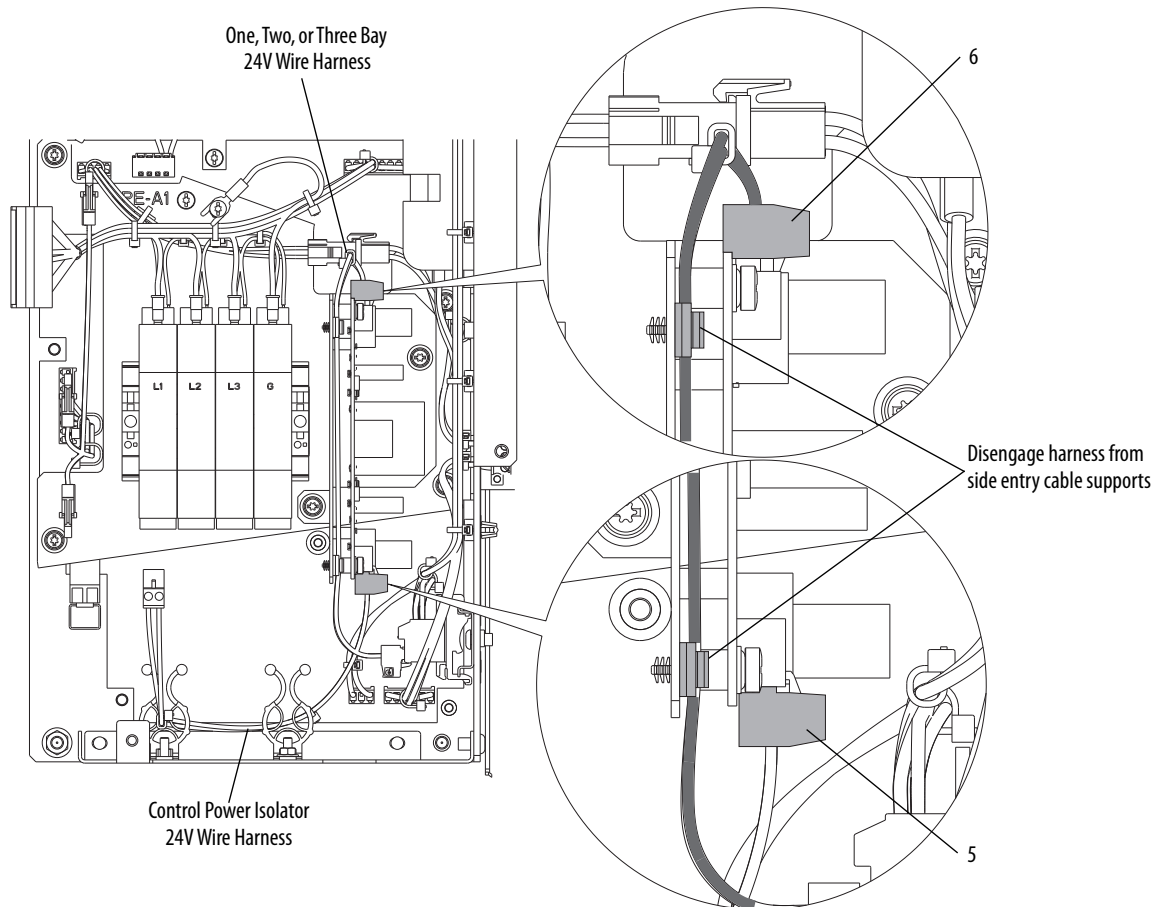
Install the Control Power Isolator Board 24V Wire Harness

Install the control power isolator board 24V wire harness in the reverse order of removal. See [Remove the Control Power Isolator Board 24V Wire Harness](#) on page [146](#).

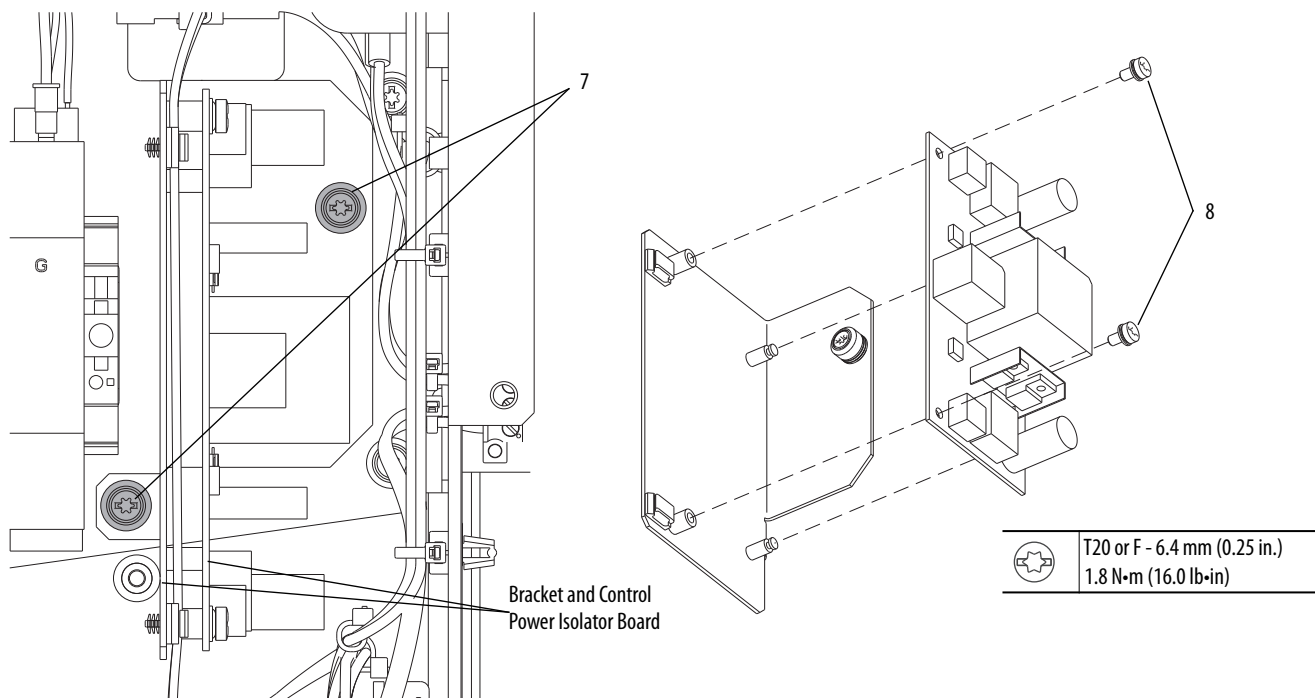
Control Power Isolator Board Removal/Installation (600/690V AC Input Drives Only)

Remove the Control Power Isolator Board

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the door of the enclosure that contains the control pod.
4. To gain access to the converter control panel, rotate the control pod. See Rotate the Control Pod Forward on page [88](#).
5. Disconnect the 24V wire harness two-position connector from the bottom of the control power isolator board.
6. Disconnect the upper one, two, or three bay 24V wire harness two-position connector from the top of the control power isolator board. Disengage the harness from the two side-entry cable supports.



7. Loosen the two M4 captive screws that secure the control-power isolator board mounting bracket to the MOV mounting plate and remove the bracket with the board attached.
8. Remove the two M4 x 12 mm screws that secure the control power isolator board to the mounting bracket. Pull the board out to disengage it from two non-threaded standoffs and remove the board.



Install the Control Power Isolator Board

Install the control power isolator board in the reverse order of removal. See Remove the Control Power Isolator Board on page [148](#).

Converter Gate Circuit Board Removal/Installation

Remove the Converter Gate Circuit Board

IMPORTANT Determine if the existing converter gate board is series A or series B, and verify that you have ordered/received a compatible board before replacement. See Drive Series Components Compatibility on page [30](#) for details.

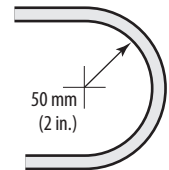
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.

- If the control pod is installed, then rotate the control pod to gain access to the converter control panel. See Rotate the Control Pod Forward on page [88](#).

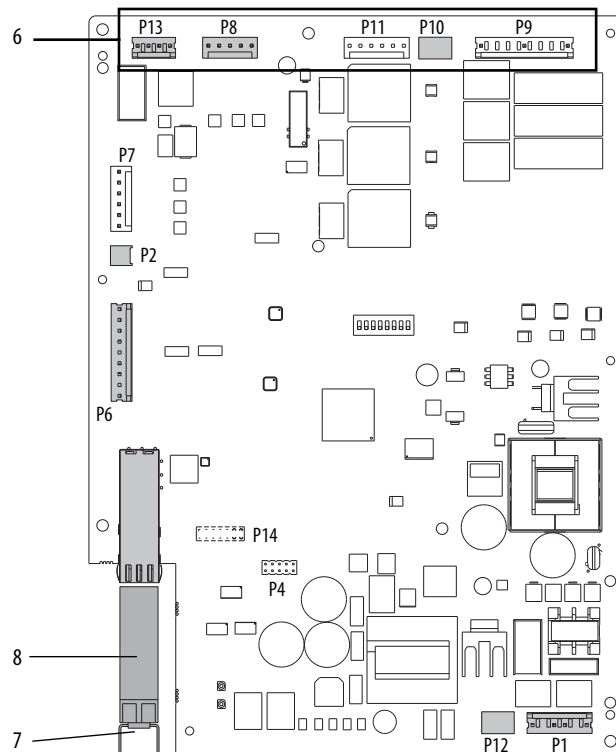
If the control pod is not installed, then remove the converter right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#).

- Remove the surge suppressor assembly. See Remove the Surge Suppressor Assembly on page [127](#).
- Disconnect all wire harnesses from the converter gate board.

IMPORTANT Minimum inside bend radius for fiber-optic cable is 50 mm (2 in.). Any bends with a shorter inside radius can permanently damage the fiber-optic cable. Signal attenuation increases with decreased inside bend radii.



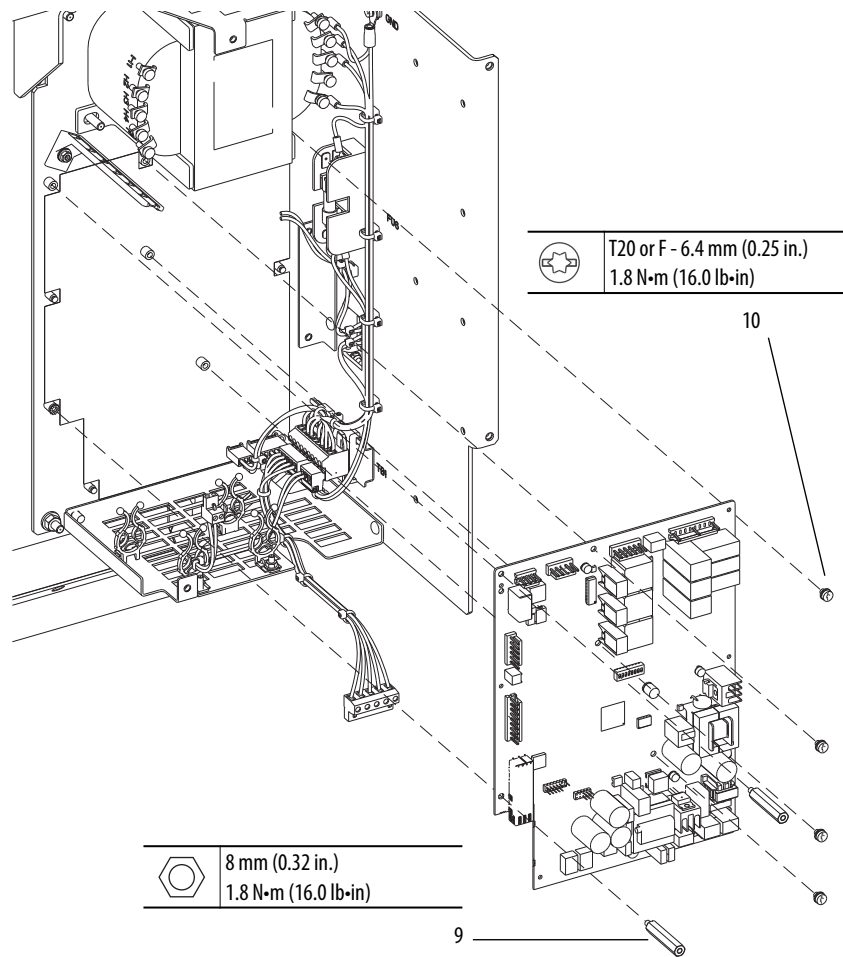
- Disconnect the fiber-optic cable from the port in the lower left corner of the gate board.
- From the fiber-optic cage in the lower left corner of the converter gate board, remove the fiber-optic transceiver by pulling its wire latch. Set the transceiver aside and save for reinstallation.



IMPORTANT When installing the fiber-optic cable, be sure that the wire latch is down.

9. Remove the two M4 x 40 mm hex standoffs.
10. Remove the four M4 x 6 mm screws that secure the converter gate board to the converter control panel. Slide the converter gate board up to disengage its four keyhole slots and remove the board.

IMPORTANT Do not remove the insulation sheet that is attached to the converter duct.



Install the Converter Gate Circuit Board

1. Verify that the insulation sheet is attached to the converter duct.
2. Install the converter gate board in the reverse order of removal. See Remove the Converter Gate Circuit Board on page [149](#).

Converter Removal/ Installation



ATTENTION: Only perform a field replacement of the converter section of the power core (the converter is attached to the inverter) as part of the drive assembly removal procedure. Otherwise, equipment damage can result.

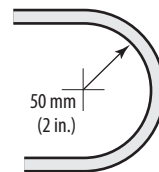
Remove the Converter from the Inverter Assembly

IMPORTANT Determine if the existing converter is series A or series B, and verify that you have ordered/received a compatible unit before replacement. See Drive Series Components Compatibility on page [30](#) for details.

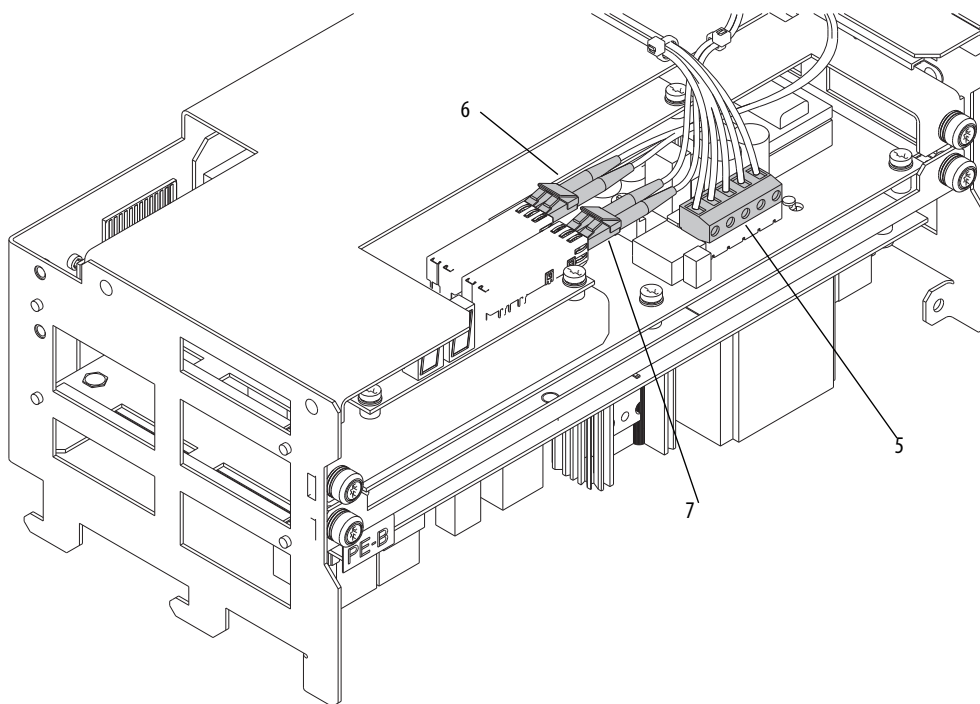
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Remove the drive assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
4. Remove the inverter circuit board connections cover from the inverter. See Inverter Circuit Board Connections Cover Removal/Installation on page [238](#).

5. Disconnect the inverter power-supply wire harness connector from terminal P6 on the inverter power control board.

IMPORTANT Minimum inside bend radius for fiber-optic cable is 50 mm (2 in.). Any bends with a shorter inside radius can permanently damage the fiber-optic cable. Signal attenuation increases with decreased inside bend radii.



6. Disconnect the converter fiber-optic cable from CONV on the inverter power-layer interface board and secure it to the converter. Do not remove the fiber-optic transceiver.
7. If the control pod is assembled on the converter, disconnect the inverter fiber-optic cable from INV on the inverter power-layer interface board and secure it to the control pod. Do not remove the fiber-optic transceiver.

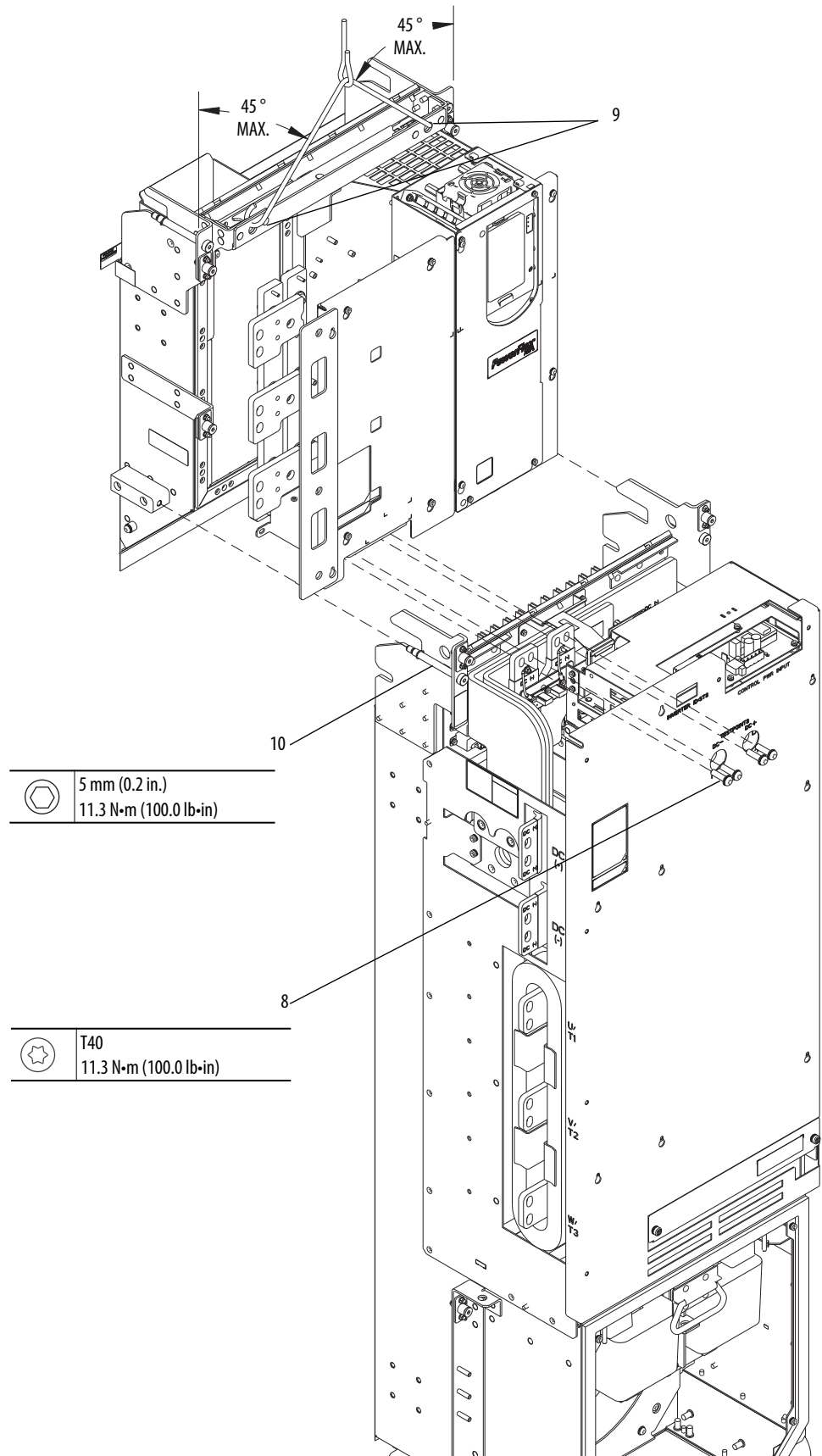


8. Remove the four M8 x 30 mm machine screws that secure the inverter DC bus bars to the converter DC bus bars.

IMPORTANT A load capacity of 80 kg (175 lb) minimum is required for all lifting equipment and hardware that is used for this procedure. Verify that the angle of attachment of the lifting hardware is no more than 45° from vertical.

9. Connect the lifting hardware to the two lifting holes on the lifting bar at the top of the converter section.
10. Loosen the two M8 screws that secure the converter duct to the inverter duct.

11. Lift and slide the converter away from the inverter assembly.



Install the Converter on the Inverter Assembly

1. Inspect the gasket at the top of the converter duct for damage and replace it if necessary. See Converter Duct Gasket Replacement on page [155](#).
2. Inspect the gasket at the top of the inverter duct for damage and replace it if necessary.
3. Install the converter on the inverter assembly in the reverse order of removal. See Remove the Converter from the Inverter Assembly on page [152](#).

Converter Duct Gasket Replacement

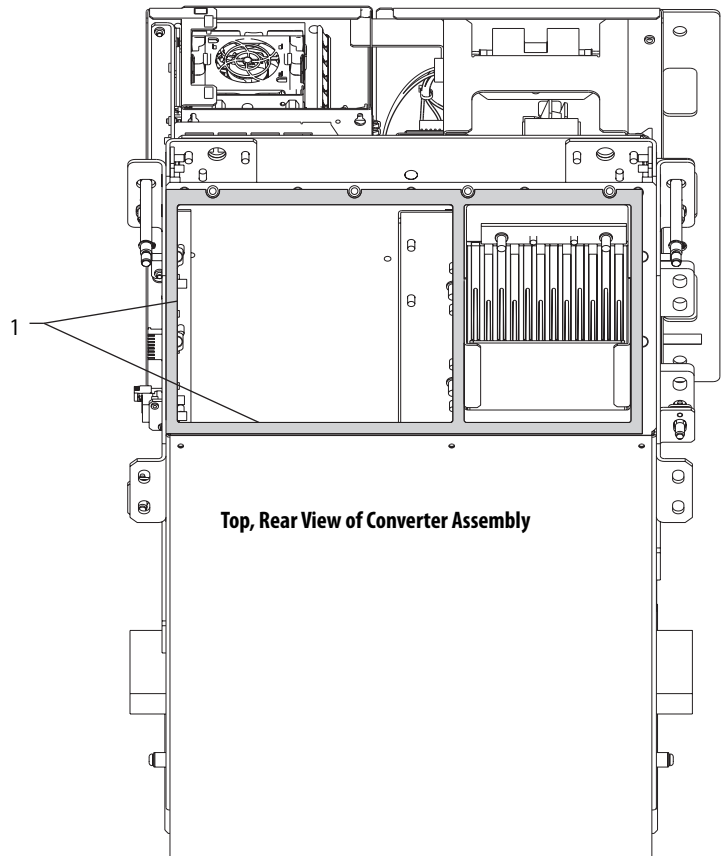
Remove the Converter Duct Gasket

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Remove the drive assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
4. Remove the converter. Remove the Converter from the Inverter Assembly on page [152](#).
5. Carefully remove the gasket and any gasket material that can be stuck to the sealing surface.
6. Clean the duct surface with a 50% isopropyl alcohol/ 50% water mixture.

Install the Converter Duct Gasket

Note: One side of the duct gasket is coated with an adhesive. Take care to align the gasket properly before fully removing the paper liner and exposing the adhesive.

1. Begin removing the paper liner as you align the replacement gasket with the duct edges as shown here and press the gasket into place on the duct.



2. Install the converter on the inverter assembly in the reverse order of removal. See [Remove the Converter from the Inverter Assembly](#) on page [152](#).

DC Input with Precharge Assembly Component Replacement Procedures

Topic	Page
DC Input with Precharge Assembly Components Identification	158
DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard Removal/Installation	163
DC Input with Precharge Assembly Left Cover and Interlock Assembly Replacement	164
DC Input with Precharge Assembly Right Cover (No Control Pod) Removal/Installation	172
Control Transformer Secondary Fuses Removal/Installation	172
DC Bus Output/Sense Wire Harness Removal/Installation	174
Precharge Resistor Assembly Removal/Installation	178
Precharge Resistor Jumper Wires Removal/Installation	179
DC Line Fuses and Fuse Indicators Removal/Installation	180
Precharge Circuit Fuses Removal/Installation	182
DC Bus Input Wire Harness Removal/Installation	183
Left Wall Removal/Installation	184
24V Control Wire Harness Removal/Installation	187
Molded-case Switch Control Wire Harness Removal/Installation	190
Transformer Primary Wire Harness Removal/Installation	193
24V/120V/240V Wire Harness Removal/Installation	195
Disconnect Switch Jumper Wires Removal/Installation	201
Disconnect Switch (SW2), Auxiliary Contact, and Handle Shaft Removal/Installation	202
Disconnect Switch Handle Removal/Installation	203
Control Transformer Removal/Installation	204
Control Power Isolator Board 24V Wire Harness Removal/Installation (810/932V DC Input Drives Only)	207
Control Power Isolator Board Removal/Installation (810/932V DC Input Drives Only)	208
Undervoltage Delay Bracket Removal/Installation	210
Undervoltage Delay Wire Harness Removal/Installation	213
Undervoltage Delay Removal/Installation	214
DC Precharge Control Board Stirring Fan Removal/Installation	215
Door-interlock Wire Harness Removal/Installation	216
Digital I/O Wire Harness Removal/Installation	218
DC Precharge Control Circuit Board Removal/Installation	220
DC Input with Precharge Assembly Removal/Installation	222
DC Input with Precharge Assembly Duct Gasket Replacement	225

This chapter provides detailed procedures for how to remove and replace DC input with precharge assembly components.

Note: In some illustrations in this chapter, the DC input with precharge assembly and/or control pod is shown removed from the drive for clarity only. Only remove the DC input with precharge assembly and/or control pod from the drive if directed to do so.

IMPORTANT Complete the procedures in Chapter 12 Drive Startup after Repairs that begin on page 419 before placing the drive back into service.

DC Input with Precharge Assembly Components Identification

Table 12 contains the components that comprise the DC input with precharge assembly and provides the following information for each component, if applicable:

- Kit catalog number or part number
- Quantity that is contained in the kit
- Illustration figure and page number and identification number

See PowerFlex Architecture Class Low Voltage Drives Spare Parts Options, publication [PFLEX-SB002](#) for a complete list of spare parts for PowerFlex® 755 Frame 8...10 and larger drives.

Table 12 - DC Input with Precharge Assembly Replacement Kits/Parts

Component Description	Replacement Kit Cat. No. or Part No.	Quantity	Figure and Page	ID No.
DC Input with Precharge Unit for 540V, 770 A / 650V, 740 A DC Input Drives	20-750-P6-C770D740	1	–	
DC Input with Precharge Unit for 810V, 510 A / 932V, 500 A DC Input Drives	20-750-P6-E510F500	1	–	
DC Line Fuse Kit, 1600 A, 540/650V DC Input Drives	SK-R1-CBPFUSE1-F8	–		
Fuse, 690/700V, 1600 A (FU1 and FU2)		1	Figure 11 on page 161	1
Fuse Indicator		1	Figure 11 on page 161	2
DC Line Fuse Kit, 1000 A, 810/932V DC Input Drives	SK-R1-CBPFUSE3-F8	–		
Fuse, 1250/1300V, 1000 A (FU1 and FU2)		1	Figure 11 on page 161	1
Fuse Indicator		1	Figure 11 on page 161	2
Precharge and Control Transformer Fuse Kit, 540/932V DC Input Drives	SK-R1-CBPFUSE2-F8	–		
Fuse, 5 A, 600V, Class CC, Time Delay (FU5)		1	Figure 12 on page 162	3
Fuse, 1 A, 600V, Class CC, Time Delay (FU6)		1	Figure 12 on page 162	4
Fuse, Ferrule, Special Purpose, 1000V DC, 20 A (FU3 and FU4)		2	Figure 11 on page 161	5

Table 12 - DC Input with Precharge Assembly Replacement Kits/Parts (continued)

Component Description	Replacement Kit Cat. No. or Part No.	Quantity	Figure and Page	ID No.
Frame 8 DC Input with Precharge Wire Harness Kit	SK-R1-CBPH1-F8	–		
Wire Harness, 24V/120V/240V		1	Figure 12 on page 162	6
Wire Harness, Digital I/O		1	Figure 12 on page 162	7
Wire Harness, Door Lock		1	Figure 12 on page 162	8
Wire Harness, 120V/240V		1	Figure 12 on page 162	9
Wire Harness, DC Bus Output/Sense		1	Figure 11 on page 161	10
Wire Harness, Undervoltage		1	Figure 12 on page 162	11
Wire Harness, 24V Control		1	Figure 12 on page 162	12
Wire Harness, Molded Case Switch Control		1	Figure 12 on page 162	13
Wire Harness, DC Bus Input		1	Figure 11 on page 161	14
Wire Harness, Disconnect Switch Jumper		1	Figure 11 on page 161	15
Wire Harness, Resistor Jumper		1	Figure 11 on page 161	16
Wire Harness, Inverter Power Supply		1	Figure 12 on page 162	17
Precharge Resistor Assembly Kit, 540/650V DC Input Drives	SK-R1-CBPRES-F8	–		
Bracket, Resistor		1	Figure 11 on page 161	18
Resistor, 10 Ohm, Metal Case, Ceramic Collar		4	Figure 11 on page 161	19
Screw, M4 x 12 mm, Pan Head Sems		8	Figure 11 on page 161	20
Precharge Resistor Assembly Kit, 810/932V DC Input Drives	SK-R1-CBPRES2-F8	–		
Bracket, Resistor		1	Figure 11 on page 161	18
Resistor, 20 Ohm, Metal Case, Ceramic Collar		4	Figure 11 on page 161	19
Screw, M4 x 12 mm, Pan Head Sems		8	Figure 11 on page 161	20
Precharge Disconnect Assembly Kit, 540/932V DC Input Drives	SK-R1-CBPSW-F8	–		
Switch, 8-Pole, 32 A, 750V		1	Figure 11 on page 161	21
Shaft, Extended, 6 mm Dia., 70 mm Long		1	Figure 11 on page 161	22
Handle, Pistol Type, Pad-lockable, 6 mm Shaft, Indication I-O; On-Off		1	Figure 11 on page 161	23
Auxiliary Contact Block, IP20, Normally Open, Right Side Mountable		1	Figure 11 on page 161	24
Control Transformer, 120/240VAC In, 120/240VAC Out, 1000VA @240VAC	SK-R1-CBPXFM1-F8	1	Figure 12 on page 162	25
Undervoltage Delay	SK-R1-CBPDELAY-F8	1	Figure 12 on page 162	26
Frame 8 Gasket Kit	20-750-G1-F8	–		
Gasket, Converter, Heatsink		1	(1)	-
Gasket, Converter/DC Input with Precharge Assembly, Duct		1	Figure 11 on page 161	27
Gasket, Inverter, Heatsink		1	(2)	-
Gasket, Inverter, Door Interface		1	(2)	-
Gasket, Inverter, Exhaust Interface		1	(2)	-
Gasket, Inverter, Inlet Ring		1	(2)	-
Gasket, Inverter, No Choke		1	(2)	-
Gasket, Inverter, Blower Box Bottom		1	(2)	-
Gasket, Inverter, Choke		1	(2)	-

Table 12 - DC Input with Precharge Assembly Replacement Kits/Parts (continued)

Component Description	Replacement Kit Cat. No. or Part No.	Quantity	Figure and Page	ID No.
DC Input Control Board Kit, 540/650V DC Input Drives	SK-R1-CBPCTRL-F8	–		
DC Precharge Control Board, 540/650V		1	Figure 12 on page 162	28
Fiber-optic Transceiver		1	Figure 12 on page 162	29
DC Input Control Board Kit, 810/932V DC Input Drives	SK-R1-CBPCTRL2-F8	–		
DC Precharge Control Board, 810/932V		1	Figure 12 on page 162	28
Fiber-optic Transceiver		1	Figure 12 on page 162	29
One-Bay fiber-optic Cable Kit	20-750-FCBL1-F8	–		
CONV Fiber-optic Cable, 560 mm Long		1	Figure 12 on page 162	30
INV Fiber-optic Cable, 560 mm Long		1	Figure 12 on page 162	30
Fiber-optic Transceiver	SK-R1-FTR1-F8	1	Figure 12 on page 162	32
One Bay 24V Wire Harness Kit (Frame 8)	20-750-PH1-F8	1	Figure 12 on page 162	33
Two Bay 24V Wire Harness Kit (Frame 9)	20-750-PH2-F9	1	Figure 12 on page 162	33
Three Bay 24V Wire Harness Kit (Frame 10)	20-750-PH3-F10	1	Figure 12 on page 162	33
Left Front Cover with Shields Kit	SK-R1-CBP-CVR1-F8	–		
Left Front Cover		1	Figure 11 on page 161	34
Top Guard		1	Figure 11 on page 161	35
Left Guard		1	Figure 11 on page 161	36
Left Front Cover and Interlock Assembly Retrofit Kit	20-750-CBPPANEL	–		
Left Front Cover with Access Panel		1	Figure 11 on page 161	34
DC Bus Guard		1	–	
Interlock Assembly		1	–	
L-bracket and Screws		1	–	
Right Front Cover (No Control POD) Kit	SK-R1-CCVR2-F8	–		
Right Front Cover		1	Figure 11 on page 161	37
Bracket, Cover, 59 mm (2.3 in.) Long		2	Figure 12 on page 162	38
Control Power Isolator Board Kit, 600/690V AC and 810/932V DC Input Drives	SK-R1-CPIB1-F8	1	Figure 11 on page 161	39
Control Power Isolator 24V Wire Harness Kit, 600/690V AC and 810/932V DC Input Drives	SK-R1-CPIH1-F8	1	Figure 11 on page 161	40
DC Precharge Control Board Stirring Fan	20-750-CFANKIT-F8	1	Figure 12 on page 162	41

- (1) This gasket is included in the Frame 8 Gasket Kit (20-750-G1-F8), but is identified in the table in Converter Components Identification on page [82](#).
- (2) This gasket is included in the Frame 8 Gasket Kit (20-750-G1-F8), but is identified in the table in Inverter Components Identification on page [228](#).

Figure 11 - DC Input with Precharge Assembly Components Diagram 1

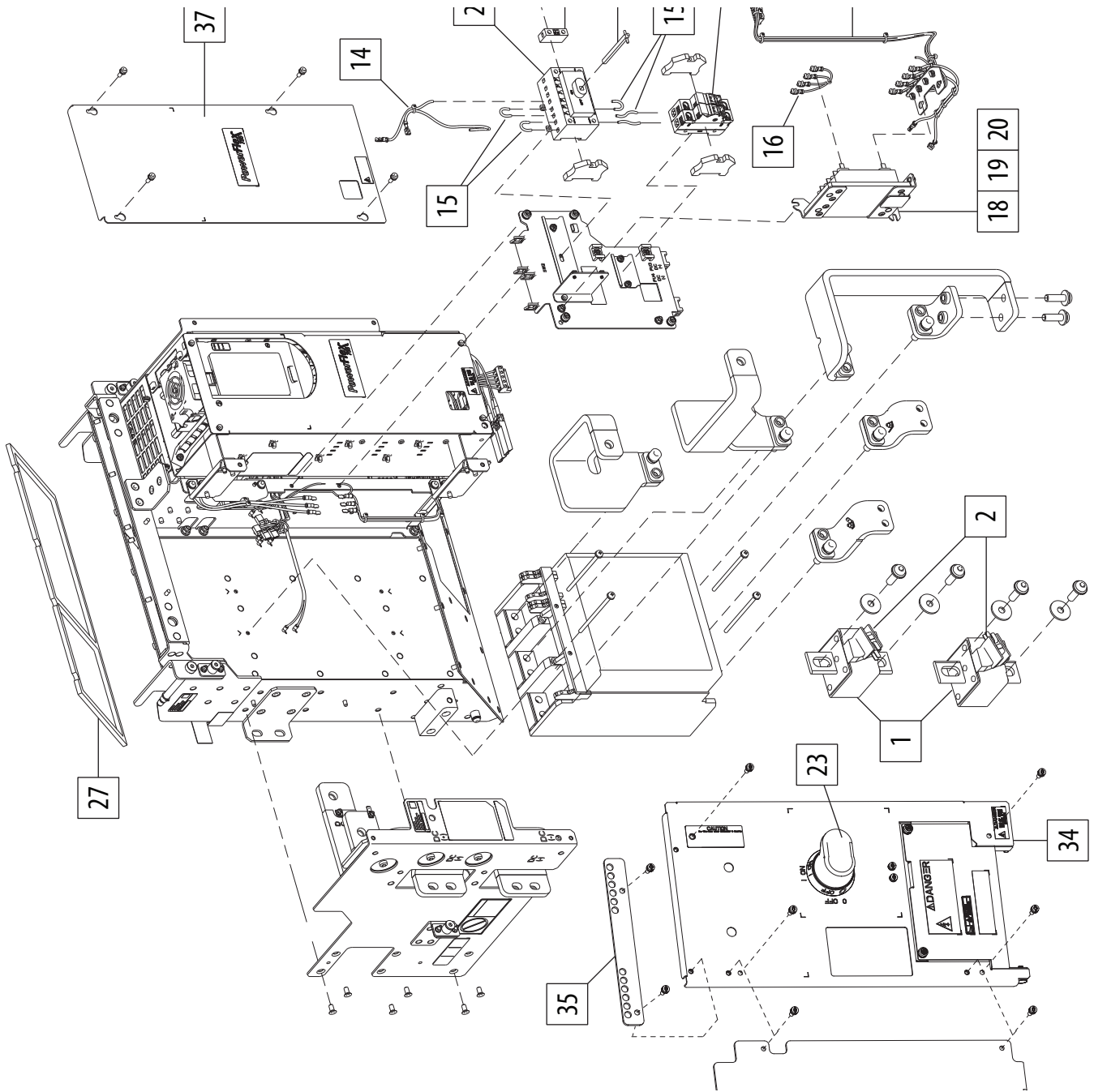
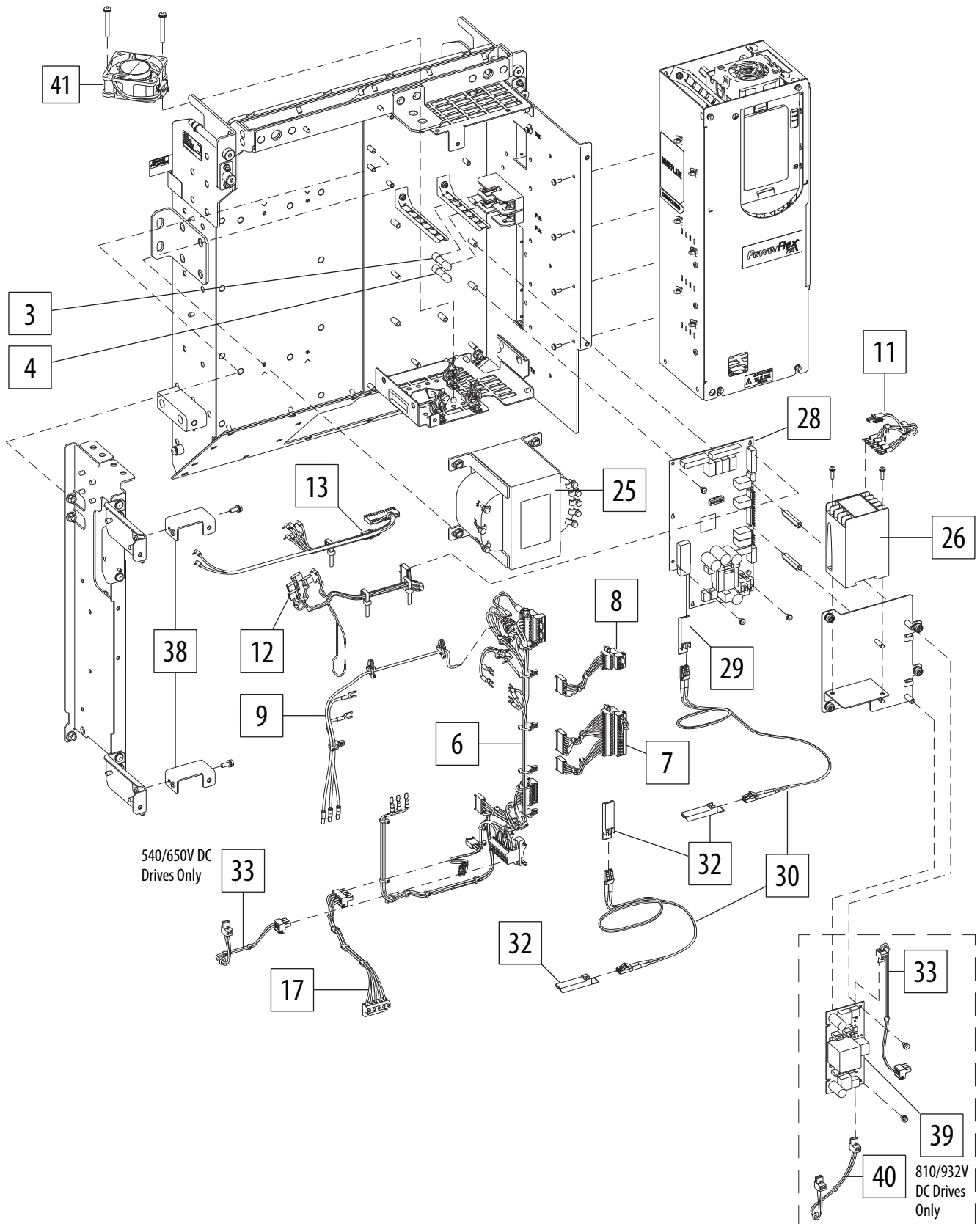


Figure 12 - DC Input with Precharge Assembly Components Diagram 2

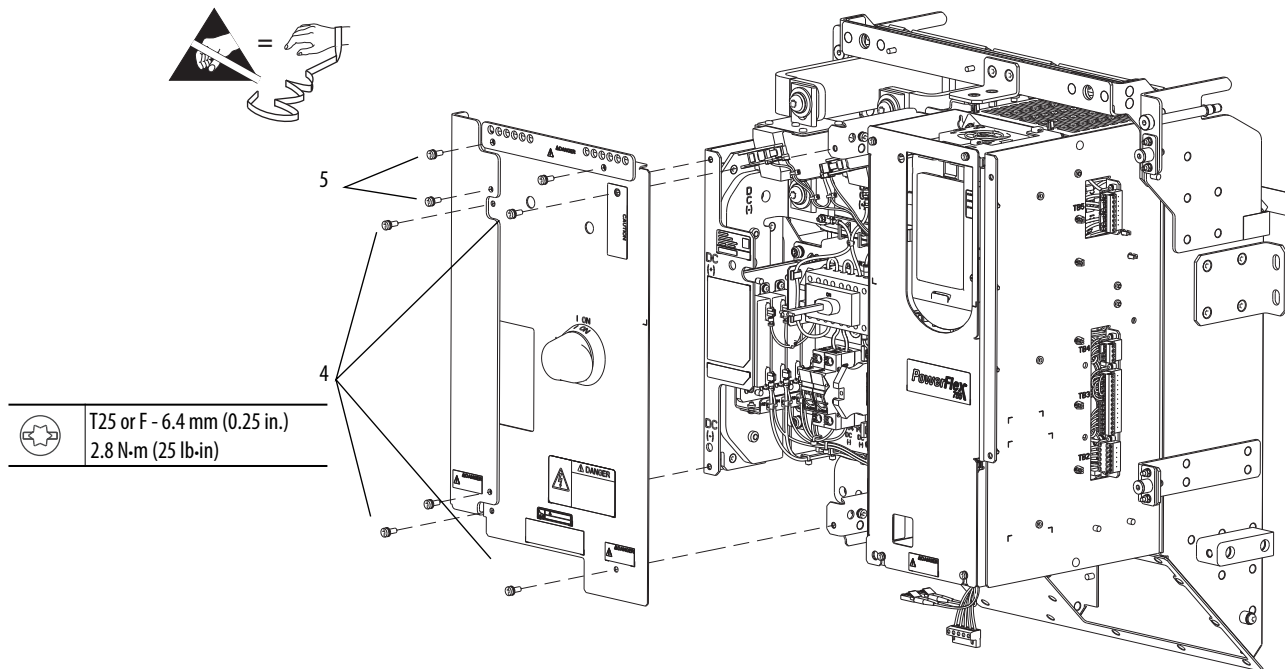


TIP See Fastener/Tool/Torque Information on page [33](#) for descriptions of the fasteners, tools, and torque figures that are used in the disassembly/assembly procedures in this chapter.

DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard Removal/Installation

Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove only the four M5 x 14 mm screws that secure the cover to the assembly and remove the cover with the top and left guards attached.
5. If necessary, remove the four M5 x 14 mm screws that secure the top and left guards to the cover; and remove the guards.



Install the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard

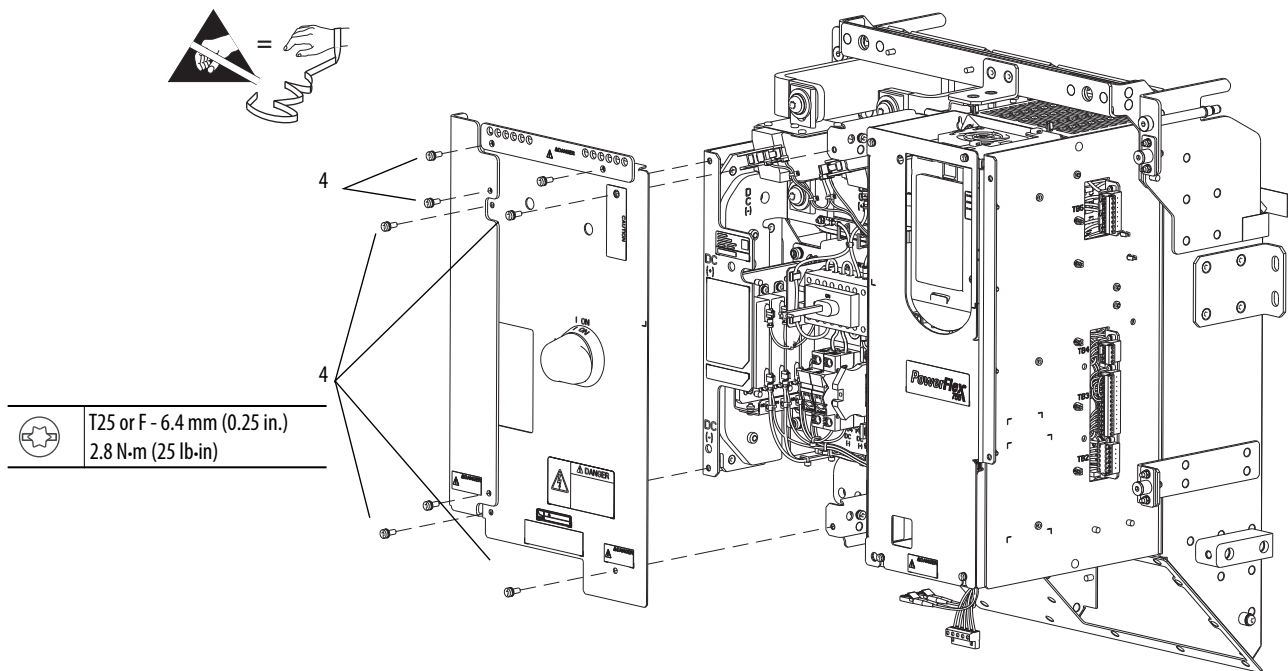
Install the left cover, top guard, and left guard in the reverse order of removal. See Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard.

DC Input with Precharge Assembly Left Cover and Interlock Assembly Replacement

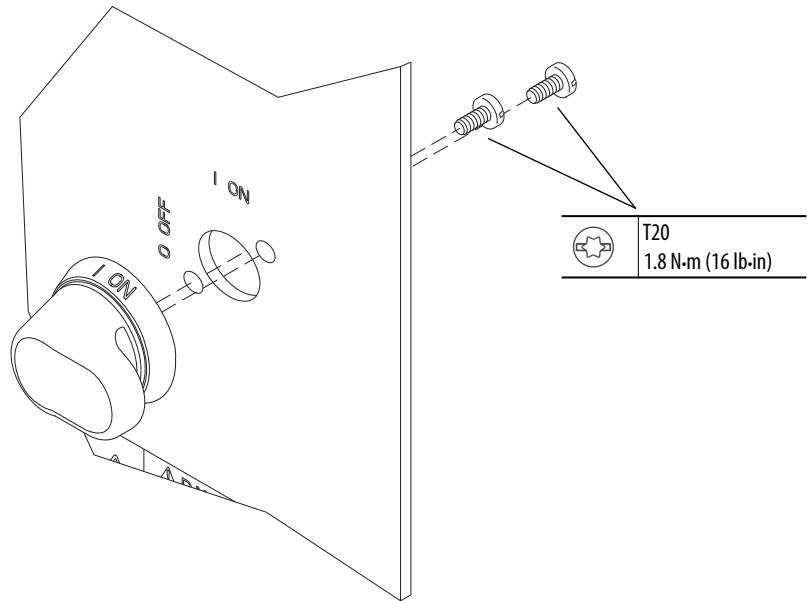
This retrofit kit (cat. no. 20-750-CBPPANEL) can be used to improve the access to the molded case switch (SW1) on common DC input drives for lockout/tagout procedures. Install this kit only on DC input with precharge modules with catalog numbers 20-750-P5-C770D740 and 20-750-P5-E510F500.

Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard and Disconnect Handle

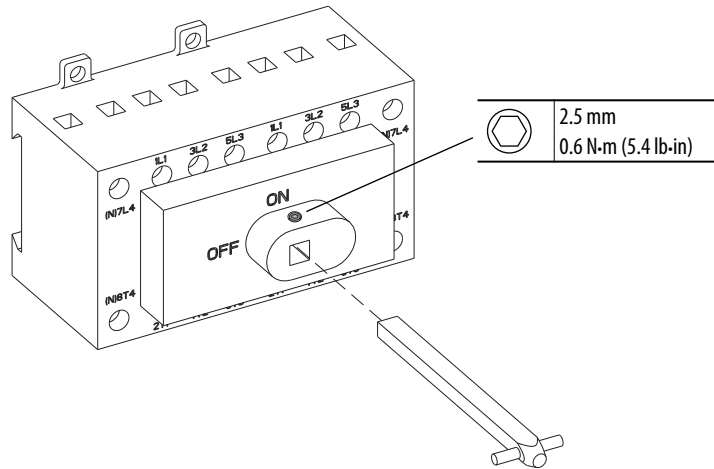
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove only the four M5 x 14 mm screws that secure the cover to the assembly and remove the cover with the top and left guards attached.
5. Remove the four M5 x 14 mm screws that secure the top and left guards to the cover, and remove the guards. Retain the guards and screws for reuse.



- Remove the two M4 x 12 mm hexalobular screws and washers that secure the rotary disconnect on/off handle to the front cover and remove the handle. Retain the handle, screws, and washers for reuse.

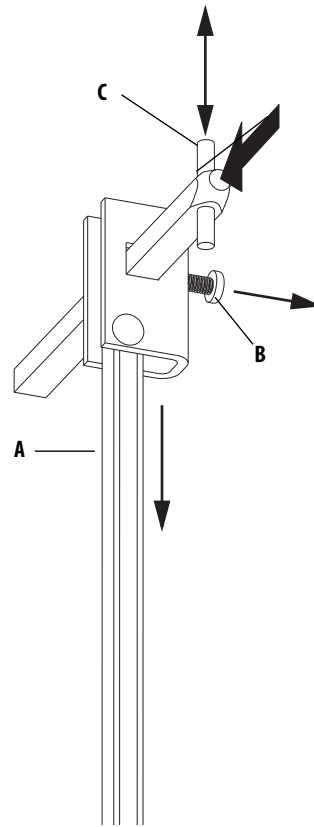


- Loosen the hexagonal screw that secures the disconnect handle shaft to the disconnect switch and remove the handle.

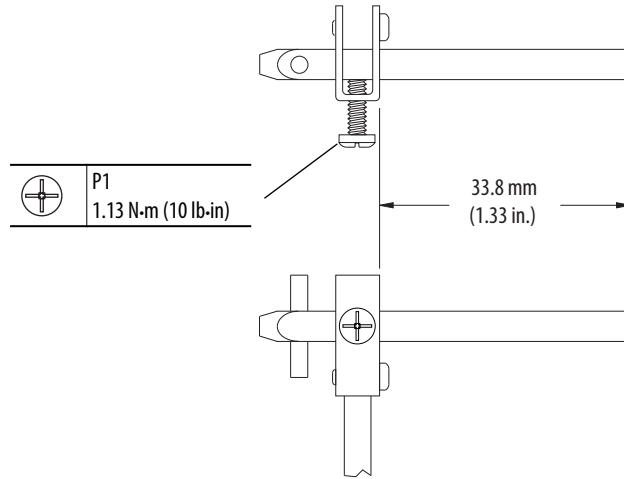


Install the New Disconnect Switch Interlock and Front Cover Assemblies

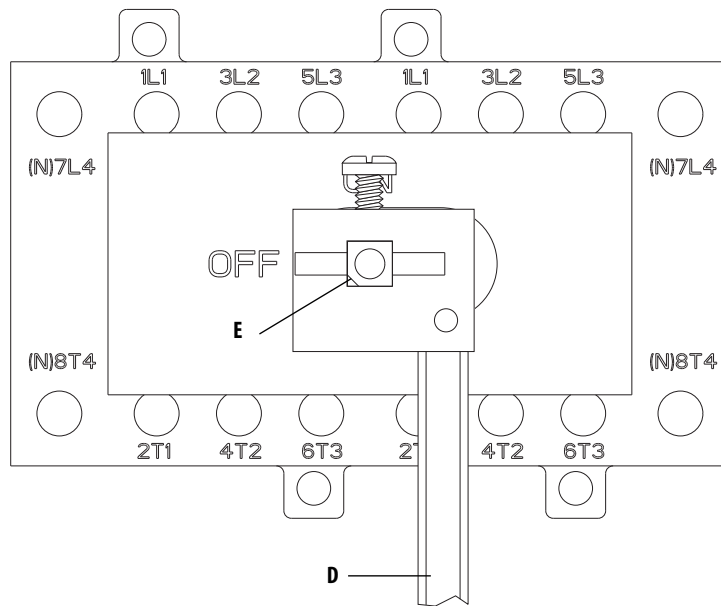
1. Complete steps a....d to install the interlock assembly on the disconnect handle shaft.
 - a. Position the interlock rod (**A**) under the clamp assembly (as shown in the illustration).
 - b. Position the set screw (**B**) to the right of the clamp assembly.
 - c. Position the pins (**C**) on the disconnect handle shaft vertically and slide the base of the shaft through the square opening in the clamp assembly.



- d. Position the back of the interlock clamp assembly 34 mm (1.33 in.) from the base of the shaft and tighten the M3 x 1.5 mm set screw.

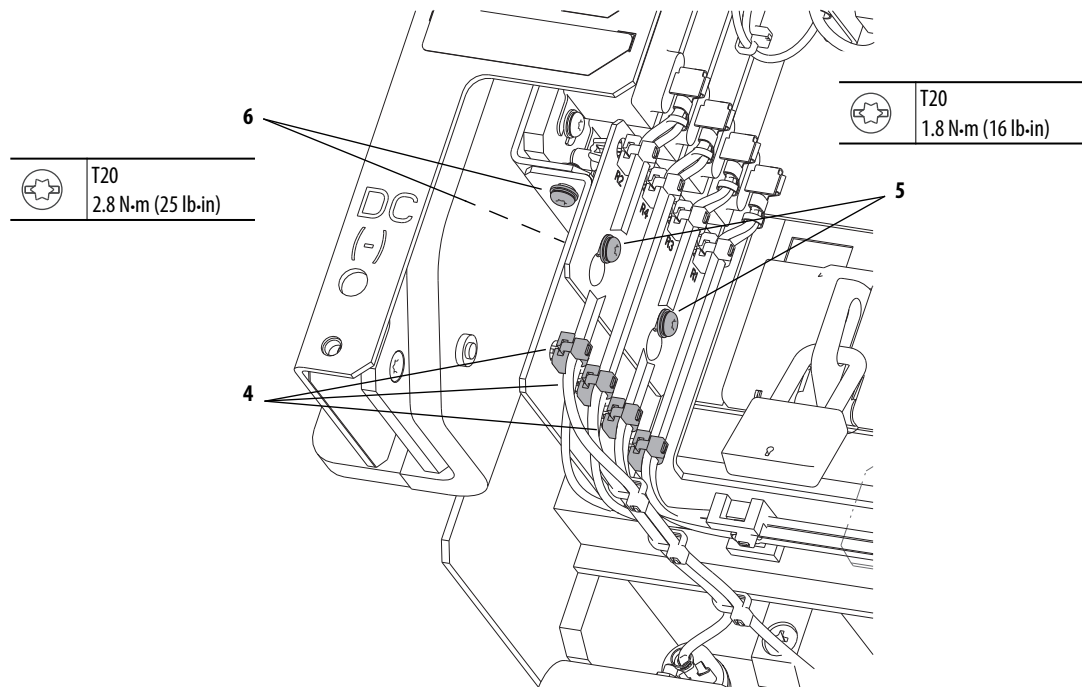


2. With the interlock rod (**D**) positioned below the handle shaft, fully insert the handle shaft (**E**) into the receptacle on the disconnect switch.

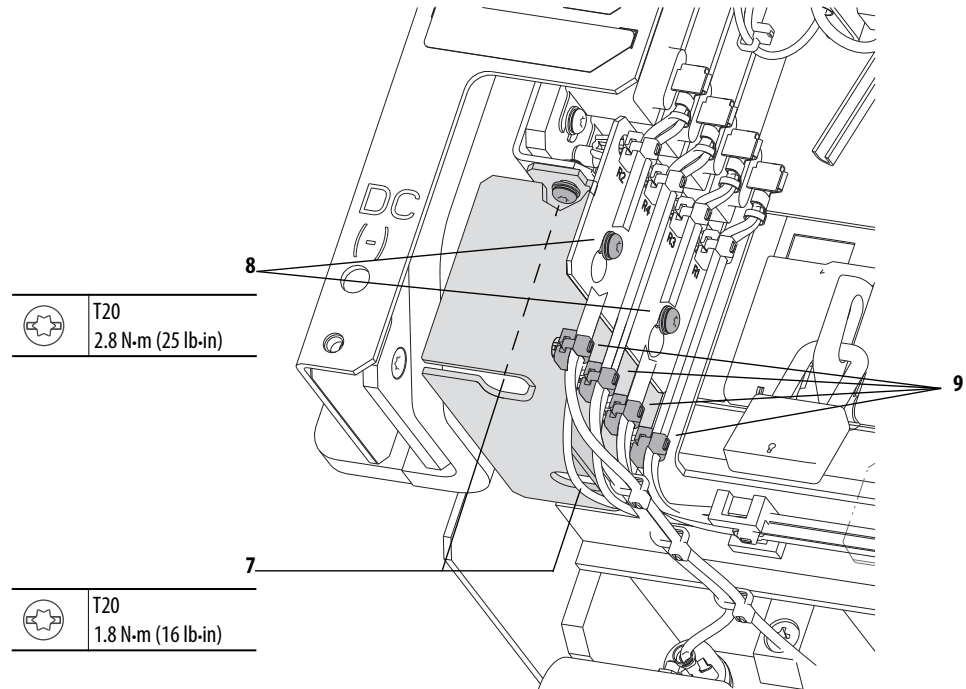


3. Secure the handle shaft in place by using the set screw on the disconnect switch. Torque requirement is 0.6 N•m (5.4 lb•in).

4. By using the pliers, remove the four cable tie mounts, which secure the resistor wires, from the back of the existing DC bus guard.
5. Loosen the two M4 x 12 mm hexalobular screws that secure the clear, plastic shield to the front of the DC bus guard and remove the plastic panel. Retain this panel for reuse.
6. Loosen the two M4 x 12 mm hexalobular screws that secure the sheet metal DC bus guard to the resistor assembly and remove and discard the guard.



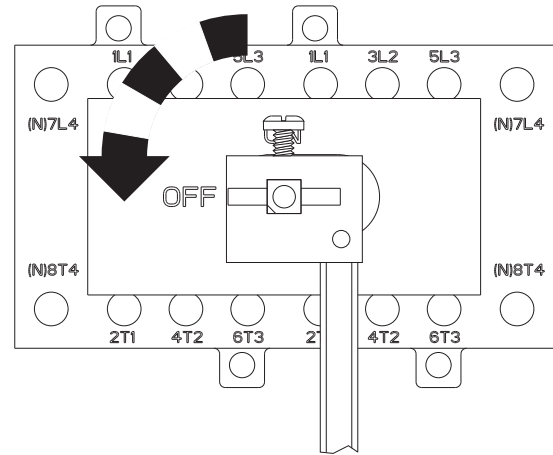
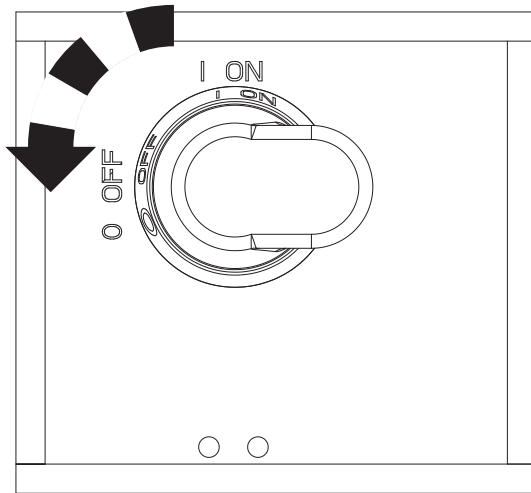
7. Place the new sheet metal DC bus guard on the resistor assembly and secure the guard by tightening the two existing screws.
8. Place the clear, plastic shield on the new DC bus guard and secure the shield by tightening the existing screws.
9. Fully insert the four cable tie mounts, which secure the resistor wires, into the holes on the new DC bus guard.



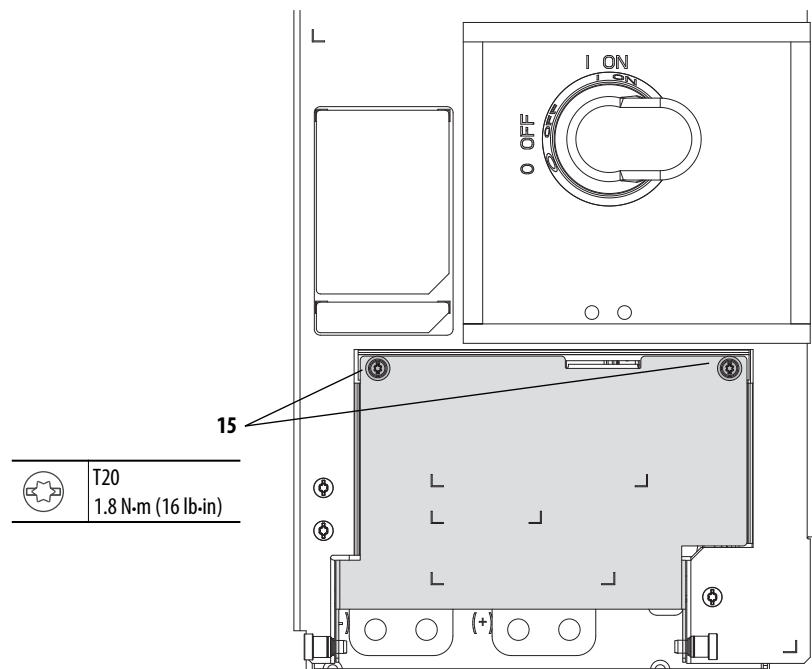
10. Secure the existing rotary on/off disconnect handle to the new DC precharge assembly left front cover by using the two M4 x 8 mm long screws and washers. Torque requirement is 1.8 N•m (16 lb•in).
11. Secure the two clear plastic guards to the new DC precharge assembly left front cover by using the four existing M5 x 14 mm screws. Torque requirement is 2.8 N•m (25 lb•in).

12. Set the rotary on/off handle and the disconnect handle shaft to the “off” position.

The disconnect handle shaft is in the “off” position when the pins on the end of the shaft are oriented horizontally.

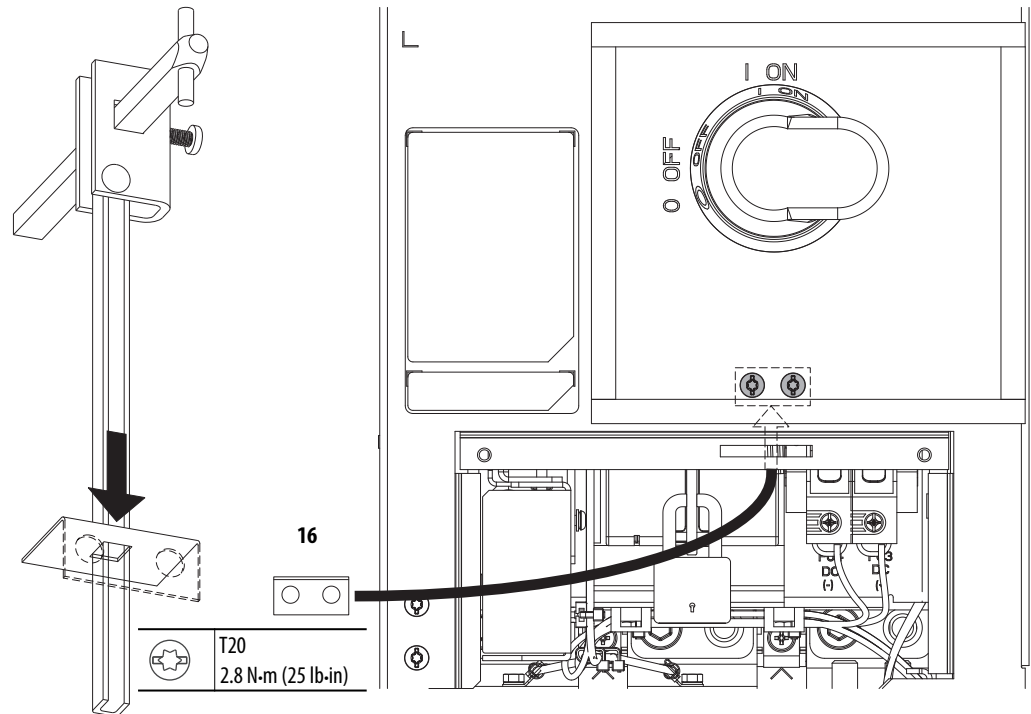


13. Align the rotary disconnect handle and shaft and place the new front cover on the DC precharge unit.
14. Secure the front cover by using the existing screws. Torque requirement is 2.8 N•m (25 lb•in).
15. Loosen the two hexalobular screws that secure the circuit-breaker access door to the left front cover and lower the door.



16. Position the L-bracket with the square opening on top and the screw holes to the front and flush with the back of the cover.

IMPORTANT The interlock rod behind the cover must fit into the square opening on the top of the L-bracket (as shown in the illustration).

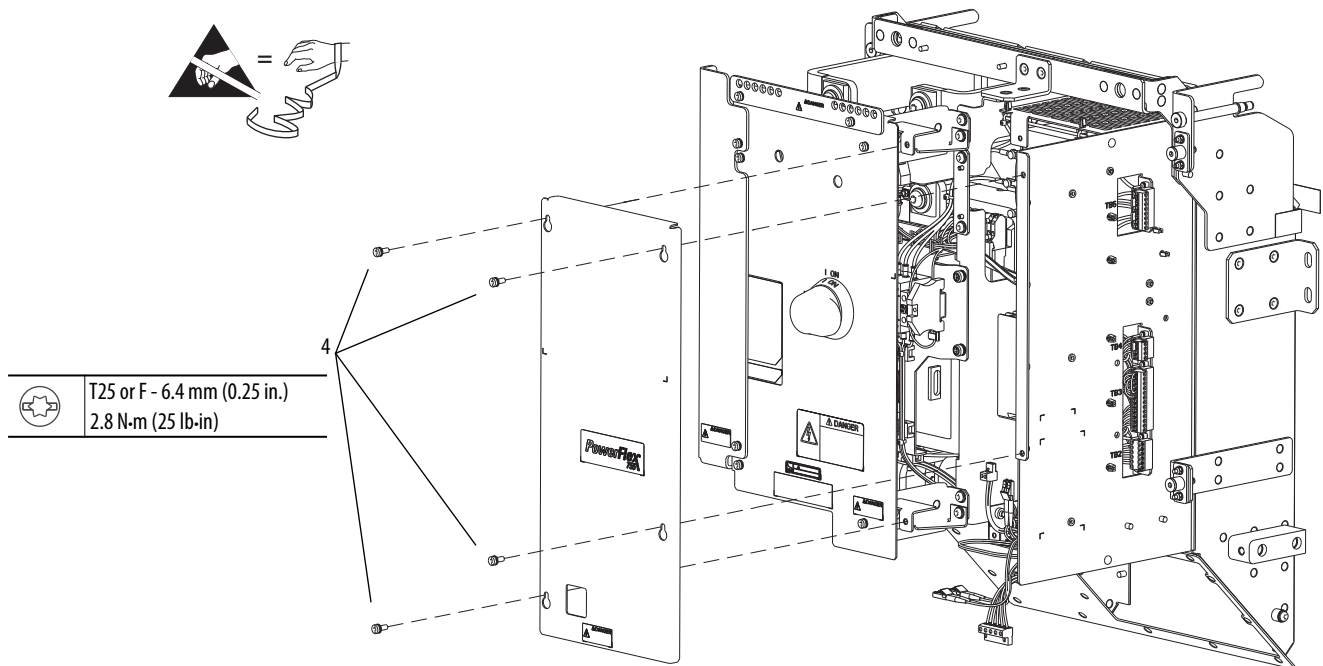


17. Secure the L-bracket by using the two M5 x 14 mm hexalobular screws that are provided in the kit.
18. Close and secure the circuit-breaker access door.
19. Move the disconnect handle to the “ON” position.
20. Verify that the circuit-breaker access door cannot be opened.
21. Secure the circuit-breaker access door by tightening the two hexalobular screws.

DC Input with Precharge Assembly Right Cover (No Control Pod) Removal/Installation

Remove the DC Input with Precharge Assembly Right Cover (No Control Pod)

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the four M5 x 14 mm screws that secure the cover to the assembly and remove the cover.



Install the DC Input with Precharge Assembly Right Cover (No Control Pod)

Install the right cover in the reverse order of removal. See Remove the DC Input with Precharge Assembly Right Cover (No Control Pod).

Control Transformer Secondary Fuses Removal/Installation

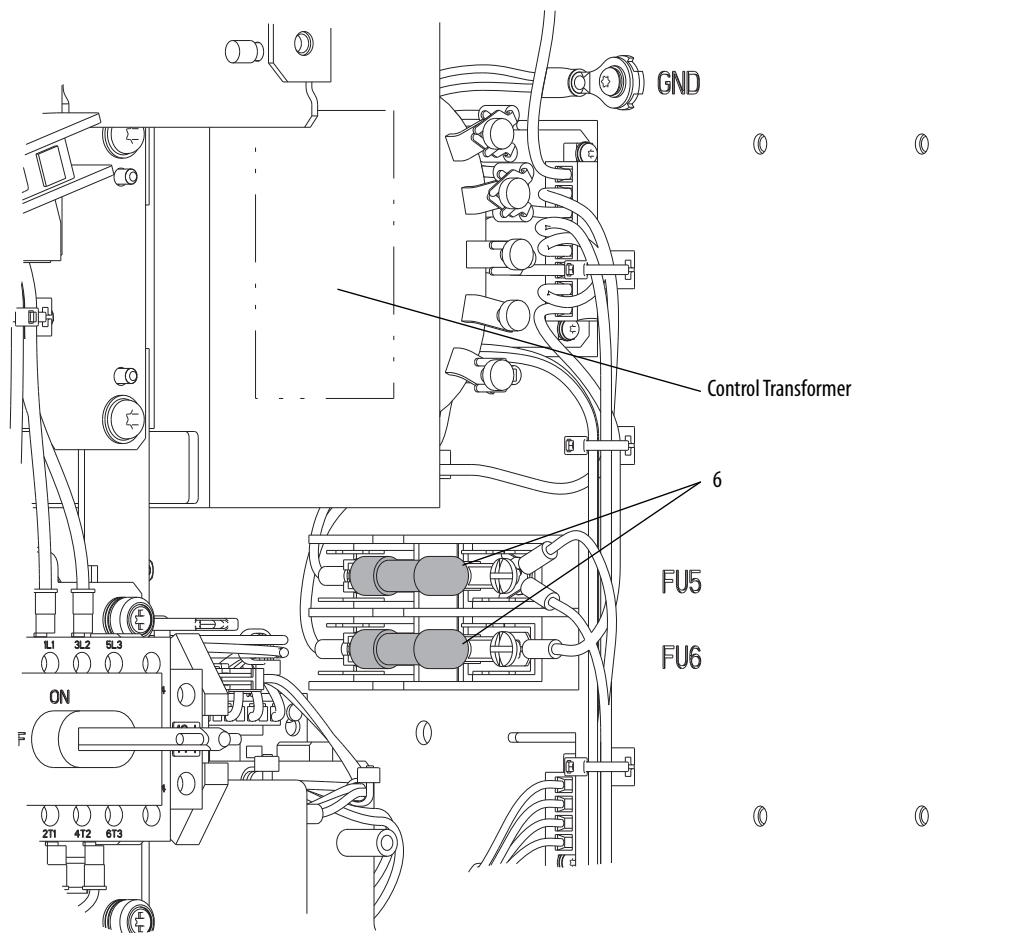
Remove the Control Transformer Secondary Fuses (FU5 and FU6)

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.

4. Remove the left cover, top guard, and left guard assembly. See Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard on page [163](#).
5. If the control pod is installed, then rotate the control pod to gain access to the DC input with precharge assembly control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the right cover. See Remove the DC Input with Precharge Assembly Right Cover (No Control Pod) on page [172](#).

6. Remove the fuse from the one-position fuse holder by using a fuse puller. The fuses are on the right wall of the control panel next to the control transformer.



Install the Control Transformer Secondary Fuses (FU5 and FU6)

Install the control transformer secondary fuses (FU5 and FU6) in the reverse order of removal. See Remove the Control Transformer Secondary Fuses (FU5 and FU6) on page [172](#).

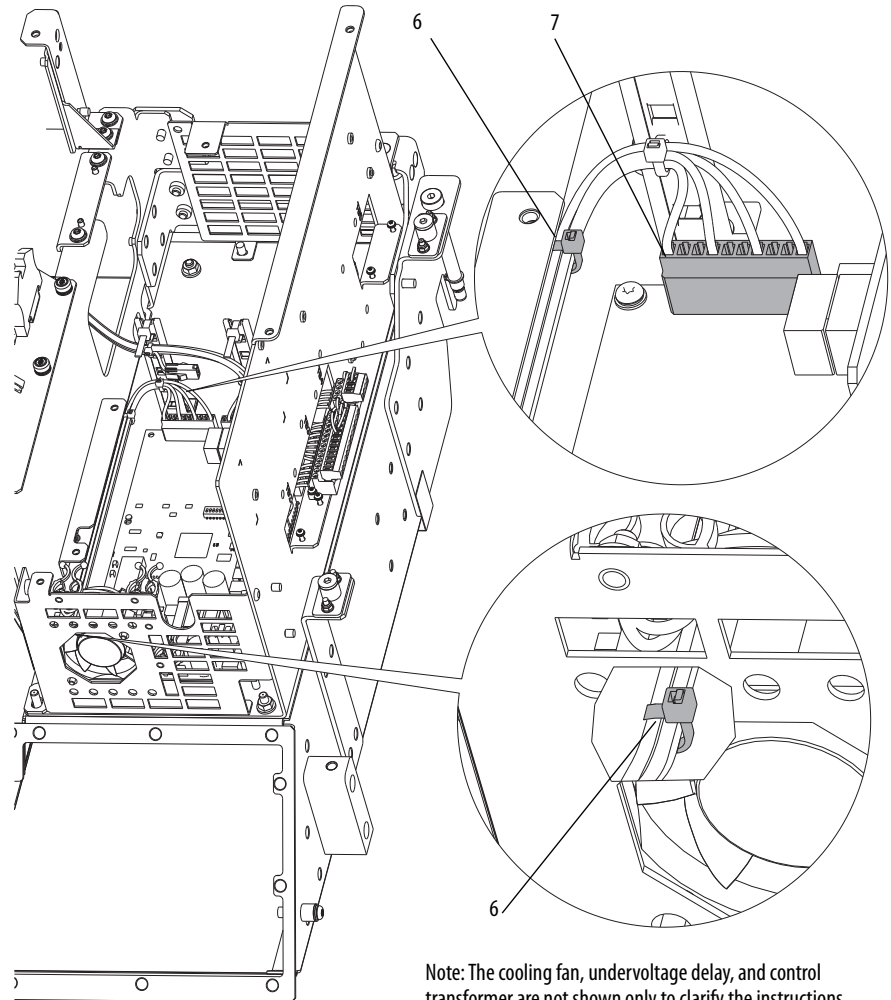
DC Bus Output/Sense Wire Harness Removal/ Installation

Remove the DC Bus Output/Sense Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left cover, top guard, and left guard assembly. See Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard on page [163](#).
5. If the control pod is installed, then rotate the control pod to gain access to the DC input with precharge assembly control panel. See Rotate the Control Pod Forward on page [88](#).

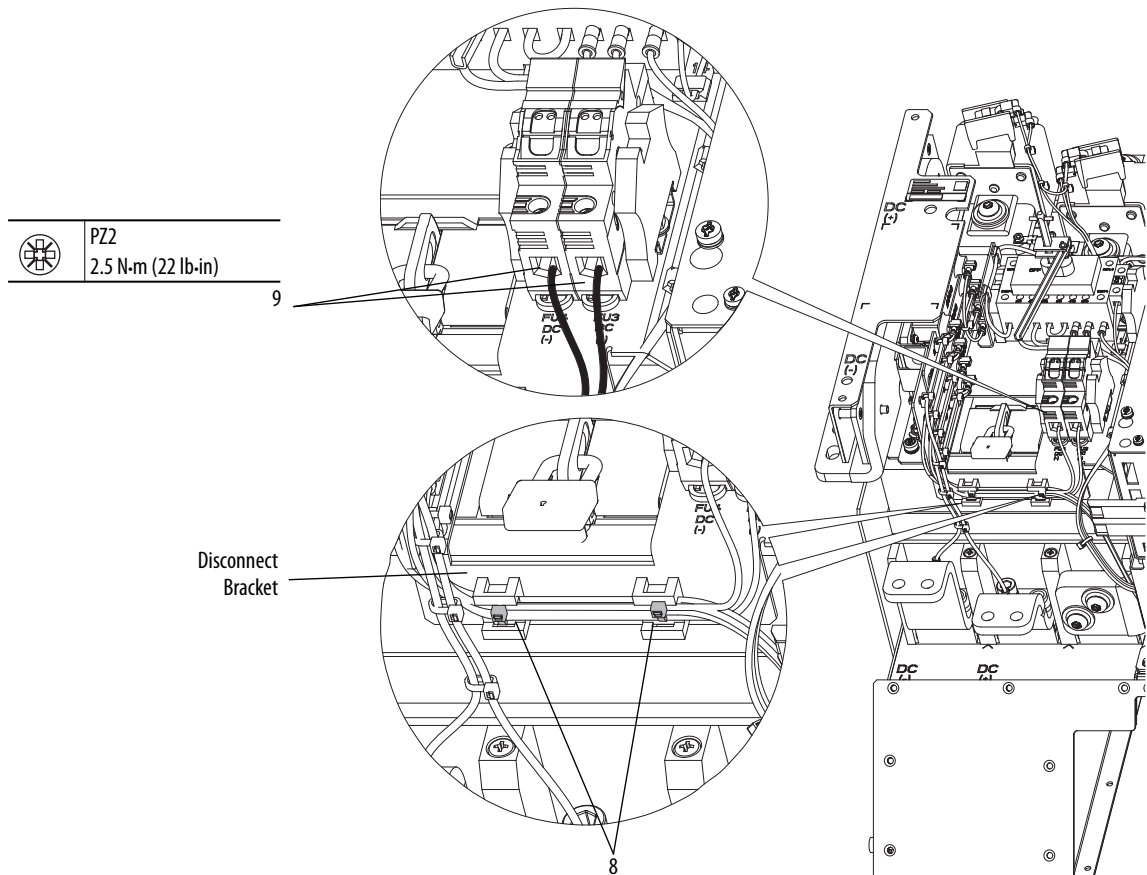
If the control pod is not installed, then remove the right cover. See Remove the DC Input with Precharge Assembly Right Cover (No Control Pod) on page [172](#).

6. Remove the two cable ties that secure the wire harness to the center wall.
7. Disconnect the connector from P1 on the DC input control board.

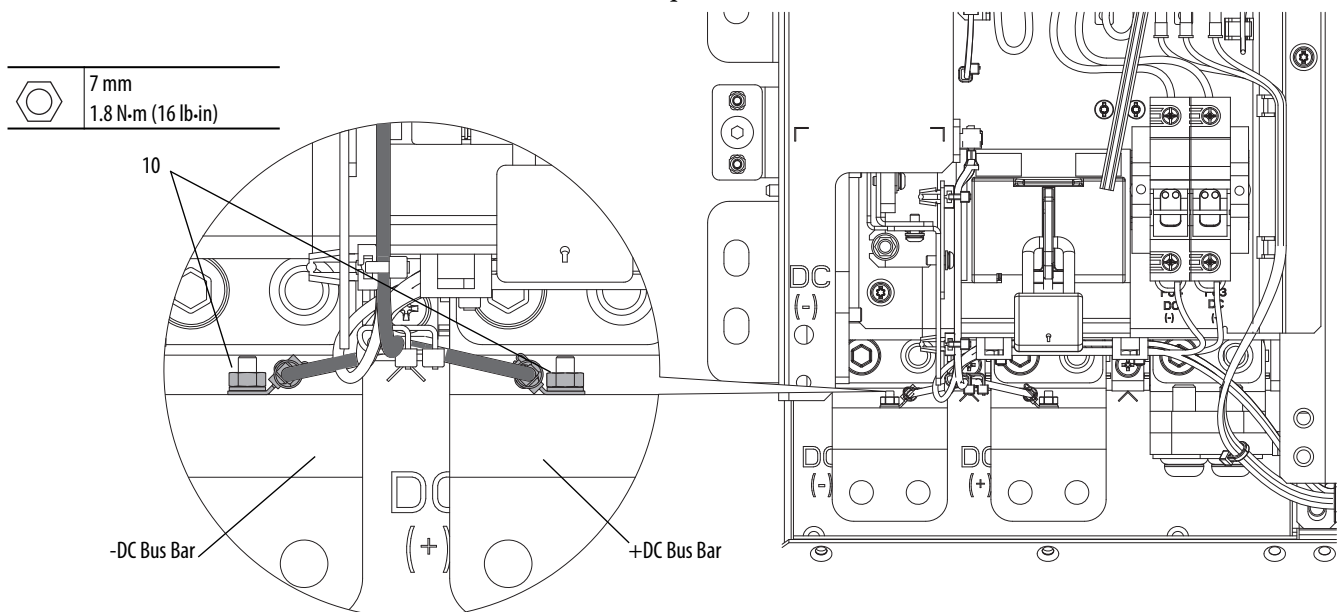


Note: The cooling fan, undervoltage delay, and control transformer are not shown only to clarify the instructions.

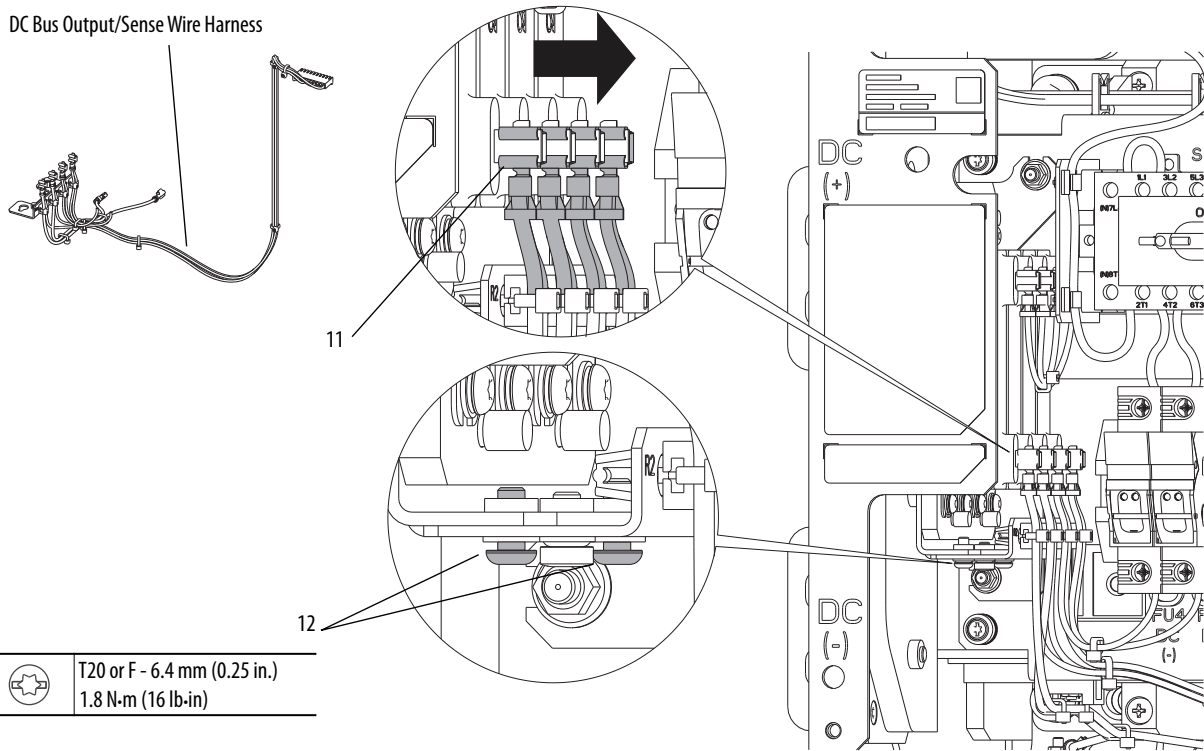
8. Remove the two cable ties that secure the wire harness to the disconnect bracket and the 24/120/240V wire harness.
9. Loosen the screws that secure the +DC and -DC wires to the fuseholder terminals and remove the wires.



10. Remove the M4 hex nuts that secure the +DC and -DC wires to the +DC and -DC output bus bars and remove the wires.



11. Disconnect the connectors from the R1, R2, R3 and, R4 precharge resistor terminals.
12. Loosen, but do not remove, the two M4 x 12 mm hexalobular screws that secure the wire harness support to the bottom of the precharge resistor assembly and remove the harness.



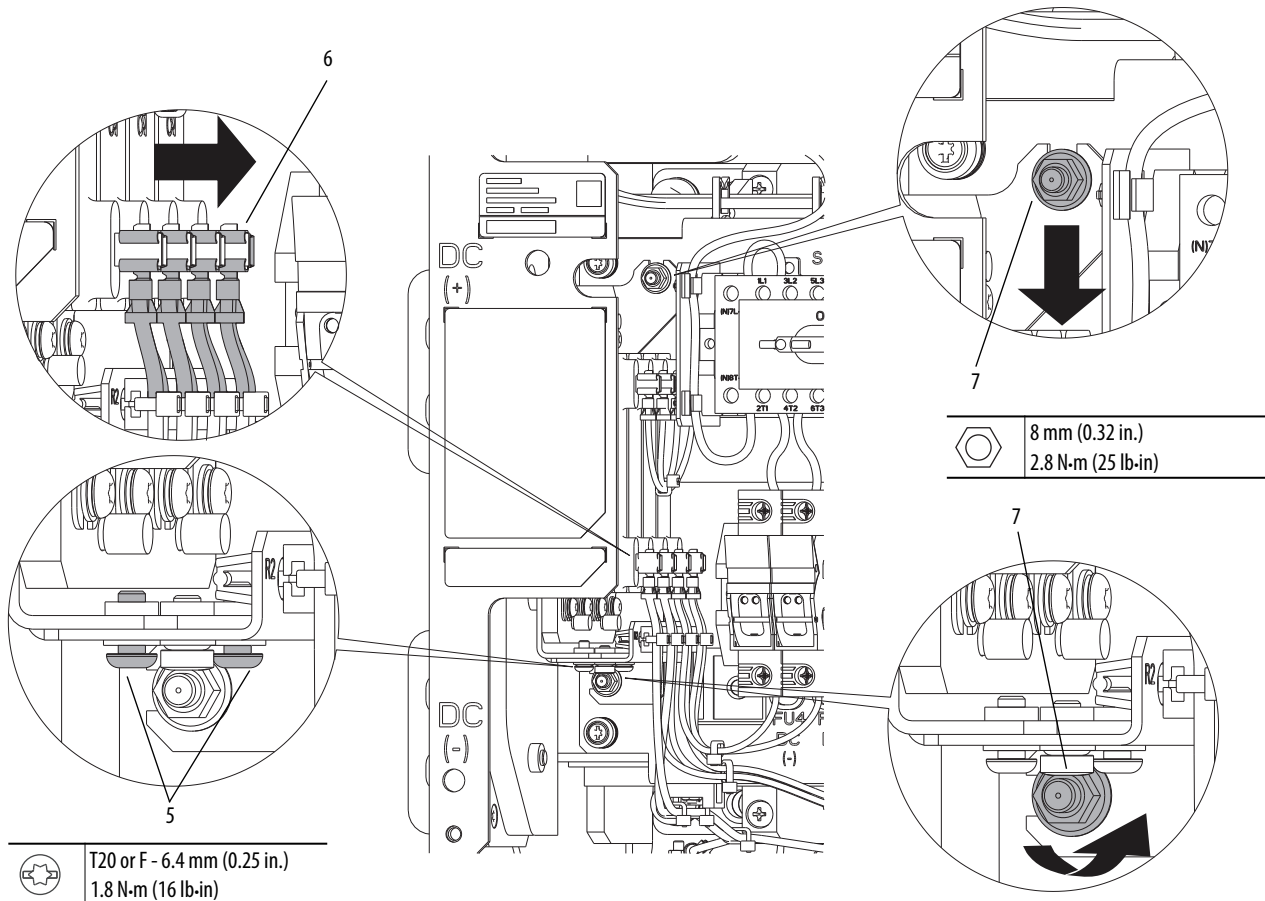
Install the DC Bus Output/Sense Wire Harness

Install the DC bus output/sense wire harness in the reverse order of removal. See Remove the DC Bus Output/Sense Wire Harness on page [174](#).

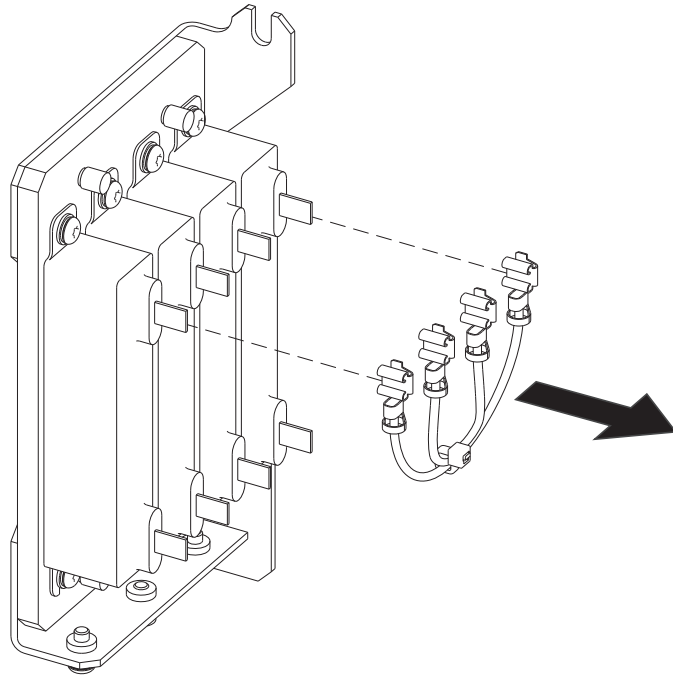
Precharge Resistor Assembly Removal/Installation

Remove the Precharge Resistor Assembly

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left cover, top guard, and left guard assembly. See Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard on page [163](#).
5. Loosen but do not remove the two M4 x 12 mm long hexalobular screws that secure the DC bus output/sense harness wire support to the resistor assembly.
6. Remove the four wire connectors of the DC bus output/sense harness from the R1, R2, R3 and, R4 precharge resistor terminals.
7. Loosen but do not remove the two M5 nuts that secure the resistor assembly to the mounting bracket.
8. Remove the resistor assembly by completing the following steps.
 - a. Disengage the bottom bracket slot by rotating the bottom of the assembly to the right.
 - b. Slide the assembly down to disengage the top bracket slot.



9. Remove the resistor jumper harness from the top four terminals.



Install the Precharge Resistor Assembly

Install the precharge resistor assembly in the reverse order of removal. See Remove the Precharge Resistor Assembly on page [178](#).

Precharge Resistor Jumper Wires Removal/Installation

Remove the Precharge Resistor Jumper Wires

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left cover, top guard, and left guard assembly. See Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard on page [163](#).
5. Remove the precharge resistor assembly. See Remove the Precharge Resistor Assembly on page [178](#).

Install the Precharge Resistor Jumper Wires

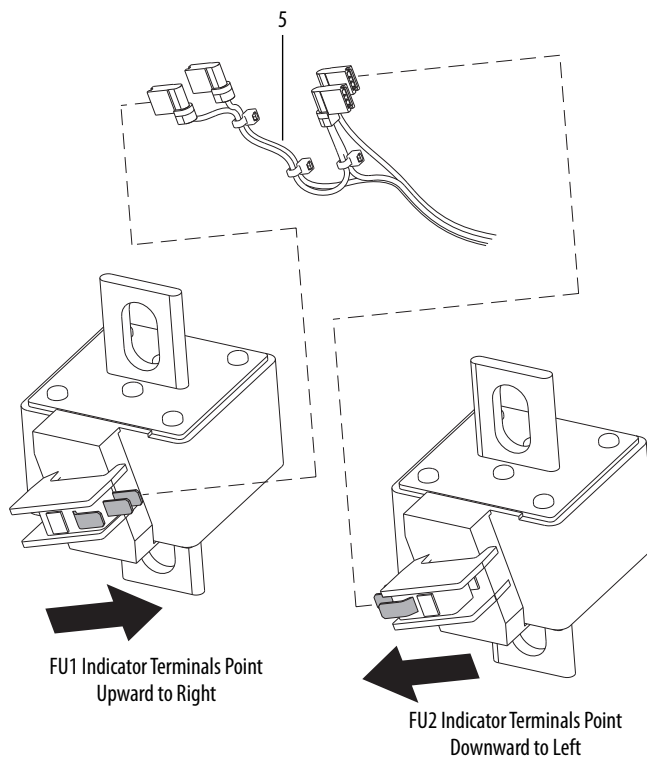
Install the precharge resistor jumper wires in the reverse order of removal. See Remove the Precharge Resistor Jumper Wires.

DC Line Fuses and Fuse Indicators Removal/Installation

Remove the DC Line Fuses (FU1 and FU2) and Fuse Indicators (SW3 and SW4)

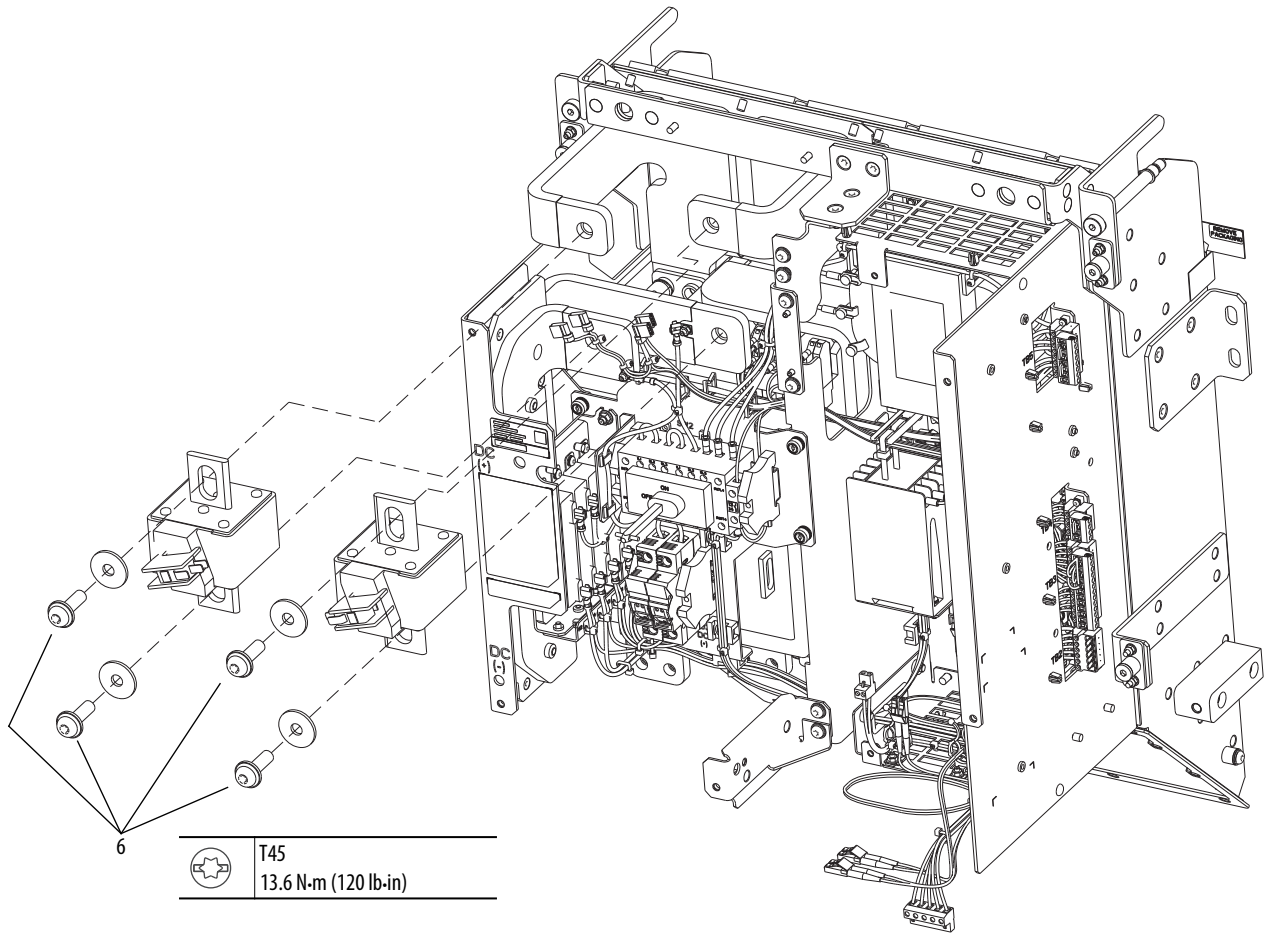
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left cover, top guard, and left guard assembly. See Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard on page [163](#).
5. Remove the 24V control wire harness leads from the fuse indicator (SW3 or SW4) terminals for the fuse being replaced (FU1 or FU2).

IMPORTANT Note the orientation of the fuse indicator terminals before removal. Replace each fuse with the terminals in the same orientation as shown here.



Note: Fuses shown removed in this illustration only to clarify the instructions.

6. Remove the M10 x 35 mm hexalobular screw and flat washer for the fuse being replaced and remove the DC line fuse. Remove the fuse indicator from the DC line fuse for reuse, if necessary.



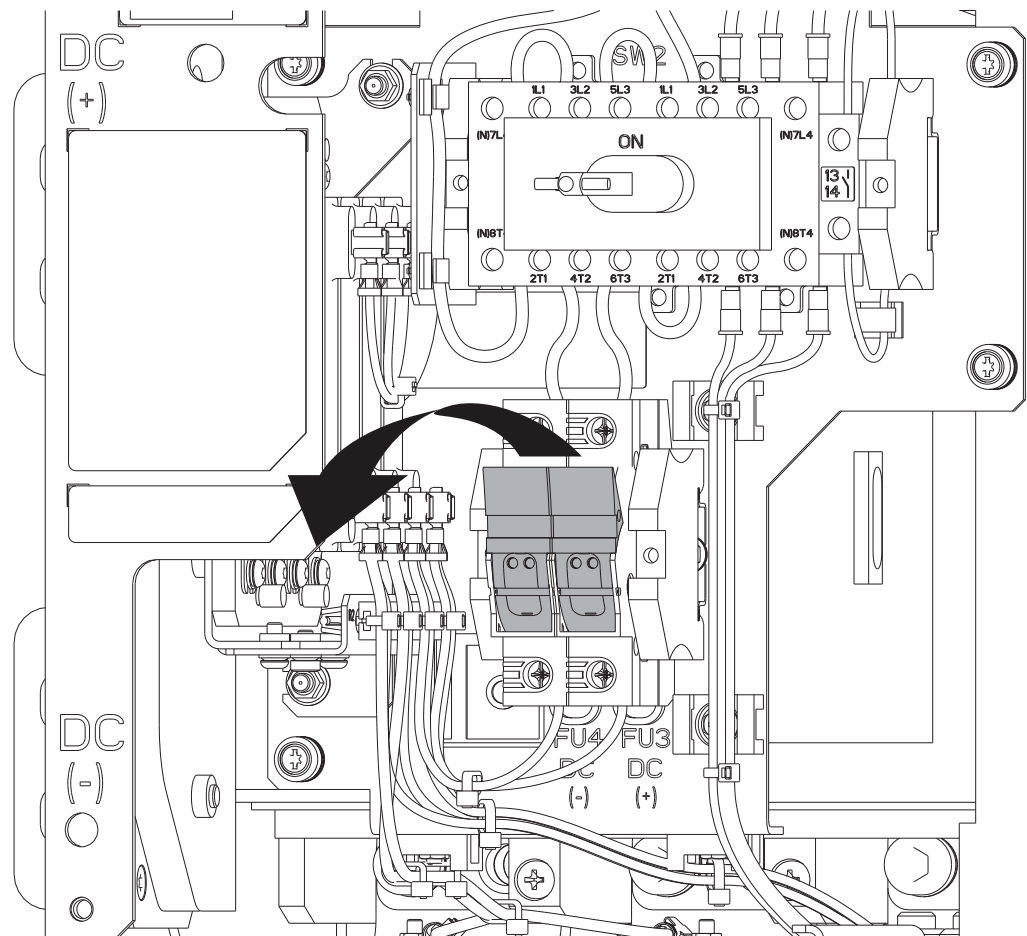
Install the DC Line Fuses (FU1 and FU2) and Fuse Indicators (SW3 and SW4)

Install the DC line fuses and fuse indicators in the reverse order of removal. See Remove the DC Line Fuses (FU1 and FU2) and Fuse Indicators (SW3 and SW4) on page [180](#).

Precharge Circuit Fuses Removal/Installation

Remove the Precharge Circuit Fuses (FU3 and FU4)

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left cover, top guard, and left guard assembly. See Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard on page [163](#).
5. Pull-down on the tabs at the top of the fuse holder and remove the fuse.



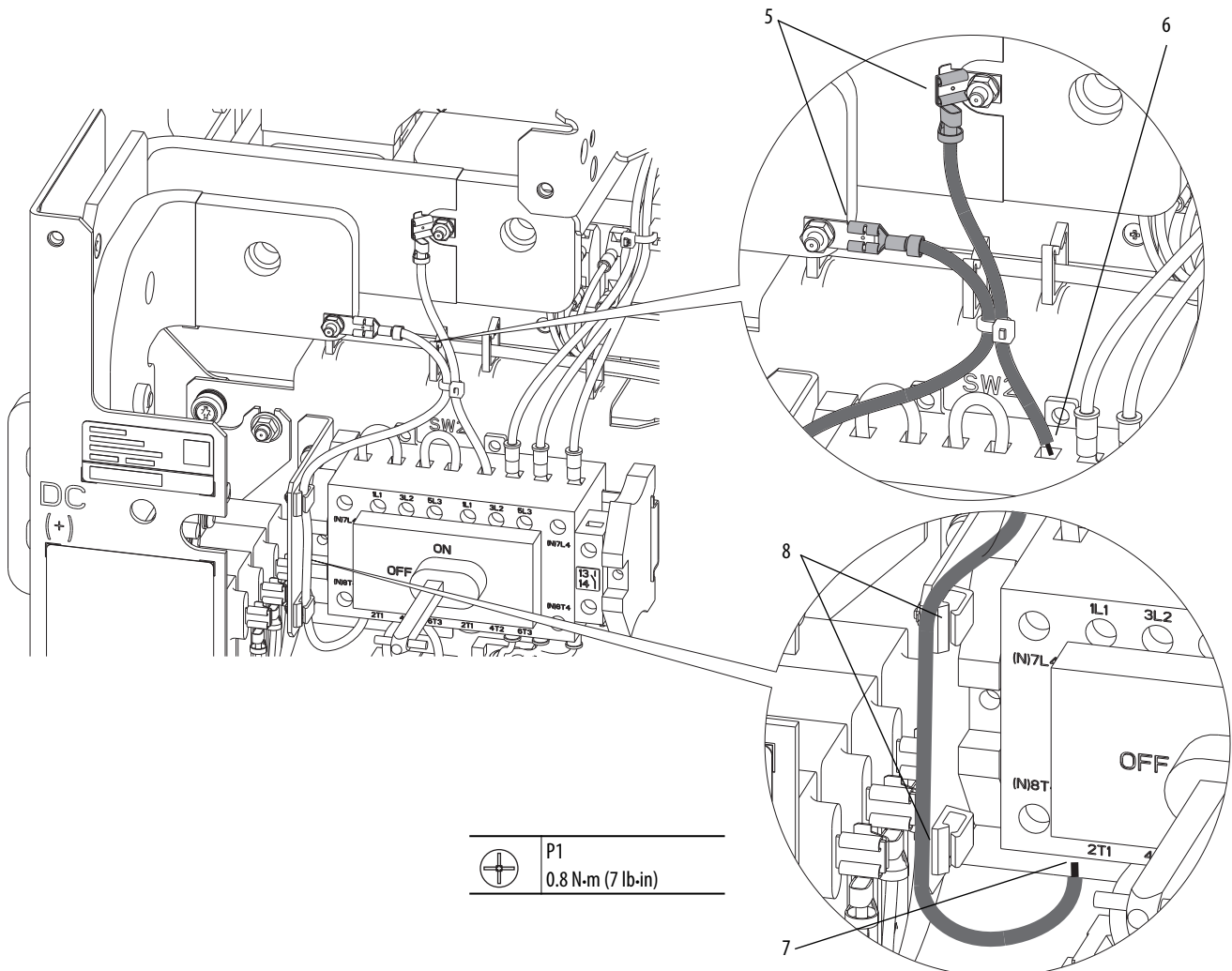
Install the Precharge Circuit Fuses (FU3 and FU4)

Install the precharge circuit fuses in the reverse order of removal. See Remove the Precharge Circuit Fuses (FU3 and FU4) on page [182](#).

DC Bus Input Wire Harness Removal/Installation

Remove the DC Bus Input Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left cover, top guard, and left guard assembly. See Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard on page [163](#).
5. Disconnect the +DC and -DC wires from the +DC and -DC bus bars, respectively.
6. Loosen the screw that secures the +DC wire to terminal SW2-5 on the disconnect switch, and remove the wire.
7. Loosen the screw that secures the -DC wire to terminal SW2-1 on the disconnect switch and remove the wire.
8. Remove the -DC wire from the two supports on the disconnect bracket and remove the wire harness.



Install the DC Bus Input Wire Harness

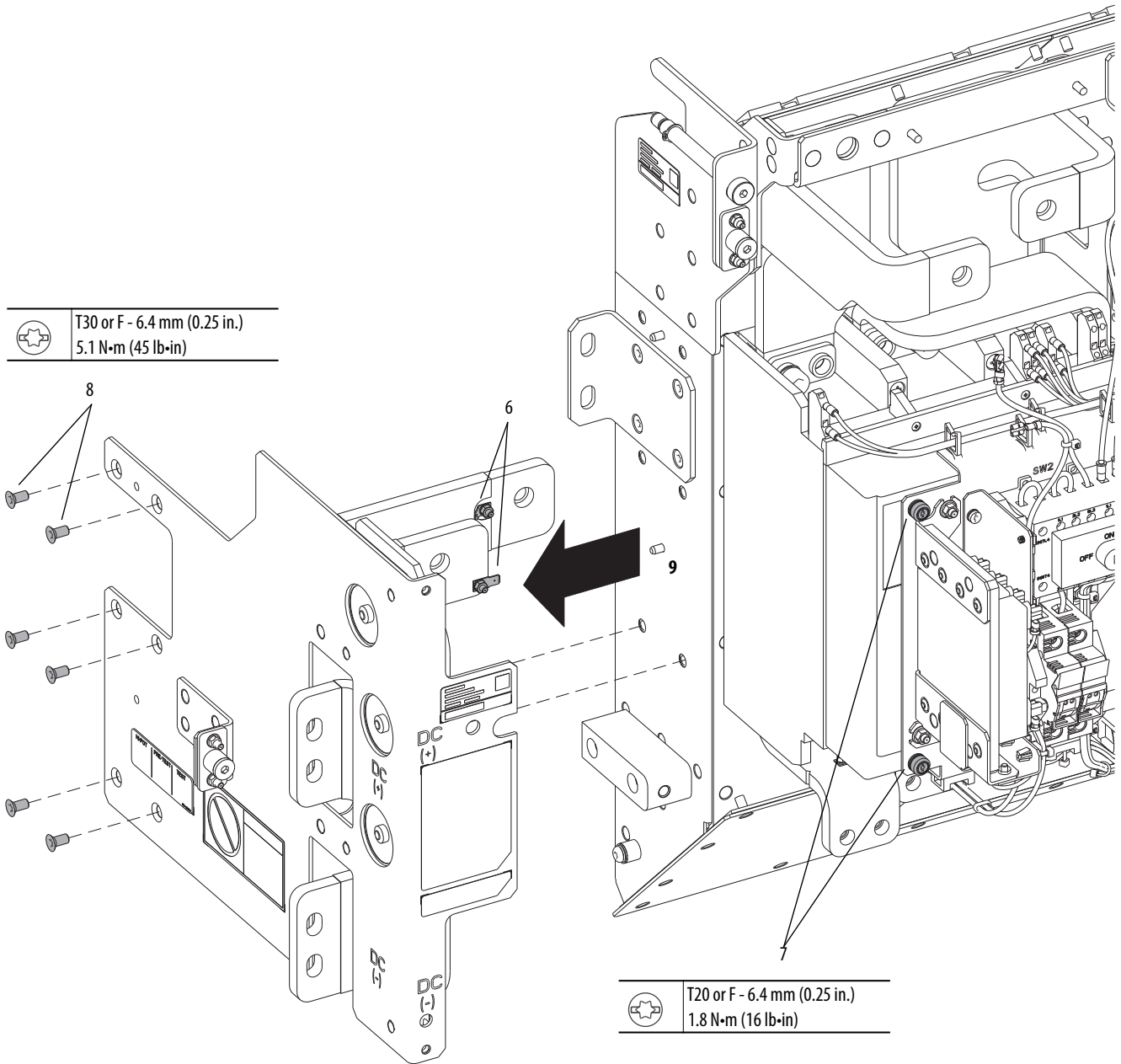
Install the DC bus input wire harness in the reverse order of removal. See Remove the DC Bus Input Wire Harness on page [183](#).

Left Wall Removal/ Installation

Remove the Left Wall

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the drive assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
5. Remove the DC line fuses and fuse indicators. See Remove the DC Line Fuses (FU1 and FU2) and Fuse Indicators (SW3 and SW4) on page [180](#).
6. Disconnect the +DC wire (of the DC bus input wire harness) from the +DC bus bar.
7. Disconnect the -DC wire (of the DC bus input wire harness) from the -DC bus bar.
8. Loosen the two captive M4 panel fasteners that secure the disconnect bracket to the left wall.
9. Remove the six M6 x 12 mm flat head screws that secure the left wall to the drive.

- Slide the left wall (with input bus bar assembly) off the two mounting pins and remove the left wall.



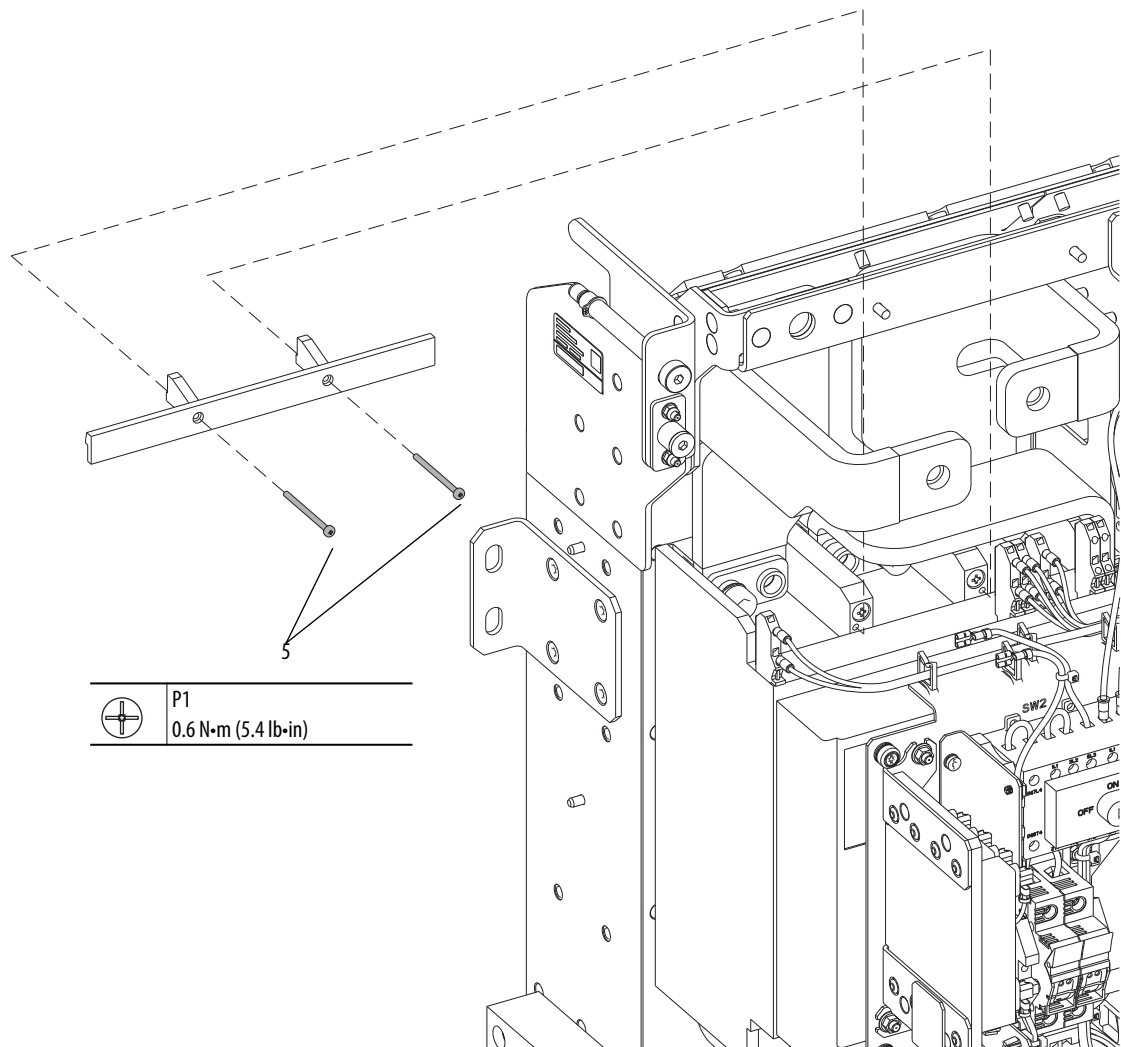
Install the Left Wall

Install the left wall in the reverse order of removal. See Remove the Left Wall on page [184](#).

Molded Case Switch Wire Terminal Support Removal/Installation

Remove the Molded Case Switch Wire Terminal Support

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left wall. See Remove the Left Wall on page [184](#).
5. Remove the two M3 x 45 mm Phillips head screws that secure the wire terminal support to the molded case switch and remove the support.



Install the Molded Case Switch Wire Terminal Support

Install the molded-case switch wire terminal support in the reverse order of removal. See Remove the Molded Case Switch Wire Terminal Support.

24V Control Wire Harness Removal/Installation

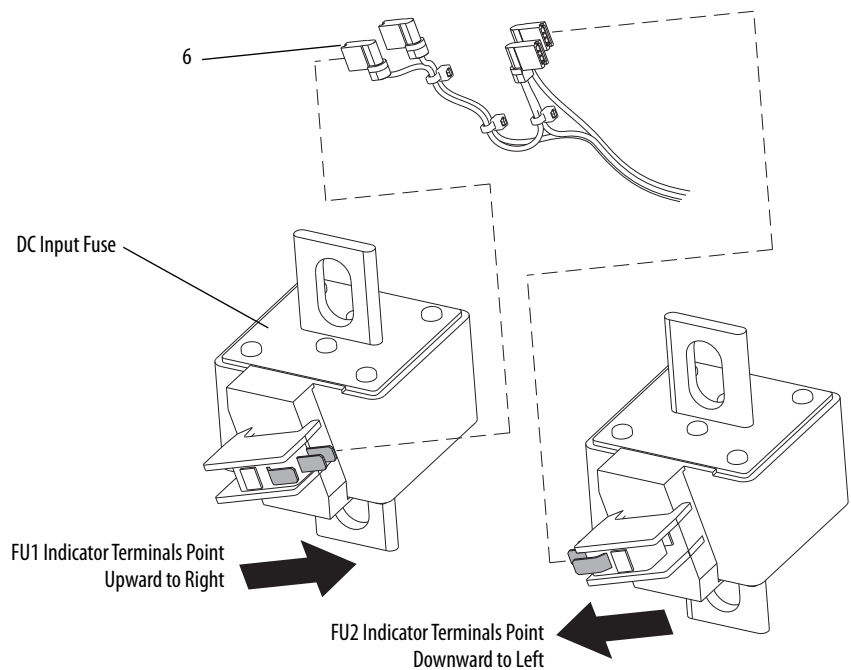
Remove the 24V Control Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left cover, top guard, and left guard assembly. See Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard on page [163](#).
5. If the control pod is installed, then rotate the control pod to gain access to the DC input with precharge assembly control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the right cover. See Remove the DC Input with Precharge Assembly Right Cover (No Control Pod) on page [172](#).

6. Remove the 24V control wire harness leads from the fuse indicators SW3 (on FU1) and SW4 (on FU2).

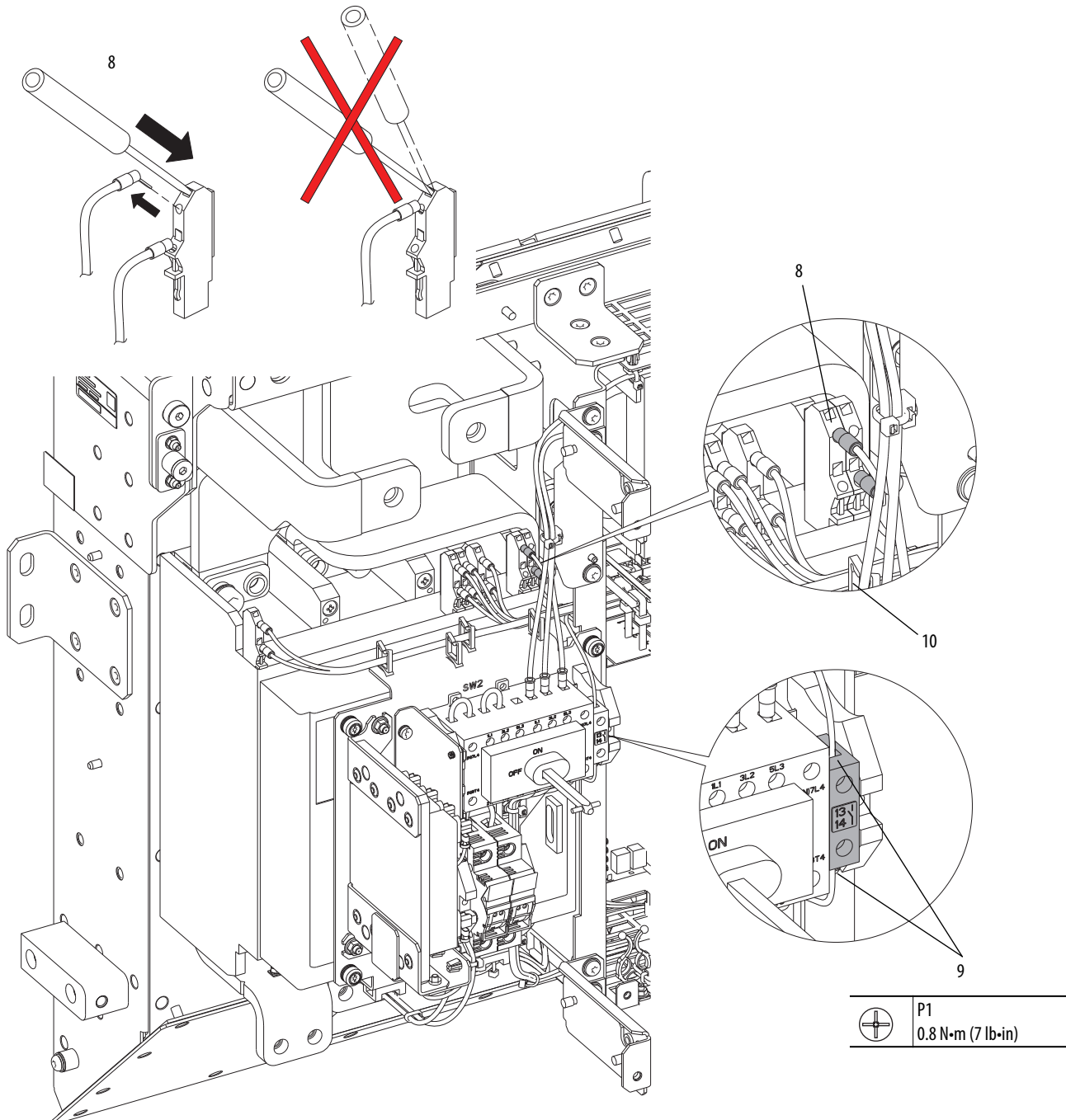
IMPORTANT Note the orientation of the fuse indicator terminals before removal. Replace each fuse with the terminals in the same orientation as shown here.



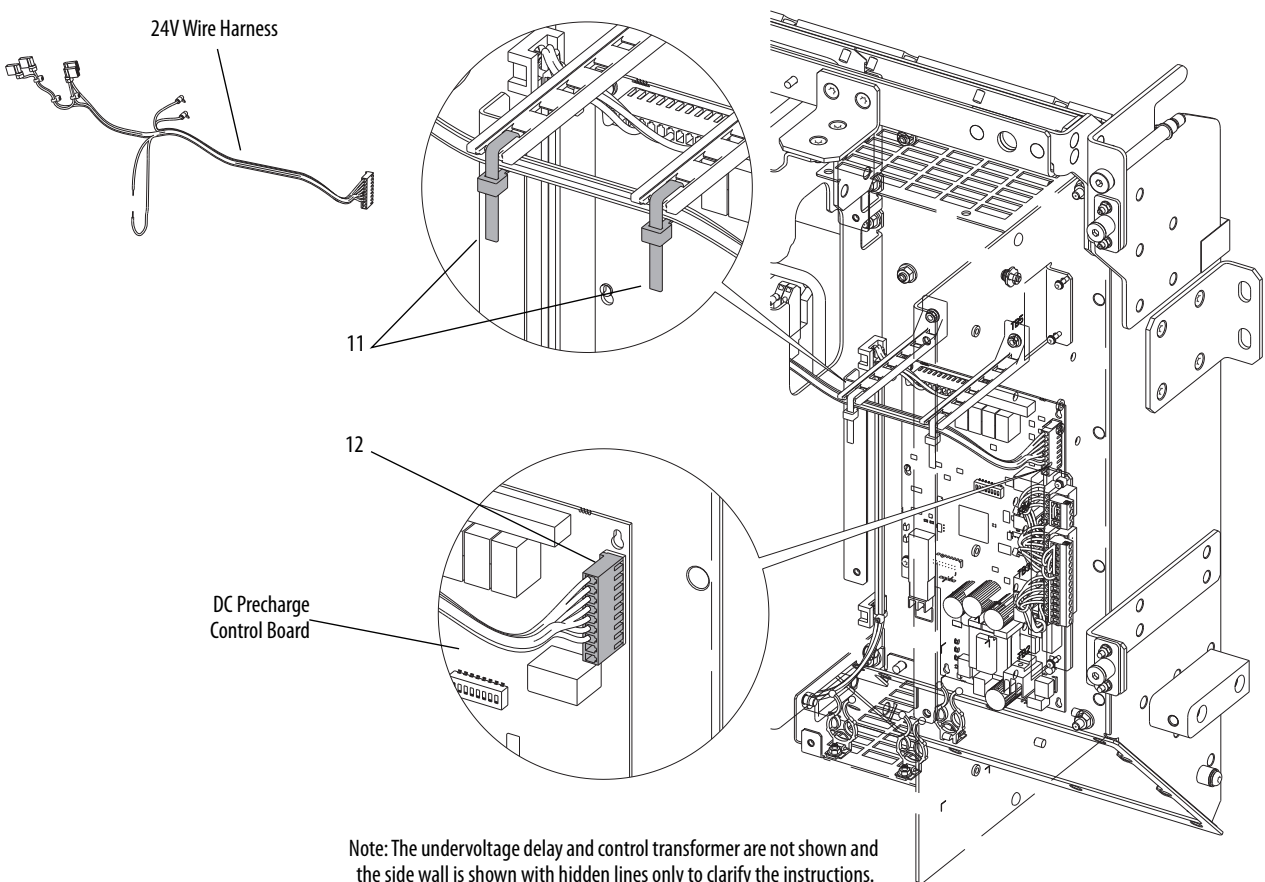
Note: Fuses shown removed in this illustration only to clarify the instructions.

7. Remove the molded-case switch wire terminal support. See Remove the Molded Case Switch Wire Terminal Support on page [186](#).

8. Disconnect the 24V wire harness connector from terminals 31/21 and 32/34 on the molded case switch by using a flat nose screwdriver (as shown in the illustration).
9. Loosen the Phillips head screws that secure the 24V wire harness wires to terminals 13 and 14 on the disconnect switch auxiliary contact and remove the wires.
10. Release the 24V wire harness from the cable support on the top, front of the disconnect switch.



11. Release, but do not remove, the two releasable cable ties from the top rungs of two cable support ladders on the control panel.
12. Disconnect the 24V control wire harness connector from terminal P3 on the DC precharge control board. Pull the 24V wire harness to the right through the gap in the center wall and remove the wire harness.



Install 24V Control Wire Harness

Install the 24V control wire harness in the reverse order of removal. See [Install 24V Control Wire Harness](#) on page [189](#).

Molded-case Switch Control Wire Harness Removal/Installation

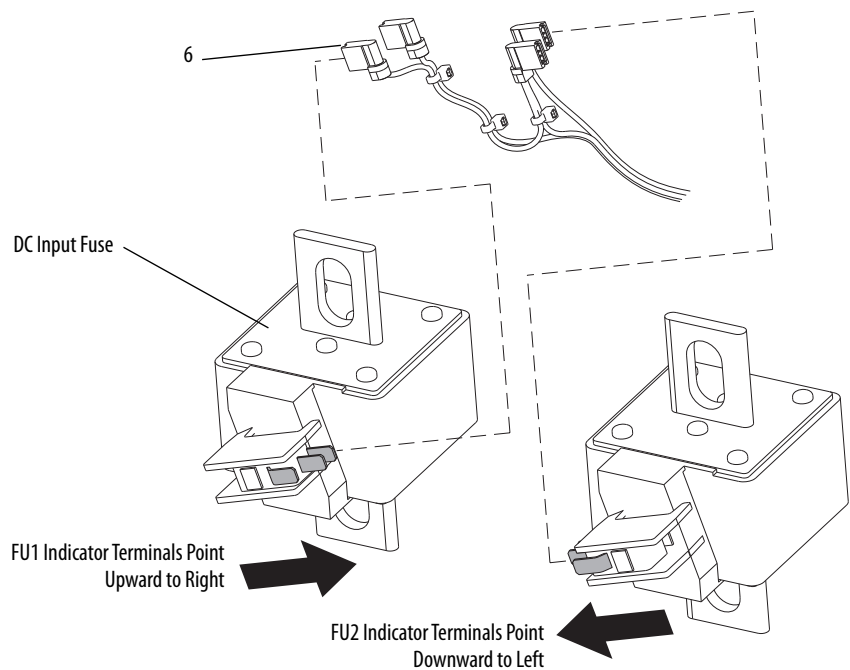
Remove the Molded-case Switch Control Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left cover, top guard, and left guard assembly. See Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard on page [163](#).
5. If the control pod is installed, then rotate the control pod to gain access to the DC input with precharge assembly control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the right cover. See Remove the DC Input with Precharge Assembly Right Cover (No Control Pod) on page [172](#).

6. Remove the 24V control wire harness leads from the fuse indicators SW3 (on FU1) and SW4 (on FU2).

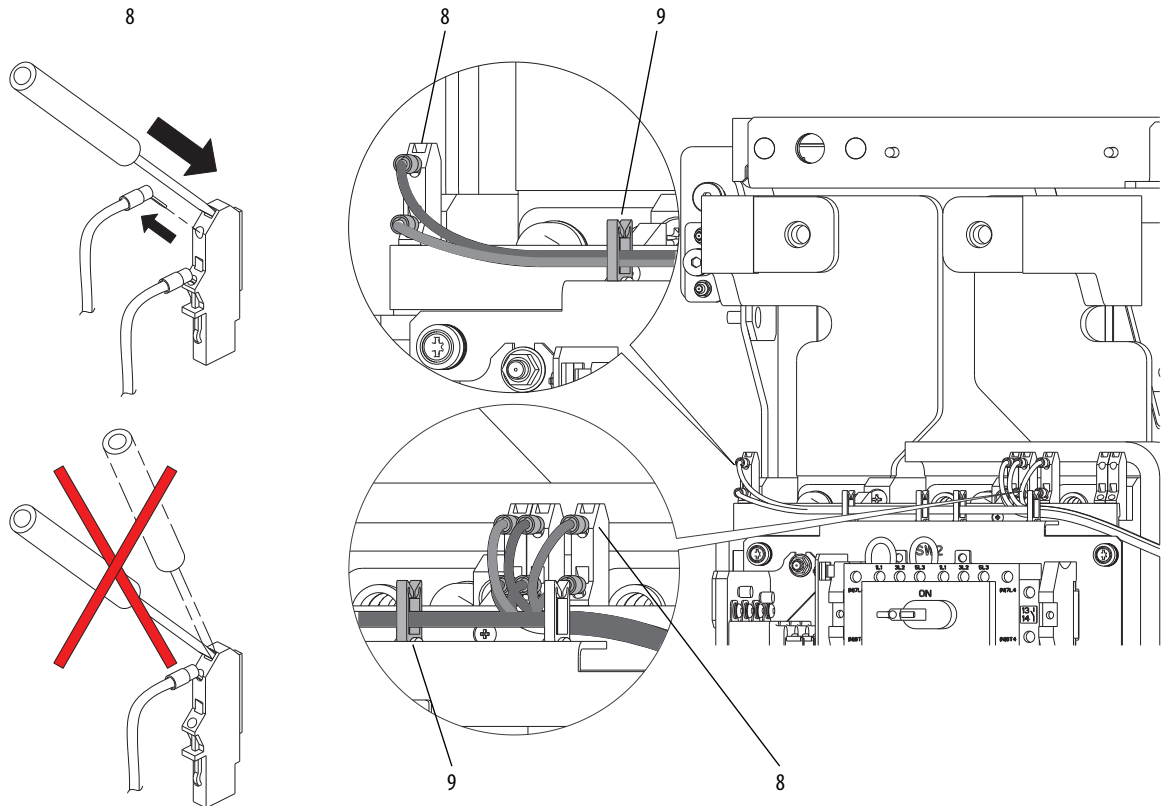
IMPORTANT Note the orientation of the fuse indicator terminals before removal. Replace each fuse with the terminals in the same orientation as shown here.



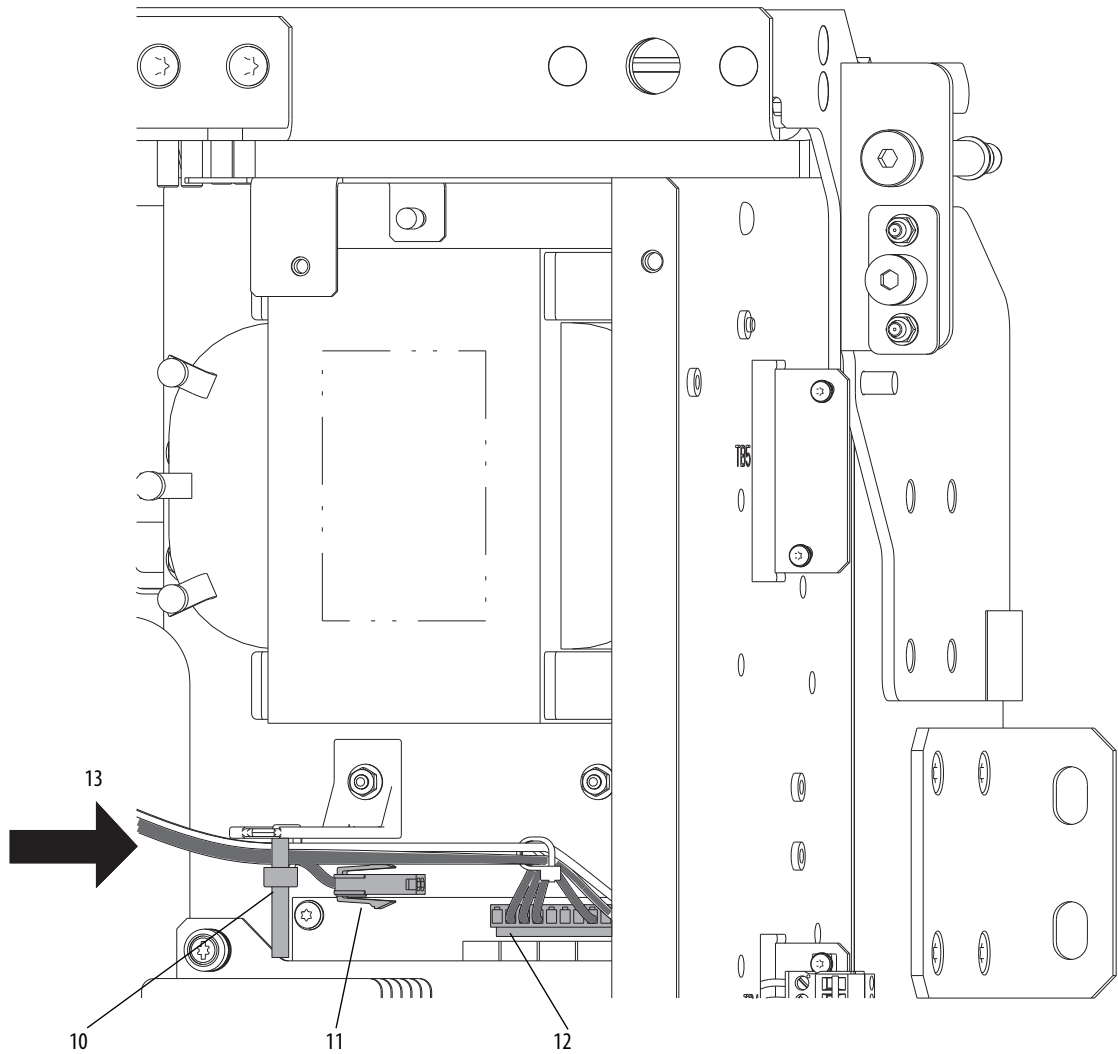
Note: Fuses shown removed in this illustration only to clarify the instructions.

7. Remove the molded-case switch wire terminal support. See Remove the Molded Case Switch Wire Terminal Support on page [186](#).

8. Disconnect the molded-case switch (MCS) control wire harness connector from terminals U1/U2, D1/D2, C1/C2, and C12/C11 on the molded case switch by using a flat nose screwdriver (as shown in the illustration).
9. Release the harness from two supports on the top, rear of the disconnect switch.



10. Release, but do not remove, the cable tie from the second rung of the left cable support ladder on the control panel.
11. Disconnect the MCS control wire harness from the UV connector for the undervoltage delay.
12. Disconnect the MCS control wire harness connector from terminal P2 on the DC precharge control board.
13. Pull the MCS control wire harness to the right and remove the wire harness.



Install the Molded-case Switch Control Wire Harness

Install the molded-case switch control wire harness in the reverse order of removal. See [Remove the Molded-case Switch Control Wire Harness](#) on page [190](#).

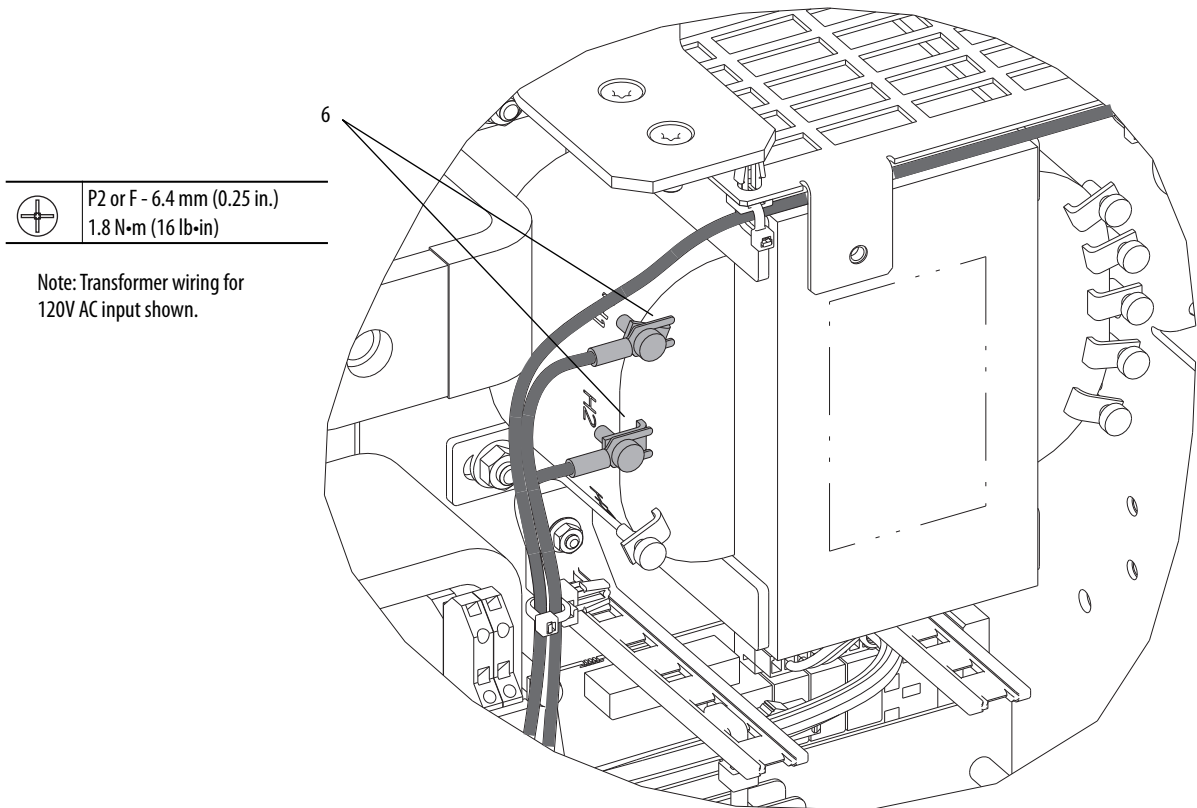
Transformer Primary Wire Harness Removal/ Installation

Remove the Transformer Primary Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left cover, top guard, and left guard assembly. See Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard on page [163](#).
5. If the control pod is installed, then rotate the control pod to gain access to the DC input with precharge assembly control panel. See Rotate the Control Pod Forward on page [88](#).

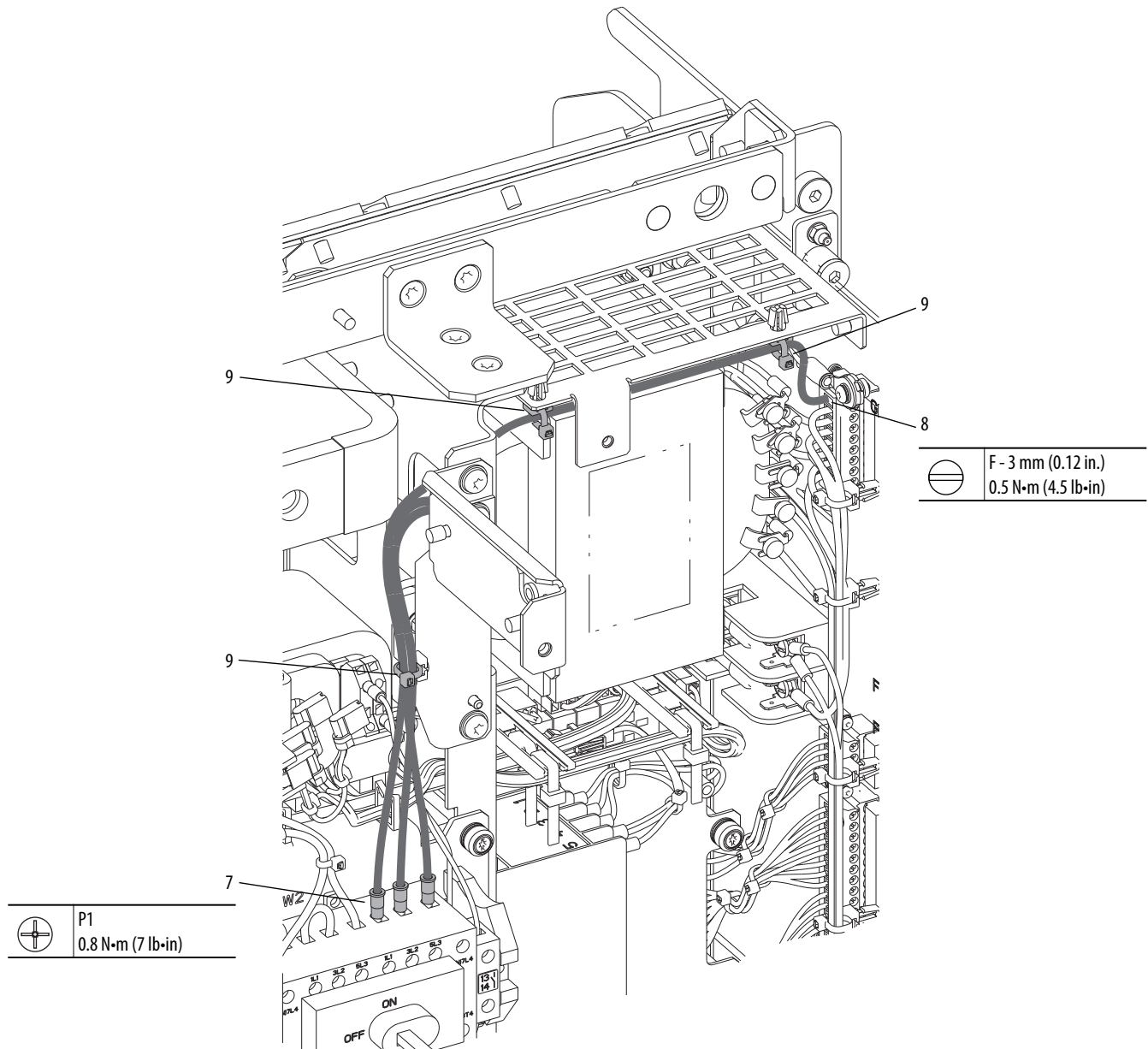
If the control pod is not installed, then remove the right cover. See Remove the DC Input with Precharge Assembly Right Cover (No Control Pod) on page [172](#).

6. Loosen, but do not remove, the captive screws that secure the control-transformer primary lead wires to terminals H1 and HX and remove the wires.



Note: Center wall shown removed only to clarify the instructions.

7. Loosen the screws that secure the three wires to terminals SW2-6, SW2-7, and SW2-8 on the disconnect switch and remove the wires.
8. Loosen the captive screw that secures the wire to TB5-1 on right side of control panel, and remove the wire.
9. Loosen the two cable tie mounts on the center wall and the cable tie mount on the top of the control panel and remove the harness by using the pliers.



Installing the Transformer Primary Wire Harness

Install the transformer primary wire harness in the reverse order of removal. See Remove the Transformer Primary Wire Harness on page [193](#).

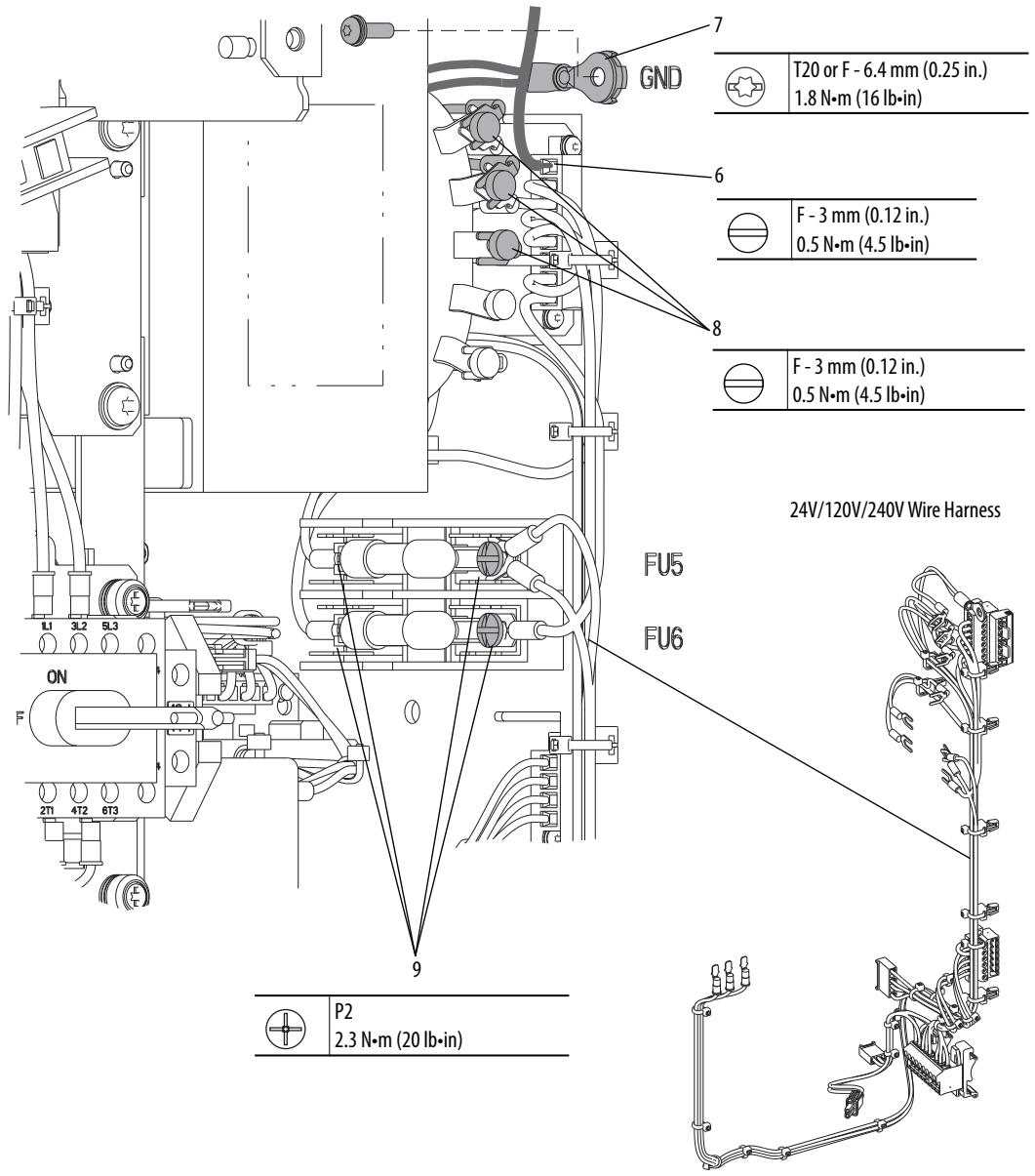
24V/120V/240V Wire Harness Removal/Installation

Remove the 24V/120V/240V Wire Harness

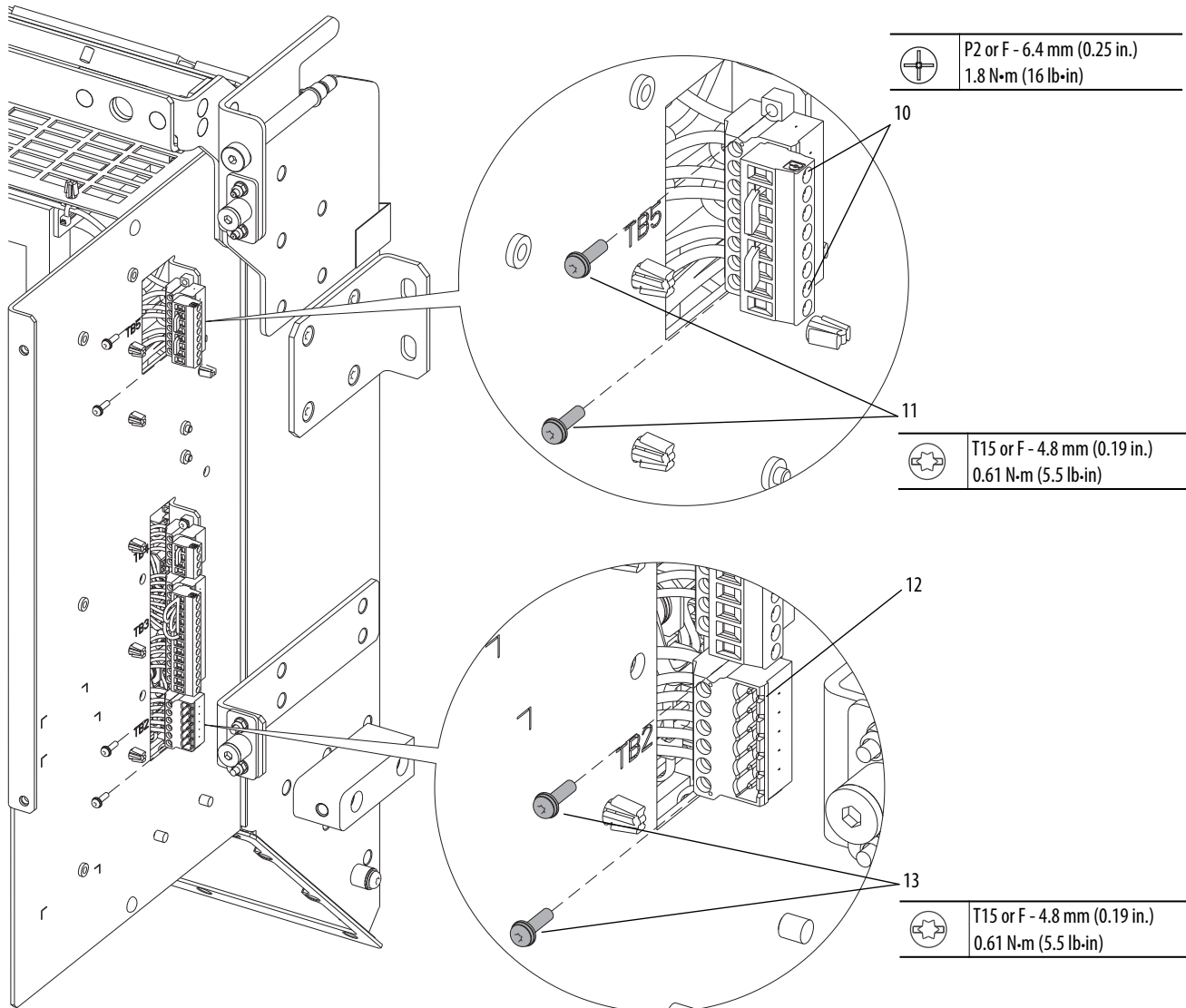
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left cover, top guard, and left guard assembly. See Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard on page [163](#).
5. If the control pod is installed, then rotate the control pod to gain access to the DC input with precharge assembly control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the right cover. See Remove the DC Input with Precharge Assembly Right Cover (No Control Pod) on page [172](#).

6. Loosen the screw that secures the transformer primary wire harness to terminal 1 on terminal block TB5, and remove the wire.
7. Remove the M4 x 12 mm screw and grounding washer that secure the ground wire lug to the control panel; and remove the ground wire lug.
8. Loosen, but do not remove, the M4 screws that secure the secondary lead wires to terminals X1, X2, and X3 on the control transformer; and remove the leads.
9. Loosen, but do not remove, the captive screws that secure the four leads wires to FU5 and FU6 fuse blocks; and remove the leads.

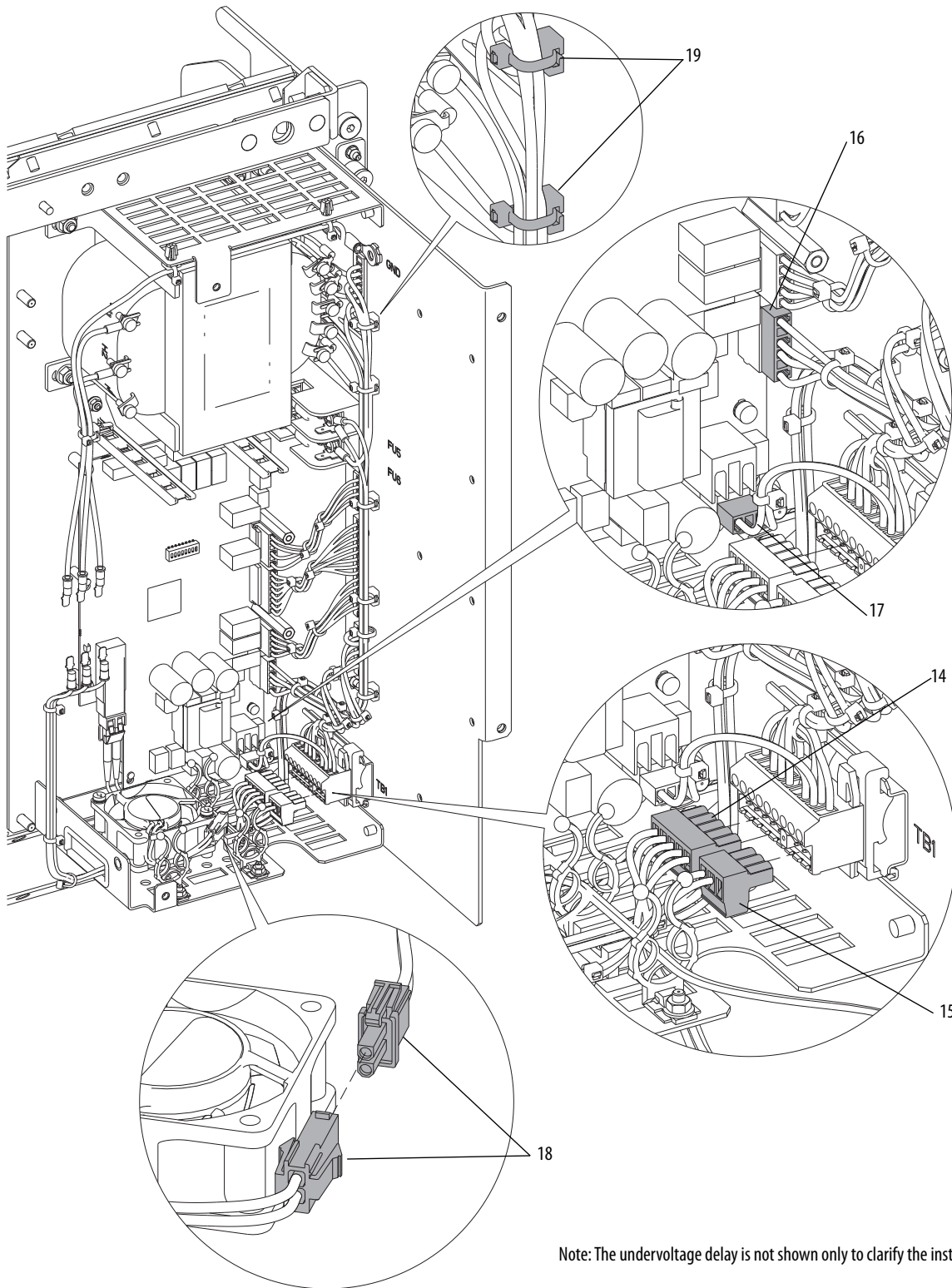


10. Loosen the screws that secure the 120V control power output wiring (if used) to terminals 7 and 8 on terminal block TB5, and remove the wires.
11. Remove the two M3 x 12 mm screws that secure terminal block TB5 to the control panel and remove the terminal block.
12. Remove the plug-in terminal block for the enclosure fan harness, 120/240V control power input harness, and 120V UPS harness from terminal block TB2.
13. Remove the two M3 x 12 mm screws that secure terminal block TB2 to the control panel and remove the terminal block.



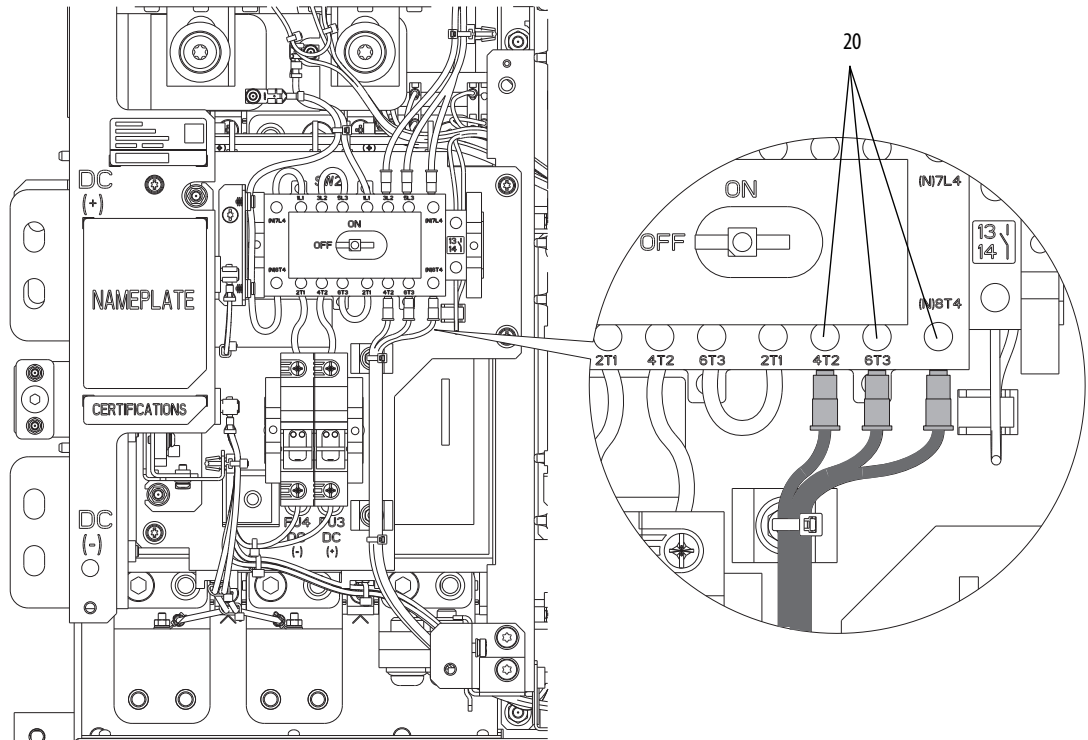
14. Disconnect the five-position inverter power supply harness connector from terminal block TB1 (see following illustration).
15. Disconnect the three-position 24V wire harness connector from terminal block TB1 (see following illustration).
16. Disconnect the enclosure fan six-position connector from P9 on the DC precharge control board (see following illustration).

17. Disconnect the system 24V three-position connector from P10 on the DC precharge control board.
18. Disconnect the two-position connector from the stirring fan.
19. Loosen and remove the seven cable tie mounts along the right surface of the control panel by using the pliers.

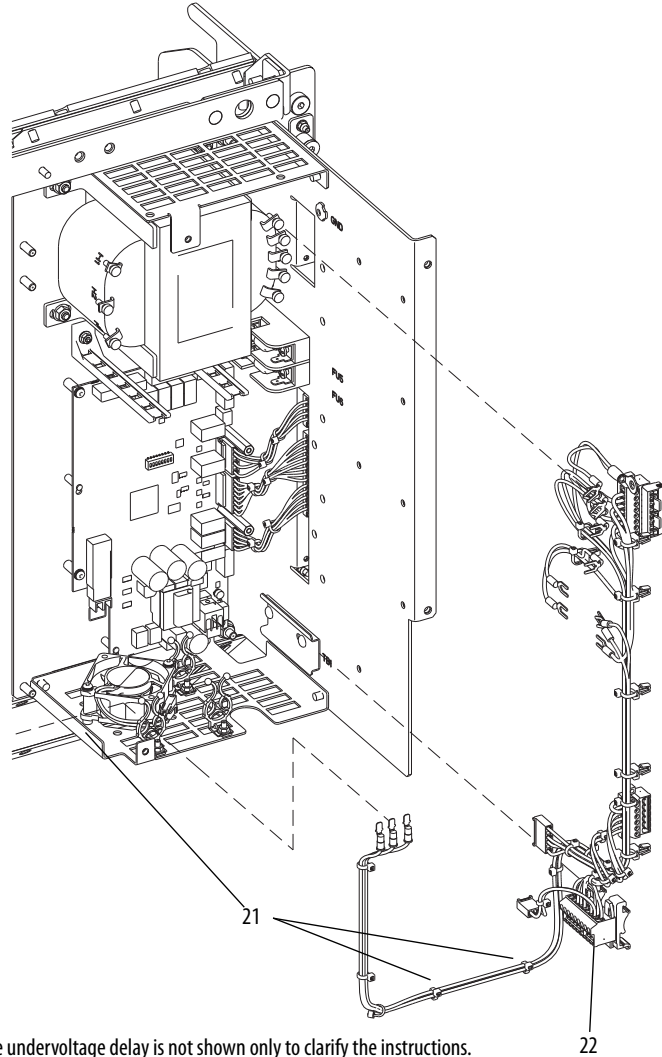


Note: The undervoltage delay is not shown only to clarify the instructions.

20. Loosen the screws that secure the input wires to terminals SW2-6, SW2-7, and SW2-8 on the disconnect switch and remove the wires.



21. Cut four cable ties between the disconnect switch and terminal block TB1. Pull the three disconnect switch wires SW2-6, SW2-7, and SW2-8 through the opening in the bottom, center wall of the control panel.
22. Release terminal block TB1 from the DIN rail and remove the 24V/120V/240V wire harness from the control panel.



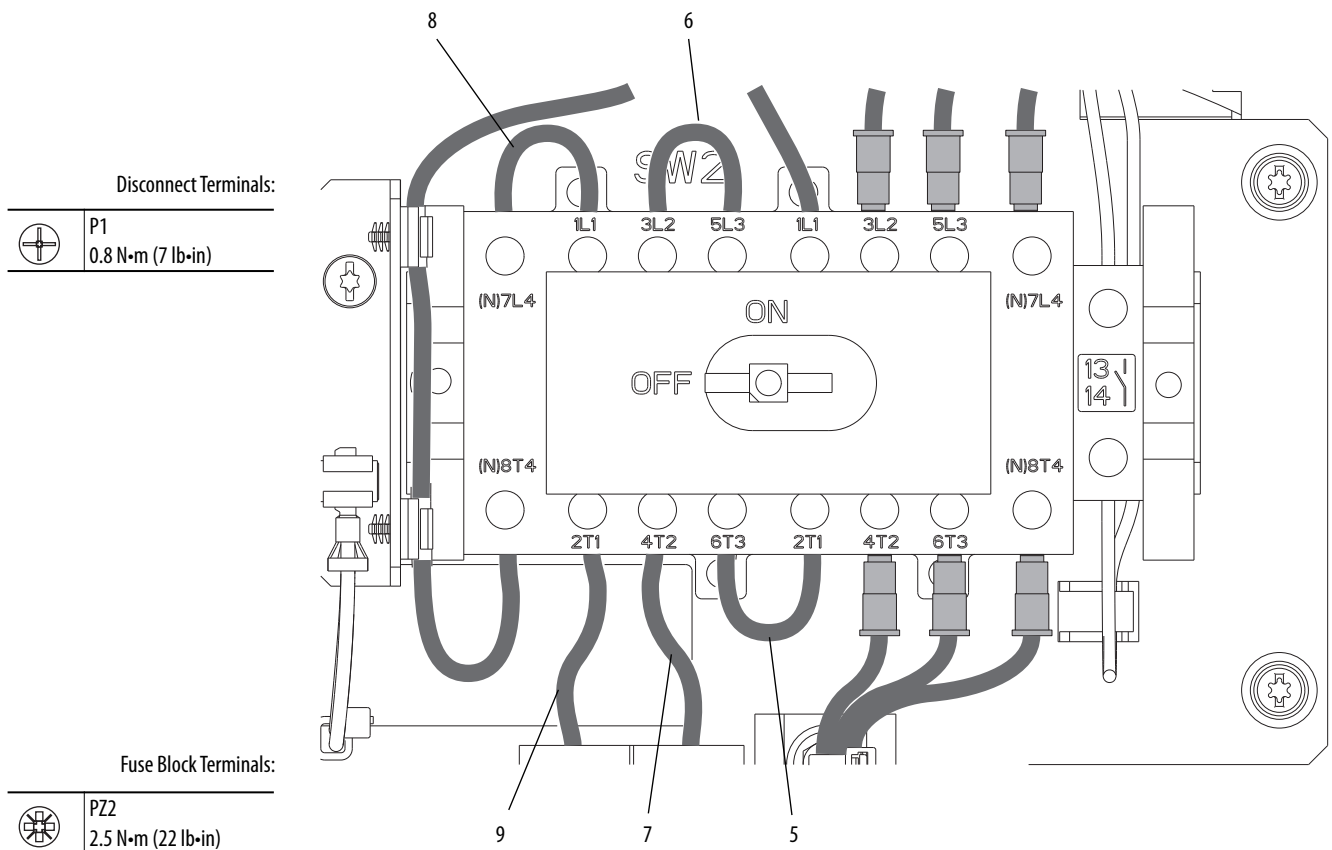
Install the 24V/120V/240V Wire Harness

Install the 24V/120V/240V wire harness in the reverse order of removal. See Remove the 24V/120V/240V Wire Harness on page [195](#).

Disconnect Switch Jumper Wires Removal/Installation

Remove the Disconnect Switch Jumper Wires

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left cover, top guard, and left guard assembly. See Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard on page [163](#).
5. Disconnect the +DC jumper wire from terminals SW2-5 and SW2-4 on the bottom of the disconnect switch.
6. Disconnect the +DC jumper wire from terminals SW2-4 and SW2-3 on the top of the disconnect switch.
7. Disconnect the +DC jumper wire from terminal SW2-3 on the bottom of the disconnect switch and the top of fuse block FU3.
8. Disconnect the -DC jumper wire from terminals SW2-1 and SW2-2 on the top of the disconnect switch.
9. Disconnect the -DC jumper wire from terminal SW2-2 on the bottom of the disconnect switch and the top of fuse block FU4.



Install the Disconnect Switch Jumper Wires

Install the disconnect switch jumper wires in the reverse order of removal. See Remove the Disconnect Switch Jumper Wires on page [201](#).

Disconnect Switch (SW2), Auxiliary Contact, and Handle Shaft Removal/Installation

Remove the Disconnect Switch, Auxiliary Contact and Handle Shaft

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left cover, top guard, and left guard assembly. See Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard on page [163](#).
5. Remove the DC bus input harness +DC wire from the disconnect switch terminal SW2-5 and the DC bus input harness -DC wire from the disconnect switch terminal SW2-1. See Remove the DC Bus Input Wire Harness on page [183](#).
6. Remove the 24V control harness wires from terminals 13 and 14 on the disconnect switch auxiliary contact. See Remove the 24V Control Wire Harness on page [187](#).
7. Remove the transformer primary wire harness from the disconnect switch terminals SW2-6, SW2-7, and SW2-8. See Remove the Transformer Primary Wire Harness on page [193](#).
8. Remove the 24V/120V/240V wire harness from the disconnect switch terminals SW2-6, SW2-7, and SW2-8. See Remove the 24V/120V/240V Wire Harness on page [195](#).
9. Remove the five disconnect switch jumper wires from the disconnect switch SW2. See Remove the Disconnect Switch Jumper Wires on page [201](#).
10. Extend the two release tabs near poles 4 and 7 on the bottom of the disconnect switch. Remove the disconnect switch, auxiliary contact, and handle shaft from the mounting rail.

Note: The auxiliary contact snaps fits onto the disconnect switch.

Note: If removed, fully insert the handle shaft to the bottom of the disconnect switch before set screw tightening. A 2.5 mm hex key and torque requirement of 0.6 N•m (5.4 lb•in) is recommended for the set screw.

Install the Disconnect Switch, Auxiliary Contact and Handle Shaft

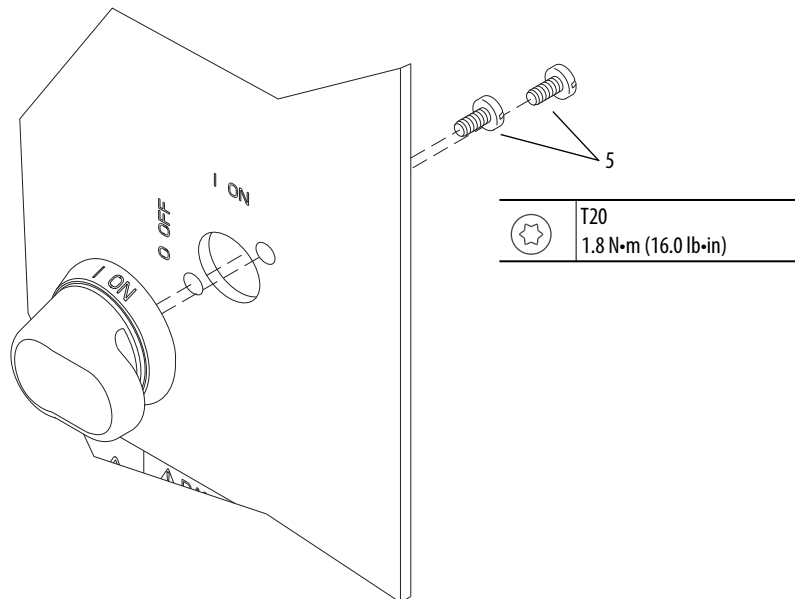
Install the disconnect switch, auxiliary contact, and handle shaft in the reverse order of removal. See Remove the Disconnect Switch, Auxiliary Contact and Handle Shaft on page [202](#).

Wiring must be installed as shown in the DC Input with Precharge Assembly Schematic Diagram (540V DC, 650V DC, 810V DC, and 932V DC Classes Common DC Input Drives) on [page 442](#).

Disconnect Switch Handle Removal/Installation

Remove the Disconnect Switch Handle

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left cover, top guard, and left guard assembly. See Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard on page [163](#).
5. Remove the two M4 x 12 mm long screws and washers that secure the handle to the front cover and remove the handle.



Install the Disconnect Switch Handle

Install the disconnect switch handle in the reverse order of removal. See Remove the Disconnect Switch Handle on page [203](#).

IMPORTANT The disconnect switch handle must be installed in the orientation that is shown in the illustration.

Control Transformer Removal/Installation

Remove the Control Transformer

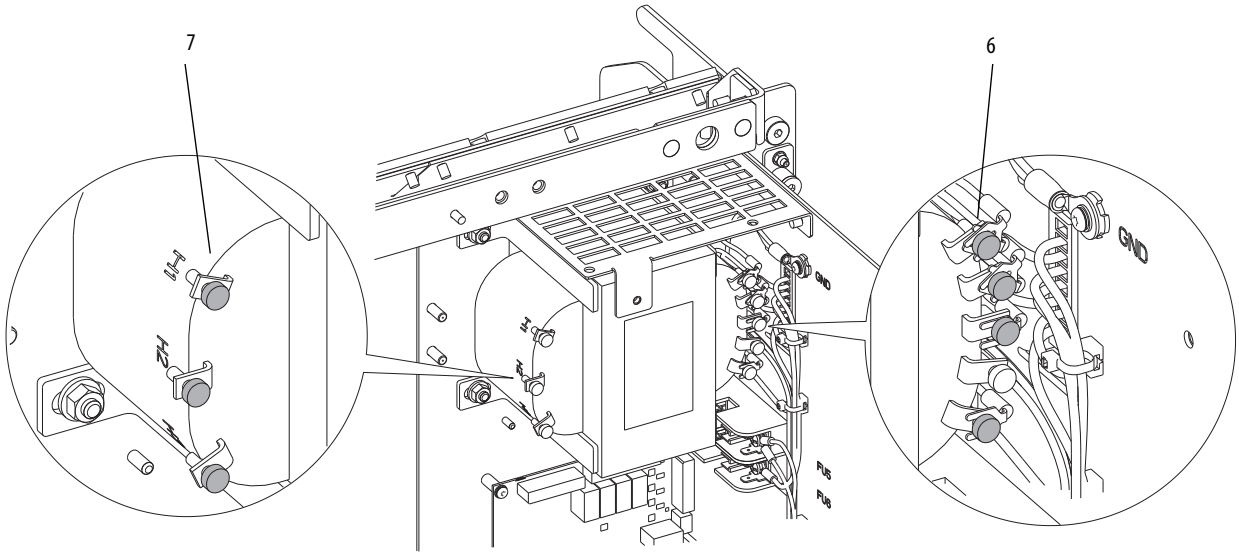
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left cover, top guard, and left guard assembly. See Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard on page [163](#).
5. If the control pod is installed, then rotate the control pod to gain access to the DC input with precharge assembly control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the right cover. See Remove the DC Input with Precharge Assembly Right Cover (No Control Pod) on page [172](#).

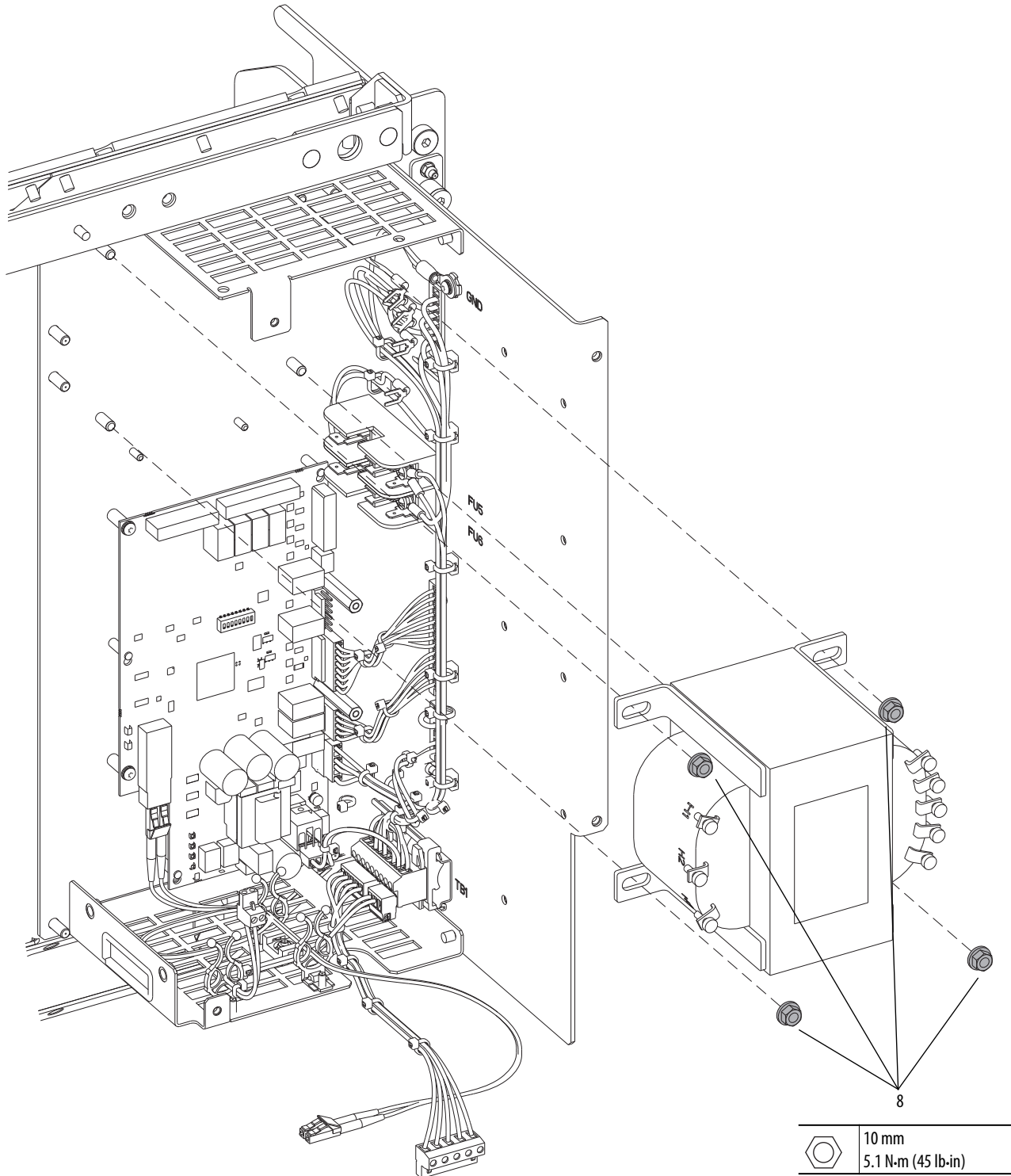
6. Loosen, but do not remove, the M4 screws that secure the X1, X2, X3, and X4 secondary lead wires to the control transformer and remove the wires.

IMPORTANT Before you disconnect the control-transformer primary wire leads, note the terminal locations. The control transformer has both 120V and 240V input phase terminals. See the DC Input with Precharge Assembly Control Transformer Schematic Diagram on page [442](#) for more information.

7. Loosen, but do not remove, the M4 screws that secure the H1 and HX primary lead wires to the control transformer and remove the wires.



8. Remove the four M6 hex nuts that secure the control transformer to the control panel and slide the control transformer forward off the control panel studs.



Install the Control Transformer

Install the control transformer in the reverse order of removal. See Remove the Control Transformer on page [204](#).

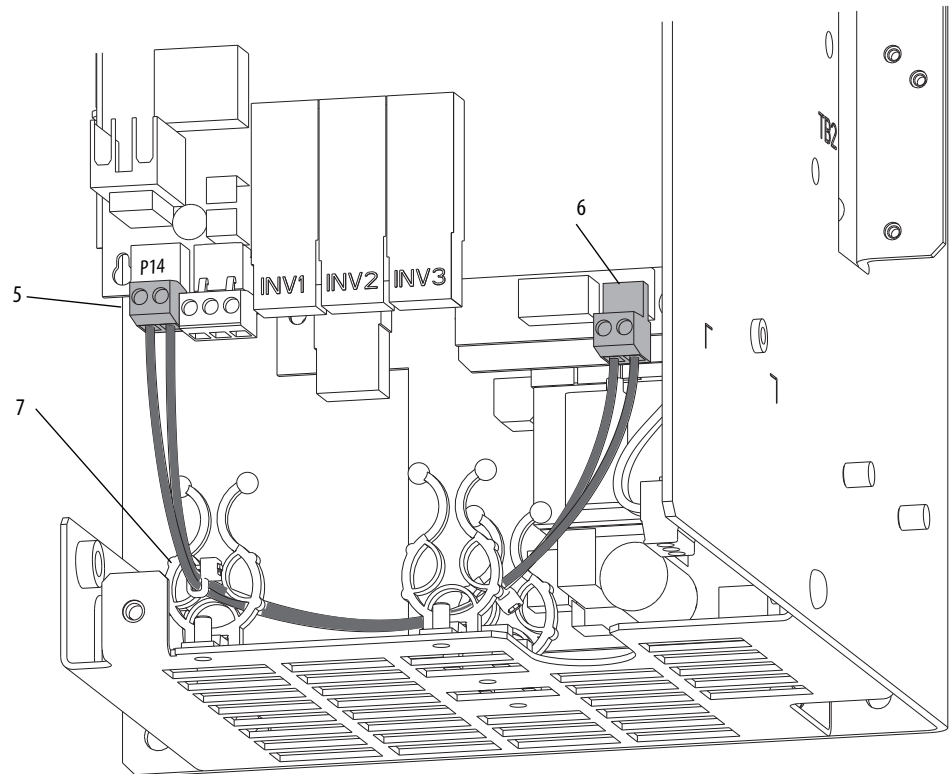
IMPORTANT Be sure that the control-transformer primary wire harness lead wires H1 and HX are connected to the proper input terminals. The control transformer has both 120V and 240V input phase terminals. See the DC Input with Precharge Assembly Control Transformer Schematic Diagram on page [442](#) for more information. If the wires are connected to the wrong terminals, drive damage can occur.

Control Power Isolator Board 24V Wire Harness Removal/ Installation (810/932V DC Input Drives Only)

Remove the Control Power Isolator Board 24V Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the door of the enclosure that contains the control pod.
4. To gain access to the DC input with precharge assembly control panel, rotate the control pod. See Rotate the Control Pod Forward on page [88](#).

5. If necessary, disconnect the 24V wire harness two-position connector from P14 on the fiber interface board in the control pod.
6. Disconnect the 24V wire harness two-position connector from the bottom of the control power isolator board.
7. Untwist one twist-lock cable support and remove the harness.



Install the Control Power Isolator Board 24V Wire Harness

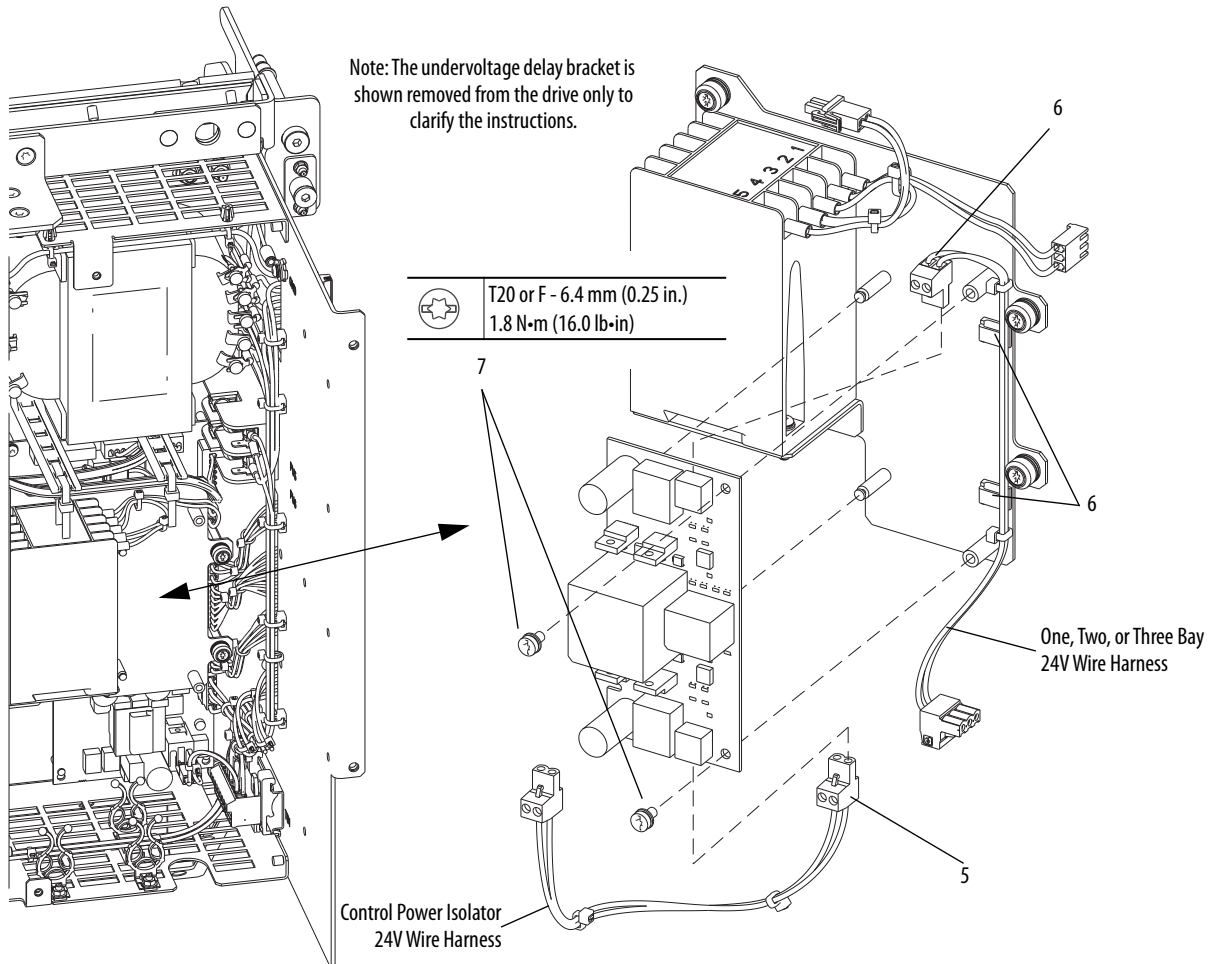
Install the control power isolator board 24V wire harness in the reverse order of removal. See Remove the Control Power Isolator Board 24V Wire Harness on page [207](#).

Control Power Isolator Board Removal/Installation (810/932V DC Input Drives Only)

Remove the Control Power Isolator Board

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the door of the enclosure that contains the control pod.
4. To gain access to the DC input with precharge assembly control panel, rotate the control pod. See Rotate the Control Pod Forward on page [88](#).

5. Disconnect the 24V wire harness two-position connector from the bottom of the control power isolator board.
6. Disconnect the one, two, or three bay 24V wire harness two-position connector from the top of the control power isolator board. Disengage the harness from the two side-entry cable supports.
7. Remove the two M4 x 12 mm screws that secure the control power isolator board to the mounting bracket, slide the board to the right to disengage it from the two keyhole standoffs, and remove the board.



Install the Control Power Isolator Board

Install the control power isolator board in the reverse order of removal. See Remove the Control Power Isolator Board on page [208](#).

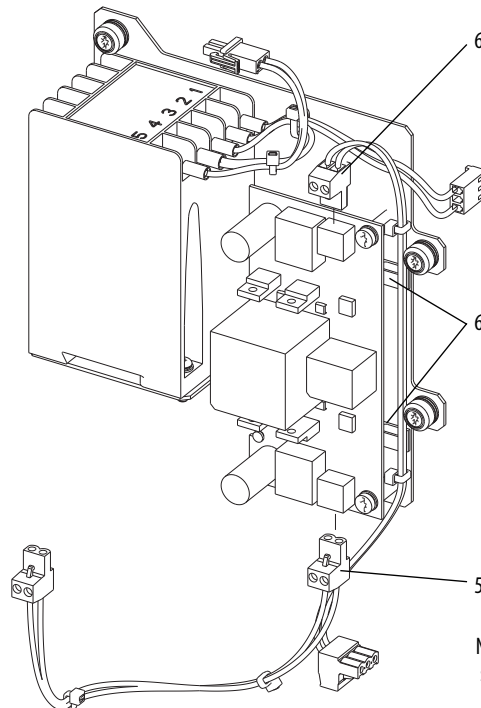
Undervoltage Delay Bracket Removal/Installation

Remove the Undervoltage Delay Bracket

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. If the control pod is installed, then rotate the control pod to gain access to the DC input with precharge assembly control panel. See Rotate the Control Pod Forward on page [88](#).

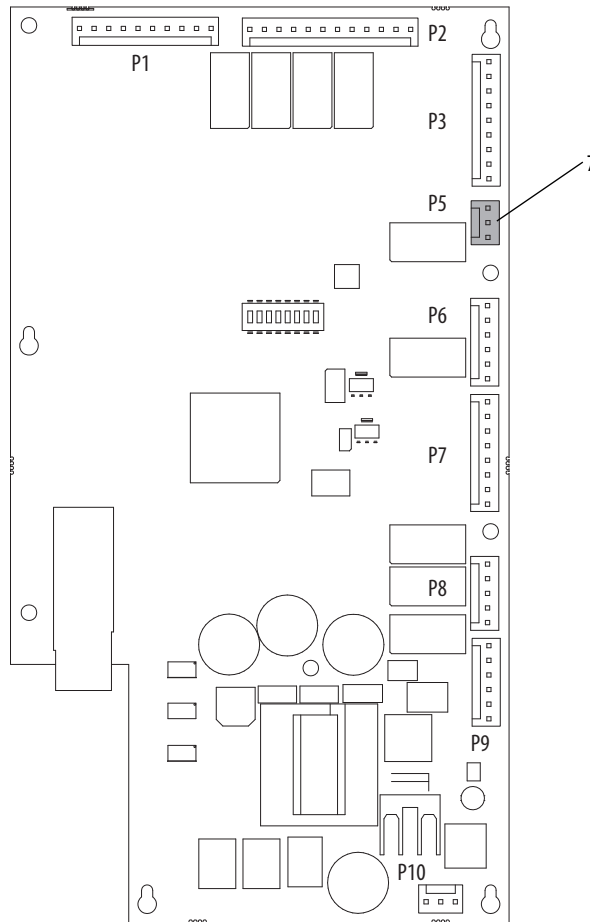
If the control pod is not installed, then remove the right cover. See Remove the DC Input with Precharge Assembly Right Cover (No Control Pod) on page [172](#).

5. For 810/932V DC input drives only, disconnect the 24V wire harness two-position connector from the bottom of the control power isolator board.
6. For 810/932V DC input drives only, disconnect the upper 24V wire harness two-position connector from the top of the control power isolator board. Disengage the harness from the two side entry cable supports.

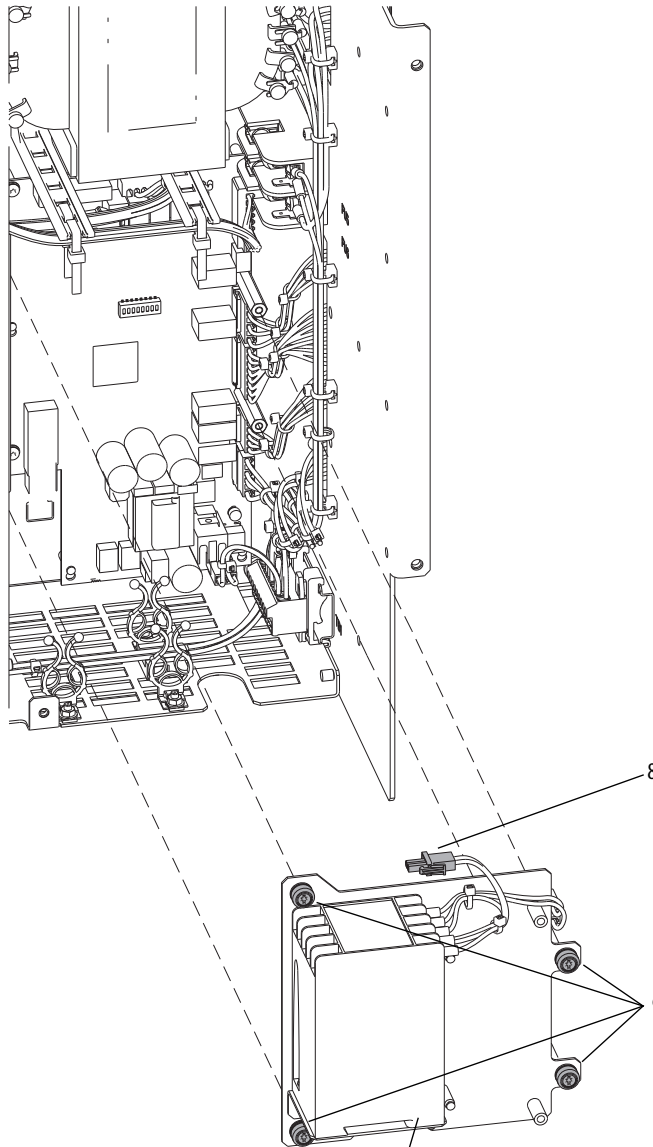


Note: The undervoltage delay bracket is shown removed from the drive only to clarify the instructions.

7. Disconnect the undervoltage wire harness connector from terminal P5 on the DC precharge control board.




8. Disconnect the undervoltage wire harness connector from connector UV on the molded-case switch control wire harness.
9. Loosen the four M4 captive panel fasteners on the undervoltage delay bracket and remove bracket.



Note: The control power isolation board is not shown only to clarify the instructions.

Undervoltage Delay

	T20 or F - 6.4 mm (0.25 in.) 1.8 N-m (16 lb-in)
---	--

Install the Undervoltage Delay Bracket

Install the undervoltage delay bracket in the reverse order of removal. See Remove the Undervoltage Delay Bracket on page [210](#).

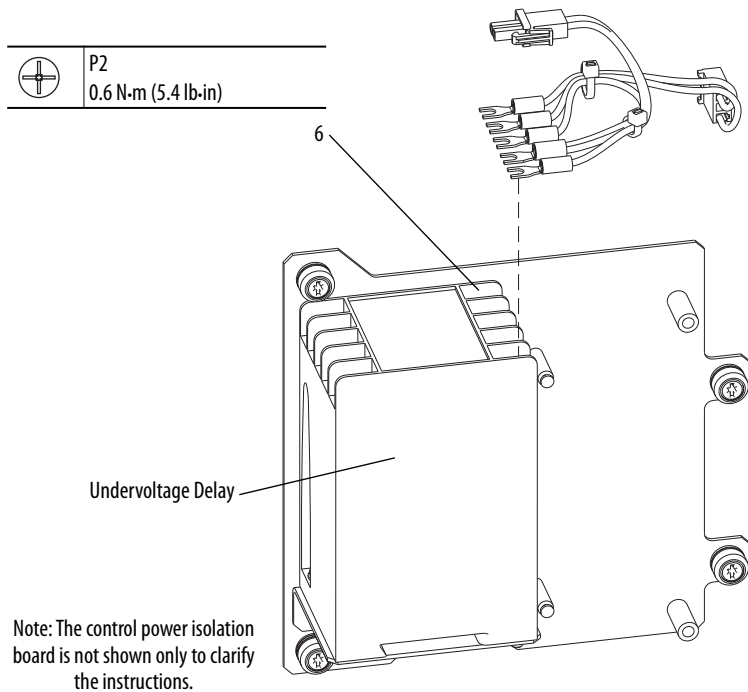
Undervoltage Delay Wire Harness Removal/Installation

Remove the Undervoltage Delay Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. If the control pod is installed, then rotate the control pod to gain access to the DC input with precharge assembly control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the right cover. See Remove the DC Input with Precharge Assembly Right Cover (No Control Pod) on page [172](#).

5. Remove the undervoltage delay bracket from the control panel. See Remove the Undervoltage Delay Bracket on page [210](#).
6. Loosen the captive screws that secure the five harness wires to the undervoltage delay terminals and remove the wire harness.



Install the Undervoltage Delay Wire Harness

Install the undervoltage delay wire harness in reverse order of removal. See Remove the Undervoltage Delay Wire Harness on page [213](#).

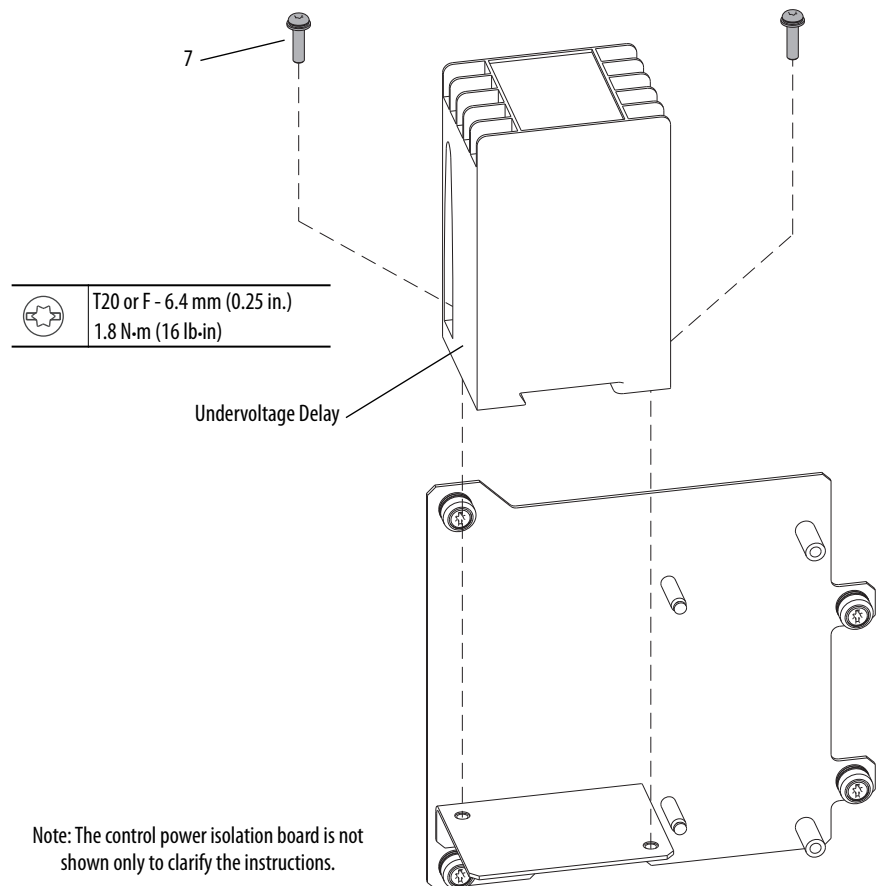
Undervoltage Delay Removal/Installation

Remove the Undervoltage Delay

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. If the control pod is installed, then rotate the control pod to gain access to the DC input with precharge assembly control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the right cover. See Remove the DC Input with Precharge Assembly Right Cover (No Control Pod) on page [172](#).

5. Remove the undervoltage delay bracket from the control panel. See Remove the Undervoltage Delay Bracket on page [210](#).
6. Remove the undervoltage delay wire harness. See Remove the Undervoltage Delay Wire Harness on page [213](#).
7. Remove two M4 x 16 mm screws that secure the undervoltage delay to its mounting bracket, and remove the undervoltage delay.



Install the Undervoltage Delay

Install the undervoltage delay in the reverse order of removal. See Remove the Undervoltage Delay on page [214](#).

DC Precharge Control Board Stirring Fan Removal/ Installation

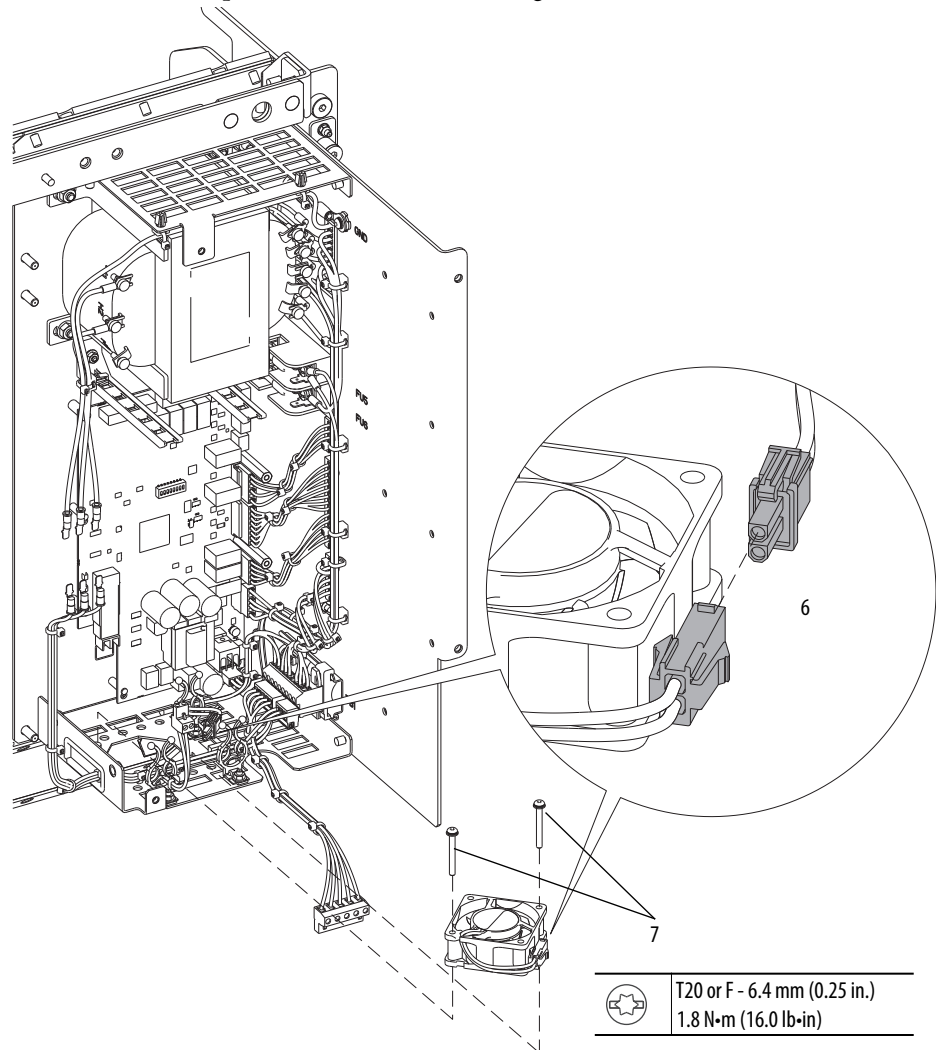
Remove the DC Precharge Control Board Stirring Fan

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. If the control pod is installed, then rotate the control pod to gain access to the DC input with precharge assembly control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the right cover. See Remove the DC Input with Precharge Assembly Right Cover (No Control Pod) on page [172](#).

5. Remove the undervoltage delay bracket. See Remove the Undervoltage Delay Bracket on page [210](#).

6. Disconnect the two-position fan connector from the stirring fan to the 24V/120V/240V wire harness.
7. Remove two M4 x 35 mm long screws that secure the stirring fan to the control panel and remove the stirring fan.



Install the DC Precharge Control Board Stirring Fan

Install the stirring fan in the reverse order of removal. See Remove the DC Precharge Control Board Stirring Fan on page [215](#).

Door-interlock Wire Harness Removal/Installation

Removing the Door Interlock Wire Harness

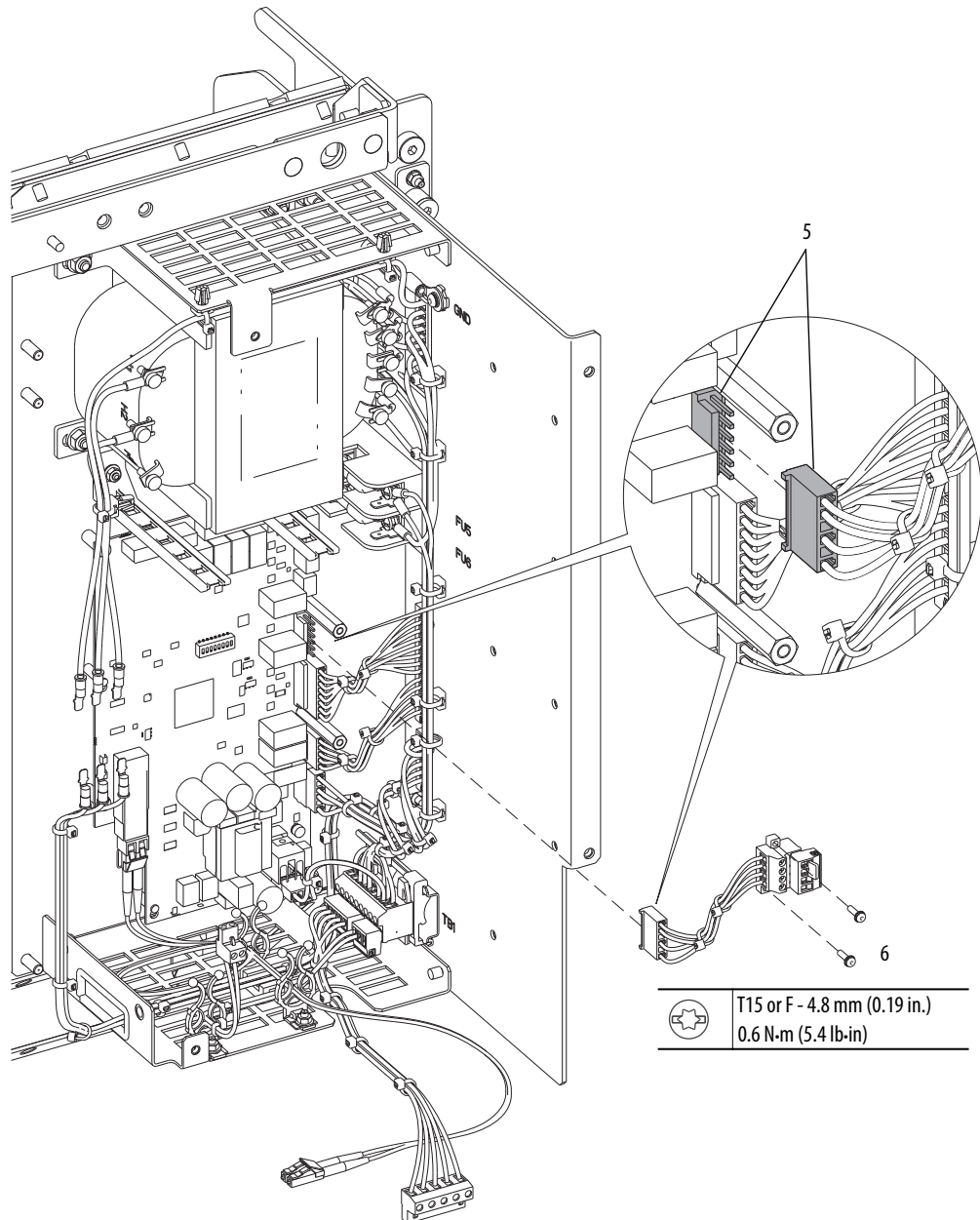
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.

4. If the control pod is installed, then rotate the control pod to gain access to the DC input with precharge assembly control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the right cover. See Remove the DC Input with Precharge Assembly Right Cover (No Control Pod) on page [172](#).

5. Disconnect the door-interlock wire harness connector J6 from the connector P6 on the DC precharge control board.
6. Remove the two M3 x 12 mm hexalobular screws that secure the terminal block TB4 to the control panel and remove the wire harness from the control panel.

Note: The control pod and undervoltage delay are shown removed only to clarify the instructions.



Install the Door Interlock Wire Harness

Install the door interlock wire harness in the reverse order of removal. See Removing the Door Interlock Wire Harness on page [216](#).

Digital I/O Wire Harness Removal/Installation

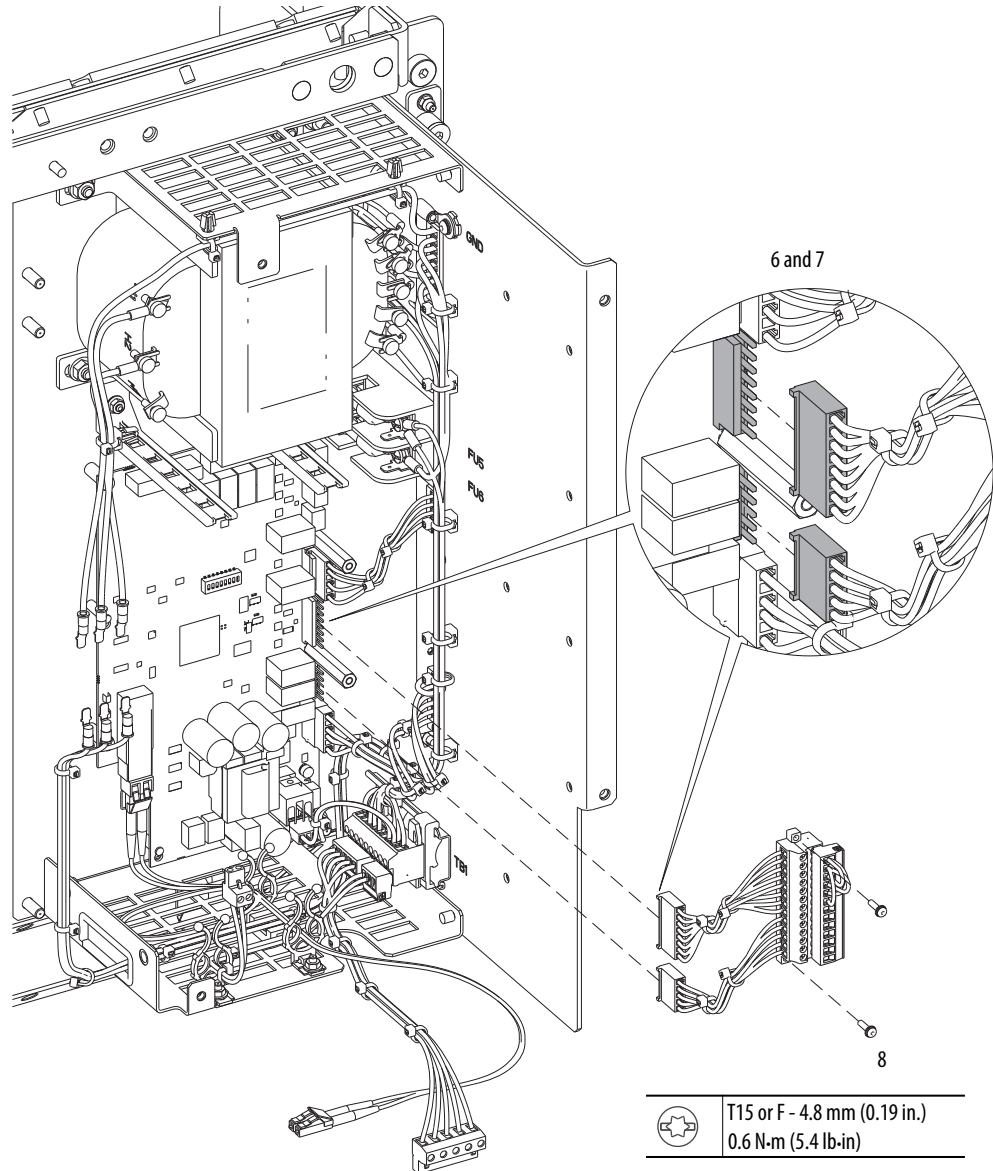
Remove the Digital I/O Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left cover, top guard, and left guard assembly. See Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard on page [163](#).
5. If the control pod is installed, then rotate the control pod to gain access to the DC input with precharge assembly control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the right cover. See Remove the DC Input with Precharge Assembly Right Cover (No Control Pod) on page [172](#).

6. Disconnect the digital I/O wire harness connector from connector P7 on the DC precharge control board.
7. Disconnect the digital I/O wire harness connector from connector P8 on the DC precharge control board.
8. Remove the two M3 x 12 mm hexalobular screws that secure the terminal block TB3 to the control panel and remove the wire harness from the control panel.

Note: The control pod and undervoltage delay are shown removed only to clarify the instructions.



Install the Digital I/O Wire Harness

Install the digital I/O wire harness in the reverse order of removal. See Remove the Digital I/O Wire Harness on page [218](#).

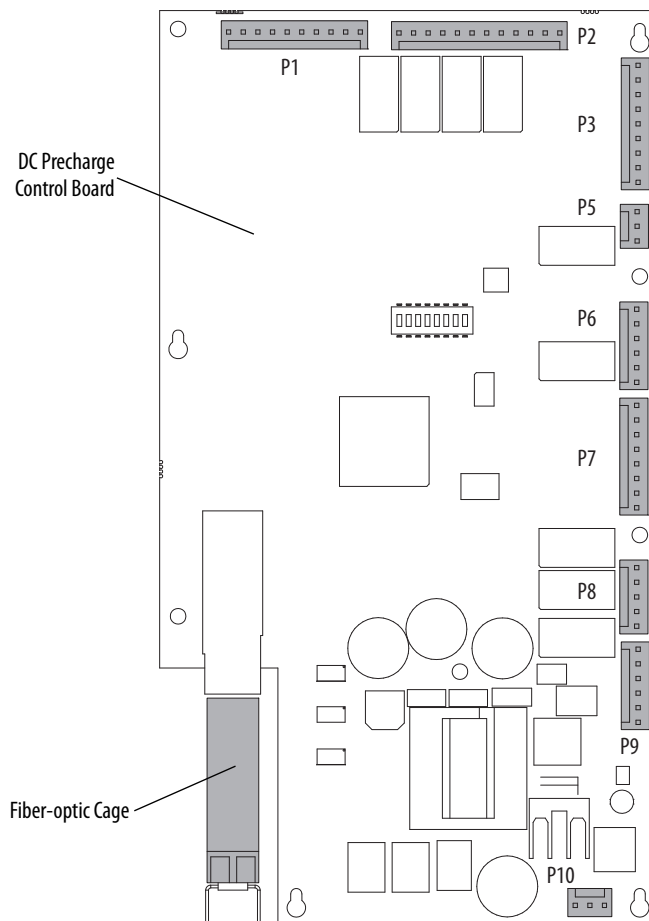
DC Precharge Control Circuit Board Removal/Installation

Remove the DC Precharge Control Circuit Board

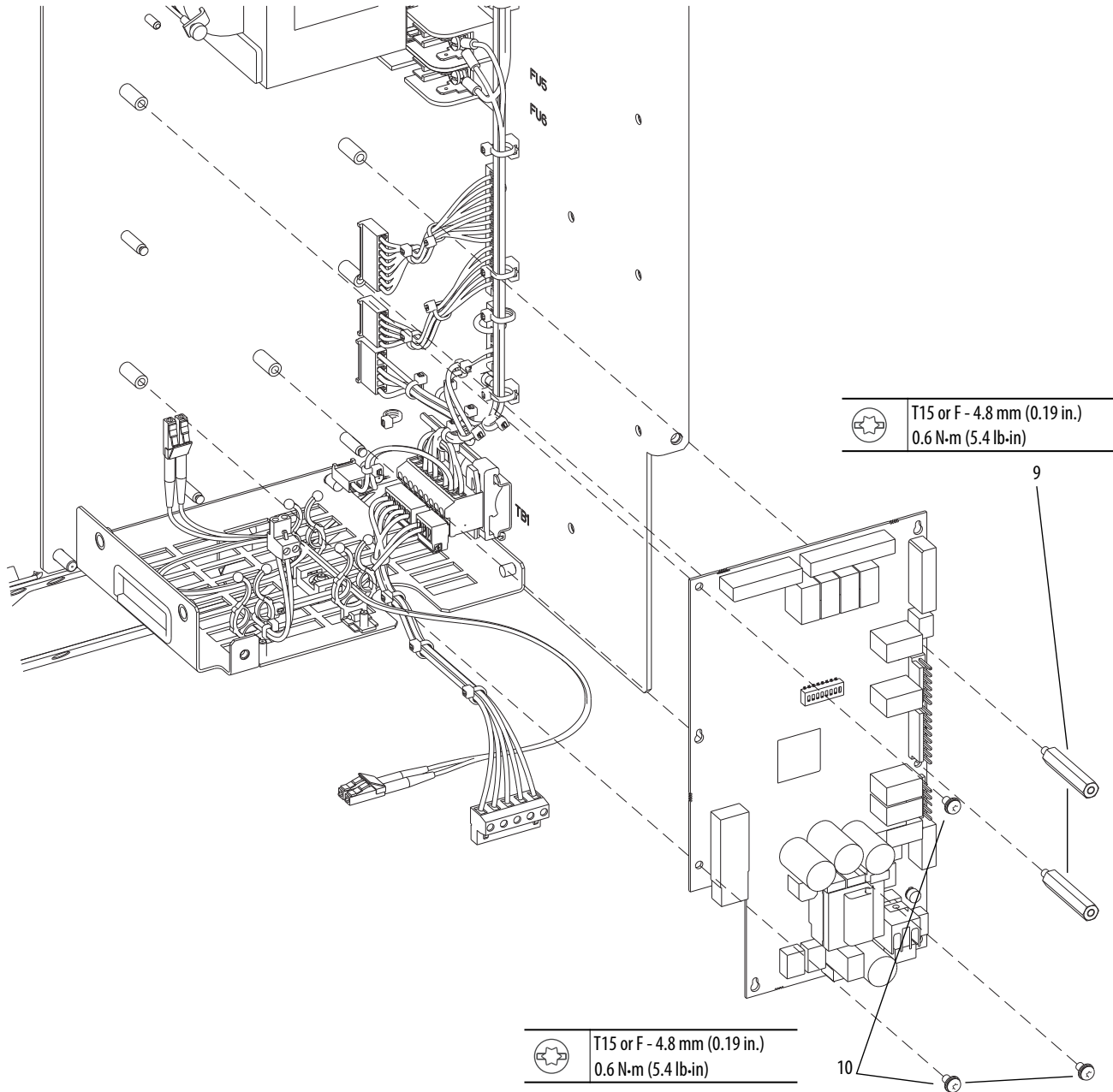
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the left cover, top guard, and left guard assembly. See Remove the DC Input with Precharge Assembly Left Cover, Top Guard, and Left Guard on page [163](#).
5. If the control pod is installed, then rotate the control pod to gain access to the DC input with precharge assembly control panel. See Rotate the Control Pod Forward on page [88](#).

If the control pod is not installed, then remove the right cover. See Remove the DC Input with Precharge Assembly Right Cover (No Control Pod) on page [172](#).

6. Remove the undervoltage delay bracket. See Remove the Undervoltage Delay Bracket on page [210](#).
7. Disconnect the wire harnesses from the DC precharge control board.
8. From the fiber-optic cage in the lower left corner of the DC precharge control board, remove the fiber-optic transceiver by pulling its wire latch. Set the transceiver aside and save for reinstallation.



9. Remove the two M4 x 40 mm hex standoffs.
10. Remove the three M4 x 8 mm screws that secure the DC precharge control board to the DC input control panel, slide the DC precharge control board up to disengage its four keyhole slots, and remove the board.



Install the DC Precharge Control Circuit Board

Install the DC precharge control board in the reverse order of removal. See Remove the DC Precharge Control Circuit Board on page [220](#).

DC Input with Precharge Assembly Removal/Installation

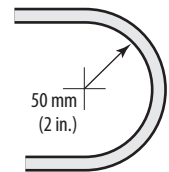


ATTENTION: Only perform a field replacement of the DC input with precharge assembly of the power core as part of the drive assembly removal procedure. Otherwise, equipment damage can result.

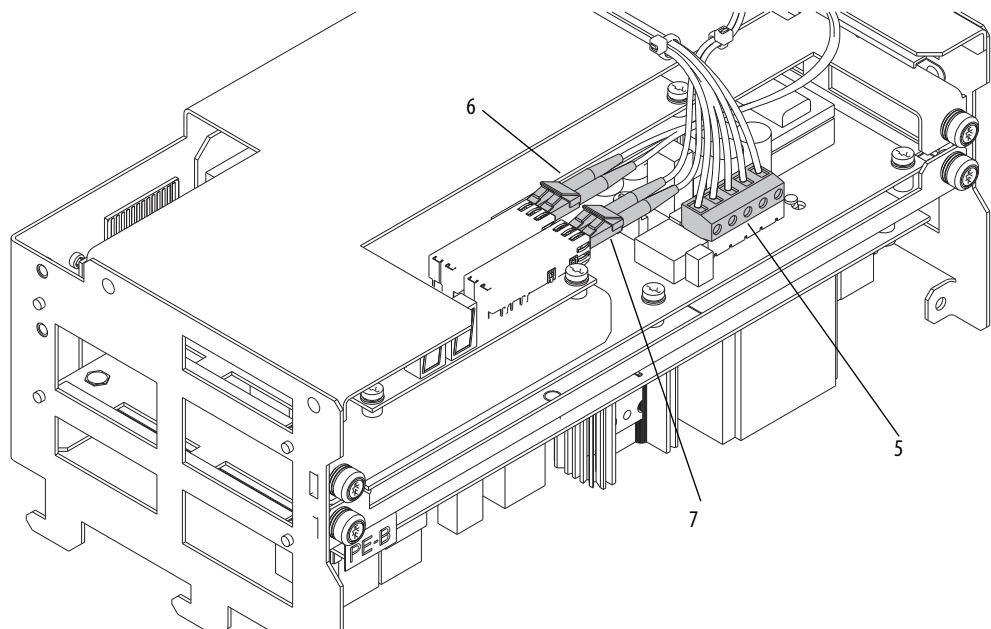
Remove the DC Input with Precharge Assembly

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Remove the drive assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
4. Remove the inverter circuit board connections cover from the inverter. See Inverter Circuit Board Connections Cover Removal/Installation on page [238](#).
5. Disconnect the inverter power-supply wire harness connector from terminal P6 on the inverter power control board.

IMPORTANT Minimum inside bend radius for fiber-optic cable is 50 mm (2 in.). Any bends with a shorter inside radius can permanently damage the fiber-optic cable. Signal attenuation increases with decreased inside bend radii.



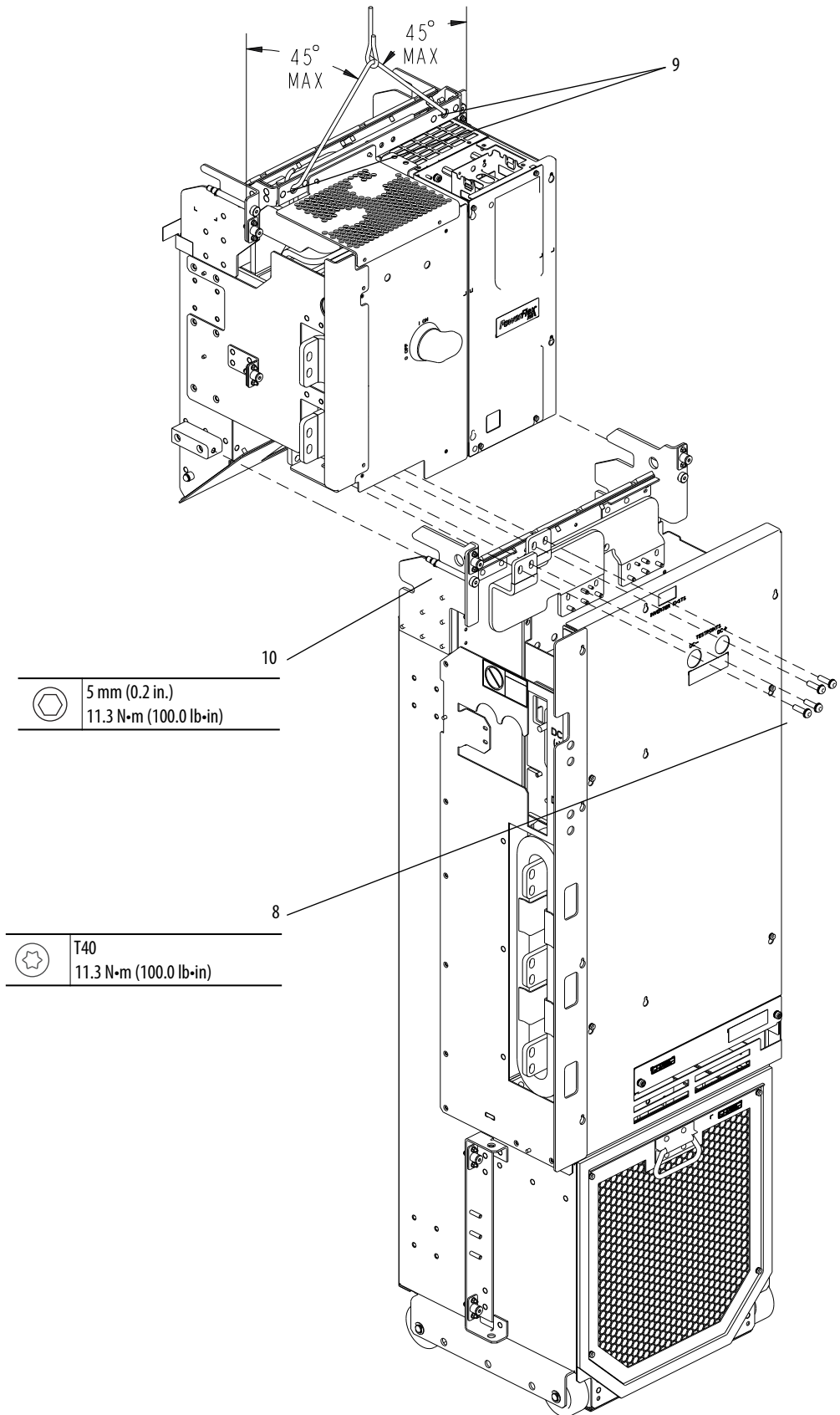
6. Disconnect the fiber-optic cable from CONV on the inverter power-layer interface board and secure it to the DC input with precharge assembly. Do not remove the fiber-optic transceiver.
7. If the control pod is assembled on the DC input with precharge assembly, disconnect the fiber-optic cable from INV on the inverter power-layer interface board and secure it to the control pod. Do not remove the fiber-optic transceiver.



8. Remove the four M8 x 30 mm machine screws that secure the inverter DC bus bars to the DC input with precharge assembly bus bars.

IMPORTANT A load capacity of 80 kg (175 lb) minimum is required for all lifting equipment and hardware that is used for this procedure.
Verify that the angle of attachment of the lifting hardware is no more than 45° from vertical.

9. Connect the lifting hardware to the two lifting holes on the lifting bar at the top of the DC input with precharge assembly.
10. Loosen the two M8 screws that secure the DC input with precharge assembly duct to the inverter duct.
11. Lift and slide the DC input with precharge assembly away from the inverter assembly.



Install the DC Input with Precharge Assembly

1. Inspect the gasket at the top of the DC input with precharge assembly duct for damage and replace if necessary. See Remove the DC Input with Precharge Assembly Duct Gasket on page [225](#).
2. Inspect the gasket at the top of the inverter duct for damage and replace if necessary.
3. Install the DC input with precharge assembly on the inverter assembly in the reverse order of removal. See Remove the DC Input with Precharge Assembly on page [222](#).

DC Input with Precharge Assembly Duct Gasket Replacement

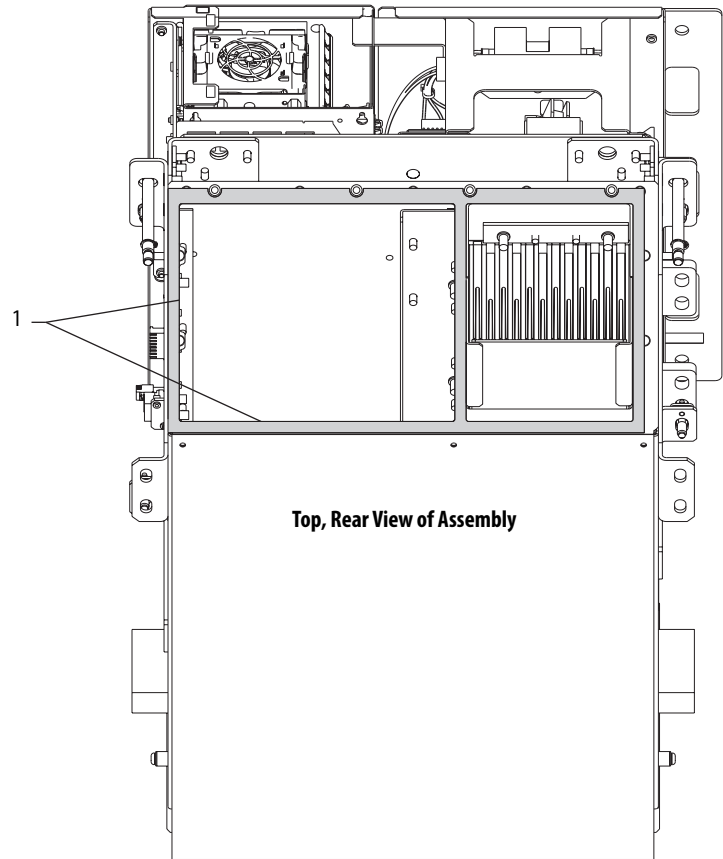
Remove the DC Input with Precharge Assembly Duct Gasket

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Remove the drive assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
4. Remove the DC input with precharge assembly. Remove the DC Input with Precharge Assembly on page [222](#).
5. Carefully remove the gasket and any gasket material that can be stuck to the sealing surface.
6. Clean the duct surface with a 50% isopropyl alcohol/ 50% water mixture.

Install the DC Input with Precharge Assembly Duct Gasket

Note: One side of the duct gasket is coated with an adhesive. Take care to align the gasket properly before fully removing the paper liner and exposing the adhesive.

1. Begin removing the paper liner as you align the replacement gasket with the duct edges as shown and press the gasket into place on the duct.



2. Install the DC input with precharge assembly on the inverter assembly in the reverse order of removal. See Remove the DC Input with Precharge Assembly on page [222](#).

Inverter Component Replacement Procedures

Topic	Page
Inverter Components Identification	228
Common-mode Core Assembly Removal/Installation	233
Internal Stirring Fan Tray Removal/Installation	234
Heatsink Fan Inlet Screen Removal/Installation	235
Heatsink Fan Assembly Removal/Installation	236
Inverter Circuit Board Connections Cover Removal/Installation	238
Inverter Front Cover Removal/Installation	239
Inverter Current Sensors Removal/Installation	240
Inverter Current Sensor Wire Harness Removal/Installation	243
Inverter Capacitor Bank Assembly Removal/Installation	246
Capacitor Balance Resistor Assembly Removal/Installation	248
IGBT Flexbus Bars Removal/Installation	250
Inverter Gate Board Connection Ribbon Cables Removal/Installation	251
Inverter Gate Circuit Board Removal/Installation	253
Rating Plug Removal/Installation	255
Power Layer Interface Circuit Board Removal/Installation	256
Power Supply Circuit Board Removal/Installation	258
Power Control Circuit Board Removal/Installation	262
Inverter Backplane Circuit Board Removal/Installation	265
Inverter EMC Capacitor Removal/Installation (AC Input Drive Only)	268
Inverter Side DC Bus Bar Removal/Installation (AC Input Drive Only)	272
Inverter Top DC Bus Bar Removal/Installation (Common DC Input Drive Only)	280
DC Choke Removal/Installation (AC Input Drives Only)	285
Inverter Wire Harness Removal/Installation	287
Discharge Resistor Assembly Removal/Installation	291
Inverter Heatsink Fan Inlet Bottom Cover Removal/Installation	298
Inlet Bottom Cover Gasket Replacement	299

This chapter provides detailed procedures for how to remove and replace inverter components.

IMPORTANT Complete the procedures in Chapter 12 Drive Startup after Repairs that begin on page 419 before placing the drive back into service.

Inverter Components Identification

Table 13 contains the components that comprise the inverter assembly and provides the following information for each component, if applicable:

- Kit catalog number or part number
- Quantity that is contained in the kit
- Illustration figure and page number and identification number

See PowerFlex Architecture Class Low Voltage Drives Spare Parts Options, publication [PFLEX-SB002](#) for a complete list of spare parts for PowerFlex® 755 Frame 8...10 drives.

IMPORTANT A replacement IGBT assembly is not available. If IGBT replacement is required, the recommendation is to replace the entire inverter unit.

Table 13 - Inverter Replacement Kits/Parts

Component Description	Replacement Kit Cat. No. or Part No.	Quantity	Figure and Page	ID No.
Inverter Unit for 400V, 460 A / 480V, 430 A AC Input Drives	20-750-I1-C460D430 (Series A) 20-750-I1B-C460D430 (Series B)	1	–	
Inverter Unit for 400V, 540 A / 480V, 485 A AC Input Drives	20-750-I1-C540D485 (Series A) 20-750-I1B-C540D485 (Series B)	1	–	
Inverter Unit for 400V, 567 A / 480V, 545 A AC Input Drives	20-750-I1-C567D545 (Series A) 20-750-I1B-C567D545 (Series B)	1	–	
Inverter Unit for 400V, 650 A / 480V, 617 A AC Input Drives	20-750-I1-C650D617 (Series A) 20-750-I1B-C650D617 (Series B)	1	–	
Inverter Unit for 400V, 750 A / 480V, 710 A AC Input Drives	20-750-I1-C750D710 (Series A) 20-750-I1B-C750D710 (Series B)	1	–	
Inverter Unit for 400V, 770 A / 480V, 740 A AC Input Drives	20-750-I1-C770D740 (Series A) 20-750-I1B-C770D740 (Series B)	1	–	
Inverter Unit for 600V, 295 A / 690V, 265 A AC Input Drives	20-750-I1B-E295F265 (Series B)	1	–	
Inverter Unit for 600V, 355 A / 690V, 330 A AC Input Drives	20-750-I1B-E355F330 (Series B)	1	–	
Inverter Unit for 600V, 395 A / 690V, 370 A AC Input Drives	20-750-I1B-E395F370 (Series B)	1	–	
Inverter Unit for 600V, 435 A / 690V, 415 A AC Input Drives	20-750-I1B-E435F415 (Series B)	1	–	
Inverter Unit for 600V, 460 A / 690V, 460 A AC Input Drives	20-750-I1B-E460F460 (Series B)	1	–	
Inverter Unit for 600V, 510 A / 690V, 500 A AC Input Drives	20-750-I1B-E510F500 (Series B)	1	–	
Inverter Unit for 540V, 460 A / 650V, 430 A DC Input Drives	20-750-I2B-C460D430 (Series B)	1	–	
Inverter Unit for 540V, 540 A / 650V, 485 A DC Input Drives	20-750-I2B-C540D485 (Series B)	1	–	
Inverter Unit for 540V, 567 A / 650V, 545 A DC Input Drives	20-750-I2B-C567D545 (Series B)	1	–	
Inverter Unit for 540V, 650 A / 650V 617 A DC Input Drives	20-750-I2B-C650D617 (Series B)	1	–	
Inverter Unit for 540V, 750 A / 650V, 710 A DC Input Drives	20-750-I2B-C750D710 (Series B)	1	–	
Inverter Unit for 540V, 770 A / 650V, 740 A DC Input Drives	20-750-I2B-C770D740 (Series B)	1	–	
Inverter Unit for 810V, 295 A / 932V, 265 A DC Input Drives	20-750-I2B-E295F265	1	–	

Table 13 - Inverter Replacement Kits/Parts (continued)

Component Description	Replacement Kit Cat. No. or Part No.	Quantity	Figure and Page	ID No.
Inverter Unit for 810V, 355 A / 932V, 330 A DC Input Drives	20-750-I2B-E355F330	1	–	
Inverter Unit for 810V, 395 A / 932V, 370 A DC Input Drives	20-750-I2B-E395F370	1	–	
Inverter Unit for 810V, 435 A / 932V, 415 A DC Input Drives	20-750-I2B-E435F415	1	–	
Inverter Unit for 810V, 460 A / 932V, 460 A DC Input Drives	20-750-I2B-E460F460	1	–	
Inverter Unit for 810V, 510 A / 932V, 500 A DC Input Drives	20-750-I2B-E510F500	1	–	
Inverter Capacitor Bank, 400V 770 A, 480V 740 A	SK-R1-CP1-C770D740	1	Figure 13 on page 231	1
Inverter Capacitor Bank, 400V 567 A, 480V 545 A	SK-R1-CP1-C567D545	1	Figure 13 on page 231	1
Inverter Capacitor Bank, 600V 395 A, 690V 370 A	SK-R1-CP1-E395F370	1	Figure 13 on page 231	1
Inverter Capacitor Bank, 600V 510 A, 690V 500 A	SK-R1-CP1-E510F500	1	Figure 13 on page 231	1
Capacitor Balance Resistors, 400/480V AC Input Drive (includes mounting tray)	SK-R1-RB1-CD-F8	1	Figure 13 on page 231	2
Capacitor Balance Resistors, 600/690V AC Input Drive (includes mounting tray)	SK-R1-RB1-EF-F8	1	Figure 13 on page 231	2
Discharge Resistor Assembly, 400/480V AC Input Drive	SK-R1-RD1-F8	1	Figure 13 on page 231	3
Discharge Resistor Assembly, 600/690V AC Input Drive	SK-R1-RD2-F8	1	Figure 13 on page 231	3
Inverter IGBT Flexbus, 400V 567 A, 480V 545 A	SK-R1-BS1-C567D545	3	Figure 13 on page 231	4
Inverter IGBT Flexbus, 400V 770 A, 480V 740 A	SK-R1-BS1-C770D740	3	Figure 13 on page 231	4
Inverter Current Sensor	SK-R1-INVIFB1-F8	1	Figure 13 on page 231	5
Inverter Heatsink Fan Kit	SK-R1-FAN1-F8	1	Figure 13 on page 231	6
Inverter Internal Stir Fans w/Tray	SK-R1-FAN2-F8	1	Figure 13 on page 231	7
DC Choke, 33 mH, 400V 770 A, 480V 740 A	SK-R1-DCCHK1-F8	1	Figure 13 on page 231	8
DC Choke, 50 mH, 400V 567 A, 480V 545 A	SK-R1-DCCHK2-F8	1	Figure 13 on page 231	8
DC Choke, 69 mH, 600V 510 A, 690V 500 A	SK-R1-DCCHK3-F8	1	Figure 13 on page 231	8
Inverter Power Control Board	SK-R1-PC1-F8	1	Figure 14 on page 232	10
Inverter Heatsink Power Supply Board, 400/480V	SK-R1-PWRS1-CD-F8	1	Figure 14 on page 232	11
Inverter Heatsink Power Supply Board, 600/690V	SK-R1-PWRS1-EF-F8	1	Figure 14 on page 232	11
Inverter Power Layer Interface Board (Includes two fiber-optic transceivers)	SK-R1-PINT1-F8 (Series A) SK-R1-PINT2-F8 (Series B)	1	Figure 14 on page 232	12
Inverter Gate Board, 400V 770 A, 480V 740 A	SK-R1-IG1-C770D740	1	Figure 13 on page 231	14
Inverter Gate Board, 400V 567 A, 480V 545 A	SK-R1-IG1-C567D545	1	Figure 13 on page 231	14
Inverter Gate Board, 600V 510 A, 690V 500 A	SK-R1-IG1-E510F500	1	Figure 13 on page 231	14
Inverter Gate Board, 600V 395 A, 690V 370 A	SK-R1-IG1-E395F370	1	Figure 13 on page 231	14
Inverter Ribbon Cable	SK-R1-ICBL1-F8	1	Figure 13 on page 231	15
Inverter Front Cover with Side Shield	SK-R1-IFCVR1-F8	1	Figure 13 on page 231	16 ⁽²⁾
Inverter Heatsink Fan Inlet Screen	SK-R1-IFCVR2-F8	1	Figure 13 on page 231	17
Inverter Heatsink Fan Inlet Bottom Cover	SK-R1-IBCVR1-F8	1	Figure 13 on page 231	18
Inverter Wire Harness Kit	SK-R1-INVH1-F8	1	Figure 13 on page 231	19
EMC Capacitors	SK-R1-EMCCAP1-F8	3	Figure 13 on page 231	21

Table 13 - Inverter Replacement Kits/Parts (continued)

Component Description	Replacement Kit Cat. No. or Part No.	Quantity	Figure and Page	ID No.
Frame 8 Gasket Kit	20-750-G1-F8	–		
Gasket, Converter, Heatsink		1	(1)	–
Gasket, Converter/DC Input with Precharge Assembly, Duct		1	(1)	–
Gasket, Inverter, IGBT Assembly Heatsink		1	Figure 13 on page 231	22
Gasket, Inverter, Door Interface		1	Figure 13 on page 231	23
Gasket, Inverter, Exhaust Interface		1	Figure 13 on page 231	24
Gasket, Inverter, Inlet Ring		1	Figure 13 on page 231	25
Gasket, Inverter, No Choke		1	Figure 13 on page 231	26
Gasket, Inverter, Fan Inlet Bottom Cover		1	Figure 13 on page 231	27
Gasket, Inverter, Choke		1	Figure 13 on page 231	28

(1) This gasket is included in the Frame 8 Gasket Kit (20-750-G1-F8), but is identified in the table in Converter Components Identification on page 82.

(2) Updated panel excludes access to the P6 connector on the inverter power control board. Access to this connector, is now gained by removing the entire side shield.

TIP

See Fastener/Tool/Torque Information on page 33 for descriptions of the fasteners, tools, and torque figures that are used in the disassembly/assembly procedures in this chapter.

Figure 13 - Inverter Main Assembly Components Diagram

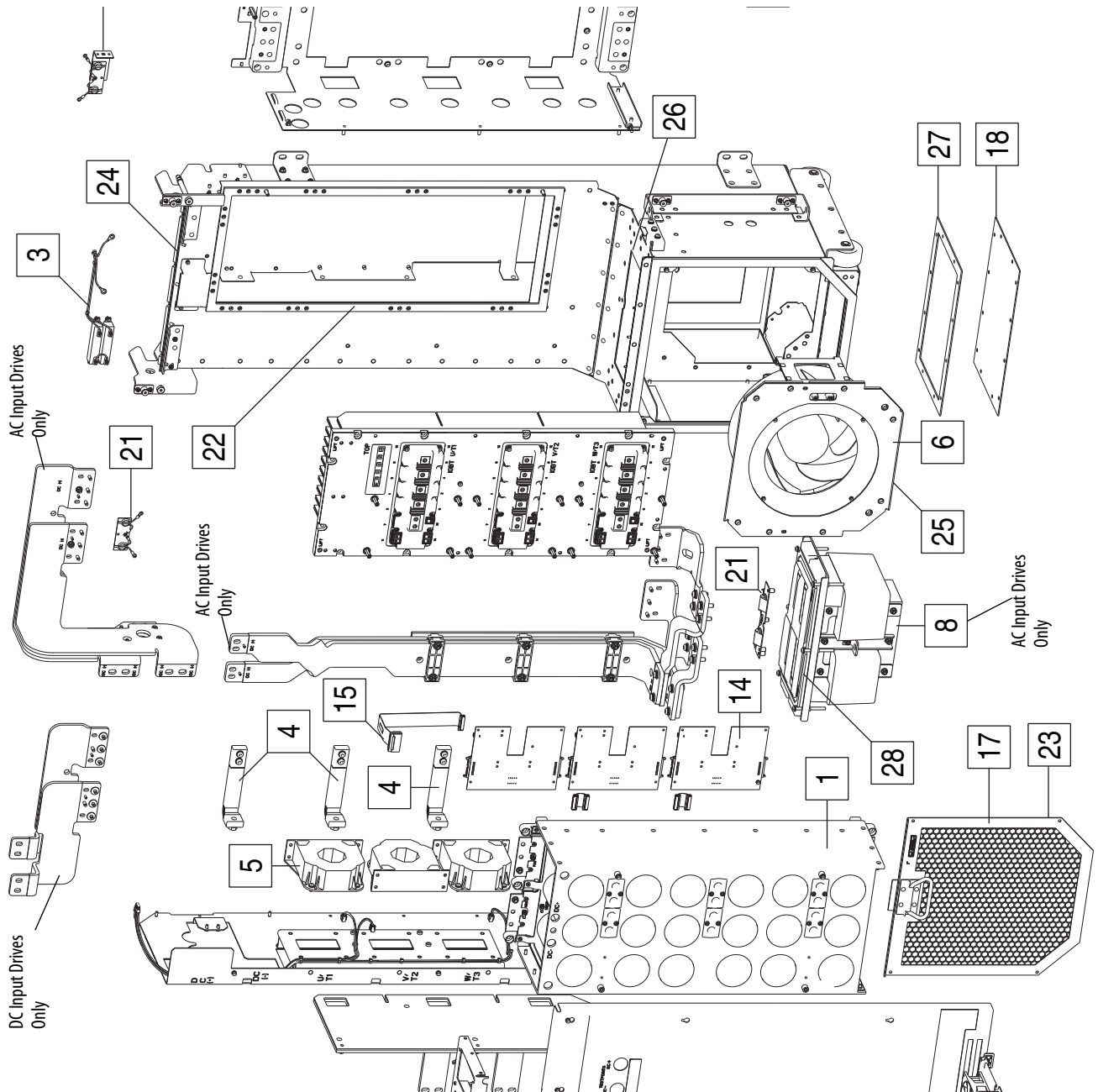
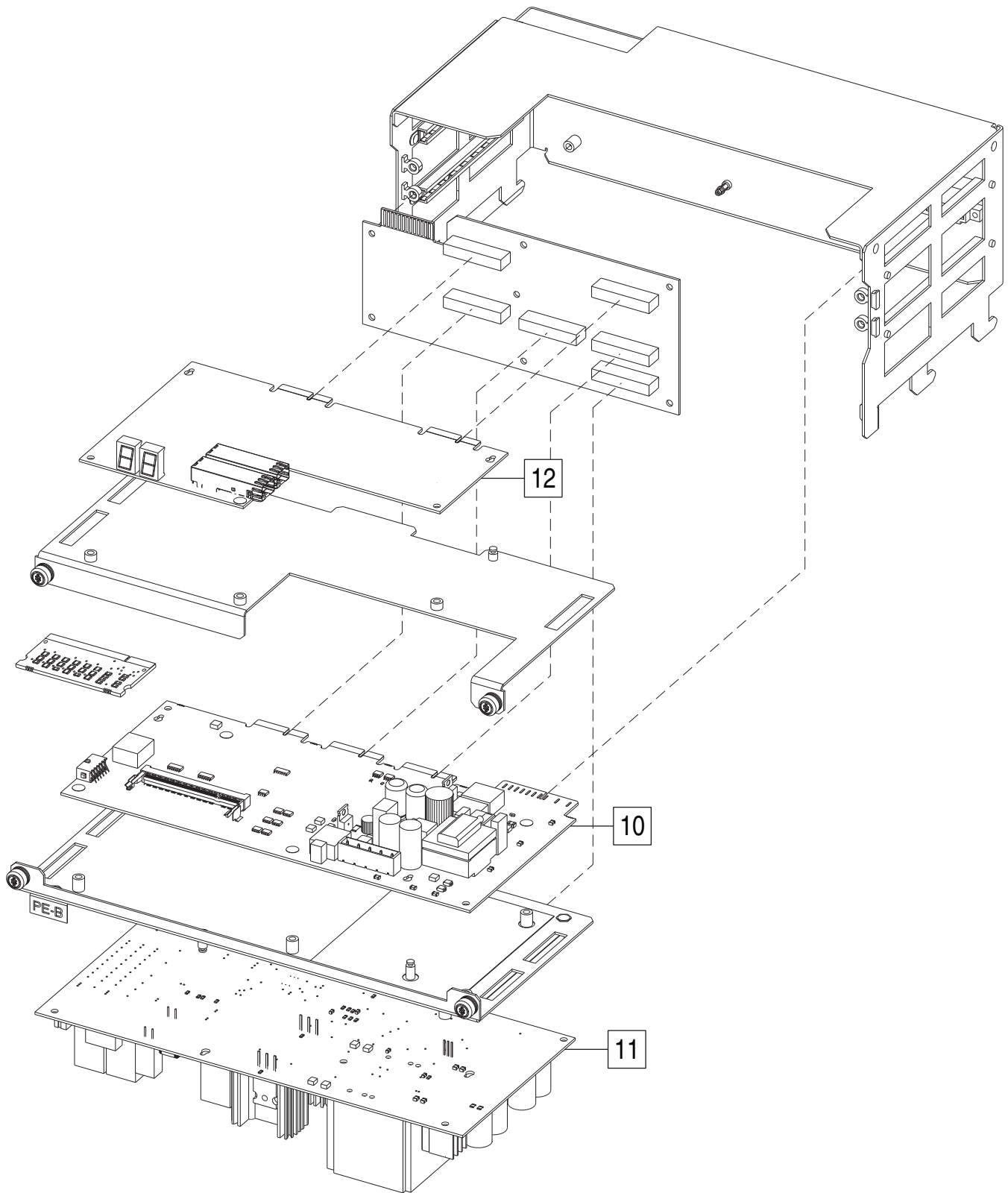


Figure 14 - Inverter Card Cage Assembly Components Diagram

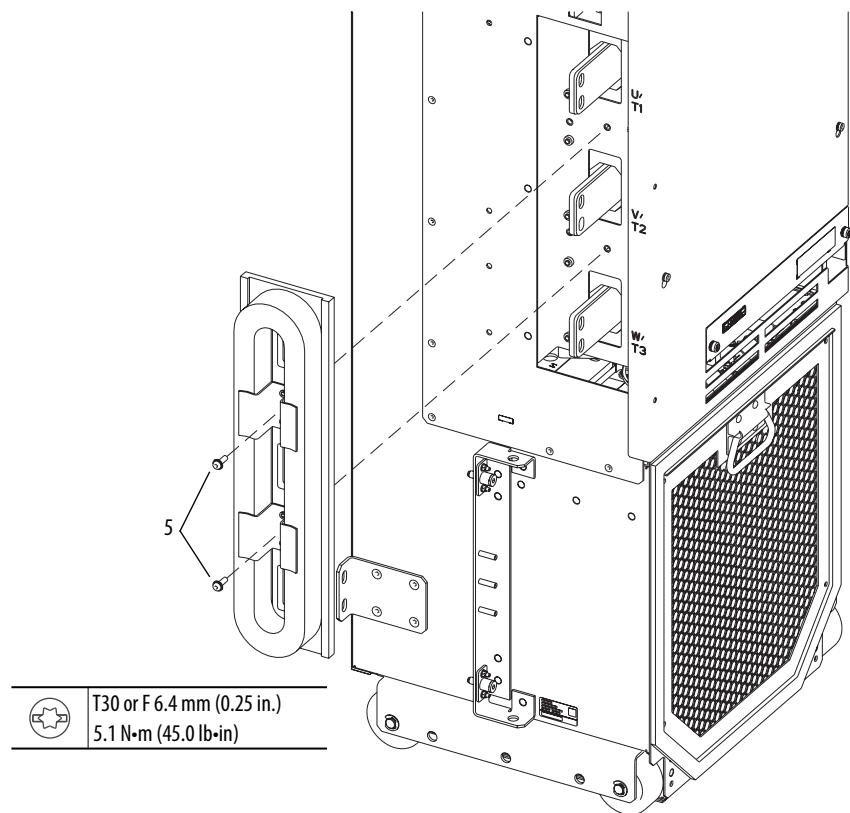


Common-mode Core Assembly Removal/Installation

Remove the Common Mode Core Assembly

Note: This assembly is installed in the field only.

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the inverter assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
5. Remove the two M6 x 25 mm screws that secure the common mode core assembly to the drive frame and slide the assembly off the AC output bus terminals.



Install the Common Mode Core Assembly

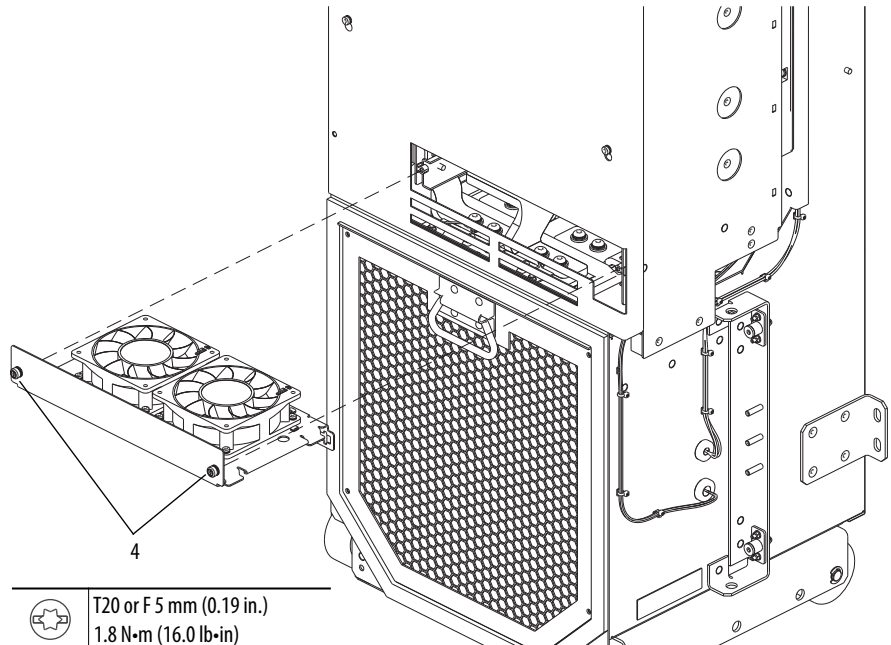
Install the common mode core assembly in the reverse order of removal. See Remove the Common Mode Core Assembly.

IMPORTANT Grounding and Power Jumper configuration must be appropriate for EMC applications. See "Drive Power Jumper Configuration" in the Powerflex 750-Series Installation Instructions (Publication [750-IN001](#)) for detailed information.

Internal Stirring Fan Tray Removal/Installation

Remove the Internal Stirring Fan Tray

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Loosen the two captive screws on the face of the fan tray and pull the tray straight out from the inverter frame.



Note: The inverter is shown removed from the drive enclosure only to clarify the instructions.

Install the Internal Stirring Fan Tray

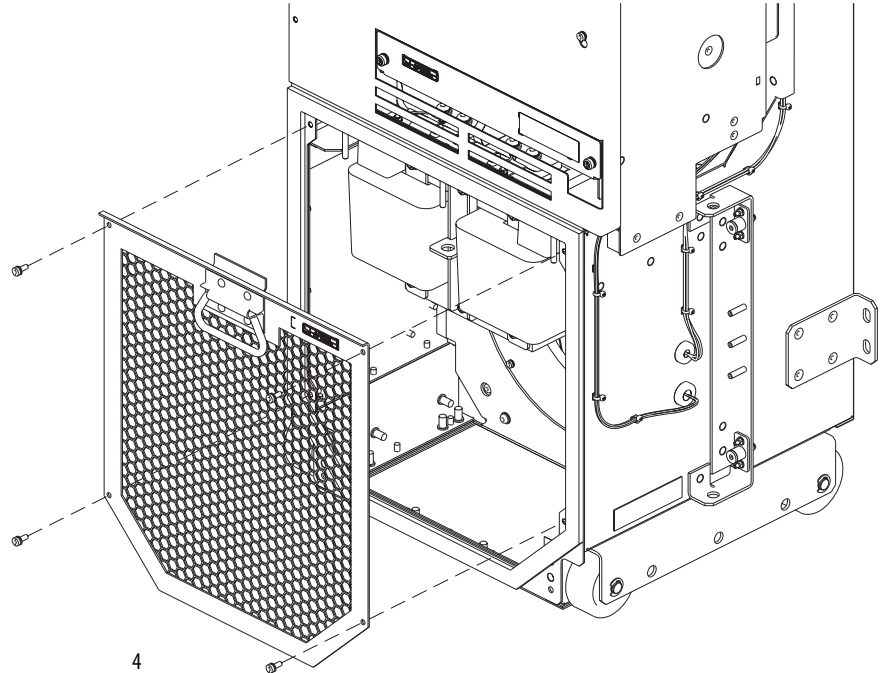
Install in the internal stirring fan tray in the reverse order of removal. See Remove the Internal Stirring Fan Tray.


IMPORTANT The power wire connector for the fans is at the right, rear of the fan mounting tray. Verify that the connector mates with the socket at the back of the enclosure when sliding the tray into the inverter frame.

Heatsink Fan Inlet Screen Removal/Installation

Remove the Heatsink Fan Inlet Screen

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the four M5 x 14 mm screws that secure the screen to the drive frame pull down and out on the bottom screen.



	T20 or F - 6.4 mm (0.25 in.) 2.8 N·m (25 lb·in)
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Note: The inverter is shown removed from the drive enclosure only to clarify the instructions.

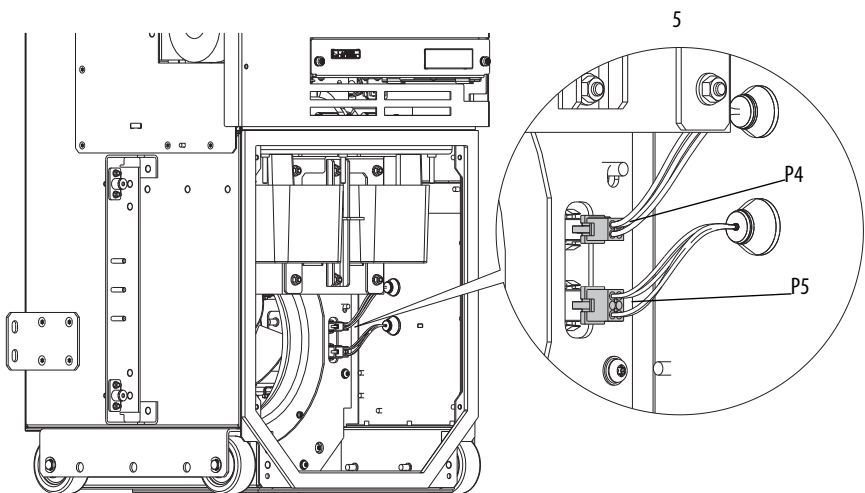
Install the Heatsink Fan Inlet Screen

Install the heatsink fan inlet screen in the reverse order of removal. See Remove the Heatsink Fan Assembly.

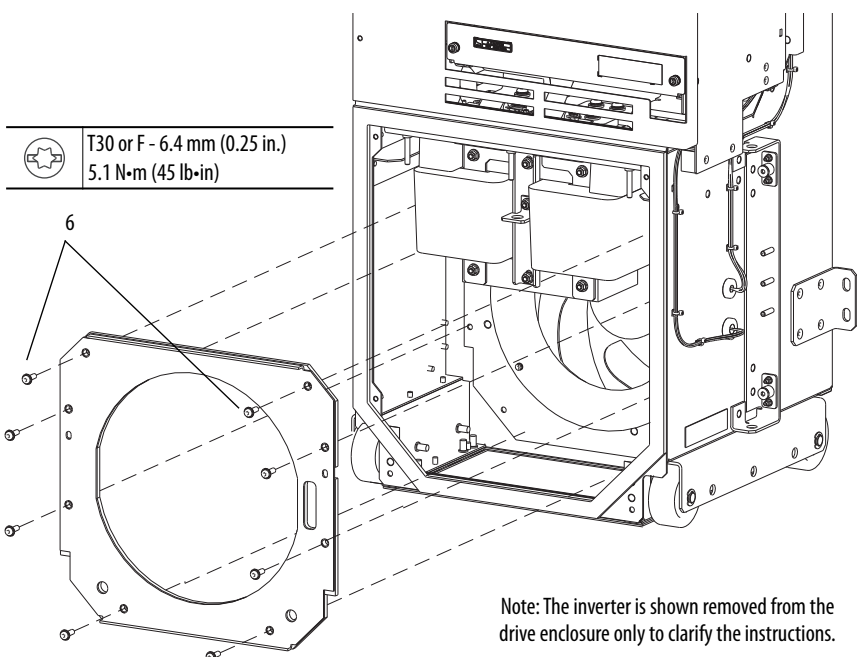
Heatsink Fan Assembly Removal/Installation

Remove the Heatsink Fan Assembly

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the heatsink fan inlet screen. See Remove the Heatsink Fan Inlet Screen on page [235](#).
5. Disconnect the control and power wire connectors P4 and P5 from the front, right side of the fan assembly.

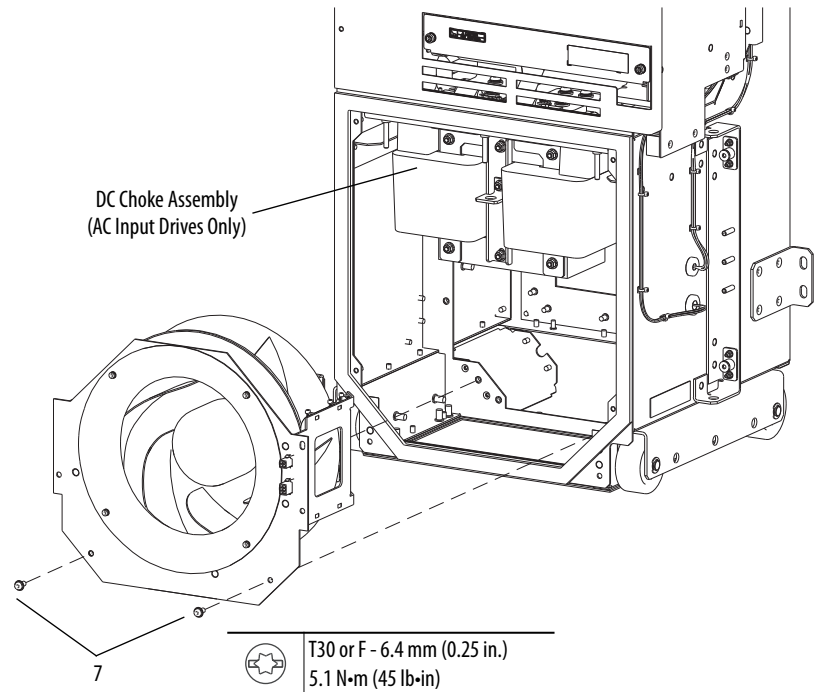


6. Remove the eight M6 x 20 mm screws that secure the inlet seal mounting plate to the chassis and remove the plate.



Note: The inverter is shown removed from the drive enclosure only to clarify the instructions.

7. Remove the two M6 x 20 mm screws from the fan assembly. The assembly rests on two guide pins on the back wall.
8. Remove the fan assembly:
 - a. By using both hands, pull the assembly slightly forward until it comes off the guide pins.
 - b. Pull the bottom of the assembly toward the front of the inverter chassis and tilt the top backward so it clears the DC choke assembly (if installed). Remove the assembly.



Install the Heatsink Fan Assembly

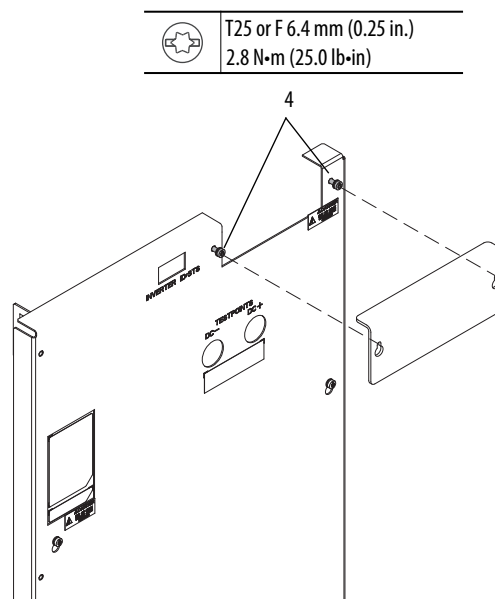
Install the heatsink fan assembly in the reverse order of removal. See Install the Heatsink Fan Assembly on page [237](#).

Inverter Circuit Board Connections Cover Removal/Installation

Remove the Inverter Circuit Board Connections Cover

This section only applies when the inverter cover has the inverter circuit board connections cover present.

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Loosen the two M5 x 14 mm screws that secure the clear cover to the inverter front cover and remove the cover.



Install the Inverter Circuit Board Connections Cover


Install the inverter circuit board connections cover in the reverse order of removal. See Remove the Inverter Circuit Board Connections Cover.

Inverter Front Cover Removal/Installation

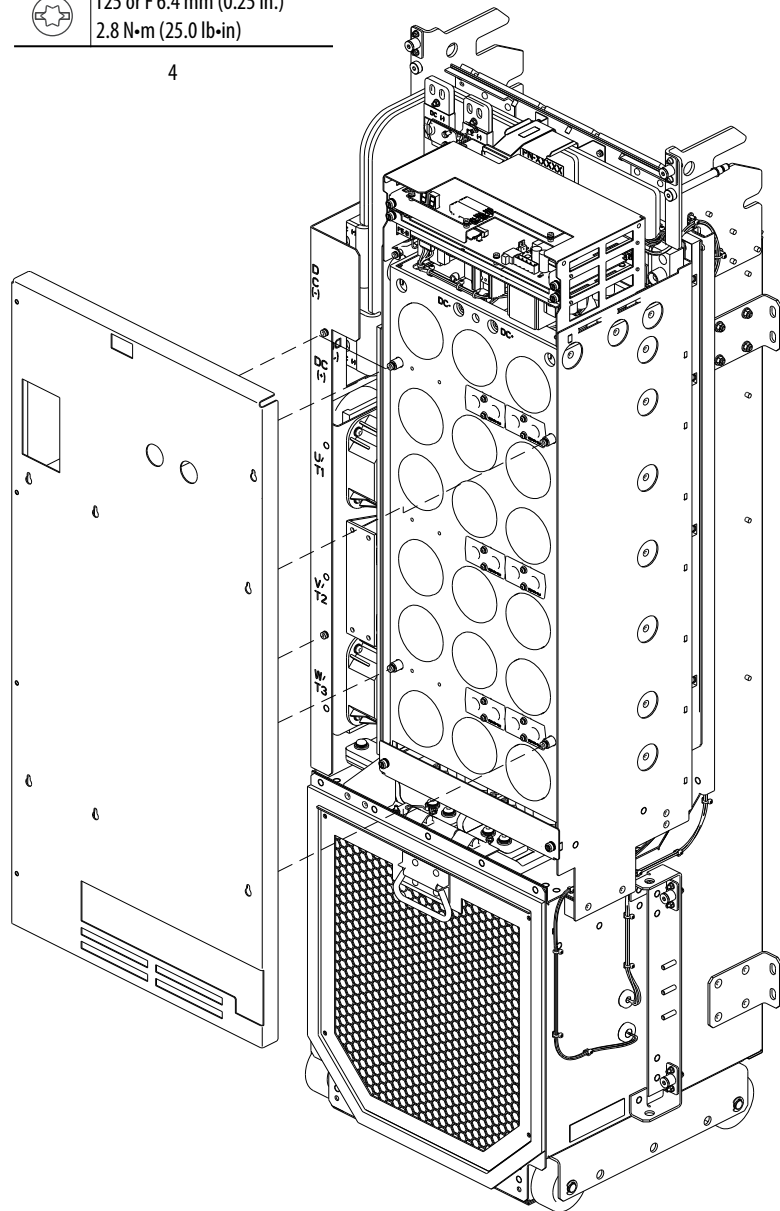
Remove the Inverter Front Cover

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Loosen the six M5 x 14 mm screws, raise the front cover vertically, and lift it off the screws.

Note: The inverter is shown removed from the drive enclosure only to clarify the instructions.

	T25 or F 6.4 mm (0.25 in.) 2.8 N·m (25.0 lb·in)
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4



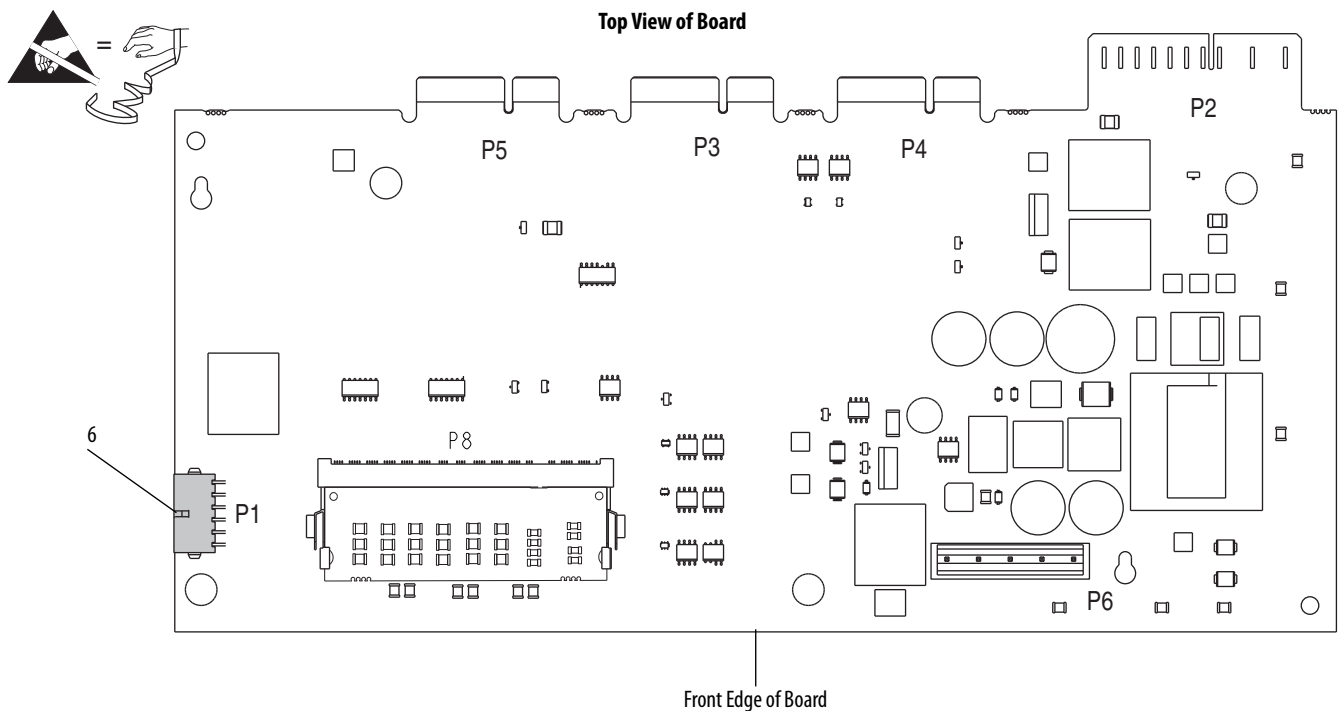
Install the Inverter Front Cover

Install the inverter front cover in the reverse order of removal. See Remove the Inverter Front Cover on page [239](#).

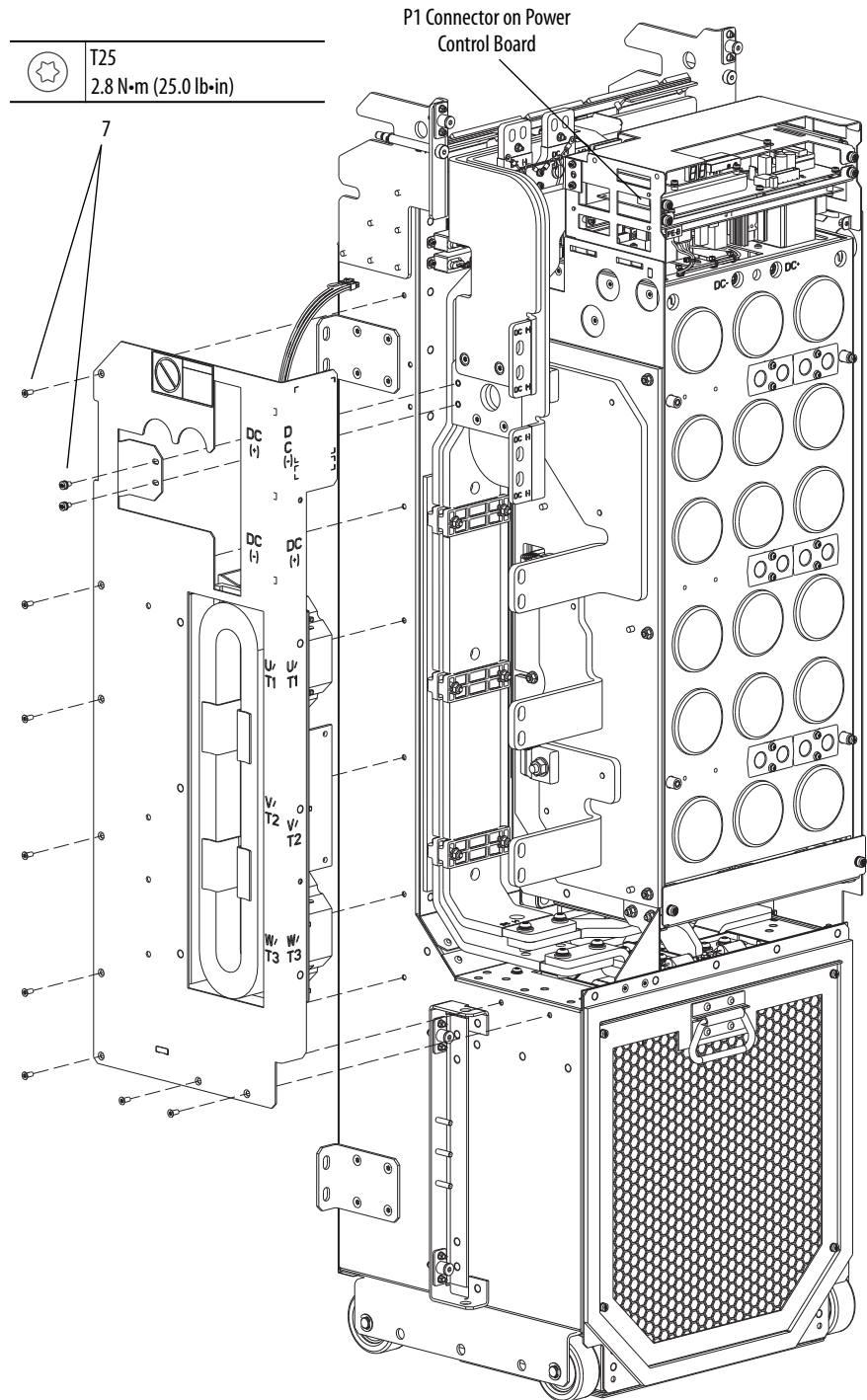
Inverter Current Sensors Removal/Installation

Remove the Inverter Current Sensors

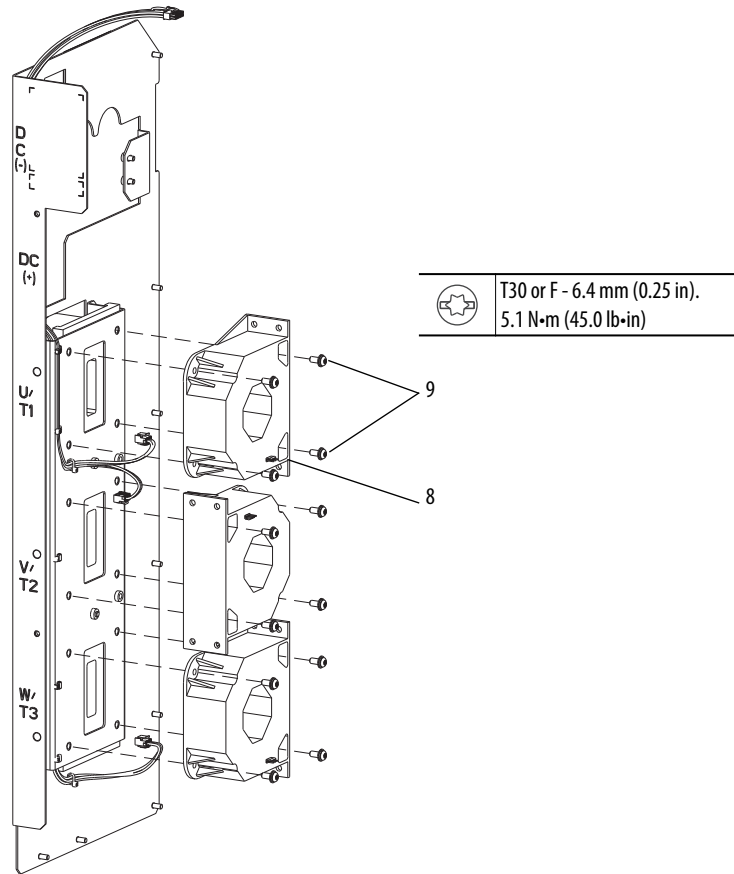
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the inverter assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
5. Remove the inverter front cover. See Remove the Inverter Front Cover on page [239](#).
6. Disengage the locking tabs and disconnect the wire connector from P1 on the power control board.



- Remove the eight M5 x 12 mm screws and the two M5 x 10 mm screws from the current sensor mounting panel on the left side of the inverter.



8. Disengage the locking tabs and disconnect the connector that is labeled U, V, or W attached to the current sensor and remove the current sensor.
9. Remove the four M6 x 14 mm screws that secure each of the current sensors to the mounting panel.



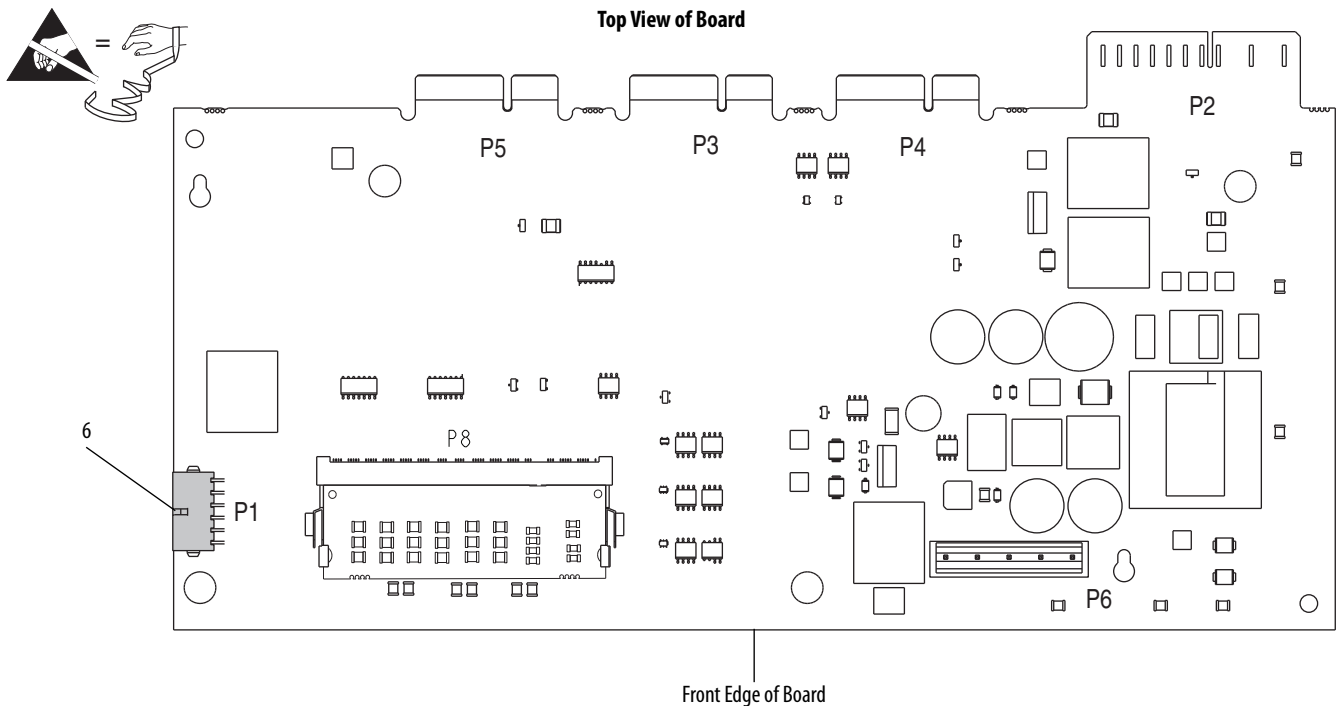
Install the Inverter Current Sensors

Install the inverter current sensor in the reverse order of removal. See Remove the Inverter Current Sensors on page [240](#).

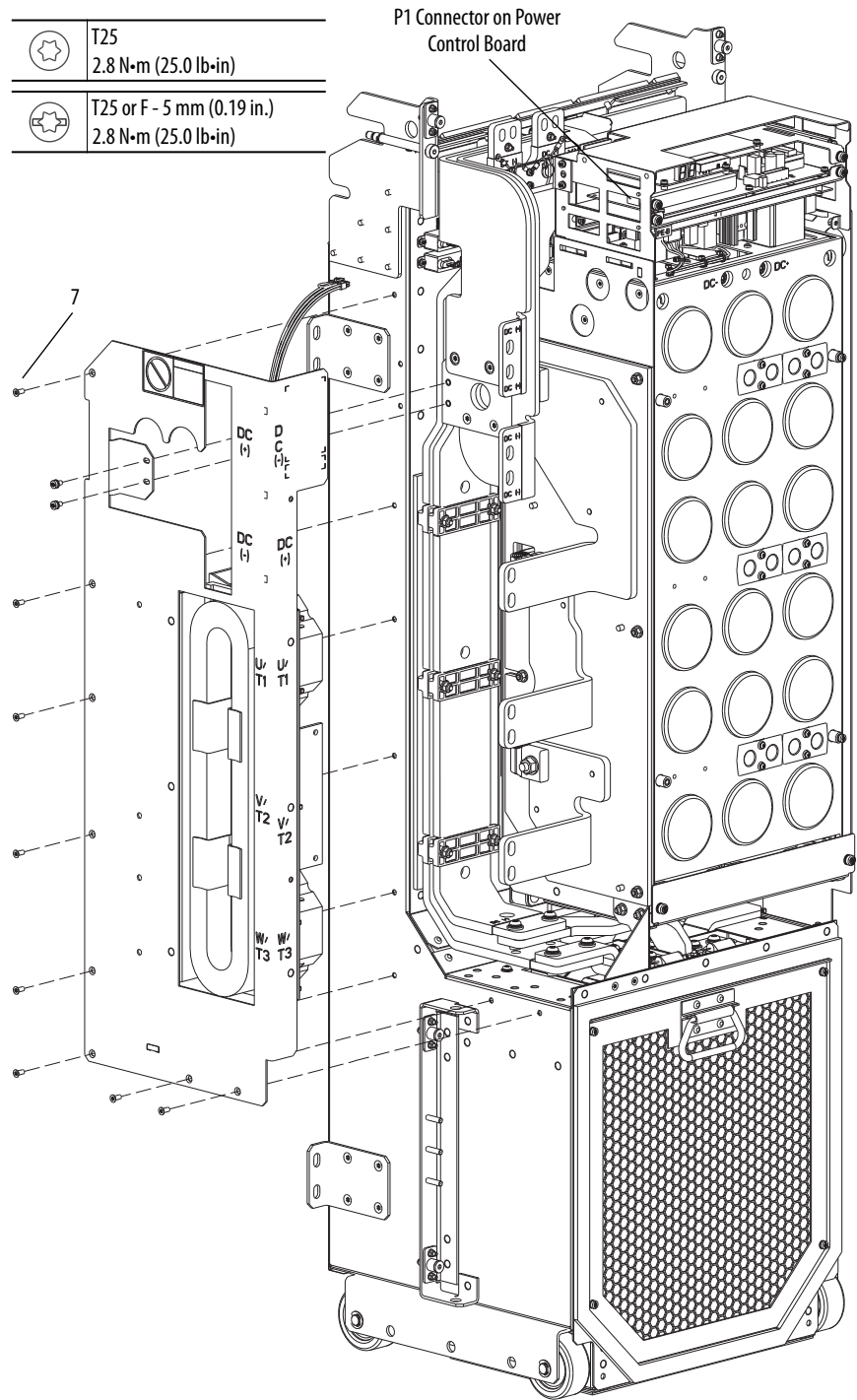
Inverter Current Sensor Wire Harness Removal/Installation

Remove the Inverter Current Sensor Wire Harness

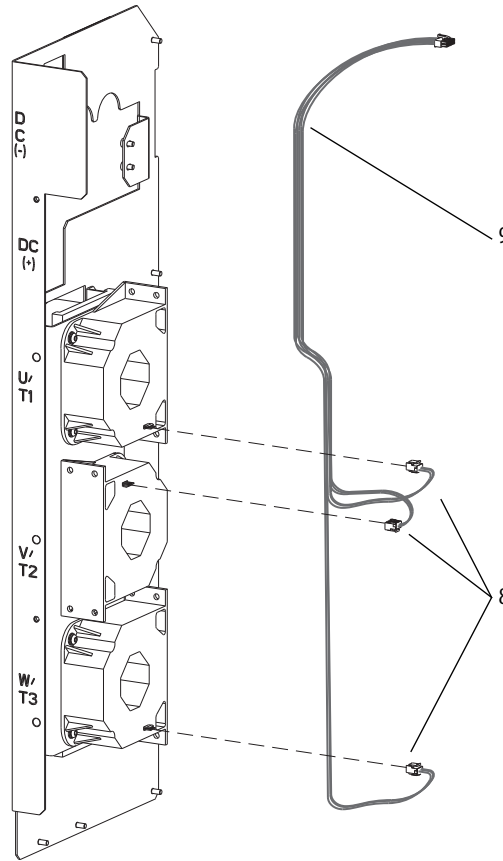
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the inverter assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
5. Remove the inverter front cover. See Remove the Inverter Front Cover on page [239](#).
6. Disengage the locking tabs and disconnect the wire connector from P1 on the power control board.



- Remove the eight M5 x 12 mm screws and the two M5 x 10 mm screws from the current sensor mounting panel on the left side of the inverter.



8. Disengage the locking tabs and disconnect the connector that is labeled U, V, or W attached to the current sensor and remove the current sensor.
9. Cut all wire ties from the tie locations and remove the harness.



Install the Inverter Current Sensor Wire Harness

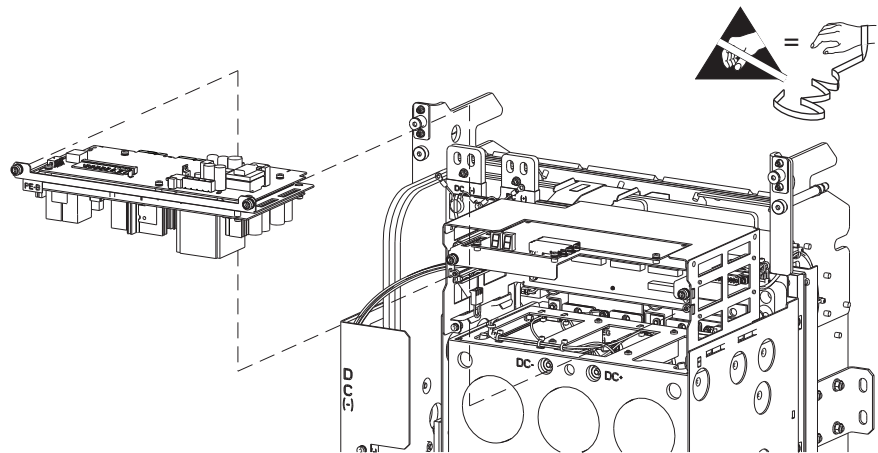
Install the inverter current-sensor wire harness in the reverse order of removal. See Remove the Inverter Current Sensor Wire Harness on page Remove the Inverter Current Sensor Wire Harness.

Inverter Capacitor Bank Assembly Removal/Installation

Remove the Inverter Capacitor Bank Assembly

IMPORTANT A load capacity of 80 kg (175 lb) minimum is required for all lifting equipment and hardware that is used for this procedure.

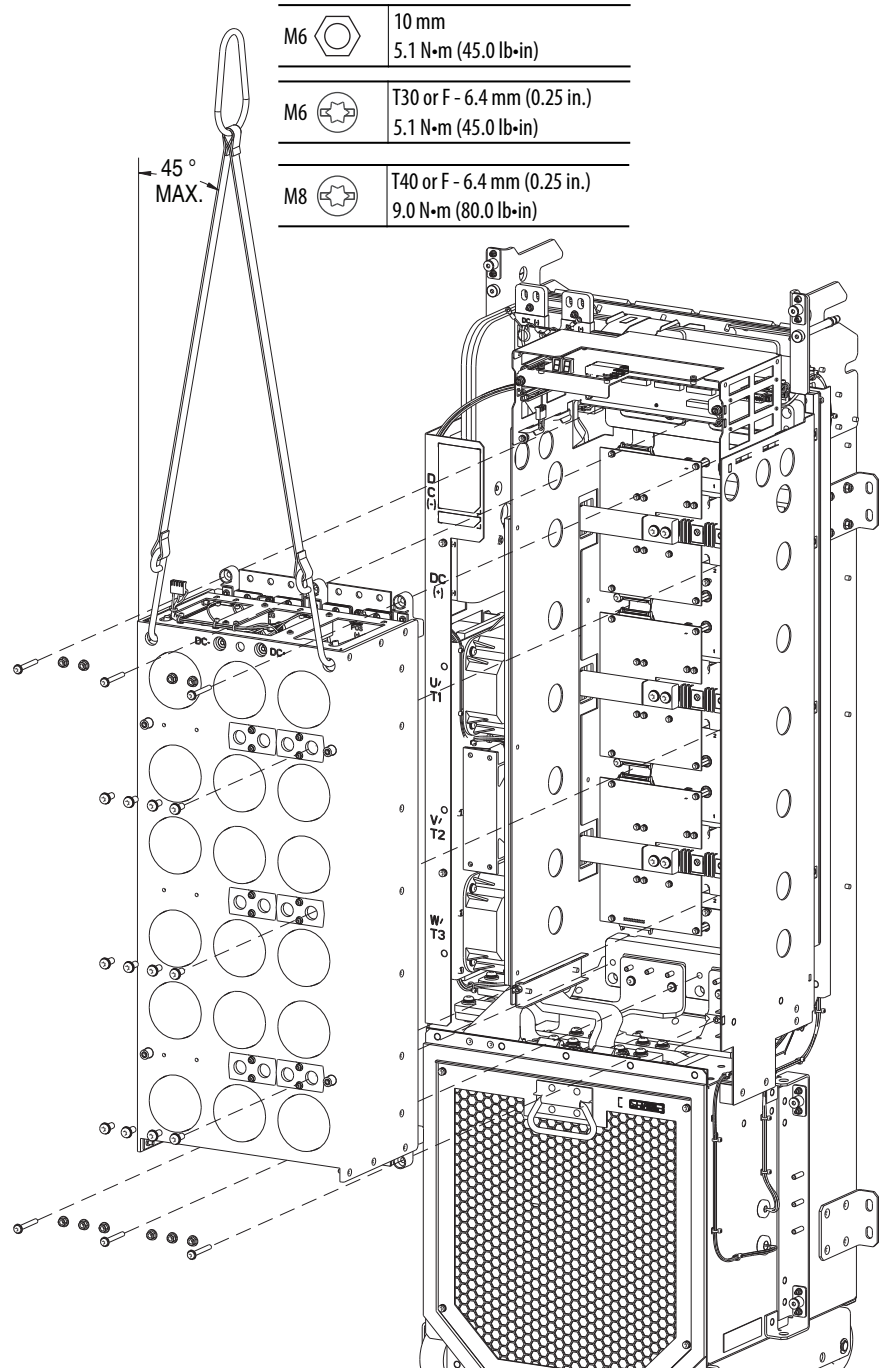
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the internal stirring fan tray. See Remove the Internal Stirring Fan Tray on page [234](#).
5. Remove the inverter front cover. See Remove the Inverter Front Cover on page [239](#).
6. Remove the lower tray in the card cage that contains the power control and power supply circuit boards and store it in a dry, electrically protected, static-free location. See Remove the Power Control Circuit Board on page [262](#). Note, it is not necessary to remove the power control board from the tray for this procedure.



Note: The inverter is shown removed from the drive enclosure only to clarify the instructions.

IMPORTANT Verify that the angle of attachment of the lifting hardware is no more than 45° from vertical.

7. Connect the lifting hardware to the two lifting holes on the front of the capacitor bank assembly.
8. Remove the 12 M6 hex nuts and washers from the bus connection tabs at the top and bottom of the capacitor bank assembly.
9. Remove the six or 12 M8 x 20 mm IGBT connection screws from the capacitor bank assembly. Use lifting equipment to pull the assembly forward and out of the inverter.
10. Remove the six M6 x 50 mm screws (three at the top, three at the bottom), from the capacitor bank assembly.



Install the Inverter Capacitor Bank

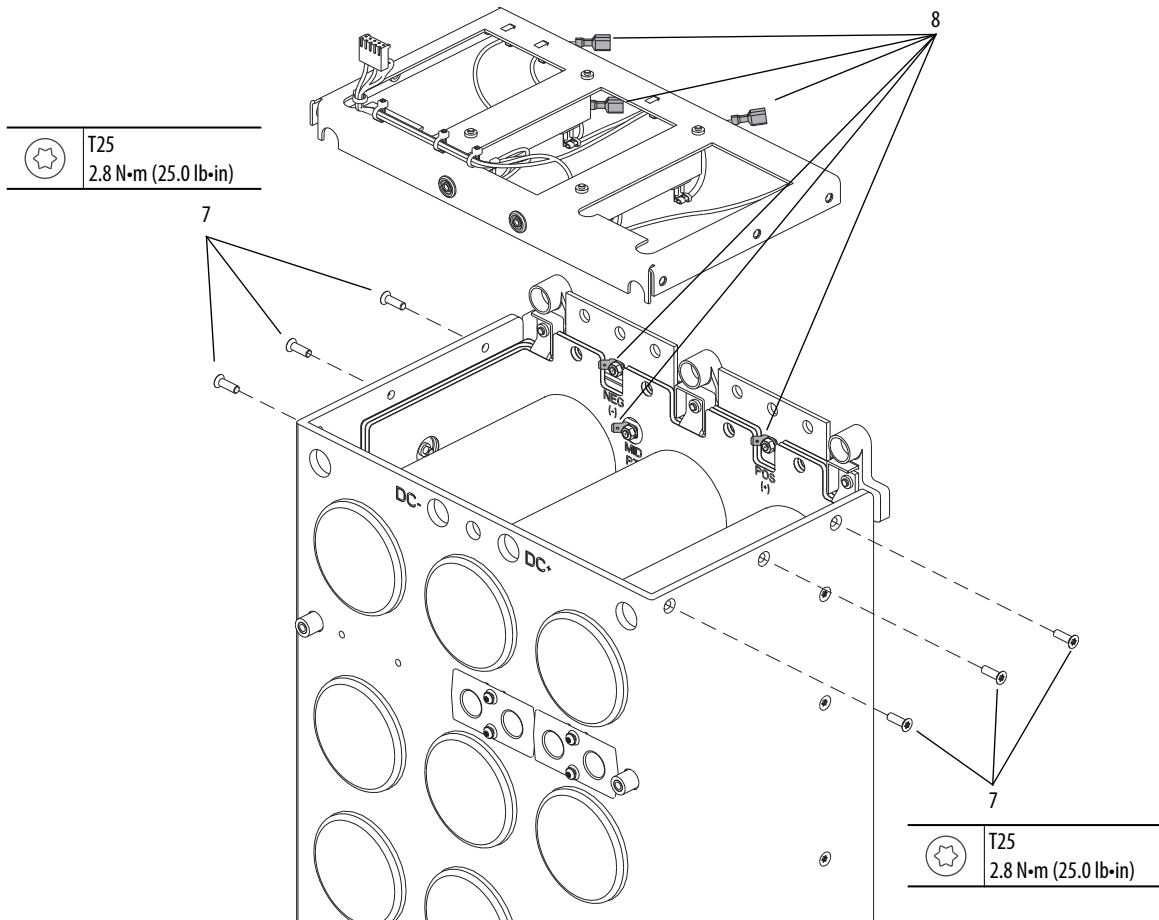
Install in the reverse order of removal. See Remove the Inverter Capacitor Bank Assembly on page [246](#).

Capacitor Balance Resistor Assembly Removal/Installation

Remove the Capacitor Balance Resistor Assembly

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the internal stirring fan tray. See Remove the Internal Stirring Fan Tray on page [234](#).
5. Remove the inverter front cover. See Remove the Inverter Front Cover on page [239](#).
6. Remove the capacitor bank. See Remove the Inverter Capacitor Bank Assembly on page [246](#).

7. Remove the six M5 x 16 mm screws from the sides of the capacitor balance resistor mounting tray.
8. Disconnect the POS, NEG, and MIDP wire connections from the three faston terminals on the capacitor bank assembly.
9. Slide the capacitor balance resistor mounting tray up and out of the capacitor bank assembly.



Install the Capacitor Balance Resistors

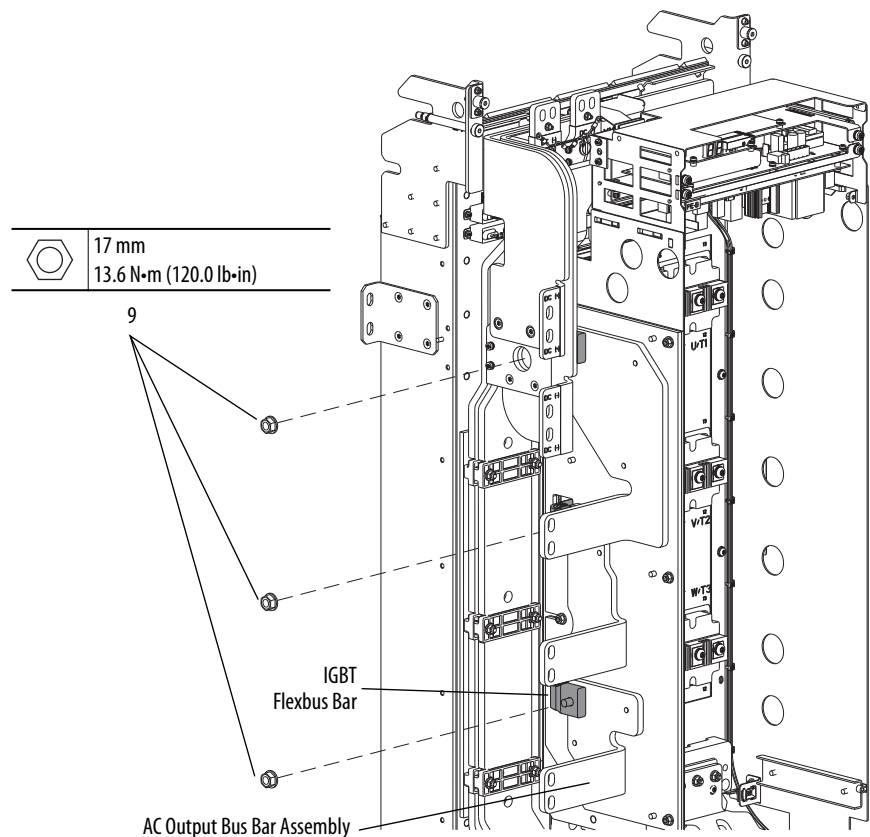
Install the capacitor balance resistors (on mounting tray) in the reverse order of removal. See Remove the Capacitor Balance Resistor Assembly on page [248](#).

IGBT Flexbus Bars Removal/ Installation

Remove the IGBT Flexbus Bars

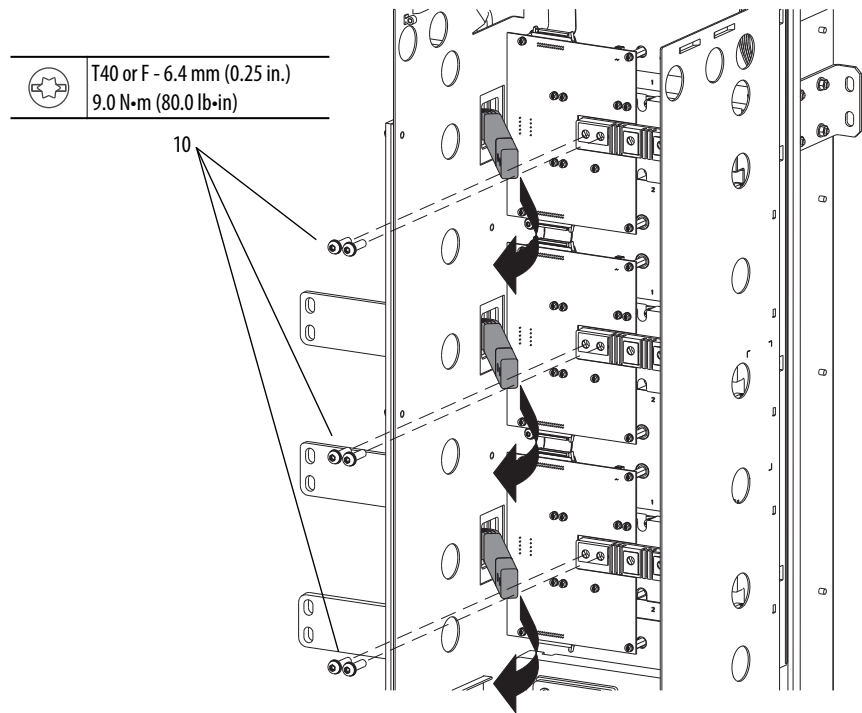
Note: This assembly is installed in the field only.

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the inverter assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
5. Remove the internal stirring fan tray. See Remove the Internal Stirring Fan Tray on page [234](#).
6. Remove the inverter front cover. See Remove the Inverter Front Cover on page [239](#).
7. Remove the current sensor mounting panel. See Remove the Inverter Current Sensors on page [240](#).
8. Remove the capacitor bank. See Remove the Inverter Capacitor Bank Assembly on page [246](#).
9. Remove the M10 hex nut that secures each IGBT Flexbus bar to the AC output bus bar assembly.



10. Remove the two M8 x 30 mm screws that secure each IGBT Flexbus bar to the IGBT connections.
11. Slide each of the IGBT Flexbus bars out of the front of the inverter.

IMPORTANT Remove the IGBT Flexbus bars carefully, so as not to damage the inverter gate boards.



Install the IGBT Flexbus Bars

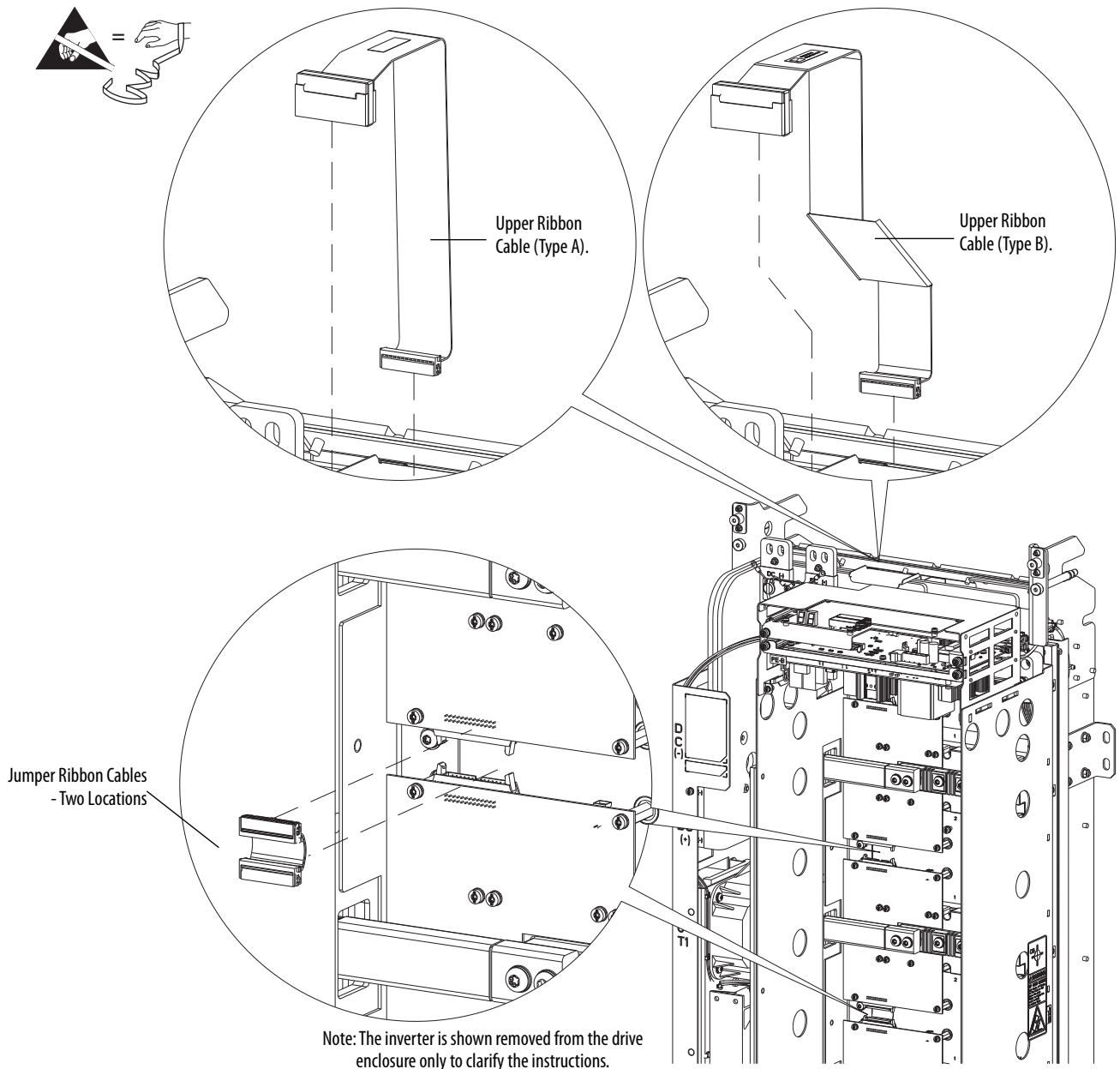
Install the IGBT Flexbus bars in the reverse order of removal. See Remove the IGBT Flexbus Bars on page [250](#).

Inverter Gate Board Connection Ribbon Cables Removal/Installation

Remove the Inverter Gate Board Connection Ribbon Cables

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the internal stirring fan tray. See Remove the Internal Stirring Fan Tray on page [234](#).
5. Remove the inverter front cover. See Remove the Inverter Front Cover on page [239](#).

6. Remove the capacitor bank. See Remove the Inverter Capacitor Bank Assembly on page 246.
7. Disengage the locking tabs and disconnect each end of the jumper ribbon cable from the inverter gate board and remove the ribbon cable.
8. Disengage the locking tabs and disconnect one end of the upper ribbon cable from the gate board and disconnect the opposite end of the ribbon cable from the backplane in the card cage. Remove the upper ribbon cable by pulling it vertically out of the top of the inverter.



Install the Inverter Gate Board Connection Ribbon Cables

Install the inverter gate board connection ribbon cables in the reverse order of removal. See Remove the Inverter Gate Board Connection Ribbon Cables on page [251](#).

- The gate board connection ribbon cables kit contains one each of the straight (type A) and folded (type B) upper ribbon cables. Only use the cable in the kit that matches that cable type that you have removed from the drive. Use the following drive sizing information for verification of the appropriate cable type to use with your drive.

Table 14 - Gate Board Upper Ribbon Cable Type

Upper Ribbon Cable Type	Drive Cat. No. Pos. 7	and	Drive Cat. No. Pos. 8...10
A (straight)	C		460, 540, or 567
	D		430, 485, or 545
B (folded)	C		650, 750, or 770
	D		617, 710, or 740


Inverter Gate Circuit Board Removal/Installation

Remove the Inverter Gate Circuit Board

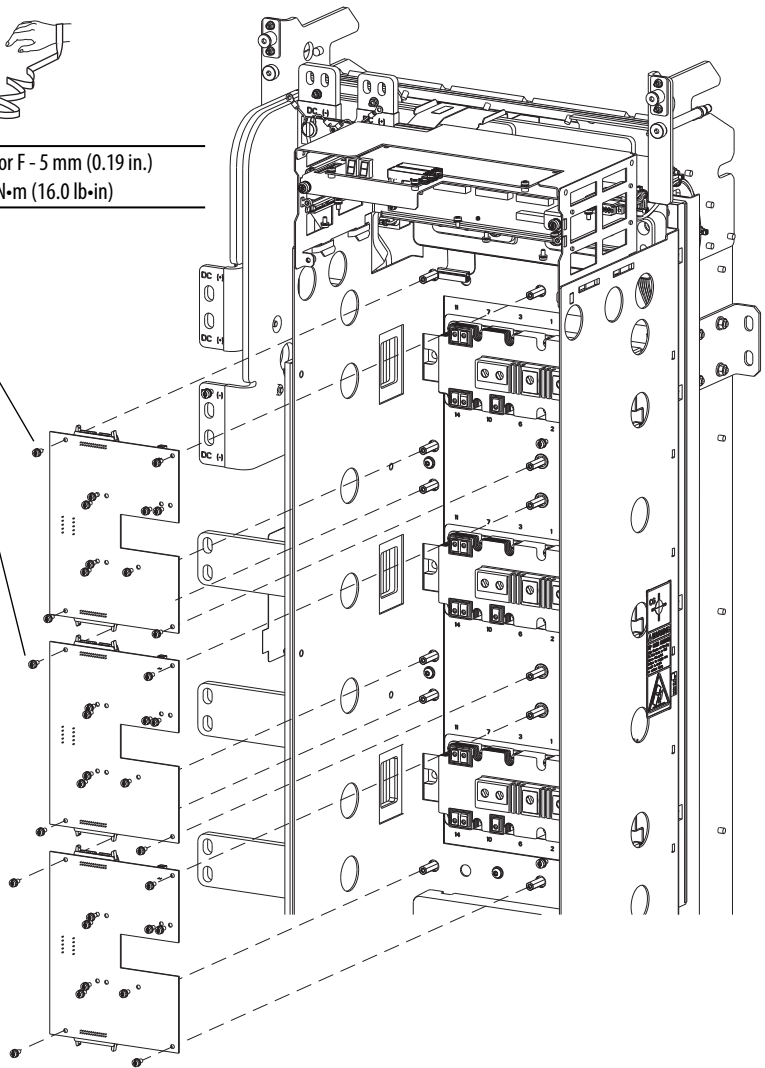
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the inverter assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
5. Remove the internal stirring fan tray. See Remove the Internal Stirring Fan Tray on page [234](#).
6. Remove the inverter front cover. See Remove the Inverter Front Cover on page [239](#).
7. Remove the current sensor mounting panel. See Remove the Inverter Current Sensors on page [240](#).
8. Remove the capacitor bank. See Remove the Inverter Capacitor Bank Assembly on page [246](#).
9. Remove the IGBT Flexbus bars. See Remove the IGBT Flexbus Bars on page [250](#).
10. Remove the inverter ribbon cables. See Remove the Inverter Gate Board Connection Ribbon Cables on page [251](#).
11. Remove the seven M4 x 10 mm screws that secure the gate board to the IGBT (E1, E2, G1, G2, C1, NTC1, NTC2 connections).

12. Remove the four M4 x 10 mm screws that secure the gate board to the standoffs and remove the board.



	T20 or F - 5 mm (0.19 in.) 1.8 N•m (16.0 lb•in)
---	--

12



Install the Inverter Gate Circuit Board

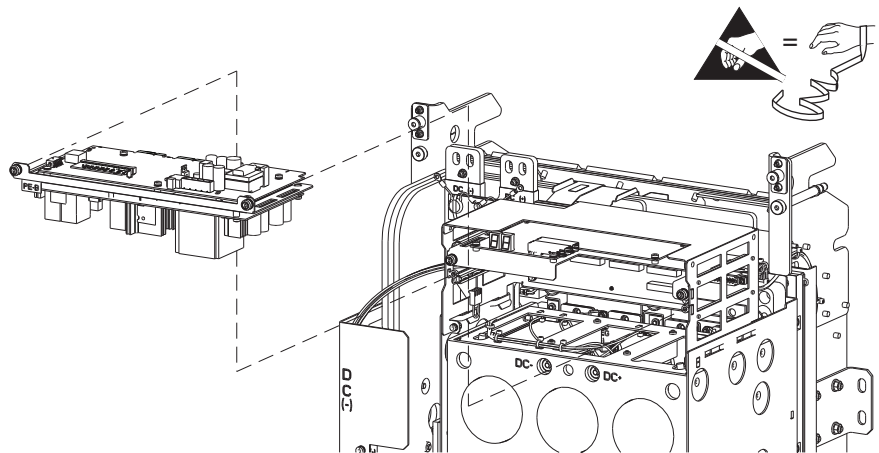
Install the inverter gate board in the reverse order of removal. See Remove the Inverter Gate Circuit Board on page [253](#).

Rating Plug Removal/ Installation

Remove the Rating Plug

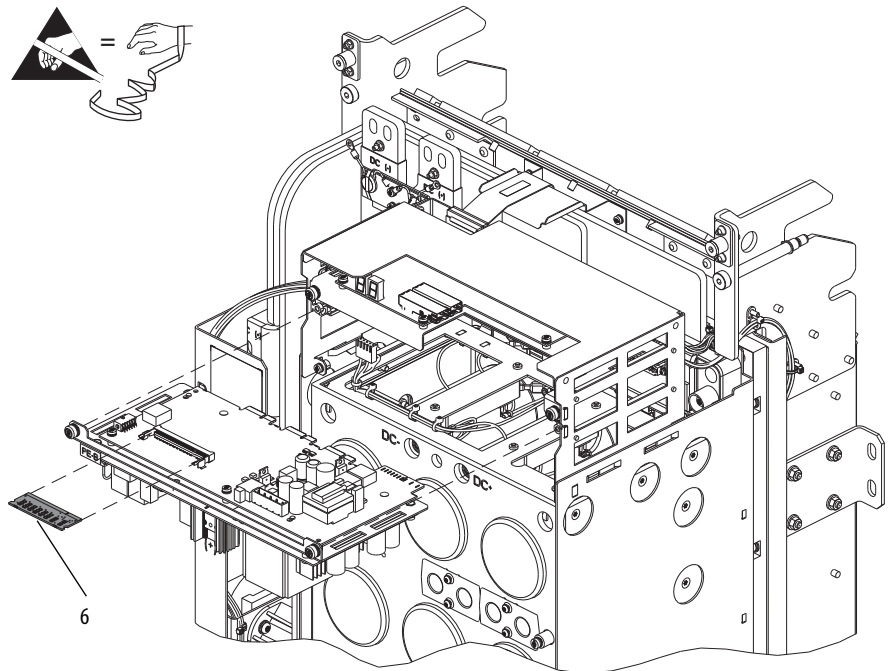
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the inverter front cover. See Remove the Inverter Front Cover on page [239](#).
5. Remove the lower tray in the card cage that contains the power control and power supply circuit boards and store it in a dry, electrically protected, static-free location. See Remove the Power Control Circuit Board on page [262](#). Note, it is not necessary to remove the power control board from the tray for this procedure.

IMPORTANT The program that is embedded in the backplane board determines the inverter rating, the rating plug must be compatible with the programmed value.



Note: The inverter is shown removed from the drive enclosure only to clarify the instructions.

6. Unlatch the two metal clips that secure the rating plug in the slot, tilt slightly upward, and gently pull forward to remove the plug.



Note: The inverter is shown removed from the drive enclosure only to clarify the instructions.

Install the Rating Plug

Install the rating plug in the reverse order of removal. See Remove the Rating Plug on page [255](#).

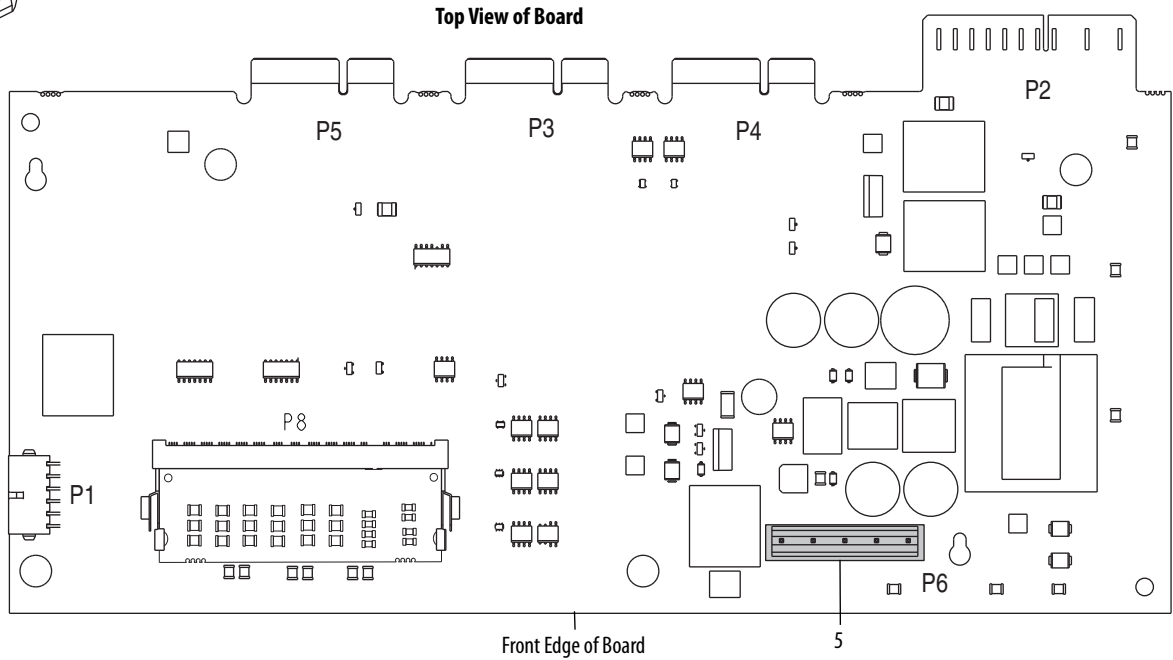
Power Layer Interface Circuit Board Removal/Installation

Remove the Power-layer Interface Circuit Board

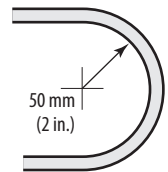
IMPORTANT Determine if the existing inverter power-layer interface board is series A or series B, and verify that you have ordered/received a compatible board before replacement. See Drive Series Components Compatibility on page [30](#) for details.

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the inverter front cover. See Remove the Inverter Front Cover on page [239](#).

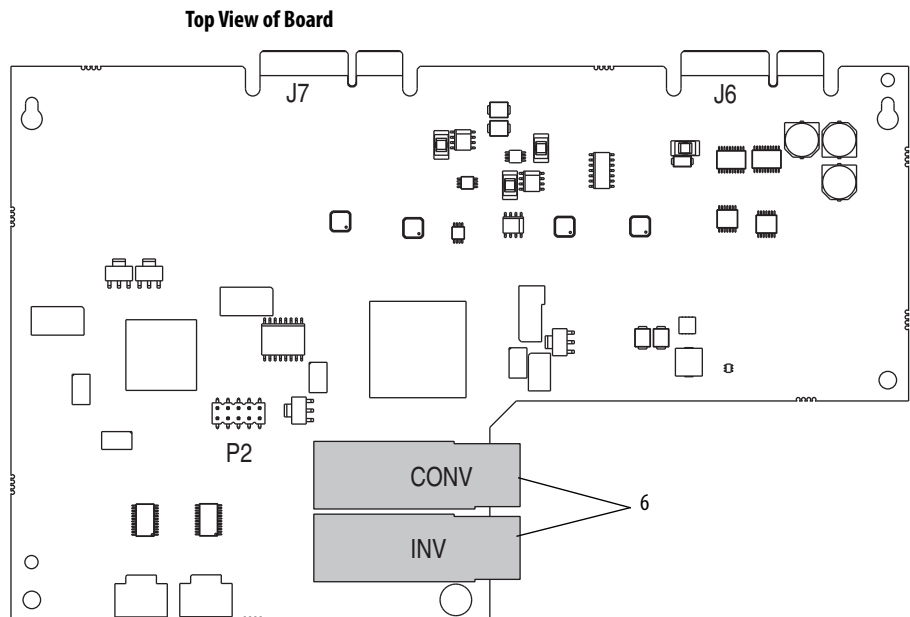
5. Disconnect the terminal block from P6 on the power control board.




IMPORTANT Minimum inside bend radius for fiber-optic cable is 50 mm (2 in.). Any bends with a shorter inside radius can permanently damage the fiber-optic cable. Signal attenuation increases with decreased inside bend radii.

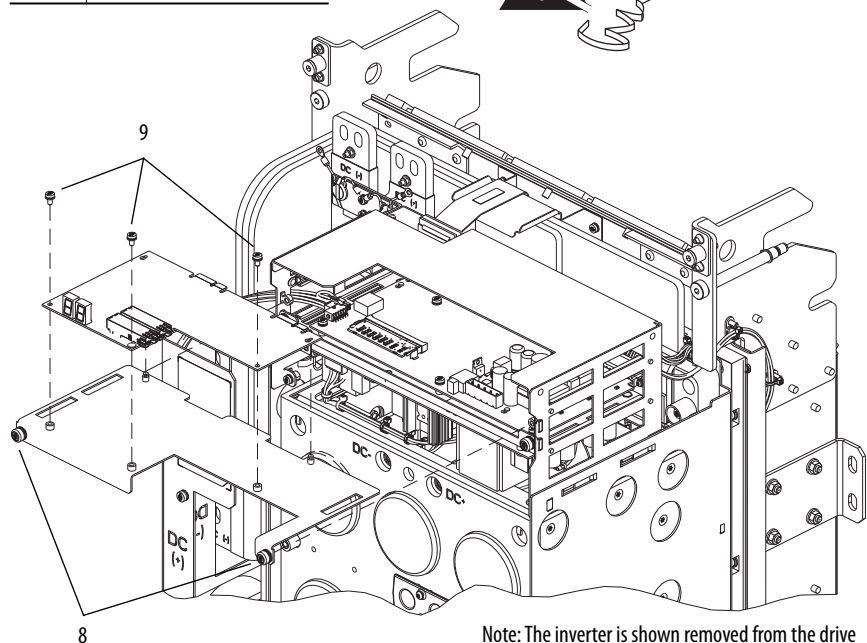


6. Disconnect the fiber-optic cables from CONV and INV on the power layer interface board.



7. From the INV and CONV fiber-optic cages on the power layer interface board, remove each fiber-optic transceiver by pulling its wire latch. Set the transceivers aside and save for reinstallation.
8. Fully loosen the two captive screws on the face of the top tray in the card cage, pull forward, and remove the tray. Note, the right front corner of the power layer interface board may not clear the card cage frame. Lift the tray up to clear the card cage.
9. Remove the three M4 x 8 mm screws that secure the power layer interface board to the tray, push the board slightly back and then up to remove it from the two keyhole standoffs on the tray.

	T20 or F - 5 mm (0.19 in.) 1.8 N•m (16.0 lb•in)
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Note: The inverter is shown removed from the drive enclosure only to clarify the instructions.

Install the Power-layer Interface Circuit Board

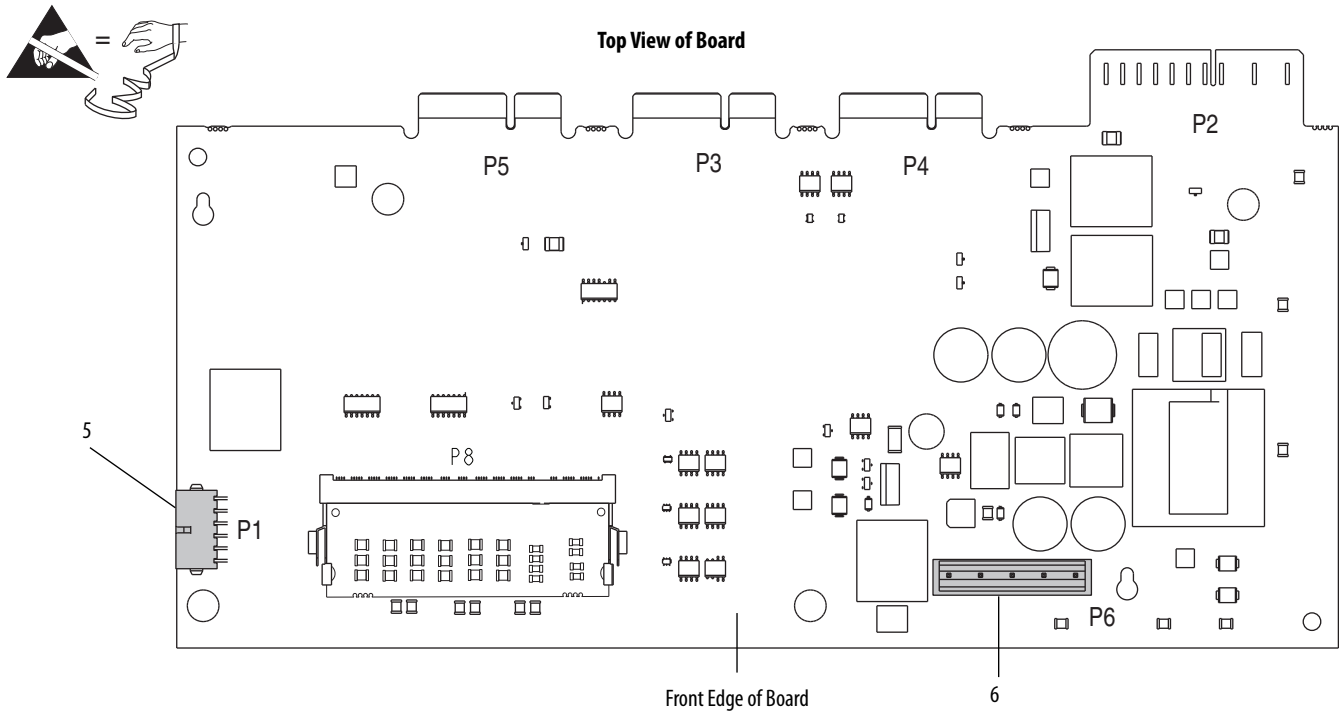
Install the power layer interface board in the reverse order of removal. See Remove the Power-layer Interface Circuit Board on page [256](#).

Power Supply Circuit Board Removal/Installation

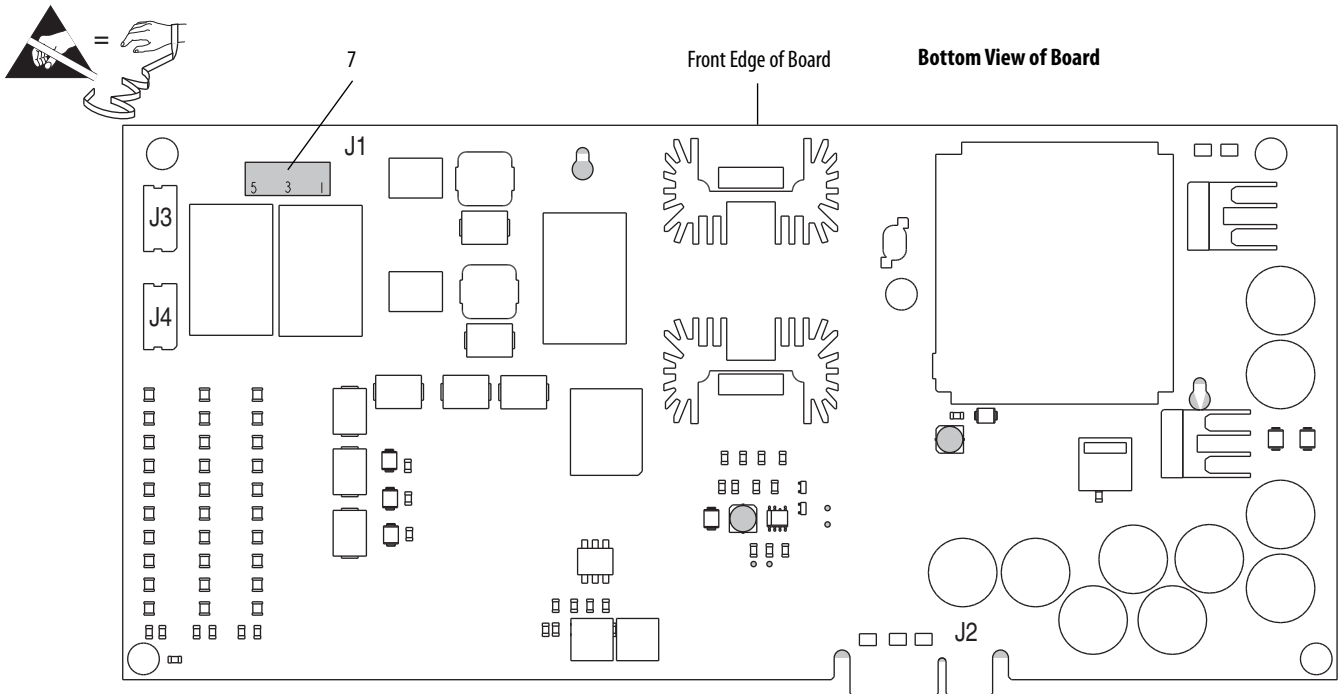
Remove the Power Supply Circuit Board

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.

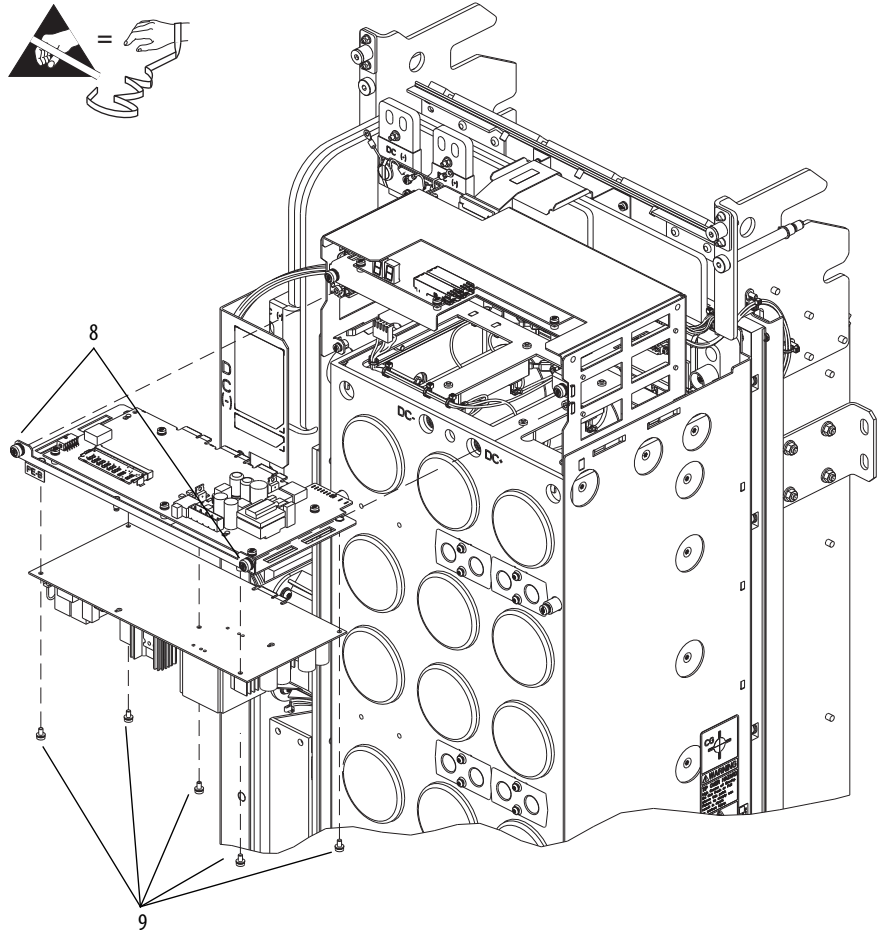
4. Remove the inverter front cover. See Remove the Inverter Front Cover on page [239](#).
5. Disengage the locking tabs and disconnect the wire connector from P1 on the power control board.
6. Disconnect the terminal block from P6 on the power control board.




7. Disengage the locking tabs and disconnect the wire connector from J1 on the power supply board.



8. Fully loosen the two captive screws on the face of the bottom tray in the card cage and pull the tray out of the cage.
9. Remove the five M4 x 8 mm screws that secure the power supply board to the tray, pull the board slightly forward and then down to remove it from the two keyhole standoffs on the tray.



	T20 or F - 5 mm (0.19 in.)
	1.8 N·m (16.0 lb·in)

Note: The inverter is shown removed from the drive enclosure only to clarify the instructions.

Install the Power Supply Circuit Board

Install the power supply board in the reverse order of removal. See Remove the Power Supply Circuit Board on page [258](#).

Power Control Circuit Board Removal/Installation

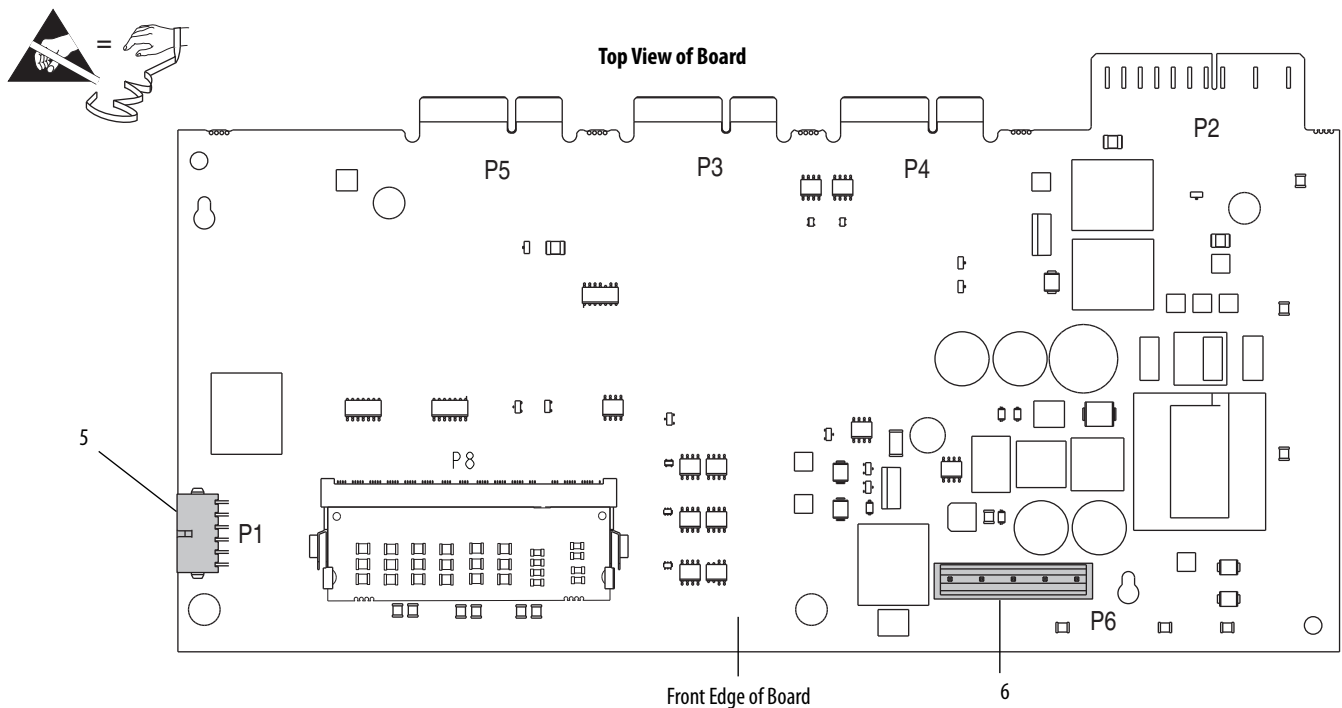
Remove the Power Control Circuit Board

TIP During removal, keep the rating plug. It is needed for proper installation of the replacement board.

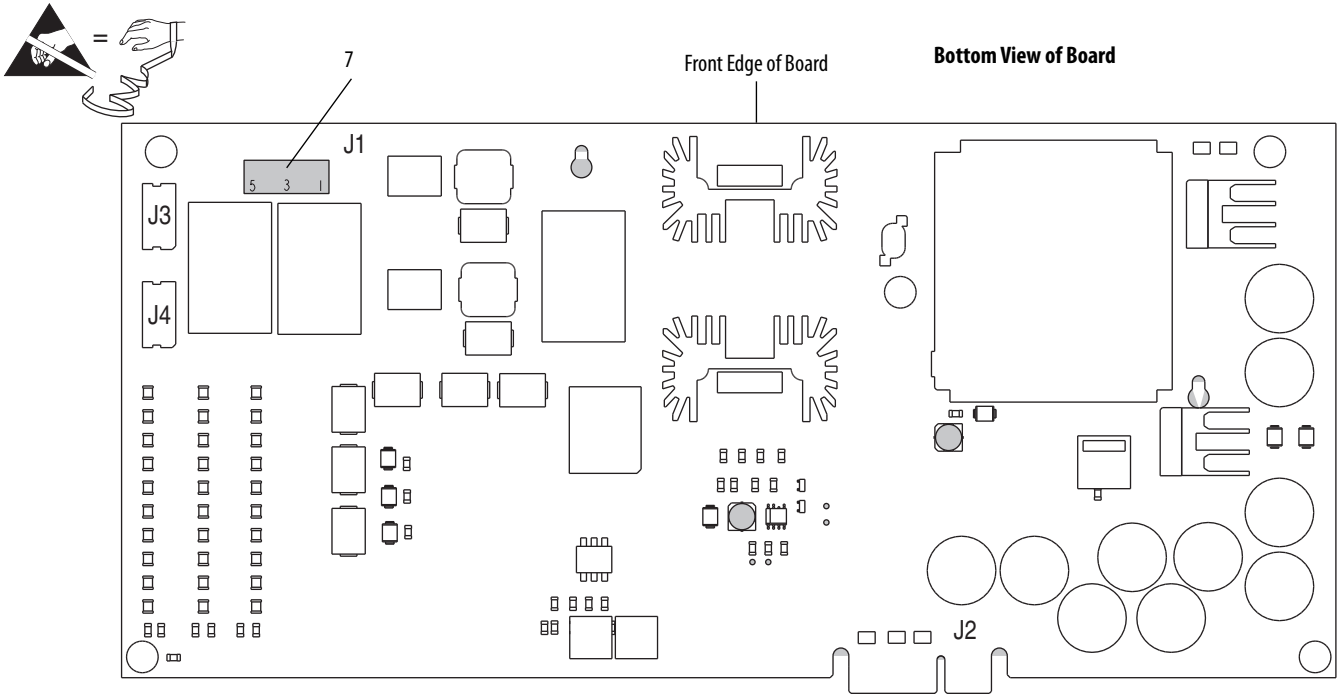
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the inverter front cover. See Remove the Inverter Front Cover on page [239](#).
5. Disengage the locking tabs and disconnect the wire connector from P1 on the power control board.

TIP During installation mate P1 to J1.

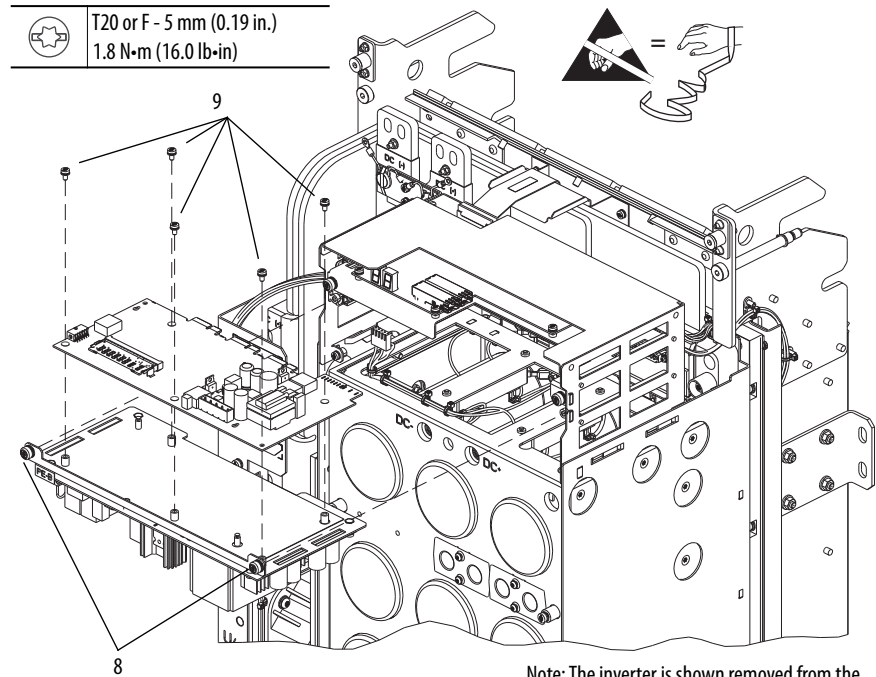
6. Disconnect the terminal block from P6 on the power control board.



- Disengage the locking tabs and disconnect the wire connector from J1 on the power supply board.



8. Fully loosen the two captive screws on the face of the bottom tray in the card cage and pull the tray out of the cage.
9. Remove the five M4 x 8 mm screws that secure the power control board to the tray, pull the board slightly back and then up to remove it from the two keyhole standoffs on the tray.



Note: The inverter is shown removed from the drive enclosure only to clarify the instructions.

Install the Power Control Circuit Board

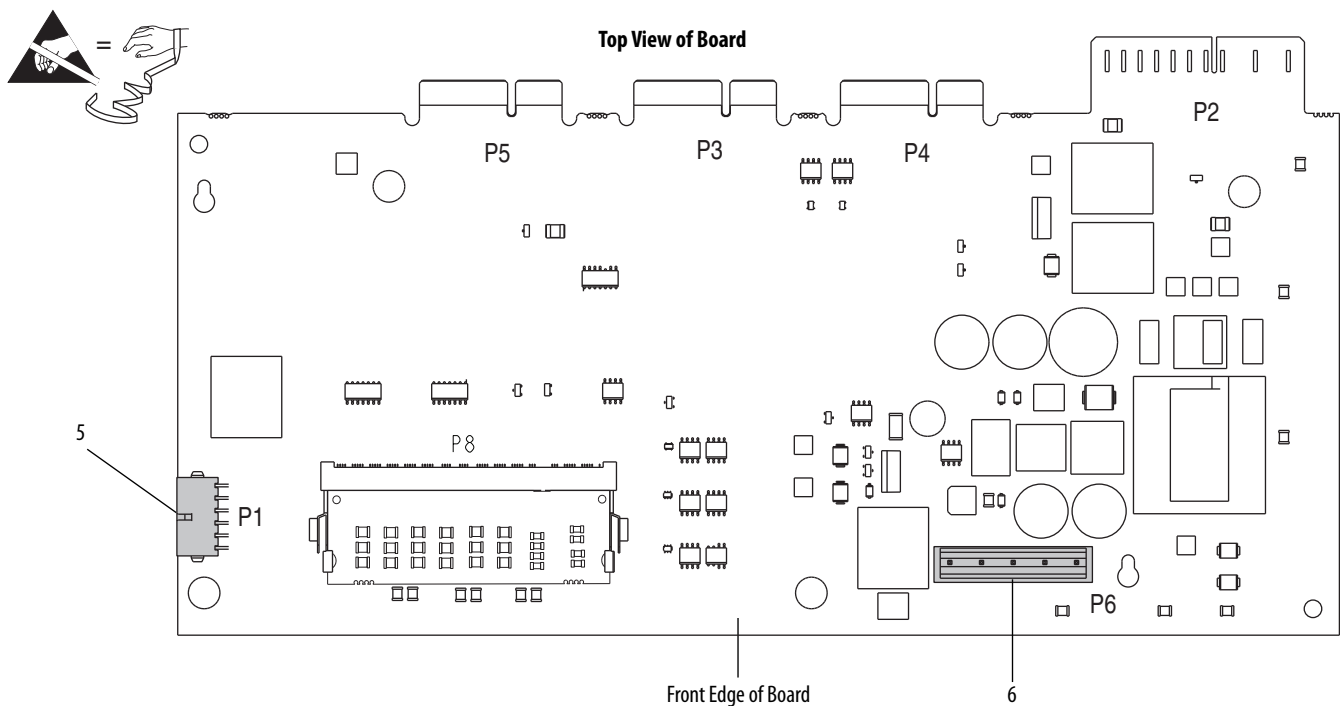
Install the power control board in the reverse order of removal. See Remove the Power Control Circuit Board on page [262](#).

Inverter Backplane Circuit Board Removal/Installation

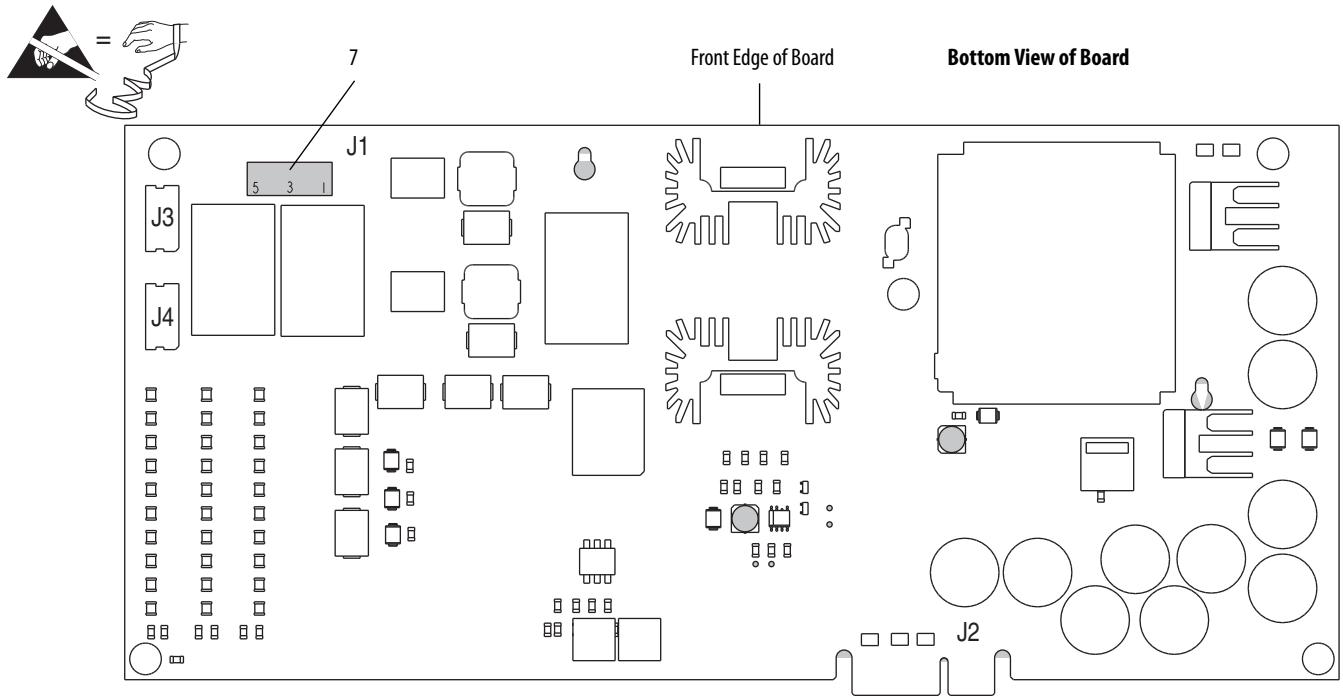
Remove the Inverter Backplane Circuit Board

IMPORTANT Firmware must be factory programmed into the inverter backplane board by qualified Rockwell Automation personnel. Field programming is not supported.

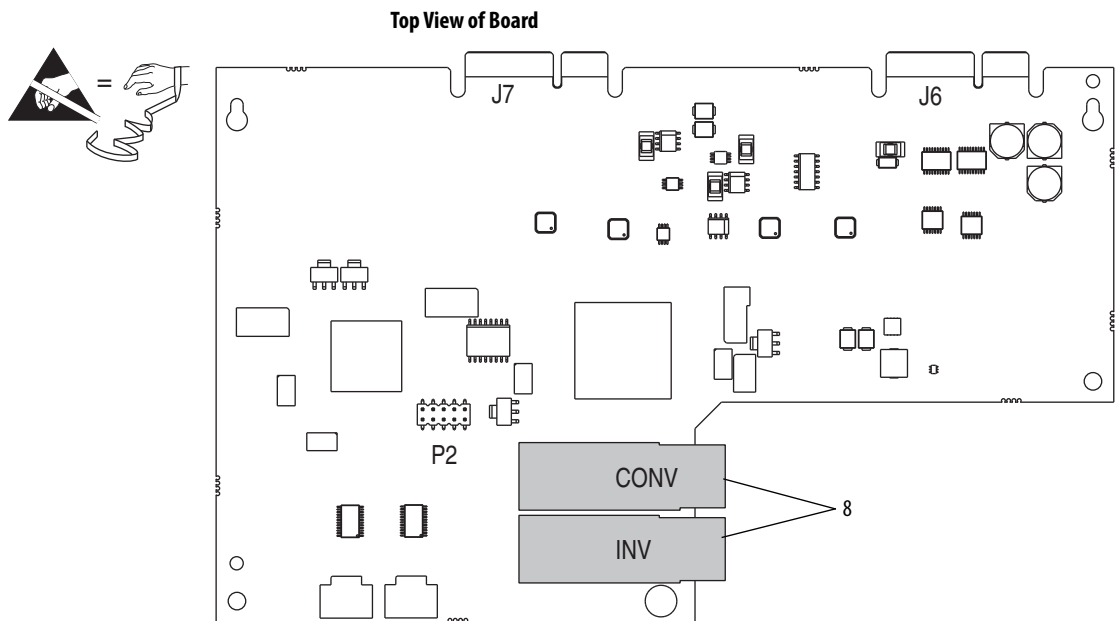
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the inverter front cover. See Remove the Inverter Front Cover on page [239](#).
5. Disengage the locking tabs and disconnect the wire connector from P1 on the power control board.
6. Disconnect the terminal block from P6 on the power control board.



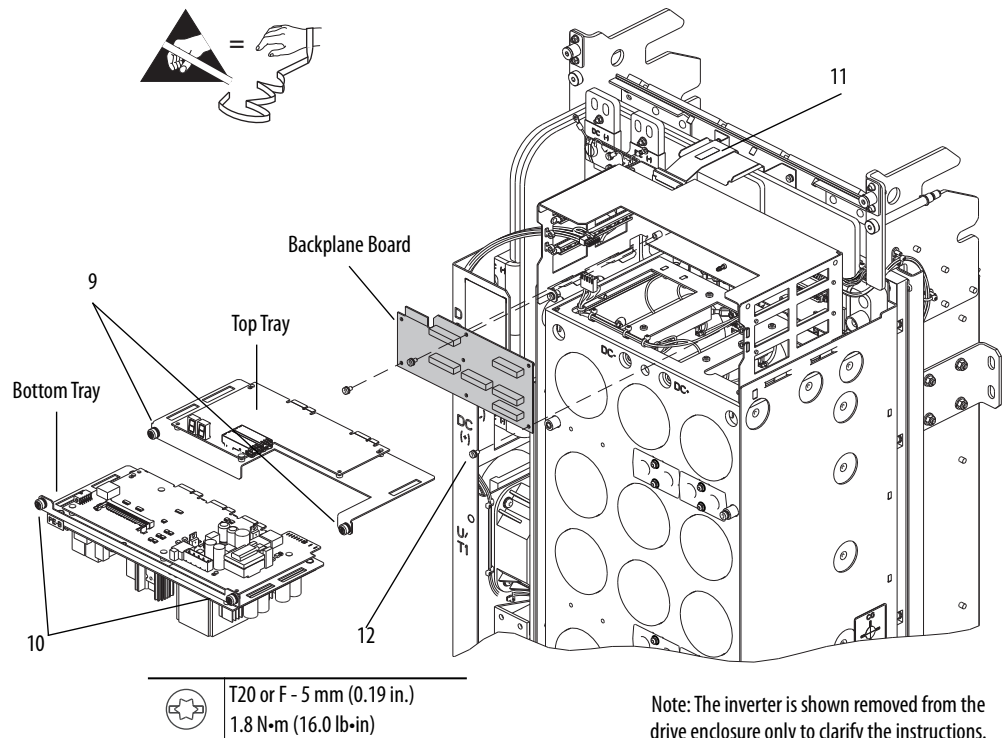
7. Disengage the locking tabs and disconnect the wire connector from J1 on the power supply board.



8. Disconnect the fiber-optic cables from CONV and INV on the power layer interface board.



9. Fully loosen the two captive screws on the face of the top tray in the card cage, pull forward, and remove the tray.
10. Fully loosen the two captive screws on the face of the bottom tray in the card cage and pull the tray out of the cage.
11. Disconnect the ribbon cable that is connected to the top edge of the backplane board.
12. Remove the three M4 x 8 mm screws that secure the backplane board to the tray and pull the backplane board gently forward to release it from the four snap-top standoffs.



Install the Inverter Backplane Circuit Board

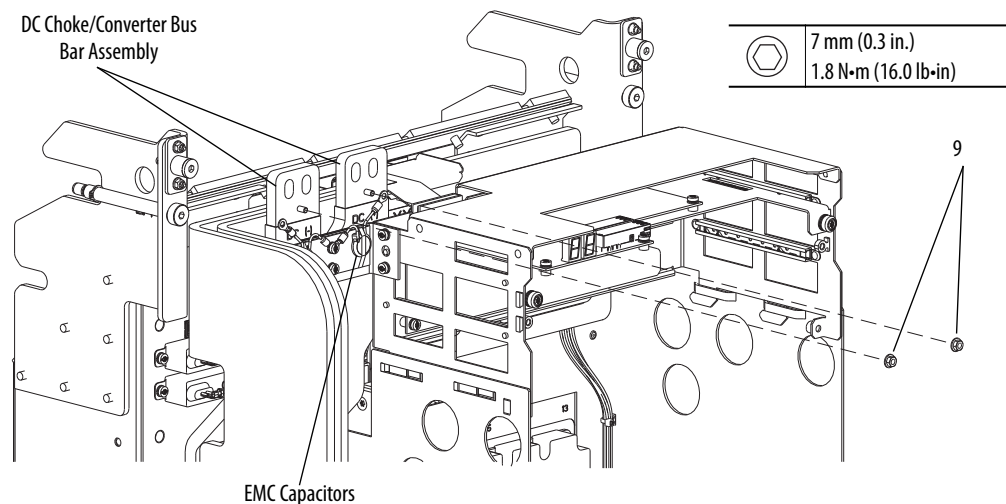
Install the inverter backplane board in the reverse order of removal. See Remove the Inverter Backplane Circuit Board on page [265](#).

Inverter EMC Capacitor Removal/Installation (AC Input Drive Only)

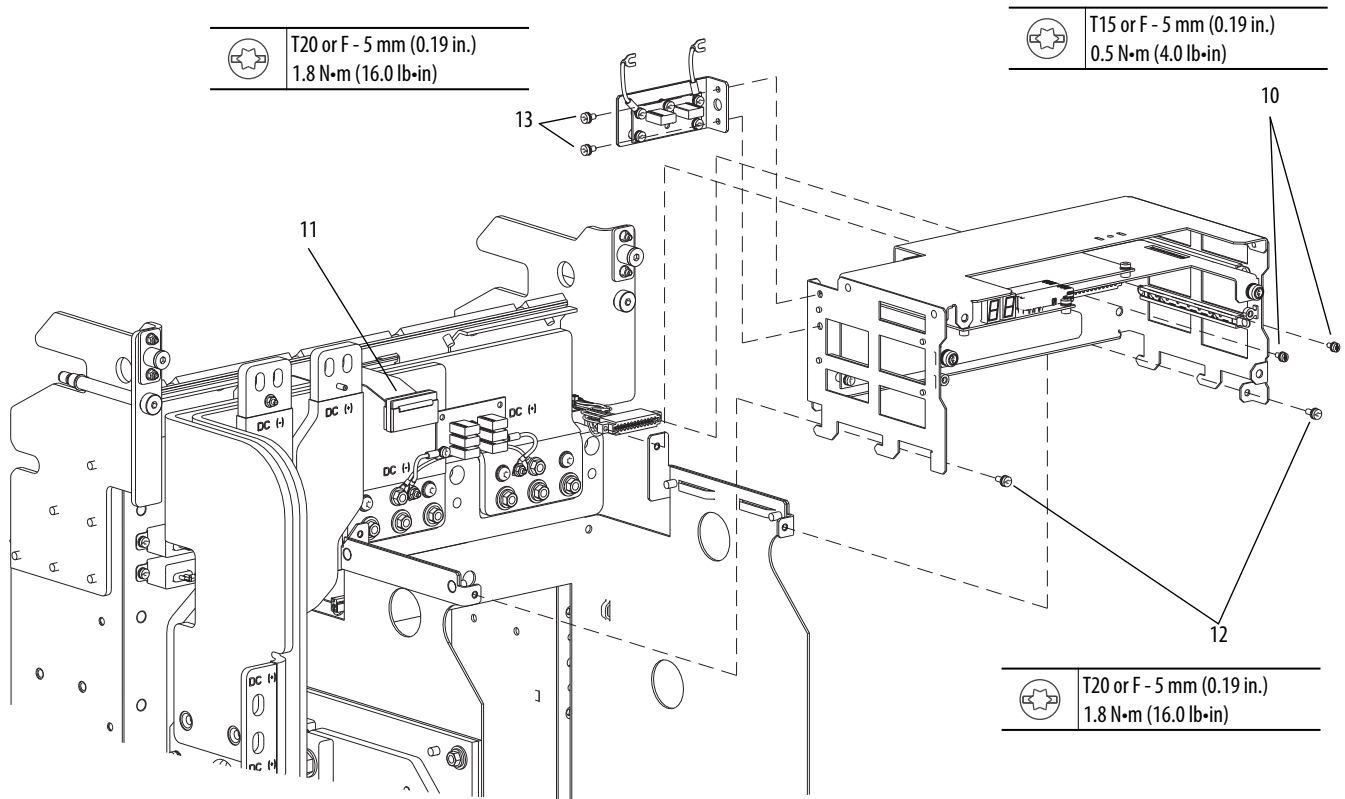
Remove the Inverter EMC Capacitors (AC Input Drive Only)

Note: There are three sets of EMC capacitors on the inverter. One set is to the left of the card cage, a second set is behind the card cage, and a third set is below the capacitor bank.

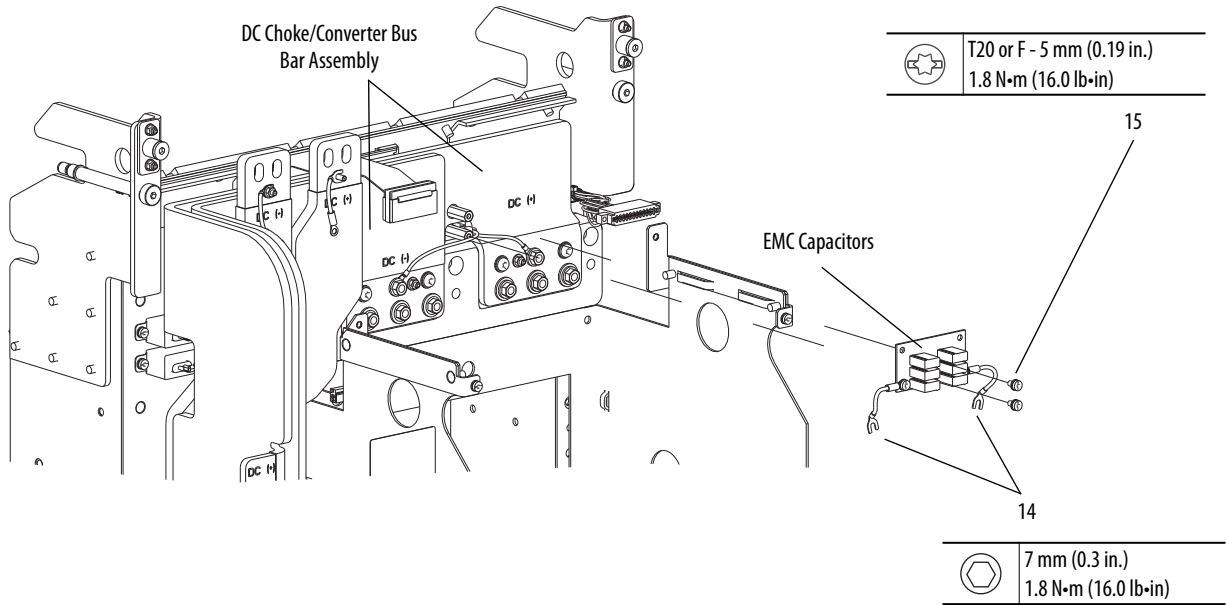
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the inverter assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
5. Remove the internal stirring fan tray. See Remove the Internal Stirring Fan Tray on page [234](#).
6. Remove the inverter front cover. See Remove the Inverter Front Cover on page [239](#).
7. Remove the current sensor mounting panel. See Remove the Inverter Current Sensors on page [240](#).
8. Remove the capacitor bank. See Remove the Inverter Capacitor Bank Assembly on page [246](#).
9. Remove the two M4 hex nuts that secure the connections from the EMC capacitors to DC choke/converter bus bar assembly.



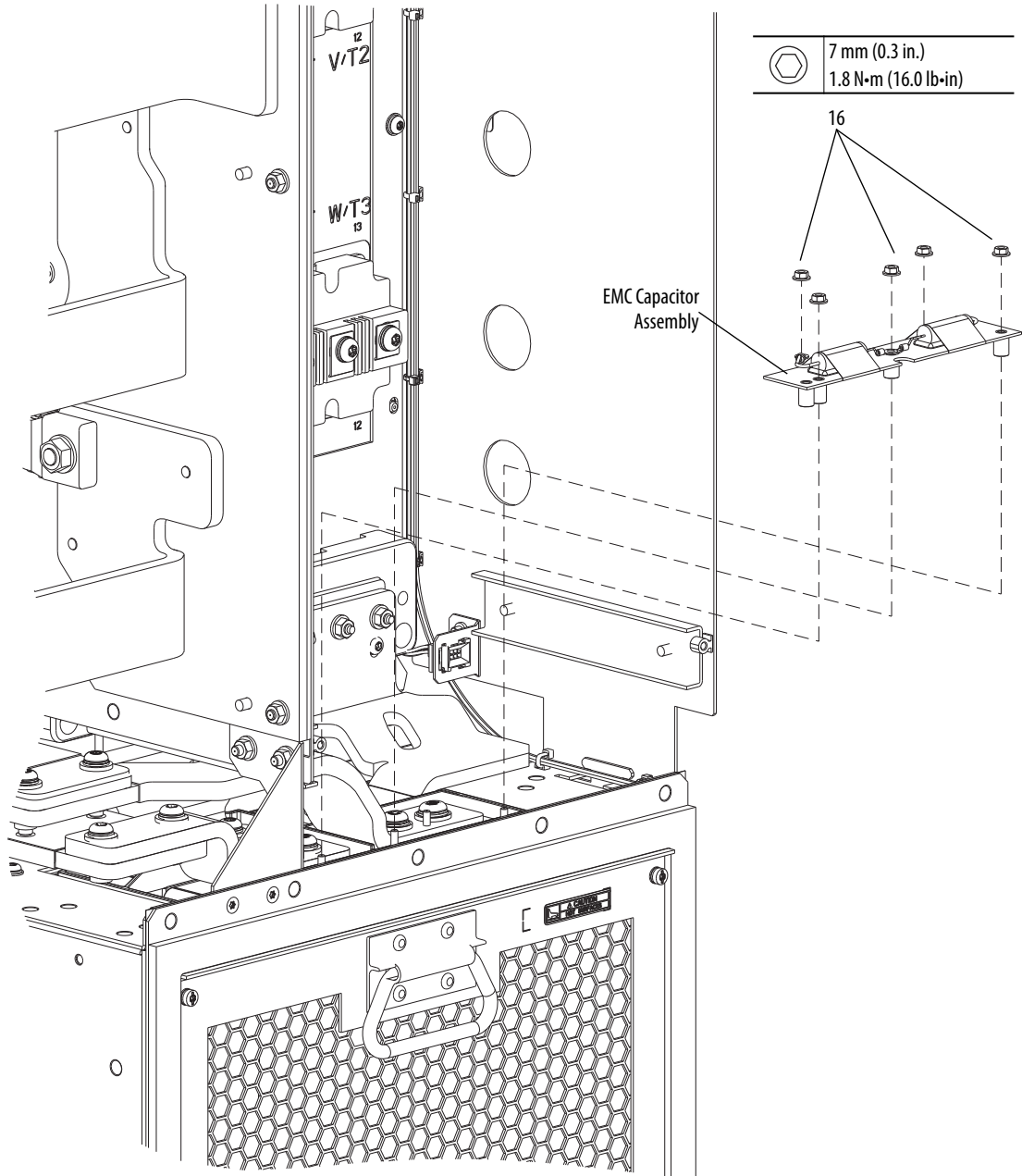
10. Remove the two M3 x 12 mm screws that secure the inverter wire harness to the backplane in the card cage.
11. Disconnect the ribbon cable that is connected to the top edge of the backplane board.
12. Remove the two M4 x 10 mm screws that secure the card cage to the inverter frame and slide the card cage out and up to remove it.
13. Remove the two M4 x 8 mm screws that secure the EMC capacitor assembly to the card cage and remove the capacitor assembly.



14. Remove the two M4 hex nuts that secure the connections from the EMC capacitors to DC choke/converter bus bar assembly.
15. Remove the two M4 x 8 mm screws that secure the EMC capacitor assembly to the standoffs on the capacitor bank support and remove the EMC capacitor assembly.



16. Remove the five M4 hex nuts that secure the connections from the EMC capacitors to the DC choke input positive and negative bus bars and the EMC capacitor assembly to the drive chassis and remove the EMC capacitor assembly.



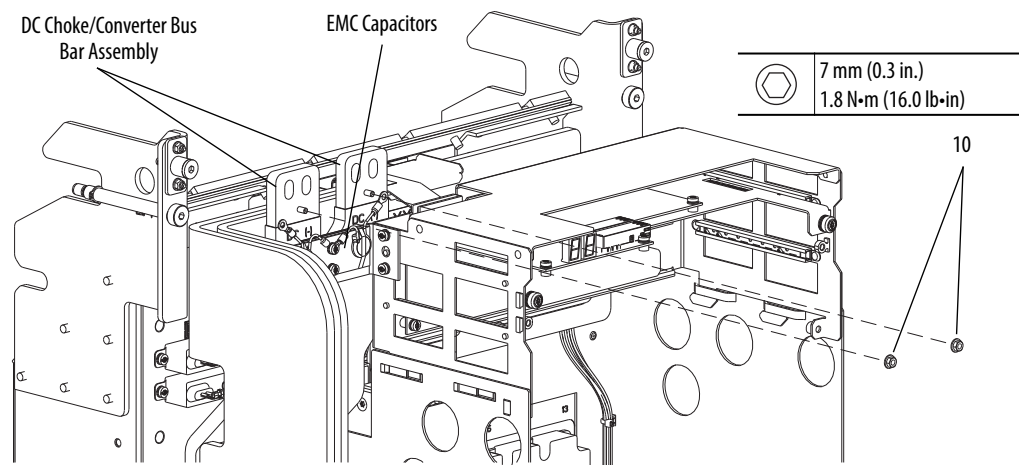
Install the Inverter EMC Capacitors (AC Input Drive Only)

Install the Inverter EMC Capacitors in the reverse order of removal. See Remove the Inverter EMC Capacitors (AC Input Drive Only) on page [268](#).

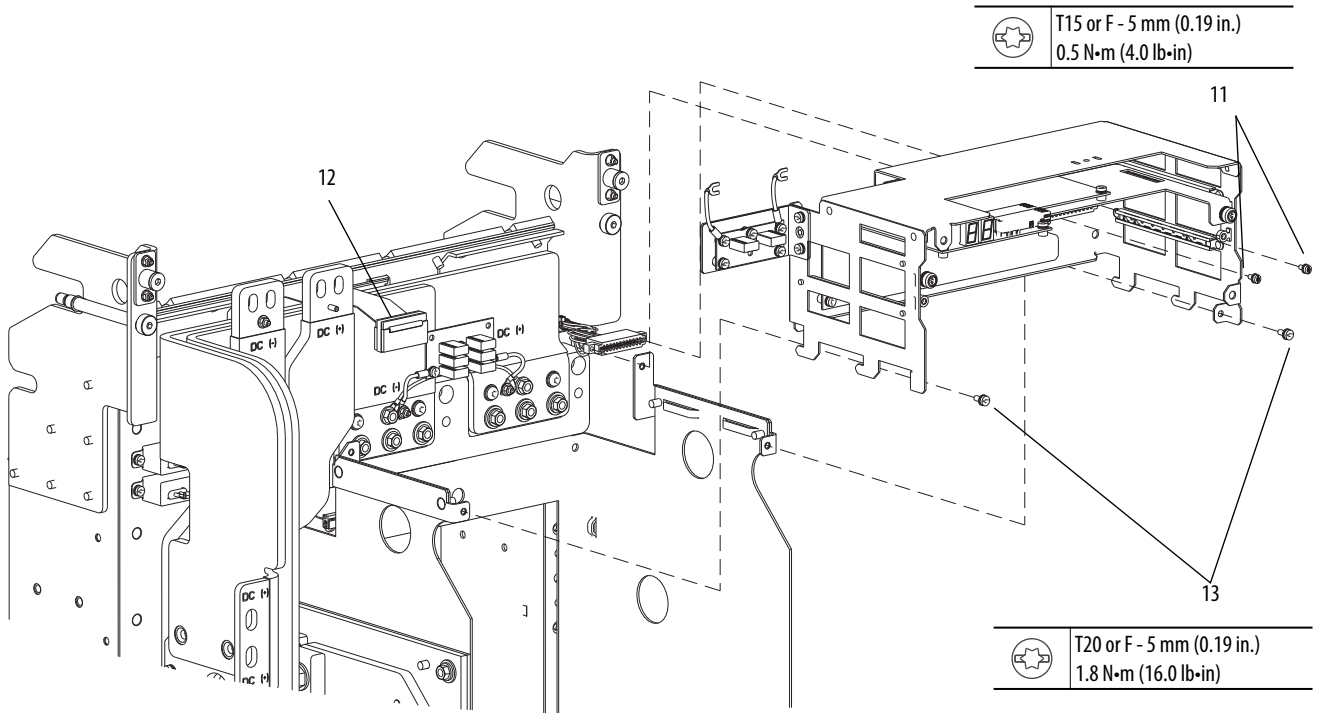
Inverter Side DC Bus Bar Removal/Installation (AC Input Drive Only)

Remove the Inverter Side DC Bus Bars (AC Input Drive Only)

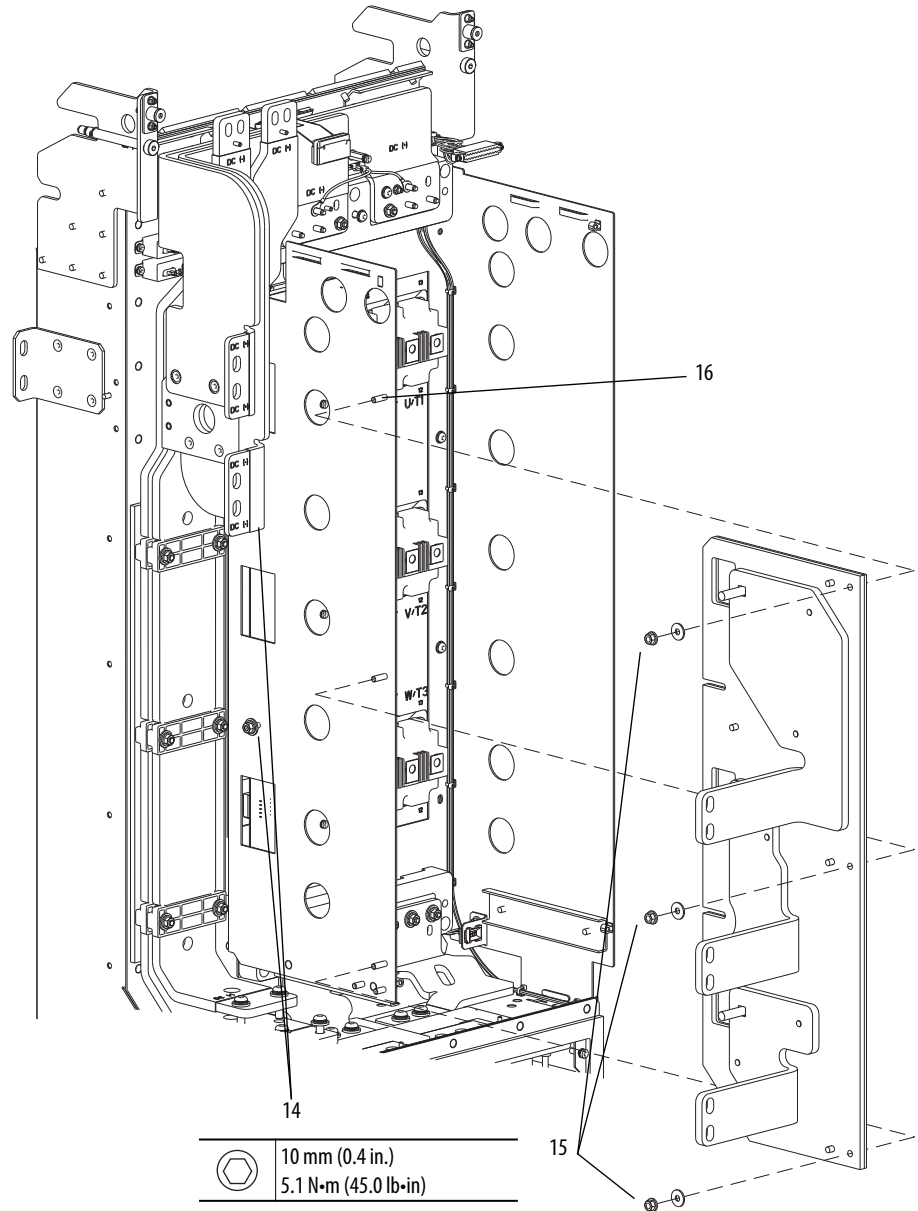
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the inverter assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
5. Remove the internal stirring fan tray. See Remove the Internal Stirring Fan Tray on page [234](#).
6. Remove the inverter front cover. See Remove the Inverter Front Cover on page [239](#).
7. Remove the current sensor mounting panel. See Remove the Inverter Current Sensors on page [240](#).
8. Remove the capacitor bank. See Remove the Inverter Capacitor Bank Assembly on page [246](#).
9. Remove the IGBT Flexbus bars. See Remove the IGBT Flexbus Bars on page [250](#).
10. Remove the two M4 hex nuts that secure the connections from the EMC capacitors to DC choke/converter bus bar assembly.




11. Remove the two M3 x 12 mm screws that secure the inverter wire harness to the backplane in the card cage.
12. Disconnect the ribbon cable that is connected to the top edge of the backplane board.
13. Remove the two M4 x 10 mm screws that secure the card cage to the inverter frame and slide the card cage out and up to remove it.

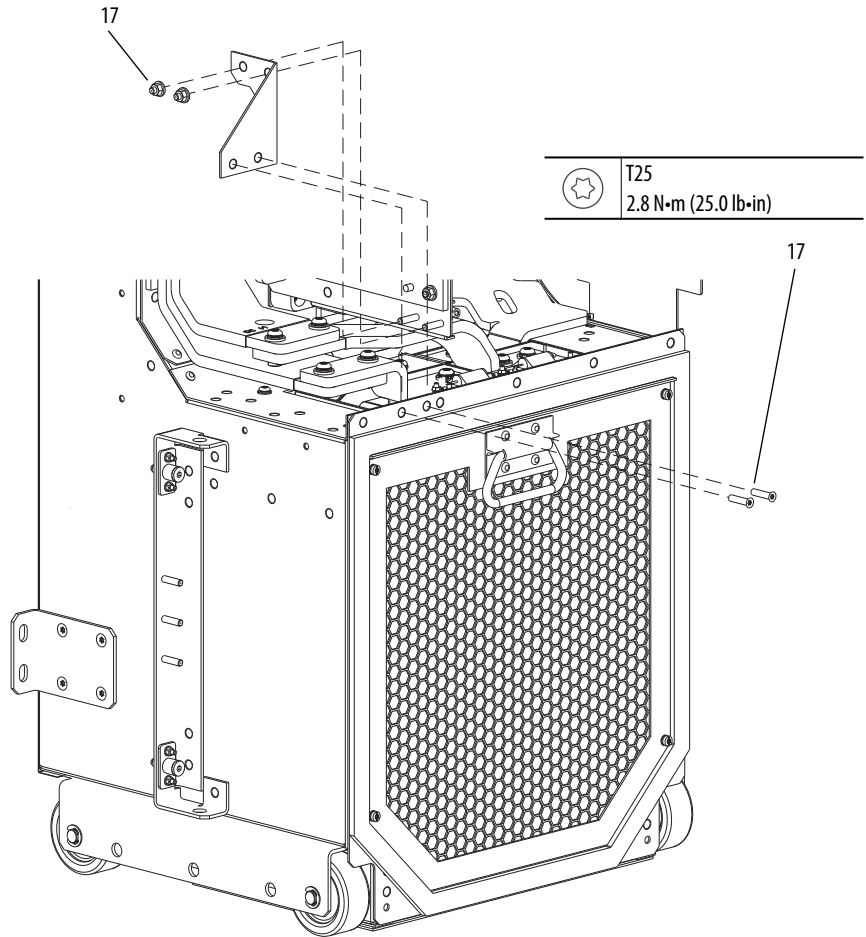


14. Fully loosen, but do not remove, the two M6 hex nuts at the back edge of the AC output bus bar assembly.
15. Remove the three M6 hex nuts and washers that secure the front of the AC output assembly to the capacitor bank support.
16. Lift the assembly off the front three bolts and pull forward to remove the AC output assembly.

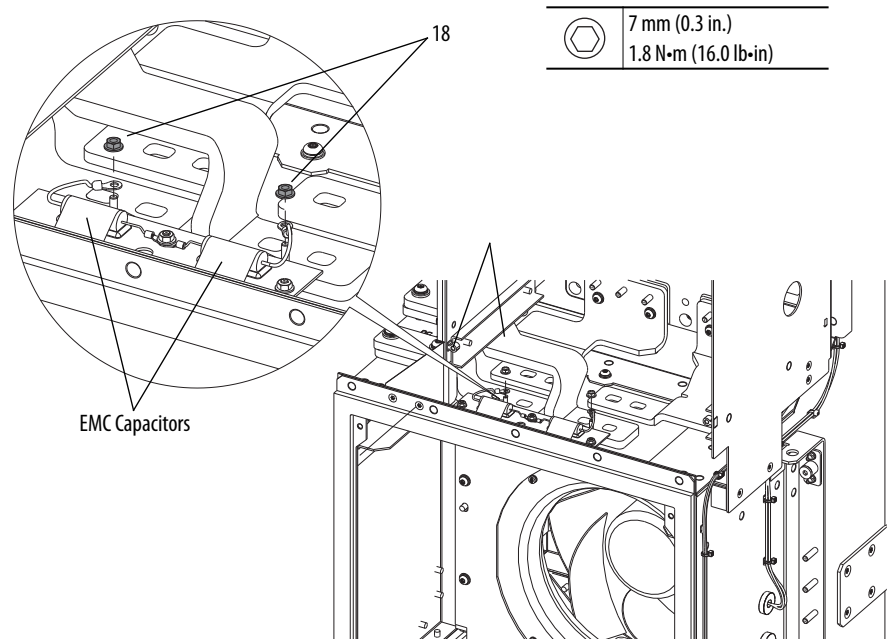


17. Remove the two M6 hex nuts and two M5 x 10 mm screws that secure the capacitor bank gusset to the capacitor bank support and drive chassis and remove the gusset.

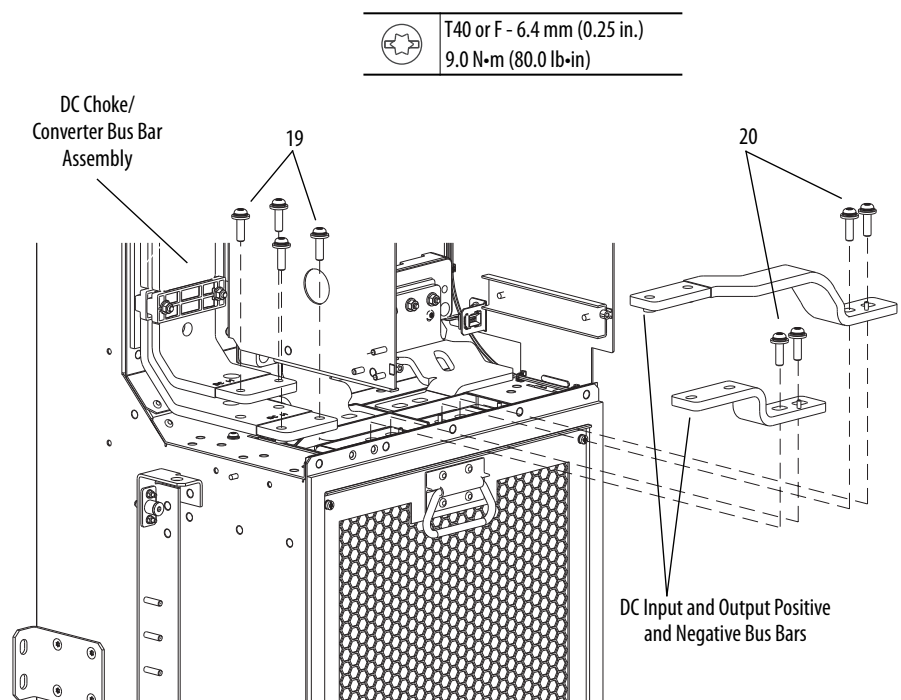
	10 mm (0.4 in.)
	5.1 N·m (45.0 lb·in)



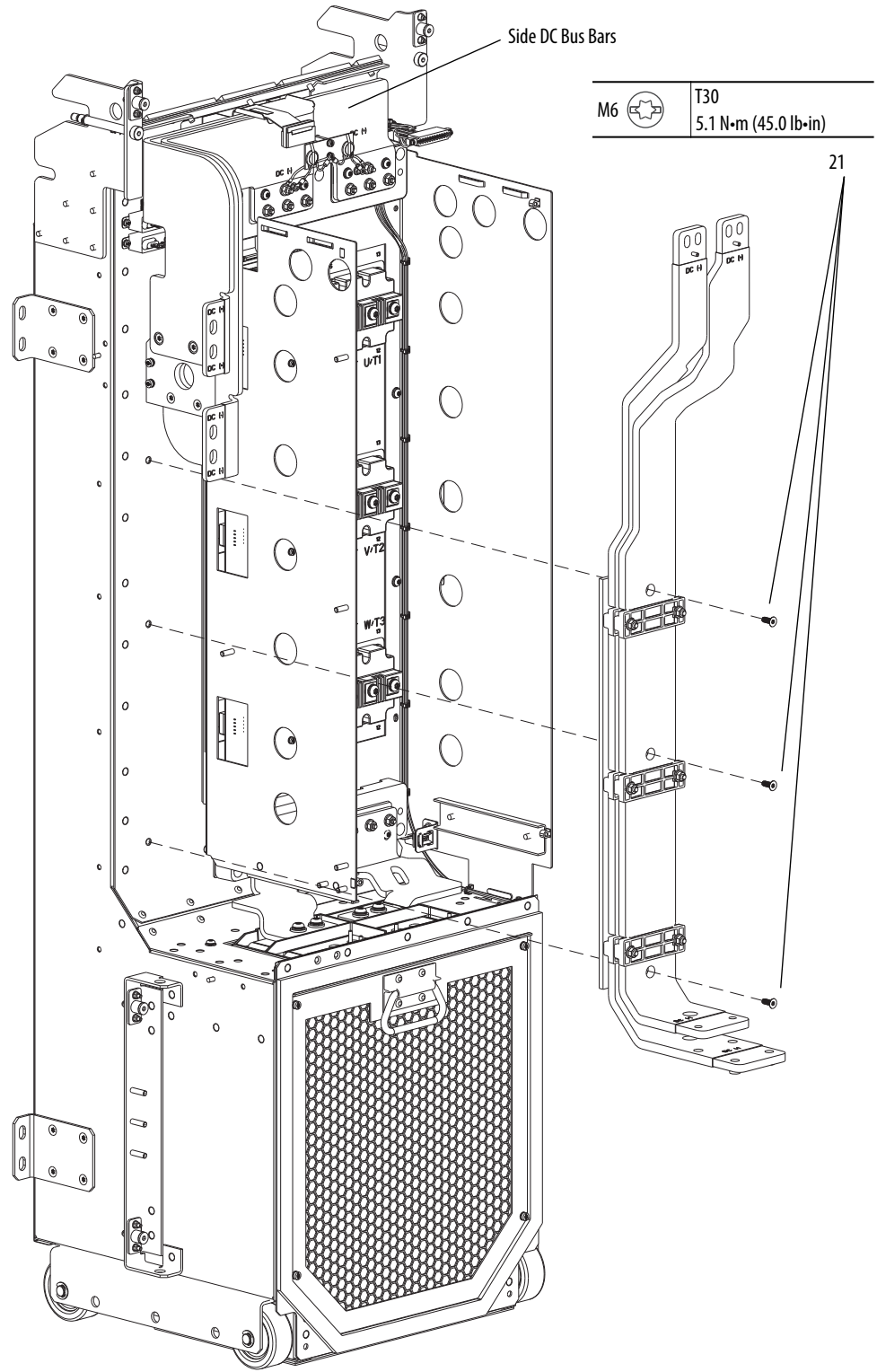
18. Remove the two M4 hex nuts that secure the connections from the EMC capacitors to the DC choke input positive and negative bus bars.



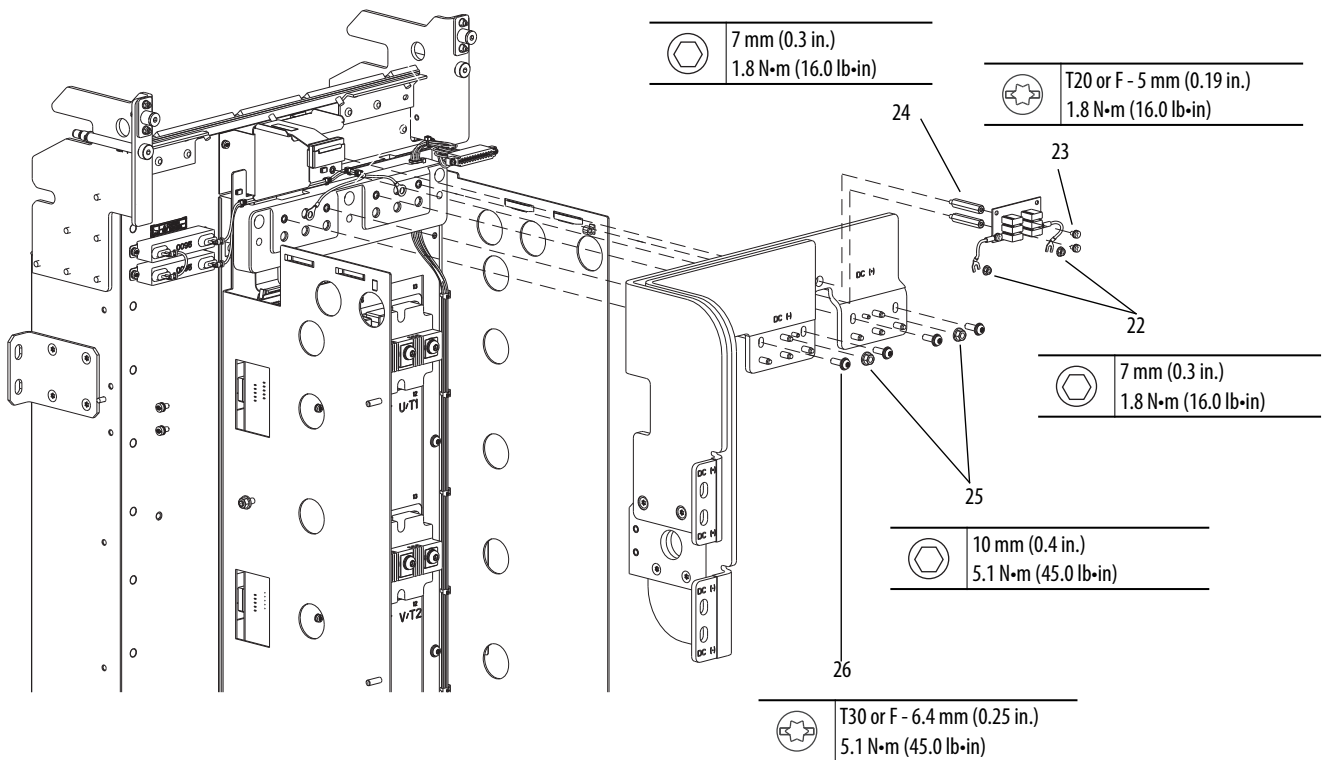
19. Remove the four M8 x 30 mm screws and four M8 flat washers that secure the bottom of the DC choke/converter bus bar assembly to the DC choke input positive and negative bus bars.
20. Remove the four M8 x 30 mm screws and M8 flat washers from the DC input and output positive and negative bus bars where they connect to the top of the DC choke and remove the bus bars.



21. Remove the three M6 x 16 mm screws that secure the DC choke/converter bus bar assembly to the chassis and remove the DC choke/converter bus bar assembly.



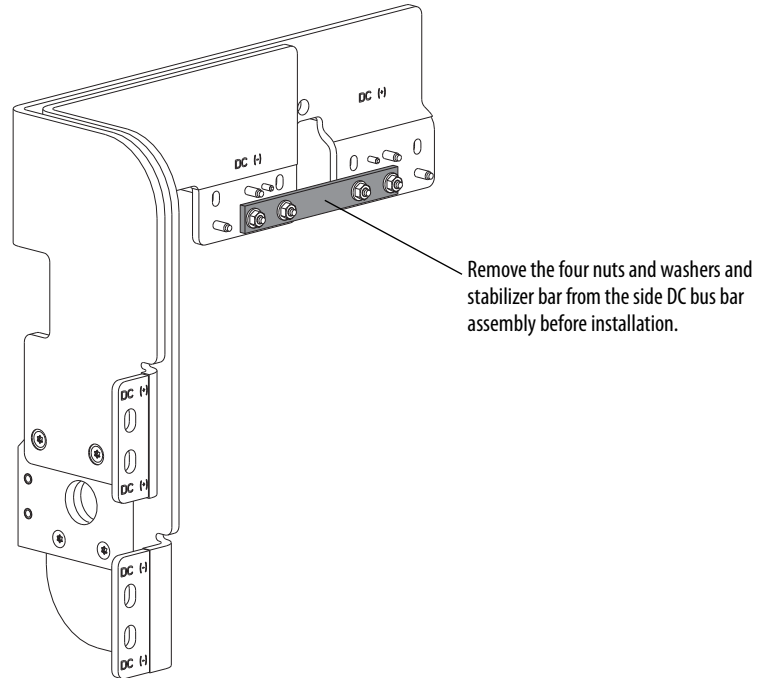
22. Remove the two M4 hex nuts that secure the connections from the EMC capacitors to side DC bus bars.
23. Remove the two M4 x 8 mm screws that secure the EMC capacitor assembly to the standoffs on the capacitor bank support and remove the EMC capacitor assembly.
24. Remove the two M4 x 40 mm standoffs that are secured to the capacitor bank support.
25. Remove the two M6 hex nuts that secure the two discharge resistor wires to the inverter side DC bus bars. Move the wires out of the way to allow for removal of the side DC bus bars.
26. Remove the four M6 x 20 mm screws that secure the side DC bus bars to the chassis and remove the bus bars.



Install the Inverter Side DC Bus Bars (AC Input Drive Only)

Install the inverter side DC bus bars in the reverse order of removal. See Remove the Inverter Side DC Bus Bars (AC Input Drive Only) on page [272](#).

IMPORTANT The new side DC bus bar assembly is shipped with a stabilizer bar secured to the upper connection bolts. This stabilizer bar must be removed before installing the new assembly.

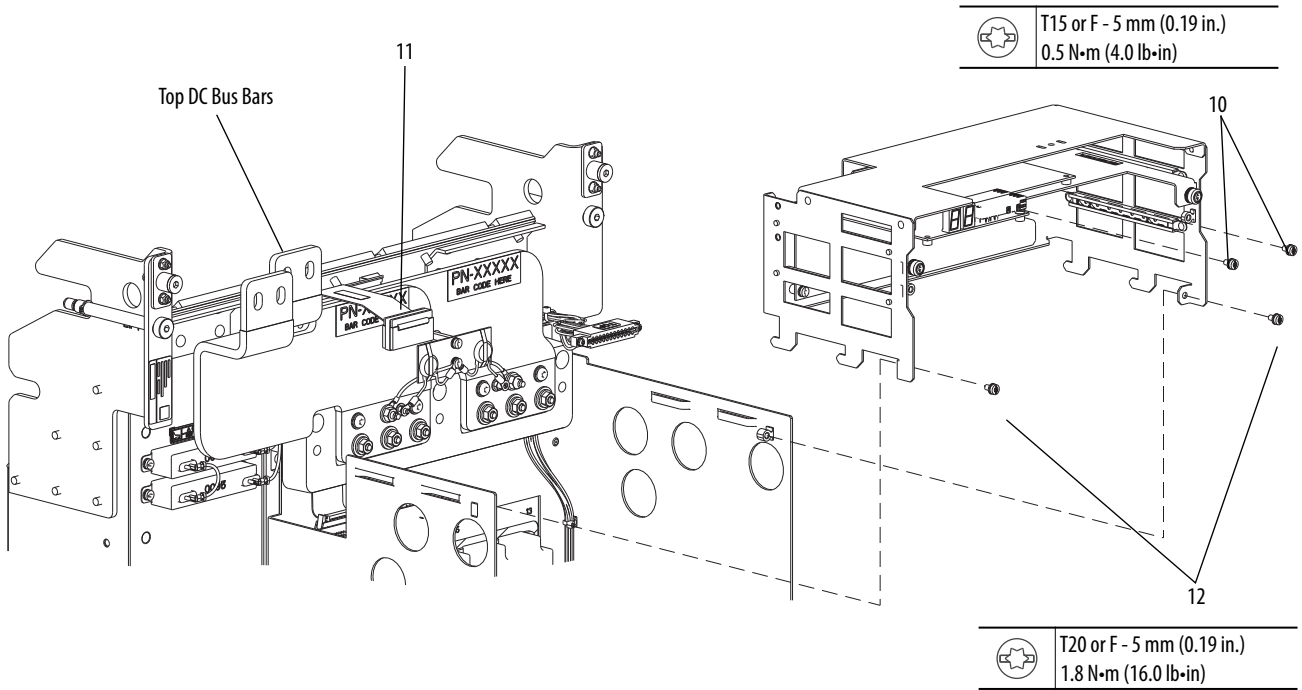


Inverter Top DC Bus Bar Removal/Installation (Common DC Input Drive Only)

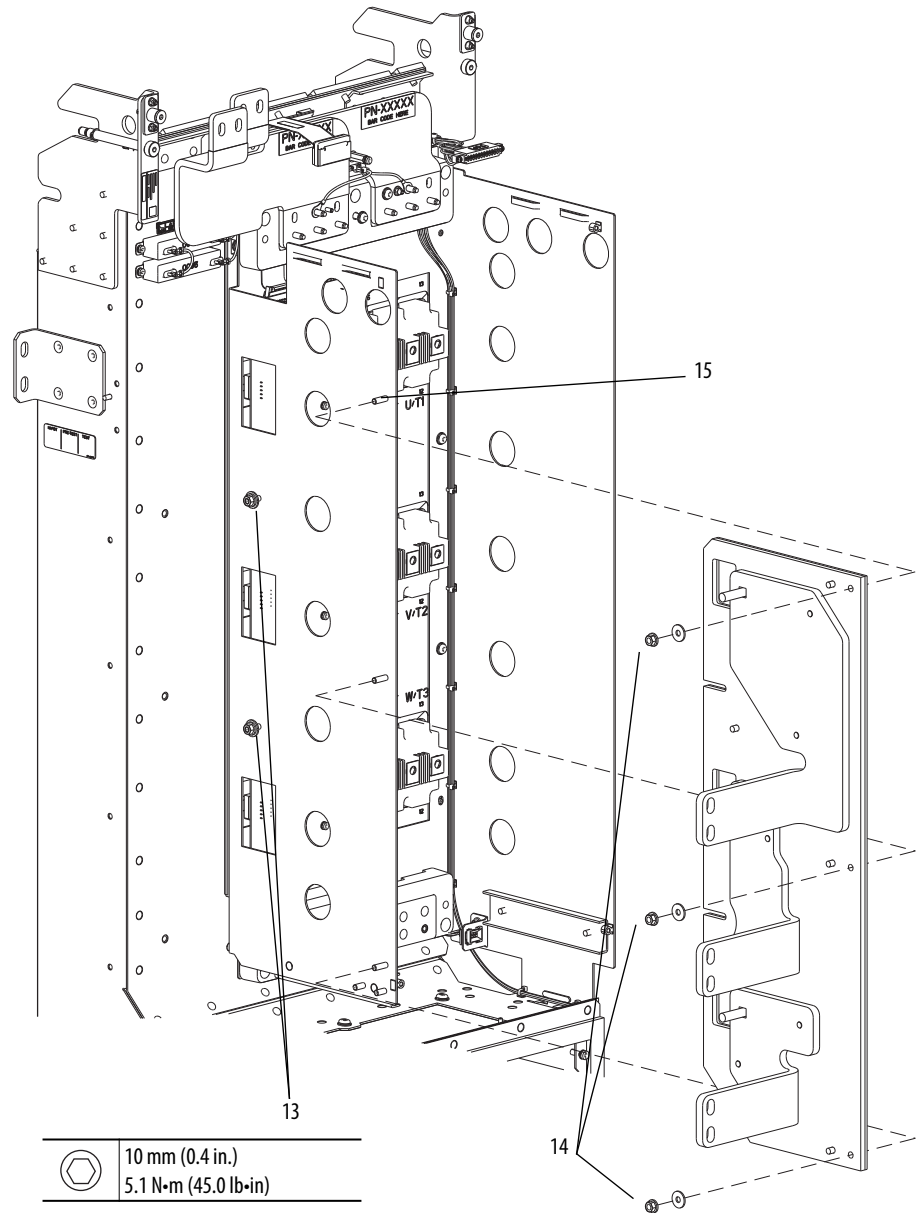
Remove the Inverter Top DC Bus Bars (Common DC Input Drive Only)

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the inverter assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
5. Remove the internal stirring fan tray. See Remove the Internal Stirring Fan Tray on page [234](#).
6. Remove the inverter front cover. See Remove the Inverter Front Cover on page [239](#).
7. Remove the current sensor mounting panel. See Remove the Inverter Current Sensors on page [240](#).
8. Remove the capacitor bank. See Remove the Inverter Capacitor Bank Assembly on page [246](#).
9. Remove the IGBT Flexbus bars. See Remove the IGBT Flexbus Bars on page [250](#).

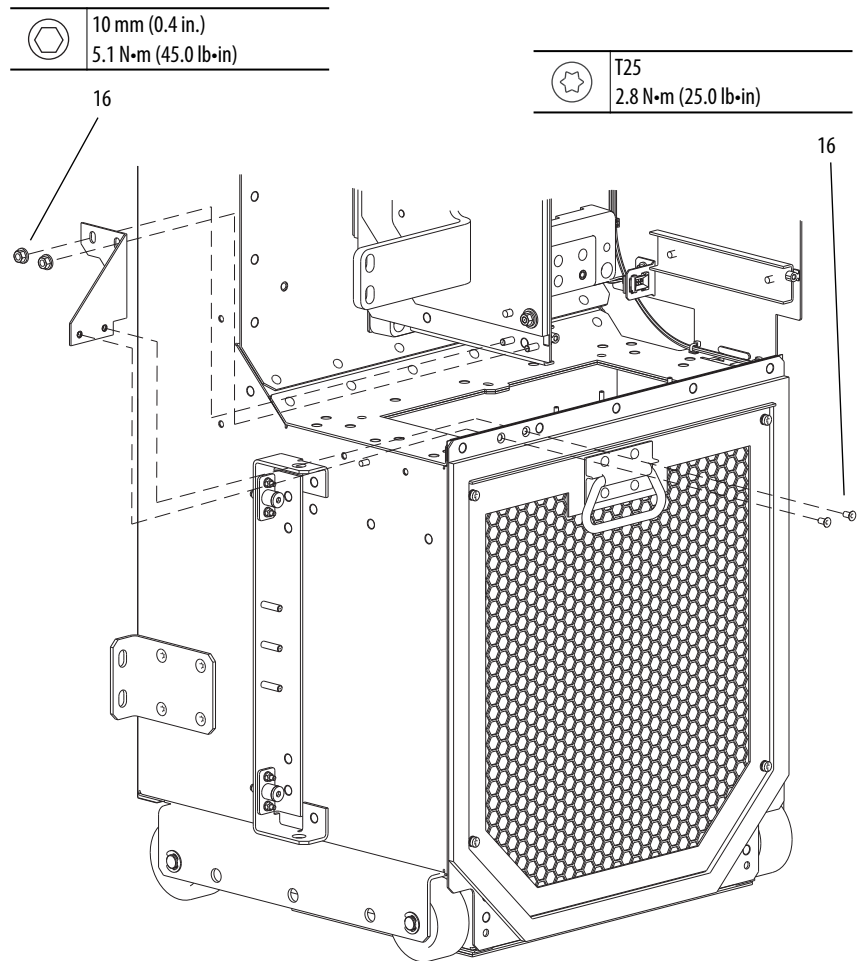
10. Remove the two M3 x 12 mm screws that secure the inverter wire harness to the backplane in the card cage.
11. Disconnect the ribbon cable that is connected to the top edge of the backplane board.
12. Remove the two M4 x 10 mm screws that secure the card cage to the inverter frame and slide the card cage out and up to remove it.



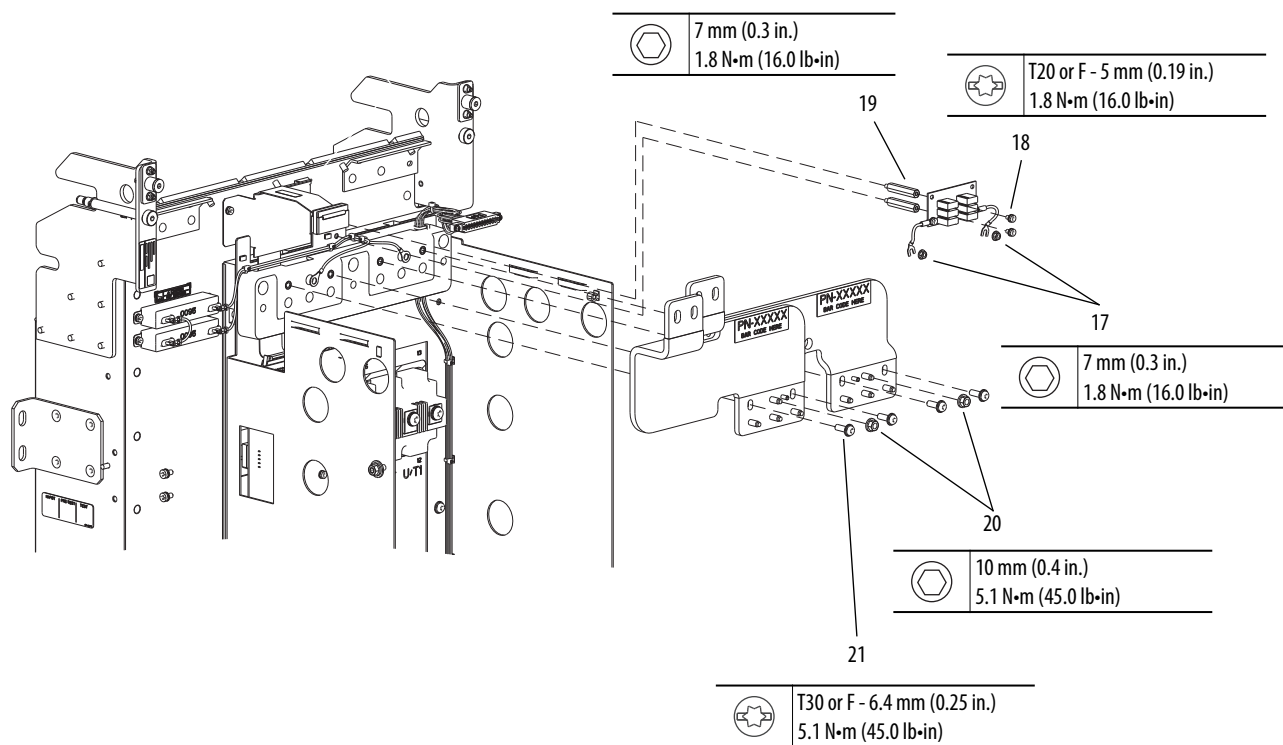
13. Fully loosen, but do not remove, the two M6 hex nuts at the back edge of the AC output bus bar assembly.
14. Remove the three M6 hex nuts and washers that secure the front of the AC output assembly to the capacitor bank support.
15. Lift the assembly off the front three bolts and pull forward to remove the AC output assembly.



16. Remove the two M6 hex nuts and two M5 x 10 mm hexalobular screws that secure the capacitor bank gusset to the capacitor bank support and drive chassis and remove the gusset.



17. Remove the two M4 hex nuts that secure the connections from the EMC capacitors to top DC bus bars.
18. Remove the two M4 x 8 mm screws that secure the EMC capacitor assembly to the standoffs on the capacitor bank support and remove the EMC capacitor assembly.
19. Remove the two M4 x 40 mm standoffs that are secured to the capacitor bank support.
20. Remove the two M6 hex nuts that secure the two discharge resistor wires to the inverter top DC bus bars. Move the wires out of the way to allow for removal of the top DC bus bars.
21. Remove the four M6 x 20 mm screws that secure the top DC bus bars to the chassis and remove the bus bars.



Install the Inverter Top DC Bus Bars (Common DC Input Drive Only)

Install the inverter top DC bus bars in the reverse order of removal. See Remove the Inverter Top DC Bus Bars (Common DC Input Drive Only) on page [280](#).

DC Choke Removal/ Installation (AC Input Drives Only)

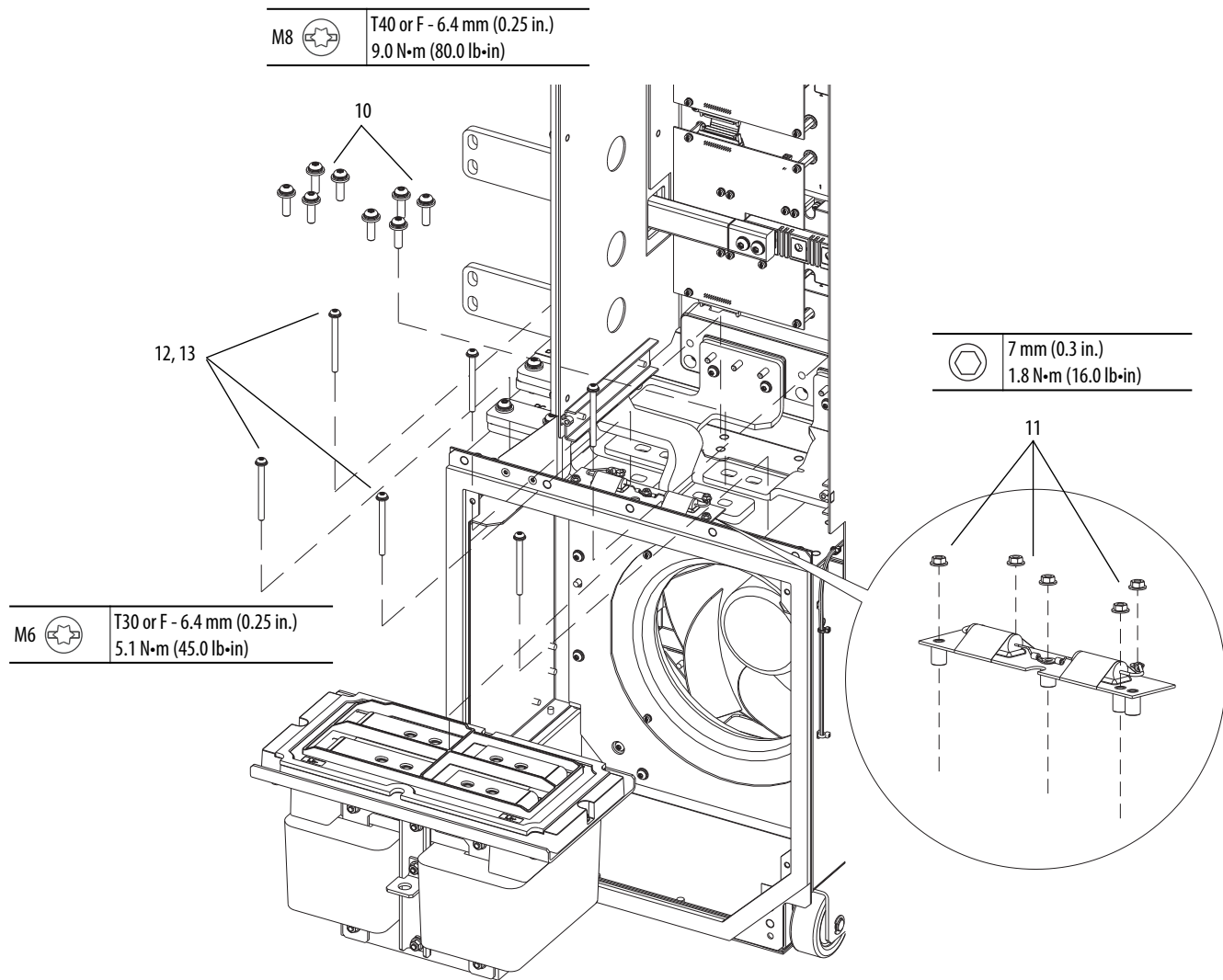
Remove the DC Choke (AC Input Drives Only)



ATTENTION: The DC choke weighs 42 kg (93 lb). To guard against possible personal injury, do not place any part of your person below the DC choke when removing it from the drive.

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the inverter assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
5. Remove the internal stirring fan tray. See Remove the Internal Stirring Fan Tray on page [234](#).
6. Remove the heatsink fan inlet screen. See Remove the Heatsink Fan Inlet Screen on page [235](#).
7. Remove the inverter front cover. See Remove the Inverter Front Cover on page [239](#).
8. Remove the current sensor mounting panel. See Remove the Inverter Current Sensors on page [240](#).
9. Remove the capacitor bank. See Remove the Inverter Capacitor Bank Assembly on page [246](#).

10. Remove the eight M8 x 30 mm screws and eight M8 flat washers from the DC input and output positive and negative bus bars where they connect to the top of the DC choke.
11. Remove the five M4 hex nuts that secure the connections from the EMC capacitors to the DC choke input positive and negative bus bars and the EMC capacitor assembly to the drive chassis and remove the EMC capacitor assembly.
12. Loosen only, the six M6 x 70 mm screws that secure the DC choke to the inverter.
13. Remove the four corner screws that were loosened in the previous step and then slowly loosen the remaining two screws to lower the DC choke onto the two angle brackets on either side of the fan inlet. Once the DC choke is resting on the two angle brackets, the remaining two screws can be removed.
14. Pull the DC choke forward through the fan inlet opening and remove the choke.



Install the DC Choke (AC Input Drives Only)

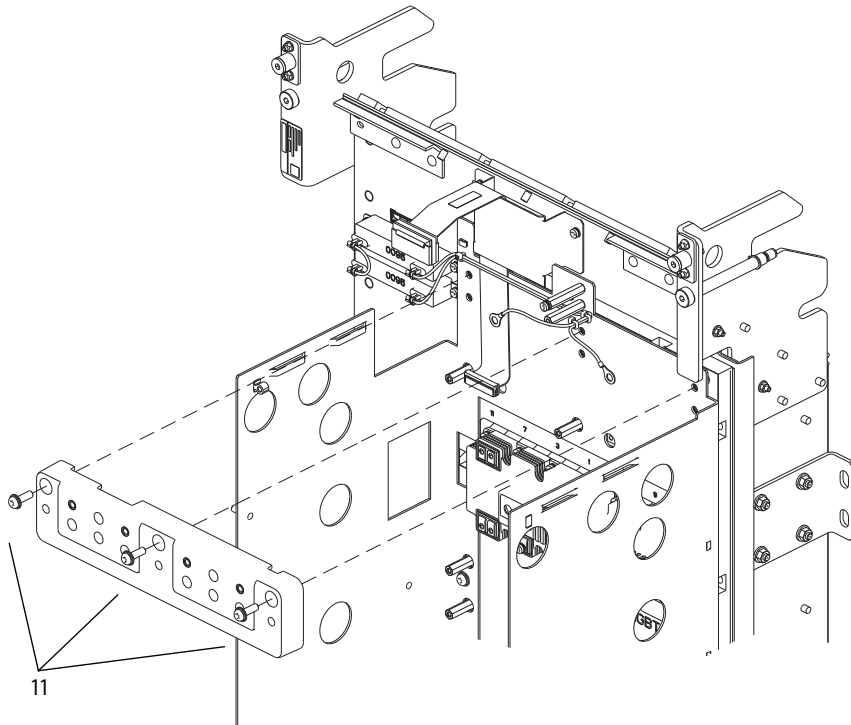
Install the DC choke in the reverse order of removal. See Remove the DC Choke (AC Input Drives Only) on page [285](#).


Inverter Wire Harness Removal/Installation

Remove the Inverter Wire Harness

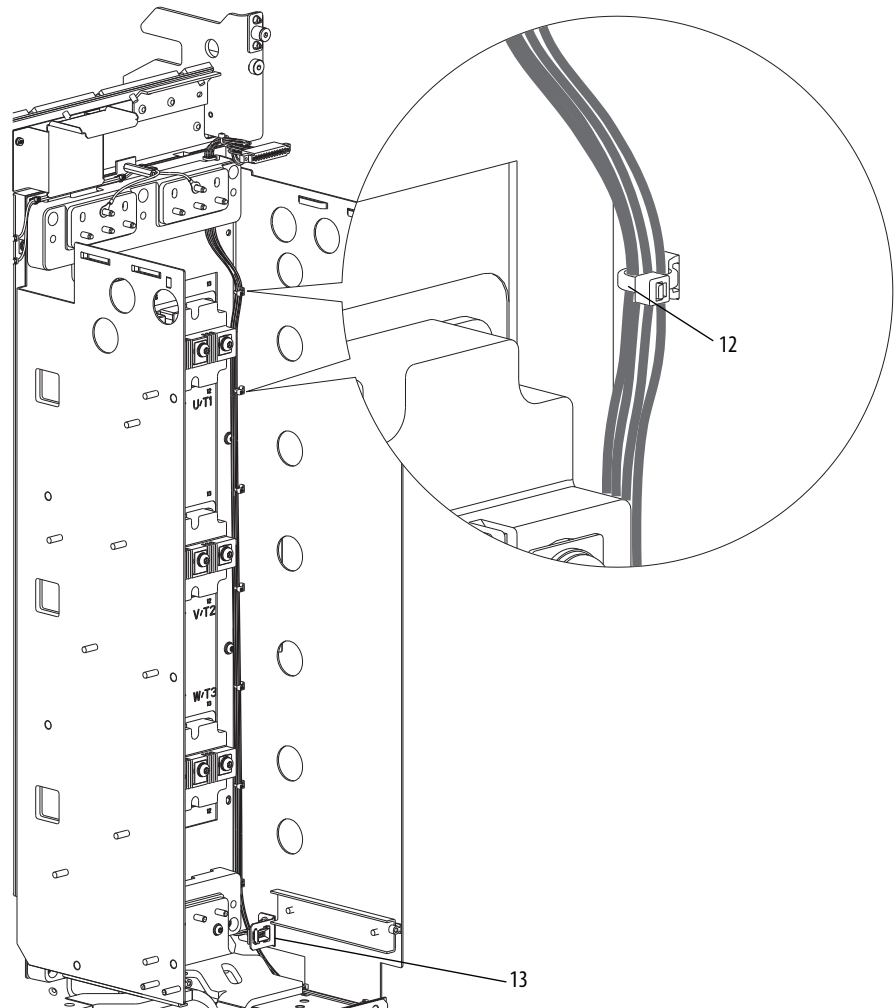
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the inverter assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
5. Remove the internal stirring fan tray. See Remove the Internal Stirring Fan Tray on page [234](#).
6. Remove the heatsink fan inlet screen. See Remove the Heatsink Fan Inlet Screen on page [235](#).
7. Remove the inverter front cover. See Remove the Inverter Front Cover on page [239](#).
8. Remove the inverter current-sensor mounting panel only. Do not remove the current sensors from the mounting panel. See Remove the Inverter Current Sensors on page [240](#).
9. Remove the capacitor bank. See Remove the Inverter Capacitor Bank Assembly on page [246](#).
10. For AC input drives, remove the side DC bus bar assembly. See Remove the Inverter Side DC Bus Bars (AC Input Drive Only) on page [272](#). For common DC input drives, remove the top DC bus bar assembly. See Remove the Inverter Top DC Bus Bars (Common DC Input Drive Only) on page [280](#).

11. Remove the three M6 x 20 mm screws that secure the top bus bar support to the capacitor bank support and remove the bus bar support.



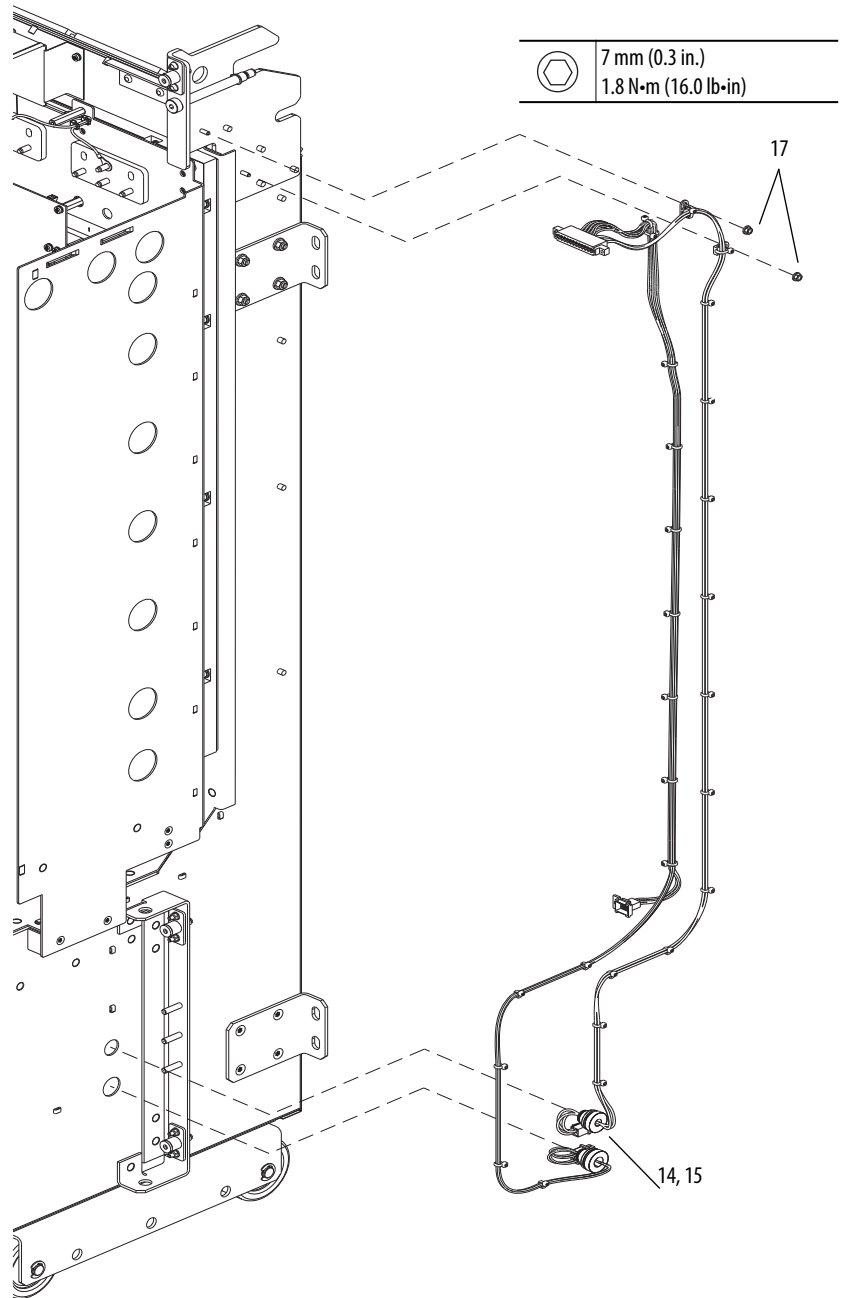
	T30 or F - 6.4 mm (0.25 in.) 5.1 N•m (45.0 lb•in)
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12. Cut the wire ties from the group of blue control wires on the inside, right-rear corner of the capacitor bank support.
13. Depress the tabs on the stirring fan connector and disconnect it from the mounting bracket.



14. Cut the two final cables ties where the blue fan control wires are routed through the right side of the heatsink fan inlet.
15. Remove the bushing and blue wires from the heatsink fan-inlet side plate.
16. On the inside of the heatsink fan inlet, depress the tabs on the blue control wire connector to remove it from the heatsink fan connection.
17. Remove the two M4 hex nuts that secure the black power wires at the top of the inverter.
18. Cut the remaining wire ties where the wires are routed down the outside of the inverter.
19. Remove the bushing and black wires from the heatsink fan-inlet side plate.

20. On the inside of the heatsink fan inlet, depress the tabs on the black power wire connector to remove it from the heatsink fan connection.



Install the Inverter Wire Harness

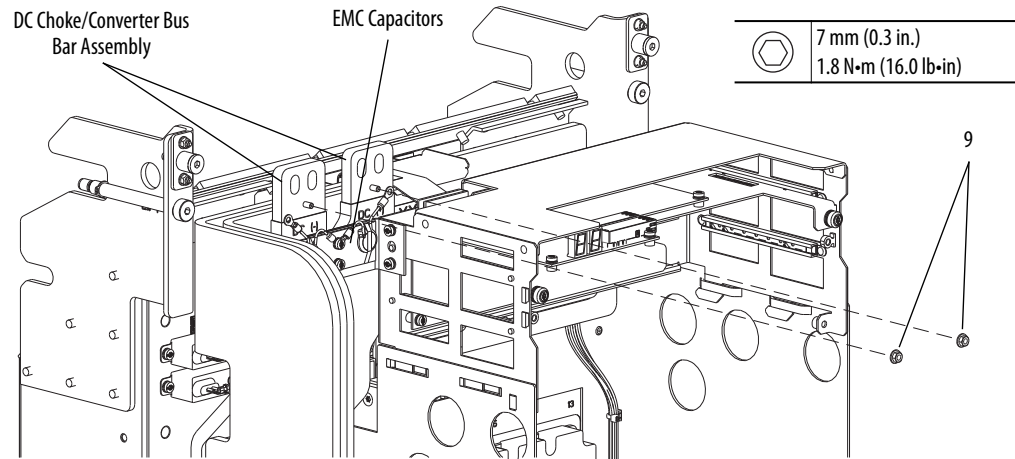
Install the inverter wire harness in the reverse order of removal. See Remove the Inverter Wire Harness on page [287](#).

Discharge Resistor Assembly Removal/Installation

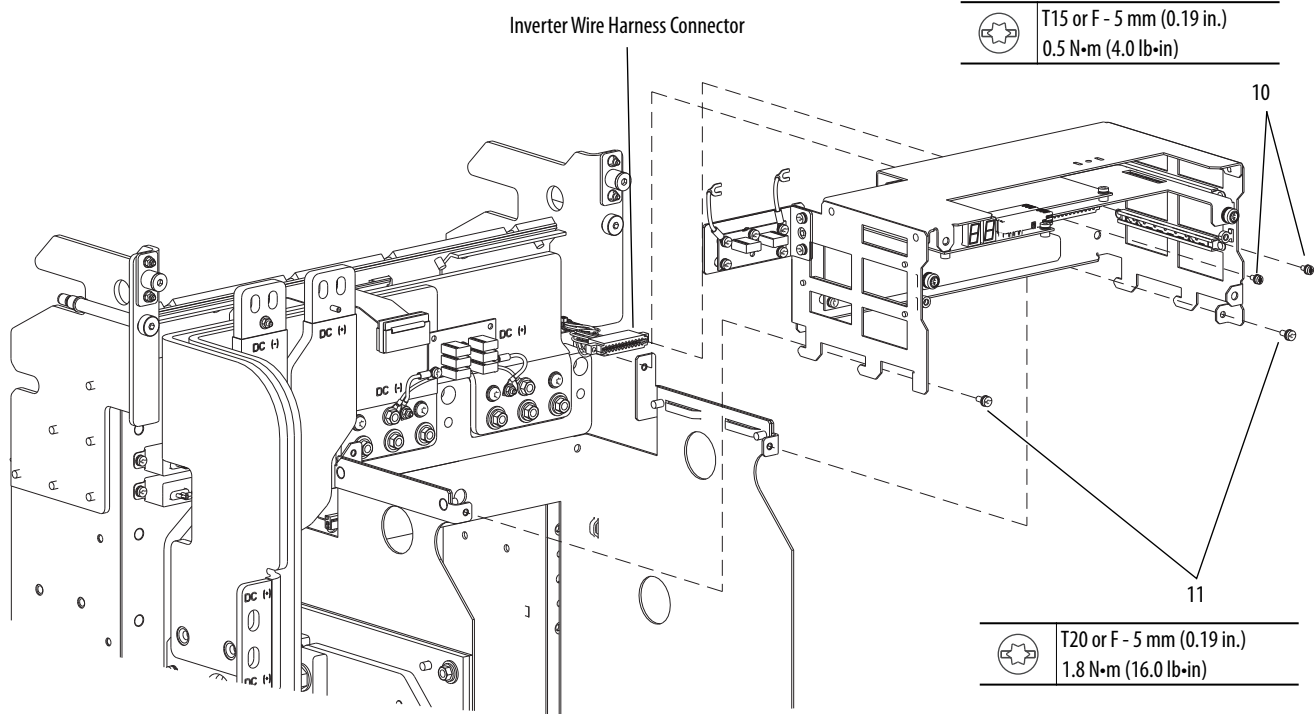
Remove the Discharge Resistor Assembly

Note: The discharge resistor assembly includes the resistors, harness, and screws.

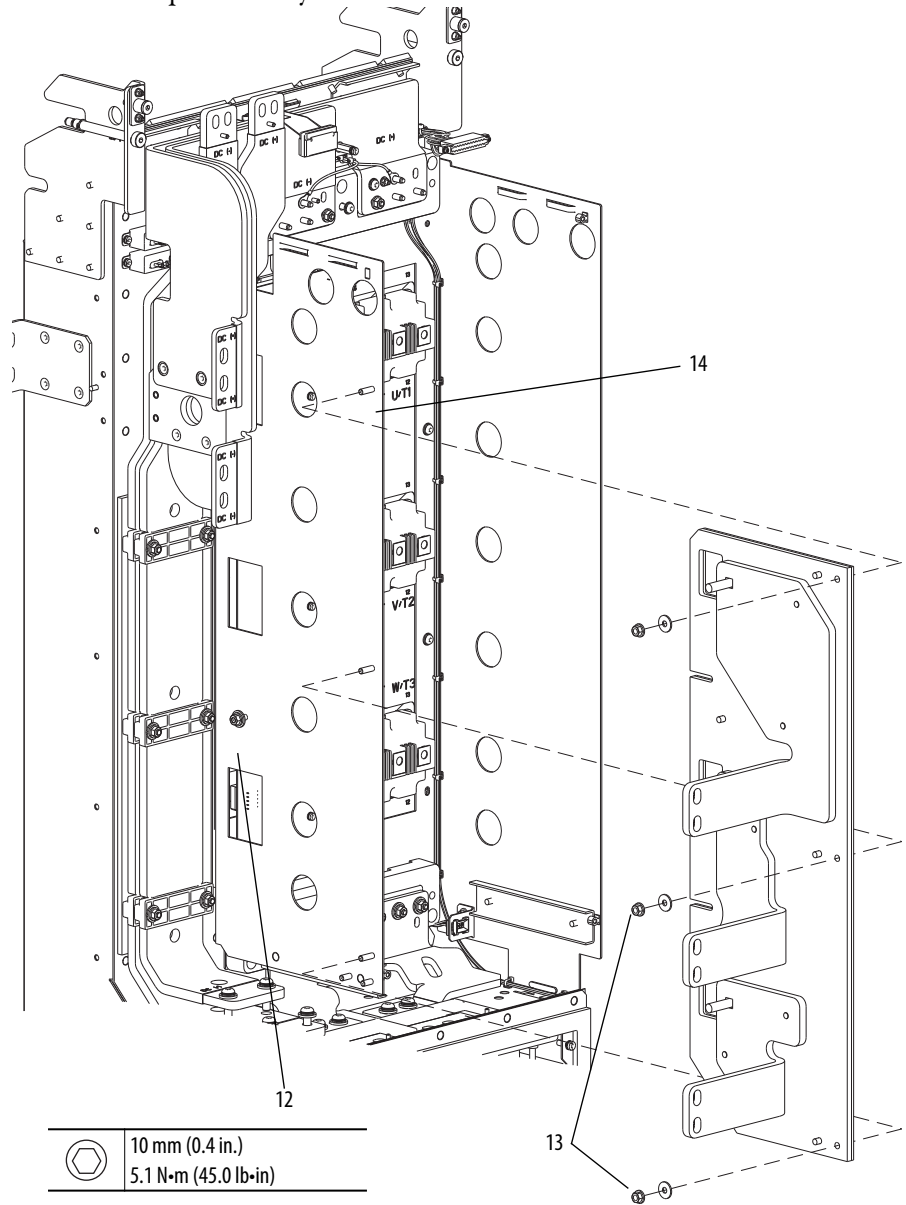
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the inverter assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
5. Remove the inverter front cover. See Remove the Inverter Front Cover on page [239](#).
6. Remove the current sensor mounting panel. See Remove the Inverter Current Sensors on page [240](#).
7. Remove the capacitor bank. See Remove the Inverter Capacitor Bank Assembly on page [246](#).
8. Remove the IGBT Flexbus bars. See Remove the IGBT Flexbus Bars on page [250](#).
9. Remove the two M4 hex nuts that secure the connections from the EMC capacitors to DC choke/converter bus bar assembly.




10. Remove the two M3 x 12 mm screws that secure the inverter wire harness connector to the backplane in the card cage.
11. Remove the two M4 x 10 mm screws that secure the card cage to the inverter frame and slide the card cage out and up to remove it.




12. Fully loosen, but do not remove, the two M6 hex nuts at the back edge of the AC output bus bar assembly.
13. Remove the three M6 screws that secure the front of the AC output assembly to the capacitor bank support.
14. Lift the assembly off the front three bolts and pull forward to remove the AC output assembly.



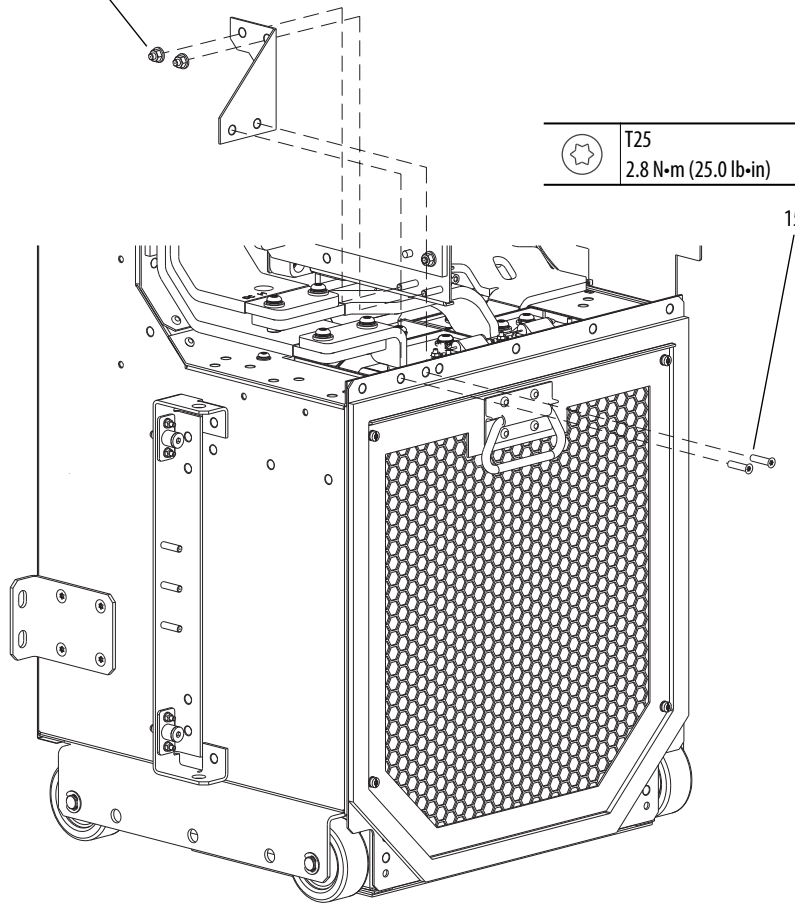
15. Remove the two M6 hex nuts and two M5 x 10 mm screws that secure the capacitor bank gusset to the capacitor bank support and drive chassis and remove the gusset.

	10 mm (0.4 in.)
	5.1 N·m (45.0 lb·in)

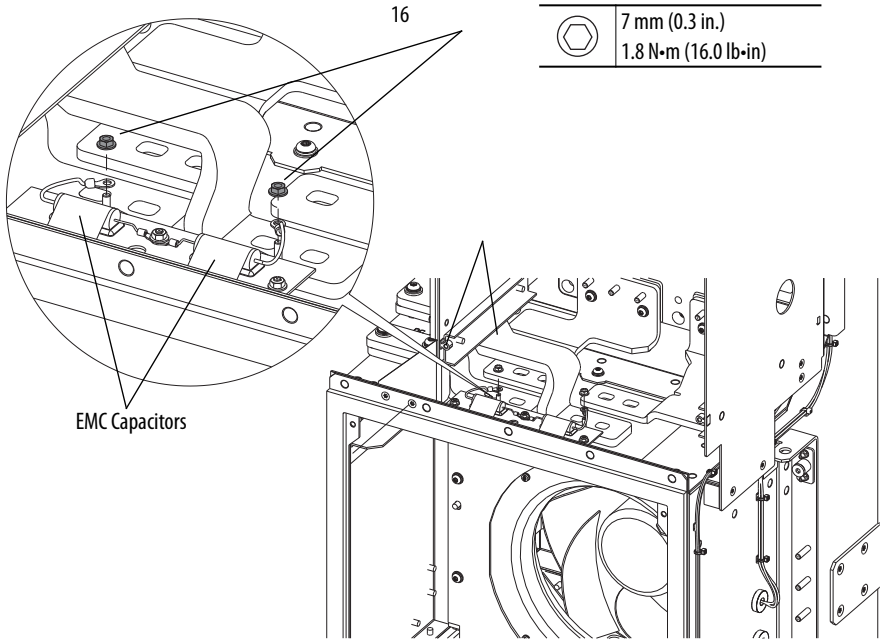
15

	T25
	2.8 N·m (25.0 lb·in)

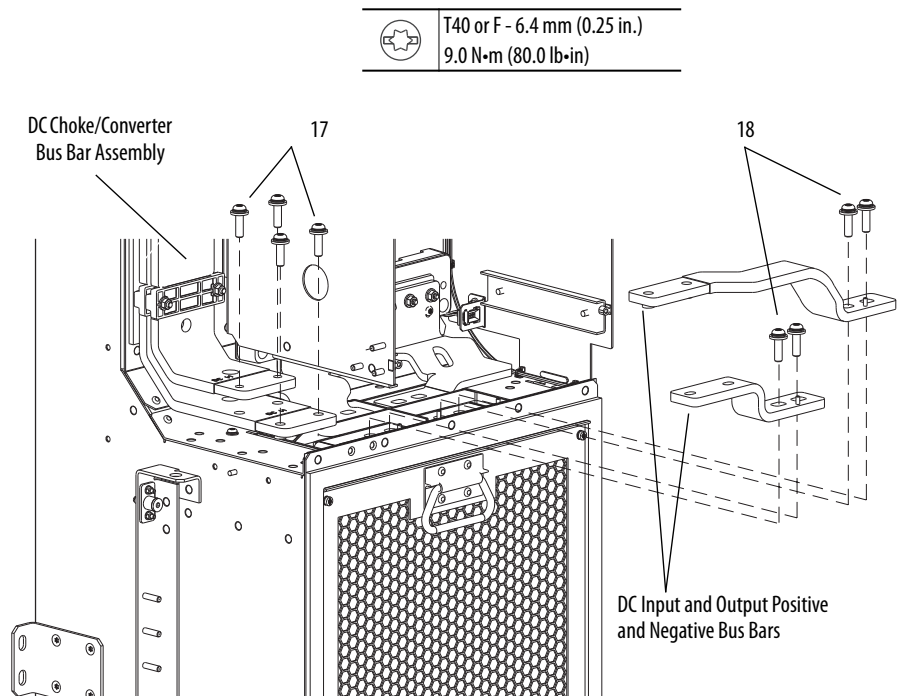
15



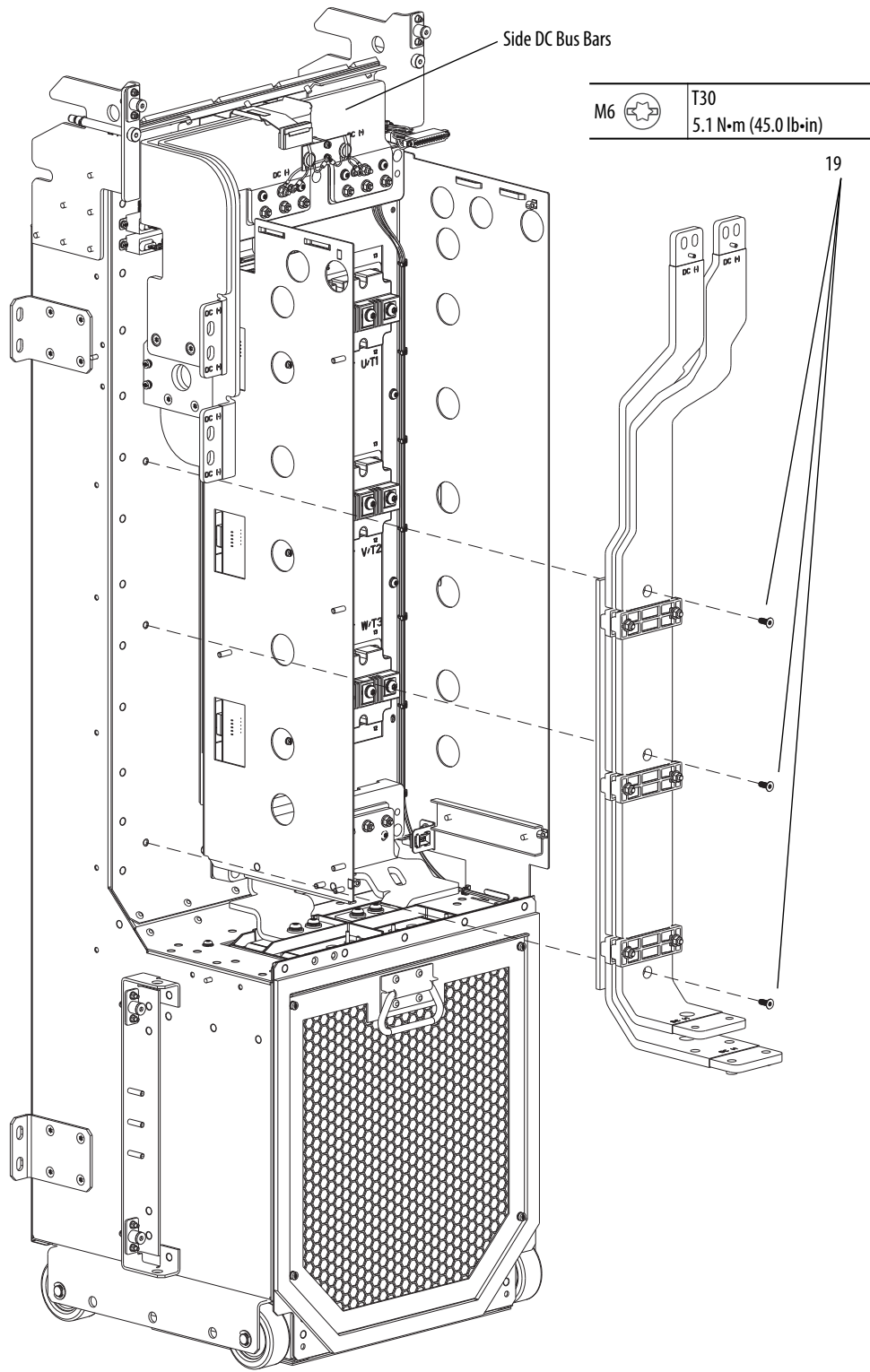
16. Remove the two M4 hex nuts that secure the connections from the EMC capacitors to the DC choke input positive and negative bus bars.



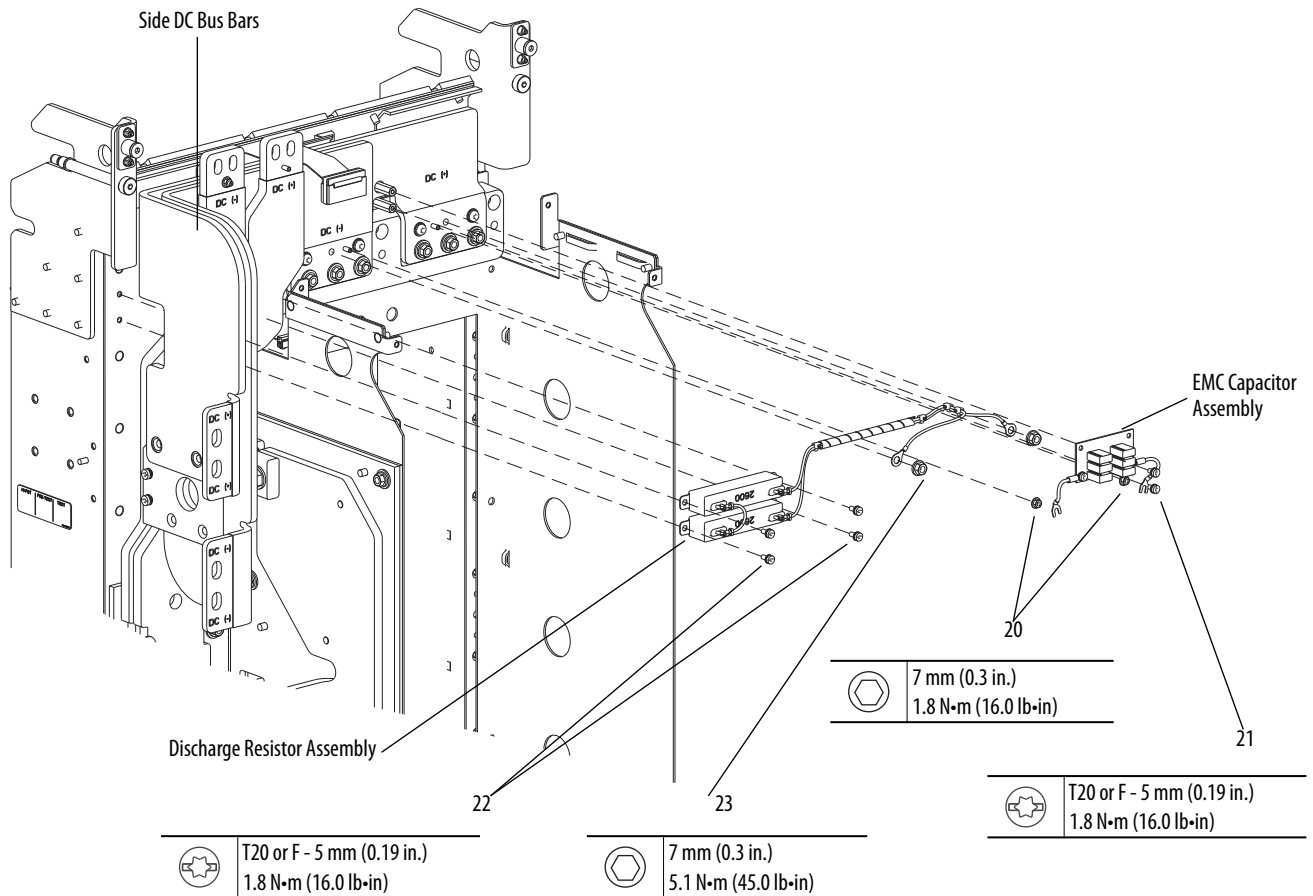
17. Remove the four M8 x 30 mm screws and four M8 flat washers that secure the bottom of the DC choke/converter bus bar assembly to the DC choke input positive and negative bus bars.
18. Remove the four M8 x 30 mm screws and M8 flat washers from the DC input and output positive and negative bus bars where they connect to the top of the DC choke and remove the bus bars.



19. Remove the three M6 x 16 mm screws that secure the DC choke/converter bus bar assembly to the chassis and remove the DC choke/converter bus bar assembly.



20. Remove the two M4 hex nuts that are used to secure the connections from the EMC capacitors to the side DC bus bar assembly.
21. Remove the two M4 x 8 mm screws that secure the EMC capacitor assembly to the standoffs on the capacitor bank support.
22. Remove the four M4 x 8 mm screws from the discharge resistors.
23. Remove the two M6 hex nuts from the wire connections on the side DC bus bars and remove the discharge resistor assembly.



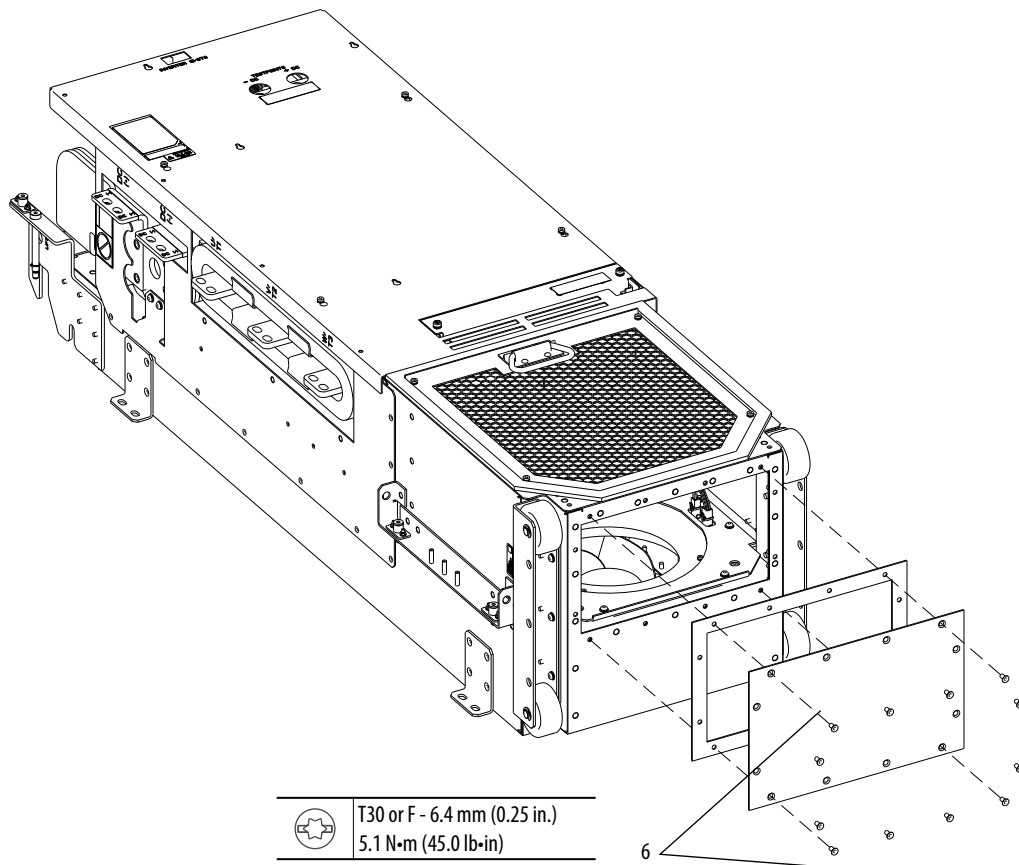
Install the Discharge Resistor Assembly

Install the discharge resistor assembly in the reverse order of removal. See Remove the Discharge Resistor Assembly on page [291](#).

Inverter Heatsink Fan Inlet Bottom Cover Removal/Installation

Remove the Inverter Heatsink Fan Inlet Bottom Cover

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the inverter assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
5. Lay the inverter on the back panel. See the Lifting instructions that are contained in the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#).
6. Remove the 12 M6 x 12 mm screws that secure the bottom cover and gasket to the inverter frame and remove the cover and gasket.



Install the Inverter Heatsink Fan Inlet Bottom Cover

1. Inspect the inlet bottom cover gasket for damage and replace it if necessary. See Inlet Bottom Cover Gasket Replacement on page [299](#).

2. Install the inverter heatsink fan-inlet bottom cover in the reverse order of removal. See Remove the Inverter Heatsink Fan Inlet Bottom Cover on page [298](#).

Inlet Bottom Cover Gasket Replacement

Remove the Inlet Bottom Cover Gasket

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the drive enclosure door.
4. Remove the inverter heatsink fan-inlet bottom cover. See Remove the Inverter Heatsink Fan Inlet Bottom Cover on page [298](#).
5. Carefully remove the gasket and any gasket material that may be stuck to the sealing surface.
6. Clean the chassis surface on which the gasket is installed with a 50% isopropyl alcohol / 50% water mixture.

Install the Inlet Bottom Cover Gasket

Note: One side of the duct gasket is coated with an adhesive. Take care to align the gasket properly before fully removing the paper liner and exposing the adhesive.

1. Begin removing the paper liner as you align the replacement gasket with the cover edges and press the gasket into place on the duct.
2. Install the inverter heatsink fan-inlet bottom cover. See Install the Inverter Heatsink Fan Inlet Bottom Cover on page [298](#).

Notes:

AC Input Drive Enclosure Component Replacement Procedures

Topic	Page
AC Input Drive Enclosure Components Identification	302
IP20, NEMA/UL Type 1 Debris Screen Removal/Installation	303
Exhaust Hood Removal/Installation	304
Top Conduit Plate Removal/Installation	305
IP20, NEMA/UL Type 1 Enclosure Door Fan Removal/Installation	306
IP20, NEMA/UL Type 1 Enclosure Door Fan Harness Removal/Installation	309
IP54, NEMA/UL Type 12 Cabinet Blower Wire Harness Removal/Installation	310
IP54, NEMA/UL Type 12 Cabinet Blower Exhaust Filters Removal/Installation	312
IP20, NEMA/UL Type 1 Door Filter Removal/Installation	313
IP54, NEMA/UL Type 12 Cabinet Door Filters Removal/Installation	314
IP54, NEMA/UL Type 12 Cabinet-door Filter Cassette Removal/Installation	316
IP54, NEMA/UL Type 12 Cabinet Door Gasket Removal/Installation	317
DC Bus Fuse Wire Harness Removal/Installation (Frame 9 and Larger Drives Only)	318
DC Bus Fuses and Fuse Indicators Removal/Installation (Frame 9 and Larger Drives Only)	320
Input Common-mode Core Removal/Installation (Frame 9 and Larger, Common DC Input Drives Only)	323
Cabinet L Bus Bars Removal/Installation	326
Cabinet Door EMC Shield Removal/Installation (Frame 10 Drives Only)	327

This chapter provides detailed procedures for how to remove and replace AC input drive and common drive enclosure components.

Note: For detailed removal and installation instructions for the IP54, NEMA/UL Type 12 cabinet blower assembly, see the PowerFlex® 755 AC Drives Cabinet Blower Assembly Kit - Frames 8...10 Installation Instructions, publication [750-IN026](#).

AC Input Drive Enclosure Components Identification

This table contains the components that comprise the AC input drive and provides the following information for each component, if applicable:

- Kit catalog number or part number
- Quantity that is contained in the kit

See PowerFlex Architecture Class Low Voltage Drives Spare Parts Options, publication [PFLEX-SB002](#) for a complete list of spare parts for PowerFlex 755 Frame 8...10 drives.

IMPORTANT Use only Rockwell Automation provided filters, gaskets, and components. Use of third-party components is not supported.

Table 15 - AC Input Drive Enclosure Replacement Kits/Parts

Component Description	Replacement Kit Cat. No. or Part No.	Qty.
IP20, NEMA/UL Type 1 Door Filter	20-750-FLTR1-F8	1
IP54, NEMA/UL Type 12 Cabinet Blower Exhaust Filter, Fiber (Single Pair)	SK-R1-FLTR2-F8	2
IP54, NEMA/UL Type 12 Cabinet Blower Exhaust Filter, Fiber (12 Pairs)	SK-R1-FLTR2M-F8	24
IP54, NEMA/UL Type 12 Cabinet Door Filter Cassette	SK-R1-FLTRFRM-F8	1
IP54, NEMA/UL Type 12 Cabinet Door Inlet Filter, Pleated (Single Piece)	SK-R1-FLTR3-F8	1
IP54, NEMA/UL Type 12 Cabinet Door Inlet Filter, Pleated (12 Pieces)	SK-R1-FLTR3M-F8	12
IP54, NEMA/UL Type 12 Cabinet Door Inlet Filter, Metal Mesh	SK-R1-FLTR4-F8	1
IP54, NEMA/UL Type 12 Cabinet Door Gasket	SK-R1-G2-F8	1
IP20, NEMA/UL Type 1 Debris Screen	SK-R1-GRILL1-F8	1
⁽¹⁾ Exhaust Hood	20-750-HOOD1-F8	1
Top Conduit Plate 600 mm	SK-R1-CPLT1-F8	1
Top Conduit Plate 800 mm	SK-R1-CPLT2-F8	1
IP20, NEMA/UL Type 1 Door Fan with Finger Guard	20-750-FAN3-F8	1
IP20, NEMA/UL Type 1 Door Fan Harness	SK-R1-FANH1-F8	1
IP54, NEMA/UL Type 12 Cabinet Blower Assembly	SK-R1-FAN4-F8	1
IP54, NEMA/UL Type 12 Cabinet Blower Harness	SK-R1-FANH4-F8	1
DC Bus Fuse, 1400 A	SK-R1-FUSE3-F9	1
DC Bus Fuse Wire Harness	SK-R1-DCBUSH1-F9	1
Cabinet L Bus Bar	20-750-LBRKT1	1
Cabinet Door Shield Kit (Frame 10)	20-750-EMCDK1-F10	15

(1) Included with IP54 enclosure, optional for IP20 enclosure.

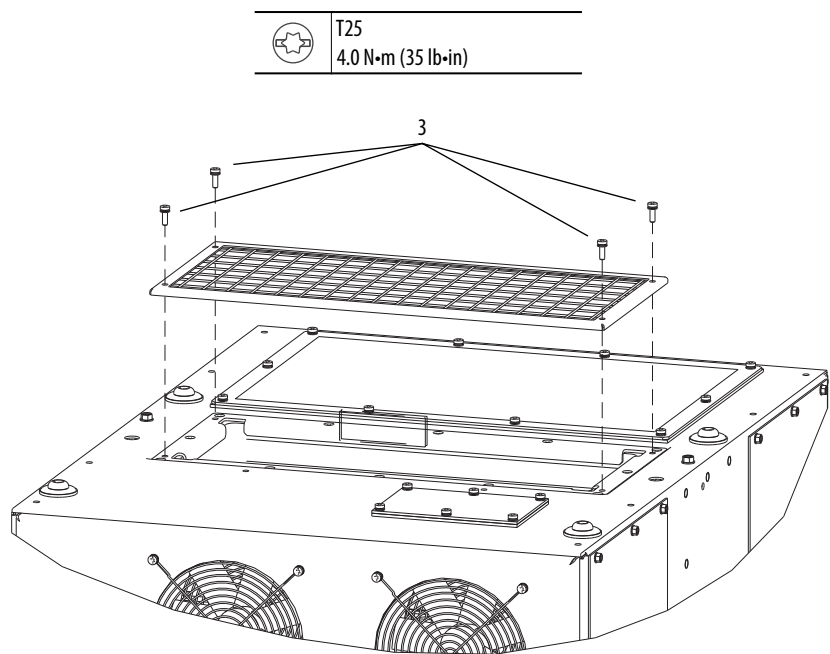
TIP See Fastener/Tool/Torque Information on page [33](#) for descriptions of the fasteners, tools, and torque figures that are used in the disassembly/assembly procedures in this chapter.

IP20, NEMA/UL Type 1 Debris Screen Removal/Installation

Remove the Debris Screen

Note: This procedure applies to both AC input and Common DC input drive enclosures.

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Remove the four M5 x 16 screws that secure the debris screen to the top of the enclosure and remove the screen.




Install the Debris Screen

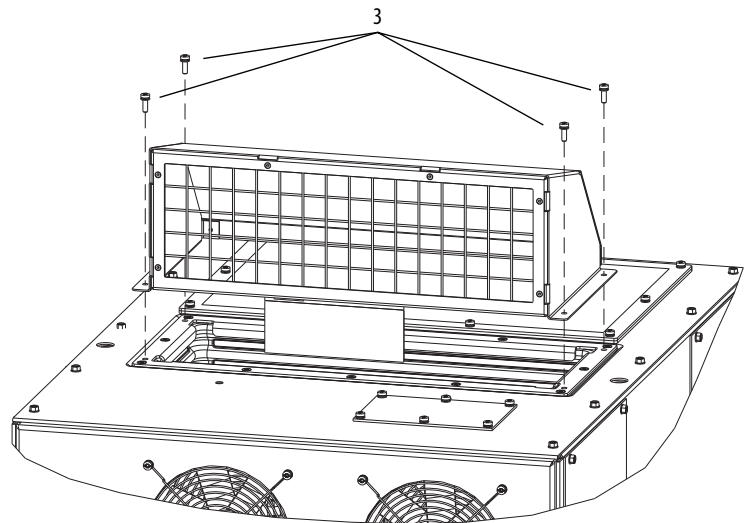
Install the debris screen in the reverse order of removal. See Remove the Debris Screen.

Exhaust Hood Removal/ Installation

Remove the Exhaust Hood

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Remove the four M5 x 16 screws that secure the exhaust hood to the top of the enclosure and remove the hood.

	T25 4.0 N•m (35 lb•in)
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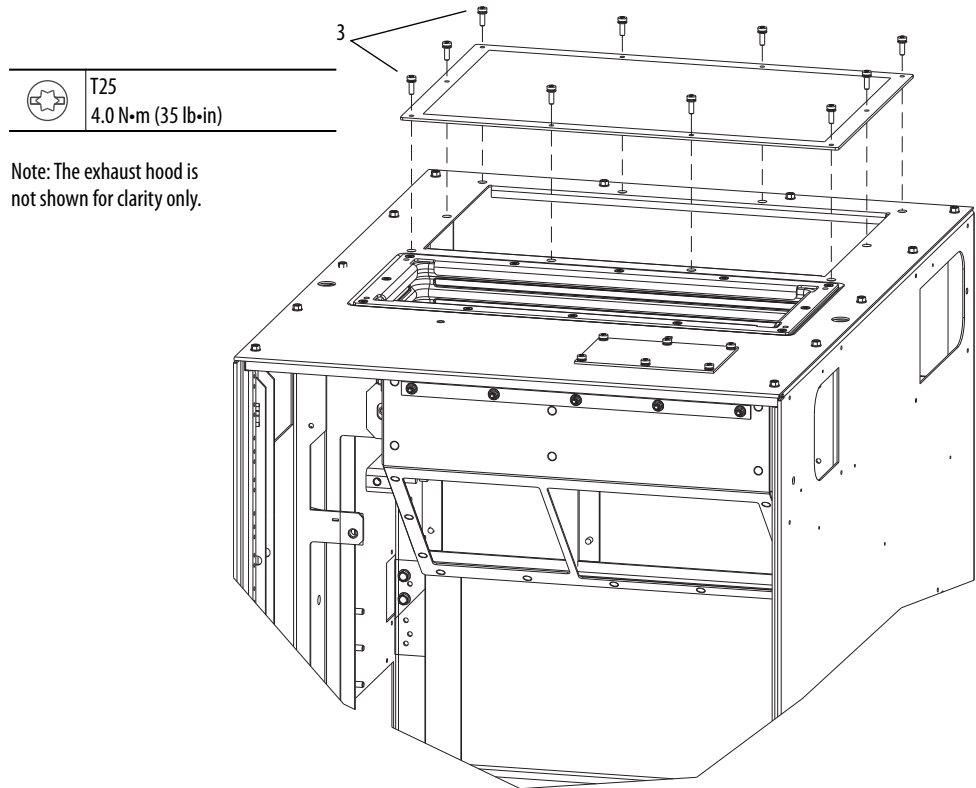
Install the Exhaust Hood

Install the exhaust hood in the reverse order of removal. See Remove the Exhaust Hood.

Top Conduit Plate Removal/ Installation

Remove the Top Conduit Plate

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Remove the eight (for 600 mm deep enclosures) or ten (for 800 mm deep enclosures) M5 x 16 screws that secure the conduit plate to the top of the enclosure and remove the plate.



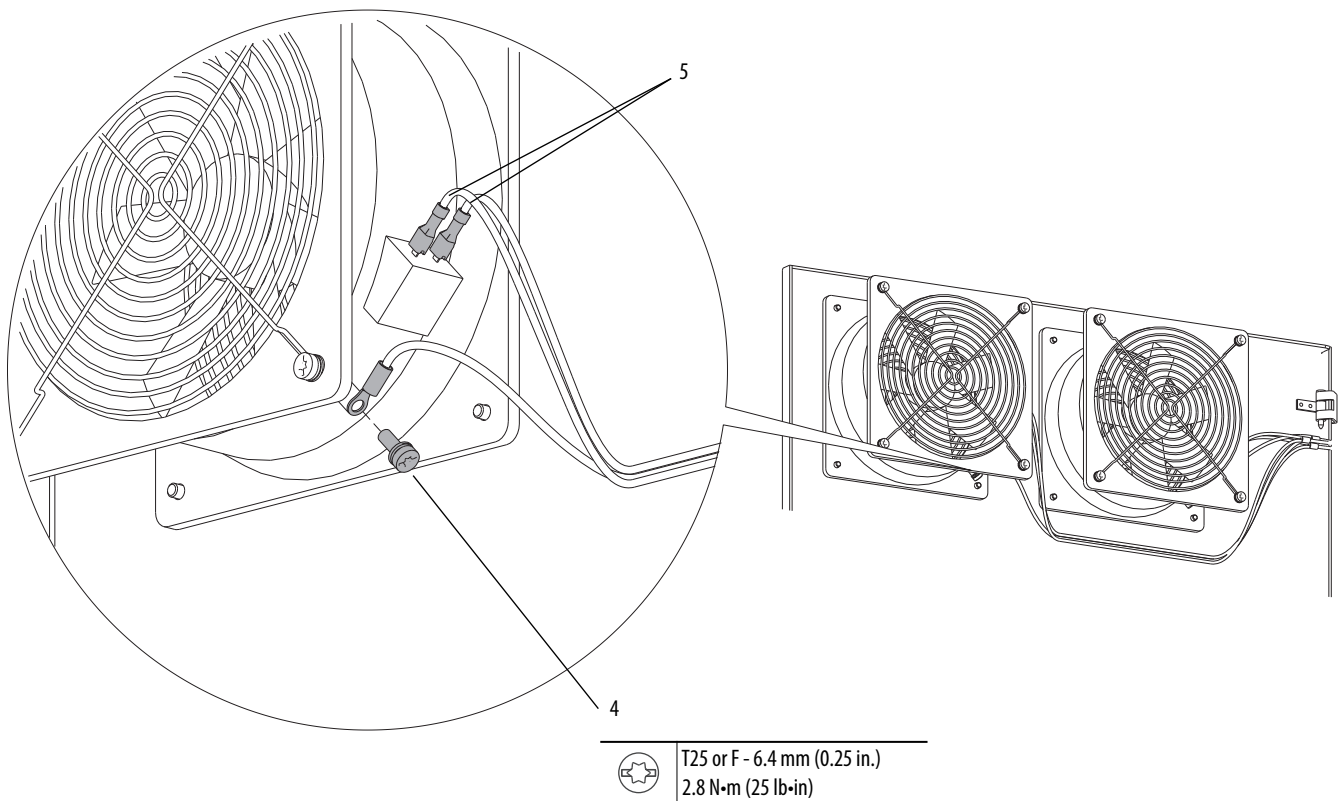
Install the Top Conduit Plate

Install the top conduit plate in the reverse order of removal. See Remove the Top Conduit Plate.

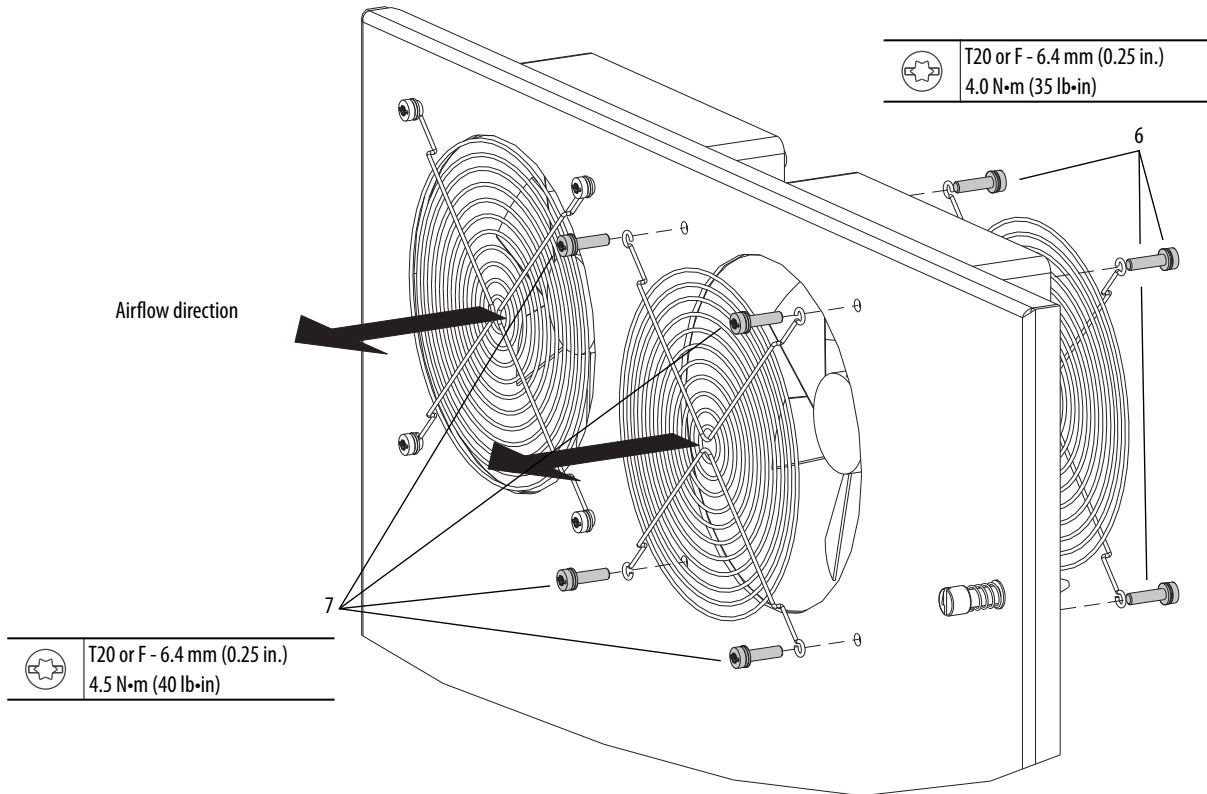
IP20, NEMA/UL Type 1 Enclosure Door Fan Removal/ Installation

Remove the Enclosure Door Fan

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the M5 x 8 mm screw that secures the fan-power harness ground wire to the fan and remove the ground wire. Retain the screw for reuse.
5. Disconnect the Fan (+) and Fan (-) power wires from the fan terminals.



6. Remove the four M5 x 20 screws that secure the inner guard to the fan housing and remove the guard.
7. Remove the four M5 x 20 screws that secure the outer fan guard and fan to the enclosure door and remove the outer fan guard and fan.

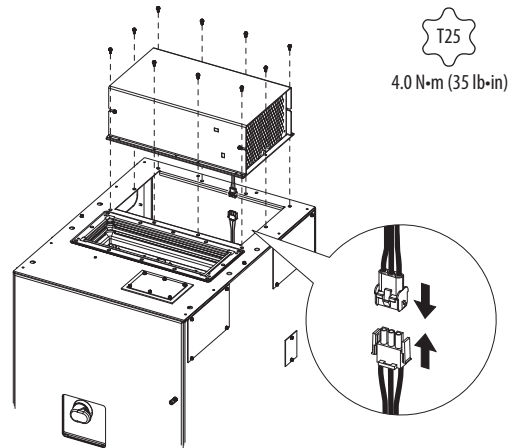


IP54, NEMA 12 Cabinet Blower Assembly and Exhaust Hood Removal/ Installation

Remove the Enclosure Door Fan

IP54, NEMA 12 drives are equipped with a top mounted blower assembly and exhaust hood.

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Remove the ten screws that secure the blower to the drive.
4. Remove the four screws that anchor the exhaust hood to the blower unit.
5. Remove the exhaust hood.



Install the Enclosure Door Fan

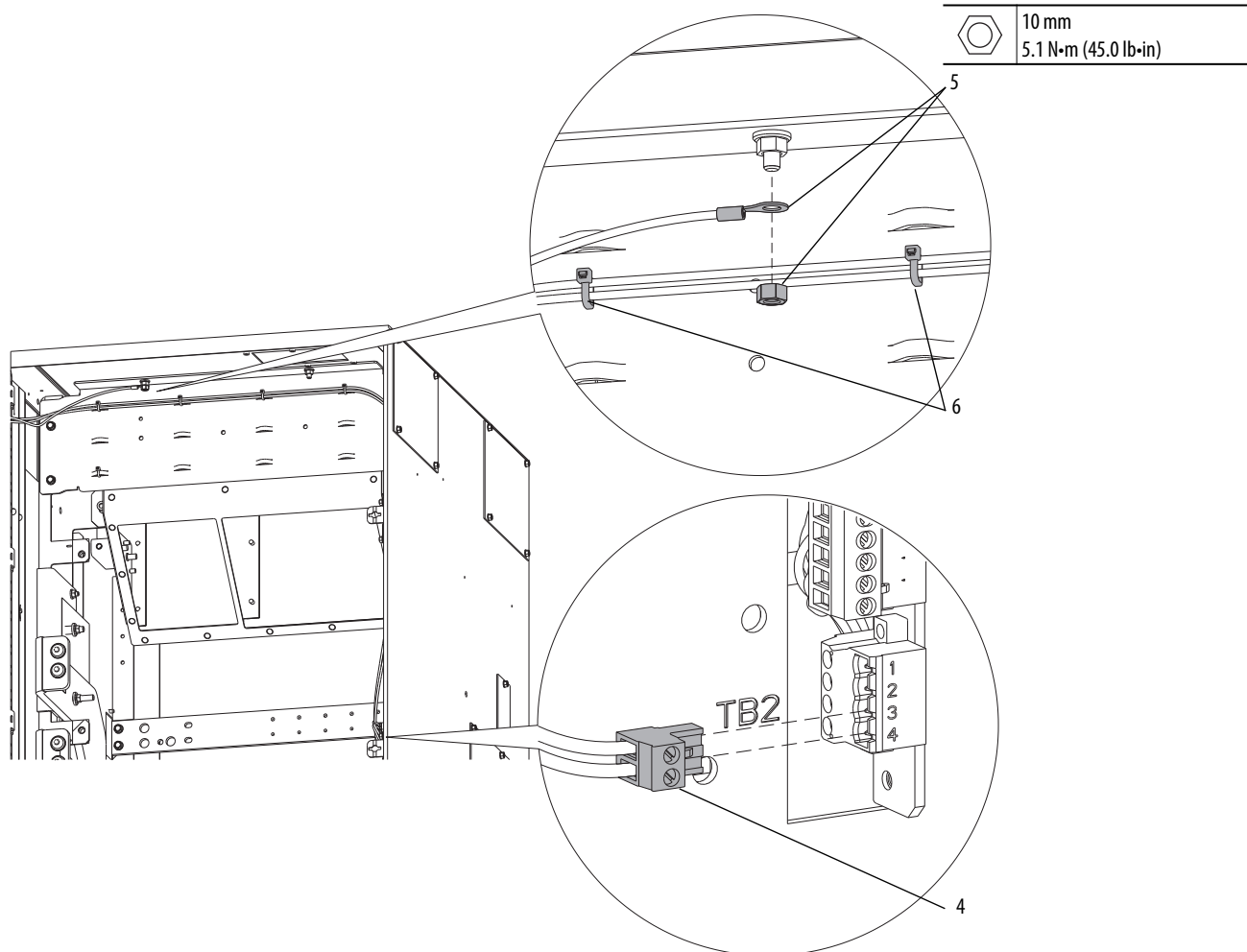
Install the enclosure door fan in the reverse order of removal. See Remove the Enclosure Door Fan on page [306](#).

IMPORTANT When installing a new fan, verify that the airflow direction arrow on the fan points toward the exterior of the drive enclosure.

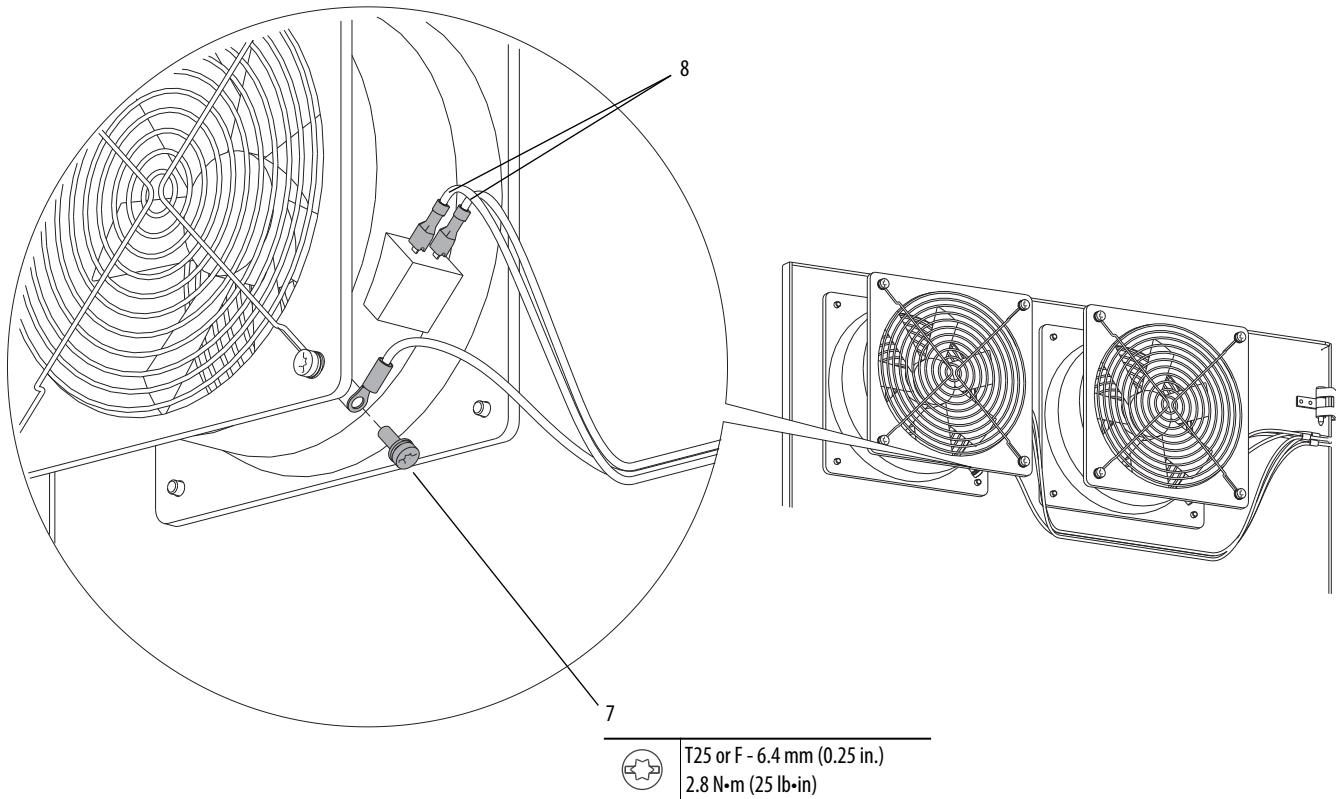
IP20, NEMA/UL Type 1 Enclosure Door Fan Harness Removal/Installation

Remove the Enclosure Door Fan Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Disconnect the two-position, fan power connector from terminal TB2-3 and TB2-4 on the outside, right wall of the drive control panel.
5. Remove the M6 grounding nut from the enclosure wireway ceiling.
6. Cut the cable ties on the enclosure wireway.



7. Remove the M5 x 8 mm screw that secures the fan-power harness ground wires to each of the fans and remove the ground wires.
8. Disconnect the Fan (+) and Fan (-) power wires from the terminals on both fans and remove the fan harness.



Install the Enclosure Door Fan Wire Harness

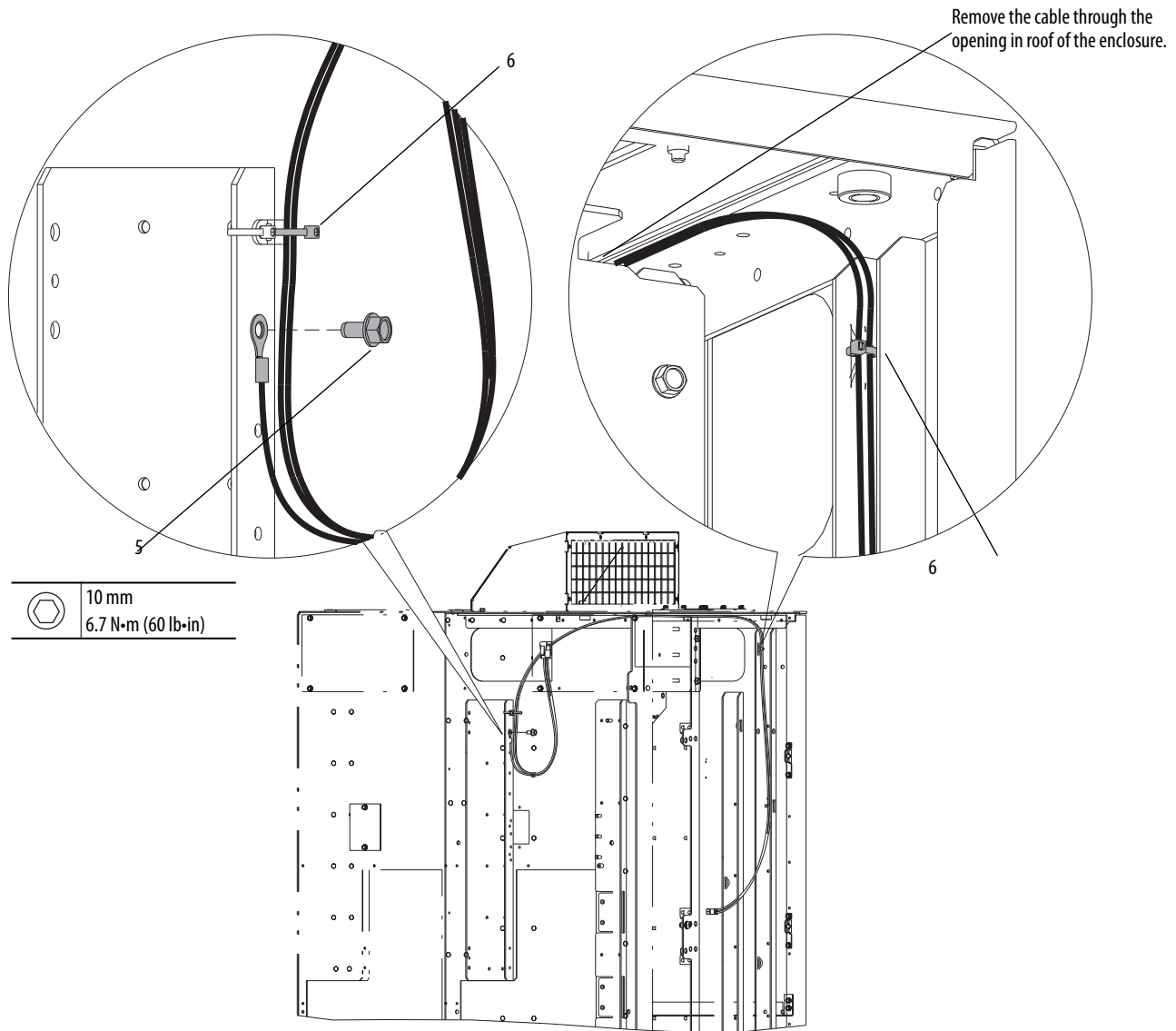
Install the enclosure door fan harness in the reverse order of removal. See Remove the Enclosure Door Fan Wire Harness on page [309](#).

IP54, NEMA/UL Type 12 Cabinet Blower Wire Harness Removal/Installation

Remove the Cabinet Blower Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Remove the drive assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.

4. Remove the blower assembly from the drive. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
5. Remove the M6 x 12 mm screw that secures the wire harness ground wire to the cabinet.
6. Cut all cable ties that secure the blower wire harness to the cabinet and remove the wire harness.



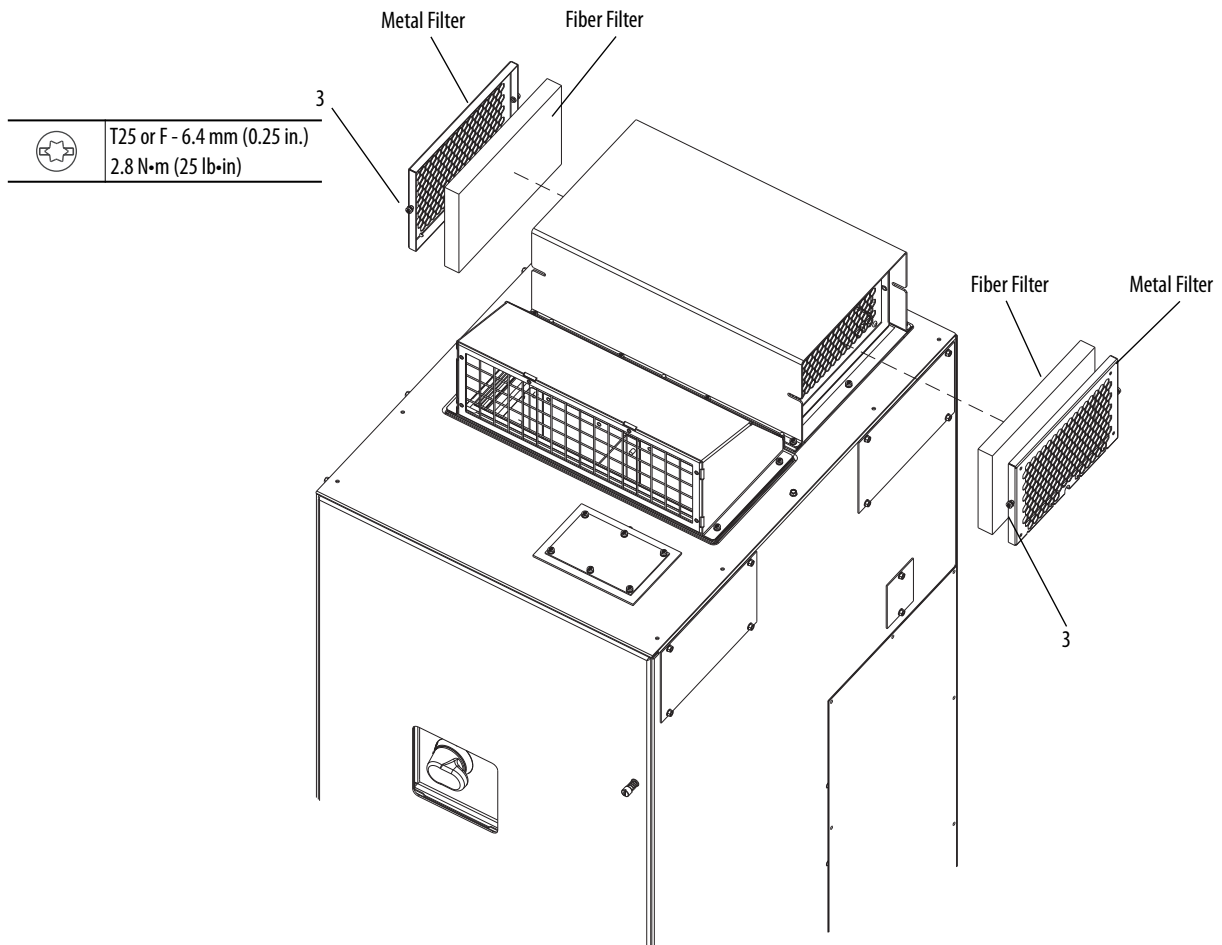
Install the Cabinet Blower Wire Harness

Install the cabinet blower wire harness in the reverse order of removal. See [Remove the Cabinet Blower Wire Harness](#) on page [310](#).

IP54, NEMA/UL Type 12 Cabinet Blower Exhaust Filters Removal/Installation

Remove the Cabinet Blower Exhaust Filters

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Loosen the two hexalobular screws that secure each of the outer metal mesh filters to the blower assembly and remove the outer metal and inner fiber filters from the blower.



Install the Cabinet Blower Exhaust Filters

Install the cabinet blower exhaust filters in the reverse order of removal. See Remove the Cabinet Blower Exhaust Filters on page [312](#).

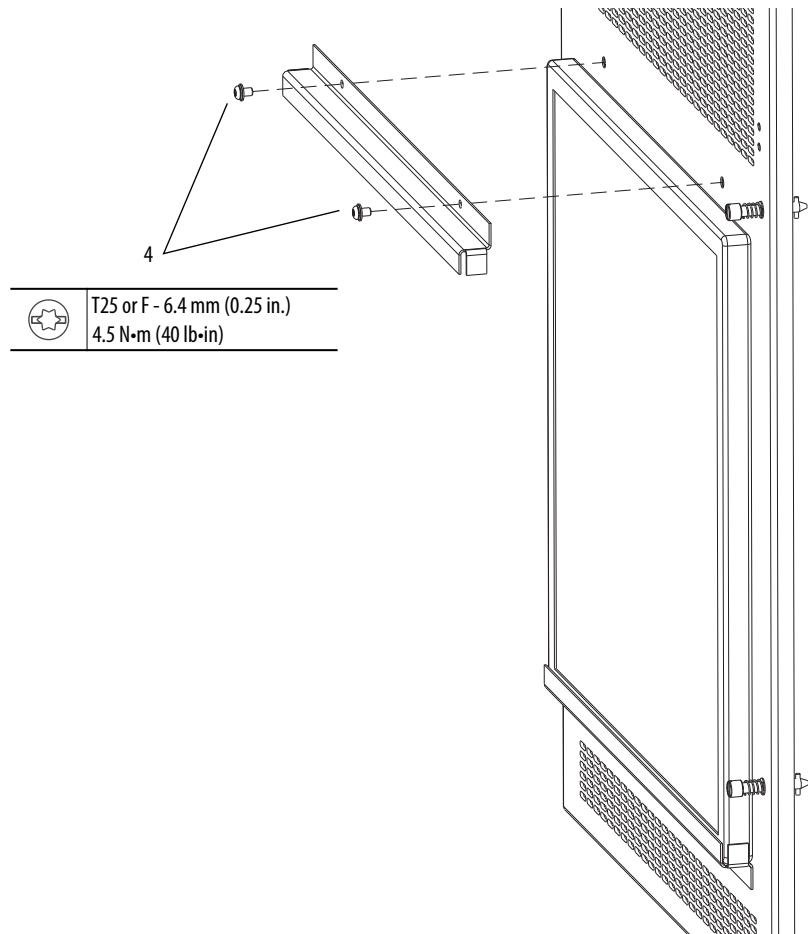
For more information on the removal and installation of the cabinet blower, see PowerFlex 755 AC Drives Cabinet Blower Assembly, publication [750-IN026](#).

IP20, NEMA/UL Type 1 Door Filter Removal/Installation

Remove the IP20 Door Filter

Note: This procedure applies to both AC input and Common DC input drive enclosures.

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Remove the two M6 x 16 mm screws that secure the filter bracket to the enclosure door and remove the bracket.
4. Remove the filter from the holder.



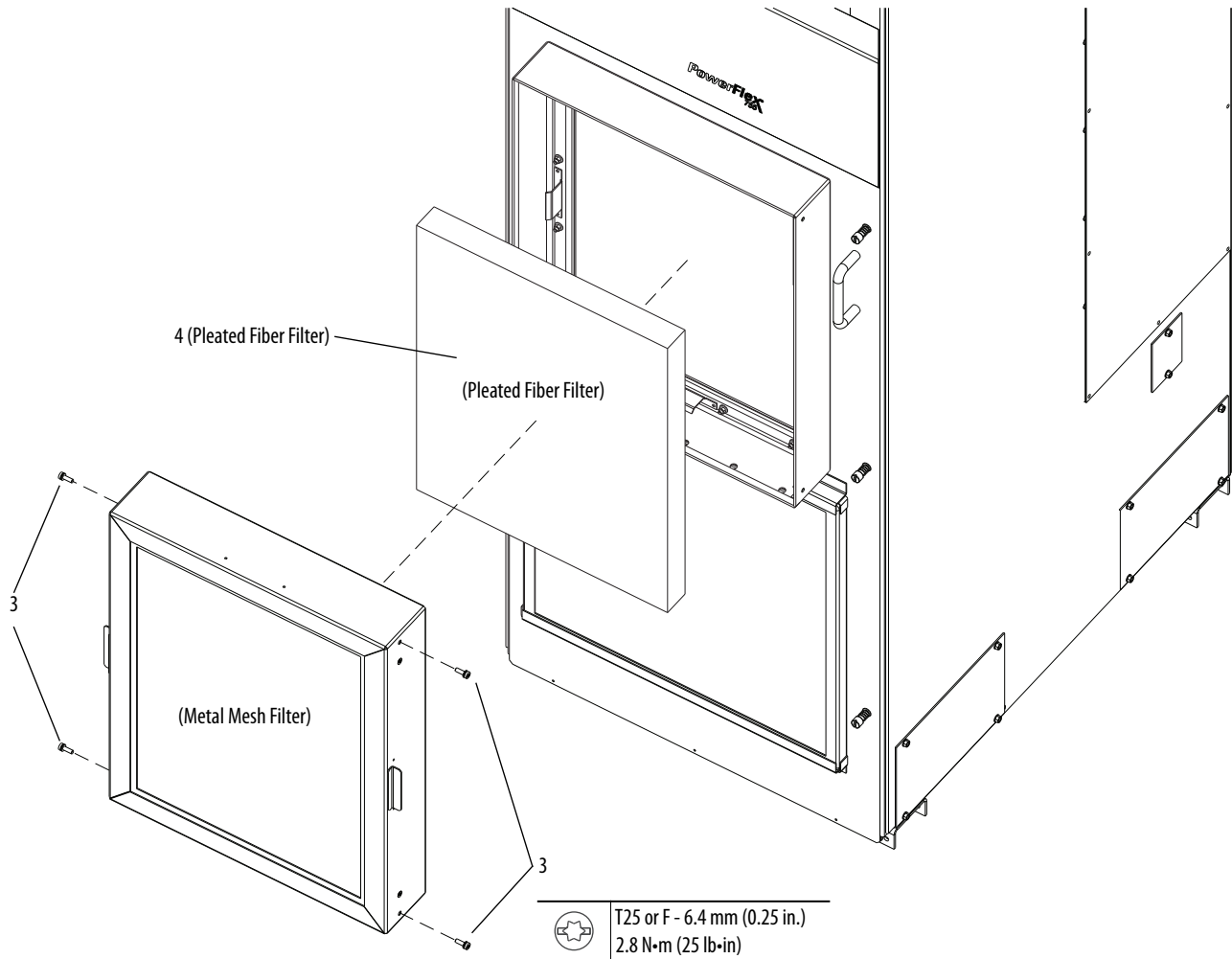
Install the Door Filter

Install the door filter in the reverse order of removal. See Remove the IP20 Door Filter.

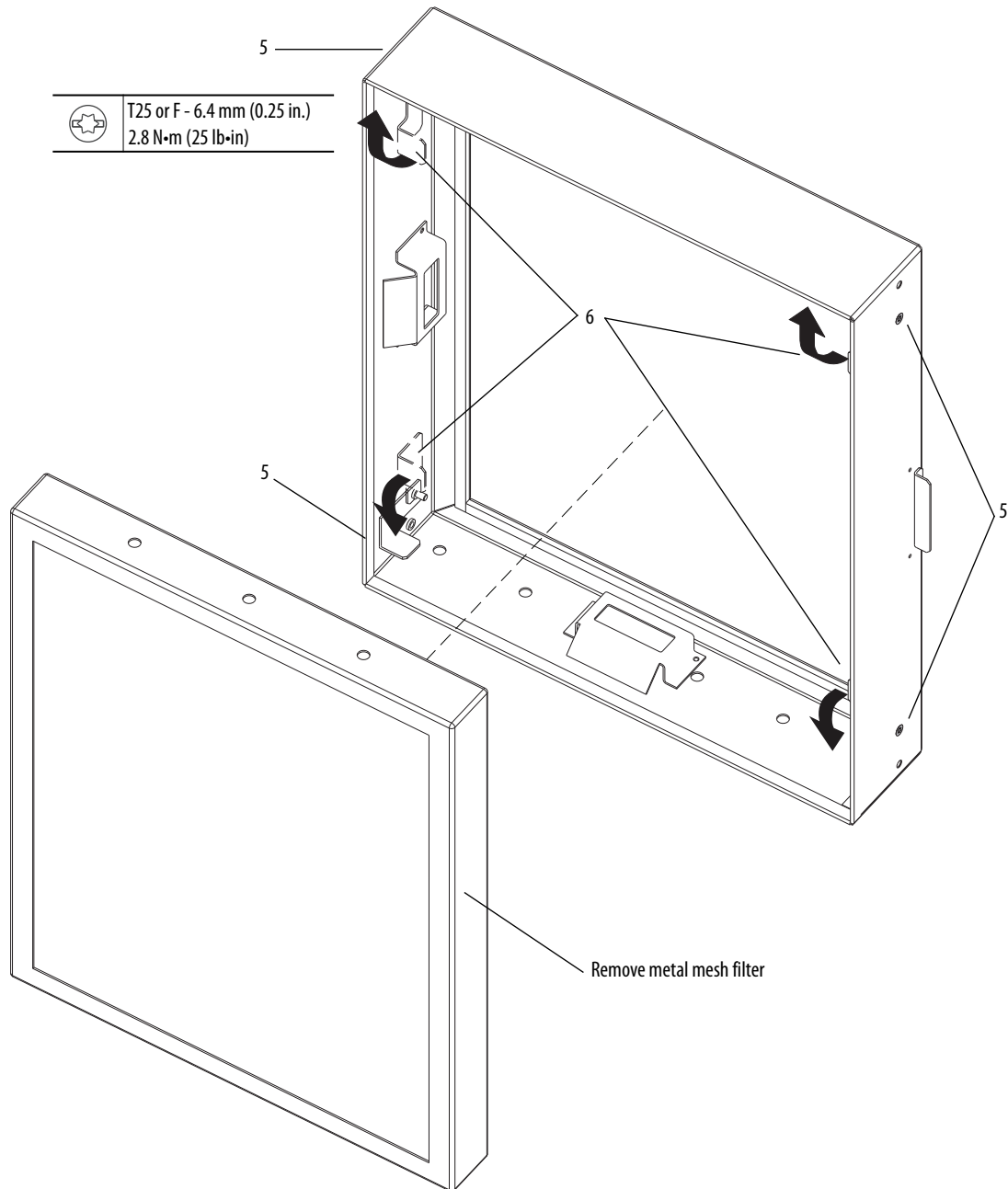
IP54, NEMA/UL Type 12 Cabinet Door Filters Removal/Installation

Remove the Cabinet Door Filters

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Remove the four hexalobular screws that secure the filter cassette cover and metal mesh filter to the filter cassette chassis and remove the cover.
4. Remove the pleated fiber filter from the cassette on the cabinet door.



5. Loosen the four hexalobular screws on the outside walls of the cassette chassis that secure the metal mesh filter to the chassis.
6. Rotate the four metal latches on the inside wall of the cassette chassis and remove the filter.



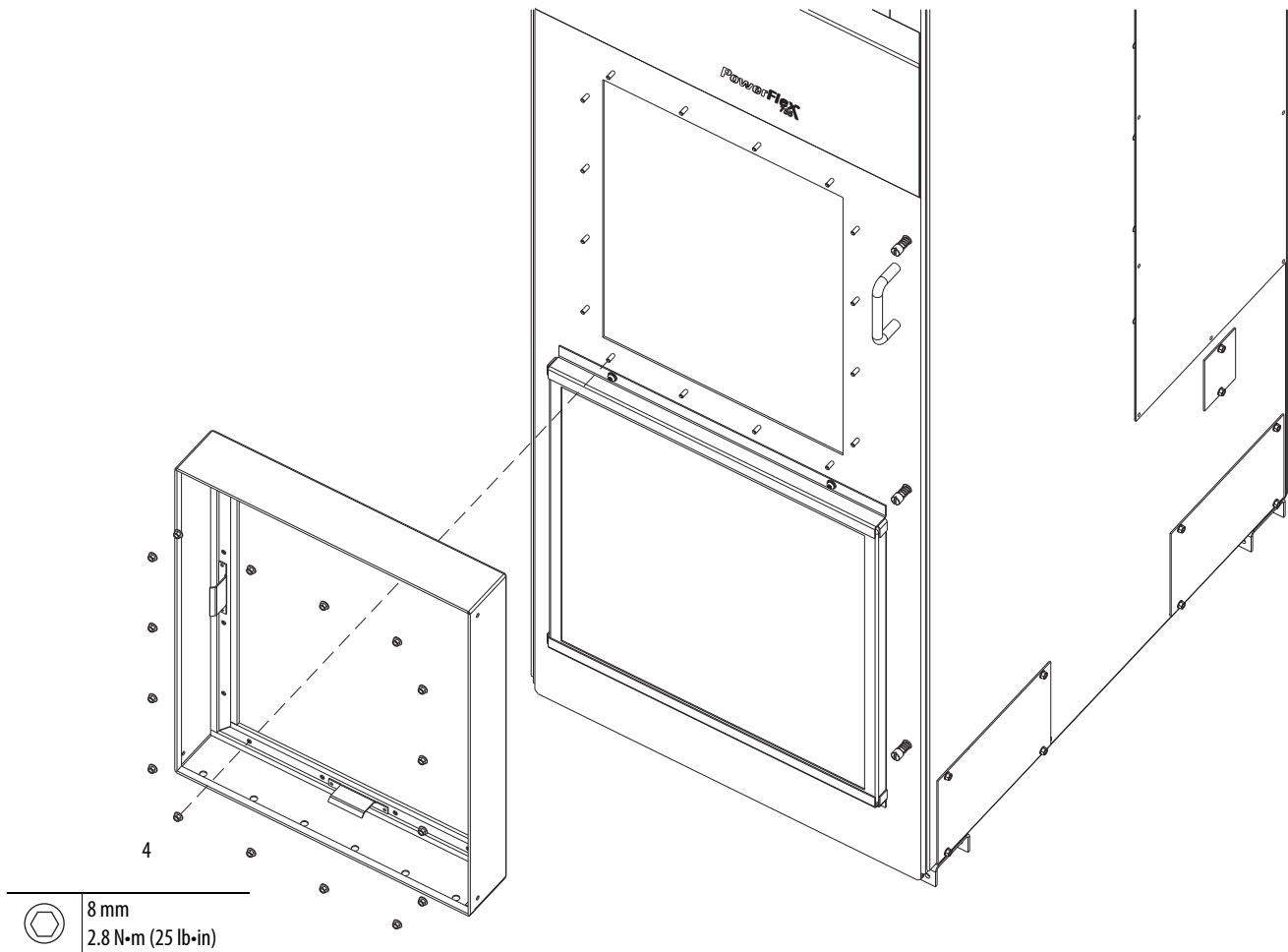
Install the Cabinet Door Filters

Install the cabinet door filters in the reverse order of removal. See Remove the Cabinet Door Filter Cassette on page [316](#).

IP54, NEMA/UL Type 12 Cabinet-door Filter Cassette Removal/Installation

Remove the Cabinet Door Filter Cassette

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Remove the cabinet door filters. See IP54, NEMA/UL Type 12 Cabinet Door Filters Removal/Installation on page [314](#).
4. Remove the 16-hex nuts that secure the filter cassette chassis to the cabinet door and remove the chassis.



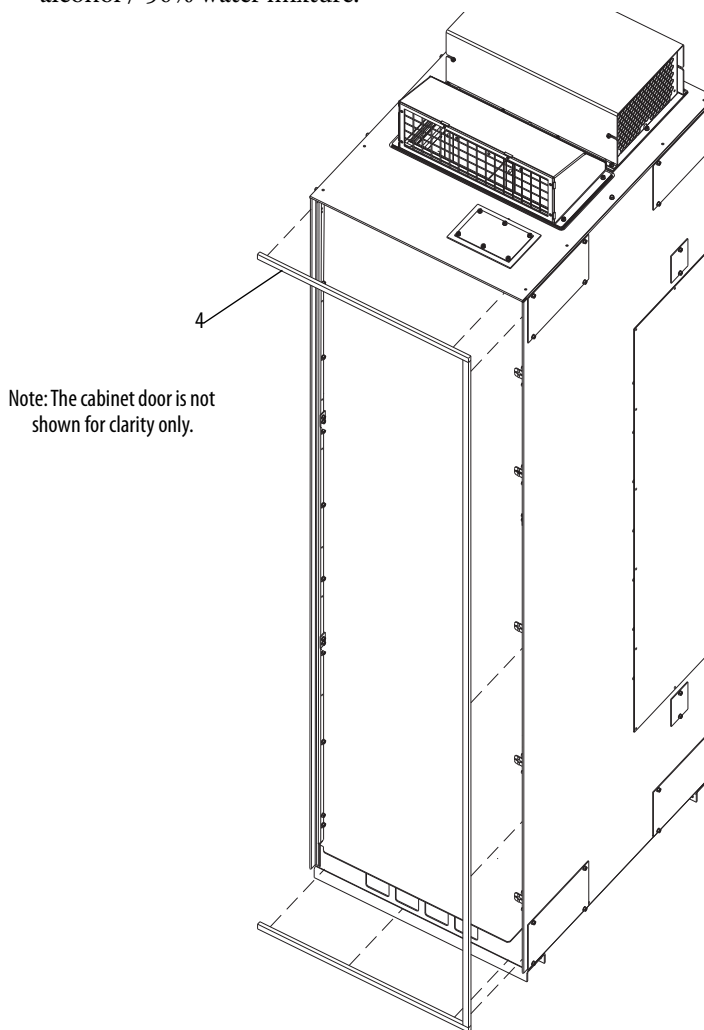
Install the Cabinet Door Filter Cassette

Install the cabinet door filter cassette in the reverse order of removal. See Remove the Cabinet Door Filter Cassette on page [316](#).

IP54, NEMA/UL Type 12 Cabinet Door Gasket Removal/Installation

Remove the Cabinet Door Gasket

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Carefully remove the gasket and any gasket material that may be stuck to the sealing surface.
5. Clean the surface on which the gasket is installed with a 50% isopropyl alcohol / 50% water mixture.



Note: The cabinet door is not shown for clarity only.

Install the Cabinet Door Gasket

Note: One side of the door gasket is coated with an adhesive. Take care to align the gasket properly before fully removing the paper liner and exposing the adhesive.

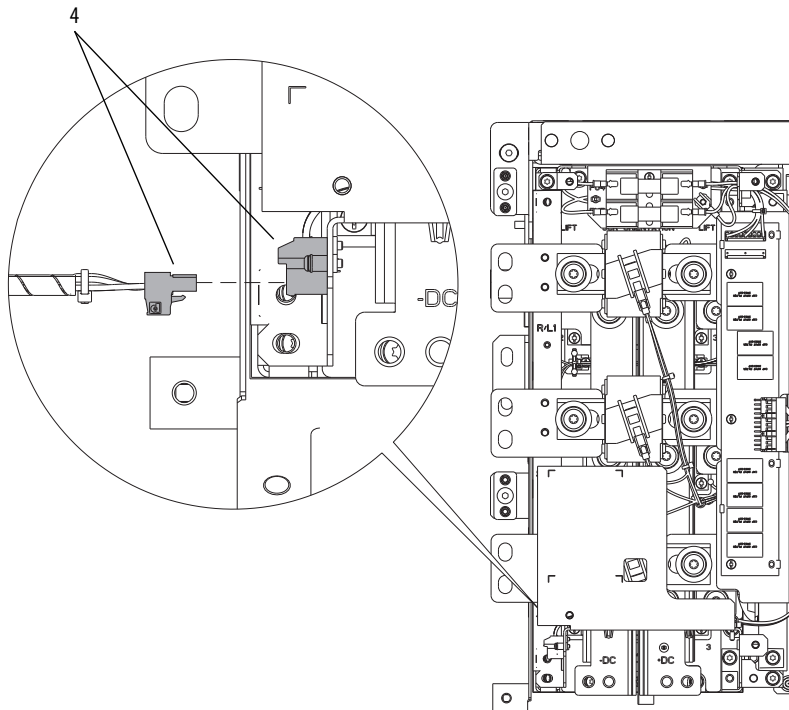
- Begin removing the paper liner as you align the replacement gasket with the cabinet edges and press the gasket into place.

DC Bus Fuse Wire Harness Removal/Installation (Frame 9 and Larger Drives Only)

Remove the DC Bus Fuse Wire Harness

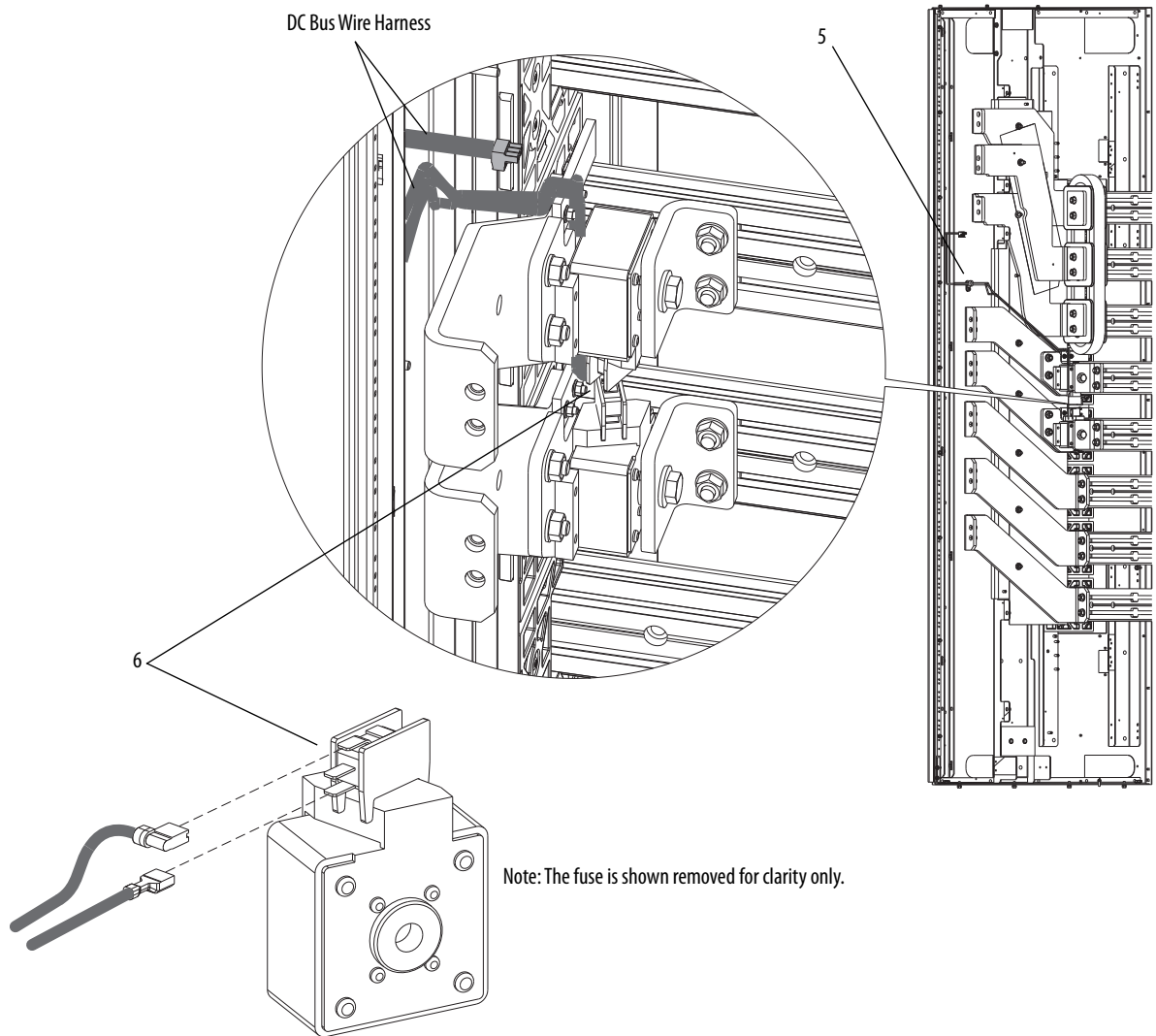
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. The DC bus fuses and fuse indicators, to which the wire harness is connected, are at the back of the drive enclosure. Therefore, the drive assemblies must be removed from the enclosure. Remove the drive assemblies from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.

IMPORTANT You must first remove the wiring as detailed in the PowerFlex 750-Series AC Drive Installation Instructions. Then, you must disconnect the three-position, DC bus fuse wire harness connector from terminal block TB6 on the lower left side of the converter (as shown here).



Note: The converter is shown removed from the drive enclosure for clarity only.

5. Unlock the cable support on the left wall of the drive enclosure and release the DC bus wire harness from the support.
6. Remove the DC bus wire harness leads from the fuse indicators and remove the wire harness.



Install the DC Bus Fuse Wire Harness

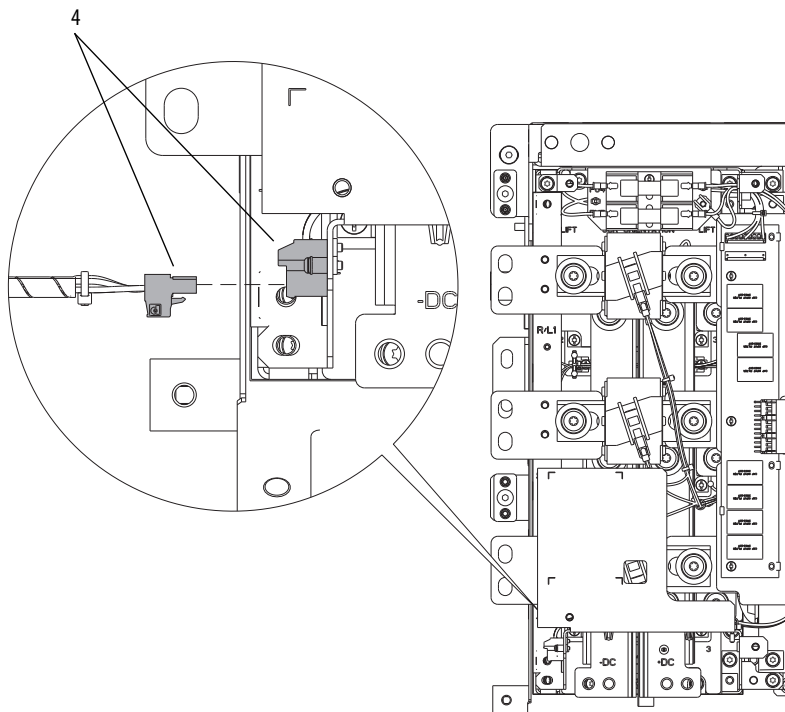
Install the DC Bus Fuse Wire Harness in the reverse order of removal. See Remove the DC Bus Fuse Wire Harness on page [318](#).

DC Bus Fuses and Fuse Indicators Removal/ Installation (Frame 9 and Larger Drives Only)

Remove the DC Bus Fuses and Fuse Indicators

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. The DC bus fuses and fuse indicators are at the back of the drive enclosure. Therefore, the drive assemblies must be removed from the enclosure. Remove the drive assemblies from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.

IMPORTANT You must first remove the wiring as detailed in the PowerFlex 750-Series AC Drive Installation Instructions. Then, you must disconnect the three-position, DC bus fuse wire harness connector from terminal block TB6 on the lower left side of the converter (as shown here).

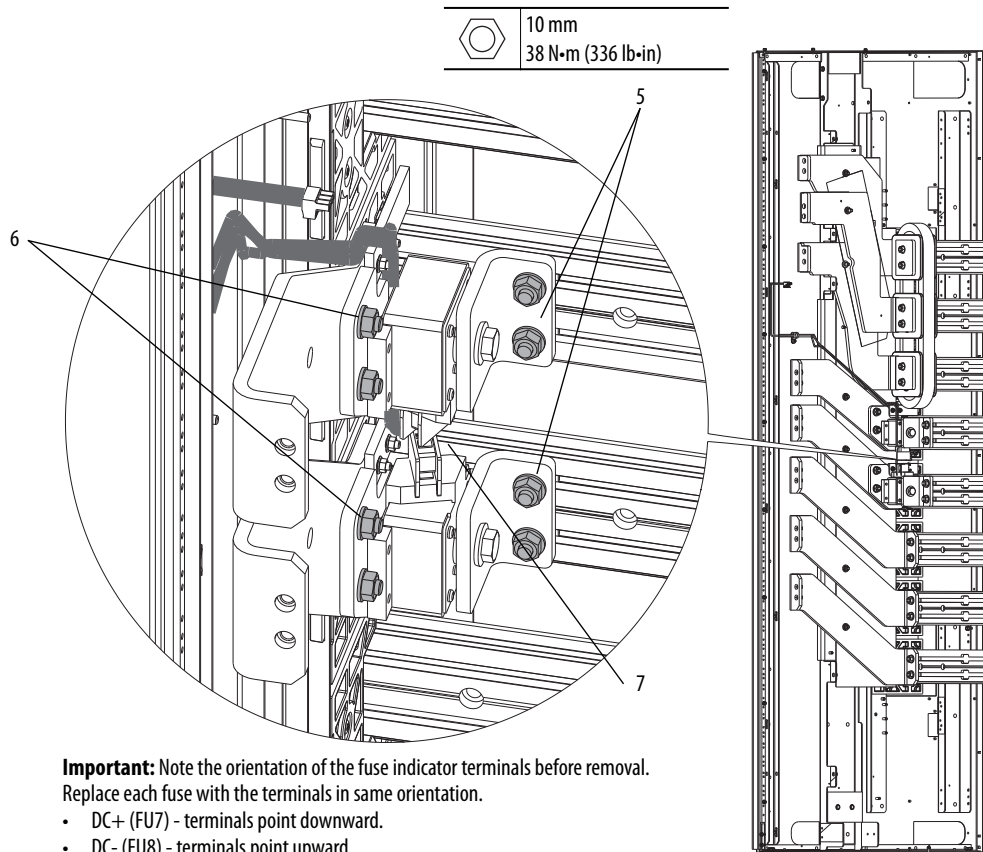


Note: The converter is shown removed from the drive enclosure for clarity only.

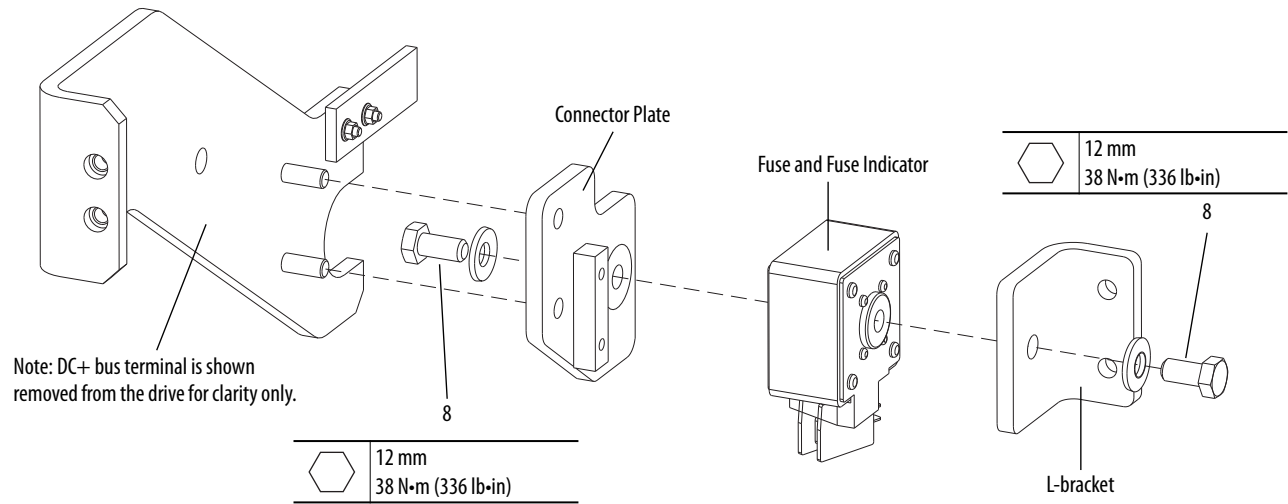
5. Remove the two M10 hex nuts that secure each of the L-brackets to the drive backplane DC bus (extruded bars) at the back of the drive enclosure.
6. Remove the two M10 hex nuts that secure each of the brackets to the DC+ and DC- forward bus bar terminals.

IMPORTANT Note the orientation of the fuse indicator terminals before removal.
Replace each fuse with the terminals in same orientation.

7. Remove the DC bus wire harness leads from the fuse indicators and slide the fuse assemblies off the bolts.



8. Remove the two M12 x 18 mm hex bolts and washers that secure the L-bracket and connector plate to the fuse and remove the fuse.



Install the DC Bus Fuses and Fuse Indicators

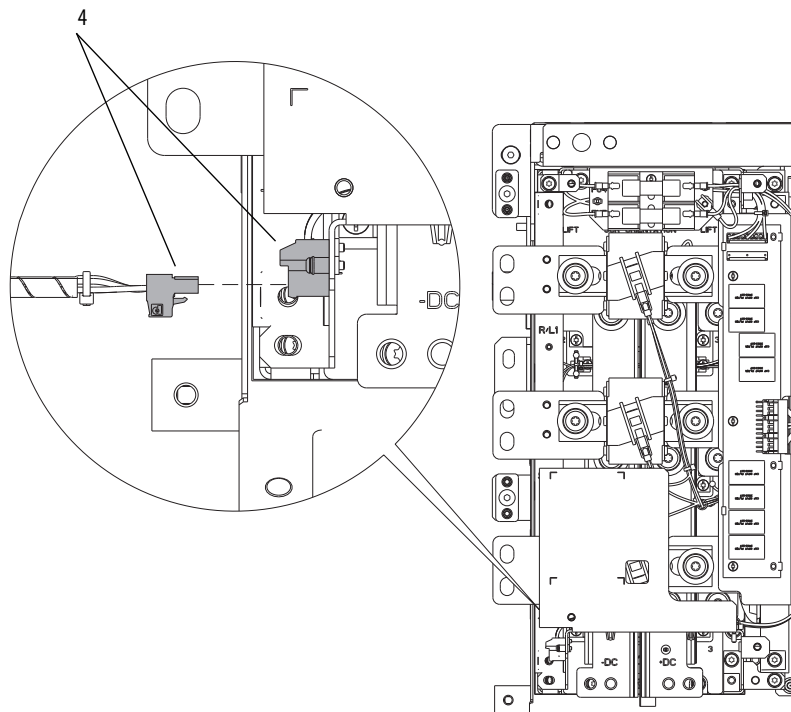
Install the DC bus fuses and fuse indicators in the reverse order of removal. See Remove the DC Bus Fuses and Fuse Indicators on page [320](#).

Input Common-mode Core Removal/Installation (Frame 9 and Larger, Common DC Input Drives Only)

Remove the Input Common Mode Core

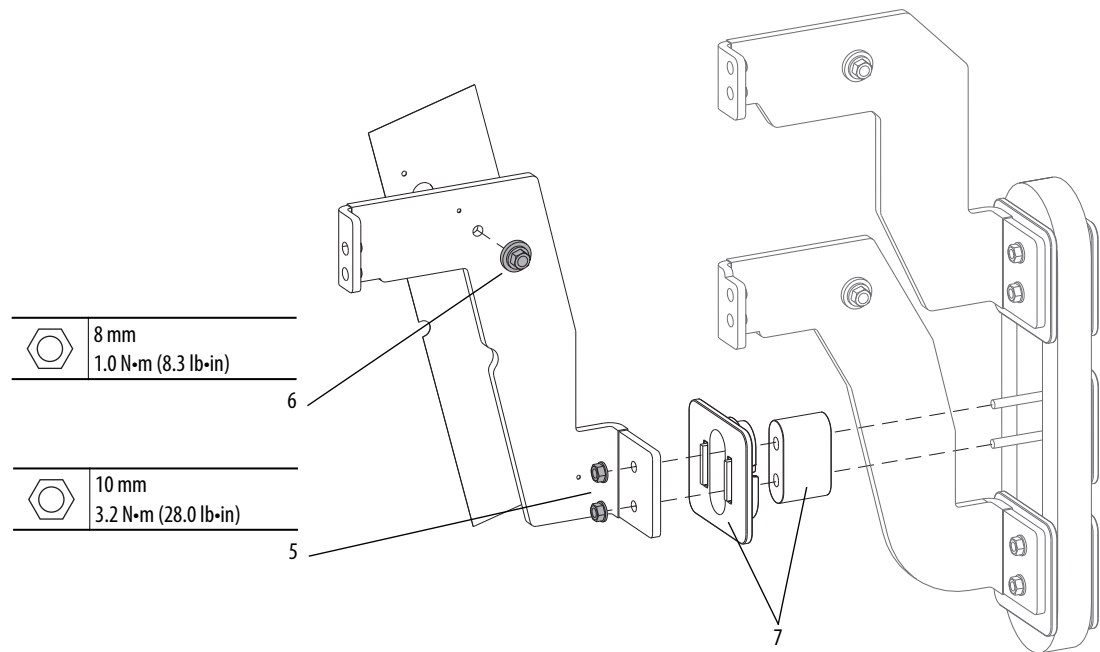
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. The input common mode core is at the back of the drive enclosure. Therefore, the drive assemblies must be removed from the enclosure. Remove the drive assemblies from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.

IMPORTANT You must first remove the wiring as detailed in the PowerFlex 750-Series AC Drive Installation Instructions. Then, you must disconnect the three-position, DC bus fuse wire harness connector from terminal block TB6 on the lower left side of the converter (as shown here).

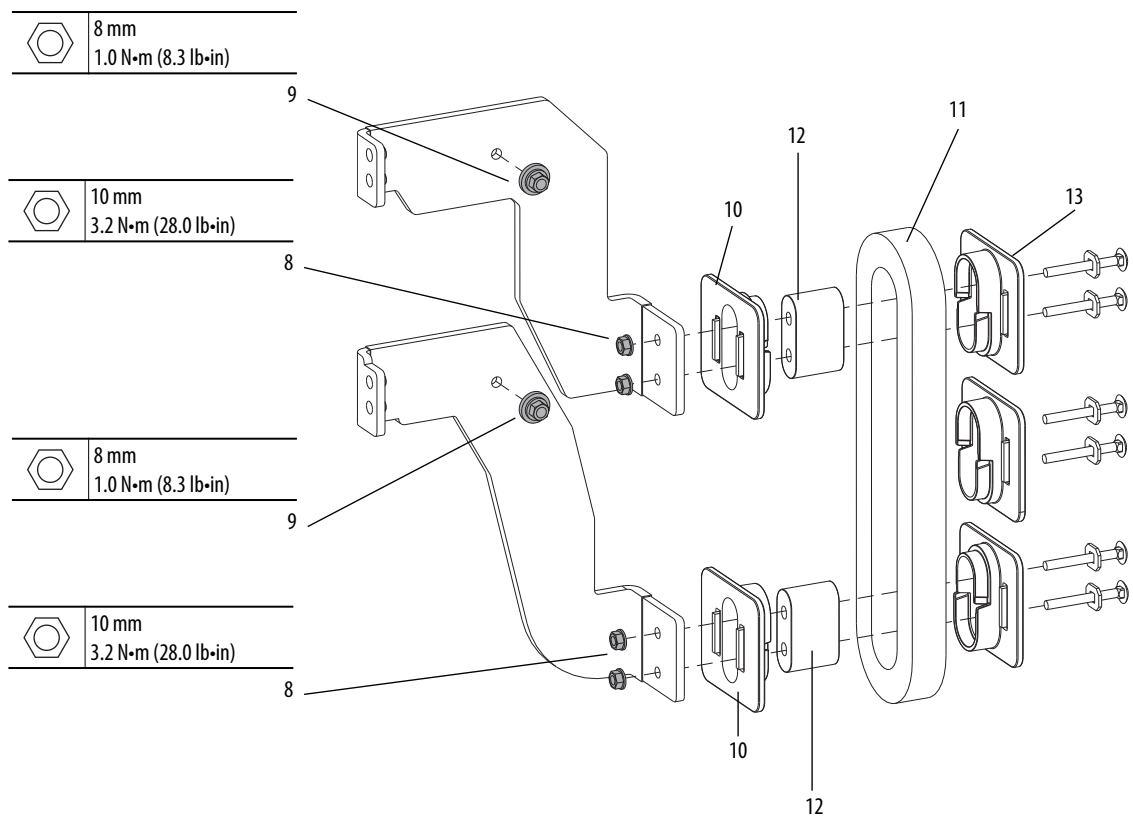


Note: The converter is shown removed from the drive enclosure for clarity only.

5. Remove the two M10 nuts that secure the center (S/L2) AC input terminal to the input common-mode core assembly.
6. Remove the M8 nut and washer that secures the center (S/L2) AC input terminal and isolation sheet to the insulator material on the side of the drive enclosure. Remove the terminal and isolation sheet.
7. Remove front plate and aluminum core for the center terminal from the bolts.



8. Remove the four M10 nuts that secure the remaining (R/L1, T/L3) AC input terminals to the input common-mode core assembly.
9. Remove the two M8 nuts that secure each of the remaining (R/L1, T/L3) AC input terminals to the insulator material on the side of the drive enclosure. Remove the terminals.
10. While supporting the input common mode core, remove the two front plates from the bolts connected to the drive backplane DC bus (extruded bars) at the back of the enclosure.
11. Remove the input common mode core.
12. Remove the two aluminum cores from the bolts.
13. Remove the three back plates from the bolts.



Install the Input Common Mode Core

Install the input common-mode core assembly in the reverse order of removal. See Remove the Input Common Mode Core on page [323](#).

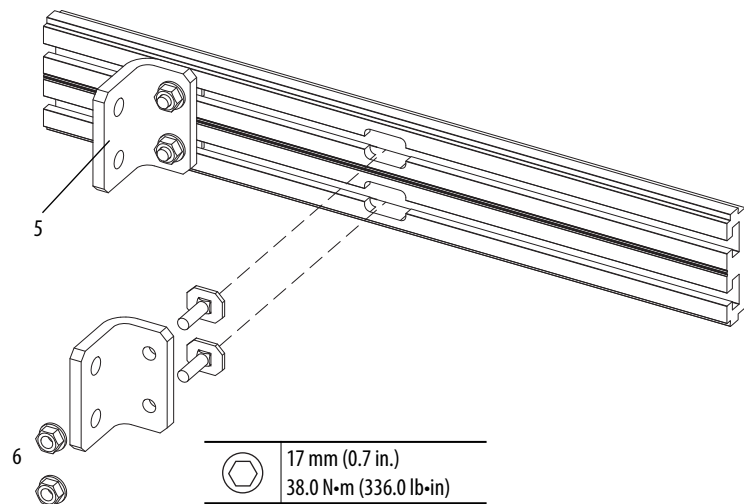
IMPORTANT The isolation sheet that separates the S/L2 terminal from the other two terminals must be installed in the same location as it was before removal.

Cabinet L Bus Bars Removal/ Installation

Remove the Cabinet L Bus Bars

Note: The cabinet L bus bars are used on both AC input and common DC input frame 10 drives.

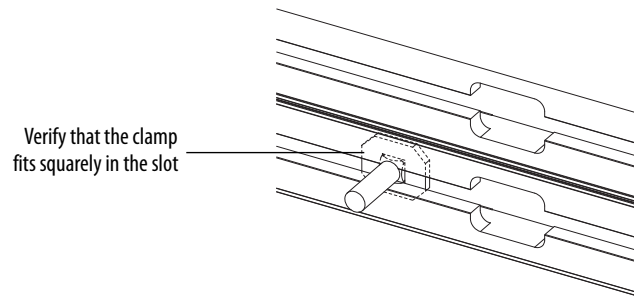
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. The cabinet L bus bar is at the back of the drive enclosure. Therefore, the drive assemblies must be removed from the enclosure. Remove the drive assemblies from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
5. Disconnect the AC line input power, output to motor, or DC power cables from the L bus bars.
6. Loosen the two M10 x 1.5 nuts that secure each L bus bar to the extruded bus bar at the back of the cabinet. Slide the L bus bars and hardware to the notch in the extruded bus bar and pull the bus bar, clamp, and bolt off the bus bar.



Install the Cabinet L Bus Bars

Install the cabinet L bus bars in the reverse order of removal. See Remove the Cabinet L Bus Bars on page [326](#).

IMPORTANT Verify that the clamp fits squarely in the extruded bus bar slot.



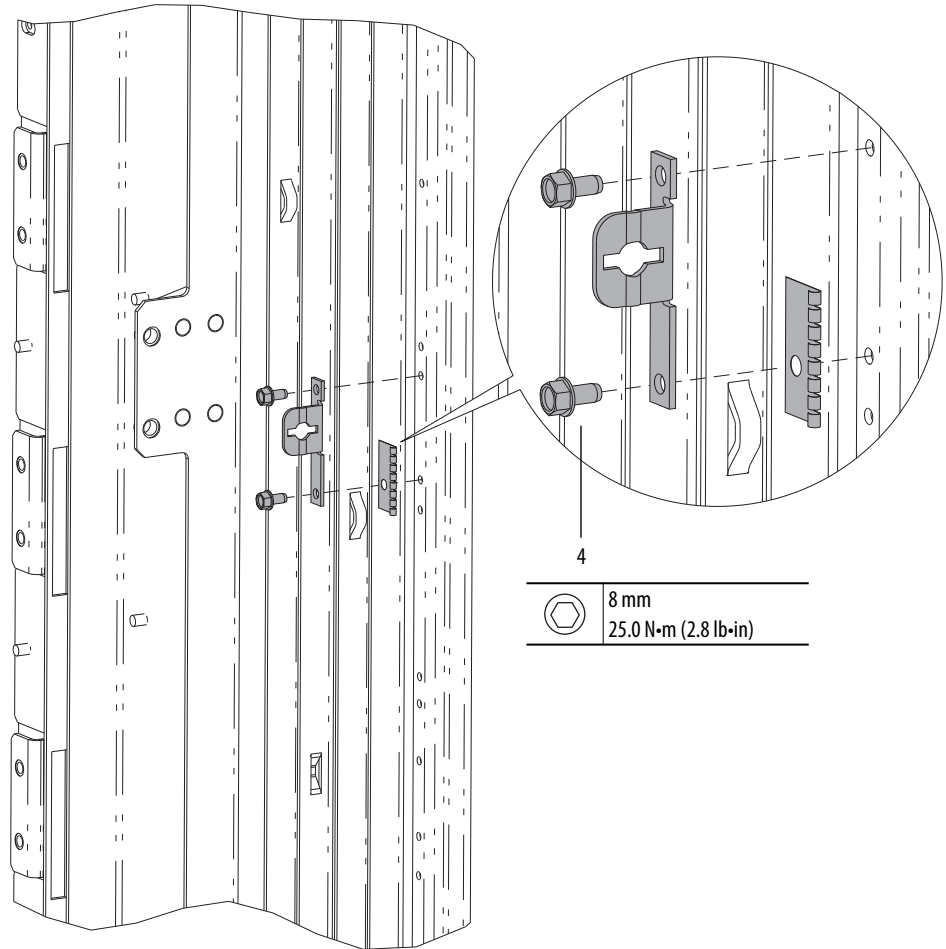
Cabinet Door EMC Shield Removal/Installation (Frame 10 Drives Only)

Remove the Cabinet Door EMC Shield

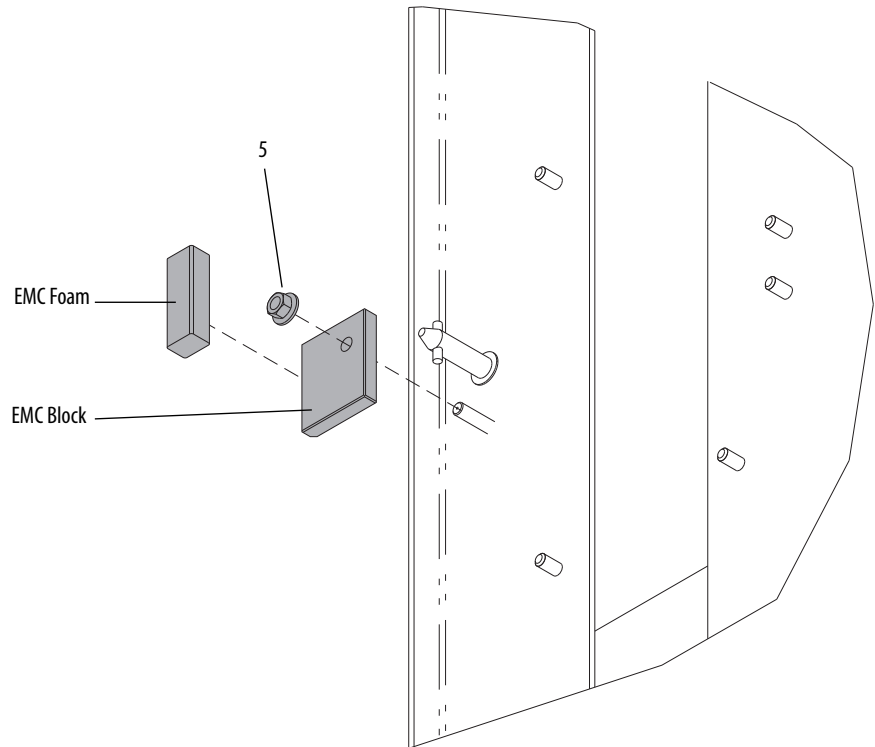
Note: The cabinet door EMC shield assembly is used on both AC input and common DC input frame 10 drives.

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.

4. Remove the two hex-head screws that secure the EMC assembly (five per cabinet) to the cabinet frame and remove the assembly.

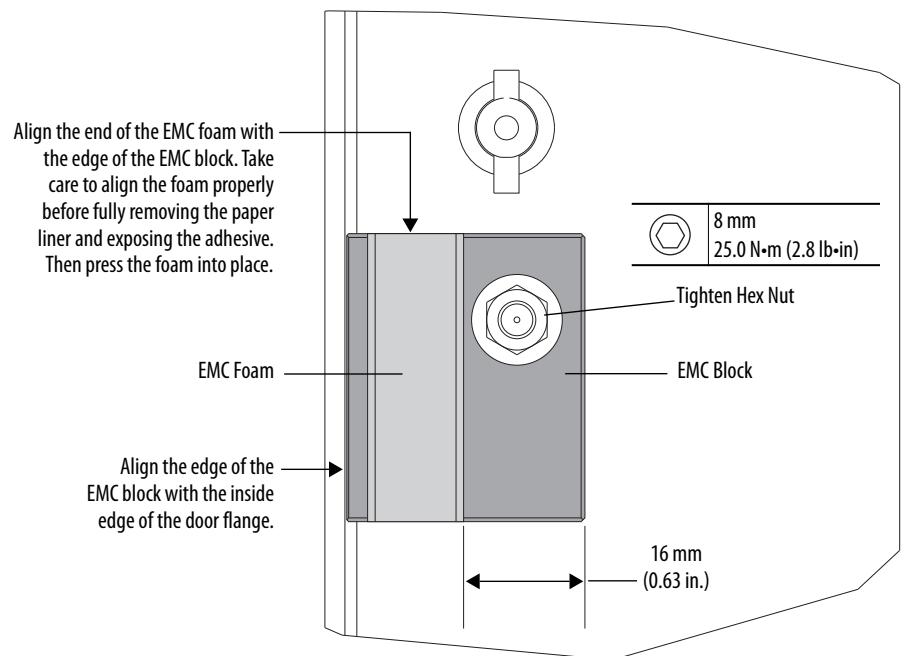


- Remove the M5 hex nut that secures the EMC assembly (five per door) to the cabinet door and remove the assembly.



Install the Cabinet Door EMC Shield

Install the cabinet door shield in the reverse order of removal. Verify that the new EMC shield kit is installed as described in the illustration that is shown here. Also, see Remove the Cabinet Door EMC Shield on page [327](#).



Notes:

Common DC Input Drive Enclosure Component Replacement Procedures

Topic	Page
Common DC Input Drive Enclosure Components Identification	332
Enclosure Door Fan Removal/Installation	333
Enclosure Door Fan Wire Harness Removal/Installation	334
DC Back Bus Guards Removal/Installation	336
120/240V Control Power Input Wire Harness Removal/Installation	338
120/240V Control Power Output Wire Harness Removal/Installation	339
120/240V Circuit Breaker Removal/Installation	340
120V UPS Power Input Wire Harness Removal/Installation	342
Input Common-mode Core Removal/Installation (Common DC Input Drives)	343

This chapter provides detailed procedures for how to remove and replace common DC input drive enclosure components.

Common DC Input Drive Enclosure Components Identification

This table contains the components that comprise the common DC input drive enclosure and provides the following information for each component, if applicable:

- Kit catalog number or part number
- Quantity that is contained in the kit

See PowerFlex Architecture Class Low Voltage Drives Spare Parts Options, publication [PFLEX-SB002](#) for a complete list of spare parts for PowerFlex® 755 Frame 8...10 drives.

Table 16 - Common DC Input Drive Enclosure Replacement Kits/Parts

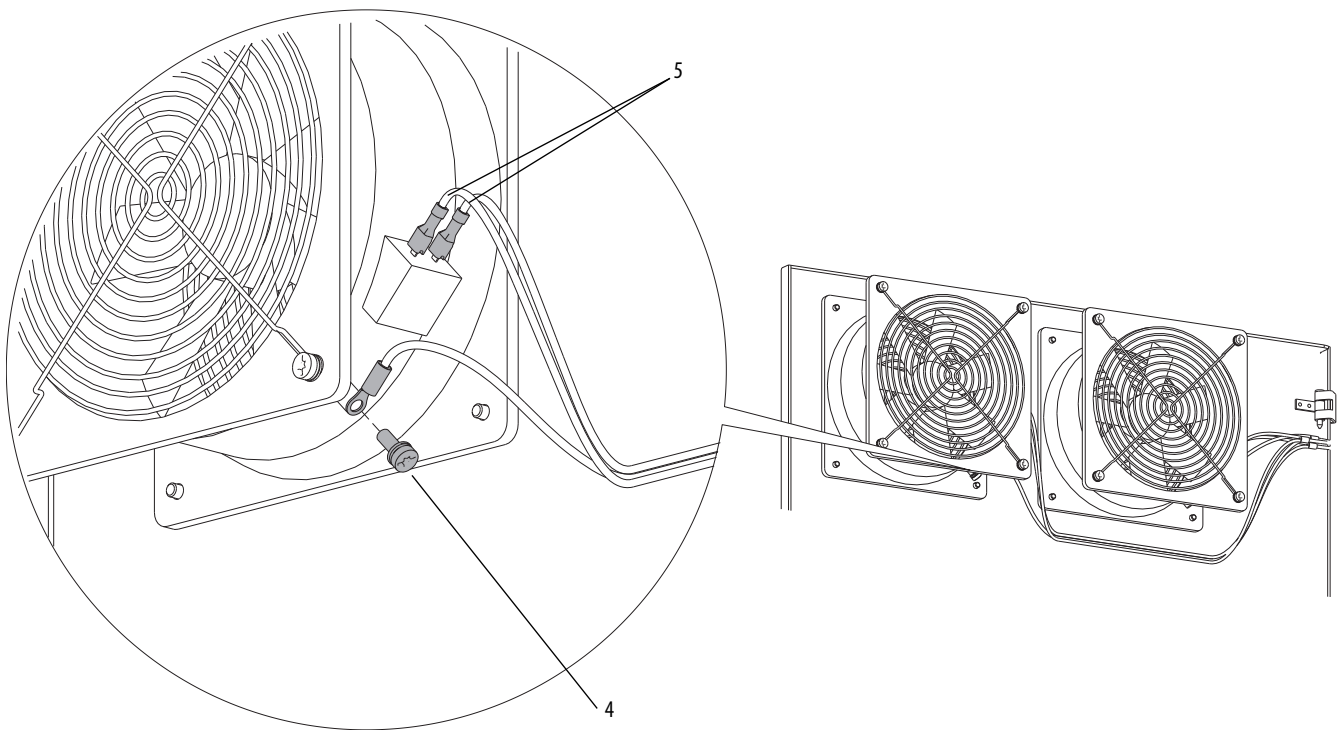
Component Description	Replacement Kit Cat. No. or Part No.	Qty.
IP20, NEMA/UL Type 1 Door Filter	20-750-FLTR1-F8	1
DC Input Cabinet Wire Harness Kit	SK-R1-CBPBRKH1-F8	–
Wire Harness, 120/240V Control Power		1
Wire Harness, Transformer Primary		1
Wire Harness, 120V UPS Input		1
DC Input Cabinet Back Bus Guard Kit	SK-R1-CBPGRD1-F8	–
Guard, Control Rail		2
Guard, DC Bus		1
Door Fan with Finger Guard	20-750-FAN3-F8	1
Door Fan Harness	SK-R1-FANH1-F8	1
Input Common Mode Core	20-750-CBPEMCCM1-F8	1
Cabinet L Bus Bar (see Cabinet L Bus Bars Removal/Installation on page 326 for instructions)	20-750-LBRKT1	1
Circuit Breaker, 2-Pole, 13 A	1489-A2D130	1
Lockout Attachment	1489-AALOA	1
Cabinet Door Shield Kit (Frame 10) (see Cabinet Door EMC Shield Removal/Installation (Frame 10 Drives Only) on page 327 for instructions)	20-750-EMCDK1-F10	1


TIP See Fastener/Tool/Torque Information on page [33](#) for descriptions of the fasteners, tools, and torque figures that are used in the disassembly/assembly procedures in this chapter.

Enclosure Door Fan Removal/ Installation

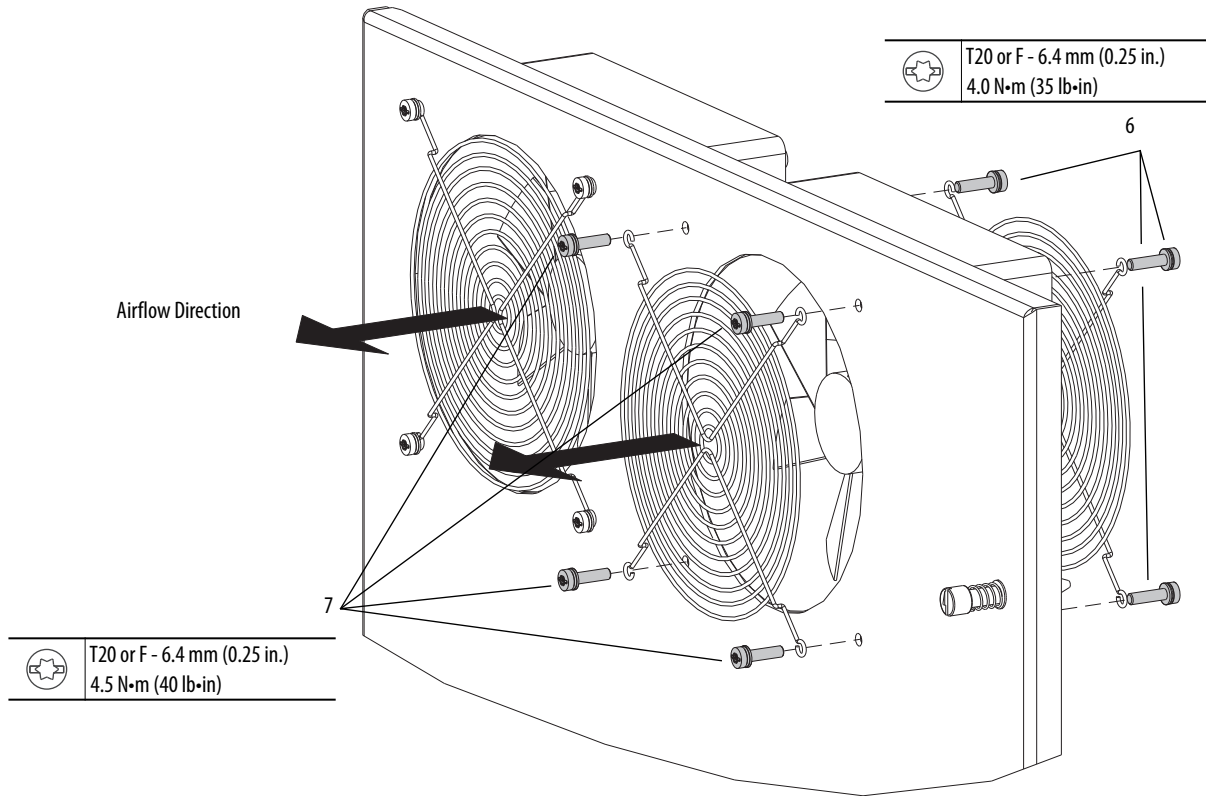
Remove the Enclosure Door Fan

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the M5 x 8 mm screw that secures the fan power-harness ground wire to the fan and remove the ground wire. Retain the screw for reuse.
5. Disconnect the Fan (+) and Fan (-) power wires from the fan terminals.



	T25 or F - 6.4 mm (0.25 in.) 2.8 N·m (25 lb·in)
---	--

6. Remove the four M5 x 20 screws that secure the inner guard to the fan housing and remove the guard.
7. Remove the four M5 x 20 screws that secure the outer fan guard and fan to the enclosure door and remove the outer fan guard and fan.



Install the Enclosure Door Fan

Install the enclosure door fan in the reverse order of removal. See Remove the Enclosure Door Fan on page [333](#).

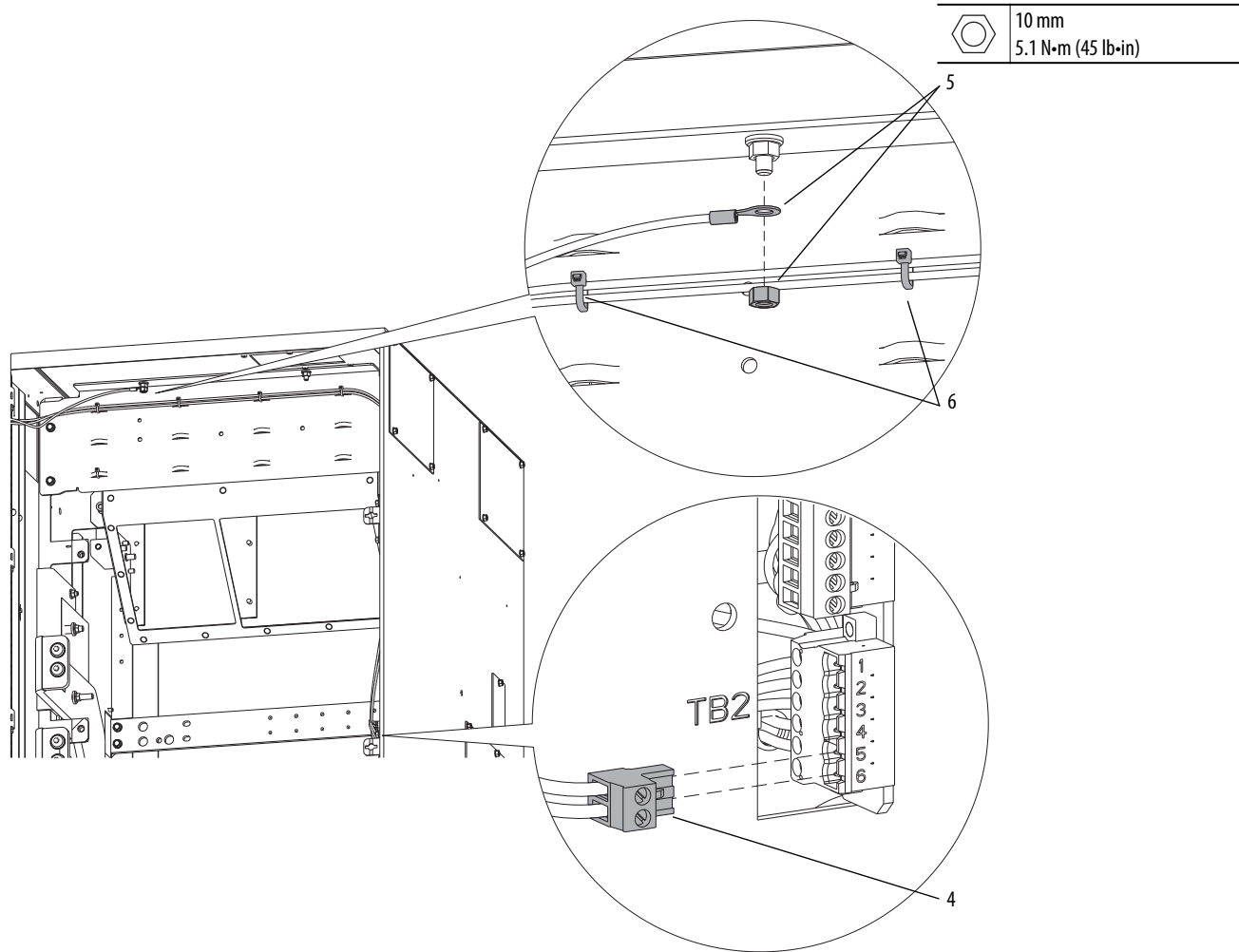
IMPORTANT When installing a new fan, verify that the airflow direction arrow on the fan points toward the exterior of the drive enclosure.

Enclosure Door Fan Wire Harness Removal/Installation

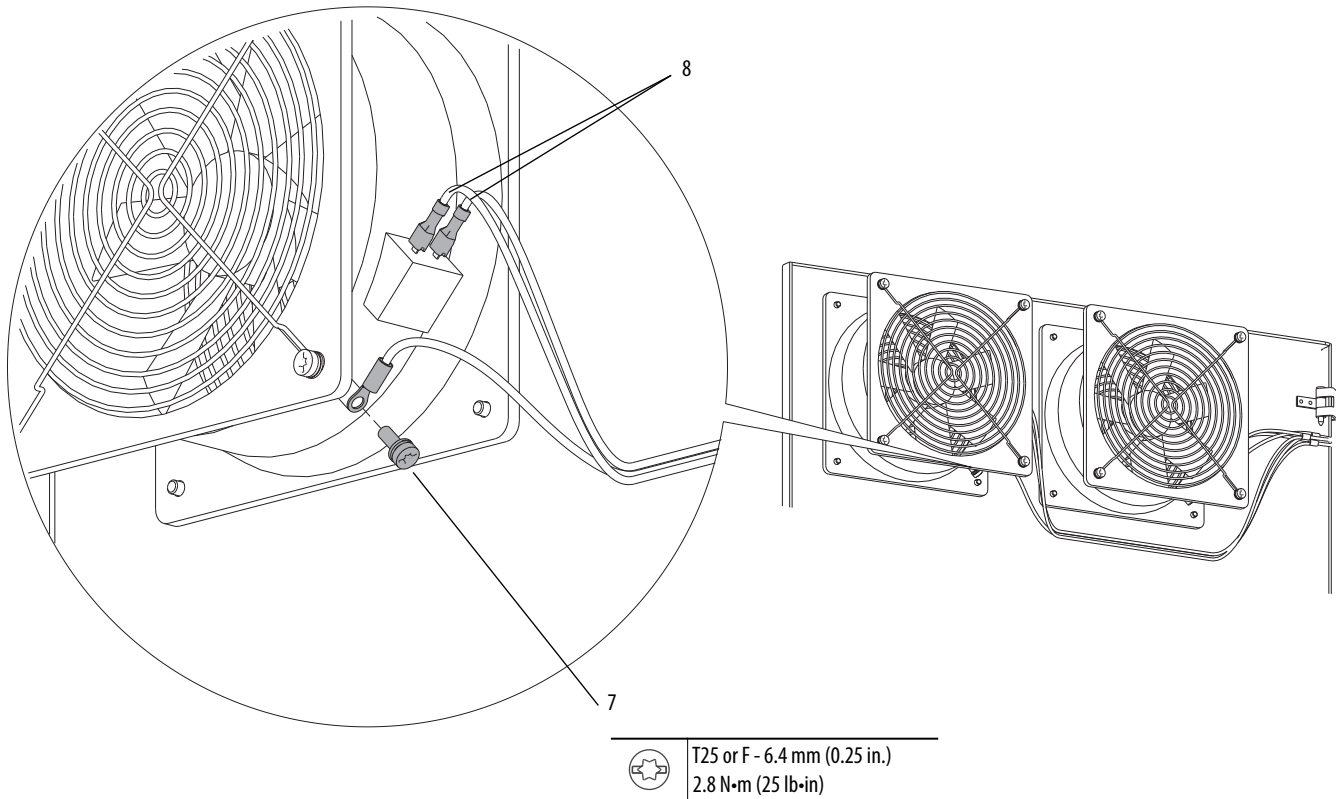
Remove the Enclosure Door Fan Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.

4. Disconnect the two-position, fan power connector from terminal TB2-5 and TB2-6 on the outside, right wall of the drive control panel.
5. Remove the M6 grounding nut from the enclosure wireway ceiling.
6. Cut the cable ties that secure the wire harness to the enclosure wireway.



7. Remove the M5 x 8 mm screw that secures the fan power-harness ground wires to each of the fans and remove the ground wires.
8. Disconnect the Fan (+) and Fan (-) power wires from the terminals on both fans and remove the fan harness.



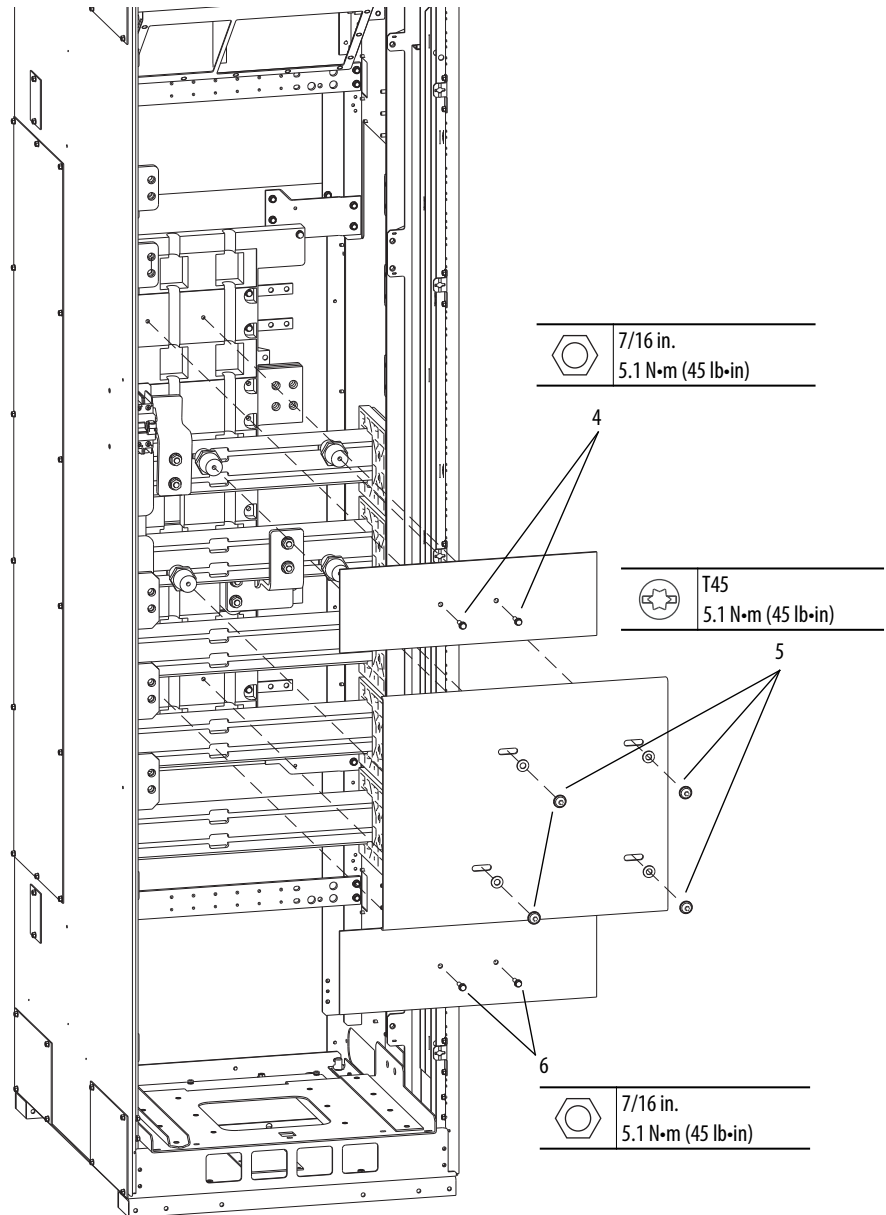
Install the Enclosure Door Fan Wire Harness

Install the enclosure door fan harness in the reverse order of removal. See Remove the Enclosure Door Fan Wire Harness on page [334](#).

DC Back Bus Guards Removal/ Installation Remove the DC Back Bus Guards

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Remove the drive assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.

4. Remove the two 7/16-20 x 1 in. hex head screws that secure the top guard (that covers the 120V control bus) to the enclosure and remove the guard.
5. Remove the four M10 x 16 mm screws that secure the middle guard (that covers the +DC and -DC bus) to the enclosure and remove the guard.
6. Remove the two 7/16-20 x 1 in. hex head screws that secure the bottom guard (that covers the 120V UPS bus) to the enclosure and remove the guard.



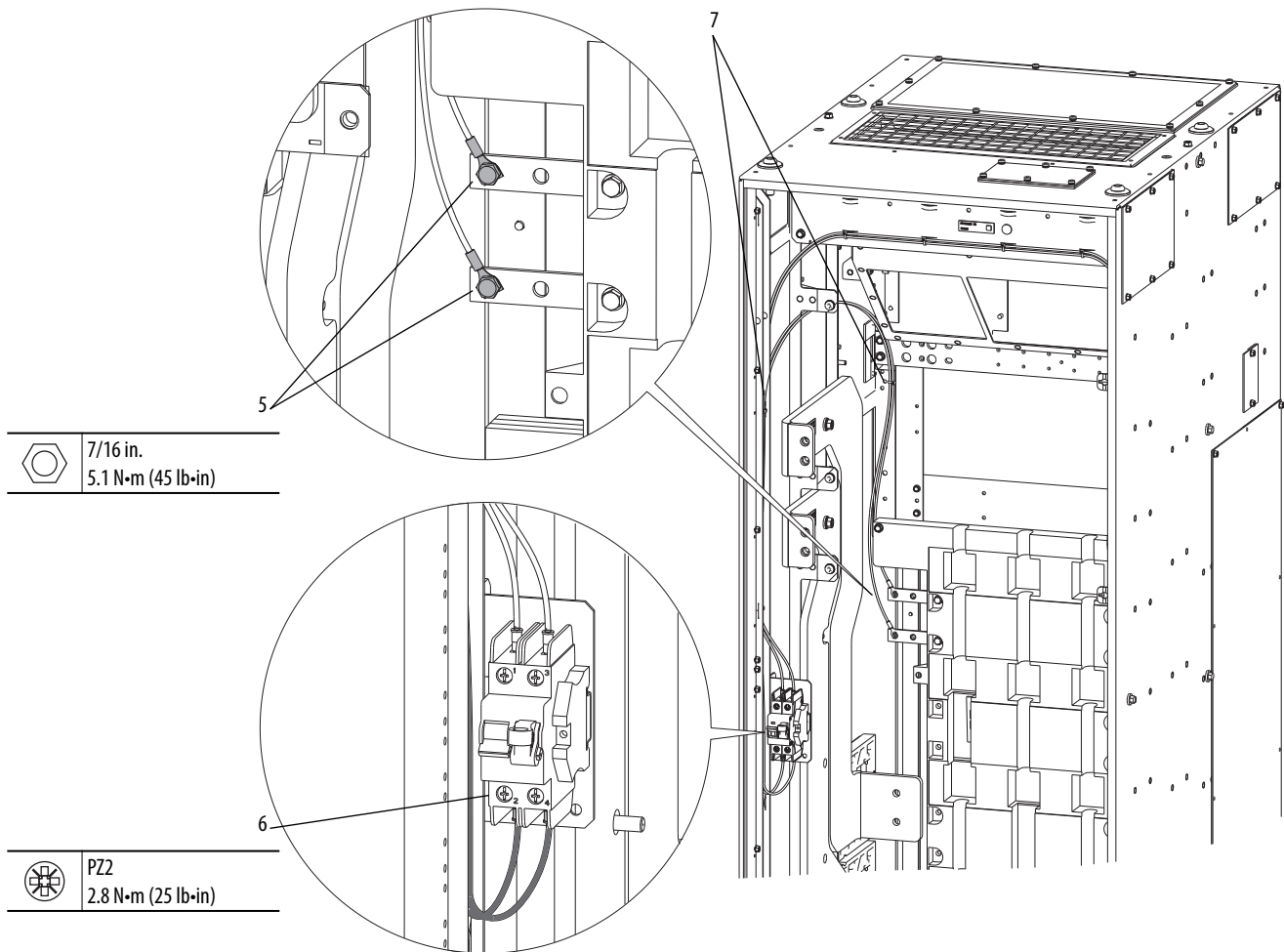
Install the DC Back Bus Guards

Install the DC back bus guards in the reverse order of removal. Guards must be replaced before returning the drive to service. See Remove the DC Back Bus Guards on page [336](#).

120/240V Control Power Input Wire Harness Removal/ Installation

Remove the 120/240V Control Power Input Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Remove the drive assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
4. Remove the top DC bus back guard to access the 120V control bus. See Remove the DC Back Bus Guards on page [336](#).
5. Loosen the two ¼-20 x ½ in. hex head screws that secure the harness to the 120V control bus and remove the wires.
6. Loosen the screws that secure the input wires to terminals SW5-2 and SW5-4 on the bottom of the circuit breaker and remove the wires.
7. Cut the cable ties that secure the wire harness to the enclosure wireways and remove the harness.



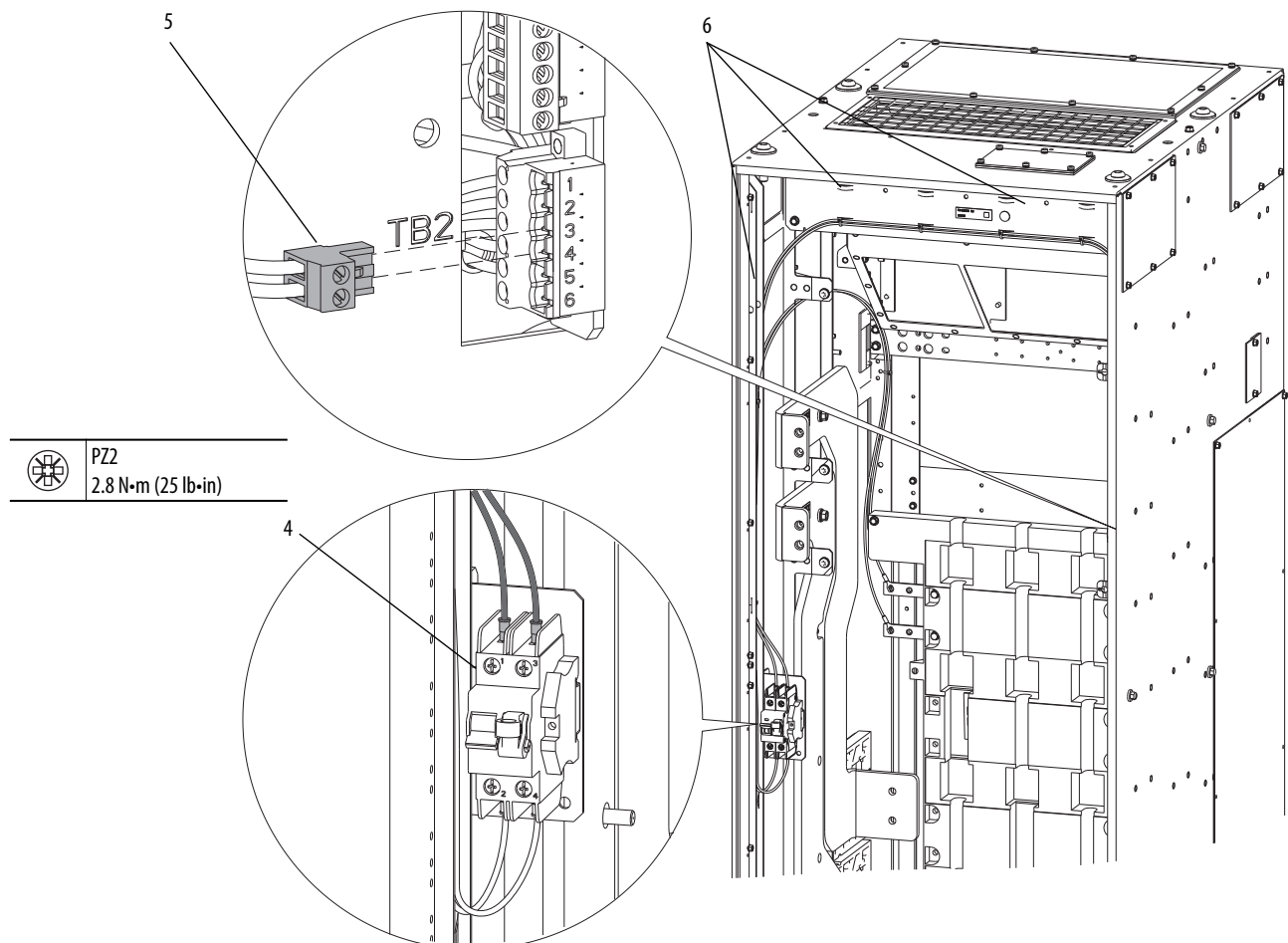
Install the 120/240V Control Power Input Wire Harness

Install the 120/240V control power-input wire harness in the reverse order of removal. See Remove the 120/240V Control Power Input Wire Harness on page [338](#).

120/240V Control Power Output Wire Harness Removal/Installation

Remove the 120/240V Control Power Output Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Loosen the screws that secure the output wires from terminals SW5-1 and SW5-3 on the top of the circuit breaker and remove the wires.
5. Disconnect the two-position connector from terminal block TB2-3 and TB2-4 on the outside right wall of the drive control panel.
6. Cut the cable ties from enclosure wireways and remove the harness.



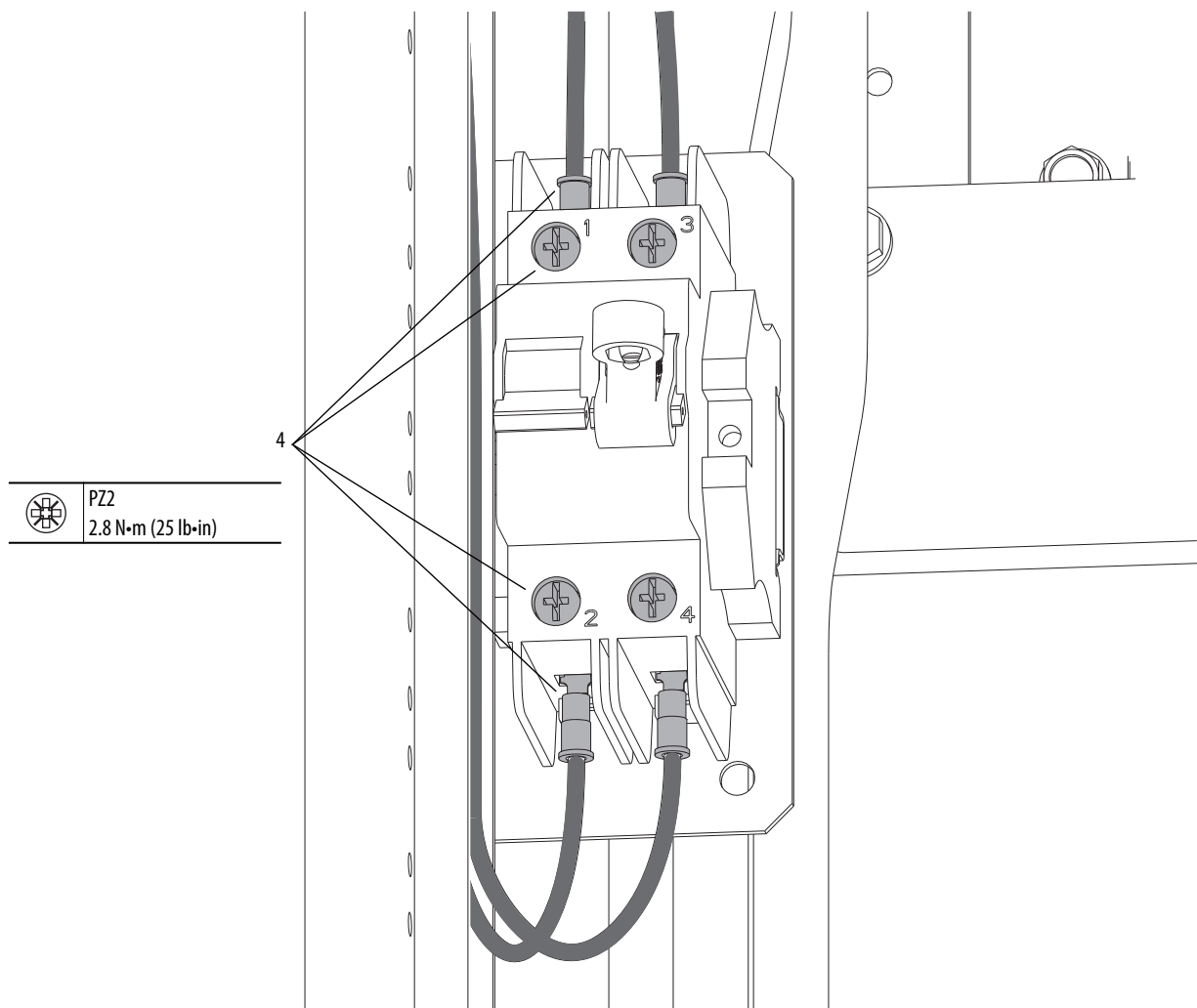
Install the 120/240V Control Power Output Wire Harness

Install the 120/240V control-power output wire harness in the reverse order of removal. See 120/240V Control Power Output Wire Harness Removal/Installation on page [339](#).

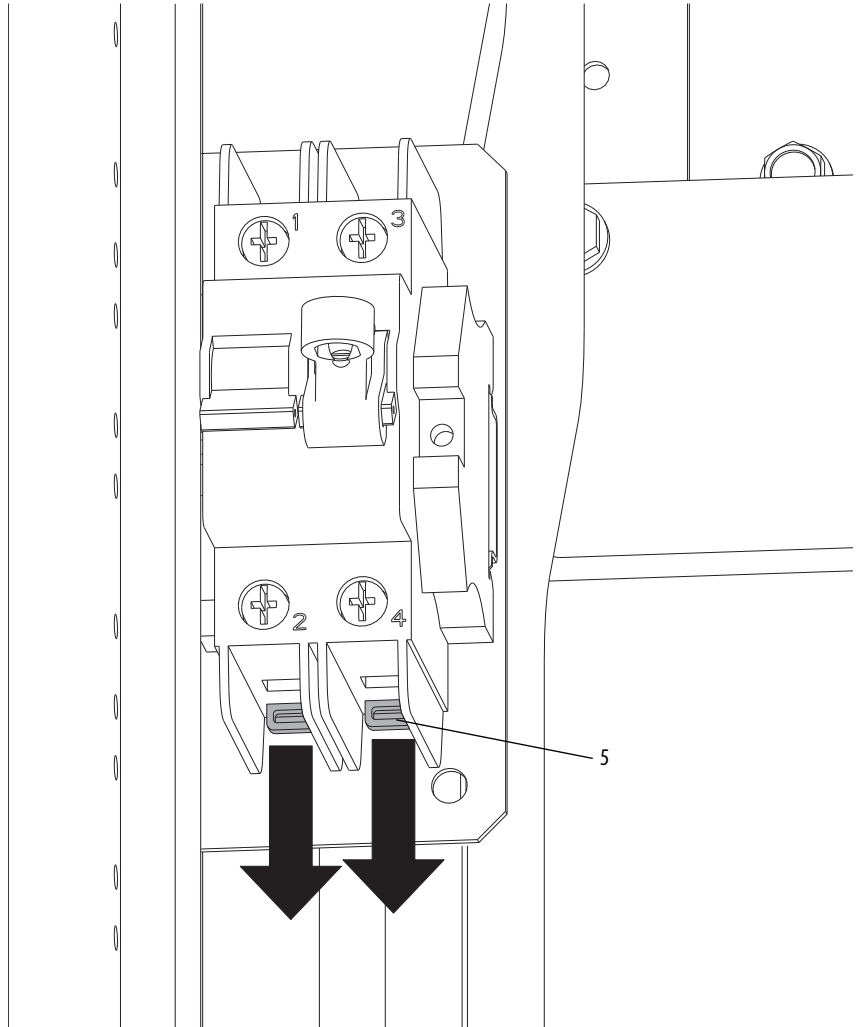
120/240V Circuit Breaker Removal/Installation

Remove the 120/240V Circuit Breaker

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Loosen the screws that secure the output wires to terminals SW5-1 and SW5-3 on the top of the circuit breaker and the input wires to terminals SW5-2 and SW5-4 on the bottom of the circuit breaker. Remove the wires.



5. Release the spring-loaded latches at the bottom of the circuit breaker and lift the circuit breaker off the DIN rail.



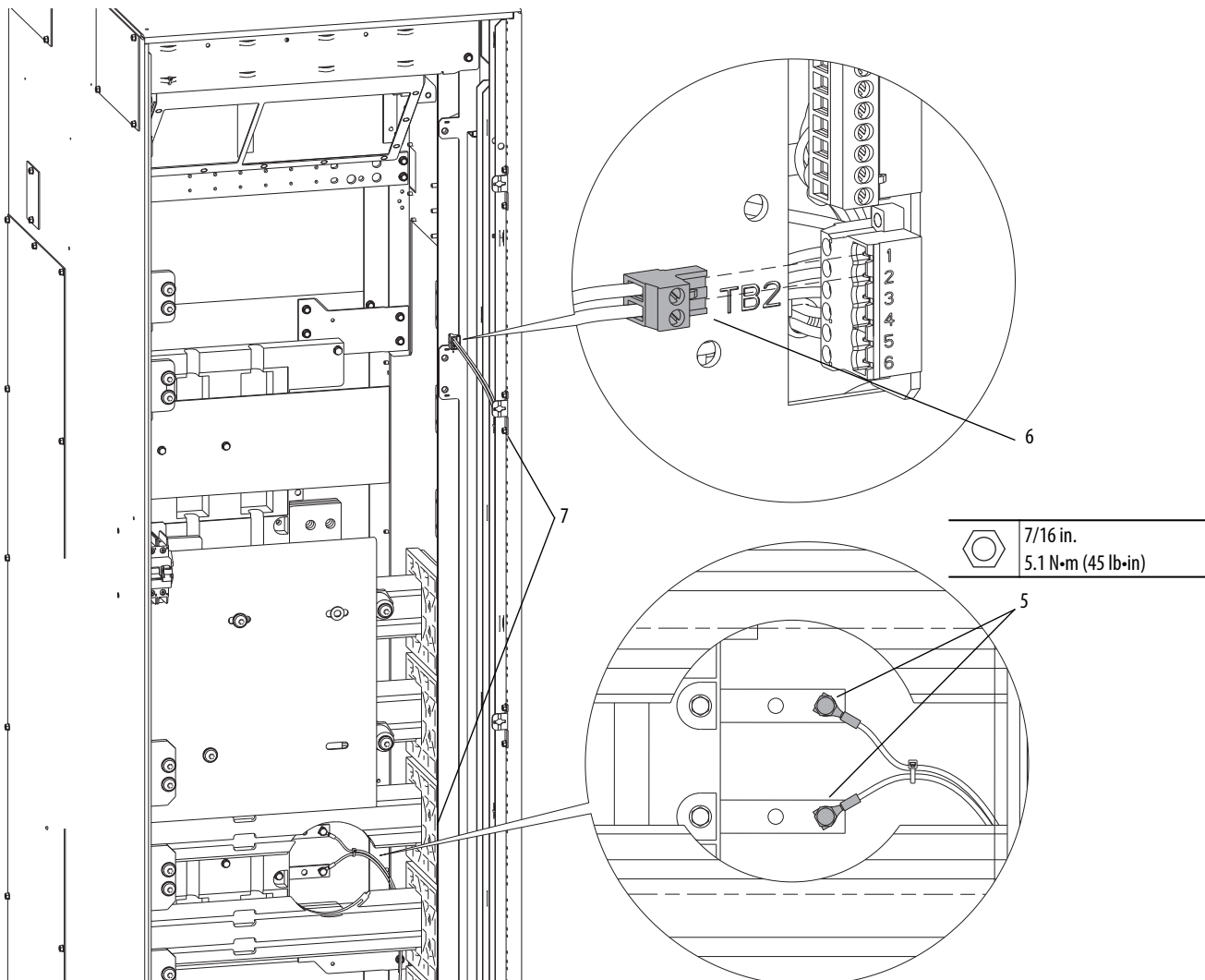
Install the 120/240V Circuit Breaker

Install the 120/240V circuit breaker in the reverse order of removal. See Remove the 120/240V Circuit Breaker on page [340](#).

120V UPS Power Input Wire Harness Removal/ Installation

Remove the 120V UPS Power Input Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Remove the drive assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.
4. Remove the bottom DC bus back guard to access the 120V UPS bus. See Remove the DC Back Bus Guards on page [336](#).
5. Loosen the two ¼-20 x ½ in. hex head screws that secure the harness to the 120V UPS bus and remove the wires.
6. Disconnect the two-position connector from terminal block TB2-1 and TB2-2 on the outside, right wall of the drive control panel.
7. Cut the cable ties that secure the wire harness to the enclosure wireways and remove the harness.



Install the 120V UPS Power Input Wire Harness

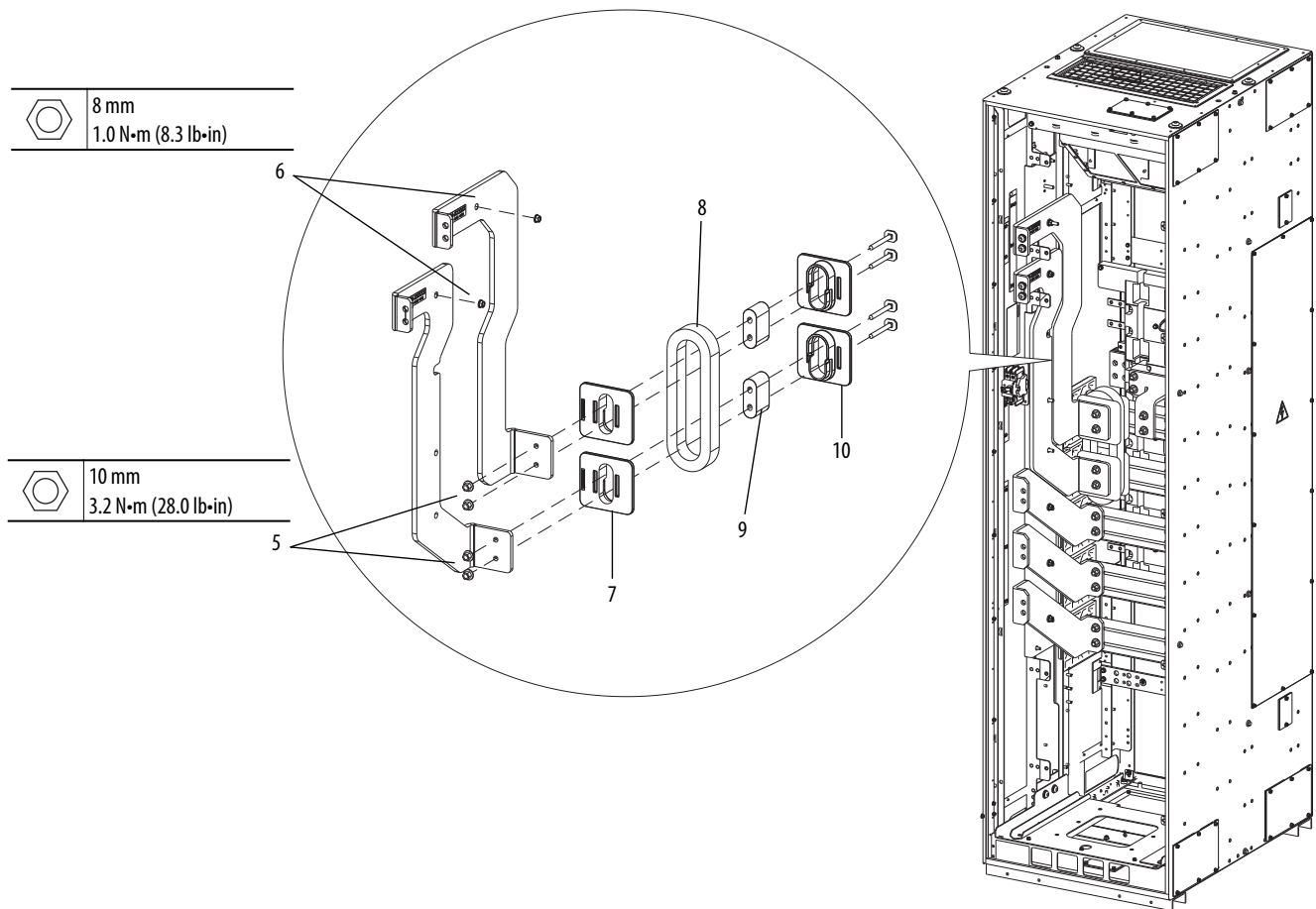
Install the 120V UPS power input wire harness in the reverse order of removal. See Remove the 120V UPS Power Input Wire Harness on page [342](#).

Input Common-mode Core Removal/Installation (Common DC Input Drives)

Remove the Input Common Mode Core

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. The input common-mode core is at the back of the drive enclosure. Therefore, the drive assembly must be removed from the enclosure. Remove the drive assembly from the enclosure. See the PowerFlex 750-Series AC Drive Installation Instructions, publication number [750-IN001](#), for details.

5. Remove the two M10 nuts and washers that secure each of the DC+ and DC- input terminals to the input common-mode core assembly.
6. Remove the M8 nut and washer that secures each of the DC+ and DC- input terminals to the insulator material on the side of the drive enclosure. Remove the terminals.
7. While supporting the input common-mode core, remove the two front plates from the bolts connected to the drive backplane DC bus (extruded bars) at the back of the enclosure.
8. Remove the input common-mode core from the back plates.
9. Remove the two aluminum cores from the bolts.
10. Remove the two back plates from the bolts.



Install the Input Common Mode Core

Install the input common-mode core assembly in the reverse order of removal. See Remove the Input Common Mode Core on page [343](#).

Option-bay Enclosure Component Replacement Procedures

Topic	Page
Option-bay Enclosure Components Identification	346
Frame 8 Circuit Breaker Disconnect Handle Panel Removal/Installation	348
IP20, NEMA/UL Type 1 Door Fan Removal/Installation (Frame 8 Only)	351
IP20, NEMA/UL Type 1 Door Fan Harness Removal/Installation (Frame 8 Only)	353
IP54, NEMA/UL Type 12 Cabinet Exhaust Blower Filter Removal/Installation	355
IP54, NEMA/UL Type 12 Cabinet Door-inlet Filters Removal/Installation	355
IP54, NEMA/UL Type 12 Cabinet Door-inlet Filter Cassette Removal/Installation	355
Frame 8 Option Bay Guard Removal/Installation	356
Frame 9 Series B Option Bay Guards Removal/Installation	357
Frame 9 Series C Option Bay Guards Removal/Installation	359
Control Transformer Fuses Removal/Installation	361
Frame 8 IP54, NEMA/UL Type 12 Cabinet Blower Assembly Removal/Installation	362
Frame 8 IP54, NEMA/UL Type 12 Cabinet Blower Wire Harness Removal/Installation	363
Frame 8 Control Transformer Removal/Installation	364
Frame 8 Control Transformer Wire Harness Removal/Installation	366
Frame 8 Contactor Wire Harness Removal/Installation	371
Frame 8 Thermostat and Wire Harness Removal/Installation	372
Frame 9 Cabinet Blower Assembly Removal/Installation	374
Frame 9 Cabinet Blower Wire Harness Removal/Installation	375
Frame 9 Circuit Breaker Disconnect Handle Panel (Series A) Removal/Installation	377
Frame 9 Thermostat and Wire Harness Removal/Installation	378
Frame 9 Control Transformer Removal/Installation	380
Frame 9 Main Control-panel Wire Harness Removal/Installation	381
Frame 9 Reactor Fan Tray Removal/Installation	386
Frame 9 Reactor Fan Tray Wire Harness Removal/Installation	387
Frame 9 Reactor Fans Wire Harness Removal/Installation	389
Frame 9 Cabinet Blower Relay Removal/Installation	391
Frame 9 Control Panel Thermostat Harness Removal/Installation	392
Top Conduit Plate Removal/Installation	394
Bottom Conduit Plate Removal/Installation	395

This chapter provides detailed procedures for how to remove and replace option bay enclosure components.

Option-bay Enclosure Components Identification

Table 17 and Table 18 (on page 347) contain the components that comprise the frame 8 and 9 option bay enclosures and provides the following information for each component, if applicable:

- Kit catalog number or part number
- Quantity that is contained in the kit

See PowerFlex Architecture Class Low Voltage Drives Spare Parts Options, publication [PFLEX-SB002](#) for a complete list of spare parts for PowerFlex® 755 Frame 8...10 drives.

Table 17 - Frame 8 Option Bay Replacement Kits/Parts

Component Description	Replacement Kit Cat. No. or Part No. (Series A & B)	Replacement Kit Cat. No. or Part No. (Series C)
Circuit Breaker Disconnect Handle Panel	SK-R1-ODISCP1-F8	SK-R1-ODISCP1-F8C
Circuit Breaker Disconnect Handle (includes handle, cable, operating, and bail mechanism)		
Operating Mechanism for 600 A, L-Frame Circuit Breaker	1494V-M72	–
Operating Mechanism for 800 A, M-Frame Circuit Breaker	1494V-M72	–
Operating Mechanism for 1200 A, N-Frame Circuit Breaker	1494V-M72	–
Disconnect Switch Handle	–	1494F-M2
IP20, NEMA/UL Type 1 Door Fan with Finger Guard	20-750-FAN3-F8	
IP20, NEMA/UL Type 1 Door Fan Harness	SK-R1-OFANH1-F8	
IP54, NEMA/UL Type 12 Cabinet Exhaust Blower Assembly	SK-R1-OFAN12-F8	
IP54, NEMA/UL Type 12 Cabinet Exhaust Blower Harness	SK-R1-OFAN12H1-F8	
IP54, NEMA/UL Type 12 Cabinet Exhaust Blower Filter, Fiber (Single)	SK-R1-FLTR2-F8	
IP54, NEMA/UL Type 12 Cabinet Exhaust Blower Filter, Fiber (Multi)	SK-R1-FLTR2M-F8	
Thermostat	SK-R1-OTH1-F8	
Thermostat Wire Harness	SK-R1-OTHH1-F8	
Control Transformer	SK-R1-OFANXFMR	
Control Transformer Fuses (includes both 400V and 600V class)	SK-R1-OXFMRFUSES	
IP20, NEMA/UL Type 1 Control Transformer Panel Harness	SK-R1-OXFMRH1-F8	SK-R1-OXFMRH1-F8C
IP54, NEMA/UL Type 12 Control Transformer Panel Harness	SK-R1-OXFMRH2-F8	SK-R1-OXFMRH2-F8C
Contactor Wire Harnesses	SK-R1-OCONTH1-F8	SK-R1-OCONTH1-F8C
IP54, NEMA/UL Type 12 Cabinet Door Inlet Filter, Pleated (Single Piece)	SK-R1-FLTR3-F8	
IP54, NEMA/UL Type 12 Cabinet Door Inlet Filter, Pleated (12 Pieces)	SK-R1-FLTR3M-F8	
IP54, NEMA/UL Type 12 Cabinet Door Inlet Filter, Metal Mesh	SK-R1-FLTR4-F8	

Table 17 - Frame 8 Option Bay Replacement Kits/Parts (continued)

Component Description	Replacement Kit Cat. No. or Part No. (Series A & B)	Replacement Kit Cat. No. or Part No. (Series C)
IP54, NEMA/UL Type 12 Cabinet Door Filter Cassette	SK-R1-FLTRFRM-F8	
IP54, NEMA/UL Type 12 Cabinet Door Gasket	SK-R1-G2-F8	
Upper and Lower Conduit Plates (600 mm deep cabinet)	SK-R1-OCPLT1-F8	
Upper and Lower Conduit Plates (800 mm deep cabinet)	SK-R1-OCPLT2-F8	

Table 18 - Frame 9 Option Bay Replacement Kits/Parts

Component Description	Replacement Kit Cat. No. or Part No. (Series B)	Replacement Kit Cat. No. or Part No. (Series C)
Option Bay Guards	SK-R1-0GRD2-F9	SK-R1-0GRD2-F9C
Door Interlock with Wire Harness	–	SK-R1-0DRL1-F9C
Circuit Breaker Disconnect Handle Panel	SK-R1-0DISCP1-F9	–
Circuit Breaker Disconnect Handle (includes handle, cable, operating, and bail mechanism)		
Flex-Cable Operating Mechanism for 1200 A, N-Frame Circuit Breaker	140U-N-FCX04	–
Flex-Cable Operating Mechanism for 2500 A, R-Frame Circuit Breaker	140U-R-FCX04	–
IP54, NEMA/UL Type 12 Cabinet Exhaust Blower Assembly	SK-R1-0FAN12-F8	
IP20, NEMA/UL Type 1 Cabinet Exhaust Blower Assembly	SK-R1-0FAN12-F9	
IP54, NEMA/UL Type 12 Cabinet Exhaust Blower Filter, Fiber (Single)	SK-R1-FLTR2-F8	
IP54, NEMA/UL Type 12 Cabinet Exhaust Blower Filter, Fiber (Multi)	SK-R1-FLTR2M-F8	
Option-bay Wire Harness Kit	SK-R1-0BAYH1-F9	
600V and below Control-transformer Panel Wire Harness		
690V Control Transformer Panel Wire Harness		
Output Reactor Wire Harness		
With input/output Reactor Jumper Wire		
No Reactor Jumper Wire		
Reactor Fan Tray Wire Harness		
Exhaust Blower Wire Harness		
Exhaust Blower Jumper Wire		
24V Supply Wire Harness		
Thermostat	SK-R1-0TH1-F8	
Thermostat Wire Harness	SK-R1-0THH1-F8	
Control Transformer	SK-R1-0FANXFMR	

Table 18 - Frame 9 Option Bay Replacement Kits/Parts (continued)

Component Description	Replacement Kit Cat. No. or Part No. (Series B)	Replacement Kit Cat. No. or Part No. (Series C)
Control Transformer Fuses (includes both 400V and 600V class)	SK-R1-OXFMRFUSES	
Reactor Fan Tray	SK-R1-OCARTFAN-F9	
Reactor Fan Relay	700-HLT12U2X	
IP54, NEMA/UL Type 12 Cabinet Door Inlet Filter, Pleated (Single Piece)	SK-R1-FLTR3-F8	
IP54, NEMA/UL Type 12 Cabinet Door Inlet Filter, Pleated (12 Pieces)	SK-R1-FLTR3M-F8	
IP54, NEMA/UL Type 12 Cabinet Door Inlet Filter, Metal Mesh	SK-R1-FLTR4-F8	
IP54, NEMA/UL Type 12 Cabinet Door Filter Cassette	SK-R1-FLTRFRM-F8	
IP54, MENEMA/UL Type 12 Cabinet Door Gasket	SK-R1-G2-F8	
Upper and Lower Conduit Plates (600 mm deep cabinet)	SK-R1-OCPLT1-F8	
Upper and Lower Conduit Plates (800 mm deep cabinet)	SK-R1-OCPLT2-F8	

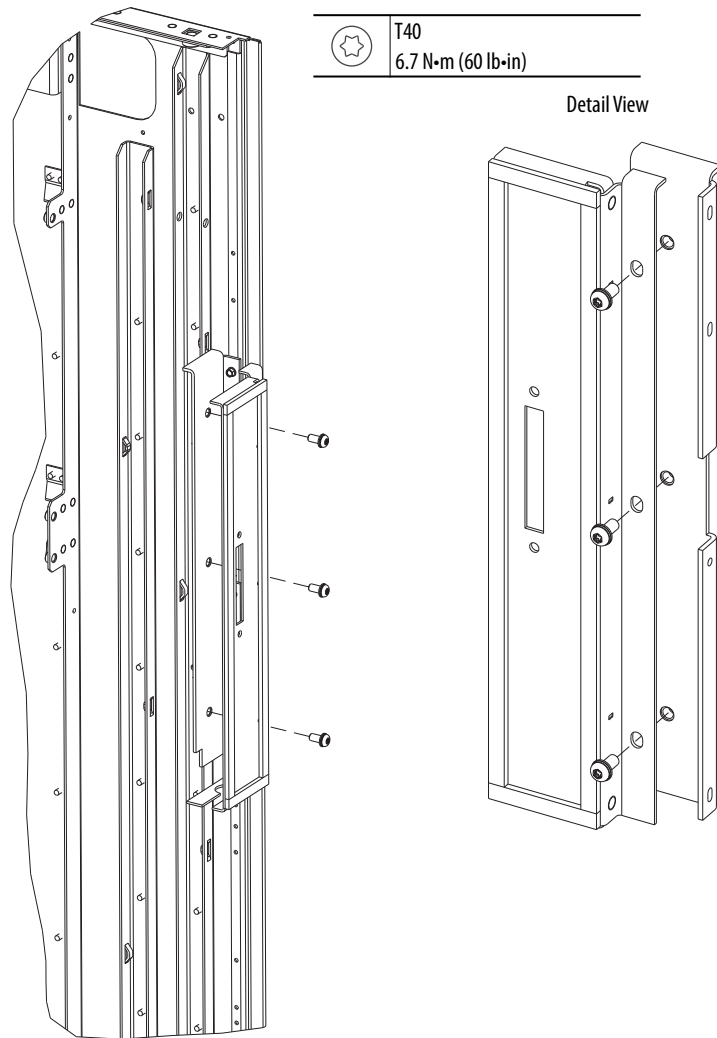
TIP See Fastener/Tool/Torque Information on page [33](#) for descriptions of the fasteners, tools, and torque figures that are used in the disassembly/assembly procedures in this chapter.

Frame 8 Circuit Breaker Disconnect Handle Panel Removal/Installation

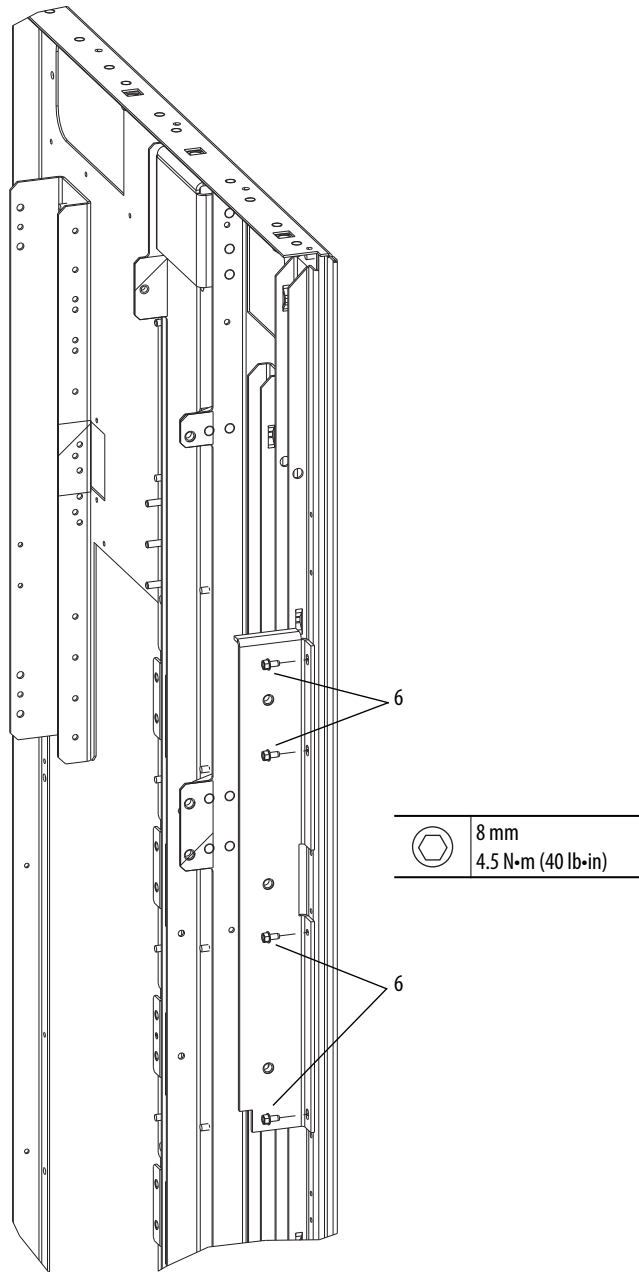
Remove the Frame 8 Circuit Breaker Disconnect Handle Panel

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Remove the circuit breaker disconnect handle per the manufacturer's instructions.

5. Remove the three M8 x 20 mm hexalobular screws that secure the disconnect handle panel to the support bracket and remove the handle panel.



6. Remove the four M5 x 12 mm hex head screws that secure the disconnect support bracket to the enclosure frame and remove the support bracket.



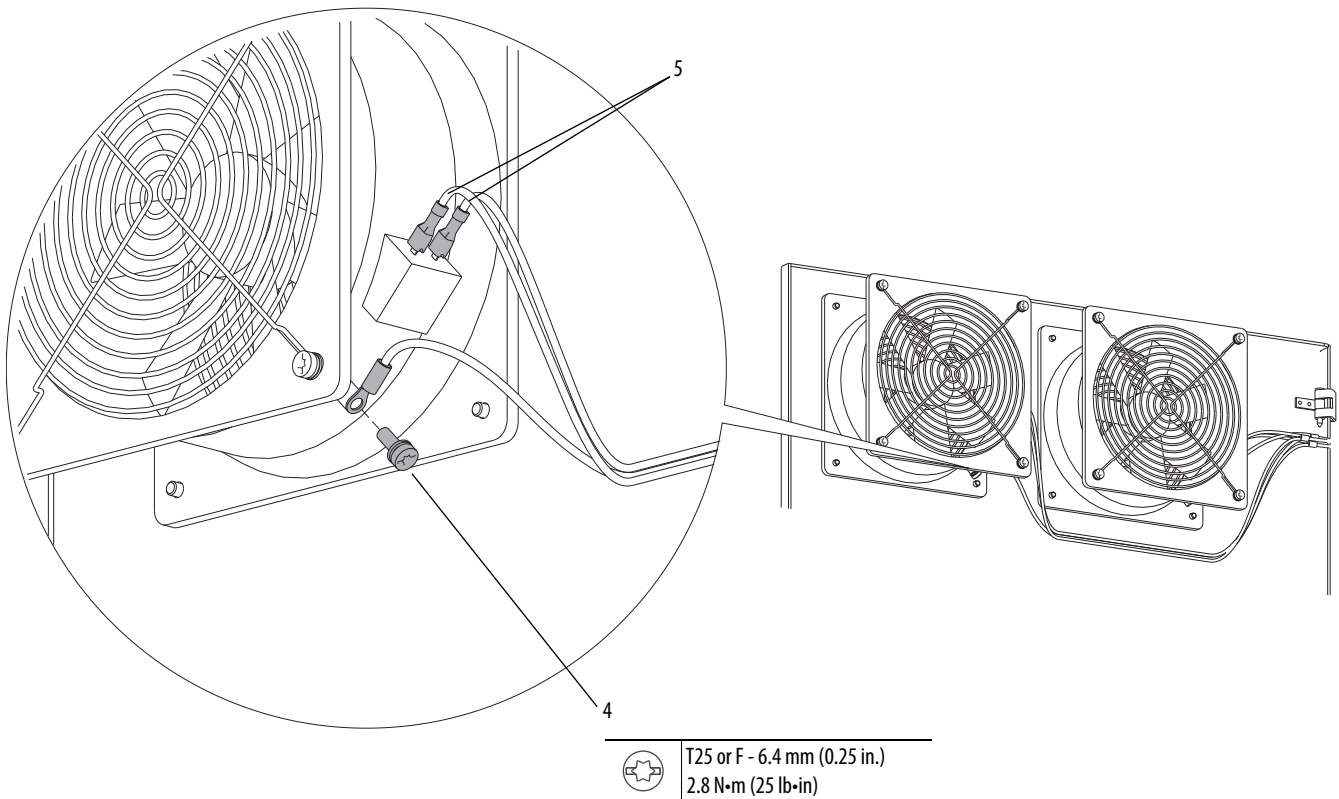
Install the Frame 8 Circuit Breaker Disconnect Handle Panel

Install the disconnect support bracket and handle panel in the reverse order of removal. See [Remove the Frame 8 Circuit Breaker Disconnect Handle Panel](#) on page [348](#).

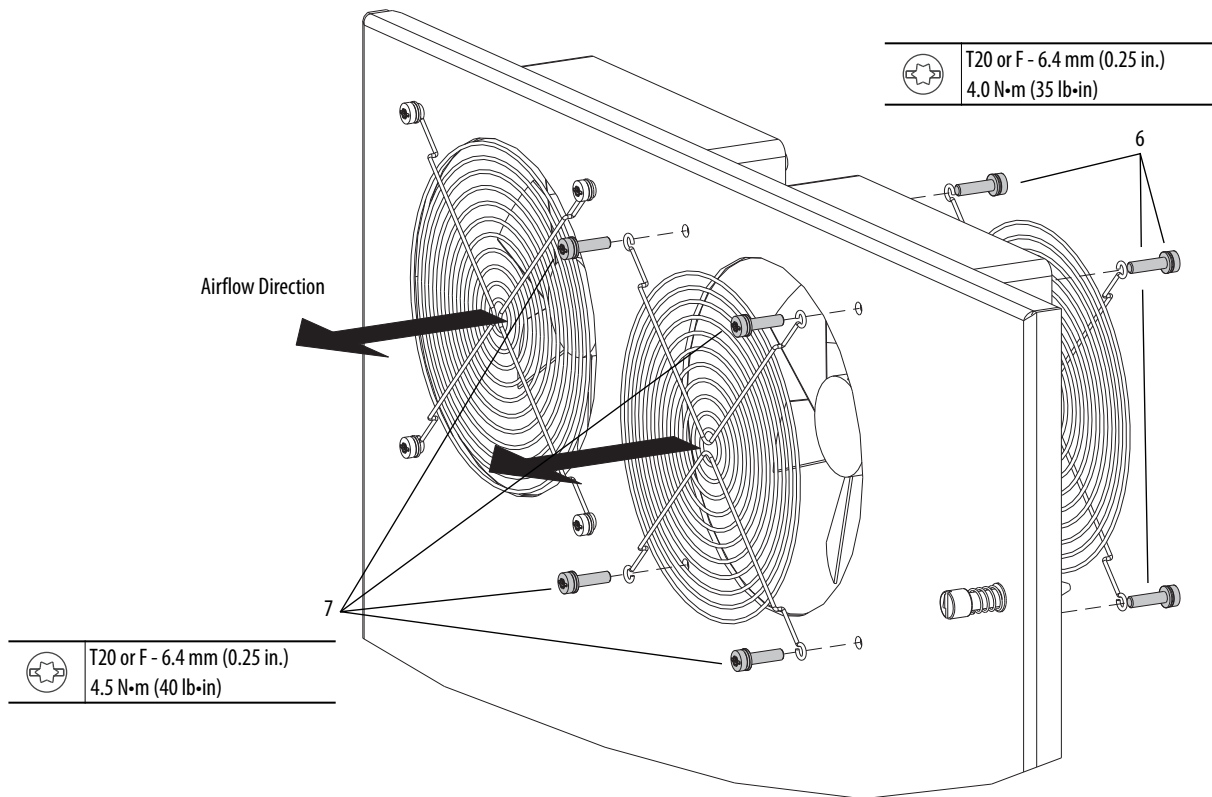
IP20, NEMA/UL Type 1 Door Fan Removal/Installation (Frame 8 Only)

Remove the IP20, NEMA/UL Type 1 Door Fan (Frame 8 Only)

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the M5 x 8 mm screw that secures the fan-power harness ground wire to the fan and remove the ground wire. Retain the screw for reuse.
5. Disconnect the Fan (+) and Fan (-) power wires from the fan terminals.



6. Remove the four M5 x 20 mm screws that secure the inner guard to the fan housing and remove the guard.
7. Remove the four M5 x 20 mm screws that secure the outer fan guard and fan to the enclosure door and remove the outer fan guard and fan.



Install the IP20, NEMA/UL Type 1 Door Fan (Frame 8 Only)

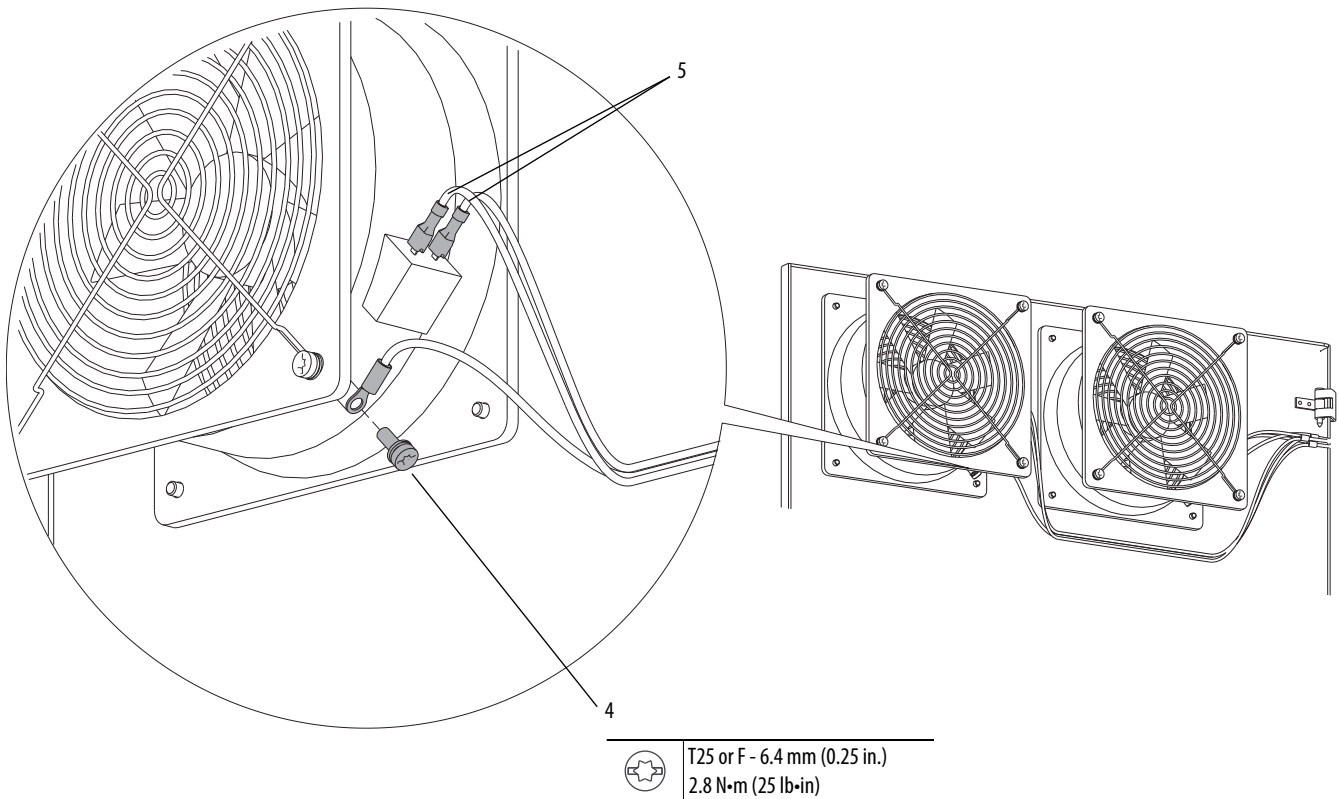
Install the door fan in the reverse order of removal. See Remove the IP20, NEMA/UL Type 1 Door Fan (Frame 8 Only) on page [351](#).

IMPORTANT When installing a new fan, verify that the airflow direction arrow on the fan points to the exterior of the drive enclosure.

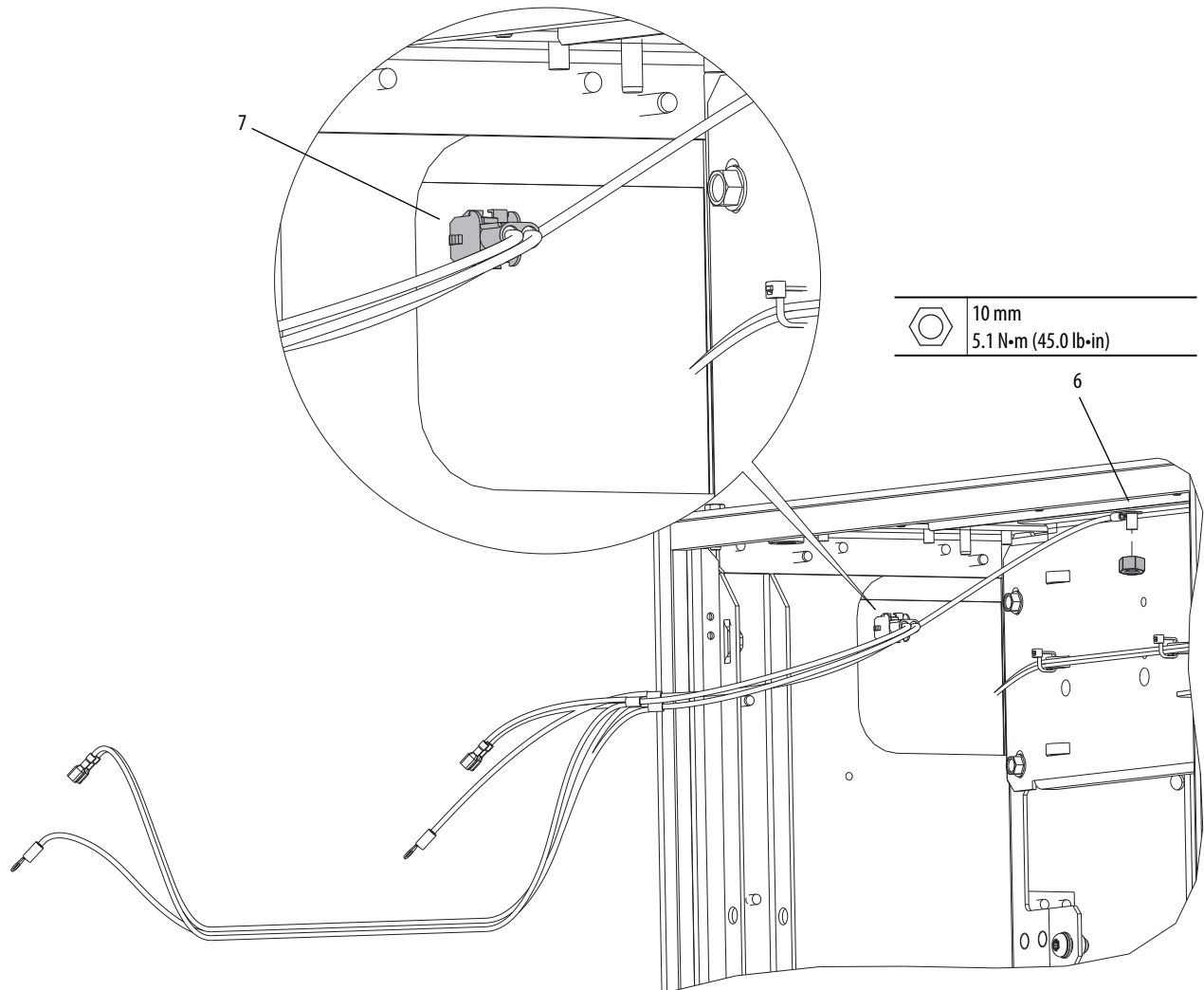
IP20, NEMA/UL Type 1 Door Fan Harness Removal/ Installation (Frame 8 Only)

Remove the IP20, NEMA/UL Type 1 Door Fan Harness (Frame 8)

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the M5 screw that secures the fan-power harness ground wire to the fan and remove the ground wire. Retain the screw for reuse.
5. Disconnect the Fan (+) and Fan (-) power wires from the fan terminals.



6. Remove the M6 grounding nut from the cabinet ceiling.
7. Disconnect the fan harness from the connector in the upper left corner of the cabinet, and remove the fan harness.



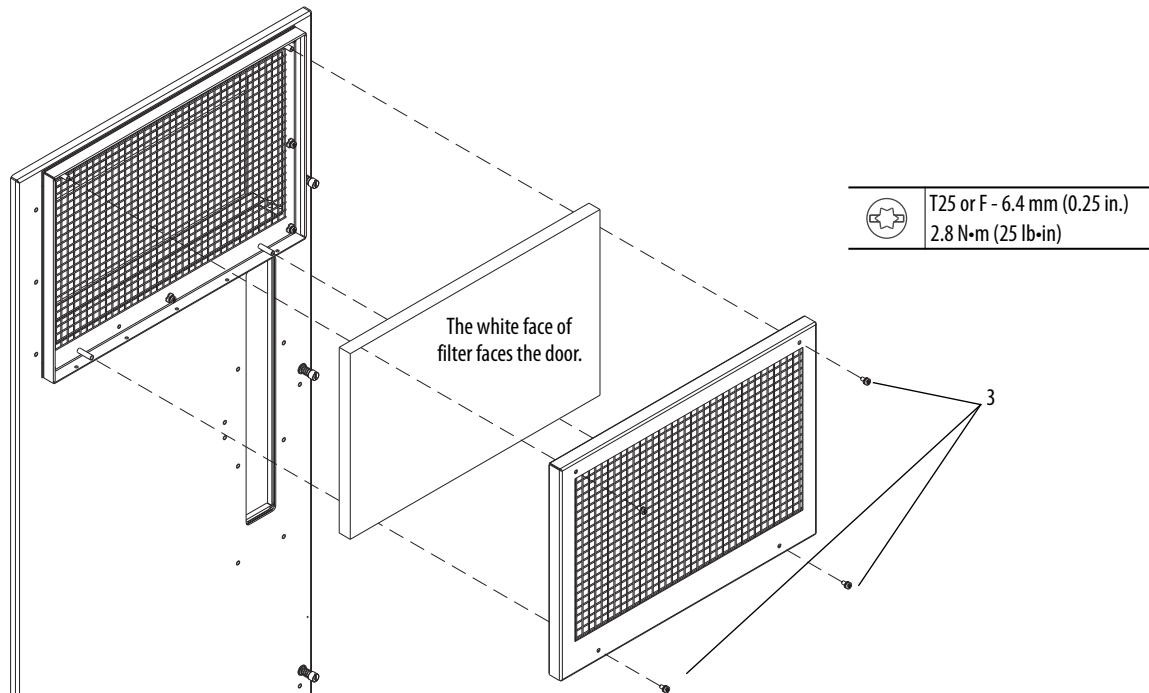
Install the IP20, NEMA/UL Type 1 Door Fan Harness (Frame 8 Only)

Install the door fan harness in the reverse order of removal. See Remove the IP20, NEMA/UL Type 1 Door Fan Harness (Frame 8) on page [353](#).

IP54, NEMA/UL Type 12 Cabinet Exhaust Blower Filter Removal/Installation

Remove the IP54, NEMA/UL Type 12 Cabinet Exhaust Blower Filter

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Remove the four hexalobular screws that secure the filter cover to the door and remove the filter and cover from the drive.



Install the IP54, NEMA/UL Type 12 Cabinet Exhaust Blower Filter

Install the IP54, NEMA/UL Type 12 cabinet exhaust blower in the reverse order of removal. See Remove the IP54, NEMA/UL Type 12 Cabinet Exhaust Blower Filter.

IP54, NEMA/UL Type 12 Cabinet Door-inlet Filters Removal/Installation

The steps to remove and install the IP54, NEMA/UL Type 12 cabinet door inlet filters is the same as the IP54, NEMA/UL Type 12 Cabinet Door Filters Removal/Installation procedures on page [314](#).

IP54, NEMA/UL Type 12 Cabinet Door-inlet Filter Cassette Removal/Installation

The steps to remove and install the IP54, NEMA/UL Type 12 cabinet door-inlet filter cassette is the same as the IP54, NEMA/UL Type 12 Cabinet-door Filter Cassette Removal/Installation procedures on page [316](#).

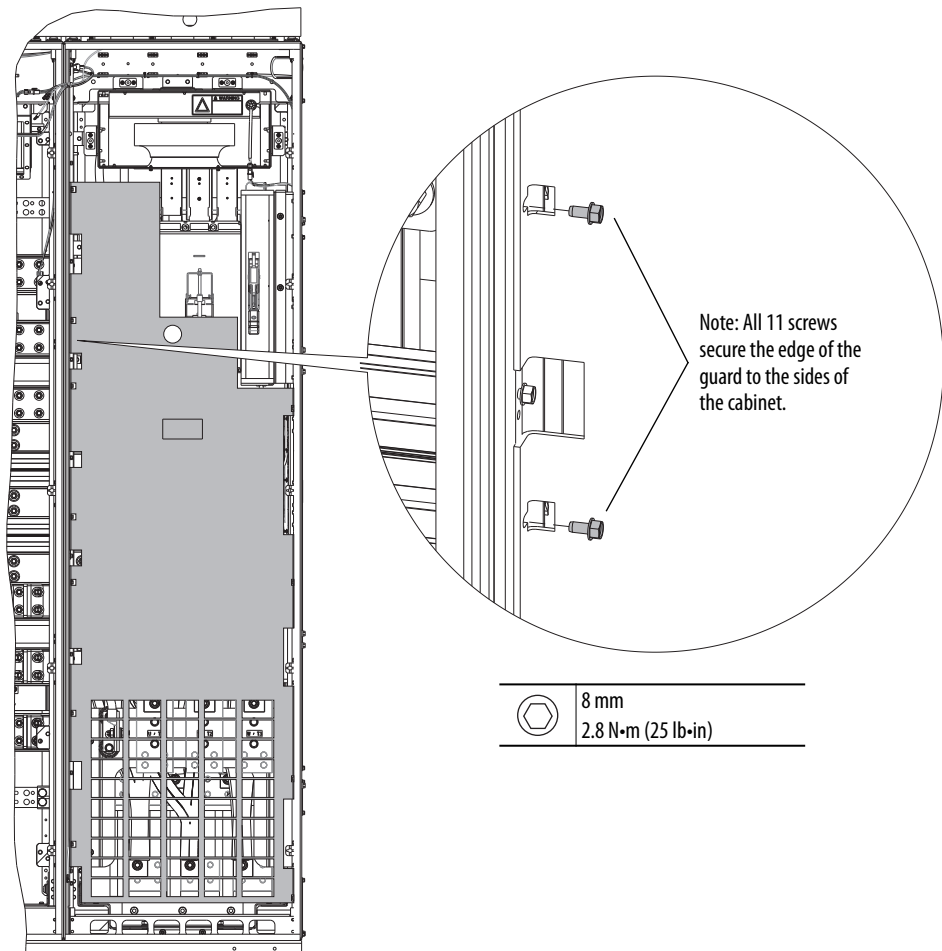
IP54, NEMA/UL Type 12 Cabinet Door Gasket Removal/Installation

The steps to remove and install the IP54, NEMA/UL Type 12 cabinet door gasket is the same as the IP54, NEMA/UL Type 12 Cabinet Door Gasket Removal/Installation procedures on page [317](#).

Frame 8 Option Bay Guard Removal/Installation

Remove the Frame 8 Option Bay Guard

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Loosen, but do not remove, the 11, M5 x 12 mm hex head screws that secure the guard to the cabinet frame and remove the guard.



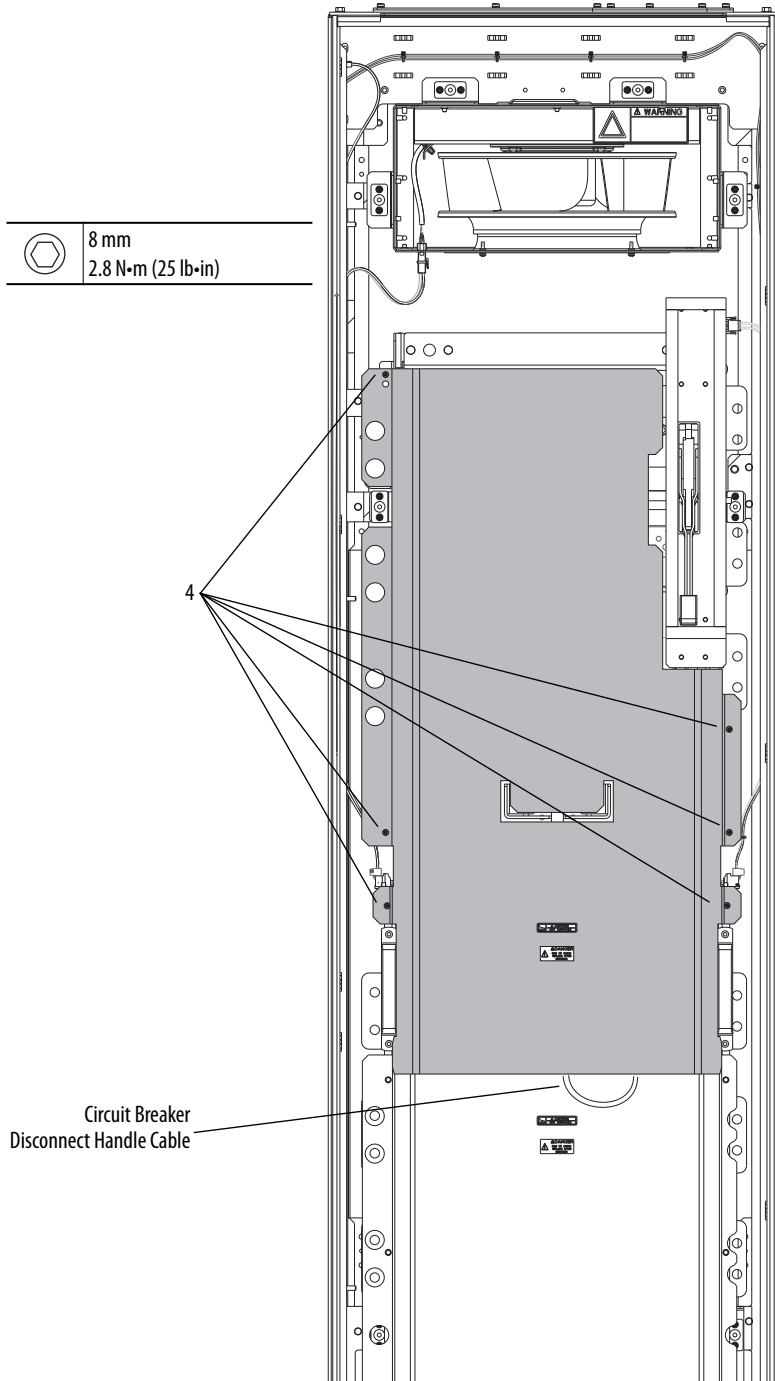
Install the Frame 8 Option Bay Guard

Install the frame 8 option bay guard in the reverse order of removal. See Remove the Frame 8 Option Bay Guard on page [356](#).

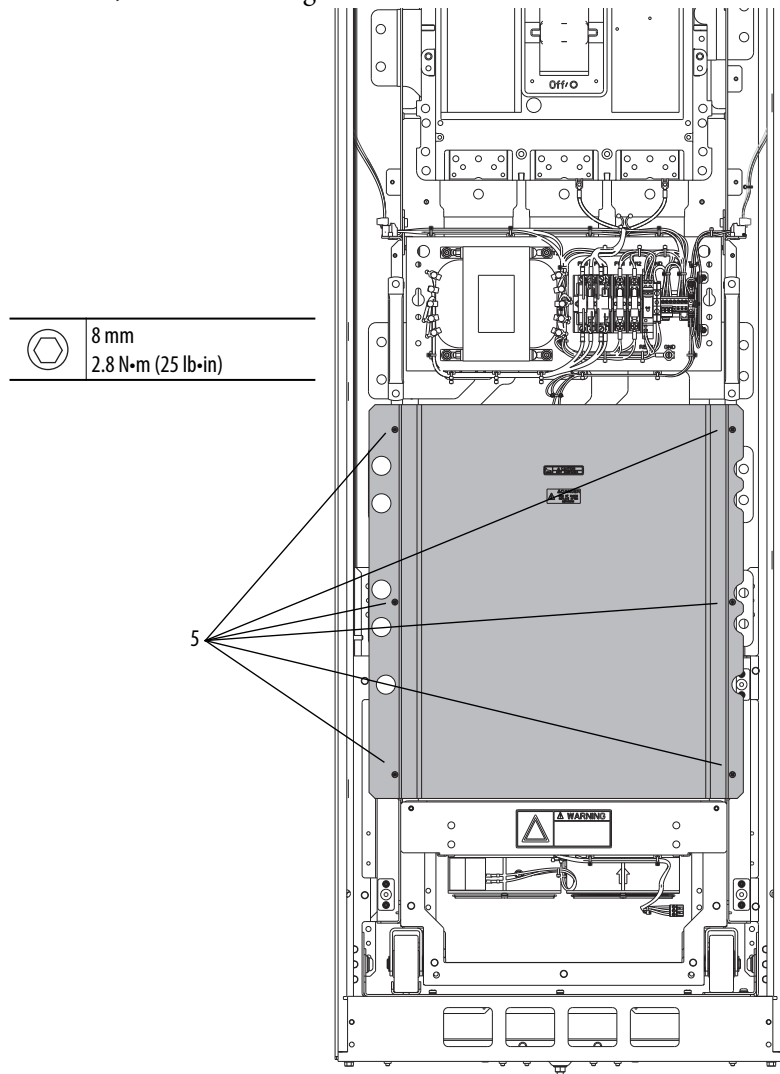
Frame 9 Series B Option Bay Guards Removal/Installation

Remove the Frame 9 Series B Option Bay Guards

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Remove the six nylon M5 hex nuts that secure the upper guard to the chassis, and remove the guard.



5. Remove the six nylon M5 hex nuts that secure the lower guard to the chassis, and remove the guard.



Install the Frame 9 Series B Option Bay Guards

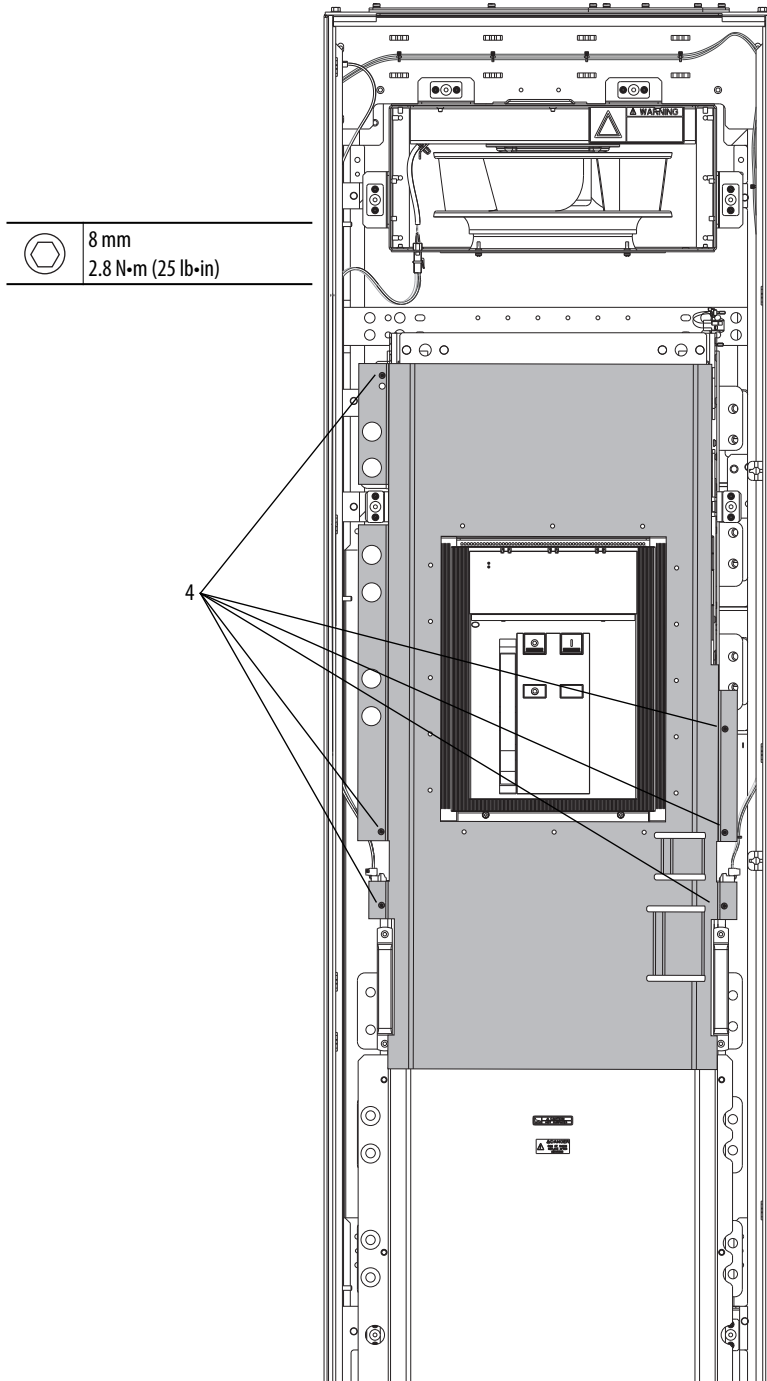
Install the frame 9 series B option bay guards in the reverse order of removal. See Remove the Frame 9 Series B Option Bay Guards on page [357](#).

IMPORTANT The circuit breaker disconnect handle cable must be positioned in front of the lower guard and behind the upper guard.

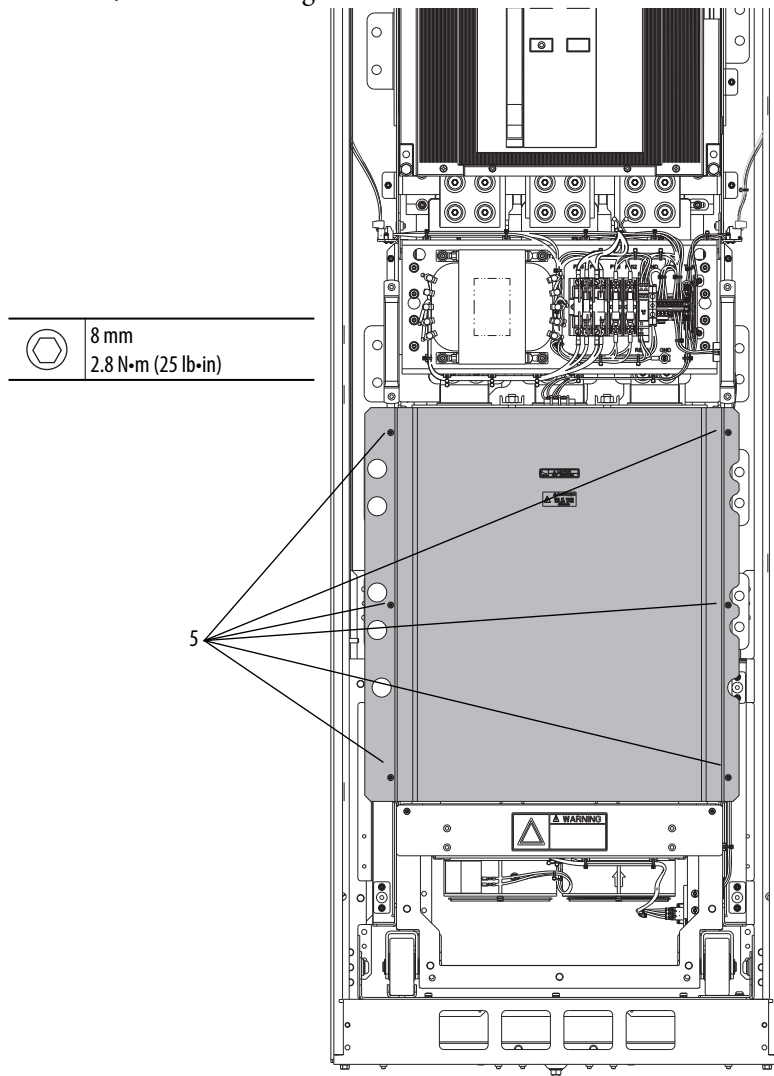
Frame 9 Series C Option Bay Guards Removal/Installation

Remove the Frame 9 Series C Option Bay Guards

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Remove the six nylon M5 hex nuts that secure the upper guard to the chassis, and remove the guard.



5. Remove the six nylon M5 hex nuts that secure the lower guard to the chassis, and remove the guard.



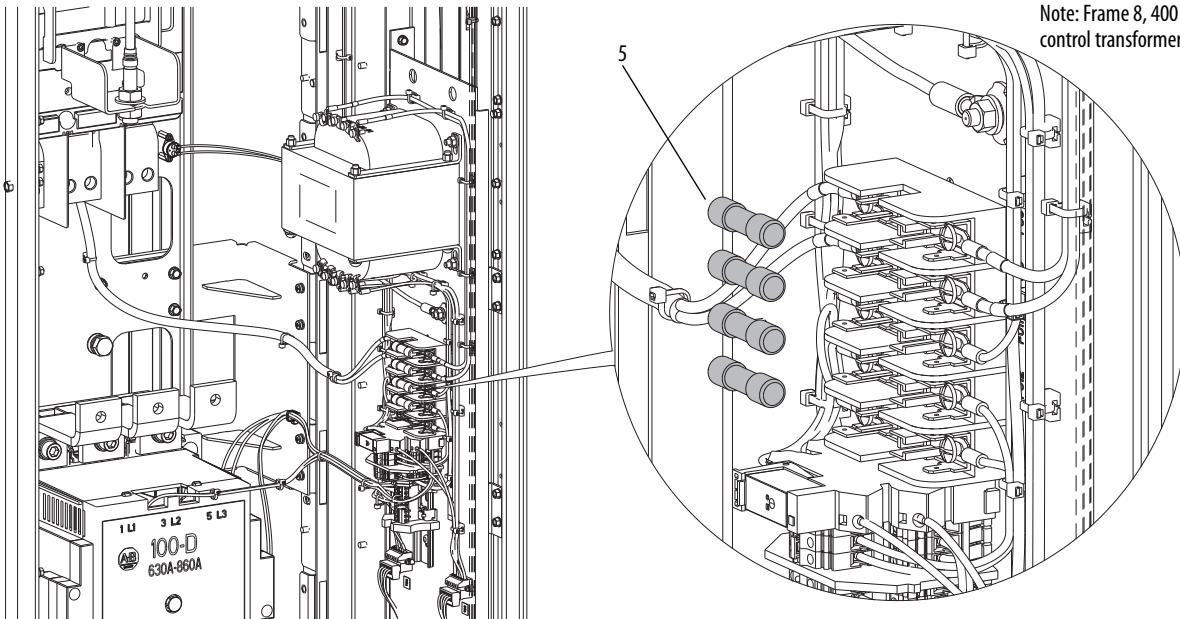
Install the Frame 9 Series C Option Bay Guards

Install the frame 9 series C option bay guards in the reverse order of removal. See [Remove the Frame 9 Series C Option Bay Guards on page 359](#).

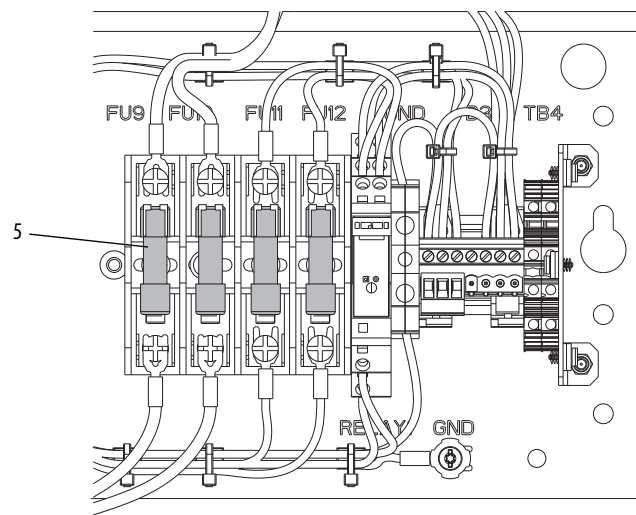
Control Transformer Fuses Removal/Installation

Remove the Control Transformer Fuses

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Remove the guards. See Remove the Frame 8 Option Bay Guard on page [356](#), or Remove the Frame 9 Series B Option Bay Guards on page [357](#).
5. To remove the fuses from the two-position fuse holders, use a fuse puller.



Note: Frame 8, 400...600V control transformer shown.



Note: Frame 9, 600V and below control transformer shown.

Install the Control Transformer Fuses

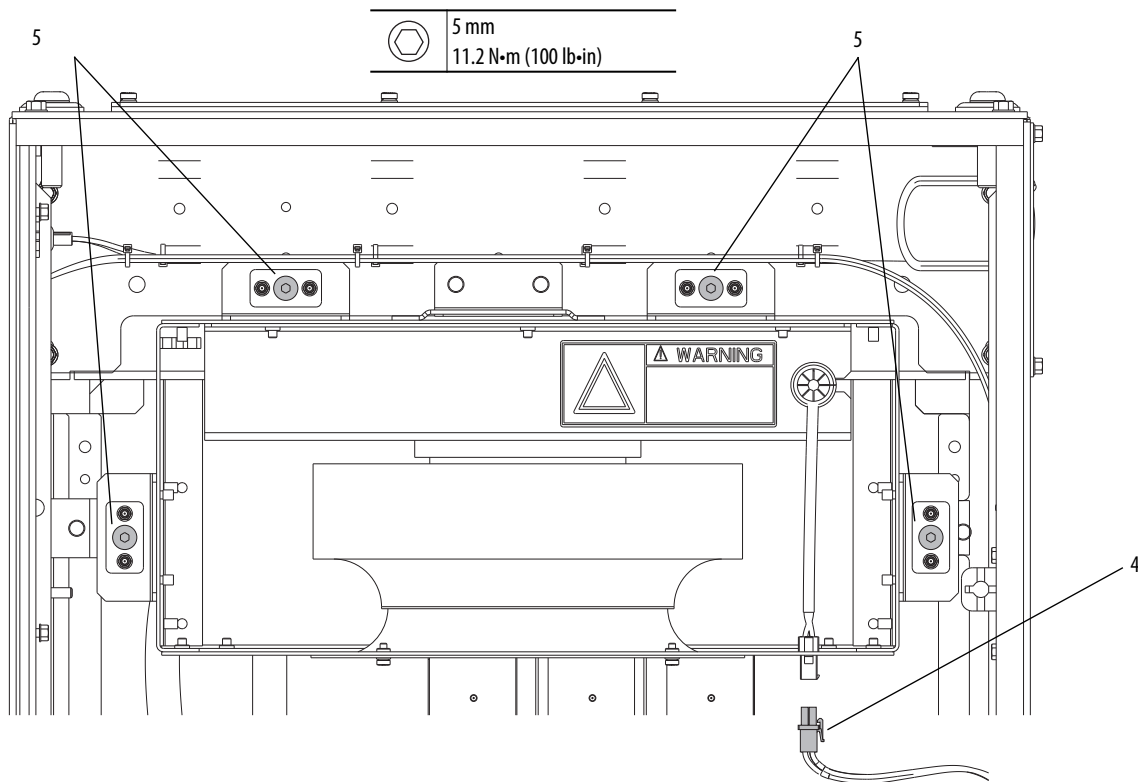
Install the control transformer fuses in the reverse order of removal. See Remove the Control Transformer Fuses on page [361](#). Also, see the frame 8 and frame 9 option bay schematics in [Appendix A](#) on page [423](#) for fuse designations.

Frame 8 IP54, NEMA/UL Type 12 Cabinet Blower Assembly Removal/Installation

Remove the Frame 8 IP54, NEMA/UL Type 12 Cabinet Blower Assembly

Note: The blower assembly weights approximately 12.4 kg (27.3 lb).

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Disconnect the four-position blower power harness connector from the connector on the bottom of the blower assembly.
5. Loosen the four captive 5 mm hex screws that secure the blower assembly to the cabinet frame and remove the assembly from the drive.



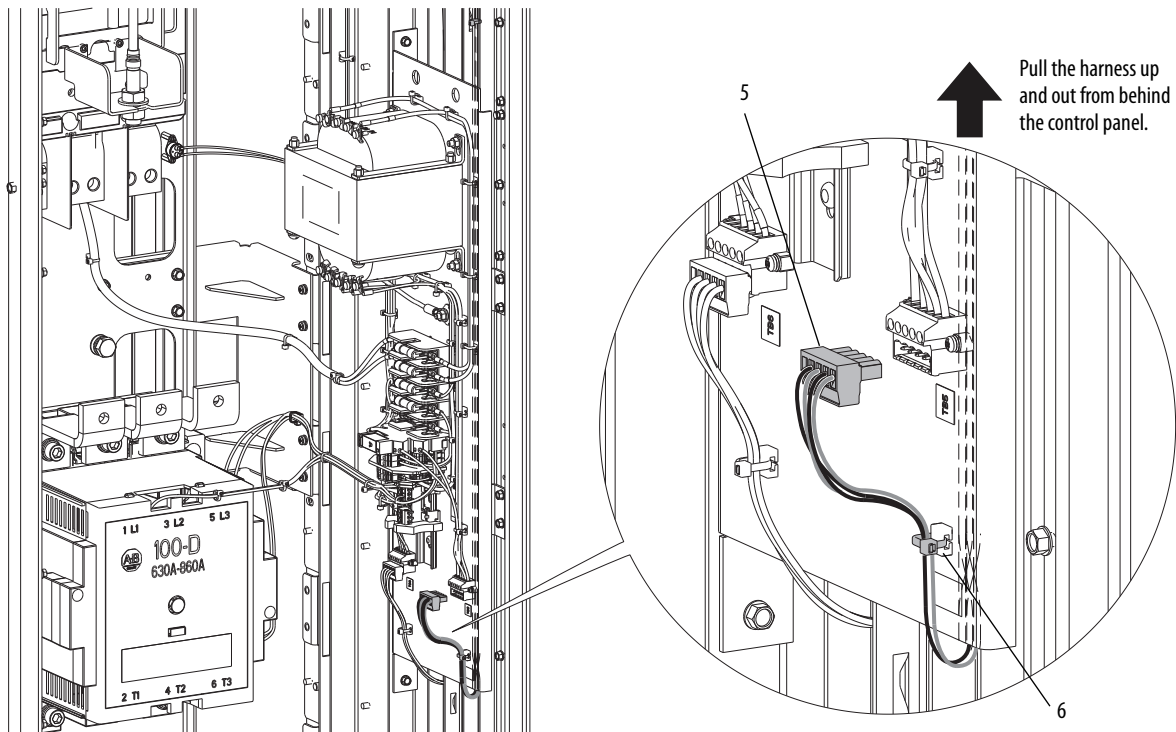
Install the Frame 8 IP54, NEMA/UL Type 12 Cabinet Blower Assembly

Install the frame 8 IP54, NEMA/UL Type 12 cabinet blower assembly in the reverse order of removal. See Remove the Frame 8 IP54, NEMA/UL Type 12 Cabinet Blower Assembly on page [362](#).

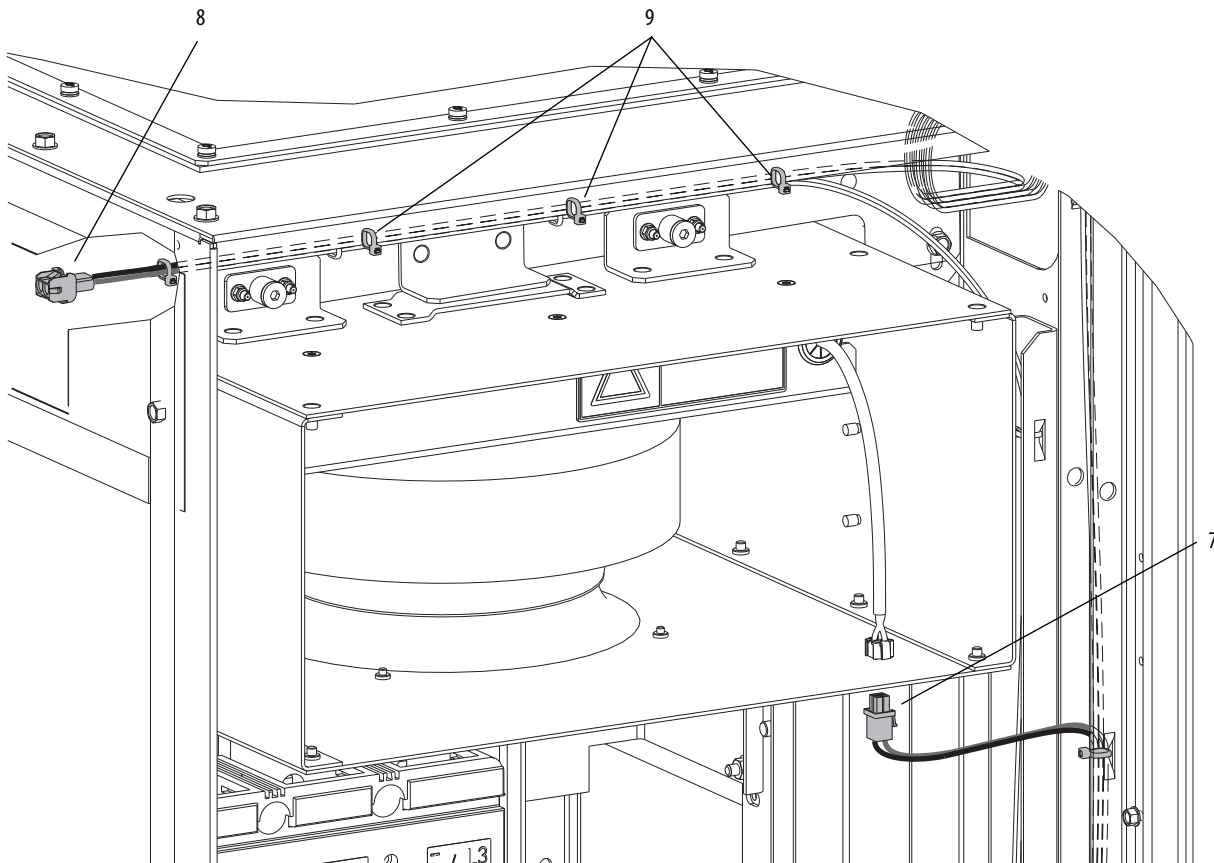
Frame 8 IP54, NEMA/UL Type 12 Cabinet Blower Wire Harness Removal/Installation

Remove the Frame 8 IP54, NEMA/UL Type 12 Cabinet Blower Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Remove the guard. See Remove the Frame 8 Option Bay Guard on page [356](#).
5. Disconnect the power connector from terminal block TB5 on the control transformer panel on the right side of the cabinet.
6. Open the releasable cable tie that secures the harness to the control transformer panel and pull the harness up from behind the panel.



7. Disconnect the cable connector from the blower assembly.
8. Disconnect the two-position blower harness connector from the drive bay connector.
9. Open the releasable cable ties that secure the blower harness to the enclosure wireway and remove the harness.



Install the Frame 8 IP54, NEMA/UL Type 12 Cabinet Blower Wire Harness

Install the IP54, NEMA/UL Type 12 cabinet blower wire harness in the reverse order of removal. See Remove the Frame 8 IP54, NEMA/UL Type 12 Cabinet Blower Wire Harness on page [363](#).

Frame 8 Control Transformer Removal/Installation

Remove the Frame 8 Control Transformer

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.

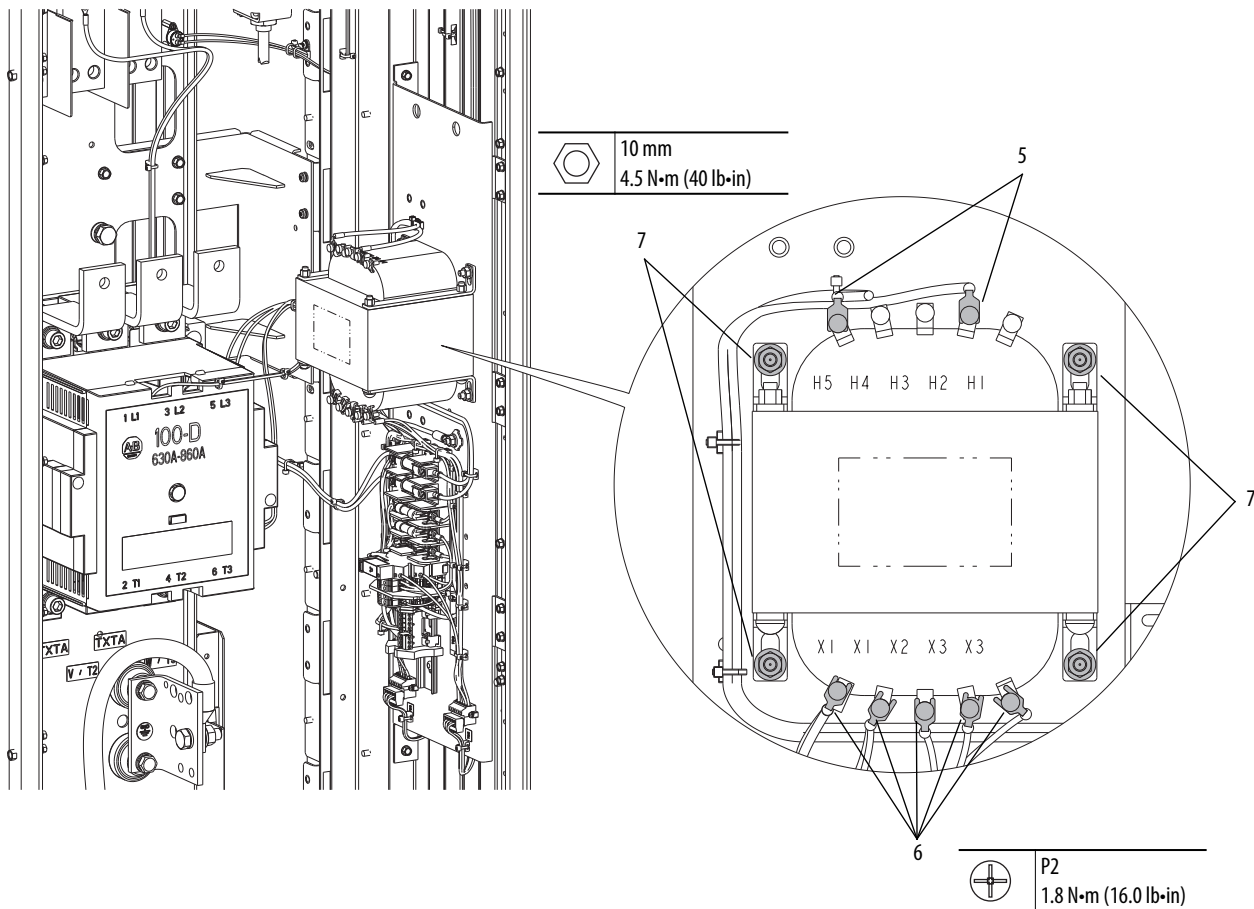
- Remove the guard. See Remove the Frame 8 Option Bay Guard on page [356](#).

IMPORTANT Before you disconnect the control-transformer primary wires leads, note the terminal connections. The control transformer has multiple input phase terminals. See Frame 8 AC Input IP20 Option Bay with a Control Transformer Schematic Diagram on page [431](#) or Frame 8 AC Input IP54 Option Bay Schematic Diagram on page [432](#) for more information.

- Loosen the M4 screws that secure the primary wire leads to the Hx terminals at the top of the transformer and remove the wires.
- Loosen the M4 screws that secure the secondary wire leads to the X1...X3 terminals at the bottom of the transformer and remove the wires.

IMPORTANT The control transformer is heavy. Be sure to support it as you remove the screws, so it does not fall and damage other components.

- Remove the four M6 nuts and washers that secure the transformer to the control panel and remove the control transformer.



Install the Frame 8 Control Transformer

Install the frame 8 control transformer in the reverse order of removal. See Remove the Frame 8 Control Transformer on page [364](#).

IMPORTANT The control transformer has multiple input phase terminals. See Frame 8 AC Input IP20 Option Bay with a Control Transformer Schematic Diagram on page [431](#) or Frame 8 AC Input IP54 Option Bay Schematic Diagram on page [432](#) for more information.

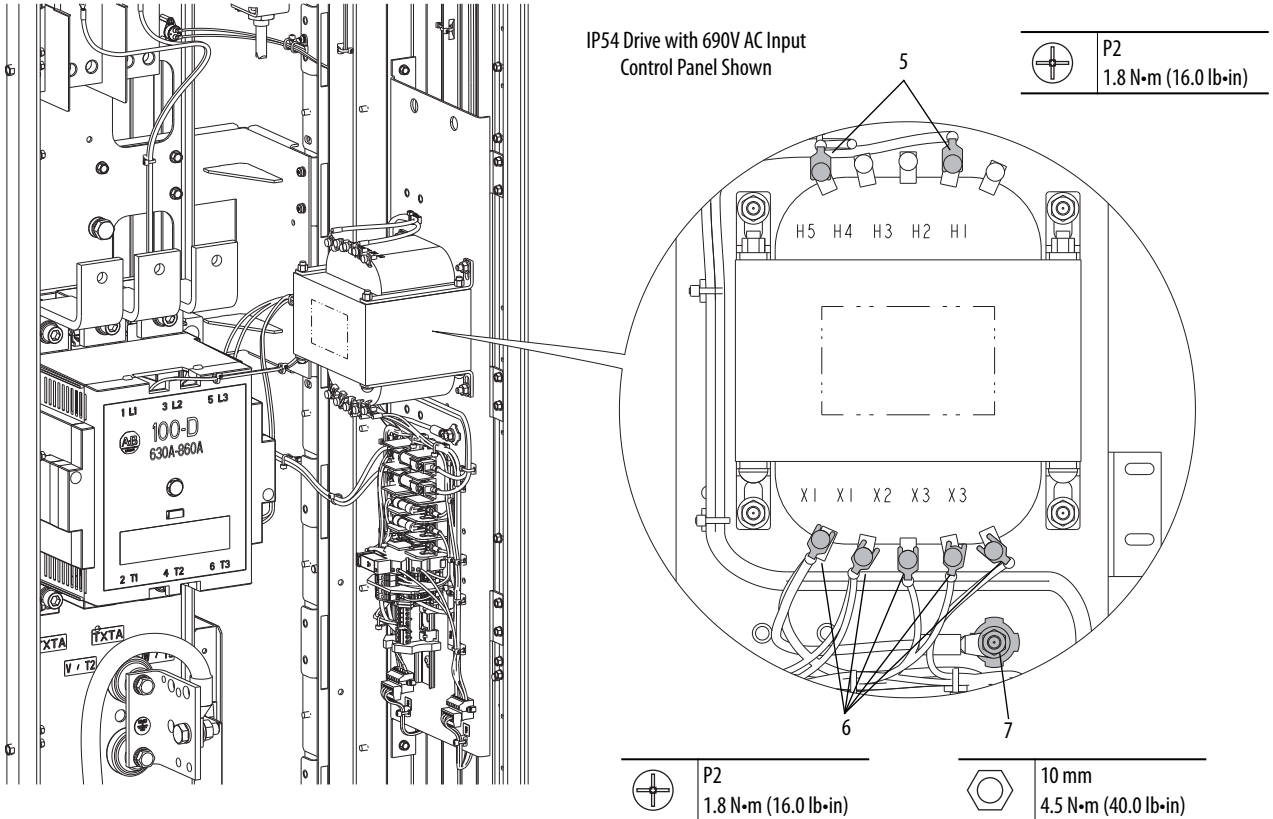
Frame 8 Control Transformer Wire Harness Removal/Installation

Remove the Frame 8 Control Transformer Wire Harness

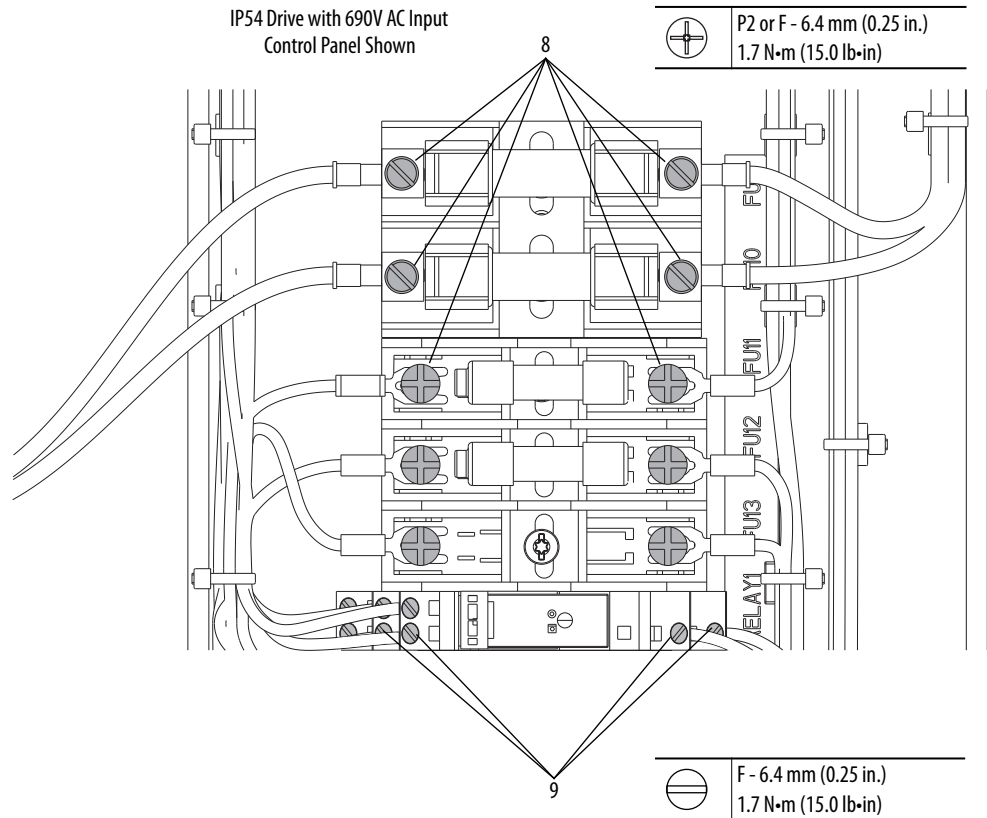
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Remove the guard. See Remove the Frame 8 Option Bay Guard on page [356](#).

IMPORTANT Before you disconnect the control-transformer primary wires leads, note the terminal connections. The control transformer has multiple input phase terminals. See Frame 8 AC Input IP20 Option Bay with a Control Transformer Schematic Diagram on page [431](#) or Frame 8 AC Input IP54 Option Bay Schematic Diagram on page [432](#) for more information.

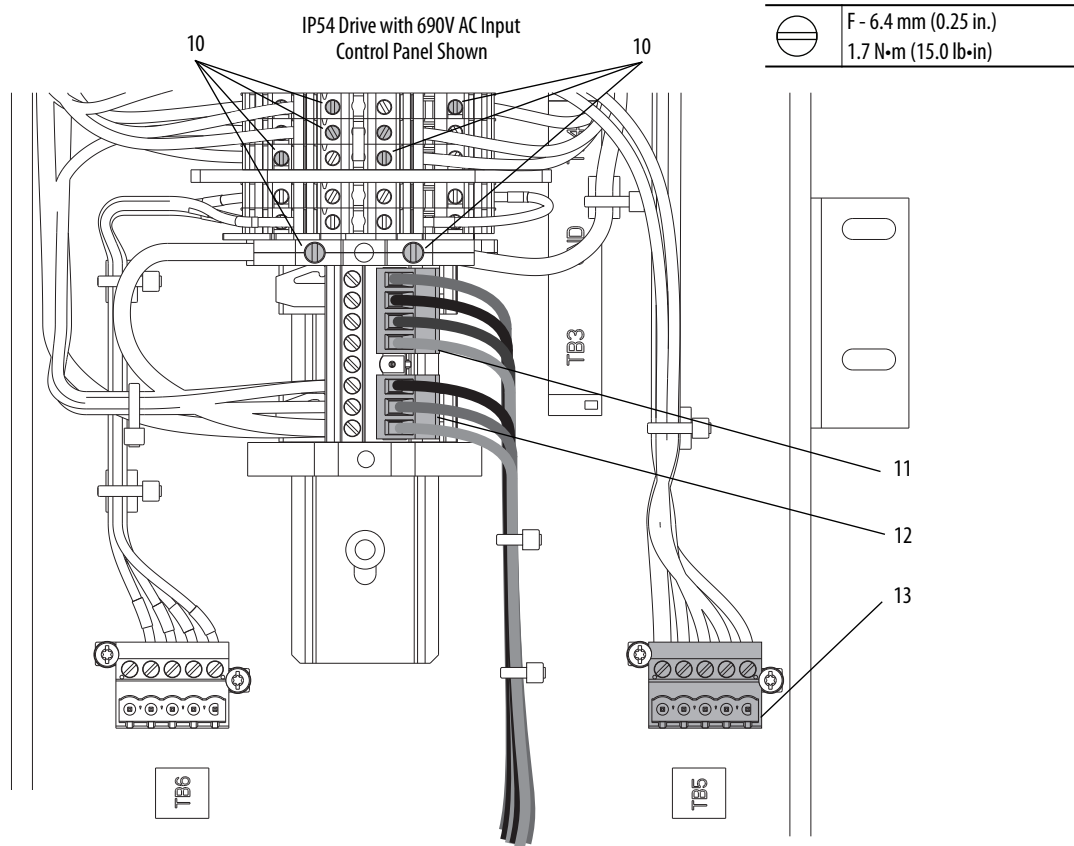
5. Loosen the M4 screws that secure the primary wire leads to the Hx terminals at the top of the transformer and remove the wires.
6. Loosen the M4 screws that secure the secondary wire leads to the X1...X3 terminals at the bottom of the transformer and remove the wires.
7. Remove the M6 nut and washer that secures the ground wire (GND) to the control panel. Retain the screw and washer for reuse.



8. Loosen the screws that secure each of the wire leads to the fuse holders (FU9, FU10, FU11, FU12, FU13) and remove the wires.
9. For IP54 drives only, loosen the screws that secure the wires to the relay terminal block (RELAY1) and remove the wires.

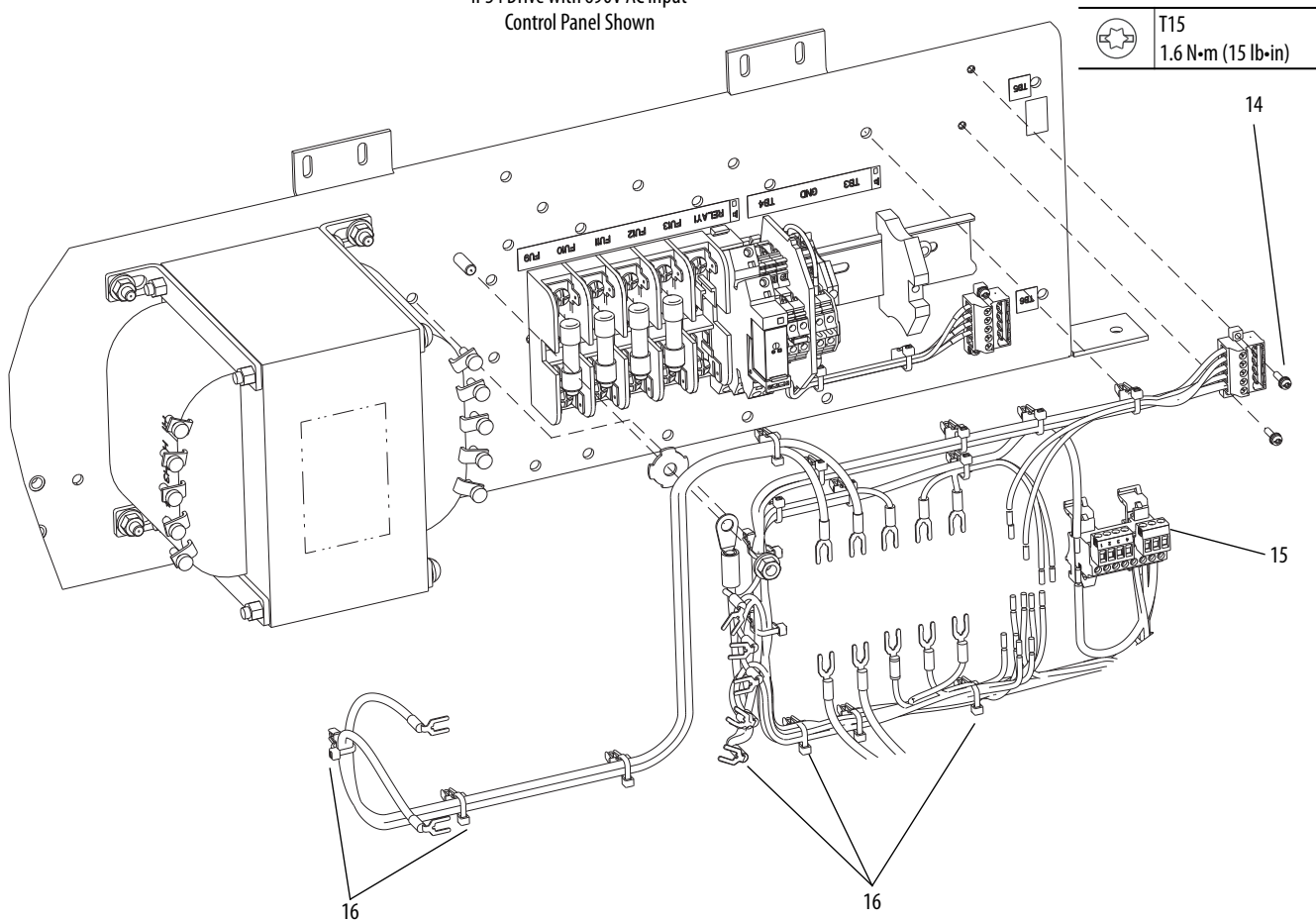


10. Loosen the screws that secure the wires to terminal blocks TB4 and GND.
11. If present, disconnect the four-position contactor status connector from terminal block TB3.
12. If present, disconnect the three-position control power connector from terminal block TB3.
13. For IP54 drives, disconnect the five-position blower power connector from terminal blocks TB5.



14. For IP54 drives, remove the two screws that secure terminal block TB5 to the control panel and remove the terminal block. Retain the screws for reuse. Torque requirement for reassembly is 1.6 N•m (15 lb•in).
15. Use a flat nose screwdriver to remove the push-mount terminal block TB3 from the DIN rail.
16. Remove the removable cable tie mounts that secure the wire harness to the control panel and remove the wire harness.

IP54 Drive with 690V AC Input
Control Panel Shown



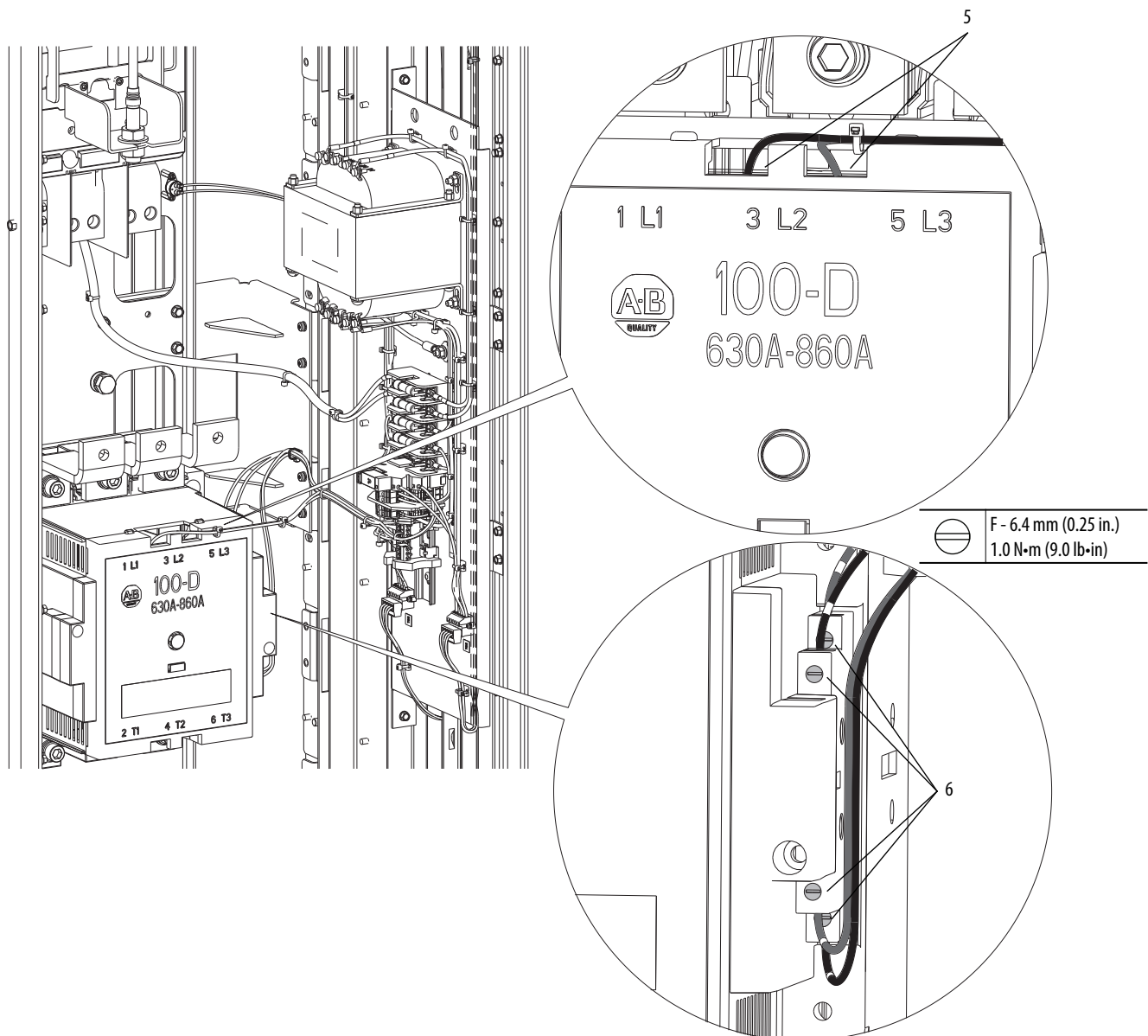
Install the Frame 8 Control Transformer Wire Harness

Install the frame 8 control transformer wire harness in the reverse order of removal. See Remove the Frame 8 Control Transformer Wire Harness on page [366](#).

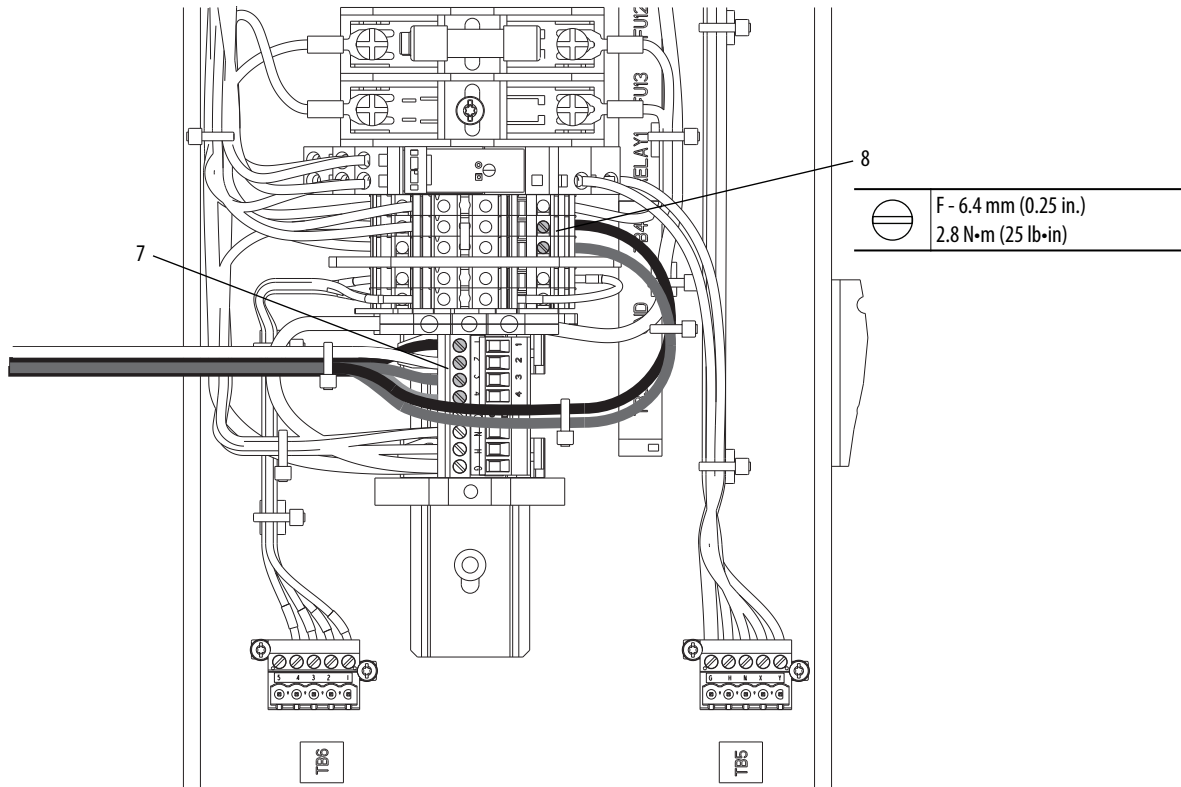
Frame 8 Contactor Wire Harness Removal/ Installation

Remove the Frame 8 Contactor Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Remove the guard. See Remove the Frame 8 Option Bay Guard on page [356](#).
5. Loosen the screws that secure the wire leads to terminals A1 and A2 on the top of the contactor and remove the wires.
6. Loosen the screws that secure the wire leads to terminals 13, 14, 21, and 22 on the side of the contactor and remove the wires.



7. Loosen the screws that secure the four wires to the top of terminal block TB3 on the control panel and remove the wires.
8. Loosen the screws that secure the two wires to the bottom of terminal block TB4 on the control panel and remove the wire harness.



Install the Frame 8 Contactor Wire Harness

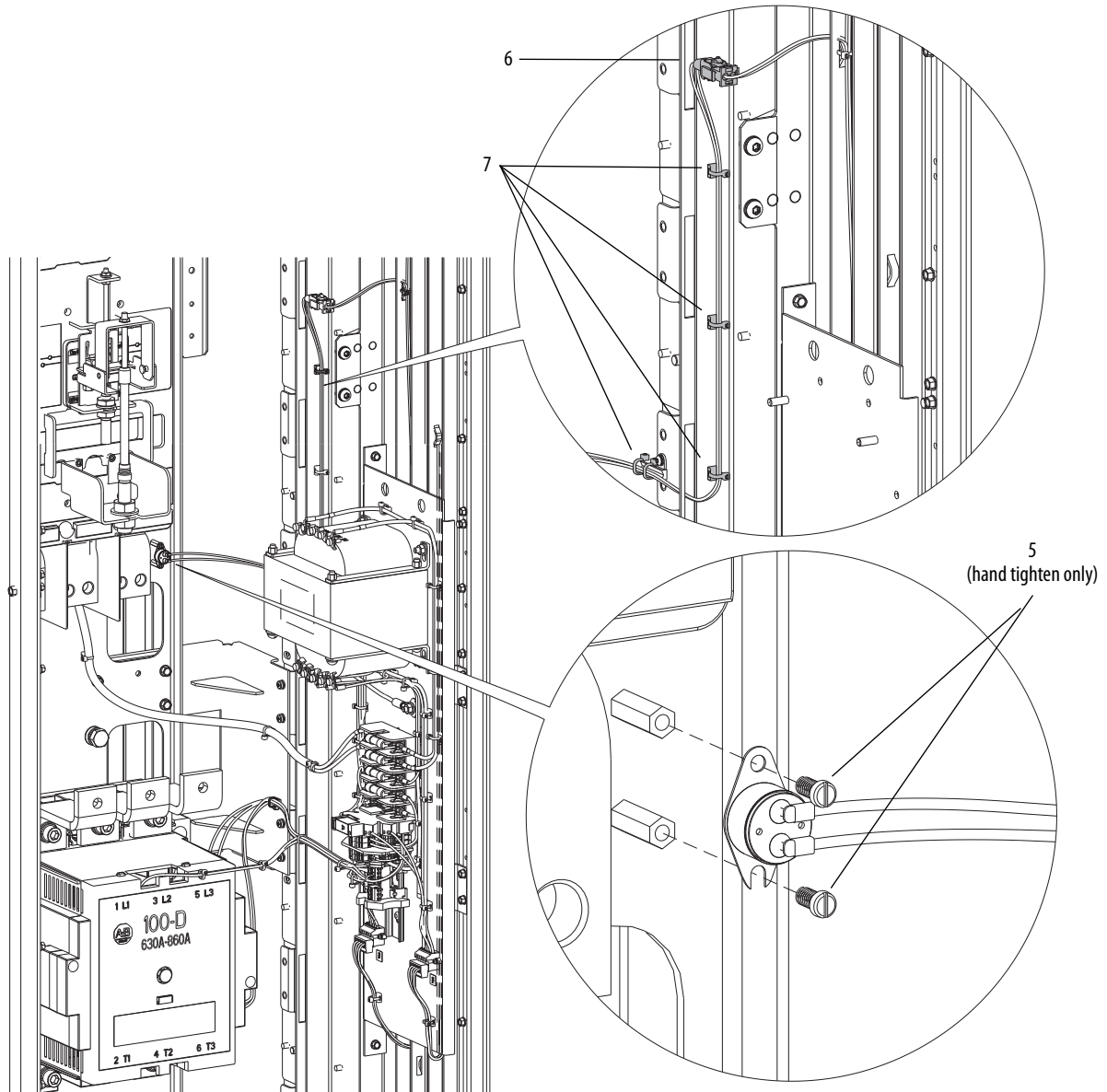
Install the frame 8 contactor wire harness in the reverse order of removal. See Remove the Frame 8 Contactor Wire Harness on page [371](#).

Frame 8 Thermostat and Wire Harness Removal/Installation

Remove the Frame 8 Thermostat and Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay enclosure door.
4. Remove the guard. See Remove the Frame 8 Option Bay Guard on page [356](#).

5. Remove the two nylon screws that secure the thermostat to the mounting standoffs and remove the thermostat and wire harness.
6. Disconnect the thermostat wire harness from the connector on the side of the cabinet frame.
7. Remove the cable tie mounts from the cabinet frame and remove the wire harness.



Install the Frame 8 Thermostat and Wire Harness

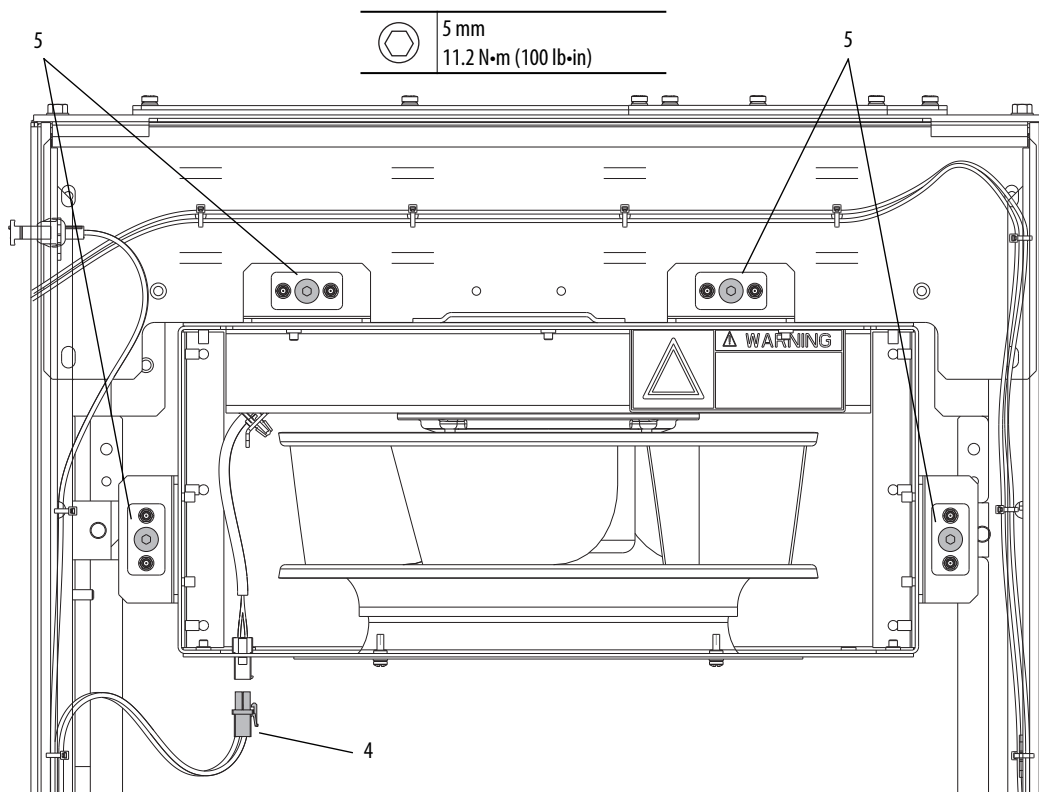
Install the thermostat and wire harness in the reverse order of removal. See Remove the Frame 8 Thermostat and Wire Harness on page [372](#).

Frame 9 Cabinet Blower Assembly Removal/Installation

Remove the Frame 9 Cabinet Blower Assembly

Note: The blower assembly weights approximately 12.4 kg (27.3 lb).

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Disconnect the blower power connector from the connector on the bottom of the blower assembly.
5. Loosen the four captive 5 mm hex screws that secure the blower assembly to the cabinet frame and remove the assembly from the drive.



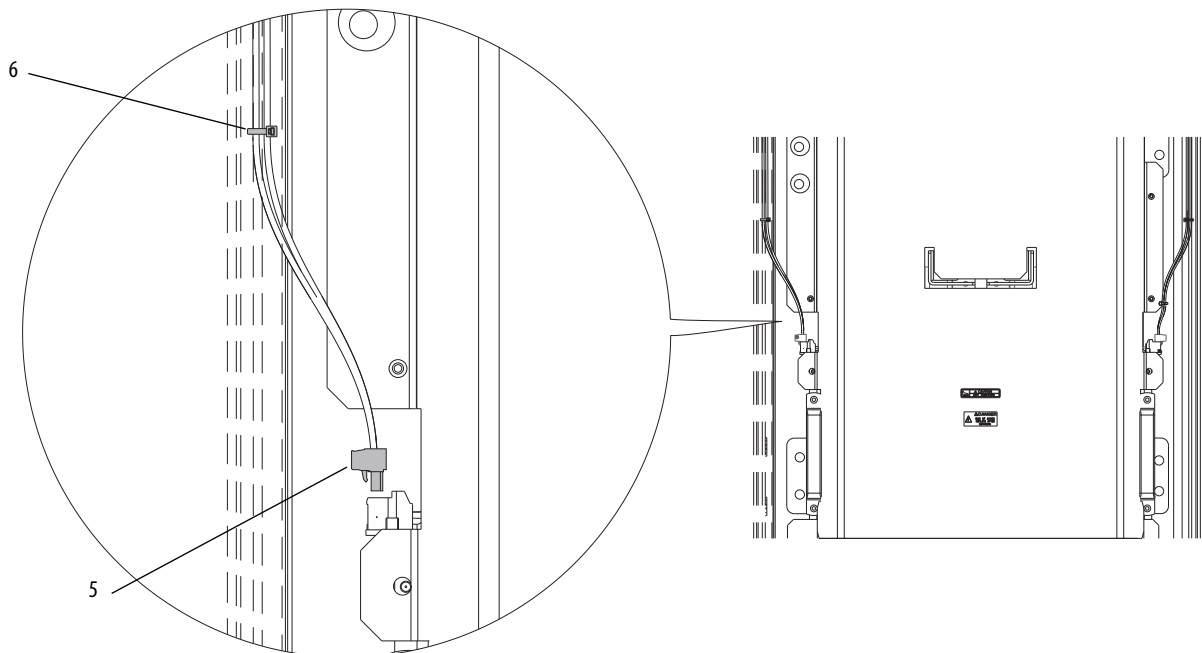
Install the Frame 9 Cabinet Blower Assembly

Install the frame 9 cabinet blower assembly in the reverse order of removal. See Remove the Frame 9 Cabinet Blower Assembly on page [374](#).

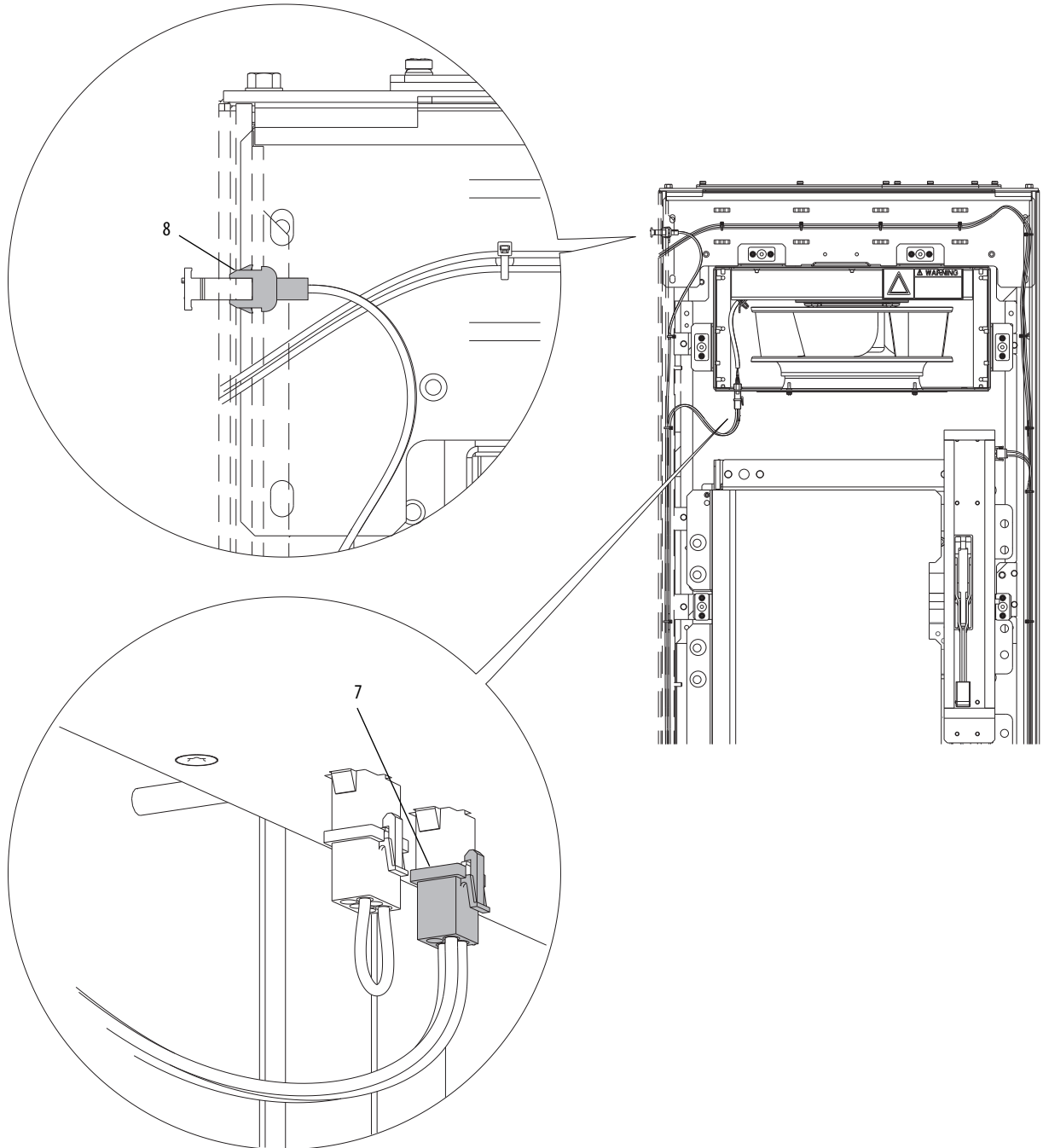
Frame 9 Cabinet Blower Wire Harness Removal/Installation

Remove the Frame 9 Cabinet Blower Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Remove the upper guard. See Remove the Frame 9 Series B Option Bay Guards on page [357](#).
5. Disconnect the blower wire harness from the terminal block on the left side of the control panel.
6. Open the releasable cable ties that secure the harness to the side of the cabinet.



7. Disconnect the blower power connector from the connector on the bottom of the blower assembly.
8. Disconnect the connector from the drive bay connector and remove the harness



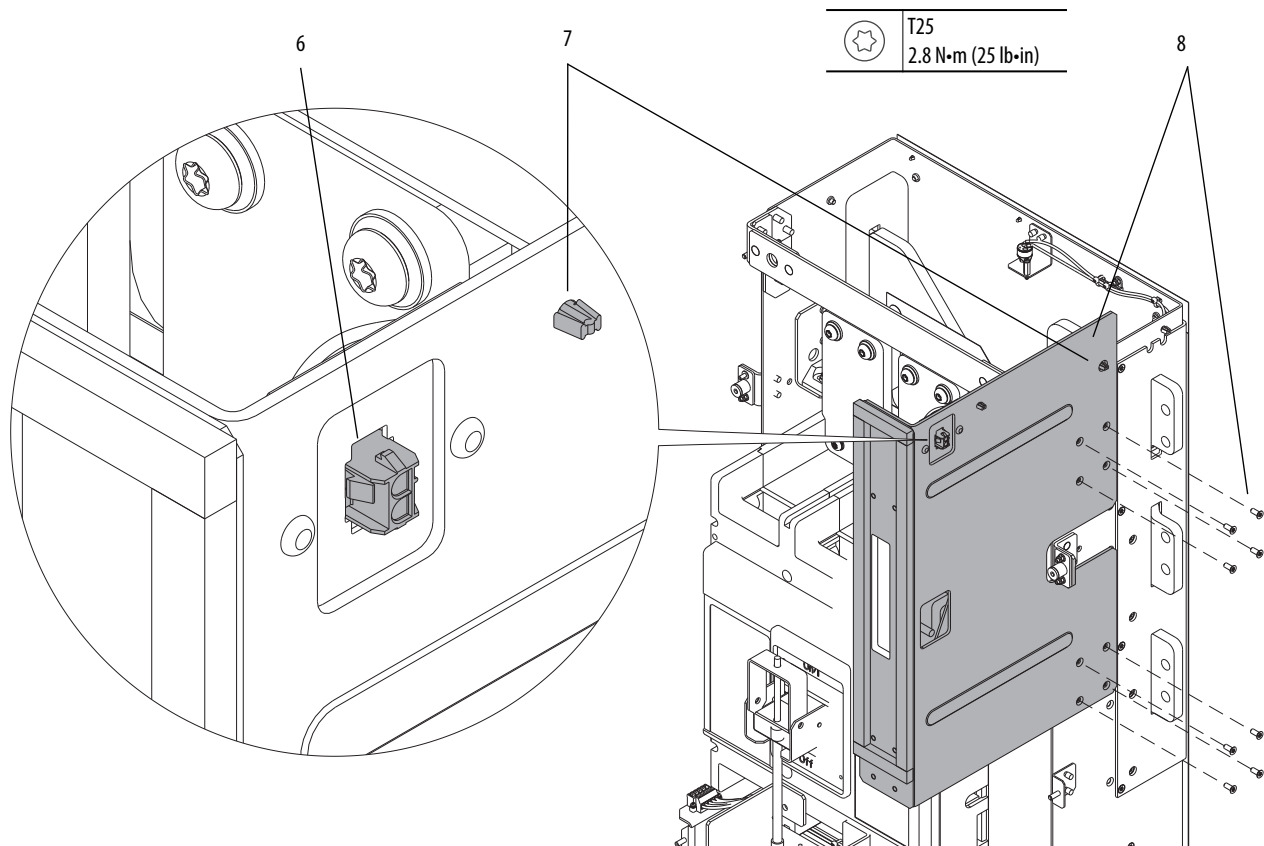
Install the Frame 9 Cabinet Blower Wire Harness

Install the frame 9 cabinet blower wire harness in the reverse order of removal. See Remove the Frame 9 Cabinet Blower Wire Harness on page [375](#).

Frame 9 Circuit Breaker Disconnect Handle Panel (Series A) Removal/Installation

Remove the Frame 9 Circuit Breaker Disconnect Handle Panel (Series A)

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Remove the power option assembly from the cabinet. See the PowerFlex 750-Series AC Drives Installation Instructions, publication [750-IN001](#) for details.
5. Remove the circuit breaker disconnect handle per the manufacturer's instructions.
6. Push the thermostat harness connector through the cutout in the top of the panel.
7. Remove the two cable tie mounts from the panel and remove the thermostat wire harness.
8. Remove the eight M5 x 12 mm hexalobular screws that secure the disconnect handle panel to the power option assembly and remove the panel.



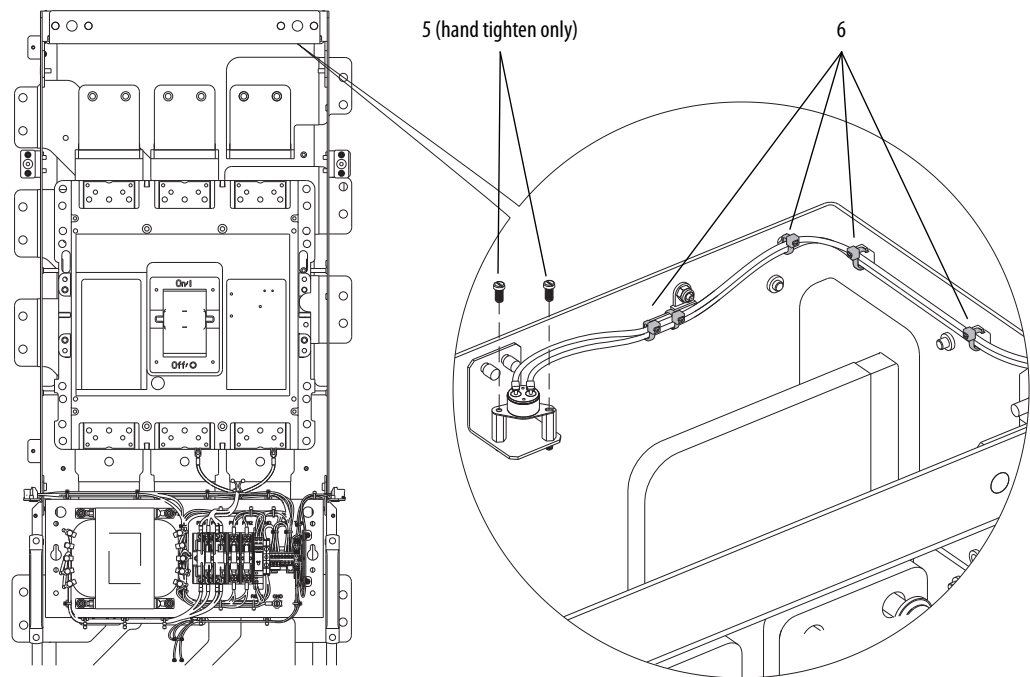
Install the Frame 9 Circuit Breaker Disconnect Handle Panel (Series A)

Install the frame 9 circuit breaker disconnect handle panel (series A) in the reverse order of removal. See Remove the Frame 9 Circuit Breaker Disconnect Handle Panel (Series A) on page [377](#).

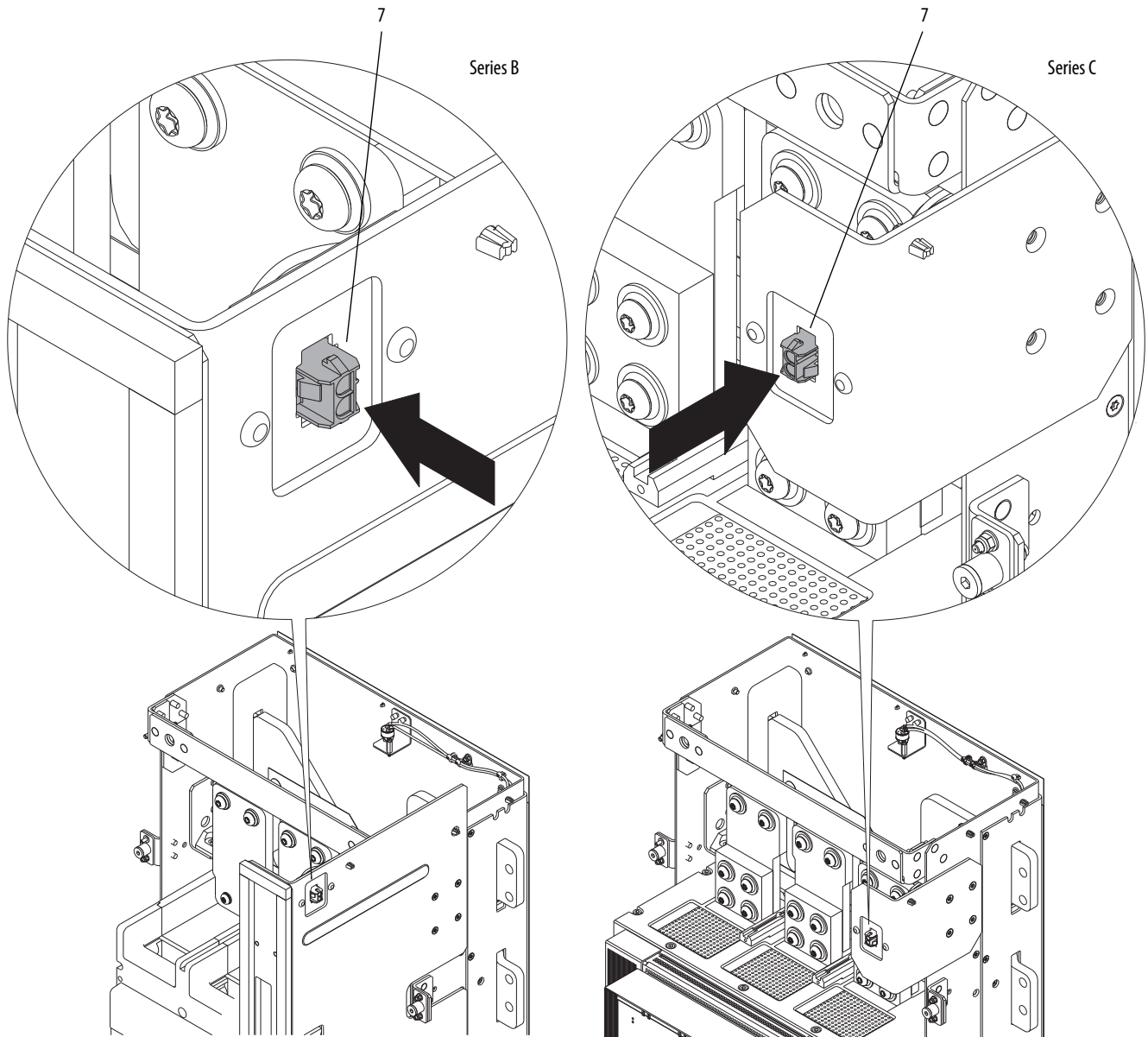
Frame 9 Thermostat and Wire Harness Removal/Installation

Remove the Frame 9 Thermostat and Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Remove the power option assembly from the cabinet. See the PowerFlex 750-Series AC Drives Installation Instructions, publication [750-IN001](#) for details.
5. Remove the two nylon screws that secure the thermostat to the mounting standoffs and remove the thermostat.
6. Open the releasable cable ties that secure the harness to the chassis.



7. Push the thermostat harness connector through the cutout in the top of the panel and remove the thermostat and wire harness.



Install the Frame 9 Thermostat and Wire Harness

Install the frame 9 thermostat and wire harness in the reverse order of removal. See Remove the Frame 9 Thermostat and Wire Harness on page [378](#).

Frame 9 Control Transformer Removal/Installation

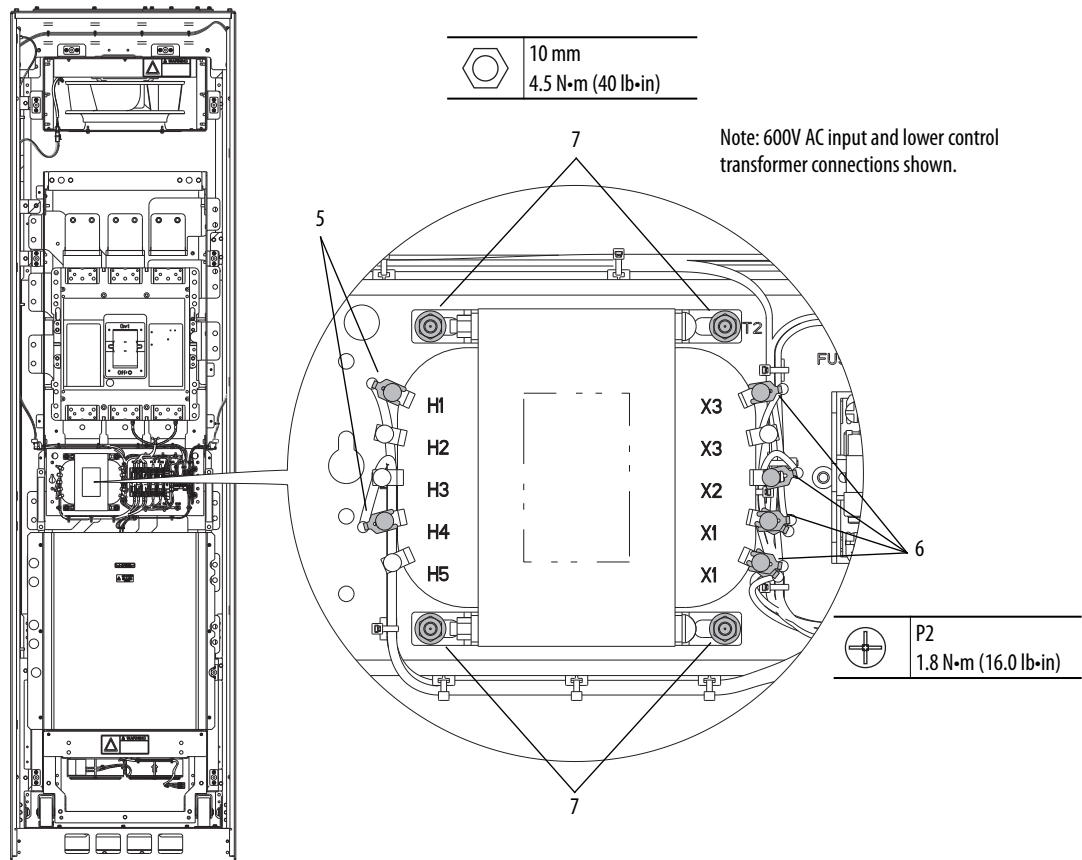
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Remove the upper guard. See Remove the Frame 9 Series B Option Bay Guards on page [357](#).

IMPORTANT Before you disconnect the control-transformer primary wires leads, note the terminal connections. The control transformer has multiple input phase terminals. See Frame 9 AC Input Option Bay Schematic Diagram on page [433](#) for more information.

5. Loosen the M4 screws that secure the primary wire leads to the Hx terminals on the left side of the transformer and remove the wires.
6. Loosen the M4 screws that secure the secondary wire leads to the X1...X3 terminals on the right side of the transformer and remove the wires.

IMPORTANT The control transformer is heavy. Be sure to support it as you remove the screws, so it does not fall and damage other components.

7. Remove the four M6 nuts and washers that secure the transformer to the control panel and remove the control transformer.



Install the Frame 9 Control Transformer

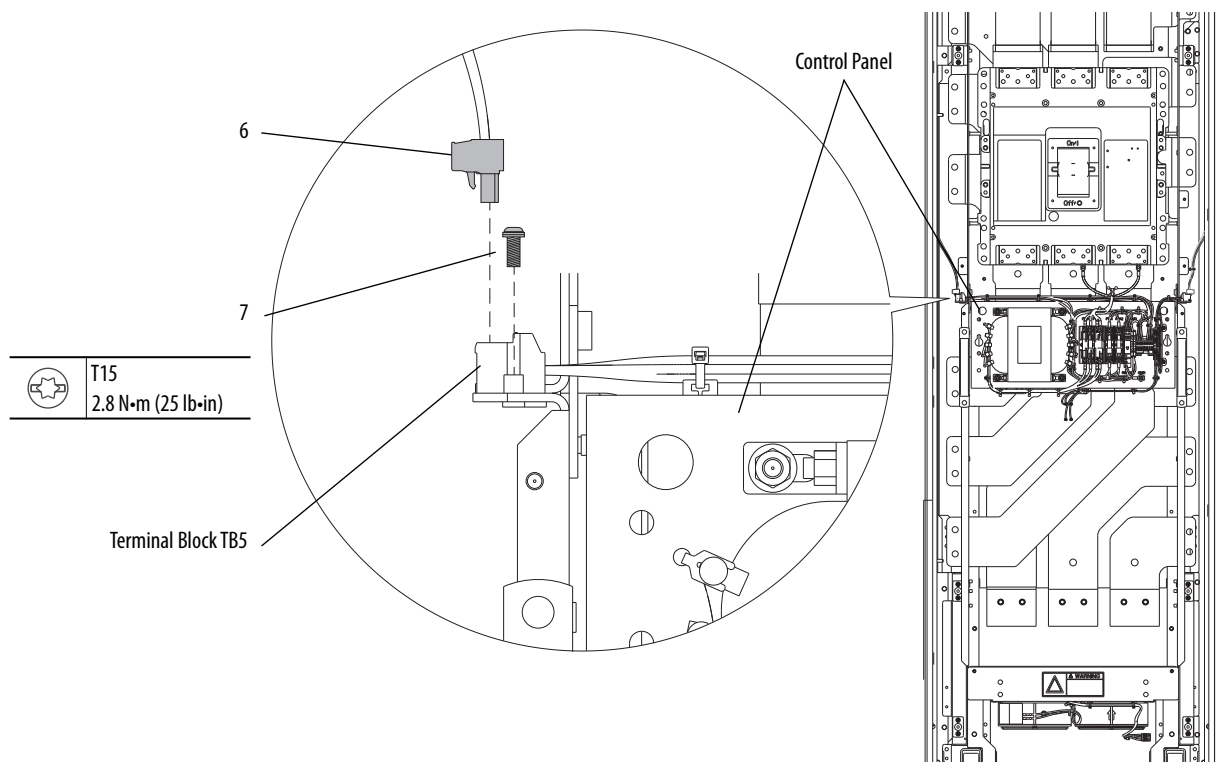
Install the frame 9 control transformer in the reverse order of removal. See Remove the Frame 9 Control Transformer on page [380](#).

IMPORTANT The control transformer has multiple input phase terminals. See Frame 9 AC Input Option Bay Schematic Diagram on page [433](#) for more information.

Frame 9 Main Control-panel Wire Harness Removal/Installation

Remove the Frame 9 Main Control-panel Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Remove the guards. See Remove the Frame 9 Series B Option Bay Guards on page [357](#).
5. Loosen the two screws that secure the wires from the control panel to the door interlock and remove the wires.
6. Disconnect the blower wire harness from terminal block TB5 on the left side of the control panel.
7. Remove the two M3 x 12 mm hexalobular screws and washers that secure the terminal block to the left side of the control panel. Retain the screws and washers for reuse.



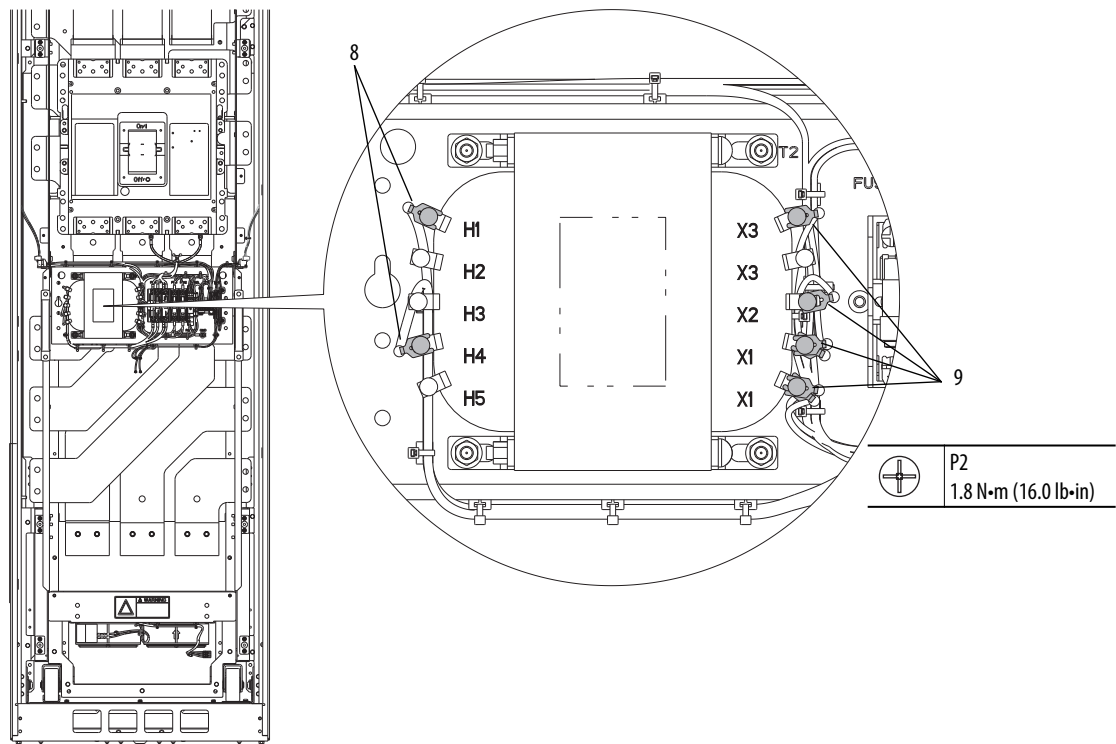
IMPORTANT Before you disconnect the control-transformer primary wires leads, note the terminal connections. The control transformer has multiple input phase terminals. See Frame 9 AC Input Option Bay Schematic Diagram on page 433 for more information.

8. Loosen the M4 screws that secure the primary wire leads to the Hx terminals on the left side of the transformer and remove the wires.
9. Loosen the M4 screws that secure the secondary wire leads to the X1...X3 terminals on the right side of the transformer and remove the wires.

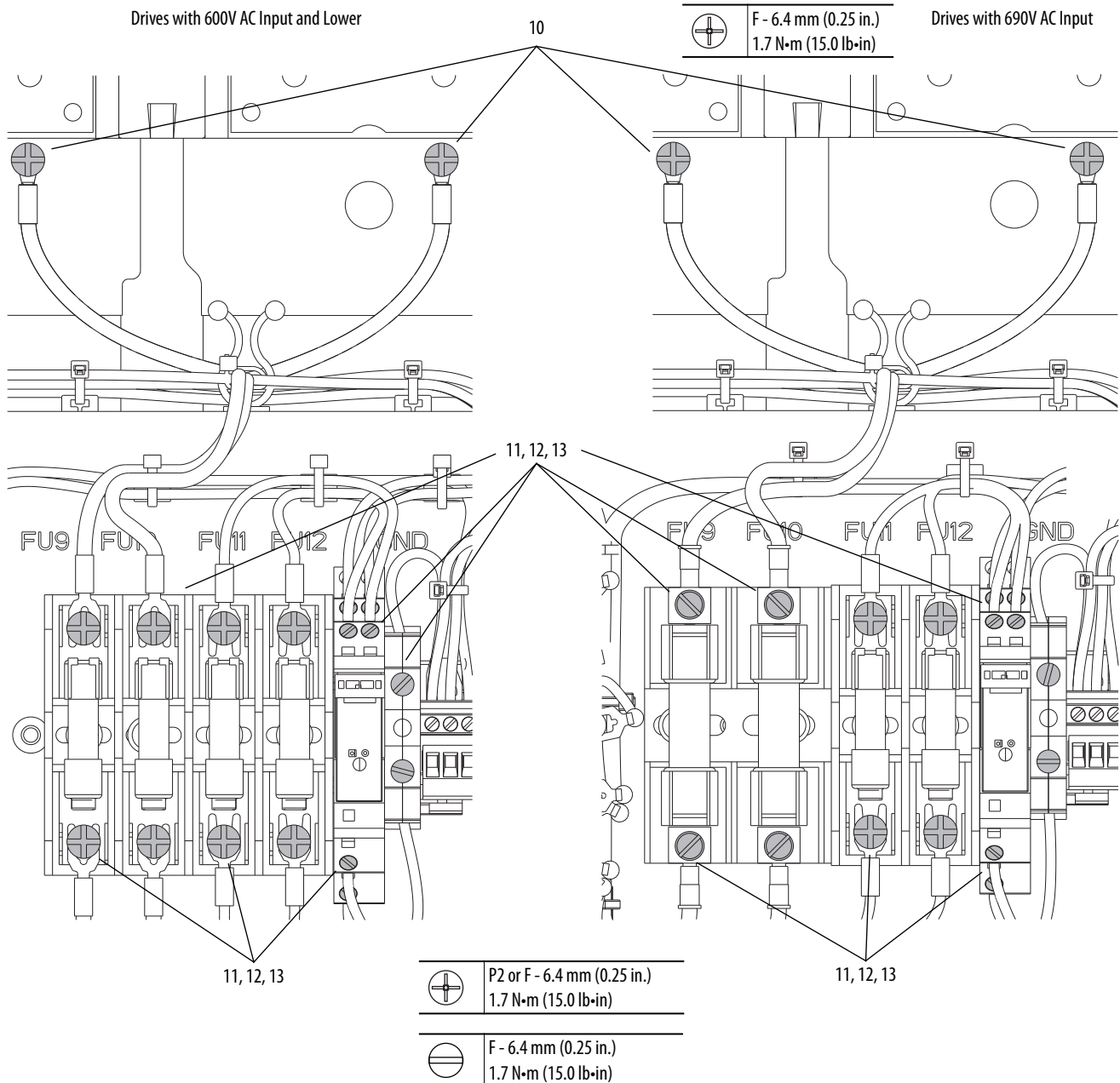


P2
1.8 N·m (16.0 lb·in)

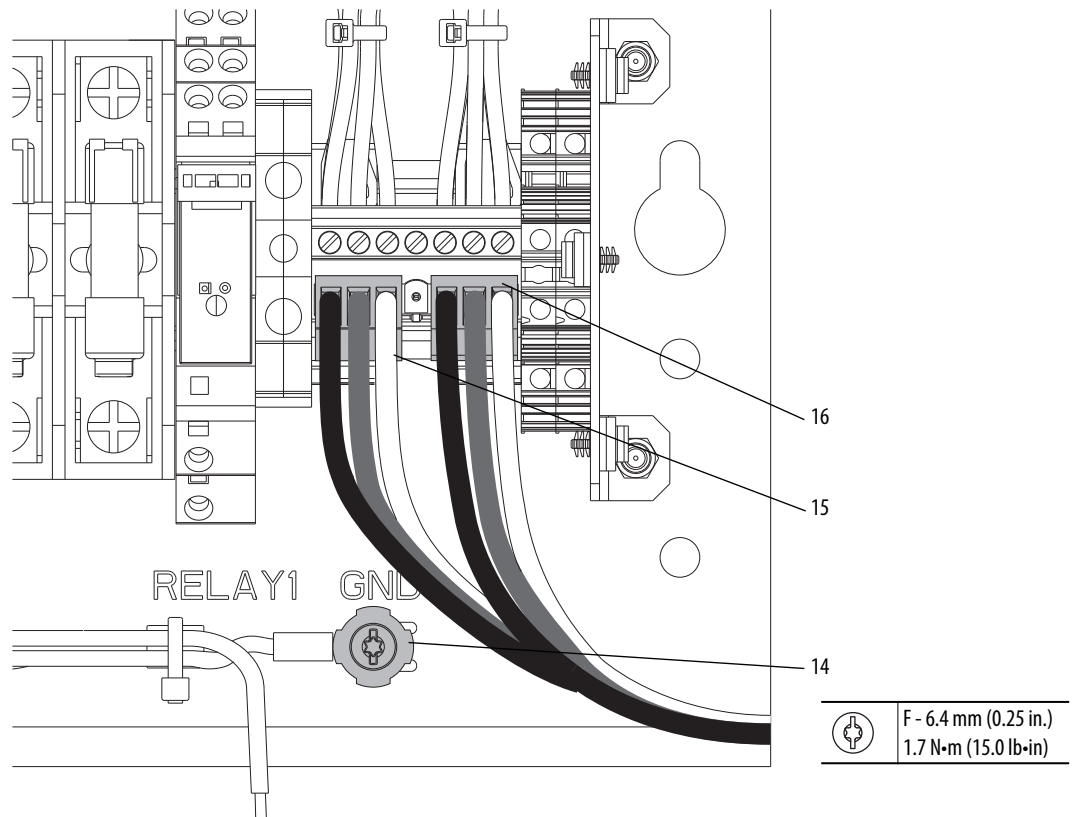
Note: 600V AC input and lower control transformer connections shown.



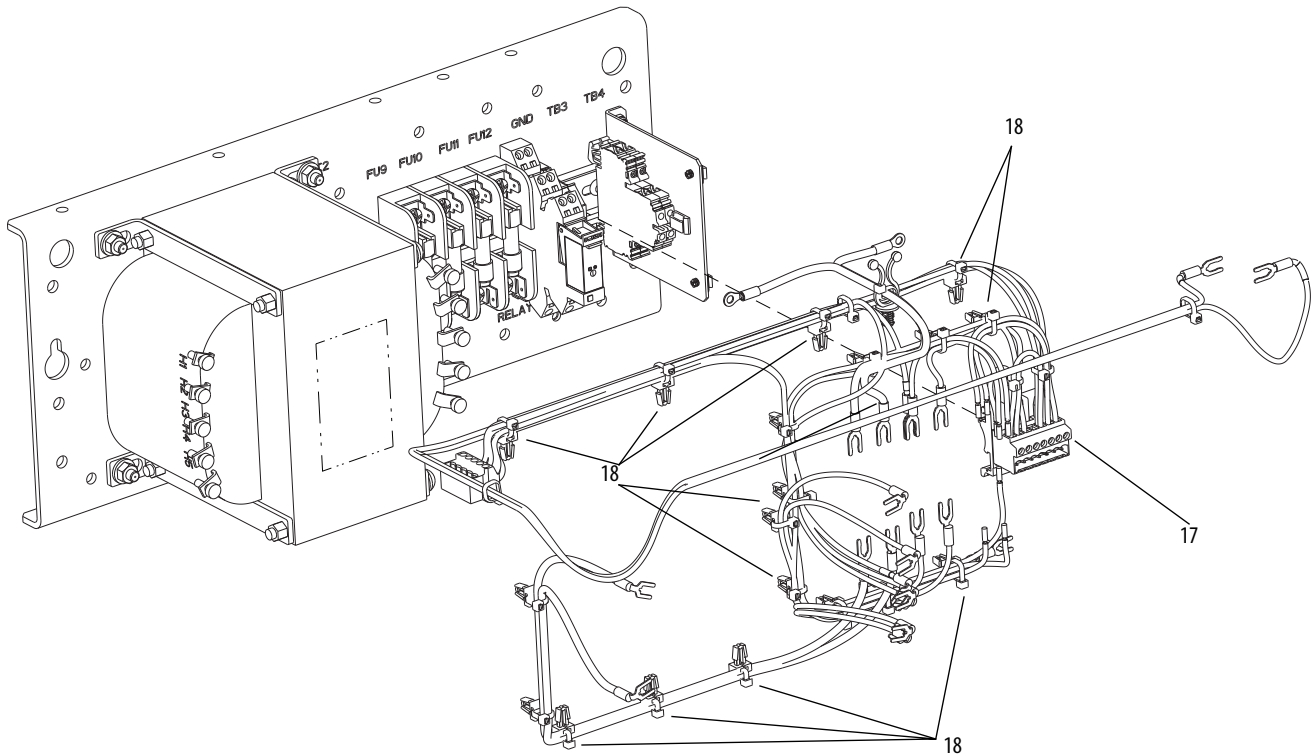
10. Remove the two screws and washers that secure the fuse wire leads to the AC input bus bars and remove the wires. Retain the screws and washers for reuse.
11. Loosen the screws that secure each of the eight wire leads to the fuse holders (FU9, FU10, FU11, FU12) and remove the wires.
12. Loosen the screws that secure the wires to the relay terminal block (RELAY1) and remove the wires.
13. Loosen the screws that secure the wires to the top and bottom of the grounding terminal block (GND) and remove the wires.



14. Remove the screw and washer that secures the ground wire to the control panel (GND) and remove the ground wire. Retain the screw and washer for reuse.
15. If present, disconnect the three-position control output power connector from terminal block TB3.
16. If present, disconnect the three-position reactor fans power connector from terminal block TB3.



17. To remove the push-mount terminal block TB3 from the DIN rail, use a flat nose screwdriver.
18. Remove the removable cable tie mounts that secure the wire harness to the control panel and remove the wire harness.



Install the Frame 9 Main Control-panel Wire Harness

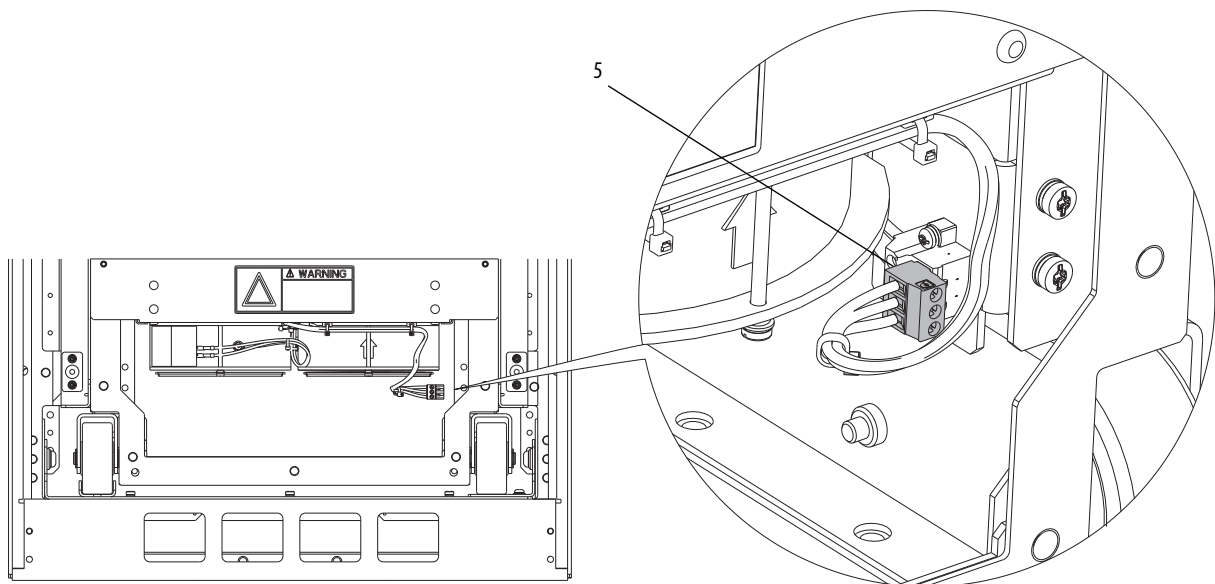
Install the frame 9 main control-panel wire harness in the reverse order of removal. See Remove the Frame 9 Main Control-panel Wire Harness on page [381](#).

IMPORTANT The control transformer has multiple input phase terminals. See Frame 9 AC Input Option Bay Schematic Diagram on page [433](#) for more information.

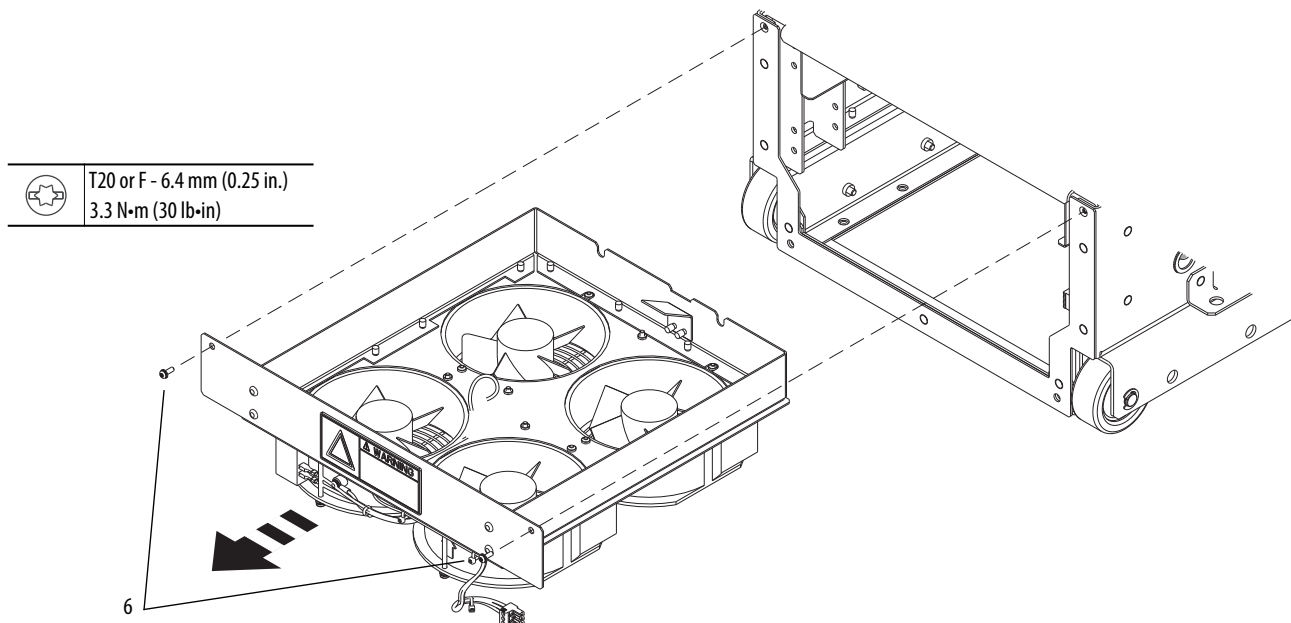
Frame 9 Reactor Fan Tray Removal/Installation

Remove the Frame 9 Reactor Fan Tray

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Remove the guards. See Remove the Frame 9 Series B Option Bay Guards on page [357](#).
5. Disconnect the three-position fan power connector from the terminal block at the bottom, right side of the option bay chassis.



6. Remove the two M4 x 12 mm hexalobular screws that secure the fan tray to the chassis and slide the fan tray out of the chassis.



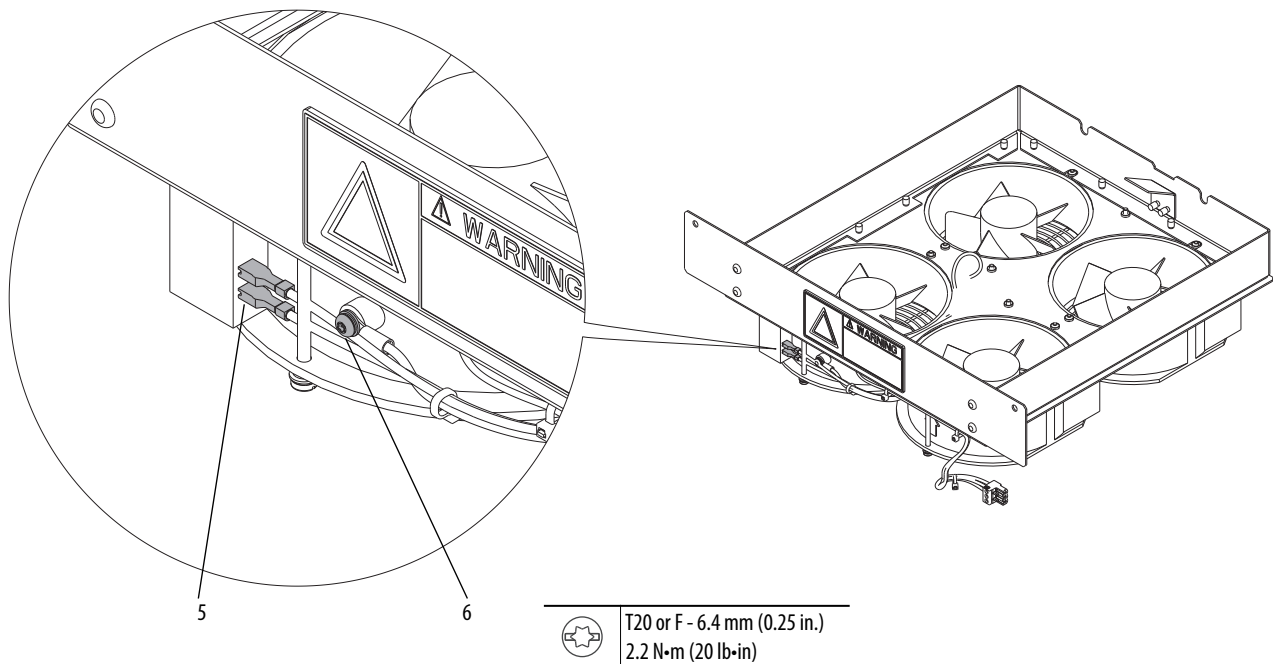
Install the Frame 9 Reactor Fan Tray

Install the frame 9 reactor fan tray in the reverse order of removal. See Remove the Frame 9 Reactor Fan Tray on page [386](#).


Frame 9 Reactor Fan Tray Wire Harness Removal/Installation


Remove the Frame 9 Reactor Fan Tray Wire Harness


1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Remove the Reactor Fan Tray from the drive. See Remove the Frame 9 Reactor Fan Tray on page [386](#).
5. Disconnect the Fan (+) and Fan (-) power wires from the fan terminals.
6. Remove the M4 x 8 mm hexalobular screw that secures the ground wire to the side of the fan and remove the ground wire.

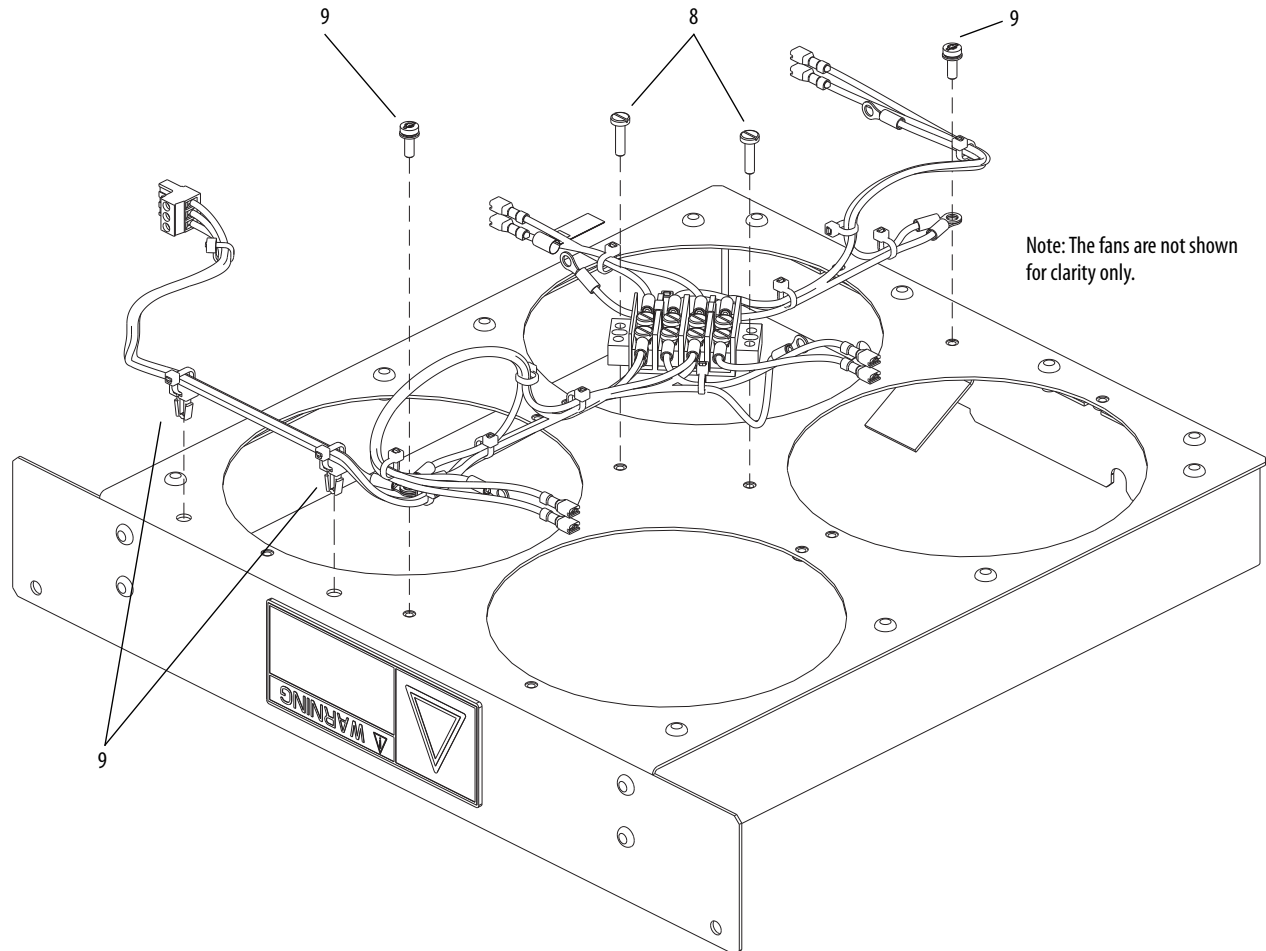


7. On the underside of the tray, remove the two M4 x 12 mm hexalobular screws that secure the fan harness ground wires to the fan tray.
8. On the underside of the tray, remove the two M4 x 16 mm hexalobular screws that secure the fan harness terminal block to the fan tray.
9. On the underside of the tray, disengage the two cable tie push mounts that secure the fan harness to the fan tray and remove the harness.

	T20 or F - 6.4 mm (0.25 in.) 2.2 N·m (20 lb·in)
---	--

	F - 6.4 mm (0.25 in.) 1.8 N·m (16 lb·in)
---	---

	T20 or F - 6.4 mm (0.25 in.) 2.2 N·m (20 lb·in)
---	--



Install the Frame 9 Reactor Fan Tray Wire Harness

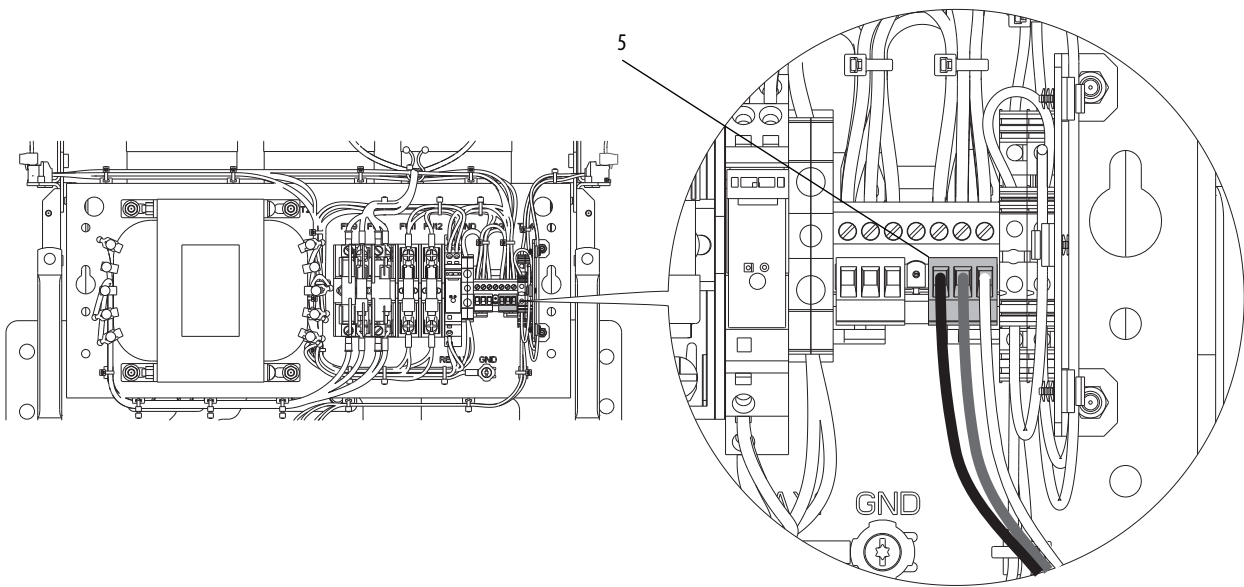
Install the frame 9 reactor fan tray harness in the reverse order of removal. See Remove the Frame 9 Reactor Fan Tray Wire Harness on page [387](#).

TIP The positions of the cable tie push mounts and ground wire connection points determine the proper orientation of the wire harness.

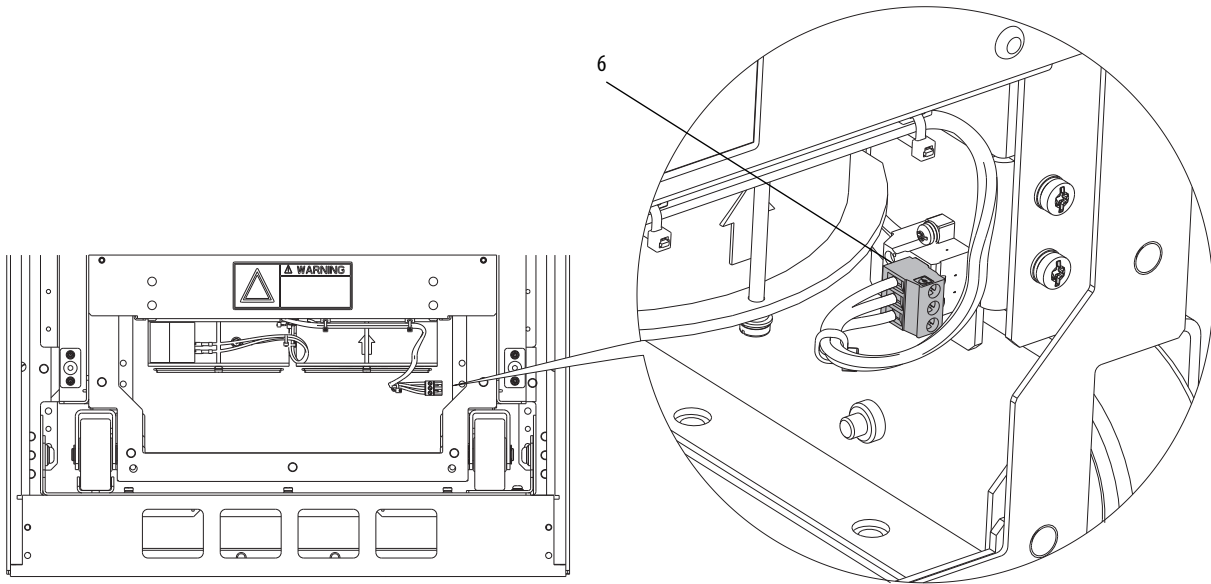
Frame 9 Reactor Fans Wire Harness Removal/ Installation

Remove the Frame 9 Reactor Fans Wire Harness

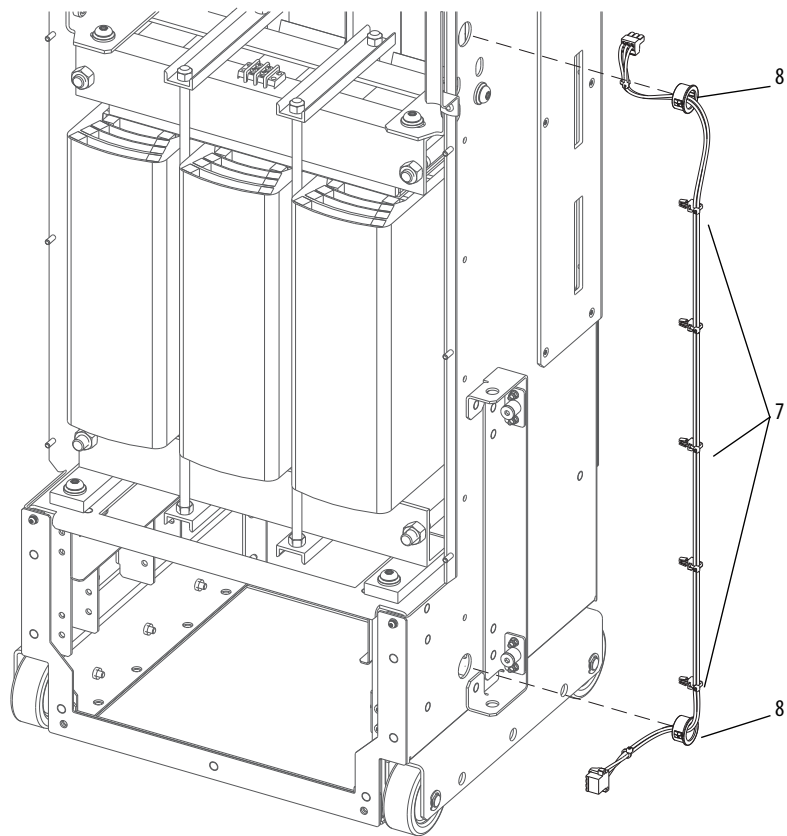
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Remove the power option assembly from the cabinet. See the PowerFlex 750-Series AC Drives Installation Instructions, publication [750-IN001](#) for details.
5. Disconnect the three-position fan power connector from terminal block TB3 on the control panel.



6. Disconnect the three-position fan power connector from the terminal block at the bottom, right side of the option bay chassis.



7. Remove the cable tie mounts from the side of the power option assembly.
8. Remove the grommets from the holes in the power option assembly and remove the wire harness.



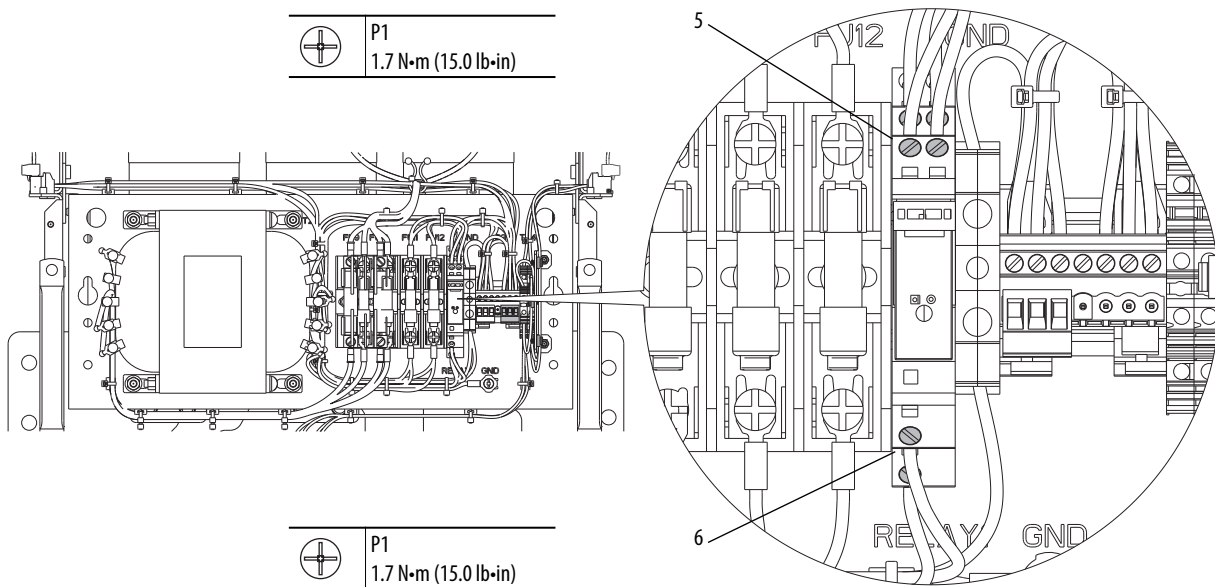
Install the Frame 9 Reactor Fans Wire Harness

Install the frame 9 reactor fans wire harness in the reverse order of removal. See Remove the Frame 9 Reactor Fans Wire Harness on page [389](#).

Frame 9 Cabinet Blower Relay Removal/Installation

Remove the Frame 9 Cabinet Blower Relay

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Remove the guards. See Remove the Frame 9 Series B Option Bay Guards on page [357](#).
5. Loosen the four screws that secure the wire leads to the top of the fan relay terminal block (RELAY1) and remove the wires.
6. Loosen the two screws that secure the wire leads to the bottom of the fan relay and remove the wires.
7. To remove the relay from the DIN rail, use a flat nose screwdriver.



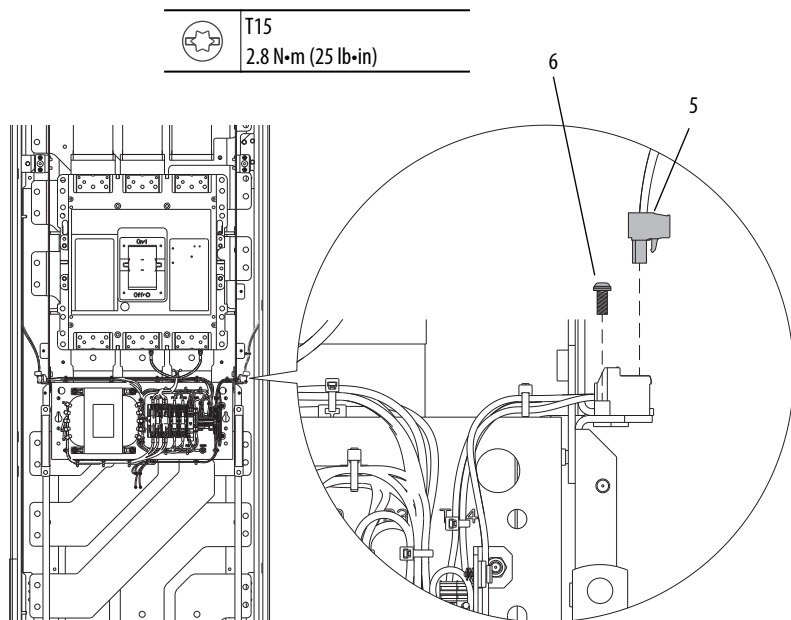
Install the Frame 9 Cabinet Blower Relay

Install the frame 9 cabinet blower relay in the reverse order of removal. See Remove the Frame 9 Cabinet Blower Relay.

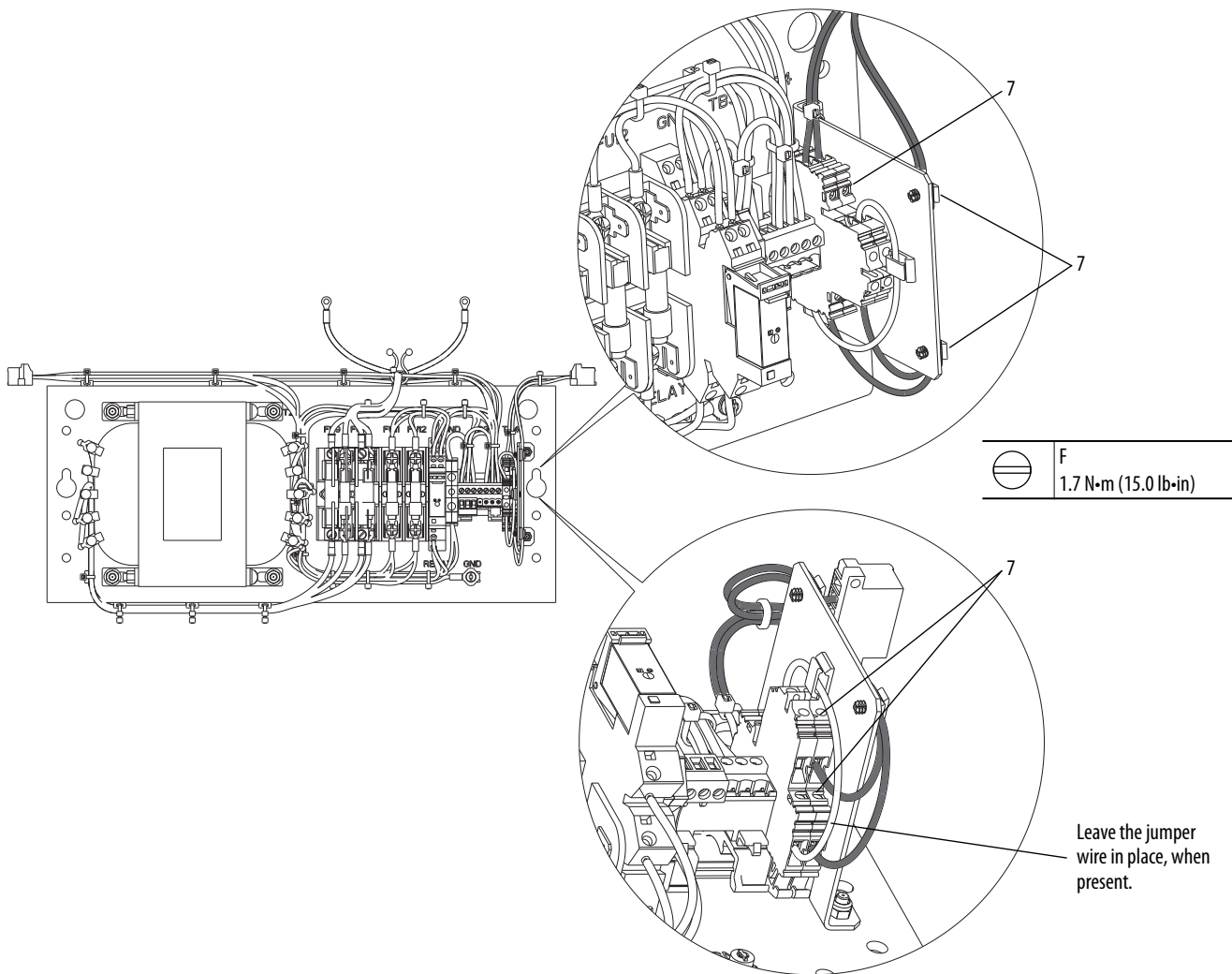
Frame 9 Control Panel Thermostat Harness Removal/Installation

Remove the Frame 9 Control-panel Thermostat Wire Harness

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the option bay door.
4. Remove the guards. See Remove the Frame 9 Series B Option Bay Guards on page [357](#).
5. Disconnect the thermostat connector from terminal block TB6 on the right side of the control panel.
6. Remove the two M3 x 12 mm hexalobular screws that secure the terminal block to the support bracket.



7. Loosen the screws that secure the wire leads to the top and bottom of terminal block TB4, remove the wire harness from the supports, and remove the wire harness.



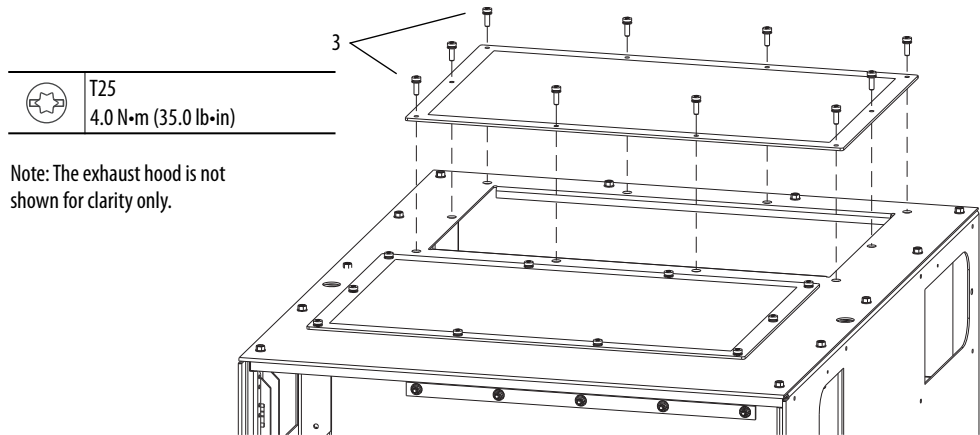
Install the Frame 9 Control-panel Thermostat Wire Harness

Install the frame 9 control-panel thermostat wire harness in the reverse order of removal. See [Remove the Frame 9 Control-panel Thermostat Wire Harness](#) on page [392](#).

Top Conduit Plate Removal/ Installation

Remove the Top Conduit Plate

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Remove the ten M5 x 16 mm screws that secure the conduit plate to the top of the enclosure and remove the plate.



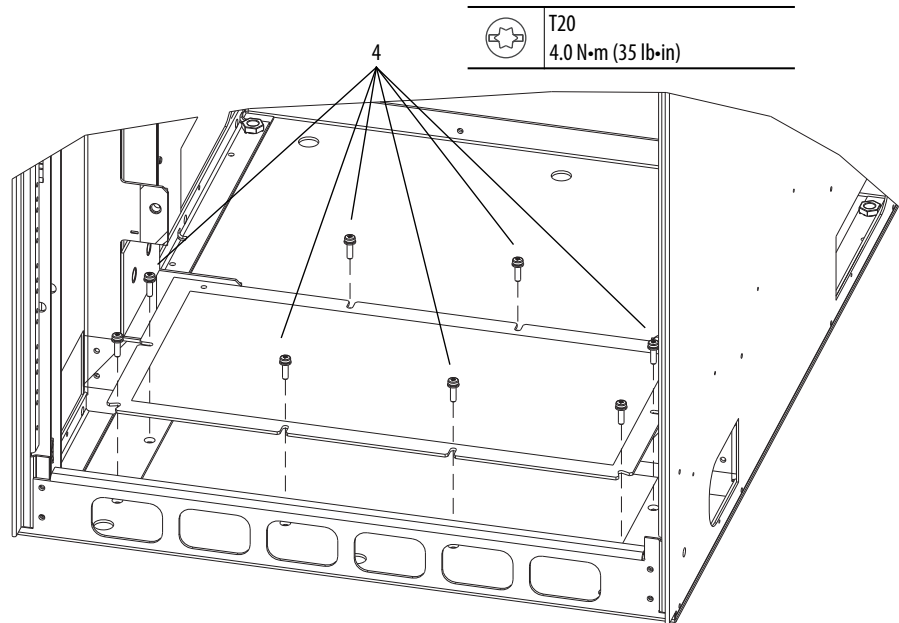
Install the Top Conduit Plate

Install the top conduit plate in the reverse order of removal. See Remove the Top Conduit Plate.

Bottom Conduit Plate Removal/Installation

Remove the Bottom Conduit Plate

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Remove the chassis from the option bay.
4. Remove the eight M5 x 16 screws that secure the plate to the bottom of the enclosure and remove the plate.



Install the Bottom Conduit Plate

Install the bottom conduit plate in the reverse order of removal. See Remove the Bottom Conduit Plate.

Notes:

Enclosure Cable Components Replacement Procedures (Frame 9 and Larger Drives)

Topic	Page
Enclosure Cable Components and Part Numbers	397
24V Wire Harness Removal/Installation (Frame 9 and Larger Drives)	398
First Inverter (INV1) Fiber-optic Cable Removal/Installation	403
Second Inverter (INV2) Fiber-optic Cable Removal/Installation	407
Third Inverter (INV3) Fiber-optic Cable Removal/Installation	412
Fiber-optic Spool Removal/Installation	416

This chapter provides detailed procedures for how to remove and replace enclosure cable components that are used on frame 9 and larger drives.

Enclosure Cable Components and Part Numbers

This table contains the components that comprise the frame 9 and larger drive enclosure cables and provides the following information for each component, if applicable:

- Kit catalog number or part number
- Quantity that is contained in the kit

See PowerFlex Architecture Class Low Voltage Drives Spare Parts Options, publication [PFLEX-SB002](#) for a complete list of spare parts for PowerFlex® 755 Frame 8...10 drives.

IMPORTANT Use only Rockwell Automation provided fiber-optic cables and transceivers. Use of third-party components is not supported.

Table 19 - Enclosure Cable Replacement Kits/Parts

Component Description	Replacement Kit Cat. No. or Part No.	Qty.
2-Bay 24V Wire Harness Kit	20-750-PH2-F9	1
3-Bay 24V Wire Harness Kit	20-750-PH3-F10	1
Fiber-optic Cable, 560 mm (22 in.) Long, Kit	20-750-FCBL1-F8	–
Fiber-optic Cable, 560 mm (22 in.) Long		2
Cable Labels (CONV and INV)		2

Table 19 - Enclosure Cable Replacement Kits/Parts (continued)

Component Description	Replacement Kit Cat. No. or Part No.	Qty.
Fiber-optic Cable, 2.8 m (110 in.) Long, Kit	20-750-FCBL1-F10	–
Fiber-optic Cable, 2.8 m (110 in.) Long		1
Cable Labels (INV1, INV2, and INV3)		3
Fiber-optic Cable Spool Kit	20-750-SPL1-F10	1
Fiber-optic Transceiver	SK-R1-FTR1-F8	1

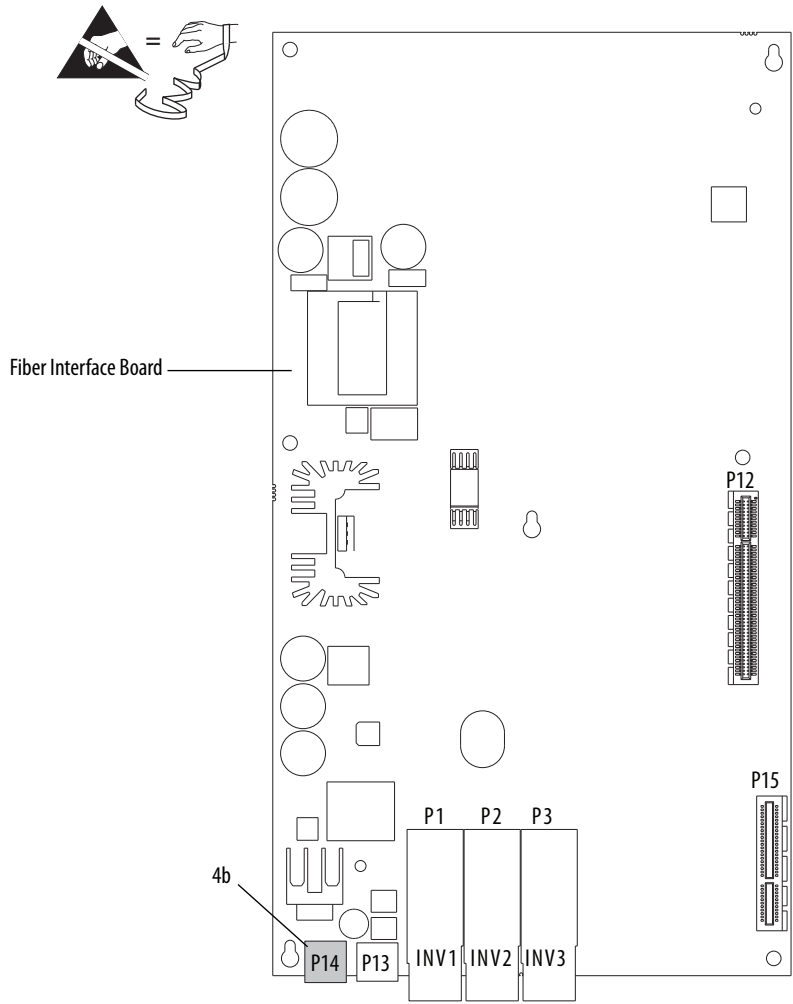
TIP See Fastener/Tool/Torque Information on page [33](#) for descriptions of the fasteners, tools, and torque figures that are used in the disassembly/assembly procedures in this chapter.

24V Wire Harness Removal/ Installation (Frame 9 and Larger Drives)

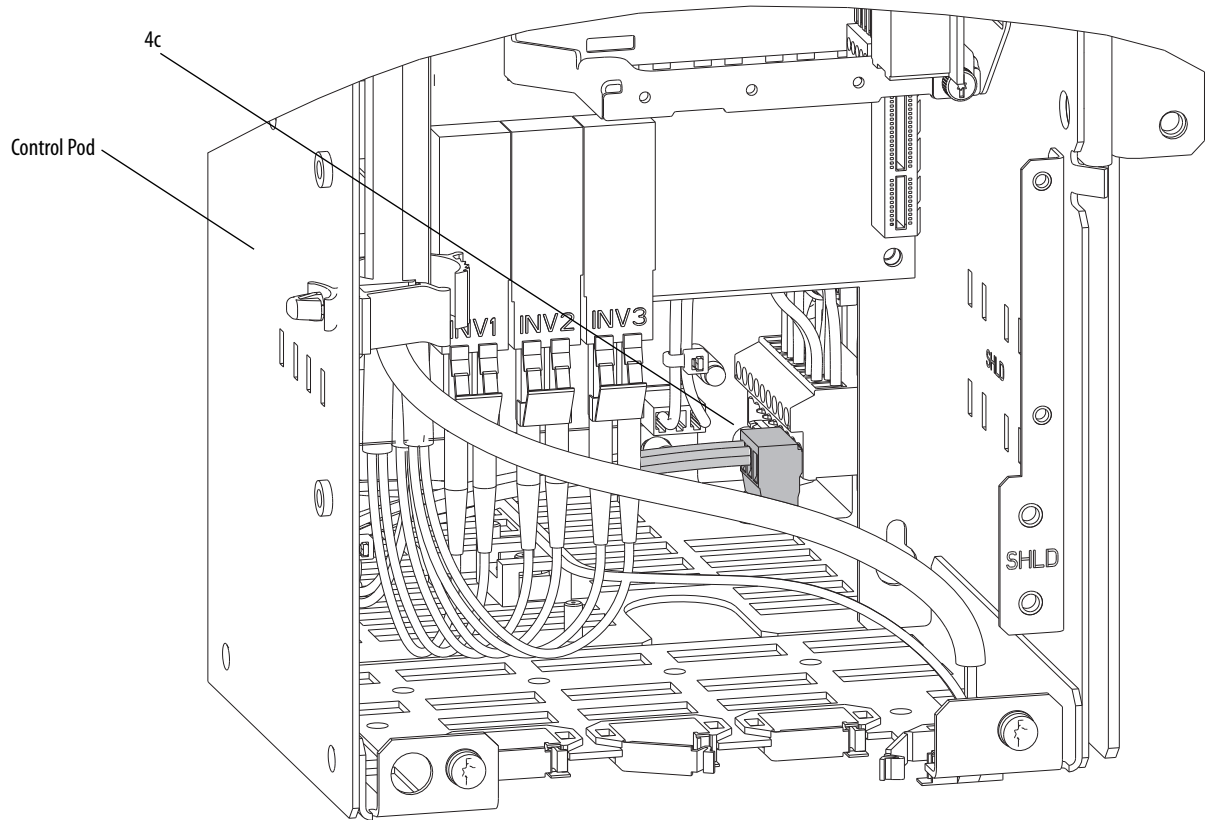
Removing the 24V Wire Harness (Frame 9 and Larger Drives)

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure doors.
4. Complete the following steps in the drive bay that holds the control pod.
 - a. Remove the control pod cover. See Remove the Control Pod Cover on page [59](#).

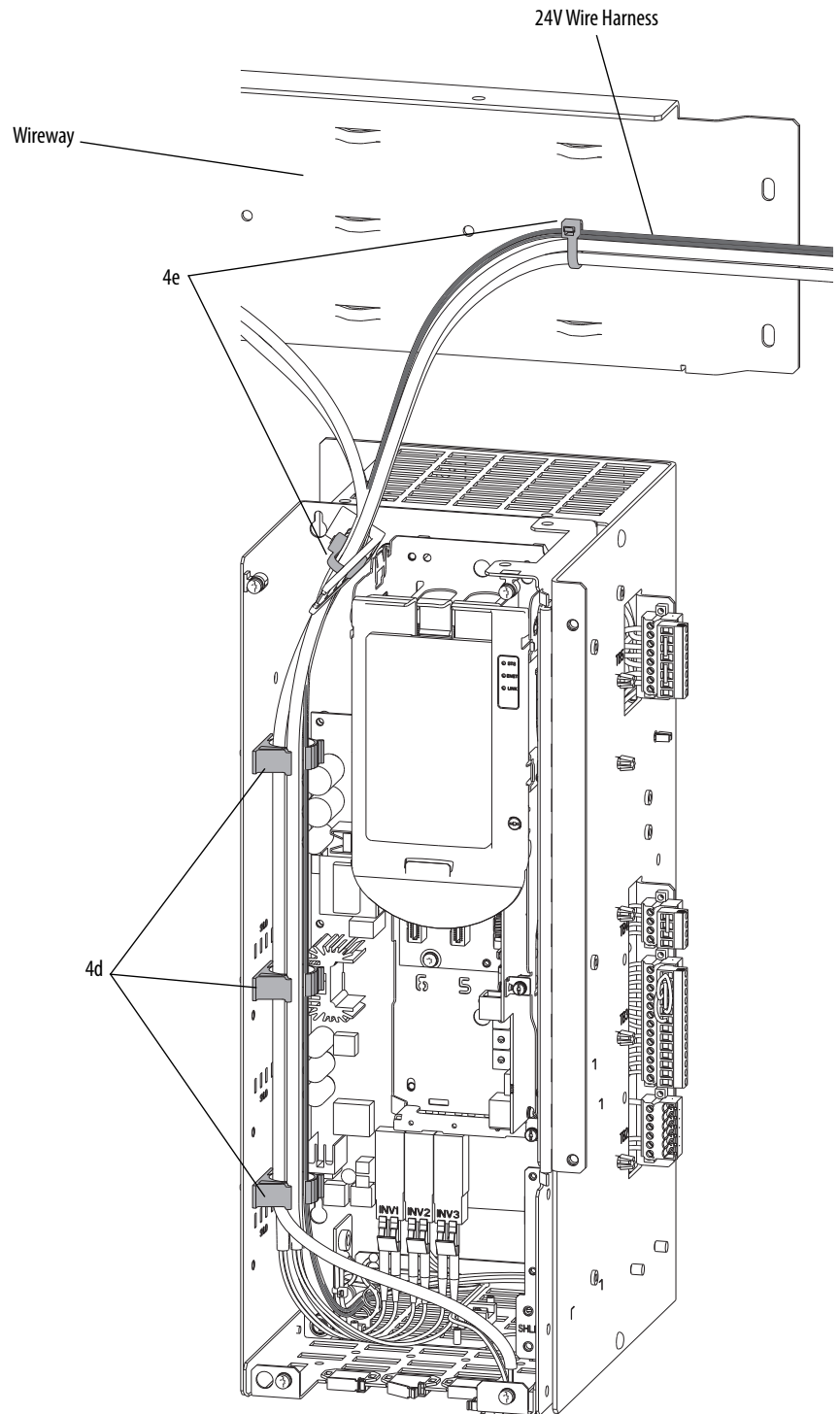
- b. Disconnect the J14 connector from P14 on the fiber interface board in the control pod.



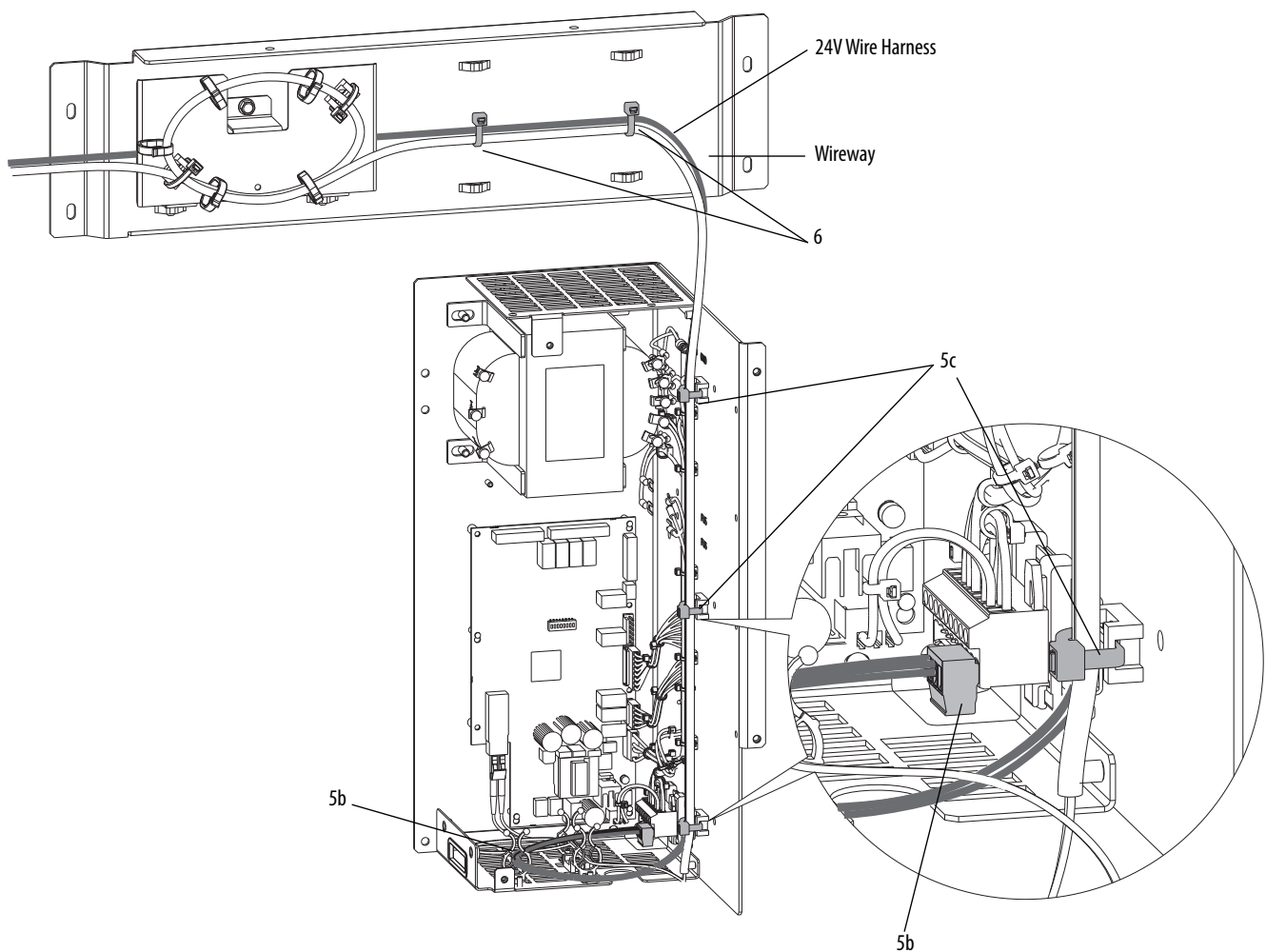
- c. Disconnect the three-position 24V wire harness connector from terminal block TB1 on the control panel (behind the control pod). Remove the cable from the cable support on the bottom of the control panel.



- d. Unlock the three cable supports along the inside left wall of the control pod.
- e. Open the two releasable cable ties; one at the top left of the control pod, and one on the horizontal wireway at the top of the enclosure.



5. Complete the following steps in each additional enclosure.
 - a. Remove the converter or common-bus precharge right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#) or Remove the DC Input with Precharge Assembly Right Cover (No Control Pod) on page [172](#).
 - b. Disconnect the three-position 24V wire harness connector from terminal block TB1 on the control panel and remove the cable from the cable support on the bottom of the control panel.
 - c. Open the three releasable cable ties along the inside right wall of the control panel.
6. On the horizontal wireway, open all releasable cable ties.
7. Remove the 24V wire harness from the enclosures.



Installing the 24V Wire Harness (Frame 9 and Larger Drives)

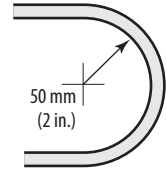
Install the 24V wire harness in the reverse order of removal. See Removing the 24V Wire Harness (Frame 9 and Larger Drives) on page [398](#).

First Inverter (INV1) Fiber-optic Cable Removal/Installation

Removing the First Inverter (INV1) Fiber-optic Cable

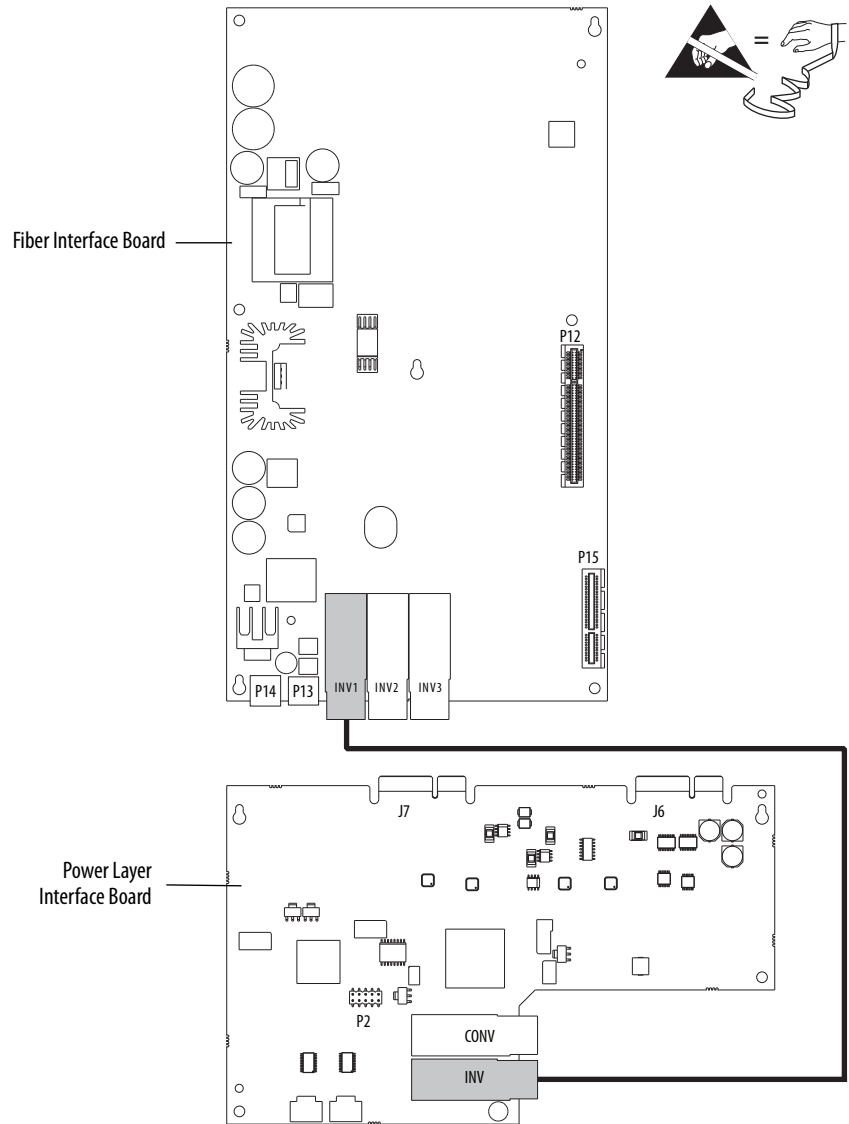
IMPORTANT

Minimum inside bend radius for fiber-optic cable is 50 mm (2 in.). Any bends with a shorter inside radius can permanently damage the fiber-optic cable. Signal attenuation increases with decreased inside bend radii.

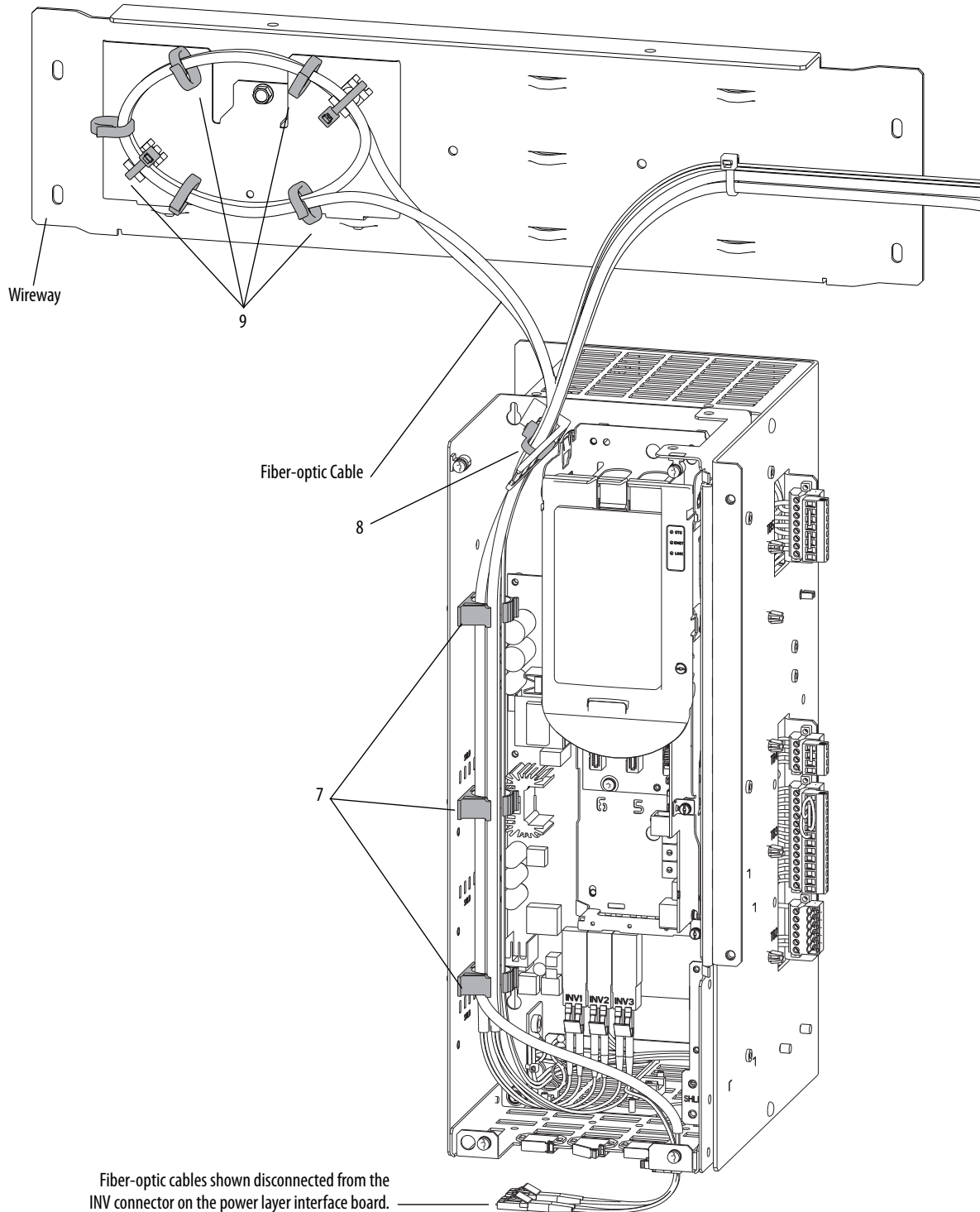


1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Remove the control pod cover. See Remove the Control Pod Cover on page [59](#).

5. Disconnect the fiber-optic cable from INV1 on the fiber interface board in the control pod.
6. Disconnect the fiber-optic cable from INV on the power layer interface board in the inverter card cage (below the control pod).



7. Unlock the three cable supports along the inside left wall of the control pod.
8. Open the releasable cable tie at the top left of the control pod.
9. On the cable spool at the top of the horizontal enclosure wireway, open the two releasable cable ties and unspool the fiber-optic cable from the cable supports and remove the fiber-optic cable.



Installing the First Inverter (INV1) Fiber-optic Cable

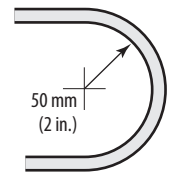
IMPORTANT Frame 9 and larger drives fiber-optic cables that are connected between the fiber interface circuit board and the power-layer interface circuit board on each inverter must be the same length. Cables kits are provided with a length of 2.8 m (110 in.) to meet this requirement.

IMPORTANT Follow these guidelines when installing the new fiber-optic cable on the inverters for frame 9 and 10 drives:

- The cable must be looped through the cable supports on the fiber-optic cable spool as directed in the following table.
- The cable must be routed through all existing cable ties as previously installed.

Drive Enclosure	Number of Fiber-optic Cable Loops on Spool
First Inverter	2
Second Inverter	1
Third Inverter	0

IMPORTANT Minimum inside bend radius for fiber-optic cable is 50 mm (2 in.). Any bends with a shorter inside radius can permanently damage the fiber-optic cable. Signal attenuation increases with decreased inside bend radii.

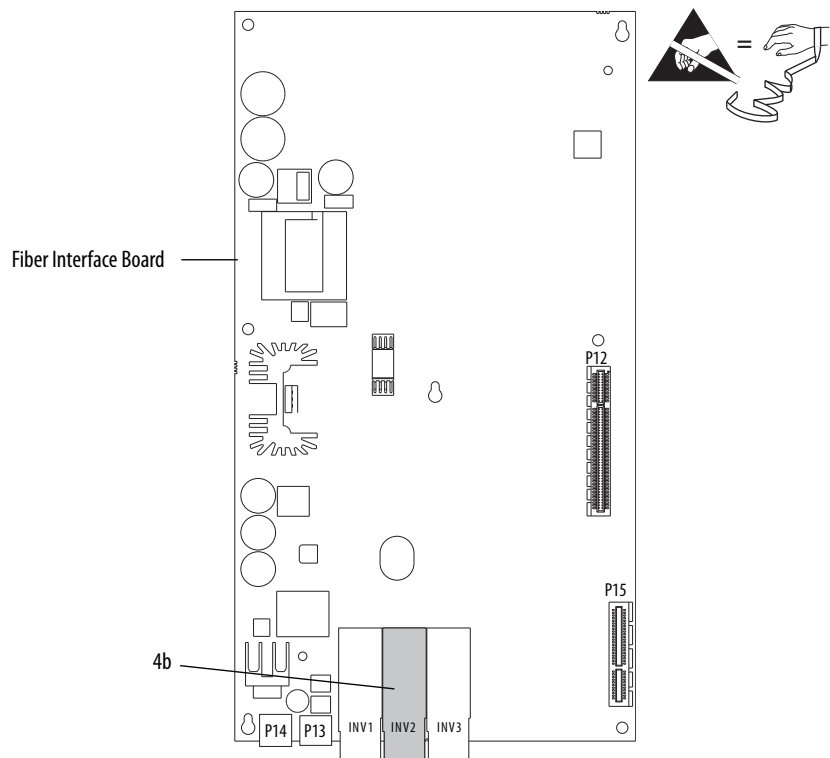


Install the first inverter (INV1) fiber-optic cable in the reverse order of removal. See Removing the First Inverter (INV1) Fiber-optic Cable on page [403](#).

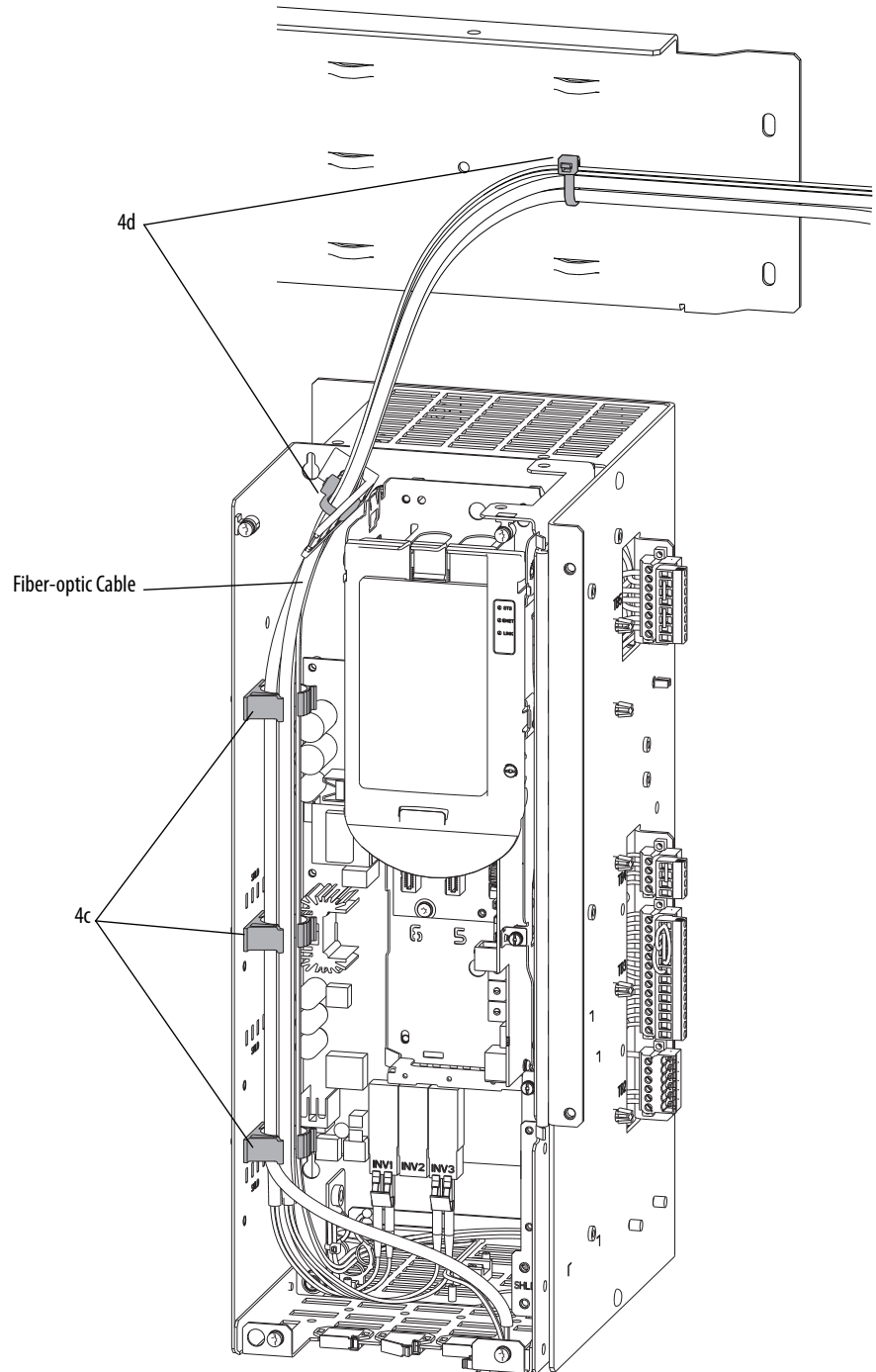
Second Inverter (INV2) Fiber-optic Cable Removal/Installation

Removing the Second Inverter (INV2) Fiber-optic Cable

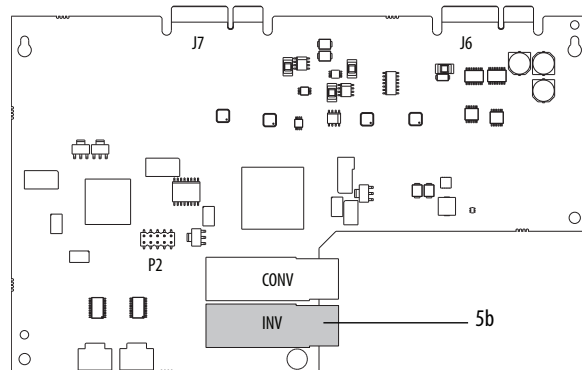
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Complete the following steps in the drive bay that holds the control pod.
 - a. Remove the control pod cover. See Remove the Control Pod Cover on page [59](#).
 - b. Disconnect the fiber-optic cable from INV2 on the fiber interface board in the control pod.



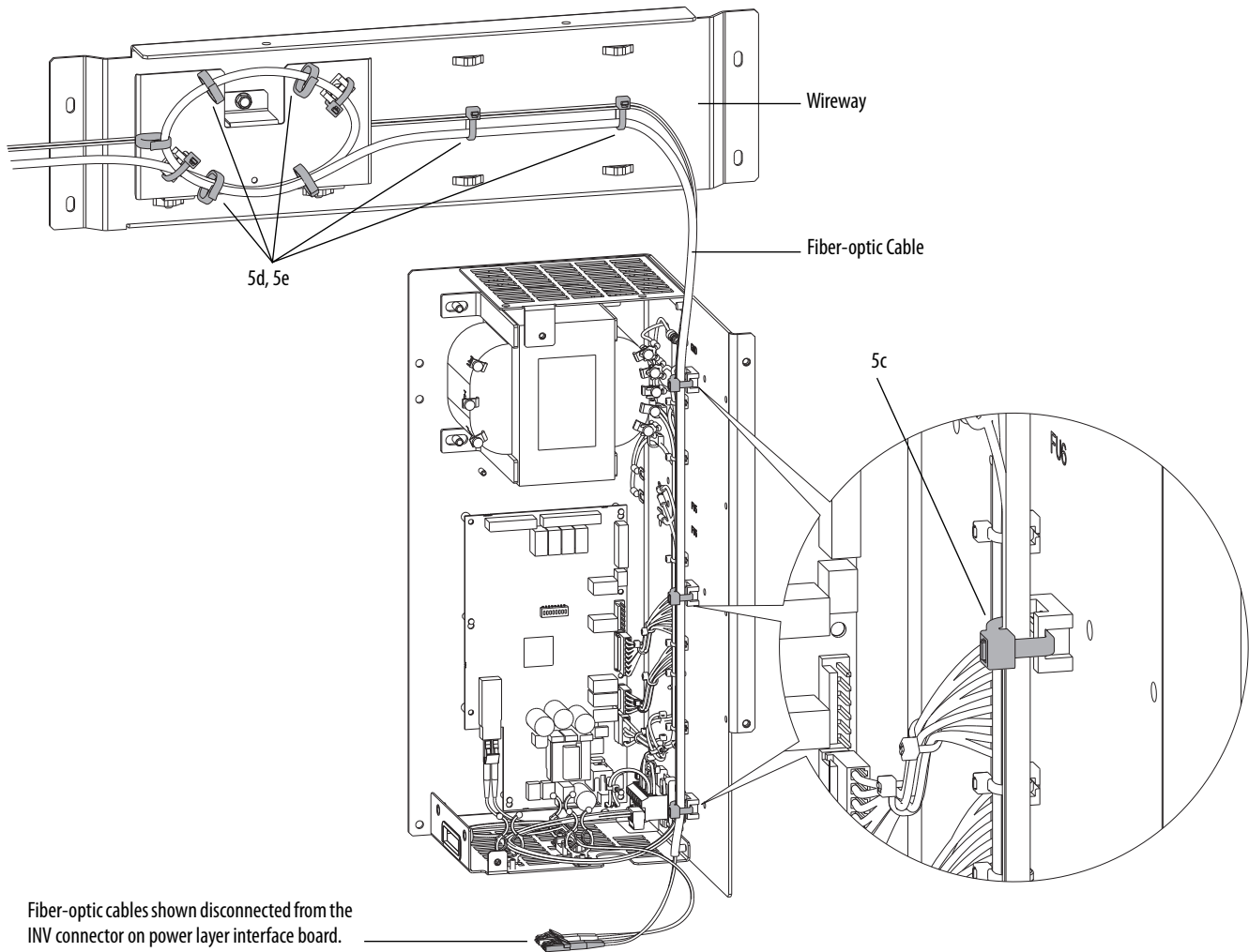
- c. Unlock three cable supports along the inside left wall of the control pod.
- d. Open the two releasable cable ties; one at the top left of the control pod, and one on the horizontal wireway at the top of the enclosure.



5. Complete the following steps in the second bay.
 - a. Remove the converter or common-bus precharge right cover. See [Remove the Converter Right Cover \(No Control Pod\)](#) on page [88](#) or [Remove the DC Input with Precharge Assembly Right Cover \(No Control Pod\)](#) on page [172](#).
 - b. Disconnect the fiber-optic cable from INV on the power layer interface board in the inverter card cage (below the control panel).



- c. Open the three releasable cable ties along the inside right wall of the control panel.
- d. Open the two releasable cable ties on the horizontal enclosure wireway.
- e. On the cable spool at the top of the horizontal enclosure wireway, open the two releasable cable ties and unspool the fiber-optic cable from the cable supports and remove the fiber-optic cable.



Installing the Second Inverter (INV2) Fiber-optic Cable

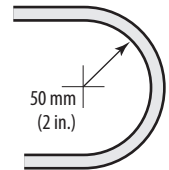
IMPORTANT Frame 9 and larger drives fiber-optic cables that are connected between the fiber interface circuit board and the power-layer interface circuit board on each inverter must be the same length. Cables kits are provided with a length of 2.8 m (110 in.) to meet this requirement.

IMPORTANT Follow these guidelines when installing the new fiber-optic cable on the inverters for frame 9 and 10 drives:

- The cable must be looped through the cable supports on the fiber-optic cable spool as directed in the following table.
- The cable must be routed through all existing cable ties as previously installed.

Drive Enclosure	Number of Fiber-optic Cable Loops on Spool
First Inverter	2
Second Inverter	1
Third Inverter	0

IMPORTANT Minimum inside bend radius for fiber-optic cable is 50 mm (2 in.). Any bends with a shorter inside radius can permanently damage the fiber-optic cable. Signal attenuation increases with decreased inside bend radii.

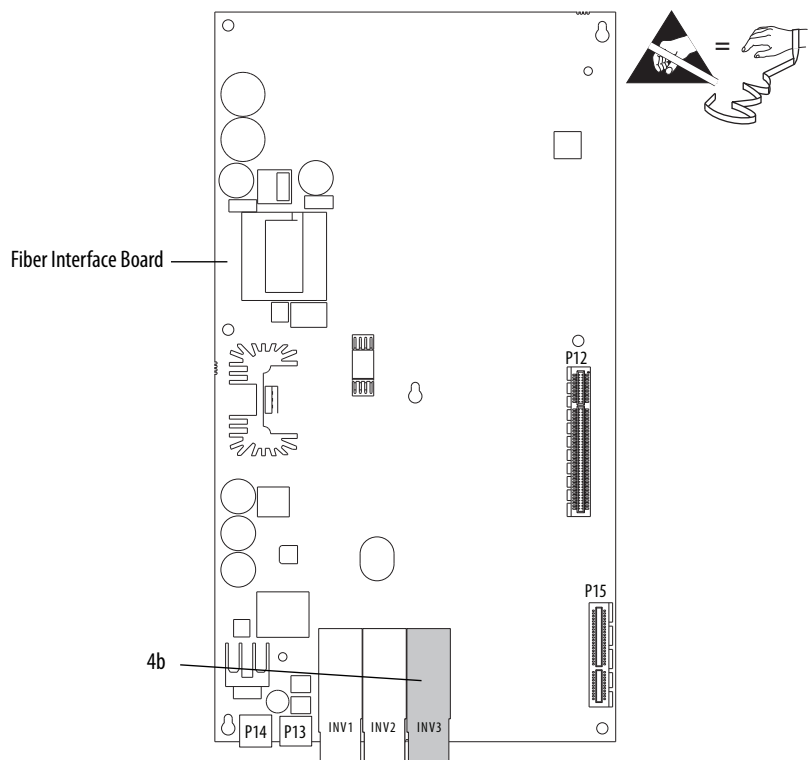


Install the second inverter (INV2) fiber-optic cable in the reverse order of removal. See [Removing the Second Inverter \(INV2\) Fiber-optic Cable](#) on page [407](#).

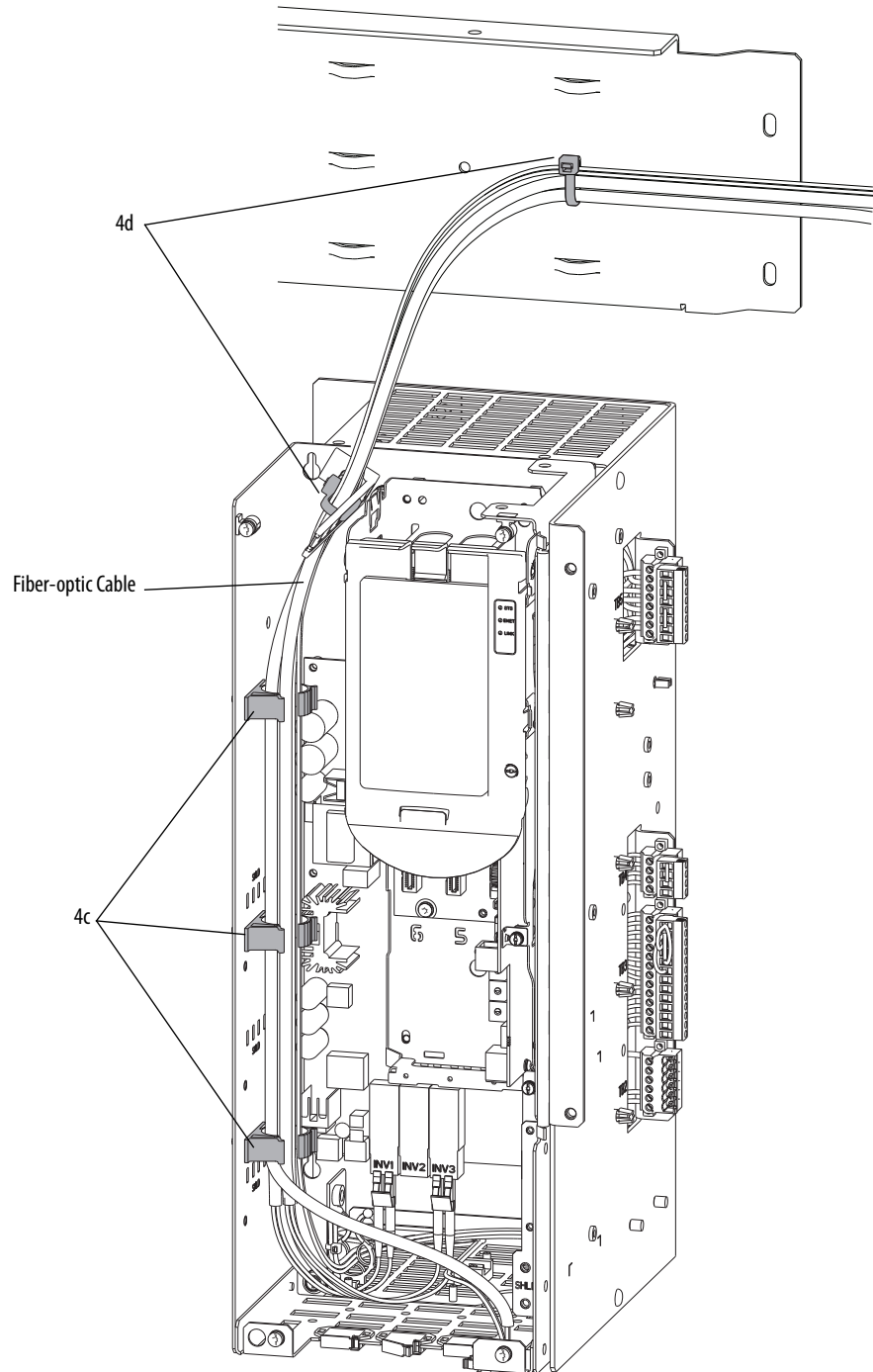
Third Inverter (INV3) Fiber-optic Cable Removal/Installation

Removing the Third Inverter (INV3) Fiber-optic Cable

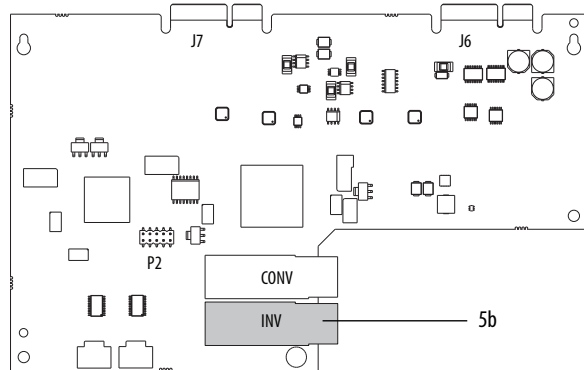
1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.
4. Complete the following steps in the drive bay that holds the control pod.
 - a. Remove the control pod cover. See Remove the Control Pod Cover on page [59](#).
 - b. Disconnect the fiber-optic cable from INV3 on the fiber interface board in the control pod.



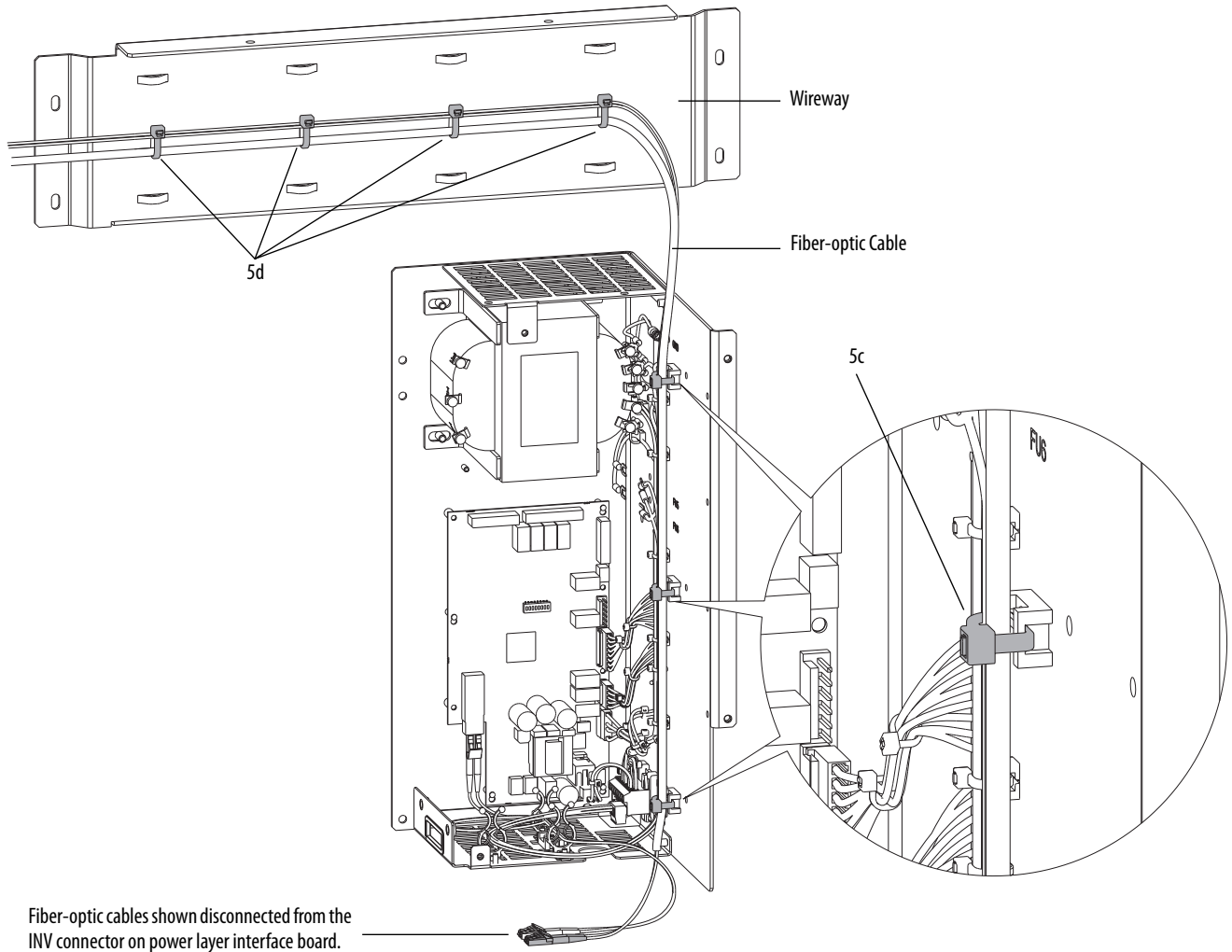
- c. Unlock three cable supports along the inside left wall of the control pod.
- d. Open the two releasable cable ties; one at the top left of the control pod, and one on the horizontal wireway at the top of the enclosure.



5. Complete the following steps in the third bay.
 - a. Remove the converter or common-bus precharge right cover. See Remove the Converter Right Cover (No Control Pod) on page [88](#) or Remove the DC Input with Precharge Assembly Right Cover (No Control Pod) on page [172](#).
 - b. Disconnect the fiber-optic cable from INV on the power layer interface board in the inverter card cage (below the control panel).



- c. Open the three releasable cable ties along the inside right wall of the control panel.
- d. Open the four releasable cable ties on the horizontal enclosure wireway and remove the fiber-optic cable.



Installing the Third Inverter (INV3) Fiber-optic Cable

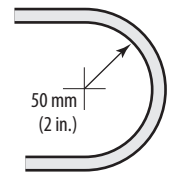
IMPORTANT Frame 9 and larger drives fiber-optic cables that are connected between the fiber interface circuit board and the power-layer interface circuit board on each inverter must be the same length. Cable kits are provided with a length of 2.8 m (110 in.) to meet this requirement.

IMPORTANT Follow these guidelines when installing the new fiber-optic cable on the inverters for frame 9 and 10 drives:

- The cable must be looped through the cable supports on the fiber-optic cable spool as directed in the following table.
- The cable must be routed through all existing cable ties as previously installed.

Drive Enclosure	Number of Fiber-optic Cable Loops on Spool
First Inverter	2
Second Inverter	1
Third Inverter	0

IMPORTANT Minimum inside bend radius for fiber-optic cable is 50 mm (2 in.). Any bends with a shorter inside radius can permanently damage the fiber-optic cable. Signal attenuation increases with decreased inside bend radii.



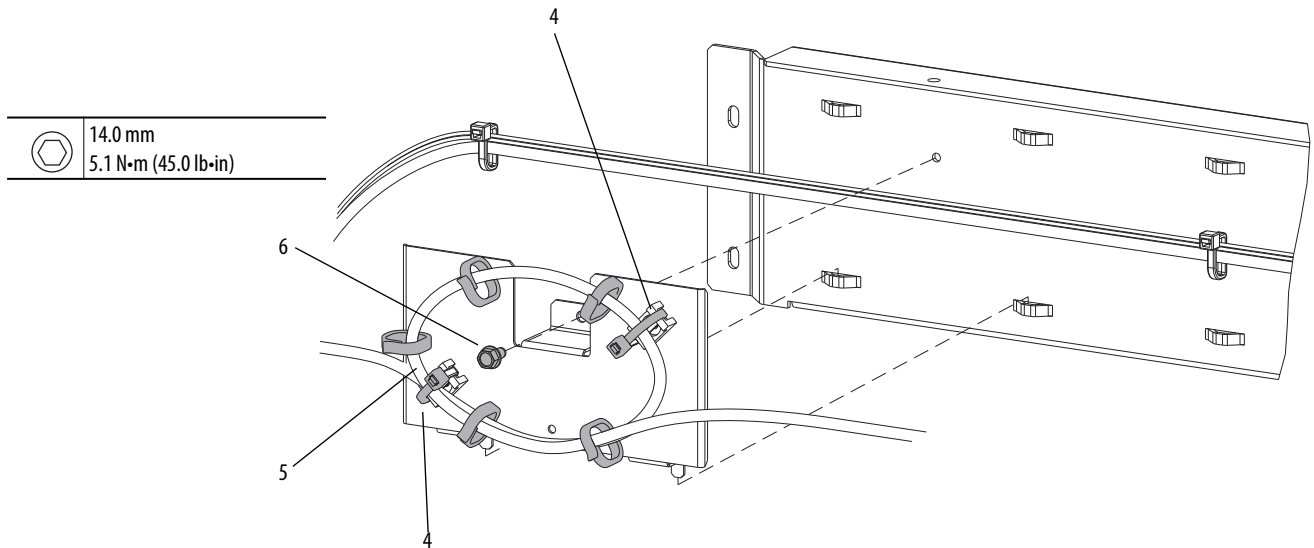
Install the third inverter (INV3) fiber-optic cable in the reverse order of removal. See Removing the Third Inverter (INV3) Fiber-optic Cable on page [412](#).

Fiber-optic Spool Removal/Installation

Removing the Fiber-optic Spool

1. Review the General Precautions on page [24](#).
2. Remove power from the drive. See Remove Power from the Drive on page [25](#).
3. Open the enclosure door.

4. Open the releasable cable ties on the fiber-optic spool.
5. Carefully unspool the fiber-optic cable from the cable supports on the spool.
6. Remove the M6 x 14 mm hex screw that secures the spool to the enclosure wireway.
7. To remove the spool, lift it off the tabs on the wireway.



Installing the Fiber-optic Spool

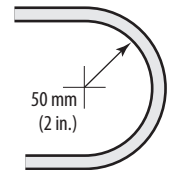
Install the fiber-optic spool in the reverse order of removal. See Removing the Fiber-optic Spool on page [416](#).

IMPORTANT Follow these guidelines when installing the new fiber-optic cable on the inverters for frame 9 and 10 drives:

- The cable must be looped through the cable supports on the fiber-optic cable spool as directed in the following table.
- The cable must be routed through all existing cable ties as previously installed.

Drive Enclosure	Number of Fiber-optic Cable Loops on Spool
First Inverter	2
Second Inverter	1
Third Inverter	0

IMPORTANT Minimum inside bend radius for fiber-optic cable is 50 mm (2 in.). Any bends with a shorter inside radius can permanently damage the fiber-optic cable. Signal attenuation increases with decreased inside bend radii.



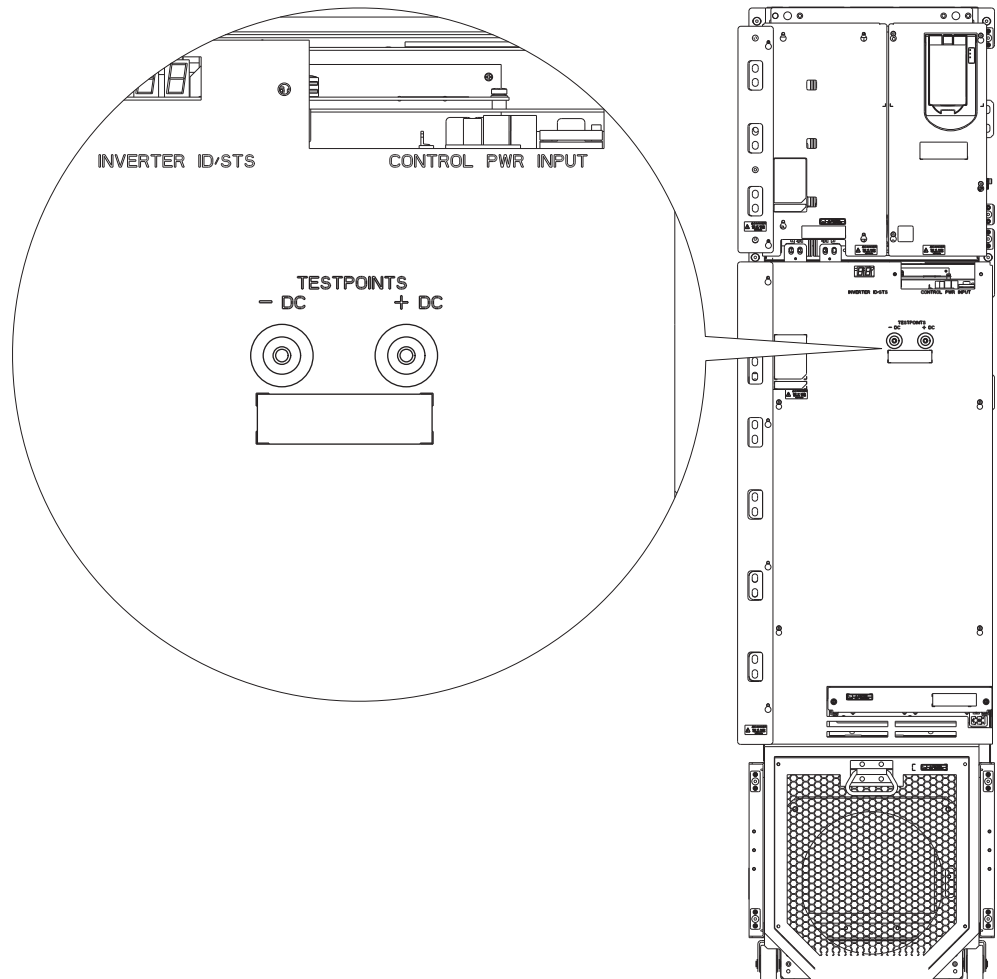
Drive Startup after Repairs

Topic	Page
Before You Apply Power to the Drive	419
Testing with the Motor without a Mechanical Load	421

This chapter provides detailed instructions for starting a drive after you have completed repairs.

Before You Apply Power to the Drive

1. Check the DC bus voltage at the -DC and +DC testpoints sockets on the front of the power module.



2. Perform forward and reverse biased diode tests, by using a digital multimeter. See Forward and Reverse Biased SCR/Diode Tests on page [49](#).
3. Inspect the drive for loose bolts, disconnected cables, and so forth.
4. Verify the following connections.
 - All fiber-optic cables are connected at both ends and properly supported by cable ties along their entire length when connected between enclosures.
 - If any work was performed on the converter, inspect all converter wire harnesses to be sure that they are all connected at both ends.
 - If any work was performed on the converter, inspect the control transformer primary connections to verify that the taps are appropriate for the applied voltage:

Primary Terminal Connections	Input Voltage
H1 & H2	380/415
H1 & H3	440/480
H1 & H4	575/600
H1 & H5	690

- If any work was performed on the DC input with precharge assembly, inspect all DC input wire harnesses to be sure that they are all connected at both ends.
- If any work was performed on the DC input with precharge assembly, inspect the control transformer primary connections to verify that the taps are appropriate for the applied voltage:

Primary Terminal Connections	Input Voltage
H1 & H2	120
H1 & H3	240

- If any work was performed on a frame 9 or larger drive, inspect the 24V wire harnesses to be sure that they are properly connected at the ends and properly supported by cables ties along their entire length.
- If any work was performed to or around the inverter card cage, verify that the current feedback cable is connected to the inverter power board, and to all three current sensors. Also verify that the P6 cable is connected to the inverter power board, and that the J1 cable is connected to the main power supply board.
- The two heatsink fan cables are connected to the fan terminal block.

Testing with the Motor without a Mechanical Load

This test lets you measure the DC bus voltage and output current and diagnose problems without connecting the motor to its mechanical load.

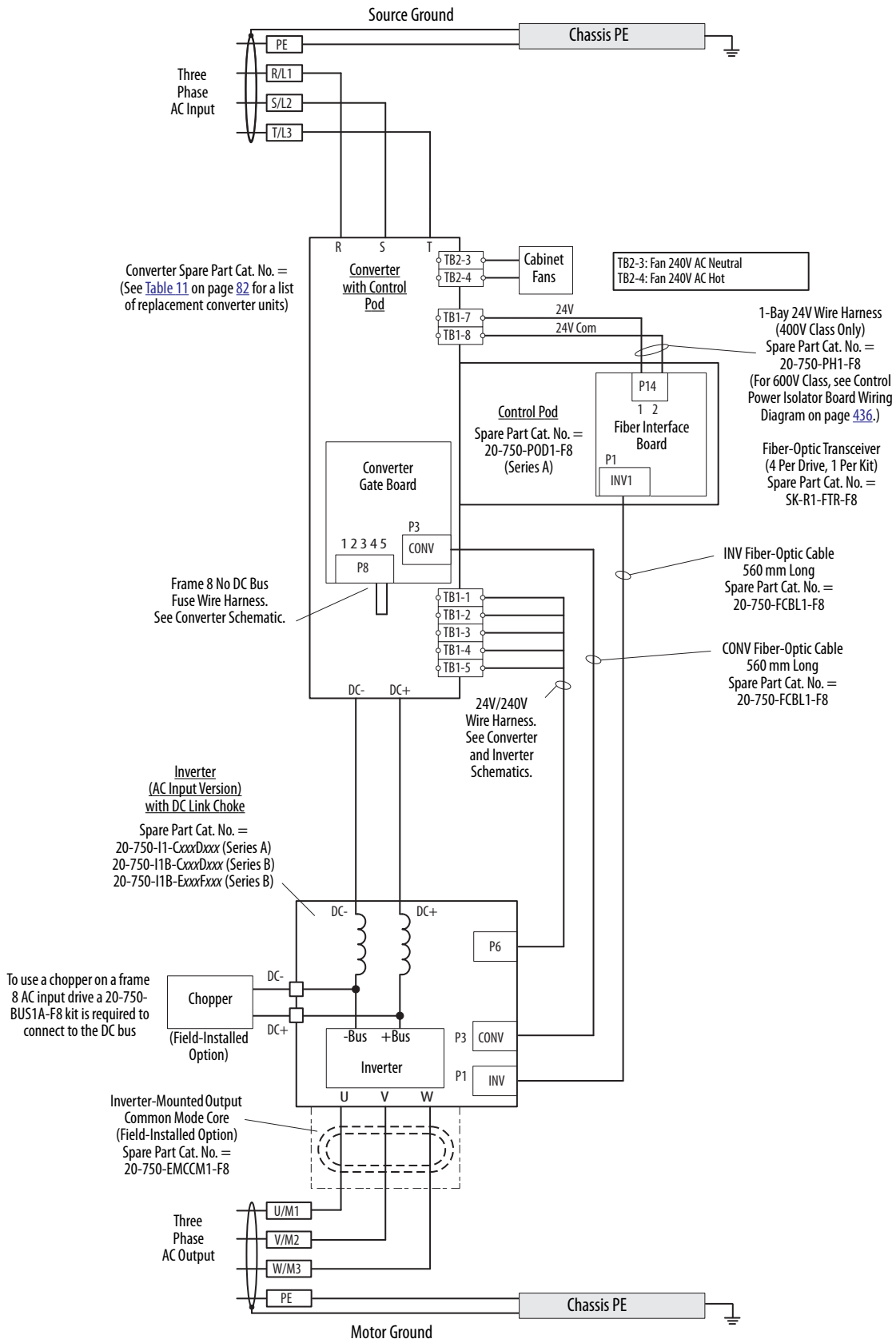
1. Verify that the input power and ground wires are connected.
2. Verify that the motor cables are connected.
3. Verify that the motor load is disconnected.
4. Energize the drive.
5. Measure the DC bus voltage and verify that the value is reflected in parameter 11 [DC Bus Volts].
6. Start the drive and increase the speed from zero to base speed.
7. Measure drive output current and verify that the value is reflected in the parameter 7 [Output Current].
8. Stop the drive.

Notes:

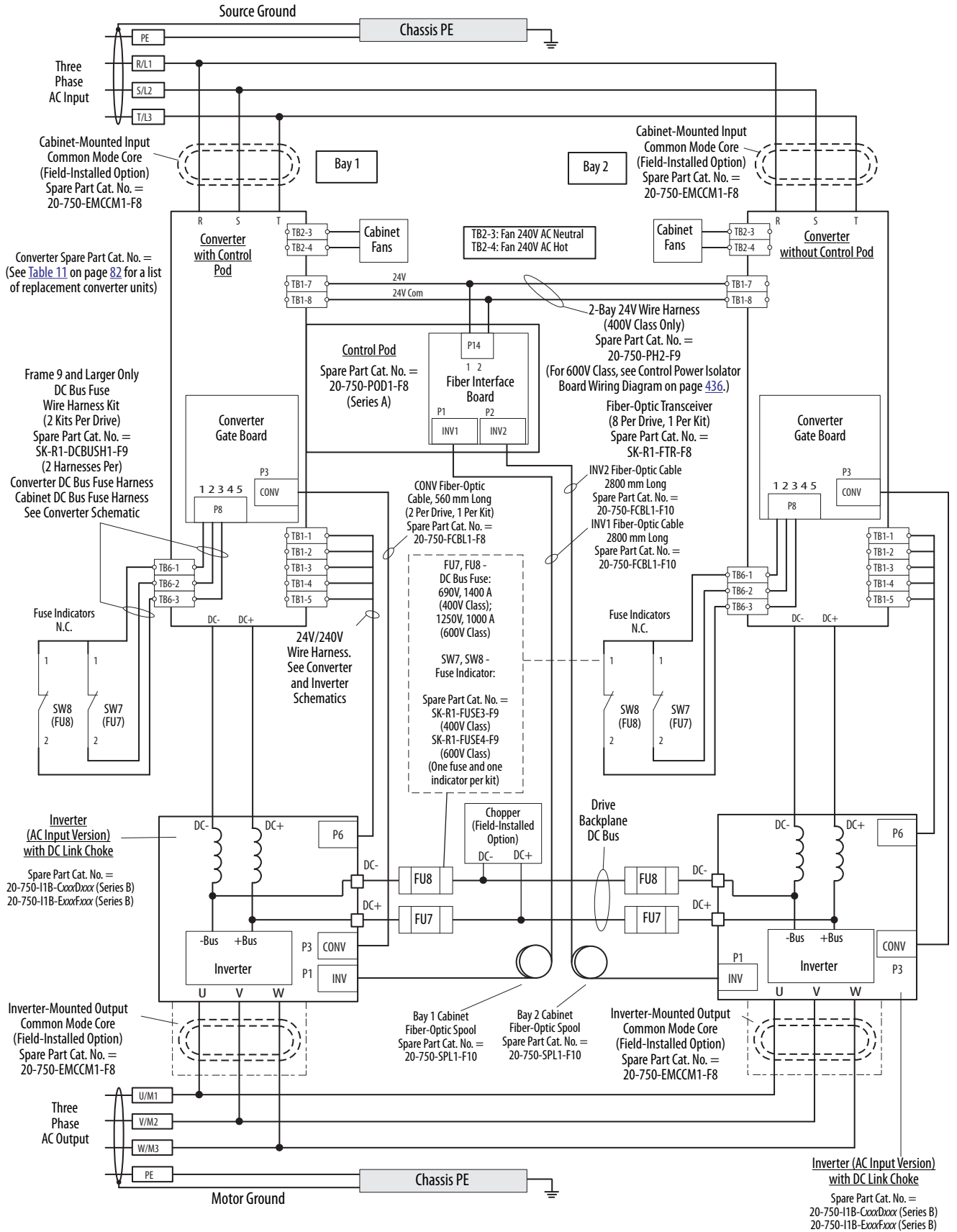
Schematics

Topic	Page
Frame 8 AC Input Drive Schematic Diagram (400VAC and 600VAC Classes)	424
Frame 9 AC Input Drive Schematic Diagram (400VAC and 600VAC Classes)	425
Frame 10 AC Input Drive Schematic Diagram (400VAC and 600VAC Classes)	426
Frame 8 Common DC Input Drive Schematic Diagram (540V DC, 650V DC, 810V DC, and 932V DC Classes)	427
Frame 9 Common DC Input Drive Schematic Diagram (540V DC, 650V DC, 810V DC, and 932V DC Classes)	428
Frame 10 Common DC Input Drive Schematic Diagram (540V DC, 650V DC, 810V DC, and 932V DC Classes)	429
Frame 8 AC Input IP20 Option Bay without a Control Transformer Schematic Diagram	430
Frame 8 AC Input IP20 Option Bay with a Control Transformer Schematic Diagram	431
Frame 8 AC Input IP54 Option Bay Schematic Diagram	432
Frame 9 AC Input Option Bay Schematic Diagram	433
Control Pod Schematic Diagram	434
Converter Schematic Diagram (400VAC and 600VAC Classes AC Input Drive)	435
Frame 8 Control Power Isolator Board Wiring Diagrams (600V AC Class AC Input Drive, and 810V DC and 932V DC Classes Common DC Input Drive)	436
Frame 9 Control Power Isolator Board Wiring Diagrams (600V AC Class AC Input Drive, and 810V DC and 932V DC Classes Common DC Input Drive)	436
Frame 10 Control Power Isolator Board Wiring Diagrams (600V AC Class AC Input Drive, and 810V DC and 932V DC Classes Common DC Input Drive)	437
DC Input with Precharge Assembly Schematic Diagram (540V DC, 650V DC, 810V DC, and 932V DC Classes Common DC Input Drives)	438
DC Input with Precharge Devices Schematic Diagrams	439
Inverter Circuit Board Schematic Diagram (All Drive Configurations)	440
Inverter Power Layer Schematic Diagram (All Drive Configurations)	441
AC Input Drive Control Transformer Schematic Diagram	442
DC Input with Precharge Assembly Control Transformer Schematic Diagram	442
Inverter Main Blower and Capacitor Bank Cooling Fan Wire Harness Diagram	443
Cabinet Cooling Wiring Diagrams	443

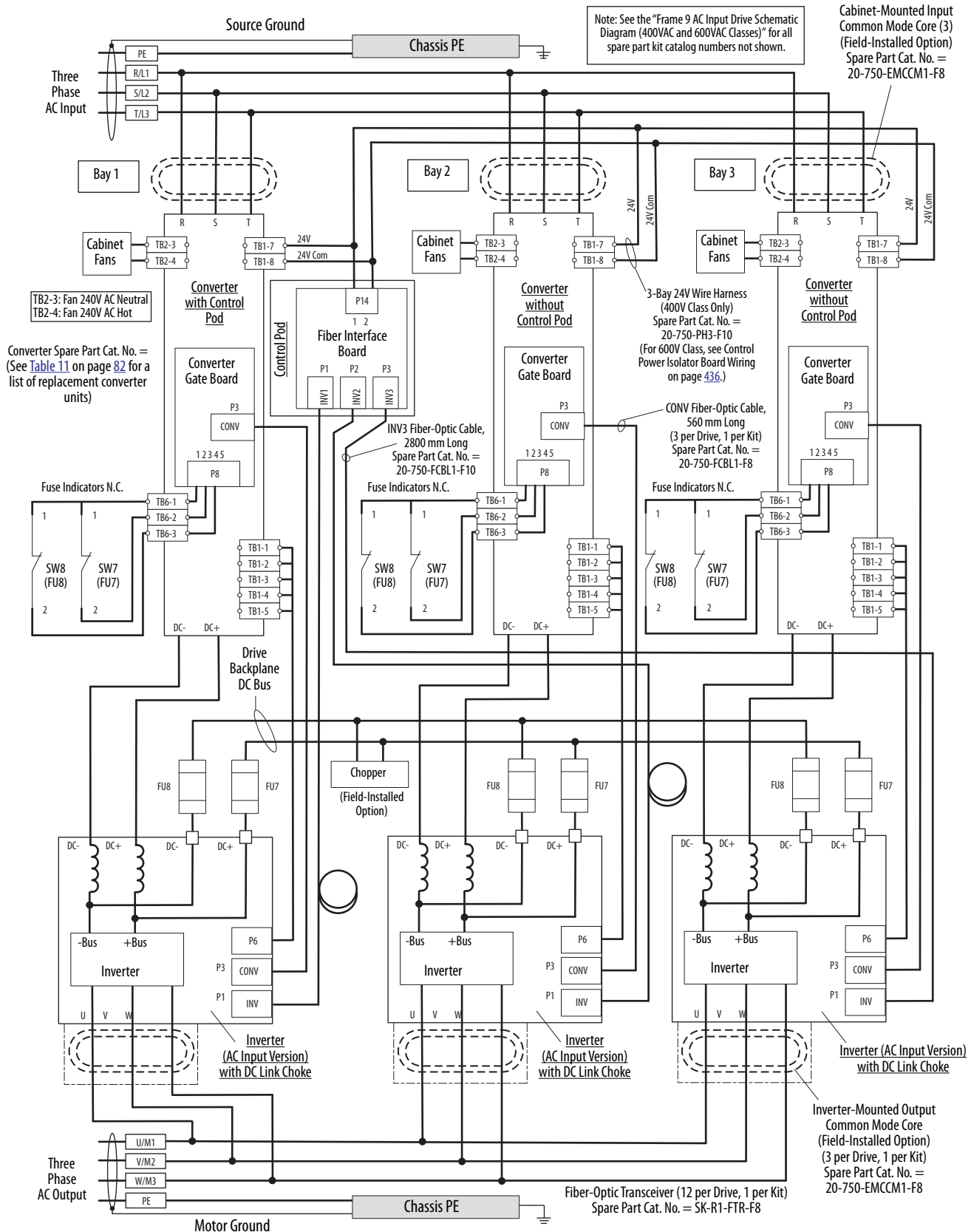
Frame 8 AC Input Drive Schematic Diagram (400VAC and 600VAC Classes)



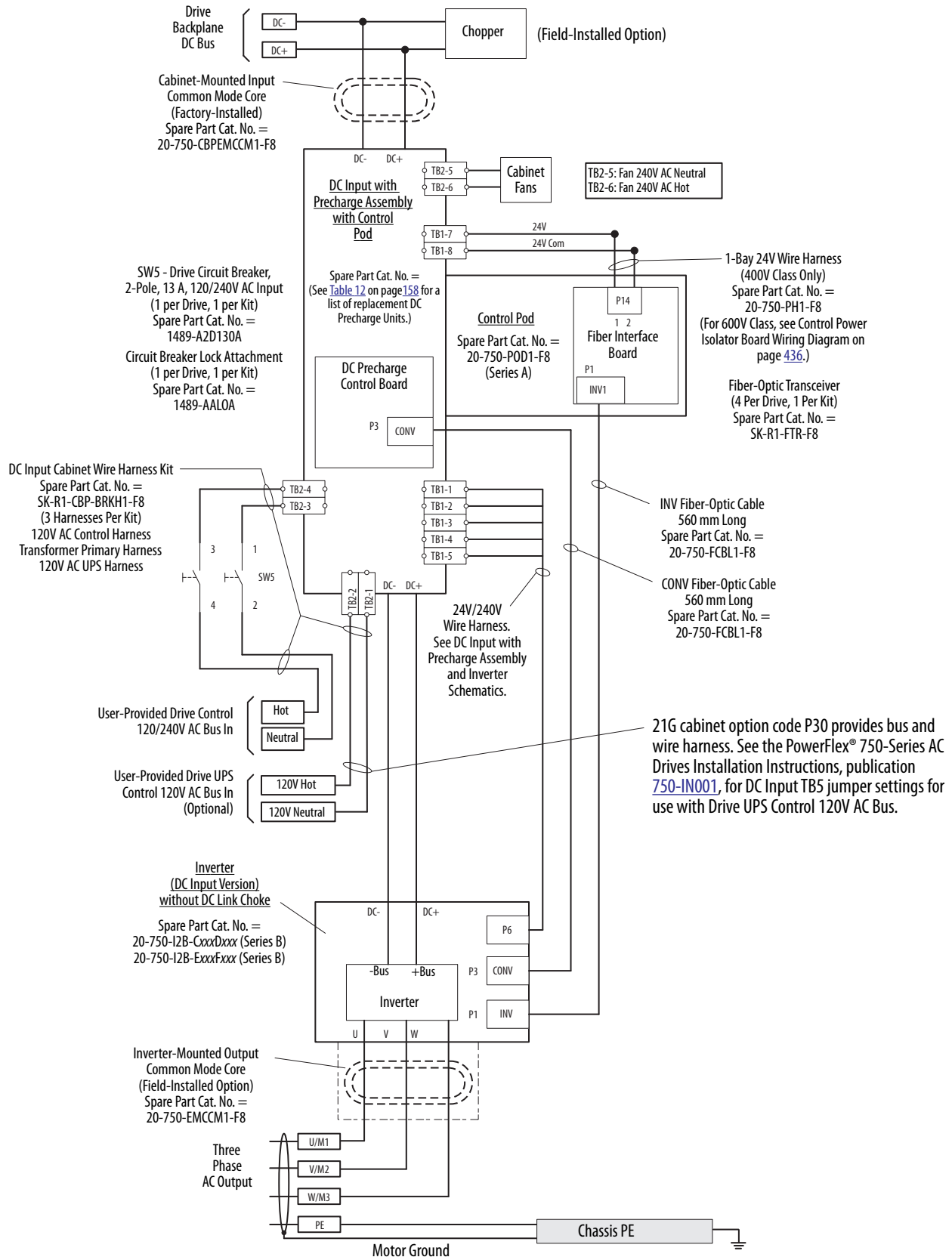
Frame 9 AC Input Drive Schematic Diagram (400VAC and 600VAC Classes)



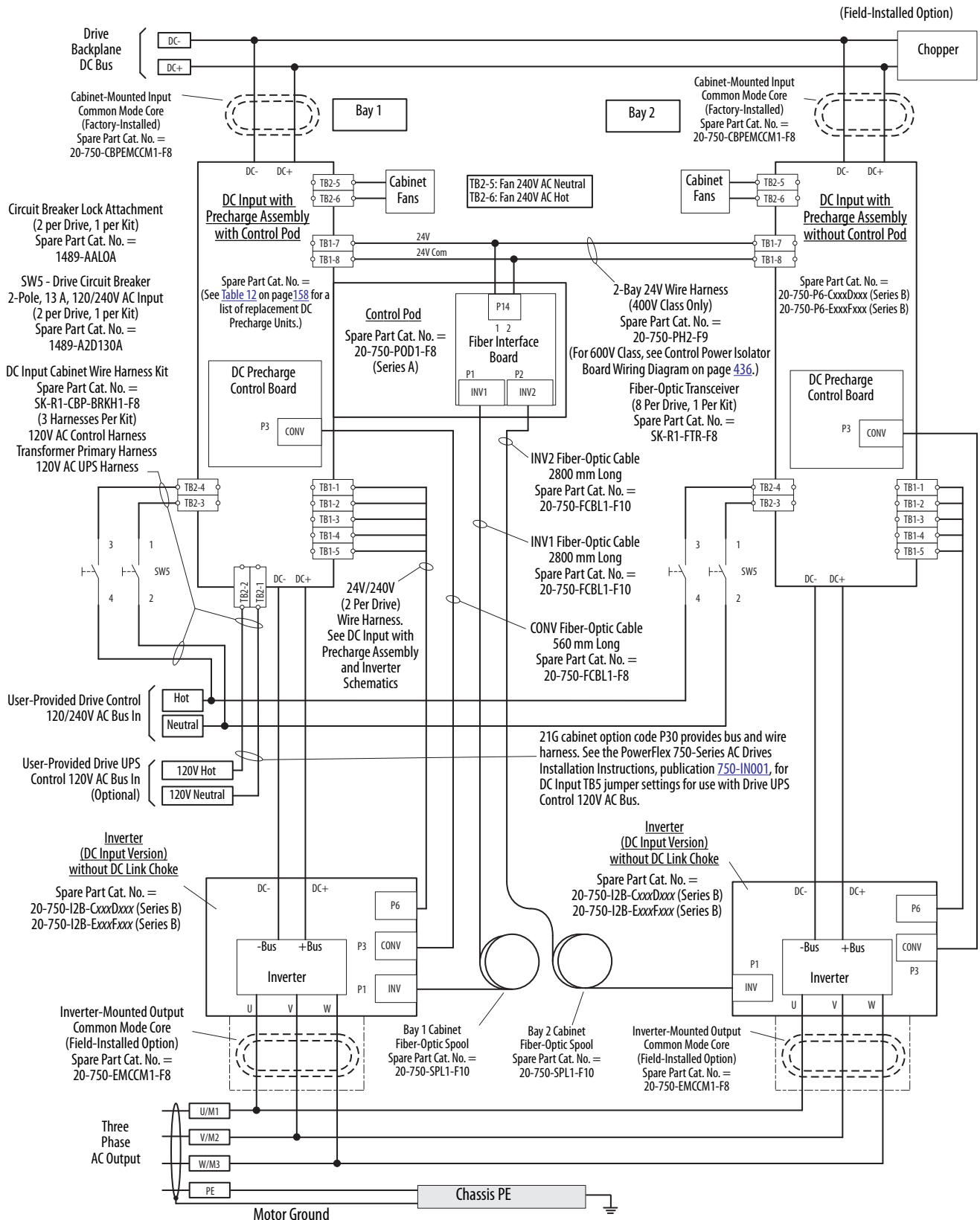
Frame 10 AC Input Drive Schematic Diagram (400VAC and 600VAC Classes)



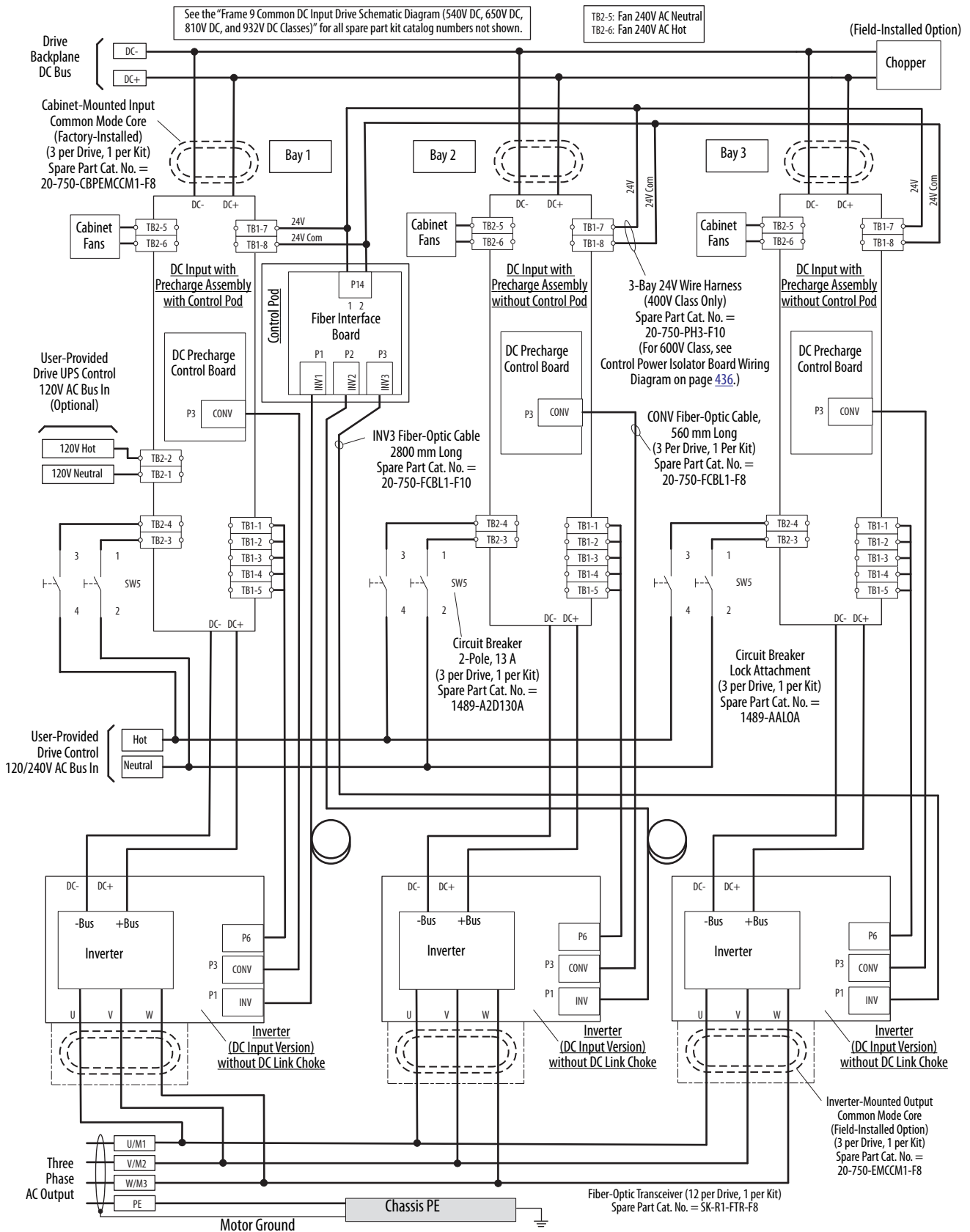
Frame 8 Common DC Input Drive Schematic Diagram (540V DC, 650V DC, 810V DC, and 932V DC Classes)



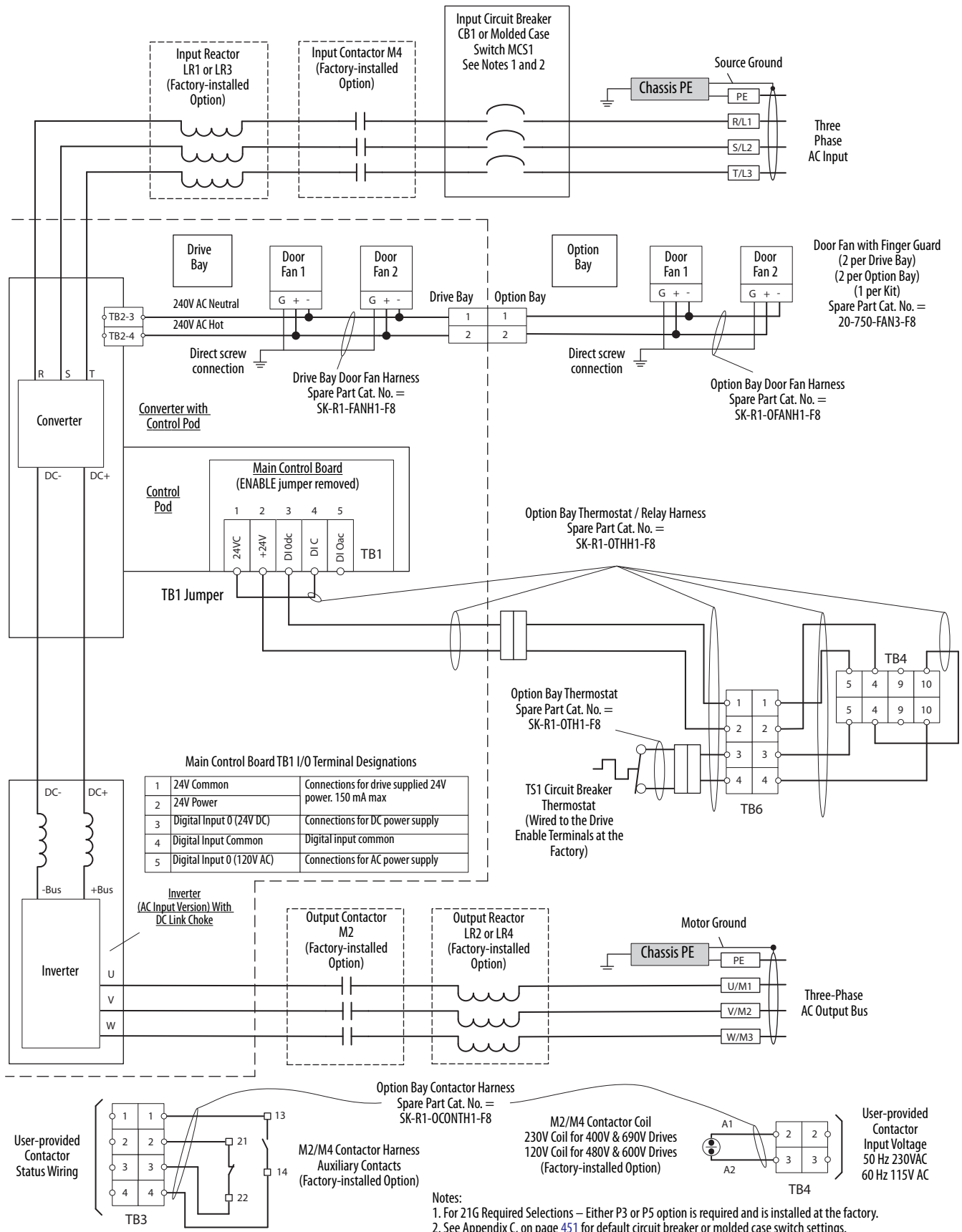
Frame 9 Common DC Input Drive Schematic Diagram (540V DC, 650V DC, 810V DC, and 932V DC Classes)



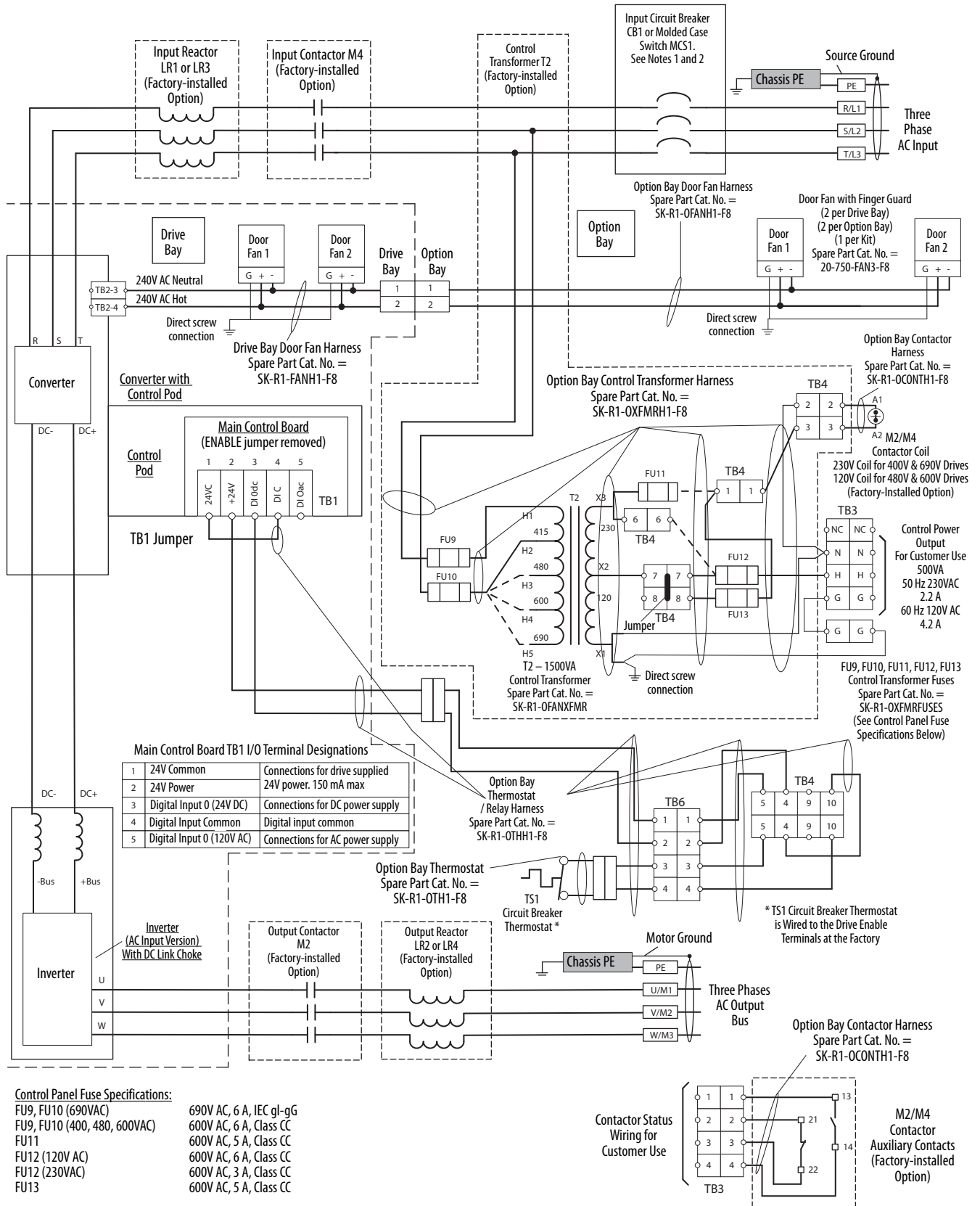
Frame 10 Common DC Input Drive Schematic Diagram (540V DC, 650V DC, 810V DC, and 932V DC Classes)



Frame 8 AC Input IP20 Option Bay without a Control Transformer Schematic Diagram



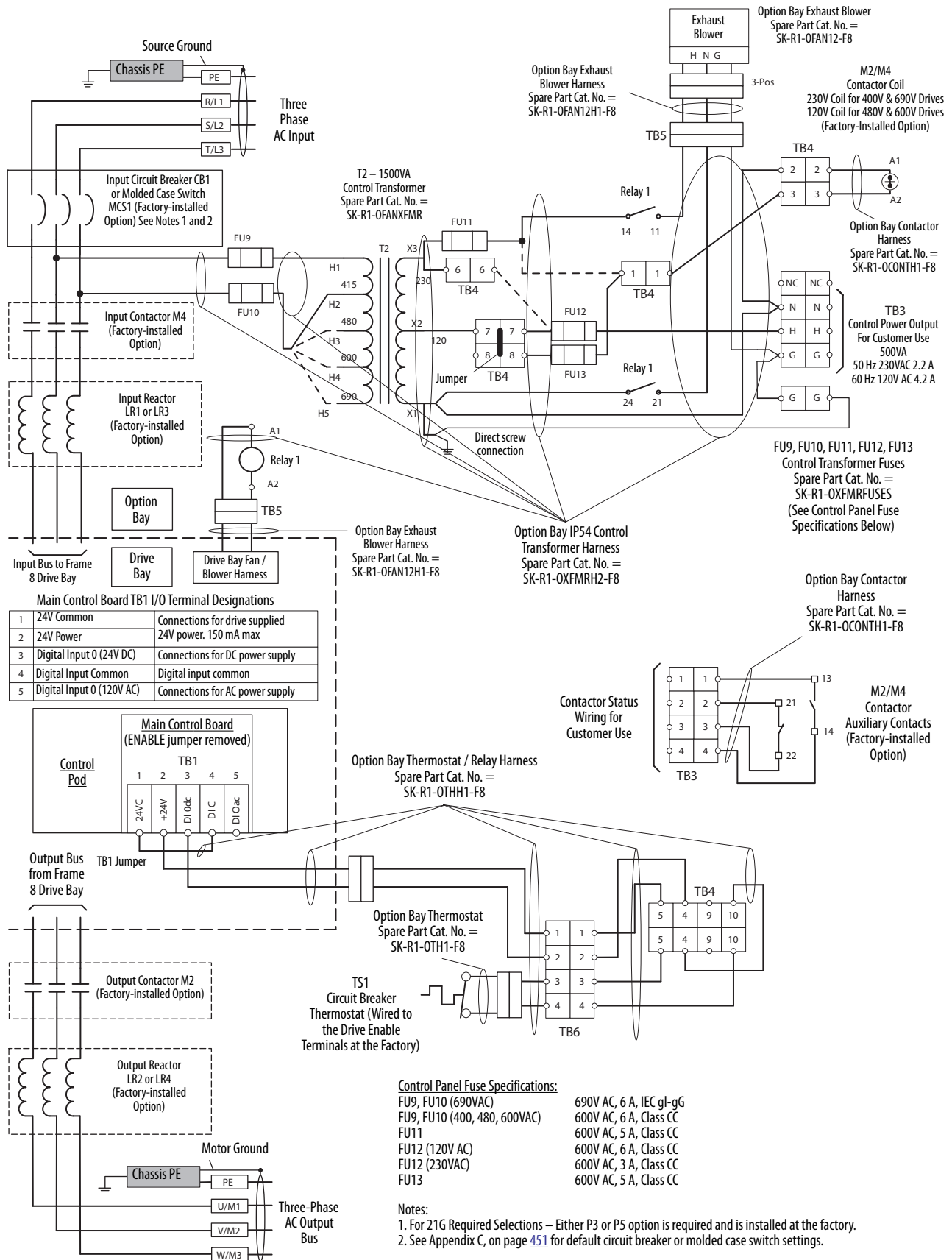
Frame 8 AC Input IP20 Option Bay with a Control Transformer Schematic Diagram



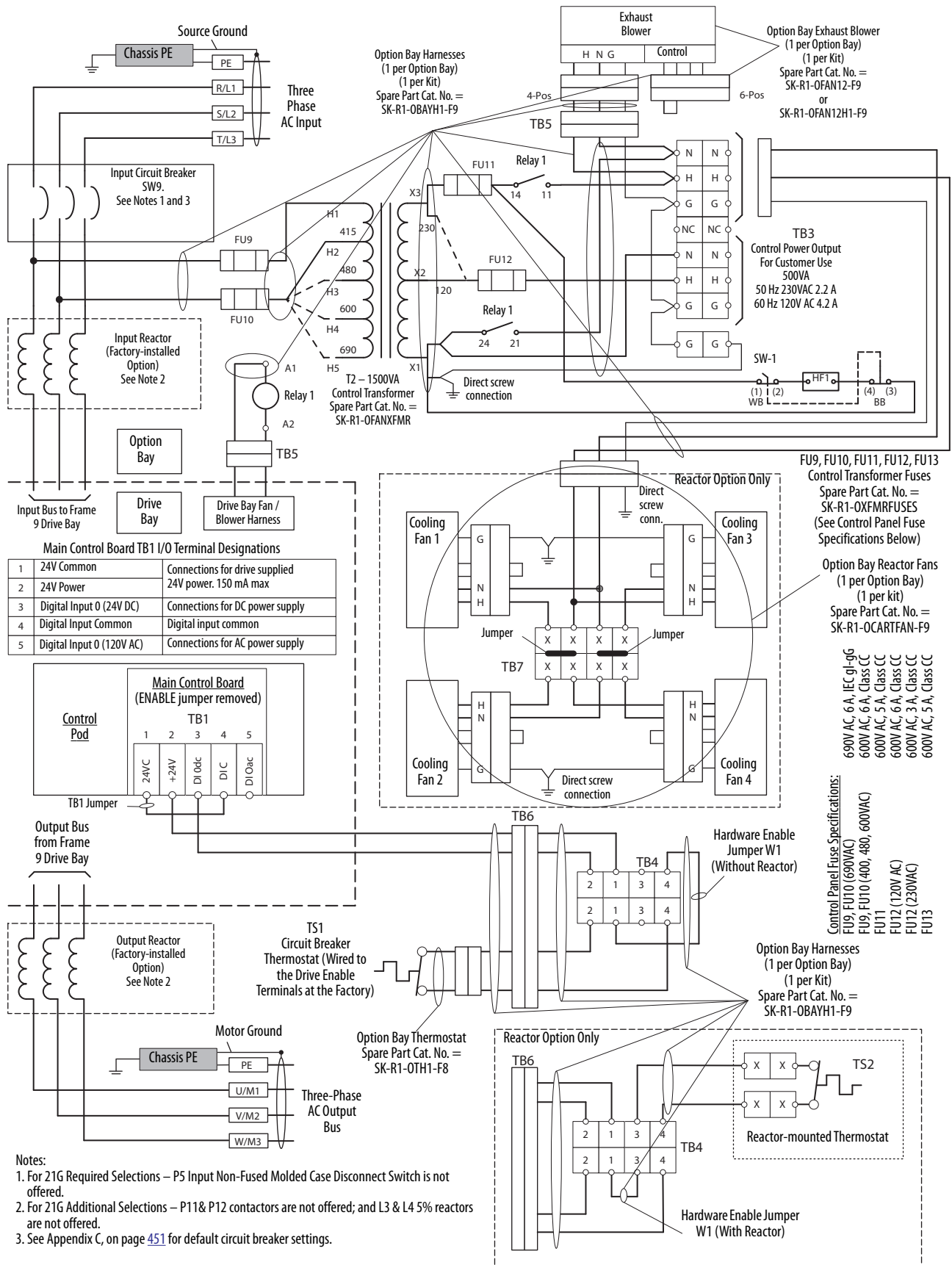
Notes:

1. For 21G Required Selections – Either P3 or P5 option is required and is installed at the factory.
2. See Appendix C, on page 451 for default circuit breaker or molded case switch settings.

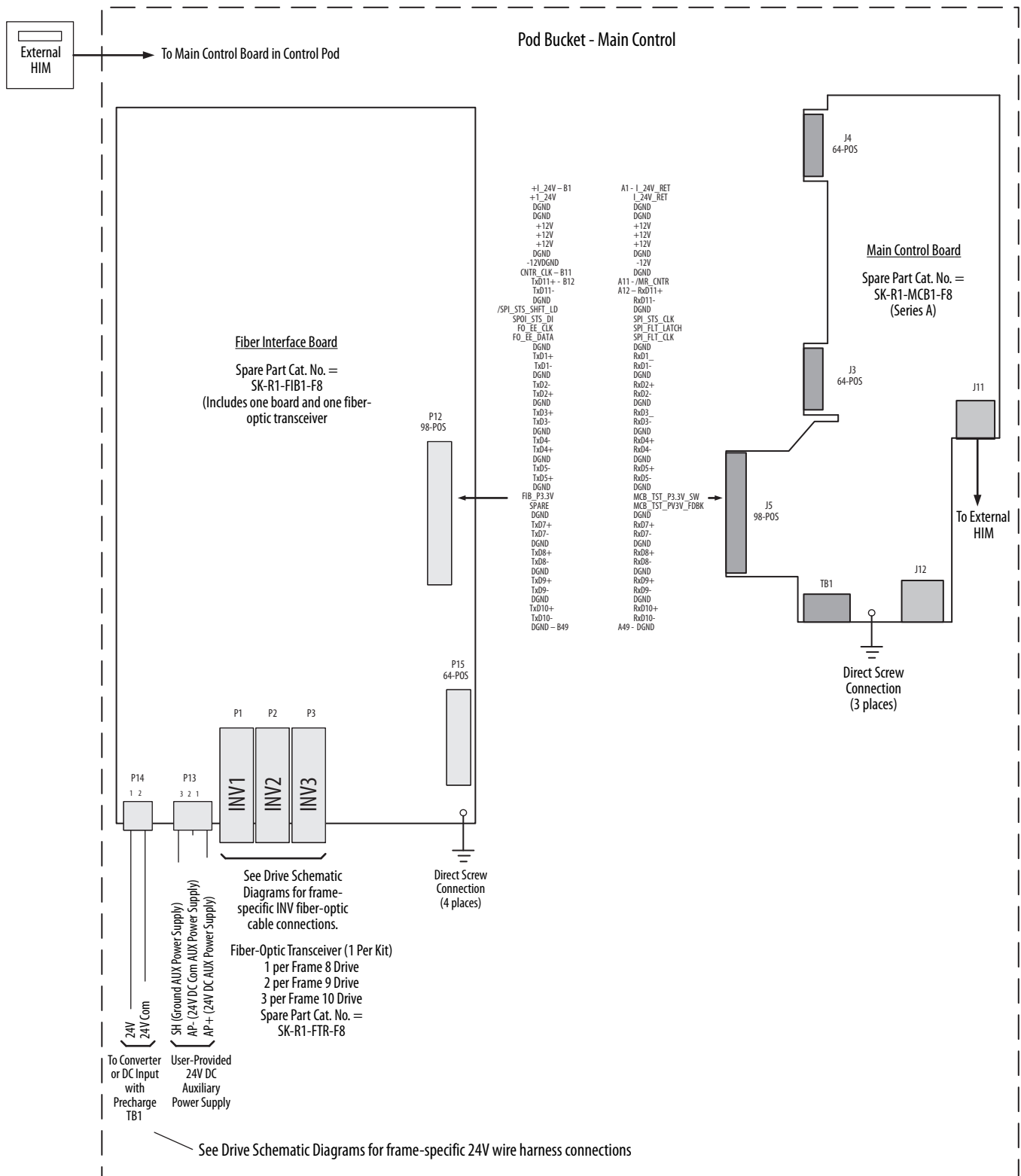
Frame 8 AC Input IP54 Option Bay Schematic Diagram



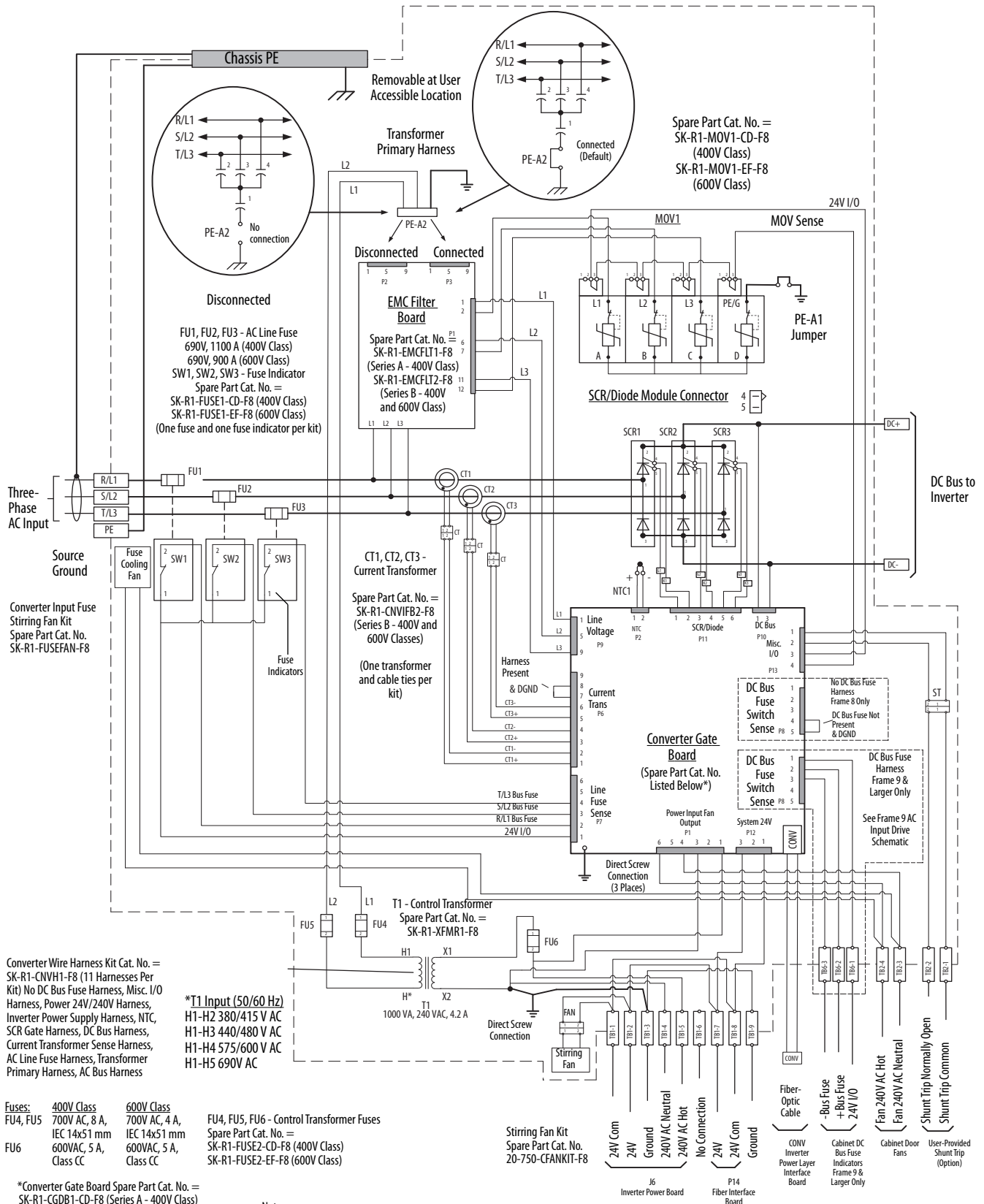
Frame 9 AC Input Option Bay Schematic Diagram



Control Pod Schematic Diagram



Converter Schematic Diagram (400VAC and 600VAC Classes AC Input Drive)



FU1, FU2, FU3 - AC Line Fuse
690V, 1100 A (400V Class)
690V, 900 A (600V Class)
SW1, SW2, SW3 - Fuse Indicator
Spare Part Cat. No. =
SK-R1-FUSE1-CD-F8 (400V Class)
SK-R1-FUSE1-EF-F8 (600V Class)
(One fuse and one fuse indicator per kit)

CT1, CT2, CT3 - Current Transformer
Spare Part Cat. No. =
SK-R1-CNVIFB2-F8
(Series B - 400V and 600V Classes)
(One transformer and cable ties per kit)

Converter Wire Harness Kit Cat. No. =
SK-R1-CNVH1-F8 (11 Harnesses Per Kit)
No DC Bus Fuse Harness, Misc. I/O Harness, Power 24V/240V Harness, Inverter Power Supply Harness, NTC, SCR Gate Harness, DC Bus Harness, Current Transformer Sense Harness, AC Line Fuse Harness, Transformer Primary Harness, AC Bus Harness

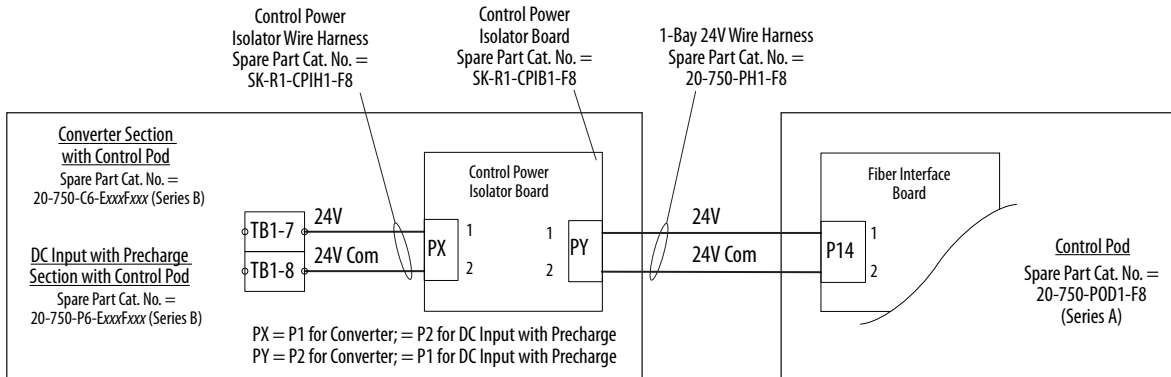
*T1 Input (50/60 Hz)
H1-H2 380/415 V AC
H1-H3 440/480 V AC
H1-H4 575/600 V AC
H1-H5 690V AC

Fuses:
FU4, FU5 400V Class 700V AC, 8 A, IEC 14x51 mm
FU6 600V Class 700V AC, 4 A, IEC 14x51 mm
FU4, FU5, FU6 - Control Transformer Fuses
Spare Part Cat. No. =
SK-R1-FUSE2-CD-F8 (400V Class)
SK-R1-FUSE2-EF-F8 (600V Class)

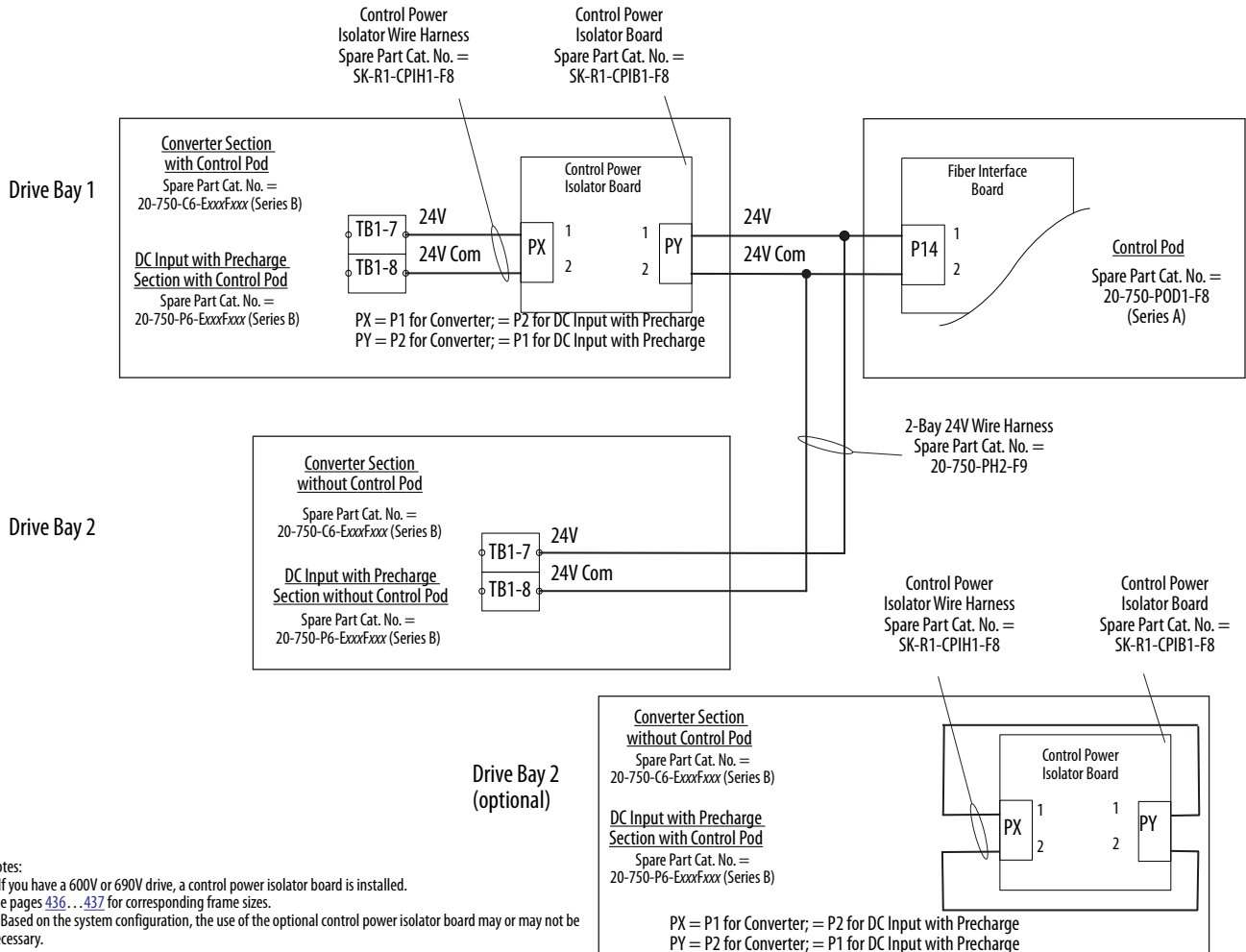
*Converter Gate Board Spare Part Cat. No. =
SK-R1-CGDB1-CD-F8 (Series A - 400V Class)
SK-R1-CGDB3-CD-F8 (Series B - 400V Class)
SK-R1-CGDB3-EF-F8 (Series B - 600V Class)
One board and one fiber-optic transceiver per kit

Notes:
1. If you have a 600V or 690V drive, a control power isolator board is installed. See pages 436...437 for corresponding frame sizes.
2. Fiber-Optic Transceiver (1 Per Converter, 1 Per Kit) Spare Part Cat. No. = SK-R1-FTR-F8.

Frame 8 Control Power Isolator Board Wiring Diagrams (600V AC Class AC Input Drive, and 810V DC and 932V DC Classes Common DC Input Drive)

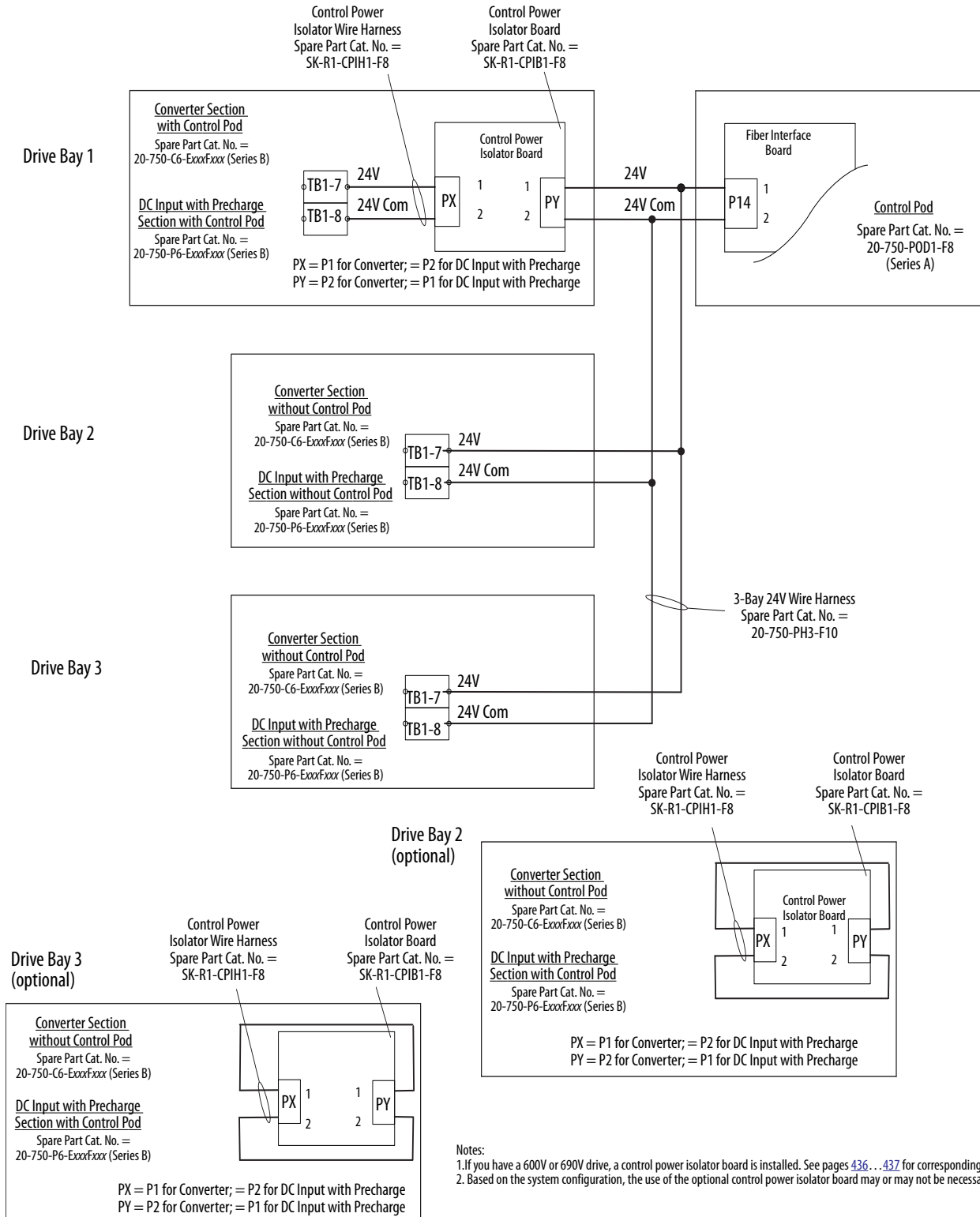


Frame 9 Control Power Isolator Board Wiring Diagrams (600V AC Class AC Input Drive, and 810V DC and 932V DC Classes Common DC Input Drive)

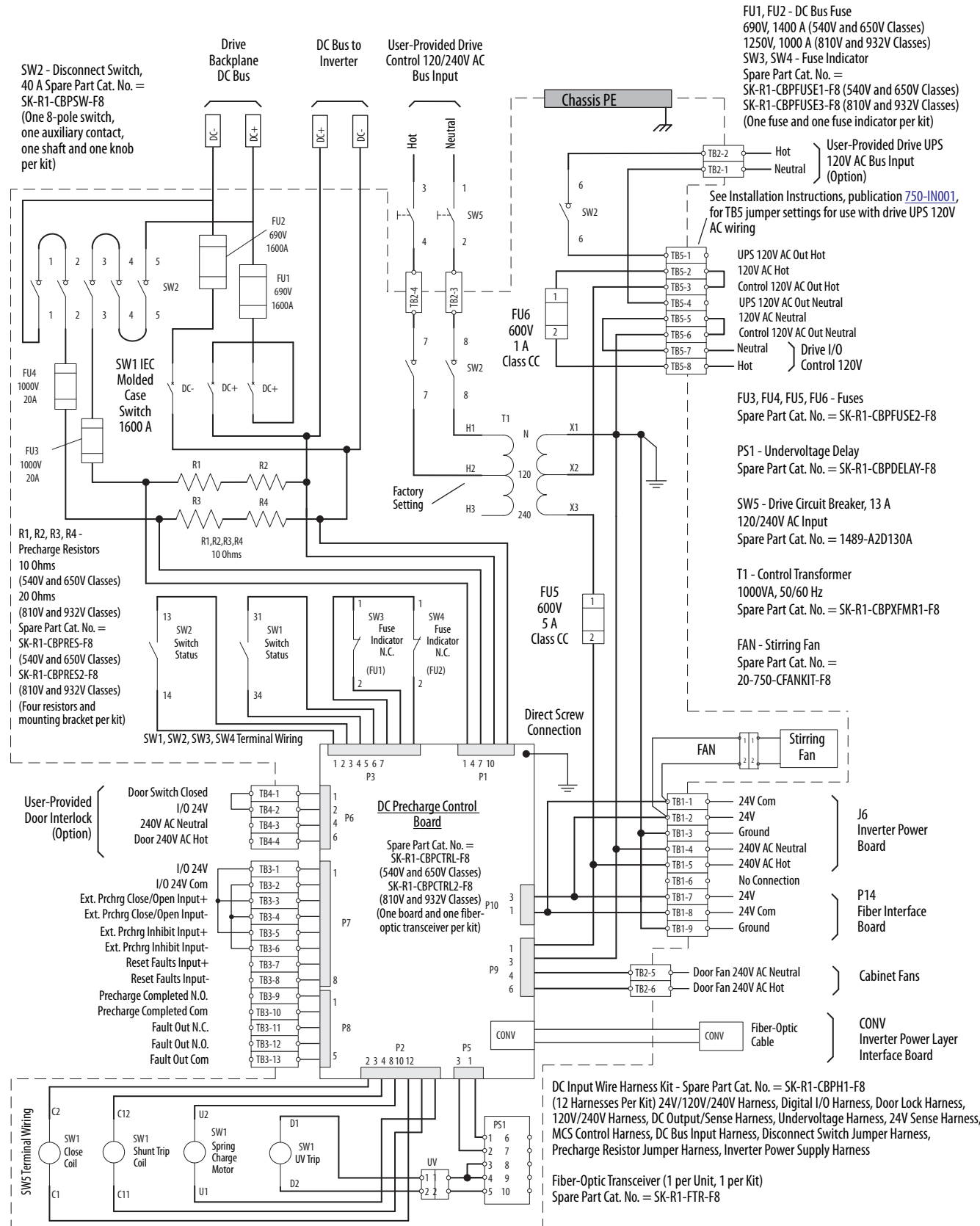


Notes:
 1. If you have a 600V or 690V drive, a control power isolator board is installed.
 See pages 436...437 for corresponding frame sizes.
 2. Based on the system configuration, the use of the optional control power isolator board may or may not be necessary.

Frame 10 Control Power Isolator Board Wiring Diagrams (600V AC Class AC Input Drive, and 810V DC and 932V DC Classes Common DC Input Drive)



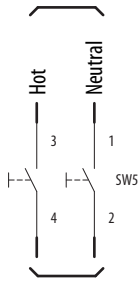
DC Input with Precharge Assembly Schematic Diagram (540V DC, 650V DC, 810V DC, and 932V DC Classes Common DC Input Drives)



DC Input with Precharge Devices Schematic Diagrams

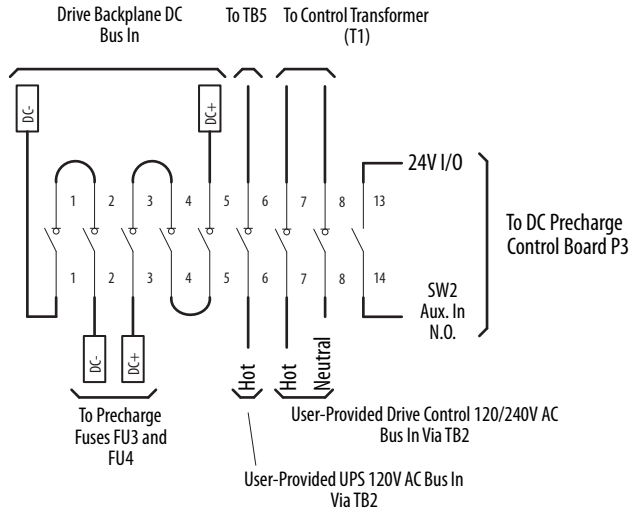
DC Input Circuit Breaker (SW5)

User-Provided Drive Control 120/240V AC Bus In

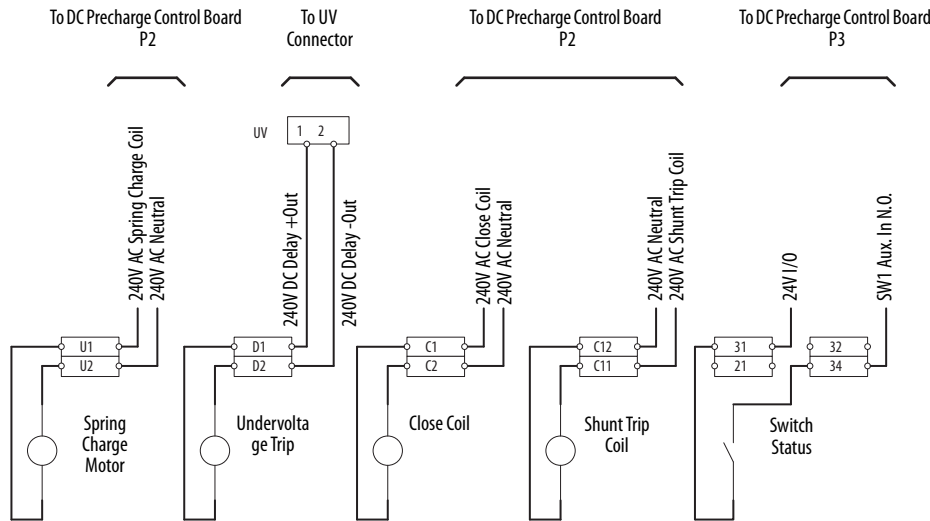


To Disconnect Switch SW2 Via TB2

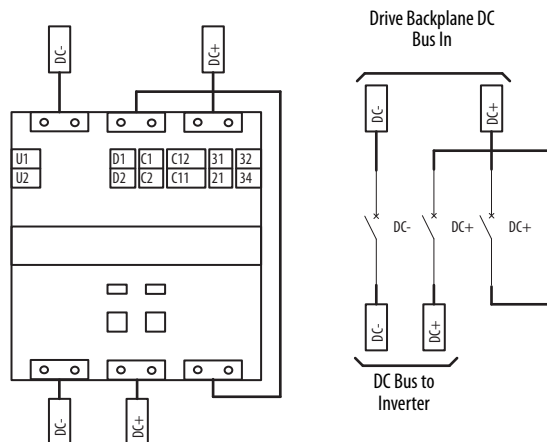
DC Input Disconnect Switch (SW2)



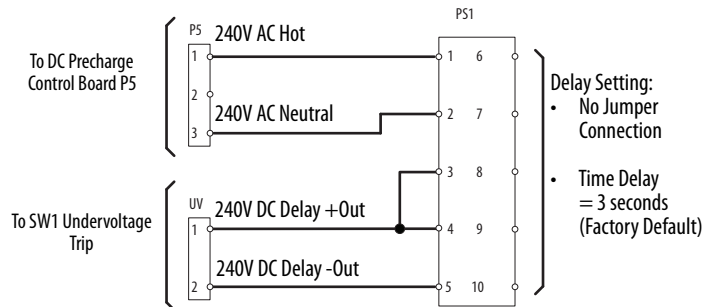
DC Input Molded Case Switch (SW1) Control



DC Input Molded Case Switch (SW1) Power



DC Input Undervoltage Delay Module (PS1)



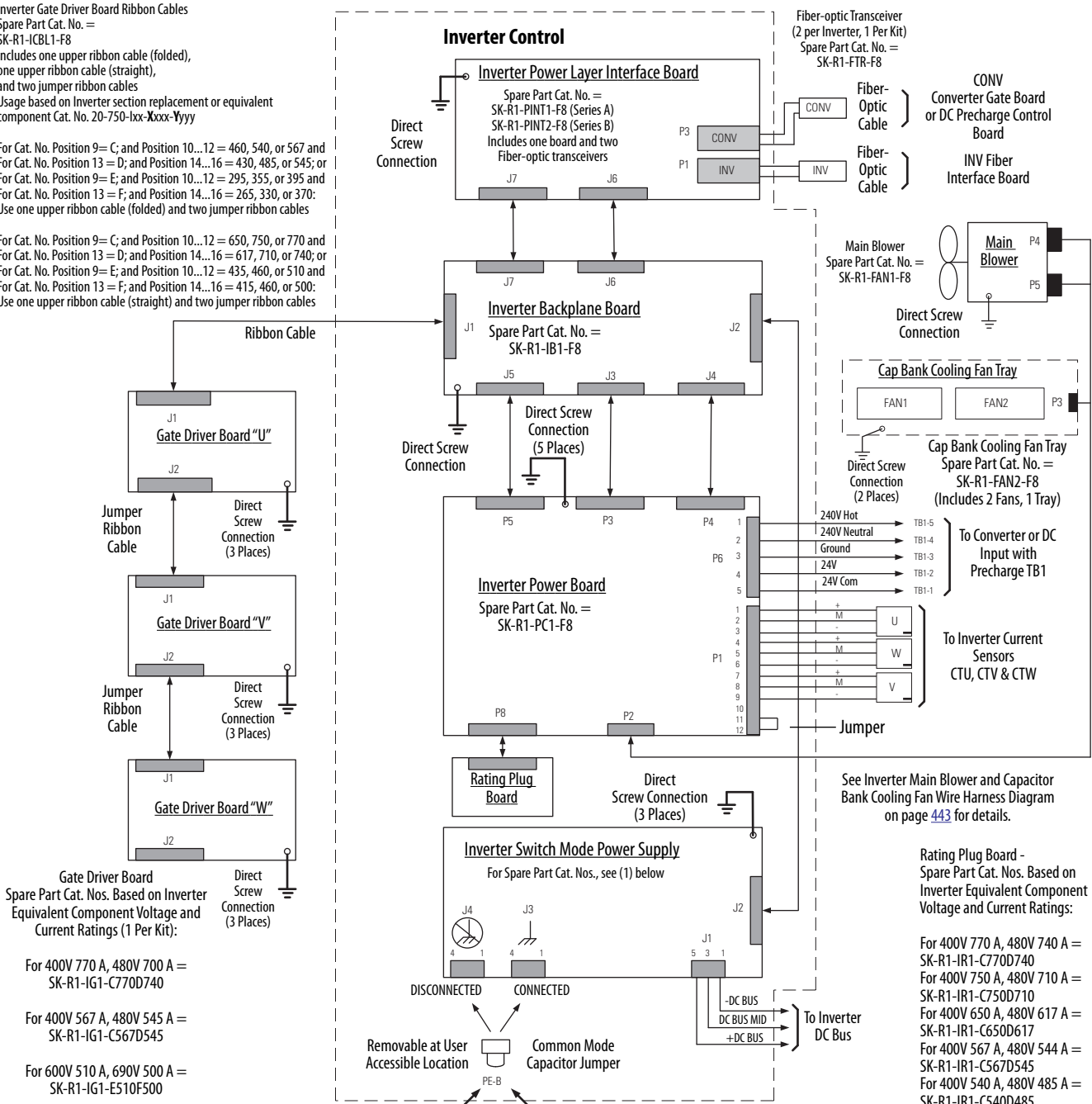
Inverter Circuit Board Schematic Diagram (All Drive Configurations)

Inverter Gate Driver Board Ribbon Cables

Spare Part Cat. No. = SK-R1-ICBL1-F8
Includes one upper ribbon cable (folded), one upper ribbon cable (straight), and two jumper ribbon cables
Usage based on Inverter section replacement or equivalent component Cat. No. 20-750-lxx-xxxx-yyy

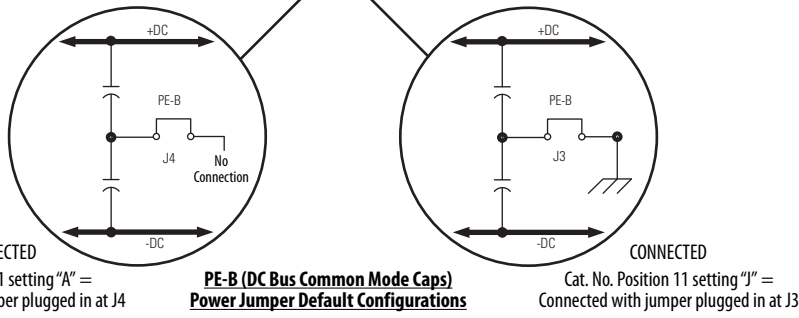
For Cat. No. Position 9=C; and Position 10...12 = 460, 540, or 567 and For Cat. No. Position 13 = D; and Position 14...16 = 430, 485, or 545; or For Cat. No. Position 9=E; and Position 10...12 = 295, 355, or 395 and For Cat. No. Position 13 = F; and Position 14...16 = 265, 330, or 370:
Use one upper ribbon cable (folded) and two jumper ribbon cables

For Cat. No. Position 9=C; and Position 10...12 = 650, 750, or 770 and For Cat. No. Position 13 = D; and Position 14...16 = 617, 710, or 740; or For Cat. No. Position 9=E; and Position 10...12 = 435, 460, or 510 and For Cat. No. Position 13 = F; and Position 14...16 = 415, 460, or 500:
Use one upper ribbon cable (straight) and two jumper ribbon cables



Gate Driver Board Spare Part Cat. Nos. Based on Inverter Equivalent Component Voltage and Current Ratings (1 Per Kit):

- For 400V 770 A, 480V 700 A = SK-R1-IG1-C770D740
- For 400V 567 A, 480V 545 A = SK-R1-IG1-CS67D545
- For 600V 510 A, 690V 500 A = SK-R1-IG1-E510F500
- For 600V 395 A, 690V 370 A = SK-R1-IG1-E395F370



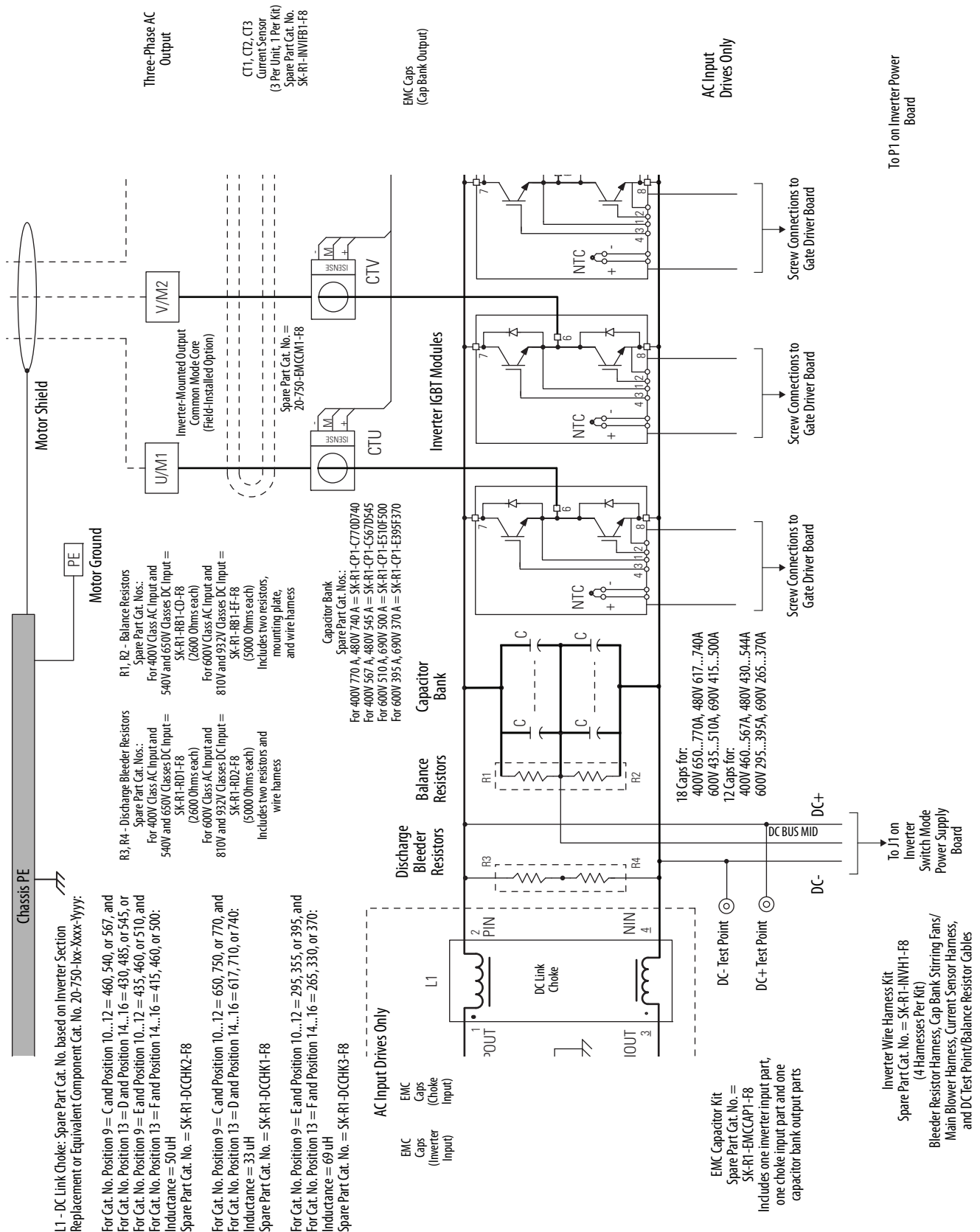
PE-B (DC Bus Common Mode Caps) Power Jumper Default Configurations

(1) Inverter Switch Mode Power Supply - Spare Part Cat. Nos.
For 400V Class AC Input and 540V and 650V Classes Common DC Input = SK-R1-PWRS1-CD-F8
For 600V Class AC Input and 810V and 932V Classes Common DC Input = SK-R1-PWRS1-EF-F8

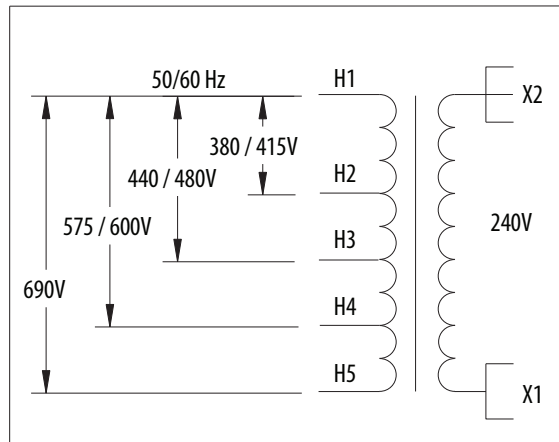
Rating Plug Board - Spare Part Cat. Nos. Based on Inverter Equivalent Component Voltage and Current Ratings:

- For 400V 770 A, 480V 740 A = SK-R1-IR1-C770D740
- For 400V 750 A, 480V 710 A = SK-R1-IR1-C750D710
- For 400V 650 A, 480V 617 A = SK-R1-IR1-C650D617
- For 400V 567 A, 480V 544 A = SK-R1-IR1-C567D545
- For 400V 540 A, 480V 485 A = SK-R1-IR1-C540D485
- For 400V 460 A, 480V 430 A = SK-R1-IR1-C460D430
- For 600V 510 A, 690V 500 A = SK-R1-IR1-E510F500
- For 600V 460 A, 690V 460 A = SK-R1-IR1-E460F460
- For 600V 435 A, 690V 415 A = SK-R1-IR1-E435F415
- For 600V 395 A, 690V 370 A = SK-R1-IR1-E395F370
- For 600V 355 A, 690V 330 A = SK-R1-IR1-E355F330
- For 600V 295 A, 690V 265 A = SK-R1-IR1-E295F265

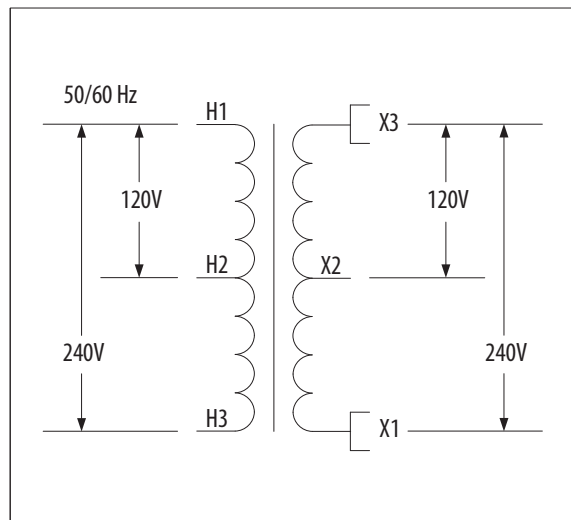
Inverter Power Layer Schematic Diagram (All Drive Configurations)



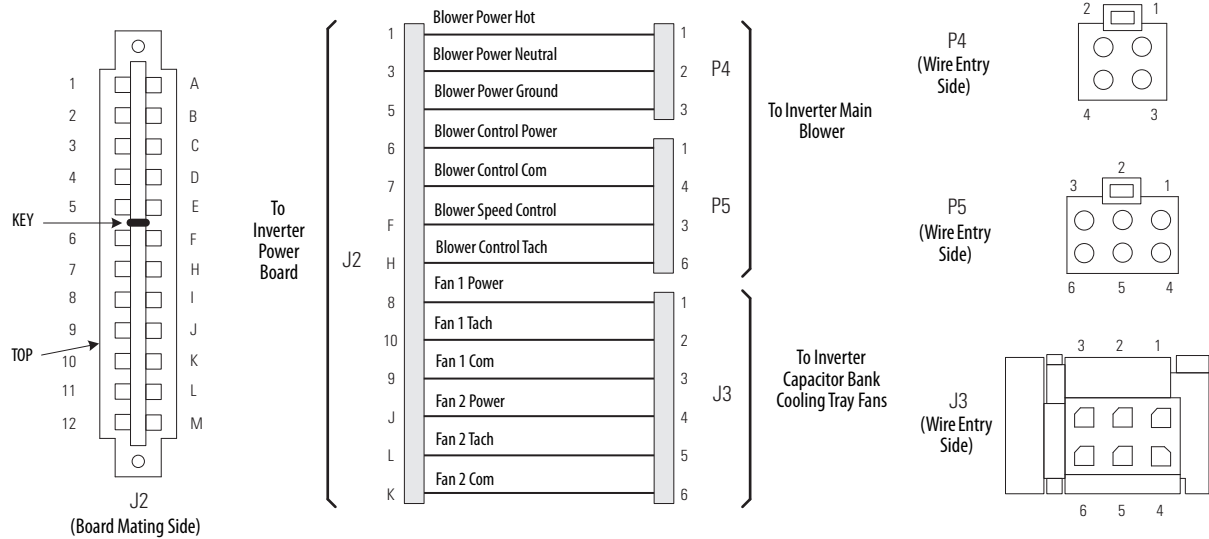
AC Input Drive Control Transformer Schematic Diagram



DC Input with Precharge Assembly Control Transformer Schematic Diagram

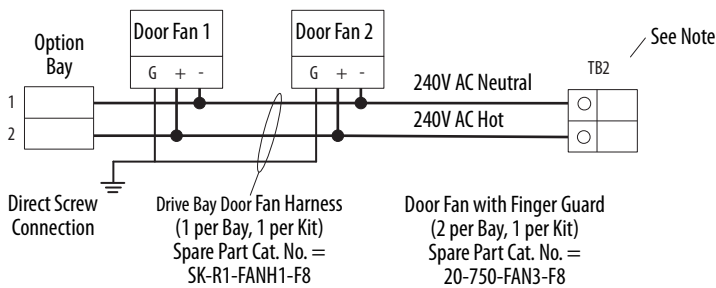


Inverter Main Blower and Capacitor Bank Cooling Fan Wire Harness Diagram

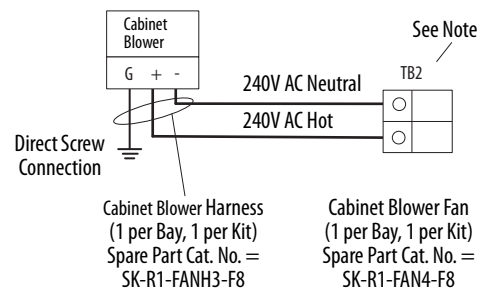


Cabinet Cooling Wiring Diagrams

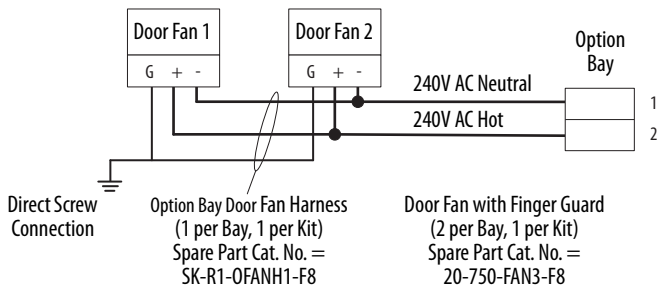
IP20, NEMA/UL Type 1 Drive Bay



IP54, NEMA/UL Type 12 Drive Bay



IP20, NEMA/UL Type 1 Option Bay (Frame 8)



Note: For TB2 terminal numbers for AC Input and Common DC Input drives, see Drive Schematic Diagrams on previous pages.

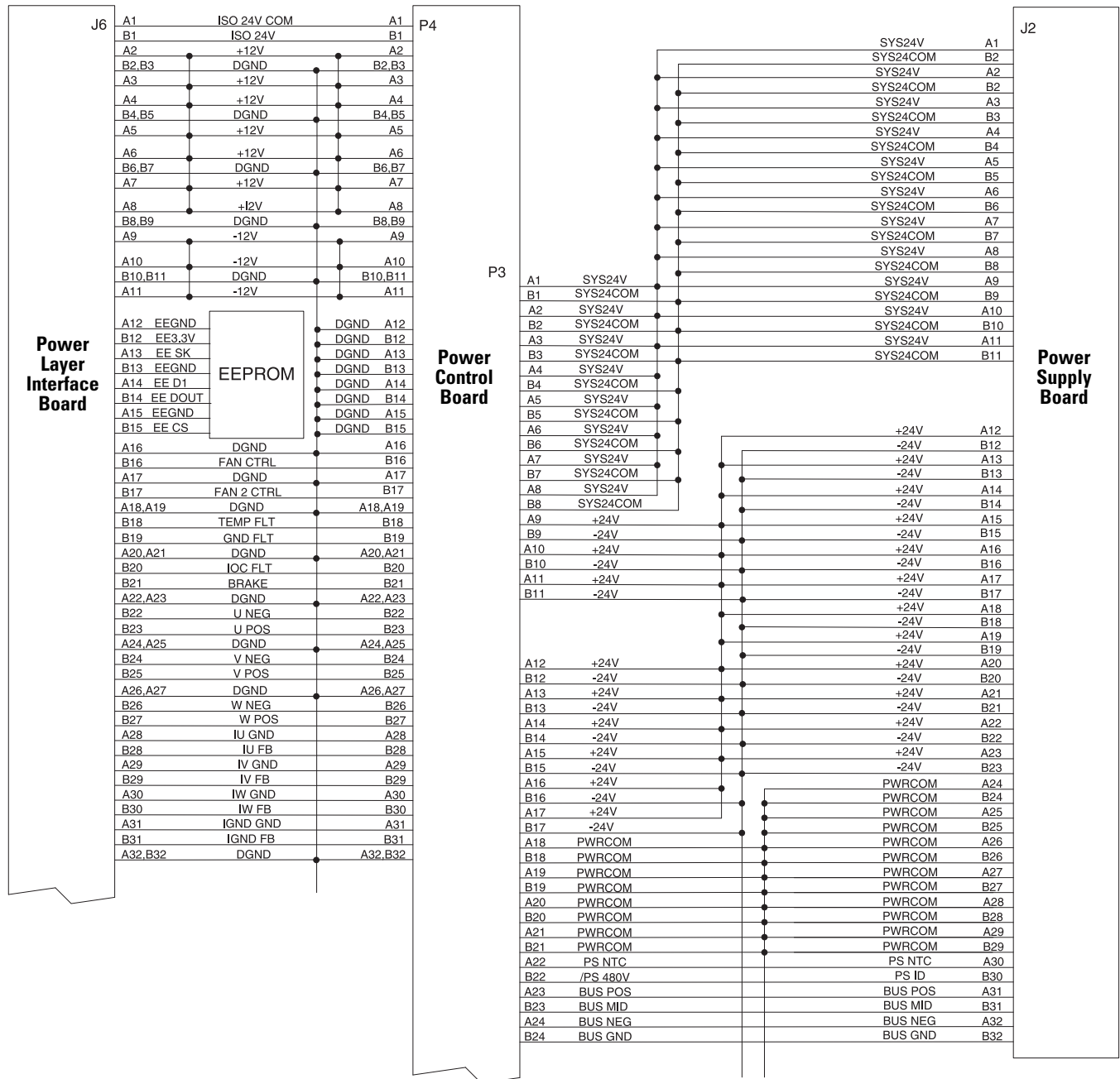
Notes:

Circuit Board Interconnections

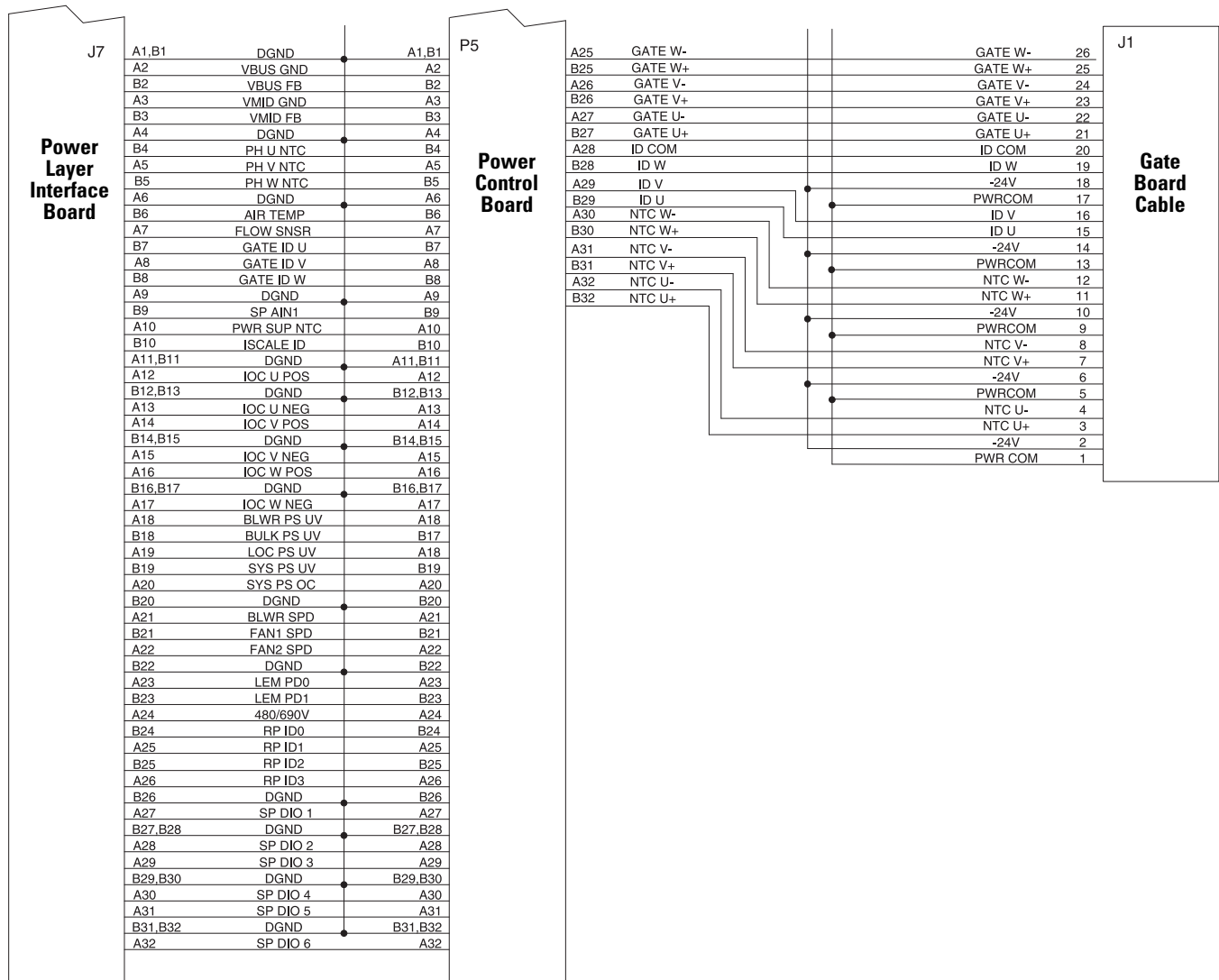
Topic	Page
Inverter Board Interconnections Diagram 1	446
Inverter Board Interconnections Diagram 2	447
Control Board Interconnections Diagram 1	448
Control Board Interconnections Diagram 2	449

This chapter provides the interconnection signals between drive circuit boards.

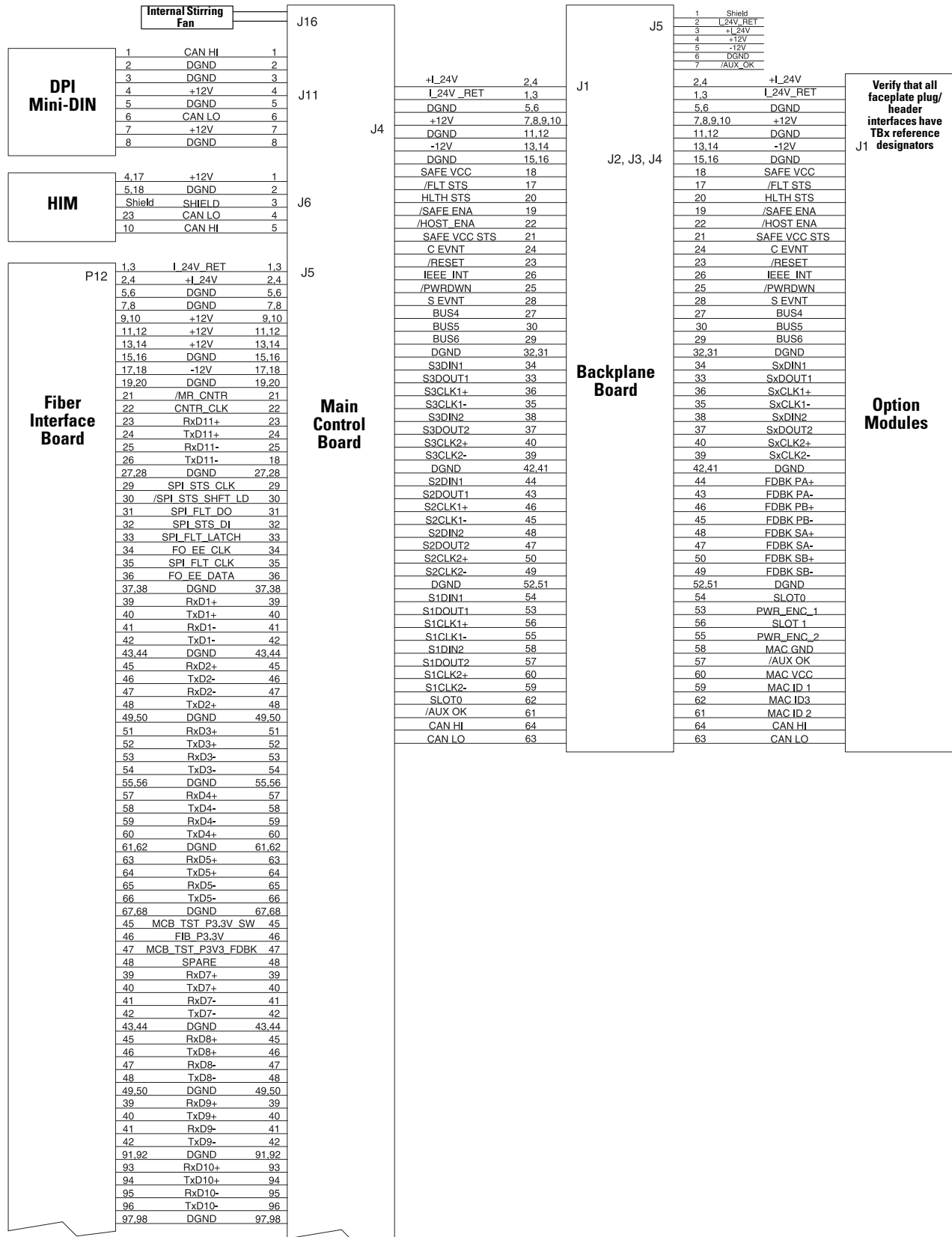
Inverter Board Interconnections Diagram 1



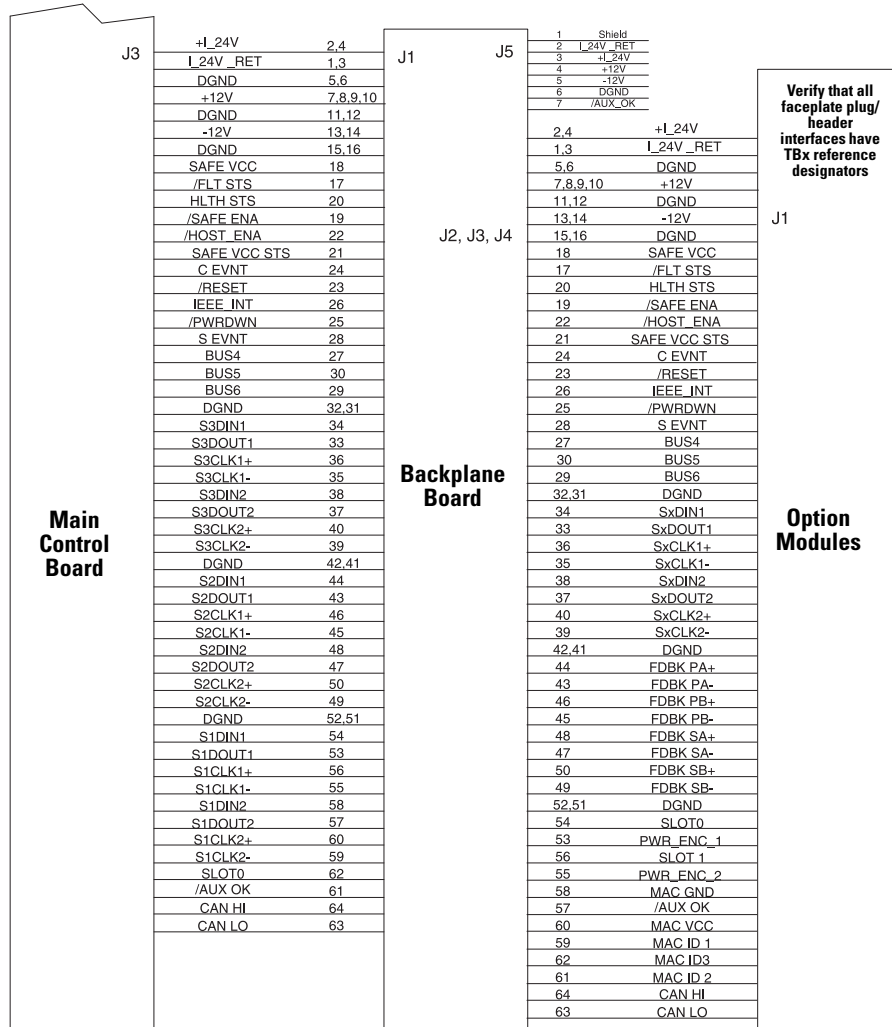
Inverter Board Interconnections Diagram 2



Control Board Interconnections Diagram 1



Control Board Interconnections Diagram 2



Notes:

Drive-compatible Circuit Breakers, Molded Case Switches, Contactors, and Line Reactors

Replacement Part Catalog Numbers, Ratings, and Settings

This appendix contains catalog numbers, ratings, and corresponding settings for the following:

- Drive-compatible circuit breakers
- Molded case switches
- Contactors
- 3% and 5% line reactors

Table 20 - 400V AC Input Drive, Light-Duty Ratings

Drive Cat. No.	Fame Size	Drive Rating (Amps)	Drive Power Rating (kW)	Circuit Breaker Cat. No.	Circuit Breaker Rating (Amps)	Circuit Breaker TM / ET Actual Current Setting (Amps) L	Circuit Breaker TM / ET Actual Current Setting (Amps) S	Circuit Breaker TM / ET Actual Current Setting (Amps) I	Circuit Breaker TM / ET Actual Current Setting (Amps) G	Molded Case Switch Cat. No.	Molded Case Switch Setting (Amps)	Contactor Cat. No.	3% Line Reactor Cat. No.	5% Line Reactor Cat. No.
C460	8	540	315	140G-N0H3-E12	1200	690	6000	10800	–	140G-M6S3-D80	800	100-D630EA11	1321-3R600-B	1321-3R600-C
C540	8	585	315	140G-N0H3-E12	1200	720	6000	10800	–	140G-M6S3-D80	800	100-D630EA11	1321-3R600-B	1321-3R600-C
C567	8	612	355	140G-N0H3-E12	1200	750	6000	10800	–	140G-M6S3-D80	800	100-D630EA11	1321-3R750-B	1321-3R750-C
C650	8	750	400	140G-N0H3-E12	1200	930	6000	10800	–	140G-N6S3-E12	1200	100-D860EA11	1321-3R750-B	1321-3R750-C
C750	8	796	450	140G-N0H3-E12	1200	990	6000	10800	–	140G-N6S3-E12	1200	100-D860EA11	1321-3R850-B	1321-3R850-C
C770	8	832	450	140G-N0H3-E12	1200	1020	6000	10800	–	140G-N6S3-E12	1200	100-D860EA11	1321-3R850-B	1321-3R850-C
C910	9	1040	560	140G-R12I3-E20	2000	1300	10000	18000	1200	–	–	–	–	–
C1K0	9	1090	630	140G-R12I3-E20	2000	1350	10000	18000	1200	–	–	–	–	–
C1K1	9	1175	710	140G-R12I3-E20	2000	1450	10000	18000	1200	–	–	–	–	–
C1K2	9	1465	800	140G-R12I3-E20	2000	1800	10000	18000	1200	–	–	–	–	–
C1K4	9	1480	850	140G-R12I3-E20	2000	1850	10000	18000	1200	–	–	–	–	–
C1K5	9	1600	900	140G-R12I3-E20	2000	2000	10000	18000	1200	–	–	–	–	–
C1K6 ⁽¹⁾	10	1715	1000	–	–	–	–	–	–	–	–	–	–	–
C2K1 ⁽¹⁾	10	2330	1400	–	–	–	–	–	–	–	–	–	–	–

(1) Contact the factory.

Table 21 - 480V AC Input Drive, Light-Duty Ratings

Drive Cat. No.	Fame Size	Drive Rating (Amps)	Drive Power Rating (Hp)	Circuit Breaker Cat. No.	Circuit Breaker Rating (Amps)	Circuit Breaker TM/ET Actual Current Setting (Amps) L	Circuit Breaker TM/ET Actual Current Setting (Amps) S	Circuit Breaker TM/ET Actual Current Setting (Amps) I	Circuit Breaker TM/ET Actual Current Setting (Amps) G	Molded Case Switch Cat. No.	Molded Case Switch Setting (Amps)	Contactor Cat. No.	3% Line Reactor Cat. No.	5% Line Reactor Cat. No.
D430	8	485	400	140G-N0H3-E12	1200	570	6000	10800	–	140G-M6S3-D80	800	100-D630ED11	1321-3R500-B	1321-3R500-C
D485	8	545	450	140G-N0H3-E12	1200	660	6000	10800	–	140G-M6S3-D80	800	100-D630ED11	1321-3R600-B	1321-3R600-C
D545	8	590	500	140G-N0H3-E12	1200	720	6000	10800	–	140G-M6S3-D80	800	100-D630ED11	1321-3R600-B	1321-3R600-C
D617	8	710	600	140G-N0H3-E12	1200	840	6000	10800	–	140G-N6S3-E12	1200	100-D860ED11	1321-3R750-B	1321-3R750-C
D710	8	765	650	140G-N0H3-E12	1200	900	6000	10800	–	140G-N6S3-E12	1200	100-G1200KD12	1321-3R850-B	1321-3R850-C
D740	8	800	700	140G-N0H3-E12	1200	960	6000	10800	–	140G-N6S3-E12	1200	100-G1200KD12	1321-3R850-B	1321-3R850-C
D800	9	960	800	140G-N0H3-E12	1200	1140	6000	10800	–	–	–	–	–	–
D960	9	1045	900	140G-R12I3-E20	2000	1250	10000	18000	1200	–	–	–	–	–
D1K0	9	1135	1000	140G-R12I3-E20	2000	1350	10000	18000	1200	–	–	–	–	–
D1K2	9	1365	1100	140G-R12I3-E20	2000	1650	10000	18000	1200	–	–	–	–	–
D1K3	9	1420	1250	140G-R12I3-E20	2000	1700	10000	18000	1200	–	–	–	–	–
D1K4	9	1540	1350	140G-R12I3-E20	2000	1850	10000	18000	1200	–	–	–	–	–
D1K5 ⁽¹⁾	10	1655	1500	–	–	–	–	–	–	–	–	–	–	–
D2K0 ⁽¹⁾	10	2240	2000	–	–	–	–	–	–	–	–	–	–	–

(1) Contact the factory.

Table 22 - 600V AC Input Drive, Light-Duty Ratings

Drive Cat. No.	Fame Size	Drive Rating (Amps)	Drive Power Rating (Hp)	Circuit Breaker Cat. No.	Circuit Breaker Rating (Amps)	Circuit Breaker TM/ET Actual Current Setting (Amps) L	Circuit Breaker TM/ET Actual Current Setting (Amps) S	Circuit Breaker TM/ET Actual Current Setting (Amps) I	Circuit Breaker TM/ET Actual Current Setting (Amps) G	Molded Case Switch Cat. No.	Molded Case Switch Setting (Amps)	Contactor Cat. No.	3% Line Reactor Cat. No.	5% Line Reactor Cat. No.
E295	8	355	350	140G-M0F3-D60	600	420	4500	–	–	140G-M6S3-D80	800	100-D420ED11	1321-3RC400-C	RL-54004
E355	8	395	400	140G-M0F3-D60	600	510	4500	–	–	140G-M6S3-D80	800	100-D420ED11	1321-3R600-C	RL-4003B14
E395	8	435	450	140G-M0F3-D60	600	510	4500	–	–	140G-M6S3-D80	800	100-D630ED11	1321-3R600-C	RL-54503
E435	8	460	500	140G-M0F3-D60	600	600	4500	–	–	140G-M6S3-D80	800	100-D630ED11	1321-3R500-B	RL-54503
E460	8	510	500	140G-M6F3-D80	800	680	6000	–	–	140G-M6S3-D80	800	100-D630ED11	1321-3R500-B	RL-54004
E510	8	545	550	140G-M6F3-D80	800	680	6000	–	–	140G-M6S3-D80	800	100-D630ED11	1321-3R600-C	RL-54503
E595	9	595	700	140G-NS0H3-E12	1200	810	6000	10800	–	–	–	–	–	–
E630	9	760	800	140G-NS0H3-E12	1200	900	6000	10800	–	–	–	–	–	–
E760	9	835	900	140G-NS0H3-E12	1200	990	6000	10800	–	–	–	–	–	–
E825	9	900	950	140G-NS0H3-E12	1200	1080	6000	10800	–	–	–	–	–	–
E900	9	980	1000	140G-R12I3-E20	2000	1150	10000	18000	1200	–	–	–	–	–
E980	9	1045	1100	140G-R12I3-E20	2000	1250	10000	18000	1200	–	–	–	–	–
E1K1 ⁽¹⁾	10	1220	1200	–	–	–	–	–	–	–	–	–	–	–
E1K4 ⁽¹⁾	10	1530	1500	–	–	–	–	–	–	–	–	–	–	–

(1) Contact the factory.

Table 23 - 690V AC Input Drive, Light-Duty Ratings

Drive Cat. No.	Fame Size	Drive Rating (Amps)	Drive Power Rating (kW)	Circuit Breaker Cat. No.	Circuit Breaker Rating (Amps)	Circuit Breaker TM/ET Actual Current Setting (Amps) L	Circuit Breaker TM/ET Actual Current Setting (Amps) S	Circuit Breaker TM/ET Actual Current Setting (Amps) I	Circuit Breaker TM/ET Actual Current Setting (Amps) G	Molded Case Switch Cat. No.	Molded Case Switch Setting (Amps)	Contactor Cat. No.	3% Line Reactor Cat. No.	5% Line Reactor Cat. No.
F265	8	330	315	140G-M0F3-D60	600	420	4500	–	–	140G-M6S3-D80	800	100-D420EA11	1321-3RC400-C	RL-41508
F330	8	370	355	140G-M0F3-D60	600	510	4500	–	–	140G-M6S3-D80	800	100-D420EA11	1321-3RC400-C	RL-41508
F370	8	410	400	140G-M0F3-D60	600	510	4500	–	–	140G-M6S3-D80	800	100-D420EA11	1321-3RC400-C	RL-41508
F415	8	460	450	140G-M0F3-D60	600	600	4500	–	–	140G-M6S3-D80	800	100-D630EA11	1321-3R500-C	RL-54004
F460	8	500	500	140G-M6F3-D80	800	680	6000	–	–	140G-M6S3-D80	800	100-D630EA11	1321-3R600-C	RL-54004
F500	8	530	530	140G-M6F3-D80	800	680	6000	–	–	140G-M6S3-D80	800	100-D420EA11	1321-3R600-C	RL-54004
F590	9	650	630	140G-NS0H3-E12	1200	780	6000	10800	–	–	–	–	–	–
F650	9	710	710	140G-NS0H3-E12	1200	840	6000	10800	–	–	–	–	–	–
F710	9	790	800	140G-NS0H3-E12	1200	930	6000	10800	–	–	–	–	–	–
F765	9	860	850	140G-NS0H3-E12	1200	1020	6000	10800	–	–	–	–	–	–
F795	9	960	900	140G-NS0H3-E12	1200	1140	6000	10800	–	–	–	–	–	–
F960	9	1020	1000	140G-R12I3-E20	2000	1300	10000	18000	1200	–	–	–	–	–
F1K0 ⁽¹⁾	10	1150	1100	–	–	–	–	–	–	–	–	–	–	–
F1K4 ⁽¹⁾	10	1485	1500	–	–	–	–	–	–	–	–	–	–	–

(1) Contact the factory.

Table 24 - 400V AC Input Drive, Normal Duty Ratings

Drive Cat. No.	Fame Size	Drive Rating (Amps)	Drive Power Rating (kW)	Circuit Breaker Cat. No.	Circuit Breaker Rating (Amps)	Circuit Breaker TM/ET Actual Current Setting (Amps) L	Circuit Breaker TM/ET Actual Current Setting (Amps) S	Circuit Breaker TM/ET Actual Current Setting (Amps) I	Circuit Breaker TM/ET Actual Current Setting (Amps) G	Molded Case Switch Cat. No.	Molded Case Switch Setting (Amps)	Contactors Cat. No.	3% Line Reactor Cat. No.	5% Line Reactor Cat. No.
C460	8	460	250	140G-M0F3-D60	600	600	4500	-	-	140G-M6S3-D80	800	100-D630EA11	1321-3R500-B	1321-3R500-C
C540	8	540	315	140G-N0H3-E12	1200	660	6000	10800	-	140G-M6S3-D80	800	100-D630EA11	1321-3R600-B	1321-3R600-C
C567	8	567	315	140G-N0H3-E12	1200	720	6000	10800	-	140G-M6S3-D80	800	100-D630EA11	1321-3R600-B	1321-3R600-C
C650	8	650	355	140G-N0H3-E12	1200	810	6000	10800	-	140G-N6S3-E12	1200	100-D860EA11	1321-3R750-B	1321-3R750-C
C750	8	750	400	140G-N0H3-E12	1200	930	6000	10800	-	140G-N6S3-E12	1200	100-D860EA11	1321-3R750-B	1321-3R750-C
C770	8	770	400	140G-N0H3-E12	1200	960	6000	10800	-	140G-N6S3-E12	1200	100-D860EA11	1321-3R850-B	1321-3R850-C
C910	9	910	500	140G-NS0H3-E12	1200	1140	6000	10800	-	-	-	-	-	-
C1K0	9	1040	560	140G-R12I3-E20	2000	1300	10000	18000	1200	-	-	-	-	-
C1K1	9	1090	630	140G-R12I3-E20	2000	1350	10000	18000	1200	-	-	-	-	-
C1K2	9	1175	710	140G-R12I3-E20	2000	1450	10000	18000	1200	-	-	-	-	-
C1K4	9	1465	800	140G-R12I3-E20	2000	1800	10000	18000	1200	-	-	-	-	-
C1K5	9	1480	850	140G-R12I3-E20	2000	1850	10000	18000	1200	-	-	-	-	-
C1K6 ⁽¹⁾	10	1590	900	-	-	-	-	-	-	-	-	-	-	-
C2K1 ⁽¹⁾	10	2150	1250	-	-	-	-	-	-	-	-	-	-	-

(1) Contact the factory.

Table 25 - 480V AC Input Drive, Normal Duty Ratings

Drive Cat. No.	Fame Size	Drive Rating (Amps)	Drive Power Rating (Hp)	Circuit Breaker Cat. No.	Circuit Breaker Rating (Amps)	Circuit Breaker TM/ET Actual Current Setting (Amps) L	Circuit Breaker TM/ET Actual Current Setting (Amps) S	Circuit Breaker TM/ET Actual Current Setting (Amps) I	Circuit Breaker TM/ET Actual Current Setting (Amps) G	Molded Case Switch Cat. No.	Molded Case Switch Setting (Amps)	Contactors Cat. No.	3% Line Reactor Cat. No.	5% Line Reactor Cat. No.
D430	8	430	350	140G-M0F3-D60	600	510	4500	–	–	140G-M6S3-D80	800	100-D630ED11	1321-3R500-B	1321-3R500-C
D485	8	485	400	140G-N0H3-E12	1200	570	6000	10800	–	140G-M6S3-D80	800	100-D630ED11	1321-3R500-B	1321-3R500-C
D545	8	545	450	140G-N0H3-E12	1200	660	6000	10800	–	140G-M6S3-D80	800	100-D630ED11	1321-3R600-B	1321-3R600-C
D617	8	617	500	140G-N0H3-E12	1200	750	6000	10800	–	140G-M6S3-D80	800	100-D630ED11	1321-3R750-B	1321-3R750-C
D710	8	710	600	140G-N0H3-E12	1200	840	6000	10800	–	140G-N6S3-E12	1200	100-D860ED11	1321-3R750-B	1321-3R750-C
D740	8	740	650	140G-N0H3-E12	1200	870	6000	10800	–	140G-N6S3-E12	1200	100-G1200KD12	1321-3R750-B	1321-3R750-C
D800	9	800	700	140G-NS0H3-E12	1200	960	6000	10800	–	–	–	–	–	–
D960	9	960	800	140G-NS0H3-E12	1200	1140	6000	10800	–	–	–	–	–	–
D1K0	9	1045	900	140G-R12I3-E20	2000	1250	10000	18000	1200	–	–	–	–	–
D1K2	9	1135	1000	140G-R12I3-E20	2000	1350	10000	18000	1200	–	–	–	–	–
D1K3	9	1365	1100	140G-R12I3-E20	2000	1650	10000	18000	1200	–	–	–	–	–
D1K4	9	1420	1250	140G-R12I3-E20	2000	1700	10000	18000	1200	–	–	–	–	–
D1K5 ⁽¹⁾	10	1525	1350	–	–	–	–	–	–	–	–	–	–	–
D2K0 ⁽¹⁾	10	2070	1750	–	–	–	–	–	–	–	–	–	–	–

(1) Contact the factory.

Table 26 - 600V AC Input Drive, Normal Duty Ratings

Drive Cat. No.	Fame Size	Drive Rating (Amps)	Drive Power Rating (Hp)	Circuit Breaker Cat. No.	Circuit Breaker Rating (Amps)	Circuit Breaker TM / ET Actual Current Setting (Amps) L	Circuit Breaker TM / ET Actual Current Setting (Amps) S	Circuit Breaker TM / ET Actual Current Setting (Amps) I	Circuit Breaker TM / ET Actual Current Setting (Amps) G	Molded Case Switch Cat. No.	Molded Case Switch Setting (Amps)	Contactor Cat. No.	3% Line Reactor Cat. No.	5% Line Reactor Cat. No.
E295	8	295	300	140G-M0F3-D60	600	420	4500	–	–	140G-M6S3-D80	800	100-D420ED11	1321-3RC400-C	RL-41508
E355	8	355	350	140G-M0F3-D60	600	420	4500	–	–	140G-M6S3-D80	800	100-D420ED11	1321-3RC400-C	RL-54004
E395	8	395	400	140G-M0F3-D60	600	510	4500	–	–	140G-M6S3-D80	800	100-D420ED11	1321-3R600-C	RL-4003B14
E435	8	435	450	140G-M0F3-D60	600	510	4500	–	–	140G-M6S3-D80	800	100-D630ED11	1321-3R600-C	RL-54503
E460	8	460	500	140G-M0F3-D60	600	600	4500	–	–	140G-M6S3-D80	800	100-D630ED11	1321-3R500-B	RL-54503
E510	8	510	500	140G-M6F3-D80	800	680	6000	–	–	140G-M6S3-D80	800	100-D630ED11	1321-3R500-B	RL-54503
E595	9	595	600	140G-NS0H3-E12	1200	720	6000	10800	–	–	–	–	–	–
E630	9	630	700	140G-NS0H3-E12	1200	750	6000	10800	–	–	–	–	–	–
E760	9	760	800	140G-NS0H3-E12	1200	900	6000	10800	–	–	–	–	–	–
E825	9	825	900	140G-NS0H3-E12	1200	990	6000	10800	–	–	–	–	–	–
E900	9	900	950	140G-NS0H3-E12	1200	1080	6000	10800	–	–	–	–	–	–
E980	9	980	1000	140G-R12I3-E20	2000	1150	10000	18000	1200	–	–	–	–	–
E1K1 ⁽¹⁾	10	1110	1100	–	–	–	–	–	–	–	–	–	–	–
E1K4 ⁽¹⁾	10	1430	1400	–	–	–	–	–	–	–	–	–	–	–

(1) Contact the factory.

Table 27 - 690V AC Input Drive, Normal Duty Ratings

Drive Cat. No.	Fame Size	Drive Rating (Amps)	Drive Power Rating (kW)	Circuit Breaker Cat. No.	Circuit Breaker Rating (Amps)	Circuit Breaker TM/ET Actual Current Setting (Amps) L	Circuit Breaker TM/ET Actual Current Setting (Amps) S	Circuit Breaker TM/ET Actual Current Setting (Amps) I	Circuit Breaker TM/ET Actual Current Setting (Amps) G	Molded Case Switch Cat. No.	Molded Case Switch Setting (Amps)	Contactor Cat. No.	3% Line Reactor Cat. No.	5% Line Reactor Cat. No.
F265	8	265	250	140G-M0F3-D60	600	420	4500	–	–	140G-M6S3-D80	800	100-D420EA11	RL-41508	RL-26503
F330	8	330	315	140G-M0F3-D60	600	420	4500	–	–	140G-M6S3-D80	800	100-D420EA11	1321-3RC400-C	RL-41508
F370	8	370	355	140G-M0F3-D60	600	510	4500	–	–	140G-M6S3-D80	800	100-D420EA11	1321-3RC400-C	RL-41508
F415	8	415	400	140G-M0F3-D60	600	510	4500	–	–	140G-M6S3-D80	800	100-D420EA11	1321-3RC400-C	RL-41508
F460	8	460	450	140G-M0F3-D60	600	600	4500	–	–	140G-M6S3-D80	800	100-D630EA11	1321-3R500-C	RL-54004
F500	8	500	500	140G-M6F3-D80	800	680	6000	–	–	140G-M6S3-D80	800	100-D630EA11	1321-3R600-C	RL-54004
F590	9	590	560	140G-NS0H3-E12	1200	690	6000	10800	–	–	–	–	–	–
F650	9	650	630	140G-NS0H3-E12	1200	780	6000	10800	–	–	–	–	–	–
F710	9	710	710	140G-NS0H3-E12	1200	840	6000	10800	–	–	–	–	–	–
F765	9	765	750	140G-NS0H3-E12	1200	900	6000	10800	–	–	–	–	–	–
F795	9	795	800	140G-NS0H3-E12	1200	930	6000	10800	–	–	–	–	–	–
F960	9	960	900	140G-NS0H3-E12	1200	1140	6000	10800	–	–	–	–	–	–
F1K0 ⁽¹⁾	10	1040	1000	–	–	–	–	–	–	–	–	–	–	–
F1K4 ⁽¹⁾	10	1400	1400	–	–	–	–	–	–	–	–	–	–	–

(1) Contact the factory.

Table 28 - 400V AC Input Drive, Heavy-Duty Ratings

Drive Cat. No.	Fame Size	Drive Rating (Amps)	Drive Power Rating (kW)	Circuit Breaker Cat. No.	Circuit Breaker Rating (Amps)	Circuit Breaker TM/ET Actual Current Setting (Amps) L	Circuit Breaker TM/ET Actual Current Setting (Amps) S	Circuit Breaker TM/ET Actual Current Setting (Amps) I	Circuit Breaker TM/ET Actual Current Setting (Amps) G	Molded Case Switch Cat. No.	Molded Case Switch Setting (Amps)	Contactors Cat. No.	3% Line Reactor Cat. No.	5% Line Reactor Cat. No.
C460	8	385	200	140G-M0F3-D60	600	510	4500	–	–	140G-M6S3-D80	800	100-D420EA11	1321-3RB400-B	1321-3RC400-C
C540	8	456	250	140G-M0F3-D60	600	600	4500	–	–	140G-M6S3-D80	800	100-D630EA11	1321-3R500-B	1321-3R500-C
C567	8	472	250	140G-M0F3-D60	600	600	4500	–	–	140G-M6S3-D80	800	100-D630EA11	1321-3R500-B	1321-3R500-C
C650	8	540	315	140G-N0H3-E12	1200	660	6000	10800	–	140G-M6S3-D80	800	100-D630EA11	1321-3R600-B	1321-3R600-C
C750	8	585	315	140G-N0H3-E12	1200	720	6000	10800	–	140G-M6S3-D80	800	100-D630EA11	1321-3R600-B	1321-3R600-C
C770	8	642	355	140G-N0H3-E12	1200	810	6000	10800	–	140G-M6S3-D80	800	100-D860EA11	1321-3R750-B	1321-3R750-C
C910	9	750	400	140G-NS0H3-E12	1200	930	6000	10800	–	–	–	–	–	–
C1K0	9	880	500	140G-NS0H3-E12	1200	1080	6000	10800	–	–	–	–	–	–
C1K1	9	910	500	140G-NS0H3-E12	1200	1140	6000	10800	–	–	–	–	–	–
C1K2	9	1040	560	140G-R12I3-E20	2000	1300	10000	18000	1200	–	–	–	–	–
C1K4	9	1090	630	140G-R12I3-E20	2000	1350	10000	18000	1200	–	–	–	–	–
C1K5	9	1175	710	140G-R12I3-E20	2000	1450	10000	18000	1200	–	–	–	–	–
C1K6 ⁽¹⁾	10	1325	710	–	–	–	–	–	–	–	–	–	–	–
C2K1 ⁽¹⁾	10	1800	1000	–	–	–	–	–	–	–	–	–	–	–

(1) Contact the factory.

Table 29 - 480V AC Input Drive, Heavy-Duty Ratings

Drive Cat. No.	Fame Size	Drive Rating (Amps)	Drive Power Rating (Hp)	Circuit Breaker Cat. No.	Circuit Breaker Rating (Amps)	Circuit Breaker TM/ET Actual Current Setting (Amps) L	Circuit Breaker TM/ET Actual Current Setting (Amps) S	Circuit Breaker TM/ET Actual Current Setting (Amps) I	Circuit Breaker TM/ET Actual Current Setting (Amps) G	Molded Case Switch Cat. No.	Molded Case Switch Setting (Amps)	Contactors Cat. No.	3% Line Reactor Cat. No.	5% Line Reactor Cat. No.
D430	8	370	300	140G-M0F3-D60	600	510	4500	–	–	140G-M6S3-D80	800	100-D420ED11	1321-3RB400-B	1321-3RC400-C
D485	8	414	350	140G-M0F3-D60	600	510	4500	–	–	140G-M6S3-D80	800	100-D420ED11	1321-3R500-B	1321-3R500-C
D545	8	454	350	140G-M0F3-D60	600	600	4500	–	–	140G-M6S3-D80	800	100-D630ED11	1321-3R500-B	1321-3R500-C
D617	8	485	400	140G-N0H3-E12	1200	570	6000	10800	–	140G-M6S3-D80	800	100-D630ED11	1321-3R500-B	1321-3R500-C
D710	8	545	450	140G-N0H3-E12	1200	660	6000	10800	–	140G-M6S3-D80	800	100-D630ED11	1321-3R600-B	1321-3R600-C
D740	8	617	500	140G-N0H3-E12	1200	750	6000	10800	–	140G-M6S3-D80	800	100-D630ED11	1321-3R750-B	1321-3R750-C
D800	9	710	600	140G-NS0H3-E12	1200	840	6000	10800	–	–	–	–	–	–
D960	9	795	700	140G-NS0H3-E12	1200	960	6000	10800	–	–	–	–	–	–
D1K0	9	800	750	140G-NS0H3-E12	1200	960	6000	10800	–	–	–	–	–	–
D1K2	9	960	800	140G-NS0H3-E12	1200	1140	6000	10800	–	–	–	–	–	–
D1K3	9	1045	900	140G-R12I3-E20	2000	1250	10000	18000	1200	–	–	–	–	–
D1K4	9	1135	1000	140G-R12I3-E20	2000	1350	10000	18000	1200	–	–	–	–	–
D1K5 ⁽¹⁾	10	1270	1100	–	–	–	–	–	–	–	–	–	–	–
D2K0 ⁽¹⁾	10	1730	1650	–	–	–	–	–	–	–	–	–	–	–

(1) Contact the factory.

Table 30 - 600V AC Input Drive, Heavy-Duty Ratings

Drive Cat. No.	Fame Size	Drive Rating (Amps)	Drive Power Rating (Hp)	Circuit Breaker Cat. No.	Circuit Breaker Rating (Amps)	Circuit Breaker TM / ET Actual Current Setting (Amps) L	Circuit Breaker TM / ET Actual Current Setting (Amps) S	Circuit Breaker TM / ET Actual Current Setting (Amps) I	Circuit Breaker TM / ET Actual Current Setting (Amps) G	Molded Case Switch Cat. No.	Molded Case Switch Setting (Amps)	Contactors Cat. No.	3% Line Reactor Cat. No.	5% Line Reactor Cat. No.
E295	8	272	250	140G-M0F3-D60	600	420	4500	-	-	140G-M6S3-D80	800	100-D420ED11	1321-3RC400-C	RL-41508
E355	8	295	300	140G-M0F3-D60	600	420	4500	-	-	140G-M6S3-D80	800	100-D420ED11	1321-3RC400-C	RL-41508
E395	8	329	350	140G-M0F3-D60	600	420	4500	-	-	140G-M6S3-D80	800	100-D420ED11	1321-3RC400-C	RL-54004
E435	8	355	350	140G-M0F3-D60	600	420	4500	-	-	140G-M6S3-D80	800	100-D420ED11	1321-3RC400-C	RL-54004
E460	8	395	400	140G-M0F3-D60	600	510	4500	-	-	140G-M6S3-D80	800	100-D420ED11	1321-3R600-C	RL-4003B14
E510	8	425	450	140G-M0F3-D60	600	510	4500	-	-	140G-M6S3-D80	800	100-D630ED11	1321-3R600-C	RL-54503
E595	9	510	500	140G-NS0H3-E12	1200	600	6000	10800	-	-	-	-	-	-
E630	9	595	600	140G-NS0H3-E12	1200	720	6000	10800	-	-	-	-	-	-
E760	9	630	700	140G-NS0H3-E12	1200	750	6000	10800	-	-	-	-	-	-
E825	9	700	750	140G-NS0H3-E12	1200	840	6000	10800	-	-	-	-	-	-
E900	9	760	800	140G-NS0H3-E12	1200	900	6000	10800	-	-	-	-	-	-
E980	9	815	900	140G-NS0H3-E12	1200	960	6000	10800	-	-	-	-	-	-
E1K1 ⁽¹⁾	10	920	1000	-	-	-	-	-	-	-	-	-	-	-
E1K4 ⁽¹⁾	10	1190	1250	-	-	-	-	-	-	-	-	-	-	-

(1) Contact the factory.

Table 31 - 690V AC Input Drive, Heavy-Duty Ratings

Drive Cat. No.	Fame Size	Drive Rating (Amps)	Drive Power Rating (kW)	Circuit Breaker Cat. No.	Circuit Breaker Rating (Amps)	Circuit Breaker TM/ET Actual Current Setting (Amps) L	Circuit Breaker TM/ET Actual Current Setting (Amps) S	Circuit Breaker TM/ET Actual Current Setting (Amps) I	Circuit Breaker TM/ET Actual Current Setting (Amps) G	Molded Case Switch Cat. No.	Molded Case Switch Setting (Amps)	Contactor Cat. No.	3% Line Reactor Cat. No.	5% Line Reactor Cat. No.
F265	8	215	200	140G-M0F3-D60	600	420	4500	–	–	140G-M6S3-D80	800	100-D420EA11	RL-41508	RL-26503
F330	8	265	250	140G-M0F3-D60	600	420	4500	–	–	140G-M6S3-D80	800	100-D420EA11	RL-41508	RL-26503
F370	8	308	300	140G-M0F3-D60	600	420	4500	–	–	140G-M6S3-D80	800	100-D420EA11	1321-3RC400-C	RL-41508
F415	8	370	355	140G-M0F3-D60	600	510	4500	–	–	140G-M6S3-D80	800	100-D420EA11	1321-3RC400-C	RL-41508
F460	8	375	375	140G-M0F3-D60	600	510	4500	–	–	140G-M6S3-D80	800	100-D420EA11	1321-3RC400-C	RL-41508
F500	8	413	400	140G-M0F3-D60	600	510	4500	–	–	140G-M6S3-D80	800	100-D420EA11	1321-3RC400-C	RL-41508
F590	9	460	450	140G-NS0H3-E12	1200	540	6000	10800	–	–	–	–	–	–
F650	9	500	500	140G-NS0H3-E12	1200	600	6000	10800	–	–	–	–	–	–
F710	9	590	560	140G-NS0H3-E12	1200	690	6000	10800	–	–	–	–	–	–
F765	9	650	630	140G-NS0H3-E12	1200	780	6000	10800	–	–	–	–	–	–
F795	9	750	710	140G-NS0H3-E12	1200	900	6000	10800	–	–	–	–	–	–
F960	9	795	800	140G-NS0H3-E12	1200	930	6000	10800	–	–	–	–	–	–
F1K0 ⁽¹⁾	10	865	900	–	–	–	–	–	–	–	–	–	–	–
F1K4 ⁽¹⁾	10	1160	1120	–	–	–	–	–	–	–	–	–	–	–

(1) Contact the factory.

Notes:

History of Changes

This appendix summarizes the revisions to this manual. Reference this appendix if you need information to determine what changes have been made across multiple revisions. This may be especially useful if you are deciding to upgrade your hardware based on information added with previous revisions of this manual.

750-TG001F-EN-P, December 2017

Table 32 - 750-TG001F-EN-P, November 2017

Topic
Added cross-reference pages (hot links) to the preventive maintenance table for maintenance items.
Updated maintenance topic names to correlate with maintenance section names.
Removed Power Switching Components, Control Pod Components Enhancements, and Operational Conditions from the maintenance table.
Updated section Maintenance of Industrial Control Equipment to have the most current descriptions.
Added publication reference for Cabinet Blower Exhaust Removal/Installation.
Separated IP54 and IP20 maintenance tasks.
Updated CH.3 to include notes for result readings from the reverse base diode tests.
Updated images of the inverter front cover. Access panel has been removed; P6 connector no longer accessible.

750-TG001E-EN-P, July 2012

Table 33 - 750-TG001E-EN-P, July 2012

Topic
Updated the Spare Part Compatibility with Series A and Series B Drives table to include a new Series B Converter Unit part number.
Updated the Converter Components Identification table to reflect the addition of the stirring fan kit.
Updated the Converter Assembly Components Diagram 2 to reflect the addition of the stirring fan kit.
Added the new Converter Gate Board Stirring Fan Removal/Installation procedure.
Updated the 24V/240V Power Wire Harness Removal/Installation procedure to include disconnecting the stirring fan.
Updated the DC Input with Precharge Assembly Components Identification table to reflect the addition of the stirring fan kit.
Updated the DC Input with Precharge Assembly Components Diagram 2 to reflect the addition of the stirring fan kit.
Updated the 24V/120V/240V Wire Harness Removal/Installation procedure to include disconnecting the stirring fan.

Table 33 - 750-TG001E-EN-P, July 2012

Topic
Added the new DC Precharge Control Board Stirring Fan Removal/Installation procedure.
Updated the Converter Schematic Diagram (400VAC and 600VAC Classes AC Input Drive) to reflect the addition of the stirring fan.
Updated the DC Input with Precharge Assembly Schematic Diagram (540V DC, 650V DC, 810V DC, and 932V DC Classes Common DC Input Drives) to reflect the addition of the stirring fan.

750-TG001D-EN-P, April 2012

Table 34 - 750-TG001D-EN-P, April 2012

Topic
Added illustrations of Frame 10 drives to the "Drive Input Power Configurations" section.
Updated the "Drive Series Components Compatibility" section to include frame 10 drives.
Updated the "Maintenance of Industrial Control Equipment" table to include filters for the IP54 cabinet blower assembly.
Removed the Series A Converter EMC Filter Board from the "Converter Components Identification" table.
Removed the Series A Converter Current Sensor kit from the "Converter Components Identification" table.
Added the Three Bay 24V Wire Harness kit for frame 10 drives to the "Converter Components Identification" table.
Updated the "Control Power Isolator Board Removal/Installation (600/690V AC Input Drives Only)" procedures to include steps for frame 10 drives.
Added the Three Bay 24V Wire Harness kit for frame 10 drives to the "DC Input with Precharge Assembly Components Identification" table.
Updated the "Control Power Isolator Board Removal/Installation (810/932V DC Input Drives Only)" procedures to include steps for frame 10 drives.
Added the Cabinet L Bus Bar kit to the "AC Input Drive Enclosure Components Identification" table.
Added the Cabinet Door Shield Kit (Frame 10) kit to the "AC Input Drive Enclosure Components Identification" table.
Added the "Cabinet L Bus Bars Removal/Installation" AC input enclosure procedures.
Added the "Cabinet Door EMC Shield Removal/Installation (Frame 10 Drives Only)" AC input enclosure procedures.
Added the Circuit Breaker kit to the "Common DC Input Drive Enclosure Components Identification" table.
Added the lockout Attachment kit to the "Common DC Input Drive Enclosure Components Identification" table.
Updated the "Enclosure Cable Components and Part Numbers" table to include the 3-Bay 24V Wire Harness Kit.
Added the new Third Inverter (INV3) Fiber-optic Cable Removal/Installation procedure.
Added the "Frame 10 AC Input Drive Schematic Diagram (400VAC and 600VAC Classes)".
Added the "Frame 10 Common DC Input Drive Schematic Diagram (540V DC, 650V DC, 810V DC, and 932V DC Classes)".
Updated the "Frame 8 Control Power Isolator Board Wiring Diagrams (600V AC Class AC Input Drive, and 810V DC and 932V DC Classes Common DC Input Drive)" for frame 10 drives.
Corrected the terminal labels on "Inverter Main Blower and Capacitor Bank Cooling Fan Wire Harness Diagram".
Added the "Cabinet Cooling Wiring Diagrams".

750-TG001C-EN-P, January 2012

Table 35 - 750-TG001C-EN-P, January 2012

Topic
Updated the Converter Components Identification table to include the new kits for 600/690V AC input drives.
Updated the Converter Assembly Components Diagram 2 to include the new Control Power Isolation board.
Updated the Surge-suppressor Sense Wire Harness Removal/Installation procedure to reflect the addition of the new Control Power Isolation board and 24V wire harness for 600/690V AC input drives.
Updated the Surge Suppressor Removal/Installation procedure to reflect the addition of the new Control Power Isolation board and 24V wire harness for 600/690V AC input drives.
Updated the Surge Suppressor Assembly Removal/Installation procedure to reflect the addition of the new Control Power Isolation board and 24V wire harness for 600/690V AC input drives.
Added the new Control Power Isolator Board 24V Wire Harness Removal/Installation (600/690V AC Input Drives Only) procedure.
Added the new Control Power Isolator Board Removal/Installation (600/690V AC Input Drives Only) procedure.
Updated the DC Input with Precharge Assembly Components Identification table to include the new kits for 810/932V DC input drives.
Updated the DC Input with Precharge Assembly Components Diagram 2 to include the new Control Power Isolation board and 24V wire harness.
Added the new Control Power Isolator Board 24V Wire Harness Removal/Installation (810/932V DC Input Drives Only) procedure.
Added the new Control Power Isolator Board Removal/Installation (810/932V DC Input Drives Only) procedure.
Updated the Undervoltage Delay Bracket Removal/Installation procedure to reflect the addition of the new Control Power Isolation board.
Updated the Inverter Components Identification table to include the new kits for 600/690V AC input drives.
Updated the following schematic diagrams in Appendix A Schematics to reflect the addition of 600/690V AC input and 810/932V DC input drives: <ul style="list-style-type: none"> • Frame 8 AC Input Drive Schematic Diagram (400VAC and 600VAC Classes) • Frame 9 AC Input Drive Schematic Diagram (400VAC and 600VAC Classes) • Frame 8 Common DC Input Drive Schematic Diagram (540V DC, 650V DC, 810V DC, and 932V DC Classes) • Frame 9 Common DC Input Drive Schematic Diagram (540V DC, 650V DC, 810V DC, and 932V DC Classes) • Converter Schematic Diagram (400VAC and 600VAC Classes AC Input Drive) • DC Input with Precharge Assembly Schematic Diagram (540V DC, 650V DC, 810V DC, and 932V DC Classes Common DC Input Drives) • Inverter Circuit Board Schematic Diagram (All Drive Configurations) • Inverter Power Layer Schematic Diagram (All Drive Configurations)
Added the following new schematic diagram to Appendix A Schematics: <ul style="list-style-type: none"> • Frame 8 Control Power Isolator Board Wiring Diagrams (600V AC Class AC Input Drive, and 810V DC and 932V DC Classes Common DC Input Drive)
Added the new History of Changes appendix.

750-TG001B-EN-P, October 2011

Table 36 - 750-TG001B-EN-P, October 2011

Change
Updated the lockout/tagout procedure to include steps for common DC input drives.
Added the new "Drive Input Power Configurations" section to provide general information on identifying the main drive components for each available configuration.
Added the new "Drive Series Components Compatibility" section to provide important information about drive component compatibility based on the drive series designator.
Updated the list of "Commonly Used Tools" to include additional required tool sizes.

Table 36 - 750-TG001B-EN-P, October 2011 (continued)

Change
Updated the "Fastener/Tool/Torque Information" table to include the Pozidriv fastener and tool types.
Updated the "Component Inspection and Maintenance" procedure to include common DC input drives.
Added the "DC Precharge Assembly Fuse Tests" procedure.
Added the "Fiber-optic Cable Removal/Installation (Frame 8)" procedures to Chapter 4.
Added the new "DC Input with Precharge Assembly Component Replacement Procedures" chapter.
Updated the "Inverter Gate Board Connection Ribbon Cables Removal/Installation" procedure to reflect new ribbon cable variation.
Added the new "Inverter Top DC Bus Bar Removal/Installation (Common DC Input Drive Only)" to Chapter 7.
Updated the "IP20, NEMA/UL Type 1 Enclosure Door Fan Removal/Installation" procedure to include an additional required step.
Added the "DC Bus Fuse Wire Harness Removal/Installation (Frame 9 and Larger Drives Only)" procedure.
Added the "DC Bus Fuses and Fuse Indicators Removal/Installation (Frame 9 and Larger Drives Only)" procedure.
Added the "Input Common-mode Core Removal/Installation (Frame 9 and Larger, Common DC Input Drives Only)" procedure.
Added the new "Common DC Input Drive Enclosure Component Replacement Procedures" chapter.
Added the new "Enclosure Cable Components Replacement Procedures (Frame 9 and Larger Drives)" chapter.
Updated the "Before Applying Power to the Drive" procedure to include steps for common DC input drives.
Added the following new schematic diagrams to Appendix A Schematics: <ul style="list-style-type: none"> • Frame 8 AC Input Drive Schematic Diagram (400VAC and 600VAC Classes) • Frame 9 AC Input Drive Schematic Diagram (400VAC and 600VAC Classes) • Frame 8 Common DC Input Drive Schematic Diagram (540V DC, 650V DC, 810V DC, and 932V DC Classes) • Frame 9 Common DC Input Drive Schematic Diagram (540V DC, 650V DC, 810V DC, and 932V DC Classes) • DC Input with Precharge Assembly Schematic Diagram (540V DC, 650V DC, 810V DC, and 932V DC Classes Common DC Input Drives) • DC Input with Precharge Devices Schematic Diagrams • DC Input with Precharge Assembly Control Transformer Schematic Diagram • Updated the following schematic diagrams in Appendix A Schematics: <ul style="list-style-type: none"> • Control Pod Schematic Diagram • Converter Schematic Diagram (400VAC and 600VAC Classes AC Input Drive) • Inverter Circuit Board Schematic Diagram (All Drive Configurations) • Inverter Power Layer Schematic Diagram (All Drive Configurations)

Numerics

- 120/240V circuit breaker (DC input drive)**
 - install 340
 - remove 341
- 120/240V control power input wire harness (DC input drive)**
 - install 338
 - remove 339
- 120/240V control power output wire harness (DC input drive)**
 - install 339
 - remove 340
- 120V UPS power input wire harness (DC input drive)**
 - install 342
 - remove 343
- 24V control wire harness (DC input drives)**
 - install 189
 - remove 187
- 24V wire harness (frame 9 and larger drives)**
 - install 402
 - remove 398
- 24V/120V/240V wire harness (DC input drives)**
 - install 200
 - remove 195
- 24V/240V power wire harness**
 - install 137
 - remove 132

A

- AC line fuse sense wire harness**
 - install 98
 - remove 97
- AC line fuses**
 - install 101
 - remove 99
- AC line wire harness**
 - install 124
 - remove 123

B

- backplane circuit board (inverter)**
 - install 267
 - remove 265
- blower assembly 307**
- board interconnections**
 - inverter 446
- bottom conduit plate (option bay)**
 - install 395
 - remove 395

C

- cabinet blower assembly (frame 9 option bay)**
 - install 374
 - remove 374
- cabinet blower exhaust filter**
 - install 312
 - remove 312
- cabinet blower relay (frame 9 option bay)**
 - install 391
 - remove 391
- cabinet blower wire harness (AC input enclosure)**
 - install 311
 - remove 310
- cabinet blower wire harness (frame 9 option bay)**
 - install 376
 - remove 375
- cabinet door EMC shield**
 - install 329
 - remove 327
- cabinet door filter cassette**
 - install 316
 - remove 316
- cabinet door gasket**
 - install 317
 - remove 317
- cabinet L bus bars**
 - install 327
 - remove 326
- cable components**
 - part numbers 397
- capacitor balance resistors**
 - install 249
 - remove 248
- capacitor bank assembly (inverter)**
 - install 248
 - remove 246
- catalog numbers**
 - control pod components 57
 - converter components 82
 - DC input with precharge assembly components 158
 - inverter components 228
- circuit boards**
 - series A and B 31
- circuit breaker disconnect handle panel (frame 8 option bay)**
 - install 350
 - remove 348
- common mode core assembly (inverter)**
 - install 233
 - remove 233
- compatibility**
 - firmware versions and components 31
- contactor wire harness (frame 8 option bay)**
 - install 372
 - remove 371
- control board interconnections 448**

control panel thermostat wire harness (frame 9 option bay)

install 393
remove 392

control pod

install 59, 72
remove 59, 68
return to service position 91
rotate 88

control pod cables

install 60
remove 60

control pod components

catalog numbers 57
part numbers 57

control power isolator board (converter)

install 149
remove 148

control power isolator board (DC input with precharge)

install 209
remove 208

control power isolator board 24V wire harness (converter)

install 147
remove 146

control power isolator board 24V wire harness (DC input with precharge)

install 208
remove 207

control transformer (converter)

install 142
remove 140

control transformer (DC input drives)

install 207
remove 204

control transformer (frame 8 option bay)

install 366
remove 364

control transformer (frame 9 option bay)

install 381
remove 380

control transformer fuses (option bay)

install 361
remove 361

control transformer primary fuses (converter)

install 91
remove 91

control transformer primary wire harness (converter)

install 140
remove 138

control transformer secondary fuse (converter)

install 92
remove 92

control transformer secondary fuses (DC input drives)

install 172, 173

control transformer wire harness (frame 8 option bay)

install 370
remove 366

converter

install 155
remove 152

converter components

catalog numbers 82
part numbers 82

converter fuse

tests 53

current sensor wire harness (converter)

install 104
remove 103

current sensor wire harness (inverter)

install 245
remove 243

current sensors (converter)

install 109
remove 105

current sensors (inverter)

install 242
remove 240

D**DC back bus guards**

install 337
remove 336

DC bus fuse wire harness

install 145, 319
remove 144, 318

DC bus fuses and fuse indicators

install 322
remove 320

DC bus input wire harness (DC input drives)

install 184
remove 183

DC bus out/sense wire harness (DC input drives)

install 177
remove 174

DC bus sense wire harness (converter)

install 103
remove 101

DC choke (AC input drive)

install 287
remove 285

DC input with precharge assembly

install 225
remove 222

DC input with precharge assembly components

catalog numbers 158
part numbers 158

DC input with precharge assembly fuse

tests 55

DC line fuses

install 181
remove 180

DC precharge control circuit board

install 221
remove 220

debris screen (drive bay)
 install 303
 remove 303

digital I/O wire harness (DC input drives)
 install 219
 remove 218

discharge resistor assembly
 install 297
 remove 291

disconnect switch handle (DC input drive)
 install 203
 remove 203

disconnect switch jumper wires
 install 202
 remove 201

disconnect switch, auxiliary contact and handle shaft
 install 203
 remove 202

door interlock wire harness
 install 218
 remove 216

drive
 remove power 25

drive enclosure (AC input) components
 part numbers 302

drive enclosure (common DC input) components
 part numbers 332

drive input power configurations 28

drive series compatibility 30

drive start-up test without a motor (no load)
 421

duct gasket (converter)
 install 156
 remove 155

duct gasket (DC input with precharge assembly)
 install 225
 remove 225

E

EMC capacitors (AC input drive)
 install 271
 remove 268

EMC filter circuit board (converter)
 install 94
 remove 93

enclosure door fan (AC input drive)
 install 308
 remove 306, 307

enclosure door fan (DC input drive)
 install 334
 remove 333

enclosure door fan wire harness (AC input drive)
 install 309, 310

enclosure door fan wire harness (DC input drive)
 install 336

remove 334

exhaust hood 307

exhaust hood (drive bay)
 install 304
 remove 304

F

fastener types 33

fiber interface board
 install 79
 remove 73

fiber-optic cable (frame 8)
 install 64
 remove 61

fiber-optic spool
 install 418
 remove 416

filter (IP20 door, AC input drive)
 install 313
 remove 313

firmware versions and components
 compatibility 31

first inverter (INV1) fiber-optic cable
 install 406
 remove 403

front cover (inverter)
 install 240
 remove 239

G

gate board connection ribbon cables (inverter)
 install 253
 remove 251

gate circuit board (converter)
 install 151
 remove 149

gate circuit board (inverter)
 install 254
 remove 253

gate leads
 resistance measurements 53

H

heat sink gasket (converter)
 install 121
 remove 120

heatsink fan
 inspection 48

heatsink fan assembly
 install 237
 remove 236

heatsink fan inlet bottom cover (inverter)
 install 298
 remove 298

heatsink fan inlet screen
 inspection 48
 install 235
 remove 235

I

IGBT flex bus bars

install 251
remove 250

input common mode core (common DC input drives)

install 344
remove 343

input common mode core (frame 9 and larger drives)

install 325
remove 323

inspect

components 48

install

120/240V circuit breaker (DC input drive) 340
120/240V control power input wire harness (DC input drive) 338
120/240V control power output wire harness (DC input drive) 339
120V UPS power input wire harness (DC input drive) 342
24V control wire harness (DC input drives) 189
24V wire harness (frame 9 and larger drives) 402
24V/120V/240V wire harness (DC input drives) 200
24V/240V power wire harness 137
AC line fuse sense wire harness 98
AC line fuses 101
AC line wire harness 124
backplane circuit board (inverter) 267
bottom conduit plate (option bay) 395
cabinet blower assembly (frame 9 option bay) 374
cabinet blower exhaust filter 312
cabinet blower relay (frame 9 option bay) 391
cabinet blower wire harness (AC input enclosure) 311
cabinet blower wire harness (frame 9 option bay) 376
cabinet door EMC shield 329
cabinet door filter cassette 316
cabinet door gasket 317
cabinet L bus bars 327
capacitor balance resistors 249
capacitor bank assembly (inverter) 248
circuit breaker disconnect handle panel (frame 8 option bay) 350
common mode core assembly (inverter) 233
contactor wire harness (frame 8 option bay) 372
control panel thermostat wire harness (frame 9 option bay) 393
control pod 59, 72
control pod cables 60
control power isolator board (converter) 149
control power isolator board (DC input with precharge) 209
control power isolator board 24V wire harness (converter) 147
control power isolator board 24V wire harness (DC input with precharge) 208
control transformer (converter) 142

control transformer (DC input drives) 207
control transformer (frame 8 option bay) 366
control transformer (frame 9 option bay) 381
control transformer fuses (option bay) 361
control transformer primary fuses (converter) 91
control transformer primary wire harness (converter) 140
control transformer secondary fuse (converter) 92
control transformer secondary fuses (DC input drives) 172, 173
control transformer wire harness (frame 8 option bay) 370
converter 155
current sensor wire harness (converter) 104
current sensor wire harness (inverter) 245
current sensors (converter) 109
current sensors (inverter) 242
DC back bus guards 337
DC bus fuse wire harness 145, 319
DC bus fuses and fuse indicators 322
DC bus input wire harness (DC input drives) 184
DC bus out/sense wire harness (DC input drives) 177
DC bus sense wire harness (converter) 103
DC choke (AC input drive) 287
DC input with precharge assembly 225
DC line fuses 181
DC precharge control circuit board 221
debris screen (drive bay) 303
digital I/O wire harness (DC input drives) 219
discharge resistor assembly 297
disconnect switch handle (DC input precharge) 203
disconnect switch jumper wires 202
disconnect switch, auxiliary contact and handle shaft 203
door interlock wire harness 218
duct gasket (converter) 156
duct gasket (DC input with precharge assembly) 225
EMC capacitors (AC input drive) 271
EMC filter circuit board (converter) 94
enclosure door fan (AC input drive) 308
enclosure door fan (DC input drive) 334
enclosure door fan wire harness (AC input drive) 309, 310
enclosure door fan wire harness (DC input drive) 336
exhaust hood (drive bay) 304
fiber interface board 79
fiber-optic cable (frame 8) 64
fiber-optic spool 418
filter (IP20 door, AC input drive) 313
first inverter (INV1) fiber-optic cable 406
front cover (inverter) 240
gate board connection ribbon cables (inverter) 253
gate circuit board (converter) 151
gate circuit board (inverter) 254
heat sink gasket (converter) 121
heatsink fan assembly 237
heatsink fan inlet bottom cover (inverter) 298
heatsink fan inlet screen 235

IGBT flex bus bars 251
 input common mode core (common DC input drives) 344
 input common mode core (frame 9 and larger drives) 325
 internal stirring fan tray (inverter) 234
 IP20 door fan (frame 8 option bay) 352
 IP20 door fan wire harness (frame 8 option bay) 354
 IP20 door filter (AC input drive) 313
 IP54 cabinet blower assembly (frame 8 option bay) 362
 IP54 cabinet blower wire harness (frame 8 option bay) 364
 IP54 cabinet exhaust blower filter (option bay) 355
 left cover (converter) 87
 left cover (DC input drives) 163
 left wall (DC input drives) 185
 main control board 68
 main control panel wire harness (frame 9 option bay) 385
 molded case switch control wire harness (DC input drives) 192
 molded case switch wire terminal support (DC input drives) 186
 no DC bus fuse wire harness 143
 option bay guard (frame 8) 356
 option bay guards - series B (frame 9) 358
 option bay guards - series C (frame 9) 360
 power control circuit board 264
 power layer interface circuit board 258
 power supply circuit board 261
 power supply wire harness (inverter) 122
 precharge circuit fuses (DC input drives) 182
 precharge resistor assembly (DC input drives) 179
 precharge resistor jumper wires (DC input drives) 179
 rating plug 256
 reactor fan tray (frame 9 option bay) 387
 reactor fan tray wire harness (frame 9 option bay) 391
 right cover, no control pod (converter) 88
 right cover, no control pod (DC input drives) 172
 SCR assembly (converter) 120
 SCR gate wire harness (converter) 110
 second inverter (INV2) fiber-optic cable 411
 side DC bus bars (inverter - AC input drive) 279
 stirring fan (converter) 132
 stirring fan (DC input with precharge assembly) 216
 surge suppressor 127
 surge suppressor assembly 130
 surge suppressor sense wire harness 125
 thermostat and wire harness (frame 8 option bay) 373
 thermostat and wire harness (frame 9 option bay) 379
 third inverter (INV3) fiber-optic cable 416
 top conduit plate (drive bay) 305
 top DC bus bars (inverter - DC input drive) 284
 transformer primary wire harness (DC input drives) 193
 undervoltage delay 215

undervoltage delay bracket 212
 undervoltage delay wire harness 213
 wire harness (inverter) 290

interconnections

control board 448

internal stirring fan tray (inverter)

install 234
remove 234

inverter board interconnections 446

inverter components

catalog numbers 228
part numbers 228

IP20 door fan (frame 8 option bay)

install 352
remove 351

IP20 door fan wire harness (frame 8 option bay)

install 354
remove 353

IP20 door filter (AC input drive)

install 313
remove 313

IP54 cabinet blower assembly (frame 8 option bay)

install 362
remove 362

IP54 cabinet blower wire harness (frame 8 option bay)

install 364
remove 363

IP54 cabinet exhaust blower filter (option bay)

install 355
remove 355

IP54, NEMA 12 Cabinet

blower assembly 307
exhaust hood 307

L

left cover (converter)

install 87
remove 87

left cover (DC input drives)

install 163
remove 163
replace 164

left wall (DC input drives)

install 185
remove 184

M**main control board**

install 68
remove 65

main control panel wire harness (frame 9 option bay)

install 385
remove 381

maintenance

schedule 43, 45
tasks 43, 45

molded case switch control wire harness (DC input drives)

install 192
remove 190

molded case switch wire terminal support (DC input drives)

install 186
remove 186

N**no DC bus fuse wire harness**

install 143
remove 143

O**option bay enclosure components**

part numbers 346

option bay guard (frame 8)

install 356
remove 356

option bay guards - series B (frame 9)

install 358
remove 357

option bay guards - series C (frame 9)

install 360
remove 359

P**part numbers**

cable components 397
control pod components 57
converter components 82
DC input with precharge assembly components 158
drive enclosure (AC input) components 302
drive enclosure (common DC input) components 332
inverter components 228
option bay enclosure components 346

power control circuit board

install 264
remove 262

power layer interface circuit board

install 258
remove 256

power supply circuit board

install 261

remove 258

power supply wire harness (inverter)

install 122
remove 121

precautions 24**precharge circuit fuses (DC input drives)**

install 182
remove 182

precharge resistor assembly (DC input drives)

install 179
remove 178

precharge resistor jumper wires (DC input drives)

install 179
remove 179

R**rating plug**

install 256
remove 255

reactor fan tray (frame 9 option bay)

install 387
remove 386

reactor fan tray wire harness (frame 9 option bay)

install 391
remove 389

remove

120/240V circuit breaker (DC input drive) 341
120/240V control power input wire harness (DC input drive) 339
120/240V control power output wire harness (DC input drive) 340
120V UPS power input wire harness (DC input drive) 343
24V control wire harness (DC input drives) 187
24V wire harness (frame 9 and larger drives) 398
24V/120V/240V wire harness (DC input drives) 195
24V/240V power wire harness 132
AC line fuse sense wire harness 97
AC line fuses 99
AC line wire harness 123
backplane circuit board (inverter) 265
bottom conduit plate (option bay) 395
cabinet blower assembly (frame 9 option bay) 374
cabinet blower exhaust filter 312
cabinet blower relay (frame 9 option bay) 391
cabinet blower wire harness (AC input enclosure) 310
cabinet blower wire harness (frame 9 option bay) 375
cabinet door EMC shield 327
cabinet door filter cassette 316
cabinet door gasket 317
cabinet L bus bars 326
capacitor balance resistors 248
capacitor bank assembly (inverter) 246
circuit breaker disconnect handle panel (frame 8 option bay) 348
common mode core assembly (inverter) 233

- contactor wire harness (frame 8 option bay) 371
- control panel thermostat wire harness (frame 9 option bay) 392
- control pod 59, 68
- control pod cables 60
- control power isolator board (converter) 148
- control power isolator board (DC input with precharge) 208
- control power isolator board 24V wire harness (converter) 146
- control power isolator board 24V wire harness (DC input with precharge) 207
- control transformer (converter) 140
- control transformer (DC input drives) 204
- control transformer (frame 8 option bay) 364
- control transformer (frame 9 option bay) 380
- control transformer fuses (option bay) 361
- control transformer primary fuses (converter) 91
- control transformer primary wire harness (converter) 138
- control transformer secondary fuse (converter) 92
- control transformer wire harness (frame 8 option bay) 366
- converter 152
- current sensor wire harness (converter) 103
- current sensor wire harness (inverter) 243
- current sensors (converter) 105
- current sensors (inverter) 240
- DC back bus guards 336
- DC bus fuse wire harness 144, 318
- DC bus fuses and fuse indicators 320
- DC bus input wire harness (DC input drives) 183
- DC bus out/sense wire harness (DC input drives) 174
- DC bus sense wire harness (converter) 101
- DC choke (AC input drive) 285
- DC input with precharge assembly 222
- DC line fuses 180
- DC precharge control circuit board 220
- debris screen (drive bay) 303
- digital I/O wire harness (DC input drives) 218
- discharge resistor assembly 291
- disconnect switch handle (DC input drive) 203
- disconnect switch jumper wires 201
- disconnect switch, auxiliary contact and handle shaft 202
- door interlock wire harness 216
- duct gasket (converter) 155
- duct gasket (DC input with precharge assembly) 225
- EMC capacitors (AC input drive) 268
- EMC filter circuit board (converter) 93
- enclosure door fan (AC input drive) 306, 307
- enclosure door fan (DC input drive) 333
- enclosure door fan wire harness (DC input drive) 334
- exhaust hood (drive bay) 304
- fiber interface board 73
- fiber-optic cable (frame 8) 61
- fiber-optic spool 416
- filter (IP20 door, AC input drive) 313
- first inverter (INV1) fiber-optic cable 403
- front cover (inverter) 239
- gate board connection ribbon cables (inverter) 251
- gate circuit board (converter) 149
- gate circuit board (inverter) 253
- heat sink gasket (converter) 120
- heatsink fan assembly 236
- heatsink fan inlet bottom cover (inverter) 298
- heatsink fan inlet screen 235
- IGBT flex bus bars 250
- input common mode core (common DC input drives) 343
- input common mode core (frame 9 and larger drives) 323
- internal stirring fan tray (inverter) 234
- IP20 door fan (frame 8 option bay) 351
- IP20 door fan wire harness (frame 8 option bay) 353
- IP20 door filter (AC input drive) 313
- IP54 cabinet blower assembly (frame 8 option bay) 362
- IP54 cabinet blower wire harness (frame 8 option bay) 363
- IP54 cabinet exhaust blower filter (option bay) 355
- left cover (converter) 87
- left cover (DC input drives) 163
- left wall (DC input drives) 184
- main control board 65
- main control panel wire harness (frame 9 option bay) 381
- molded case switch control wire harness (DC input drives) 190
- molded case switch wire terminal support (DC input drives) 186
- no DC bus fuse wire harness 143
- option bay guard (frame 8) 356
- option bay guards - series B (frame 9) 357
- option bay guards - series C (frame 9) 359
- power control circuit board 262
- power layer interface circuit board 256
- power supply circuit board 258
- power supply wire harness (inverter) 121
- precharge circuit fuses (DC input drives) 182
- precharge resistor assembly (DC input drives) 178
- precharge resistor jumper wires (DC input drives) 179
- rating plug 255
- reactor fan tray (frame 9 option bay) 386
- reactor fan tray wire harness (frame 9 option bay) 389
- right cover, no control pod (converter) 88
- right cover, no control pod (DC input drives) 172
- SCR assembly (converter) 111
- SCR gate wire harness (converter) 109
- second inverter (INV2) fiber-optic cable 407
- side DC bus bars (inverter - AC input drive) 272
- stirring fan (converter) 131
- stirring fan (DC input with precharge assembly) 215
- surge suppressor 126
- surge suppressor assembly 127
- surge suppressor sense wire harness 125

- thermostat and wire harness (frame 8 option bay) 372
- thermostat and wire harness (frame 9 option bay) 378
- third inverter (INV3) fiber-optic cable 412
- top conduit plate (drive bay) 305
- top DC bus bars (inverter - DC input drive) 280
- transformer primary wire harness (DC input drives) 194
- undervoltage delay 214
- undervoltage delay bracket 210
- undervoltage delay wire harness 213
- wire harness (inverter) 287
- remove power**
 - drive 25
- replace**
 - left cover (DC input drives) 164
- resistance measurements**
 - gate leads 53
- return to service position**
 - control pod 91
- right cover, no control pod (converter)**
 - install 88
 - remove 88
- right cover, no control pod (DC input drives)**
 - install 172
 - remove 172
- rotate**
 - control pod 88

S

- schematic**
 - control pod 434
 - control power isolator board wiring (600V AC/810V DC classes) 436, 437
 - control transformer (AC input drive) 442
 - control transformer (DC input drive) 442
 - converter 435
 - DC input with precharge 438
 - DC input with precharge devices 439
 - frame 10 AC input drive (400/600V class) 426
 - frame 10 DC input drive (540V, 650V, 810V and 932V classes) 429
 - frame 8 AC input drive (400/600V class) 424
 - frame 8 AC input IP20 option bay with a control transformer 431
 - frame 8 AC input IP20 option bay without a control transformer 430
 - frame 8 AC input IP54 option bay 432
 - frame 8 DC input drive (540V, 650V, 810V, and 932V classes) 427
 - frame 9 AC input drive (400/600V class) 425
 - frame 9 AC input option bay 433
 - frame 9 DC input drive (540V, 650V, 810V, and 932V classes) 428
 - inverter circuit board (400V class) 440
 - inverter power layer 441
- SCR assembly (converter)**
 - install 120
 - remove 111
- SCR gate wire harness (converter)**
 - install 110
 - remove 109

- SCR/diode tests** 49
- second inverter (INV2) fiber-optic cable**
 - install 411
 - remove 407
- series A and B circuit boards** 31
- series specific components** 30
- service tools** 32
- side DC bus bars (inverter - AC input drive)**
 - install 279
 - remove 272
- software tools** 32
- stirring fan (converter)**
 - install 132
 - remove 131
- stirring fan (DC input with precharge assembly)**
 - install 216
 - remove 215
- surge suppressor**
 - install 127
 - remove 126
- surge suppressor assembly**
 - install 130
 - remove 127
- surge suppressor sense wire harness**
 - install 125
 - remove 125

T

- test**
 - converter fuses 53
 - converter SCRs/diodes 51
 - DC input with precharge assembly fuses 55
 - inverter IGBTs 52
 - no motor (no load) 421
- thermostat and wire harness (frame 8 option bay)**
 - install 373
 - remove 372
- thermostat and wire harness (frame 9 option bay)**
 - install 379
 - remove 378
- third inverter (INV3) fiber-optic cable**
 - install 416
 - remove 412
- tool type and size** 33
- top conduit plate (drive bay)**
 - install 305
 - remove 305
- top DC bus bars (inverter - DC input drive)**
 - install 284
 - remove 280
- transformer primary wire harness (DC input drives)**
 - install 193
 - remove 194

U

undervoltage delay

install 215
remove 214

undervoltage delay bracket

install 212
remove 210

undervoltage delay wire harness

install 213
remove 213

W

wire harness (inverter)

install 290
remove 287

Notes:

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