



**HOW TO BUILD  
TECHNO MODULE**

**MODULAR**  
**ELSTEEL**  
**ENCLOSURES**

Lets take you through how to efficiently build a  
Techno Module panel board!

We've kept it easy and stuck with the basics and a few tips and tricks, as well  
as a selection of Cu connections with the major circuit breaker brands.

These are only the basic steps. For more detailed guidance, please set up a  
training session with your supplier of Techno Module.

Its important that you get in depth training since the end product  
you deliver will be your responsibility and this is only meant as a guide.  
We also recommend that you check out the Constructors Manual online at  
[www.elsteel.com](http://www.elsteel.com)

We've already attached the screws and brackets in as many parts as possible  
to its easy for you to unpack and assemble.

If you keep all the parts and your tools ready at hand before you start,  
it'll be quick and easy!

Have fun!



You're holding a top of the line  
quality product in your hands.  
Made with love and excellence!  
I hope you will enjoy assembling and  
using Elsteel products as much as  
I enjoy manufacturing it for you.

A handwritten signature in black ink, appearing to be 'Fang Logstrup'.

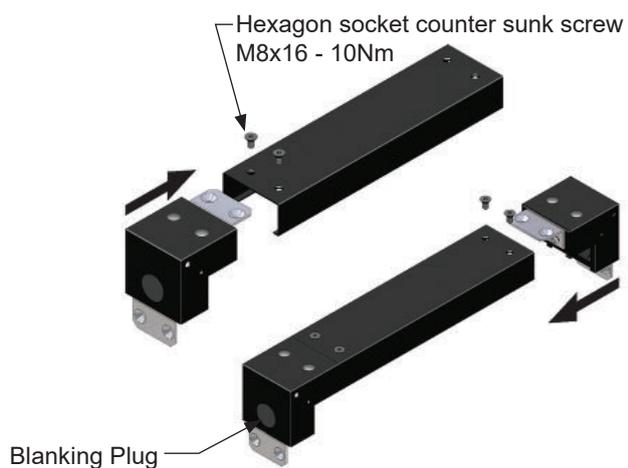
**Fang Logstrup**  
Managing Director

## CONTENTS

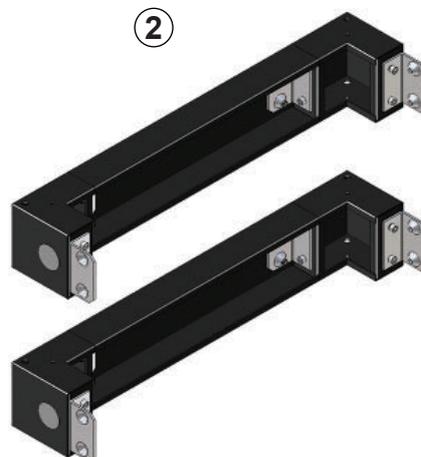
## PAGES

1. How to build basic Techno Module / Techno Module Light frame	03 - 18
2. How to transport and install the Techno Module panel	19 - 22
3. How to build the main busbar system	23 - 34
4. How to build the main busbar system in 'L' shape panel	35 - 42
5. How to assemble Interlock mechanism of the Plug & Power Reloaded fully withdrawable unit	43 - 48
6. How to build Techno Module Light Panel	49 - 52
7. How to build Arc Fault Containment Panel	53 - 54

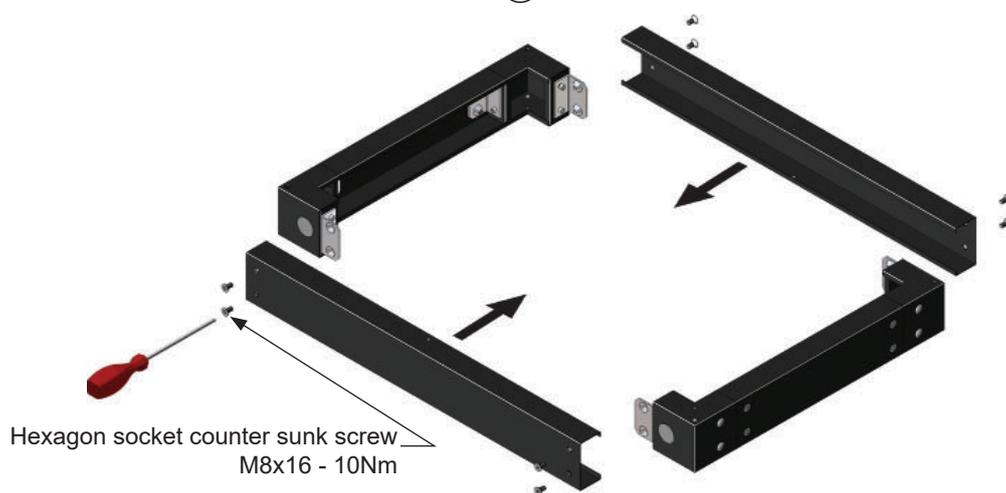
①



②

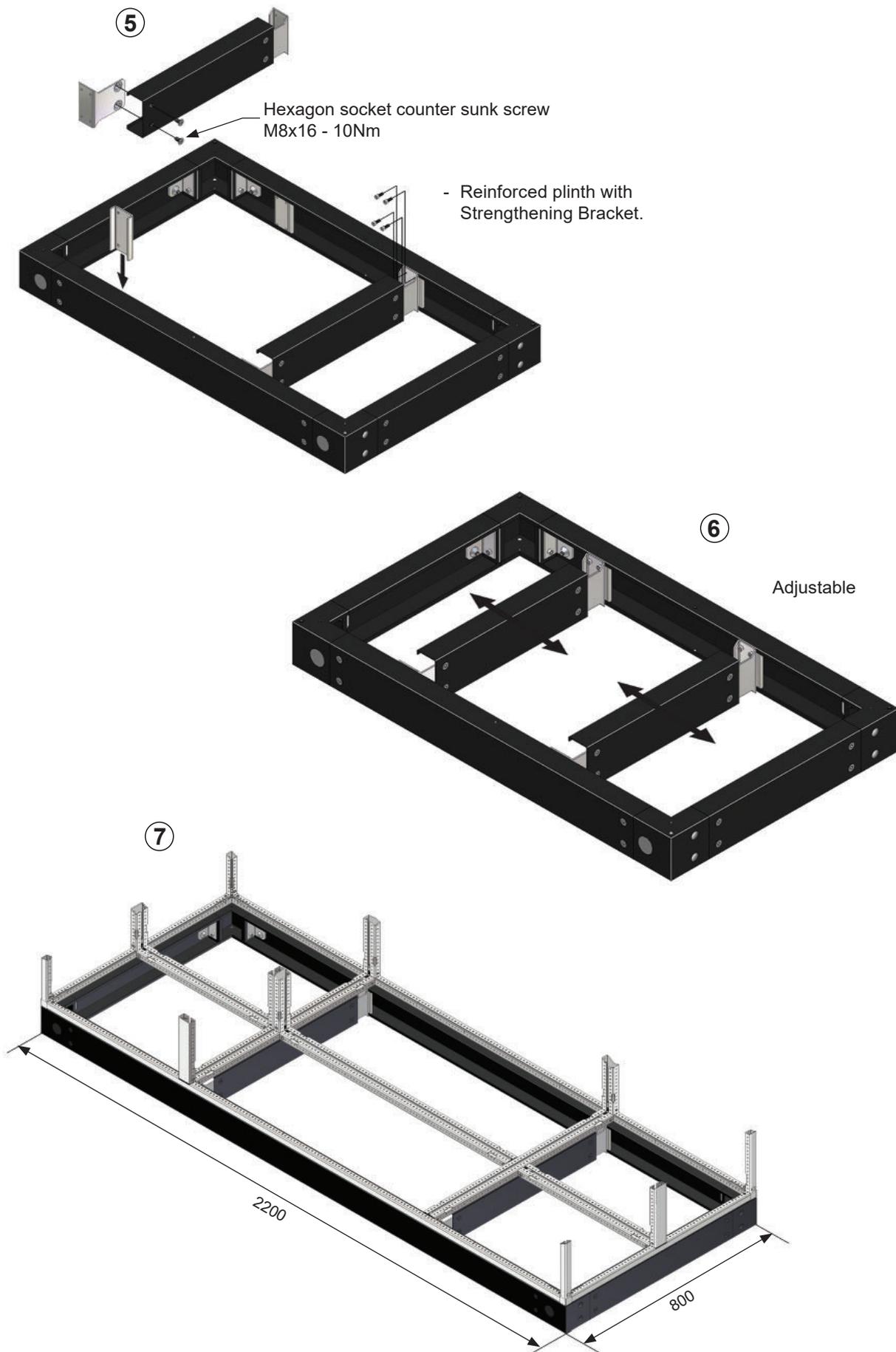


③



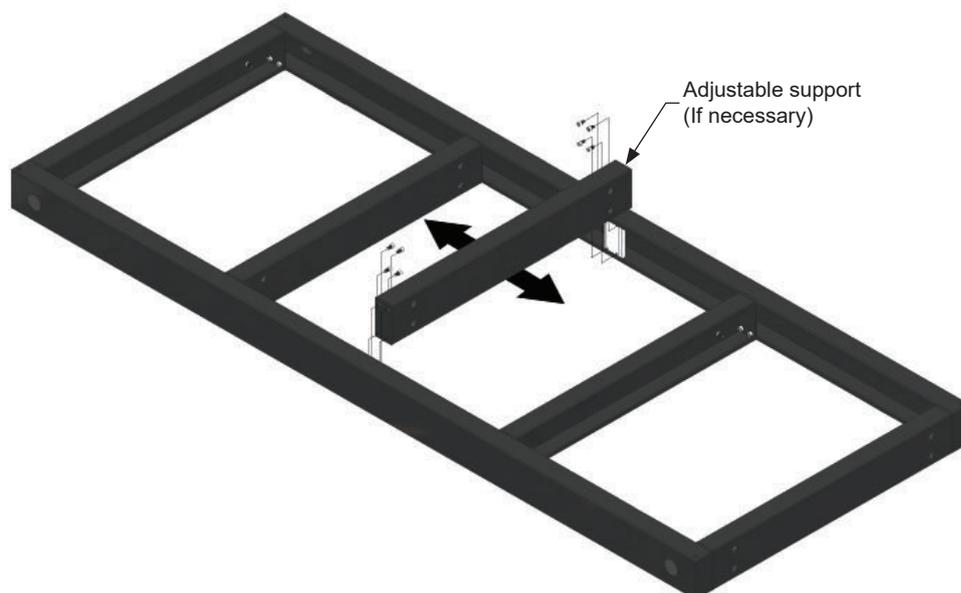
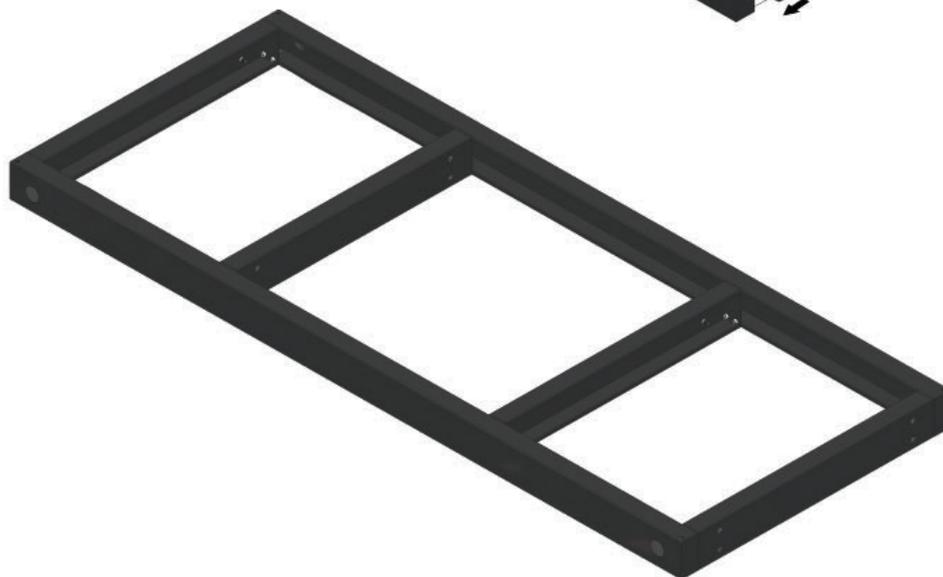
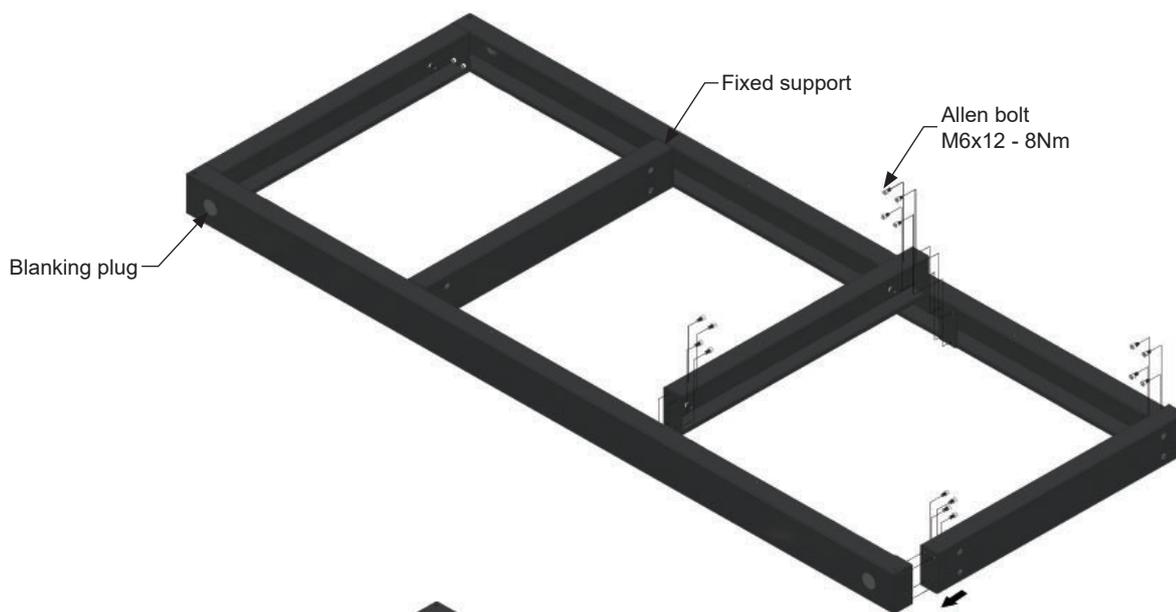
④

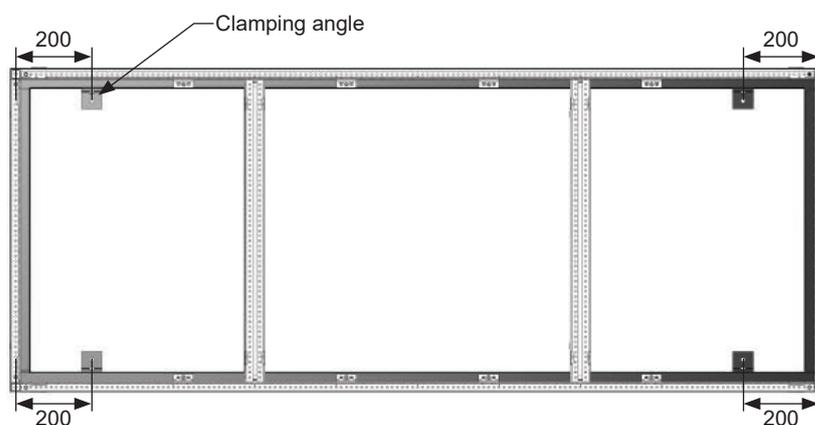
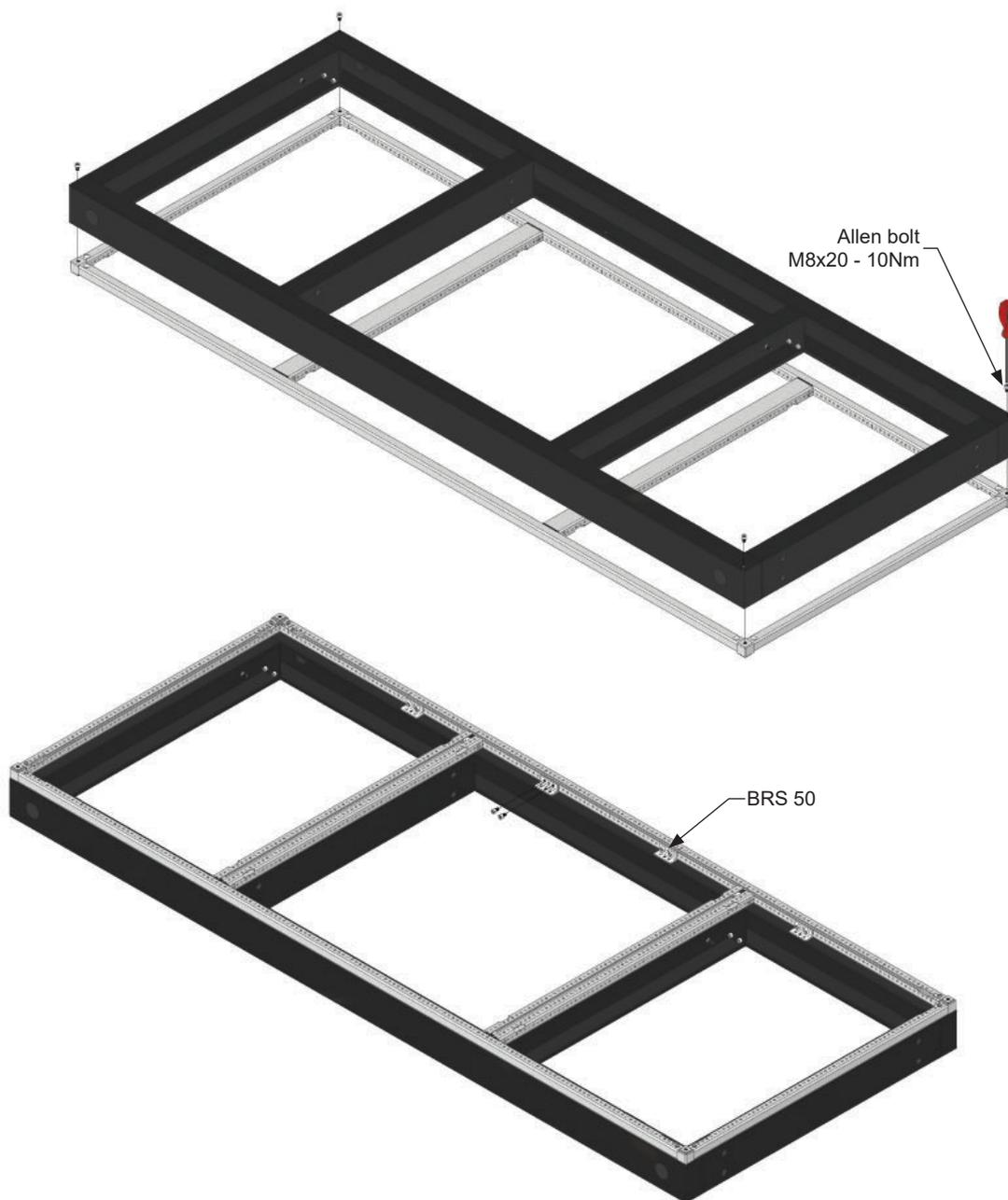




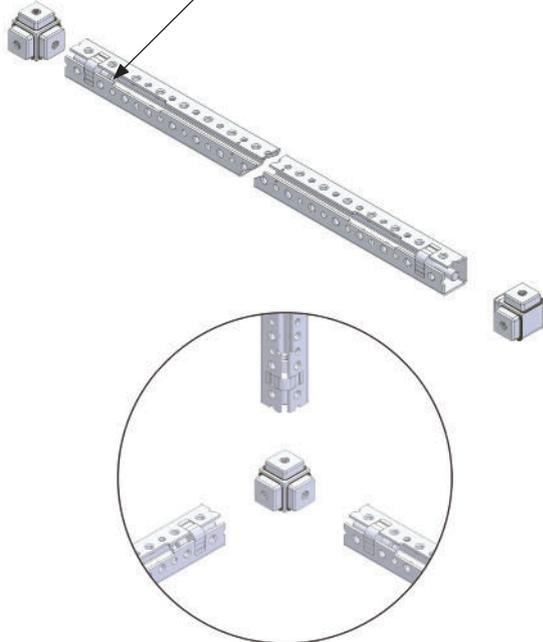
Note : Please refer page no.19 for Floor Mounting.

### HEAVY DUTY PLINTH

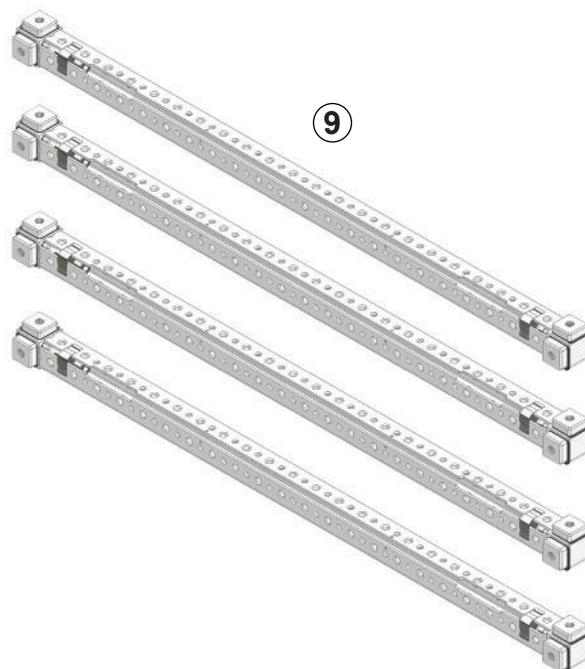




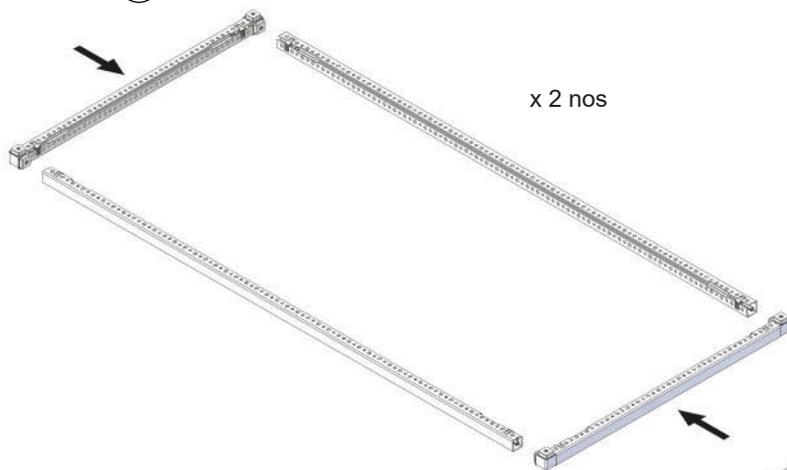
8 Allen bolt M8x25 - 10Nm



9



10



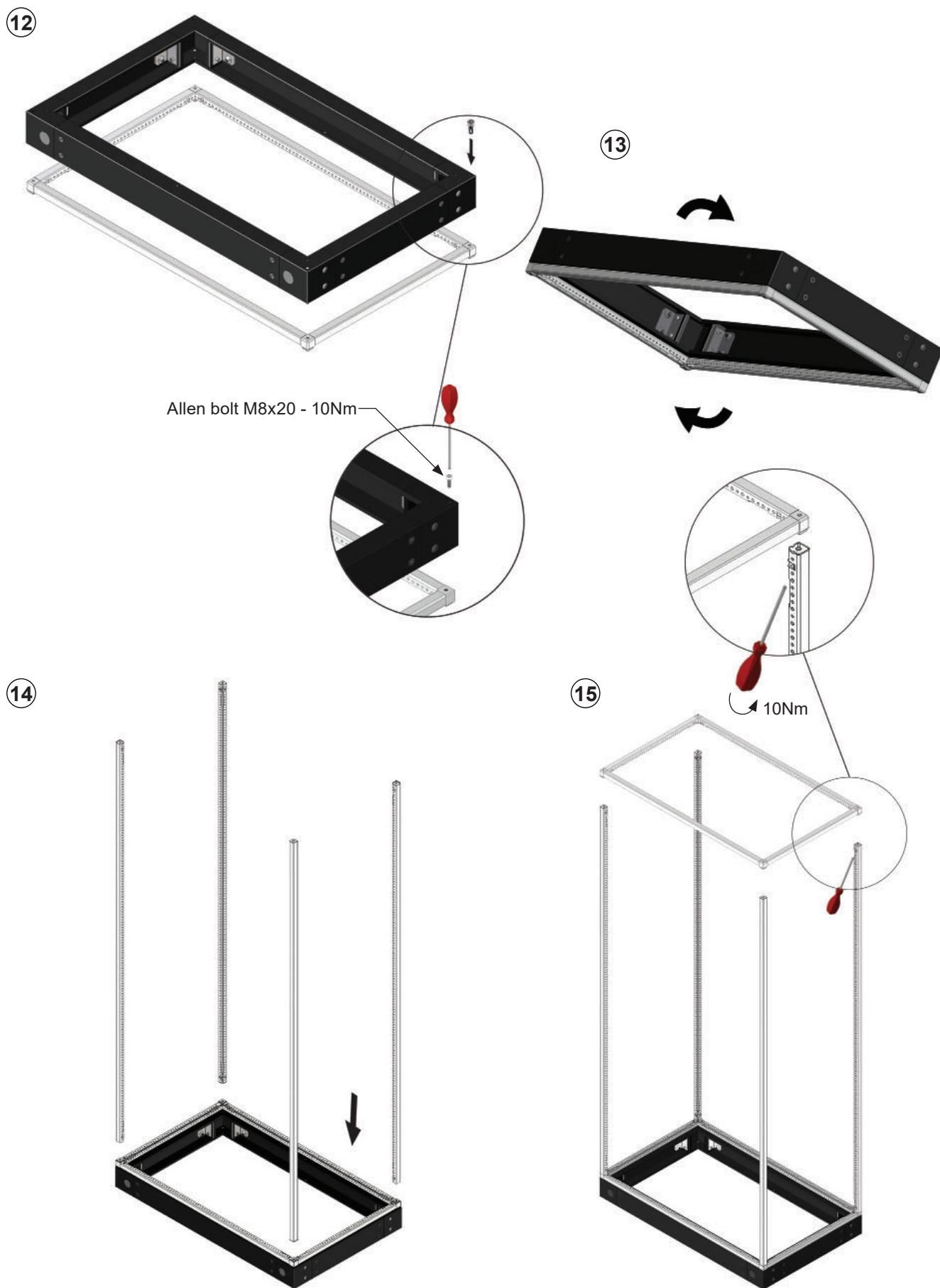
x 2 nos

11



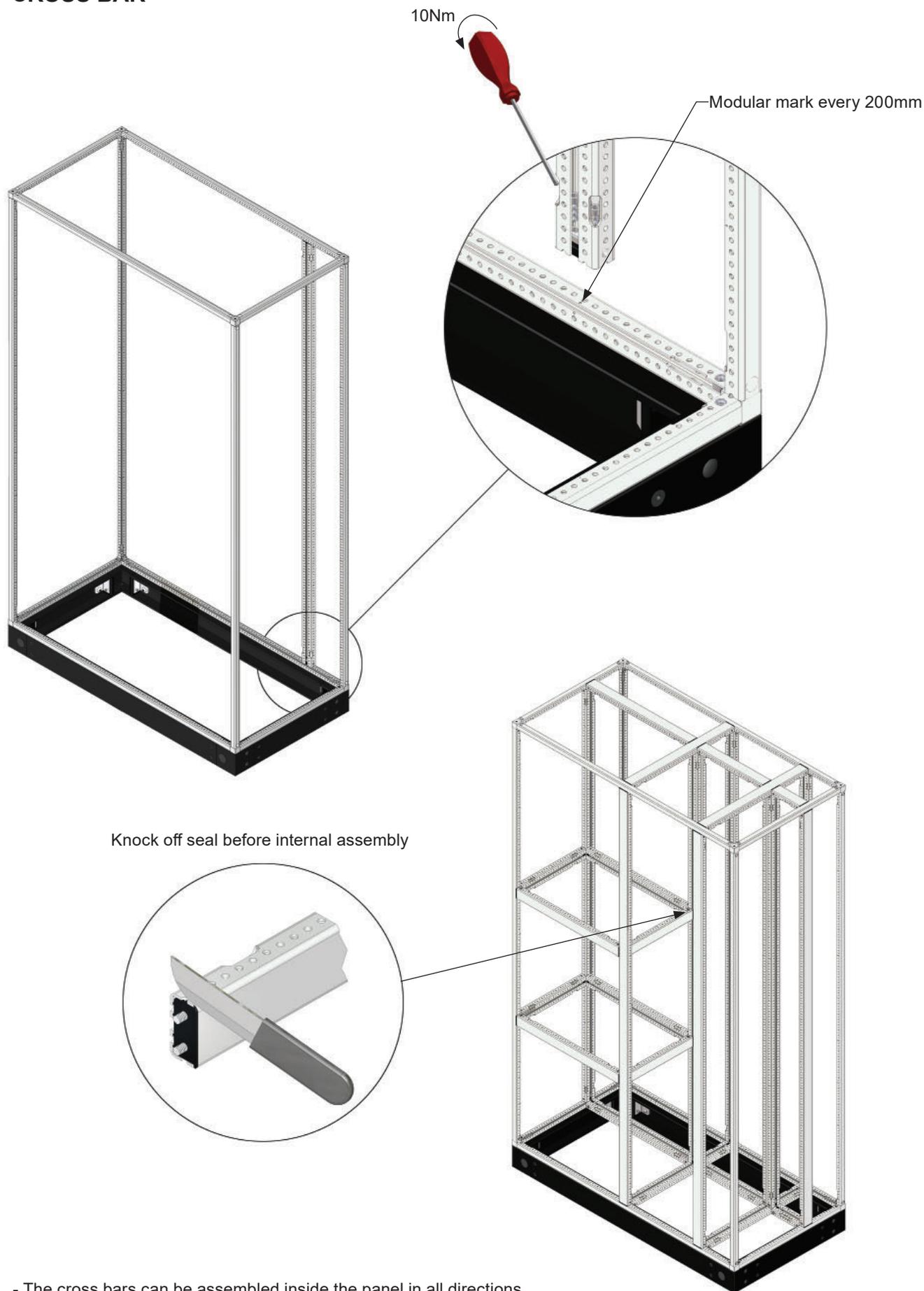
**Tip !**  
It's easier to align the holes,  
if you do the assembly on a work top.

- This is how the top and bottom frames must look.



- Place the base on the floor and fix the top frame to the corner bars

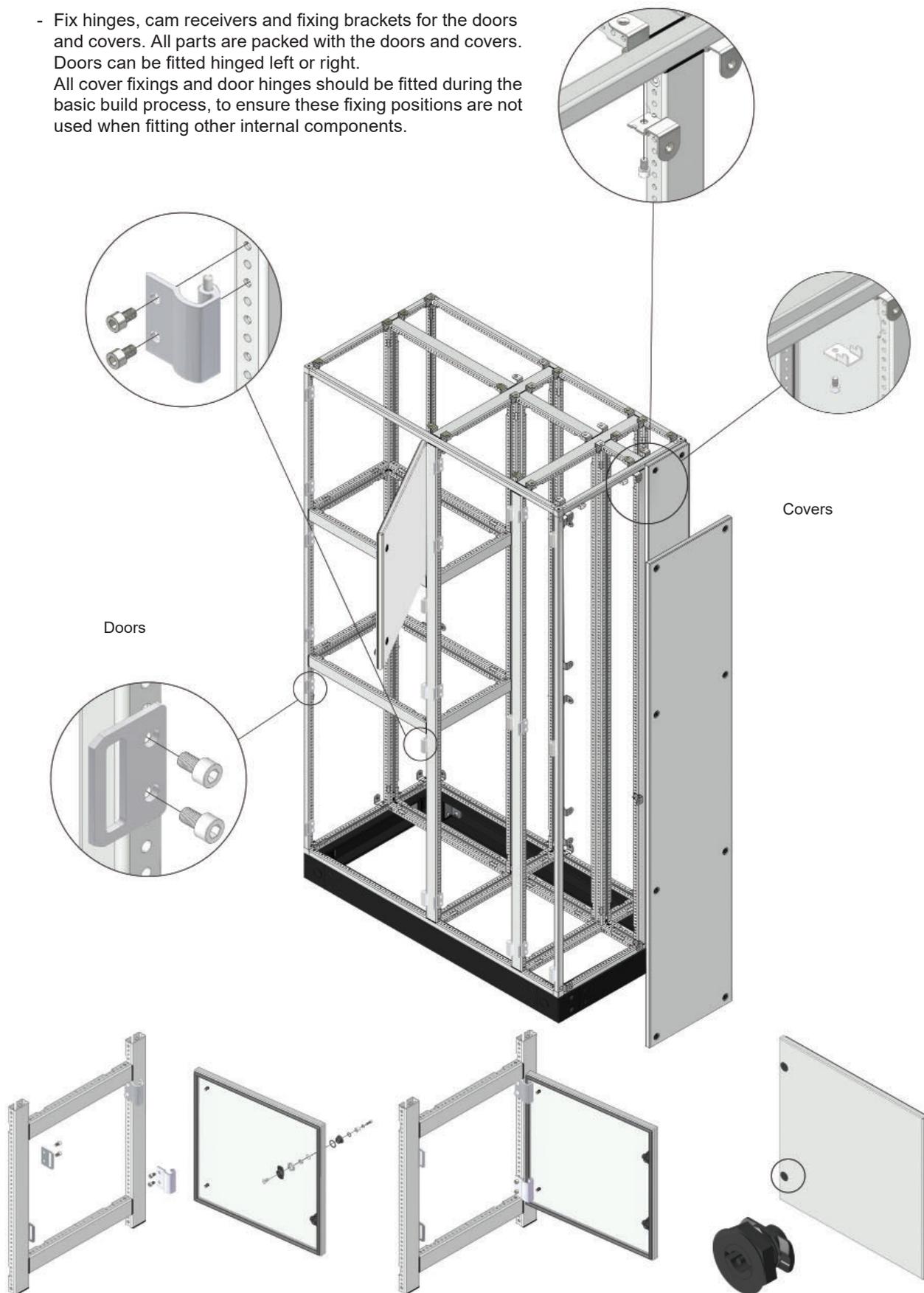
### CROSS BAR



- The cross bars can be assembled inside the panel in all directions.

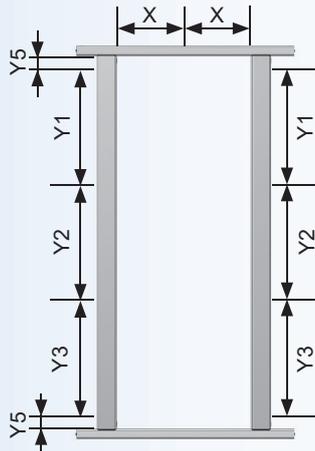
**FIXING**

- Fix hinges, cam receivers and fixing brackets for the doors and covers. All parts are packed with the doors and covers. Doors can be fitted hinged left or right. All cover fixings and door hinges should be fitted during the basic build process, to ensure these fixing positions are not used when fitting other internal components.



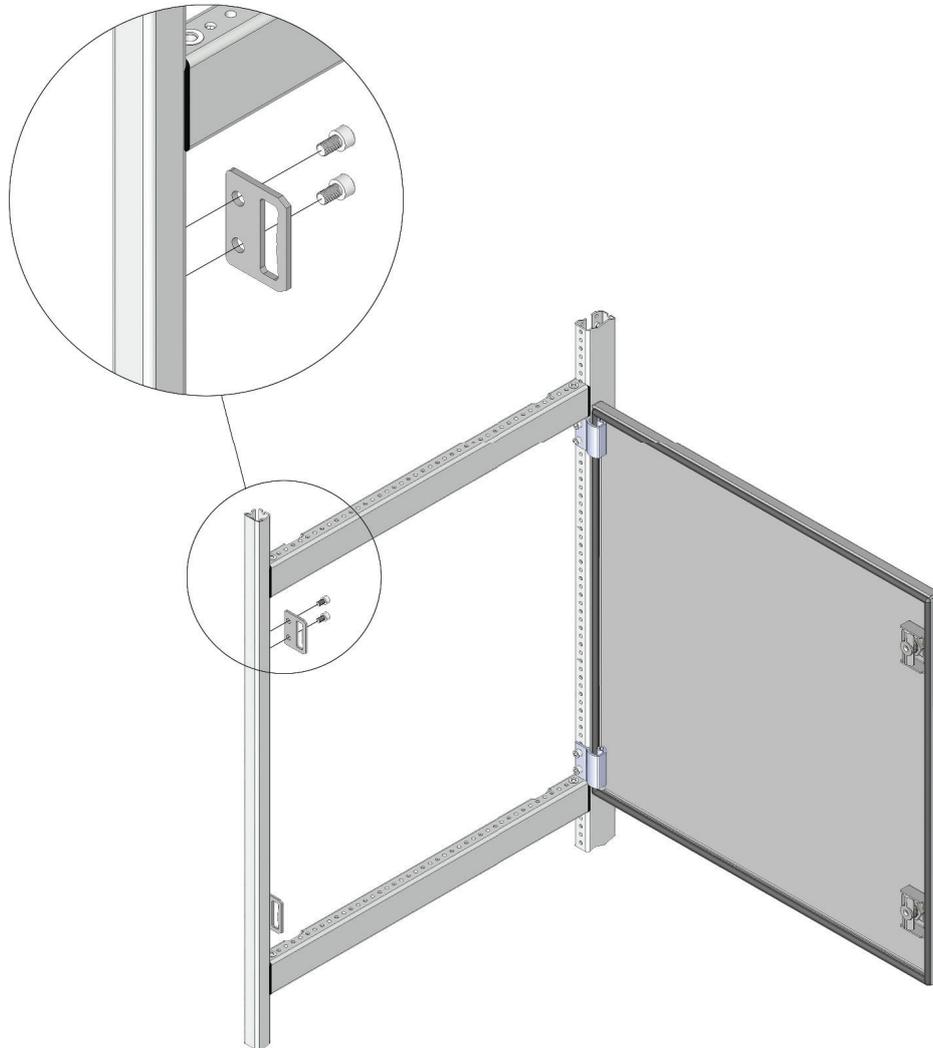
- All the M6 bolts in the system must be tightened to 10Nm.
- See the constructors manual for other type locks.

Version 3

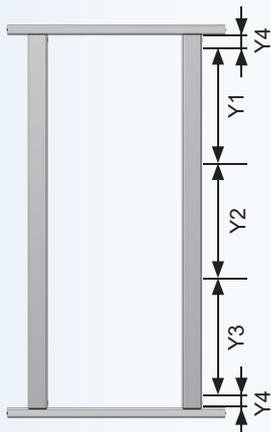


**DOOR** ■  
**CAM RECEIVER POSITION**

TYPE	NUMBER OF CAM RECEIVERS	X	Y <sub>1</sub>	Y <sub>2</sub>	Y <sub>3</sub>	Y <sub>5</sub>
DO 2.2	1	-	100	-	-	75
DO 2.4	2	-	200	-	-	75
DO 2.6	2	-	400	-	-	75
DO 2.8	3	-	300	-	300	75
DO 2.10	3	-	400	400	400	75
DO 2.12	3	-	500	500	500	75
DO 2.14	3	-	600	600	600	75
DO 2.16	4	-	400	600	400	75
DO 2.18	4	-	500	600	500	75
DO 2.20	4	-	600	600	600	75
DO 2.22	4	-	700	600	700	75
DO 4.2	1	-	100	-	-	75
DO 4.3	1	-	100	-	-	125
DO 4.4	2	-	200	-	-	75
DO 4.6	2	-	400	-	-	75
DO 4.8	3	-	300	300	300	75
DO 4.10	3	-	400	400	400	75
DO 4.12	3	-	500	500	500	75
DO 4.14	3	-	600	600	600	75
DO 4.16	4	-	400	600	400	75
DO 4.18	4	-	500	600	500	75
DO 4.20	4	-	600	600	600	75
DO 4.22	4	-	700	600	700	75
DO 6.2	1	-	100	-	-	75
DO 6.3	1	-	100	-	-	125
DO 6.4	2	-	200	-	-	75
DO 6.6	2	-	400	-	-	75
DO 6.8	3	-	300	-	300	75
DO 6.10	3	-	400	-	400	75
DO 6.12	3	-	500	-	500	75
DO 6.14	3	-	600	-	600	75
DO 6.16	4	-	400	600	400	75
DO 6.18	4	-	500	600	500	75
DO 6.20	4	-	600	600	600	75
DO 6.22	4	-	700	600	700	75
DO 8.4	2	-	200	-	-	75
DO 8.6	2	-	400	-	-	75
DO 8.8	3	-	300	-	300	75
DO 8.10	3	-	400	-	400	75
DO 8.12	3	-	500	-	500	75
DO 8.14	3	-	600	-	600	75
DO 8.16	4	-	400	600	400	75
DO 8.18	4	-	500	600	500	75
DO 8.20	4	-	600	600	600	75
DO 8.22	4	-	700	600	700	75
DO 10.10	5	475	400	400	-	75
DO 10.12	5	475	500	500	-	75
DO 10.14	5	475	600	600	-	75
DO 10.16	6	475	400	600	400	75
DO 10.18	6	475	500	600	-	75
DO 10.20	6	475	600	600	600	75
DO 10.22	6	475	700	600	700	75
DO 12.10	5	575	400	400	-	75
DO 12.12	5	575	500	500	-	75
DO 12.14	5	575	600	600	-	75
DO 12.16	6	575	400	600	400	75
DO 12.18	6	575	500	600	500	75
DO 12.20	6	575	600	600	600	75
DO 12.22	6	575	700	600	700	75

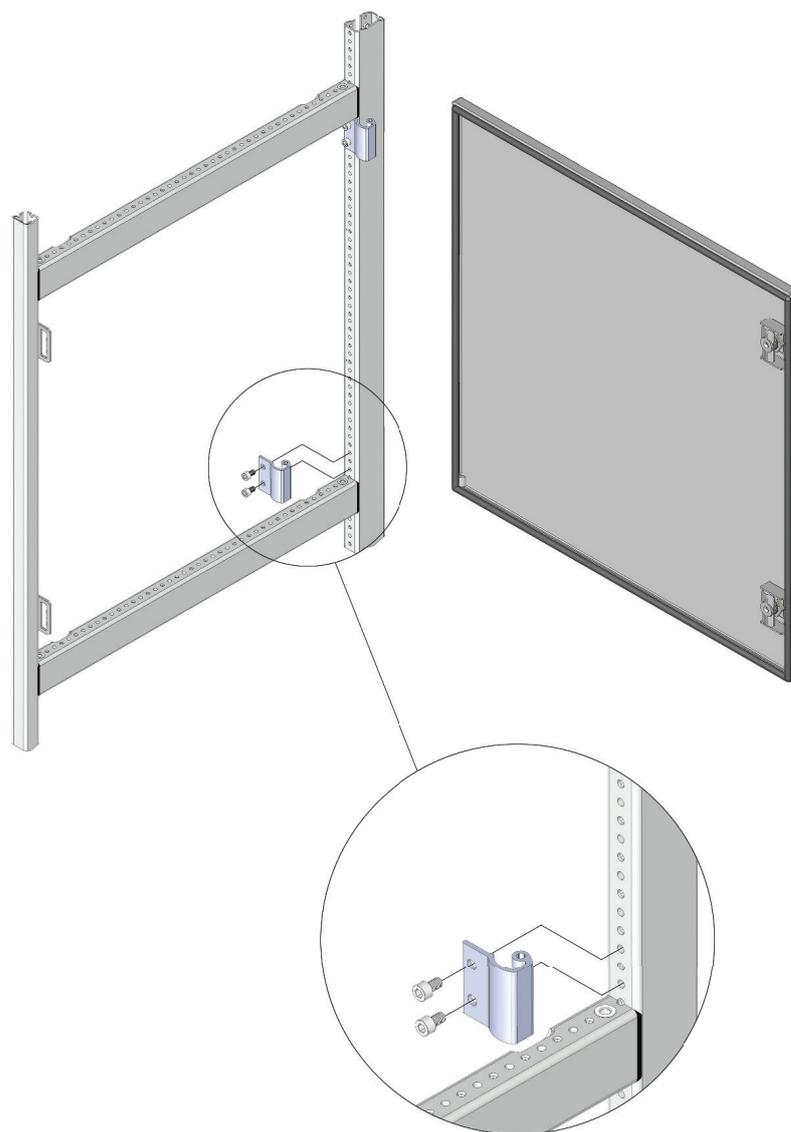


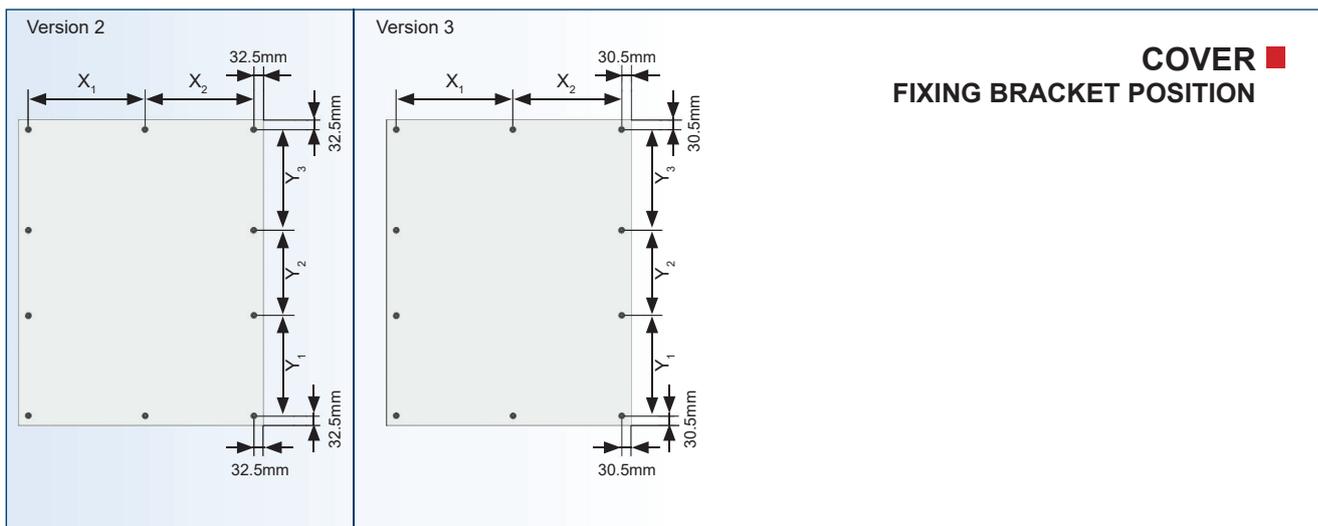
Version 3



**DOOR ■**  
**HINGE POSITION**

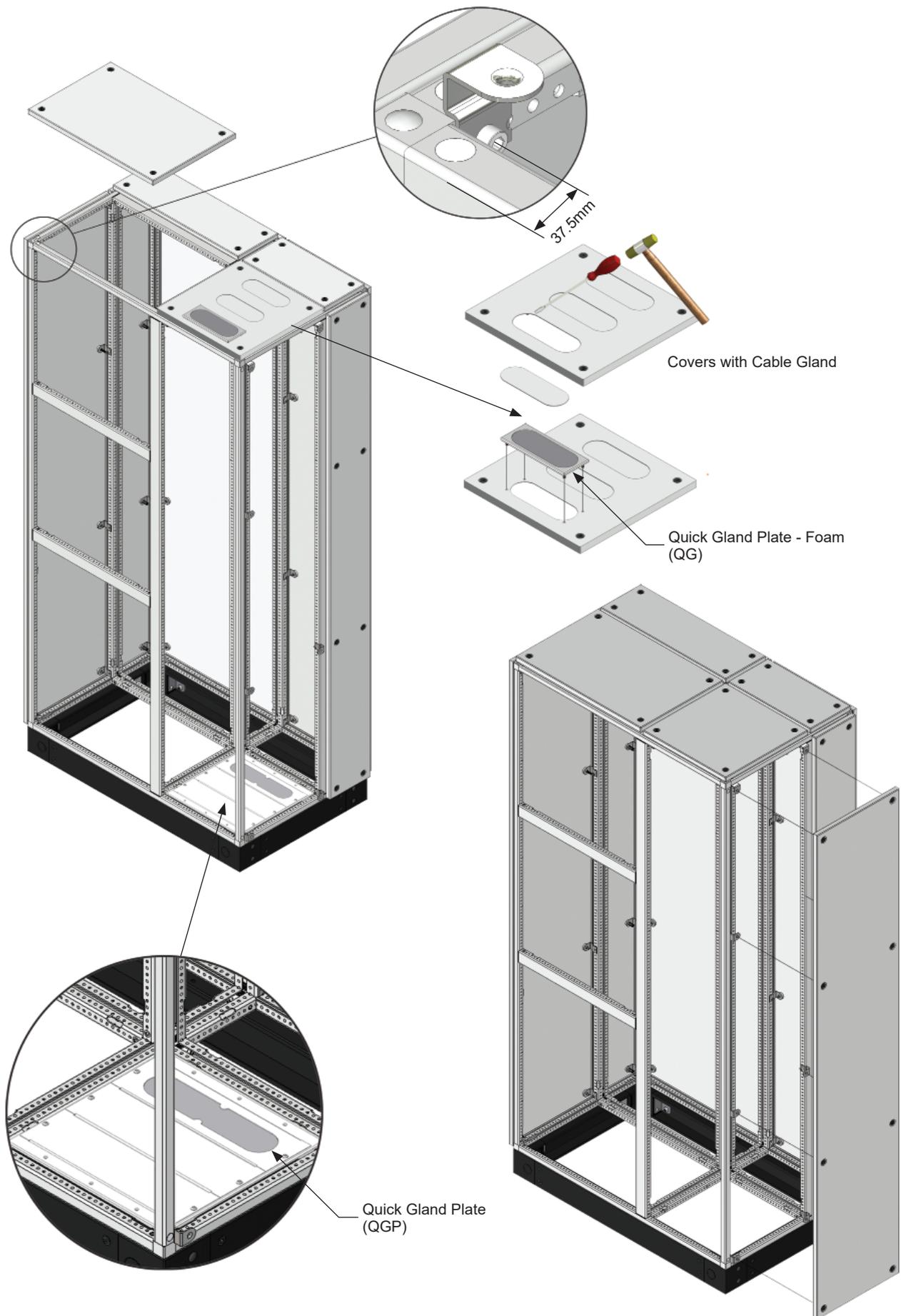
TYPE	NUMBER OF HINGES	Y <sub>1</sub>	Y <sub>2</sub>	Y <sub>3</sub>	Y <sub>4</sub>
DO 2.2	2	100	-	-	25
DO 2.4	2	300	-	-	25
DO 2.6	2	500	-	-	25
DO 2.8	3	400	300	-	25
DO 2.10	3	500	400	-	25
DO 2.12	3	600	500	-	25
DO 2.14	3	700	600	-	25
DO 2.16	4	500	600	400	25
DO 2.18	4	600	600	500	25
DO 2.20	4	700	600	600	25
DO 2.22	4	800	600	700	25
DO 4.2	2	100	-	-	25
DO 4.3	2	200	-	-	25
DO 4.4	2	300	-	-	25
DO 4.6	2	500	-	-	25
DO 4.8	3	400	300	-	25
DO 4.10	3	500	400	-	25
DO 4.12	3	600	500	-	25
DO 4.14	3	700	600	-	25
DO 4.16	4	500	600	400	25
DO 4.18	4	600	600	500	25
DO 4.20	4	700	600	600	25
DO 4.22	4	800	600	700	25
DO 6.2	2	100	-	-	25
DO 6.3	2	200	-	-	25
DO 6.4	2	300	-	-	25
DO 6.6	2	500	-	-	25
DO 6.8	3	400	300	-	25
DO 6.10	3	500	400	-	25
DO 6.12	3	600	500	-	25
DO 6.14	3	700	600	-	25
DO 6.16	4	500	600	400	25
DO 6.18	4	600	600	500	25
DO 6.20	4	700	600	600	25
DO 6.22	4	800	600	700	25
DO 8.4	2	300	-	-	25
DO 8.6	2	500	-	-	25
DO 8.8	3	400	300	-	25
DO 8.10	3	500	400	-	25
DO 8.12	3	600	500	-	25
DO 8.14	3	700	600	-	25
DO 8.16	4	500	600	400	25
DO 8.18	4	600	600	500	25
DO 8.20	4	700	600	600	25
DO 8.22	4	800	600	700	25
DO 10.10	3	500	400	-	25
DO 10.12	3	600	500	-	25
DO 10.14	3	700	600	-	25
DO 10.16	4	500	600	400	25
DO 10.18	4	600	600	600	25
DO 10.20	4	700	600	600	25
DO 10.22	4	800	600	700	25
DO 12.10	3	500	400	-	25
DO 12.12	3	600	500	-	25
DO 12.14	3	700	600	-	25
DO 12.16	4	500	600	400	25
DO 12.18	4	600	600	500	25
DO 12.20	4	700	600	600	25
DO 12.22	4	800	600	700	25



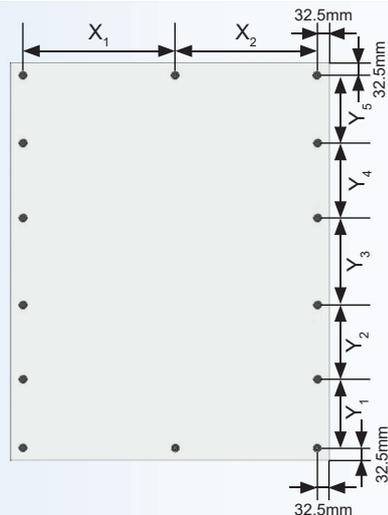


**COVER** ■  
**FIXING BRACKET POSITION**

TYPE	NO. OF SCREWS (X)	X <sub>1</sub>	X <sub>2</sub>	NO. OF SCREWS (Y)	Y <sub>1</sub>	Y <sub>2</sub>	Y <sub>3</sub>
COV 2.2	2	125	-	2	125	-	-
COV 2.4	2	125	-	2	325	-	-
COV 2.6	2	125	-	2	525	-	-
COV 2.8	2	125	-	3	375	350	-
COV 2.10	2	125	-	4	325	275	325
COV 2.12	2	125	-	4	400	325	400
COV 2.14	2	125	-	4	450	425	450
COV 2.16	2	125	-	4	500	525	500
COV 2.18	2	125	-	4	525	675	525
COV 2.20	2	125	-	4	600	725	600
COV 2.22	2	125	-	4	700	725	700
COV 4.3	2	325	-	2	225	-	-
COV 4.4	2	325	-	2	325	-	-
COV 4.6	2	325	-	2	525	-	-
COV 4.8	2	325	-	3	375	350	-
COV 4.10	2	325	-	4	325	275	325
COV 4.12	2	325	-	4	400	325	400
COV 4.14	2	325	-	4	450	425	450
COV 4.16	2	325	-	4	500	525	500
COV 4.18	2	325	-	4	525	675	525
COV 4.20	2	325	-	4	600	725	600
COV 4.22	2	325	-	4	700	725	700
COV 6.3	2	525	-	2	225	-	-
COV 6.6	2	525	-	2	525	-	-
COV 6.8	2	525	-	3	375	350	-
COV 6.10	2	525	-	4	325	275	325
COV 6.12	2	525	-	4	400	325	400
COV 6.14	2	525	-	4	450	425	450
COV 6.16	2	525	-	4	500	525	500
COV 6.18	2	525	-	4	525	675	525
COV 6.20	2	525	-	4	600	725	600
COV 6.22	2	525	-	4	700	725	700
COV 8.8	3	375	350	3	375	350	-
COV 8.10	3	375	350	4	325	275	325
COV 8.12	3	375	350	4	400	325	400
COV 8.14	3	375	350	4	450	425	450
COV 8.16	3	375	350	4	500	525	500
COV 8.18	3	375	350	4	525	675	525
COV 8.20	3	375	350	4	600	725	600
COV 8.22	3	375	350	4	700	725	700

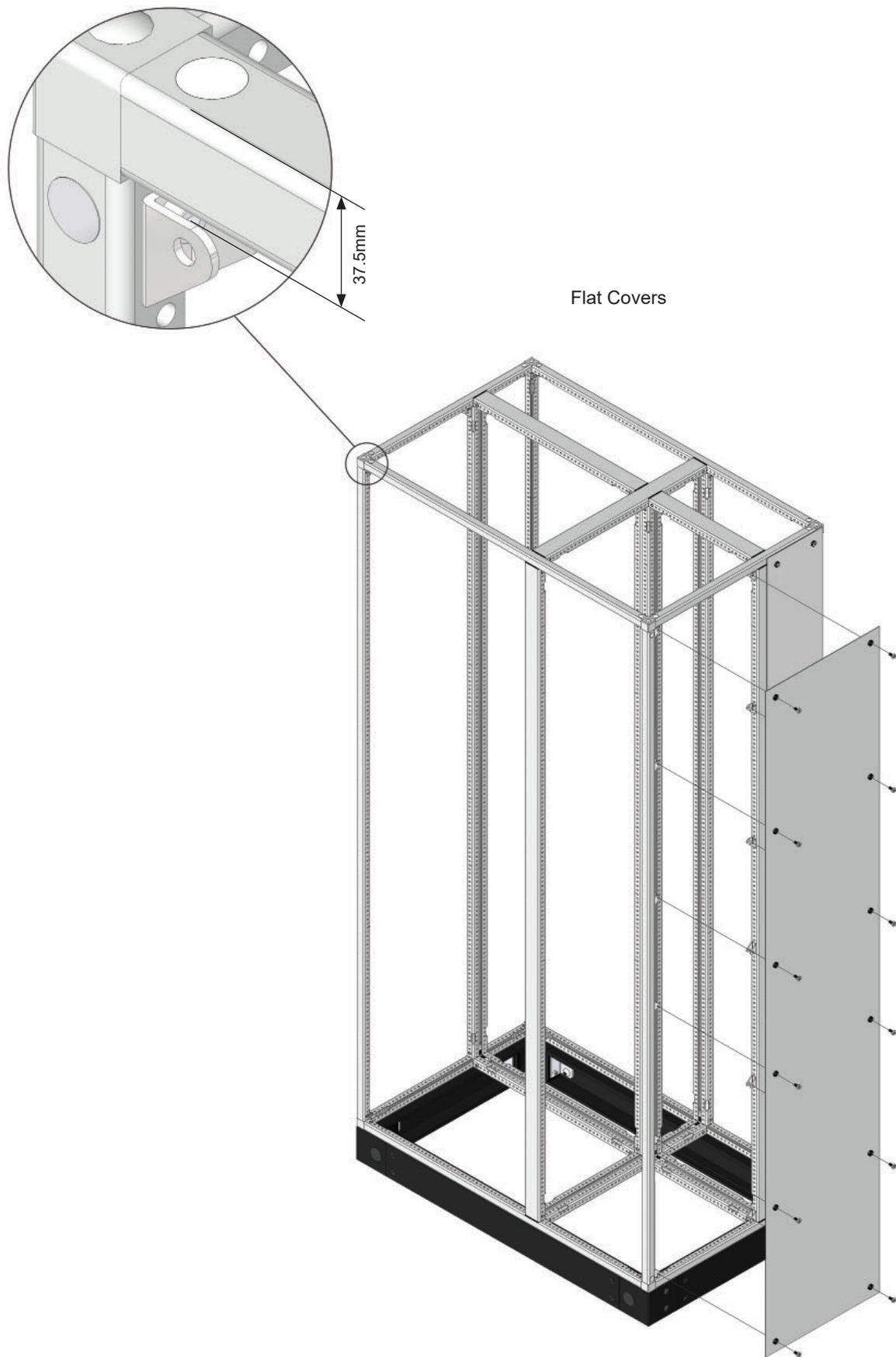


\* Please see the Constructors Manual online at [www.elsteel.com](http://www.elsteel.com) for more details on Gland Plates.

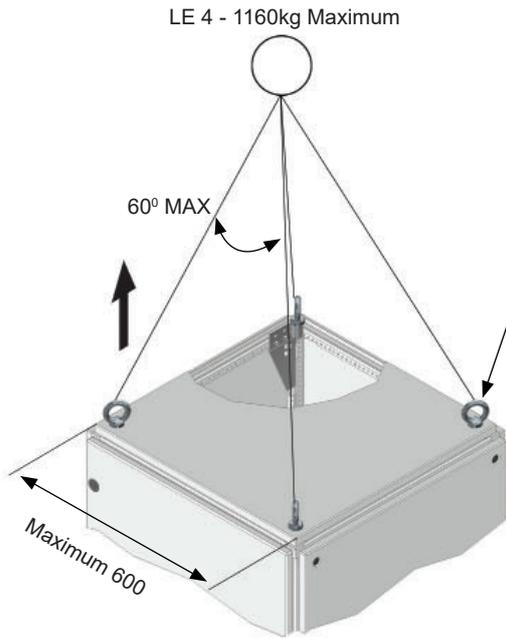


**FLAT COVER ■**  
**FIXING BRACKET POSITION**

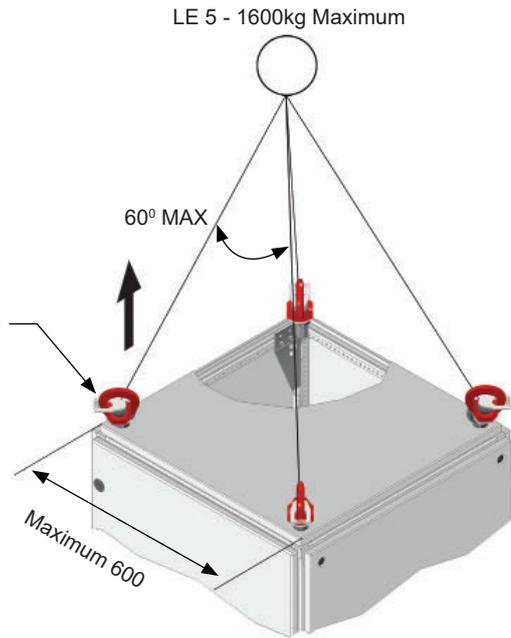
SIZE (W×H)	NO. OF SCREWS (X)	X <sub>1</sub>	X <sub>2</sub>	NO. OF SCREWS (Y)	Y <sub>1</sub>	Y <sub>2</sub>	Y <sub>3</sub>	Y <sub>4</sub>	Y <sub>5</sub>
200 × 200	2	125	-	2	125	-	-	-	-
200 × 400	2	125	-	2	325	-	-	-	-
200 × 600	2	125	-	3	275	250	-	-	-
200 × 800	2	125	-	3	375	350	-	-	-
200 × 1000	2	125	-	4	325	275	325	-	-
200 × 1200	2	125	-	4	400	325	400	-	-
200 × 1400	2	125	-	6	325	275	125	275	325
200 × 1600	2	125	-	6	325	275	325	275	325
200 × 1800	2	125	-	6	400	325	275	325	400
200 × 2000	2	125	-	6	400	400	325	400	400
200 × 2200	2	125	-	6	425	425	425	425	425
400 × 400	2	325	-	2	325	-	-	-	-
400 × 600	2	325	-	3	275	250	-	-	-
400 × 800	2	325	-	3	375	350	-	-	-
400 × 1000	2	325	-	4	325	275	325	-	-
400 × 1200	2	325	-	4	400	325	400	-	-
400 × 1400	2	325	-	6	325	275	125	275	325
400 × 1600	2	325	-	6	325	275	325	275	325
400 × 1800	2	325	-	6	400	325	275	325	400
400 × 2000	2	325	-	6	400	400	325	400	400
400 × 2200	2	325	-	6	425	425	425	425	425
600 × 600	2	525	-	3	275	250	-	-	-
600 × 800	2	525	-	3	375	350	-	-	-
600 × 1000	2	525	-	4	325	275	325	-	-
600 × 1200	2	525	-	4	400	325	400	-	-
600 × 1400	2	525	-	6	325	275	125	275	325
600 × 1600	2	525	-	6	325	275	325	275	325
600 × 1800	2	525	-	6	400	325	275	325	400
600 × 2000	2	525	-	6	400	400	325	400	400
600 × 2200	2	525	-	6	425	425	425	425	425
800 × 800	3	375	350	3	375	350	-	-	-
800 × 1000	3	375	350	4	325	275	325	-	-
800 × 1200	3	375	350	4	400	325	400	-	-
800 × 1400	3	375	350	6	325	275	125	275	325
800 × 1600	3	375	350	6	325	275	325	275	325
800 × 1800	3	375	350	6	400	325	275	325	400
800 × 2000	3	375	350	6	400	400	325	400	400
800 × 2200	3	375	350	6	425	425	425	425	425



LIFTING AND MOVING THE PANEL SECTIONS



Panel size up to 2000x2000x600



Panel size up to 2000x2000x600

Hand tighten the eye bolt, do not over tighten using tools.

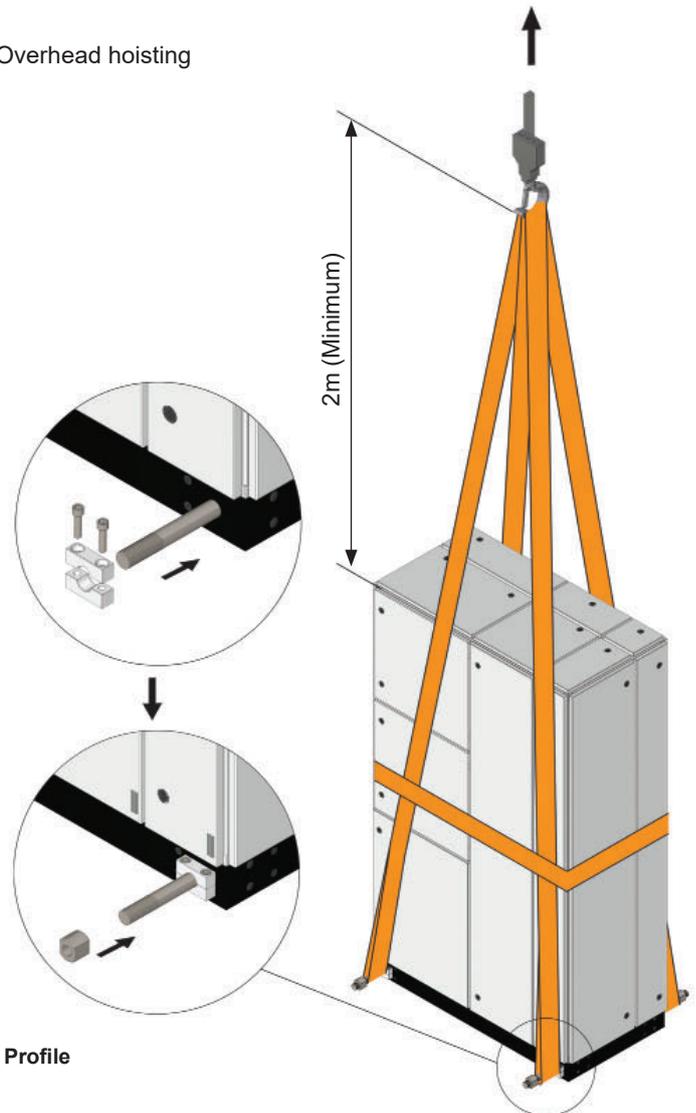


**Lifting Instructions for Forklift**  
 Maximum weight = 2300kg  
 Maximum panel width = 2200mm

**Lifting Instructions for Lifting Bars with Plinth Profile**  
 Maximum weight = 1800kg  
 Maximum panel width = 2000mm

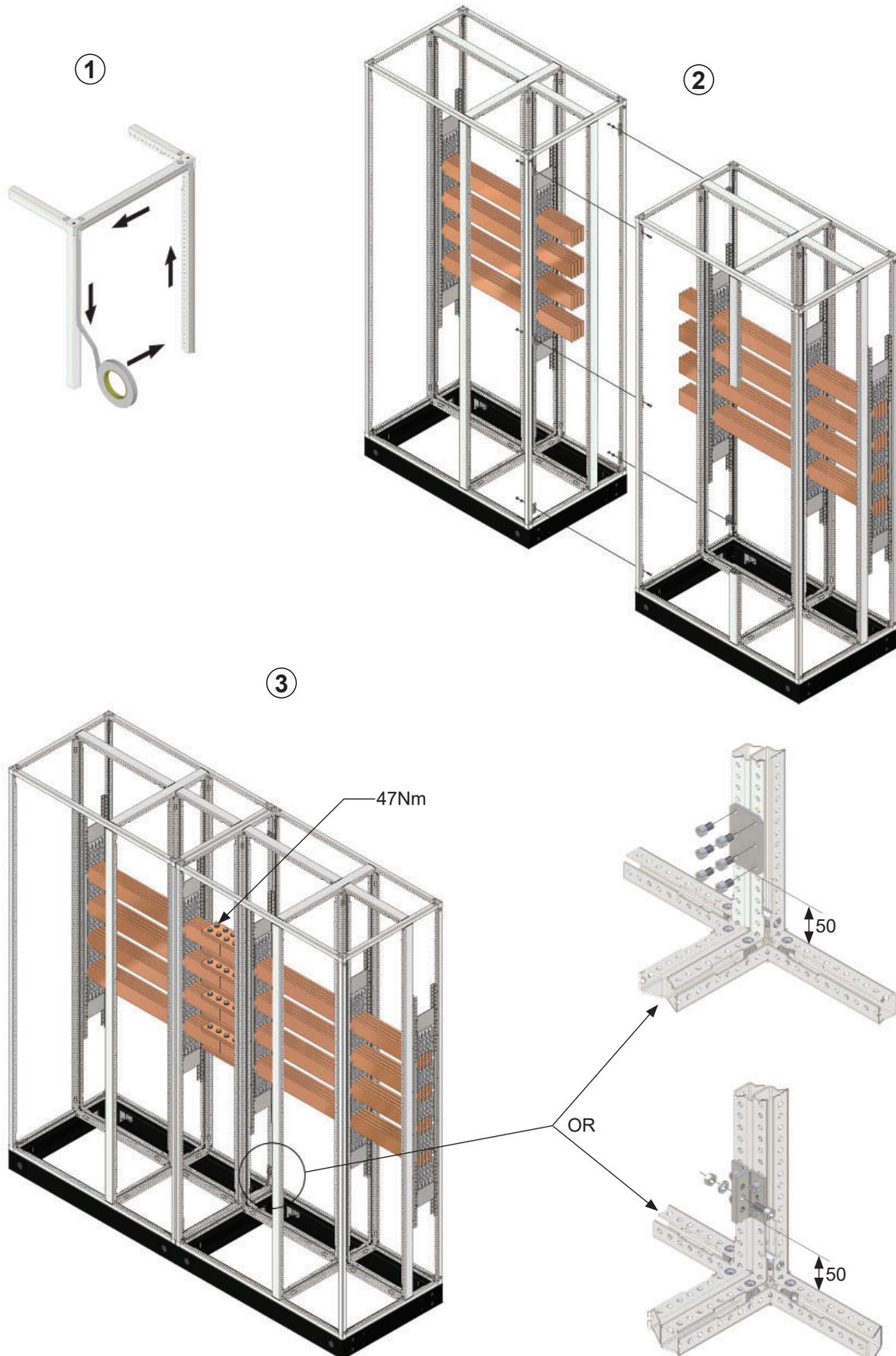
**Lifting Instructions for Lifting Bars with Heavy Duty Plinth Profile**  
 Maximum weight = 3792kg  
 Maximum panel width = 2200mm

Overhead hoisting



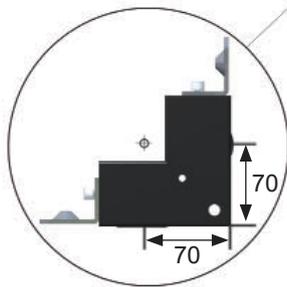
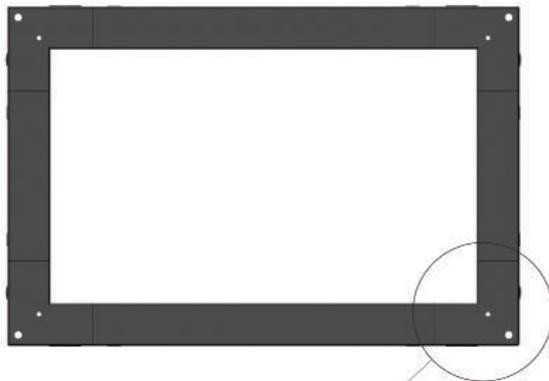
### JOINING TWO PANELS

Panels must be on an even surface.

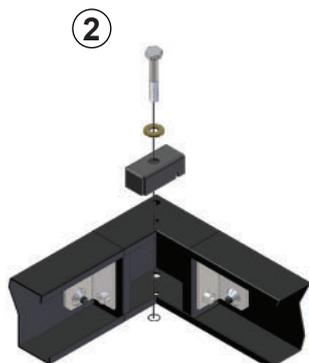


## SECURING THE PANEL BOARD TO THE FLOOR

Panels must be on an even surface.



Detail for drilling



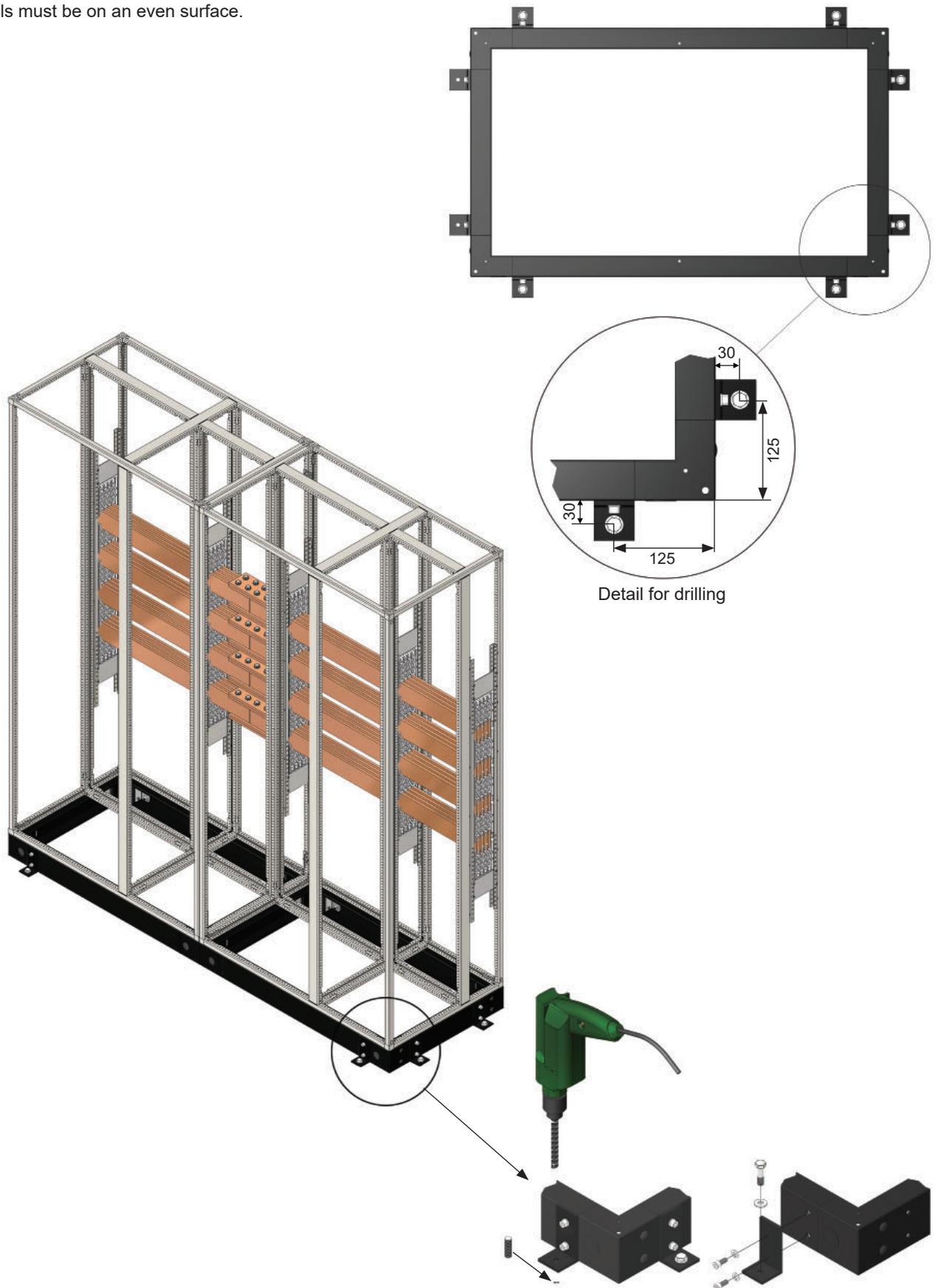
Ensure all screws, joints, bolts etc. are tightened properly before installation.

Bolt Size	Torque Nm
M5	6
M6	10
M8	24
M10	47
M12	81

## CLAMPING ANGLE FOR OUTSIDE PLINTH

### SECURING THE PANEL BOARD TO THE FLOOR

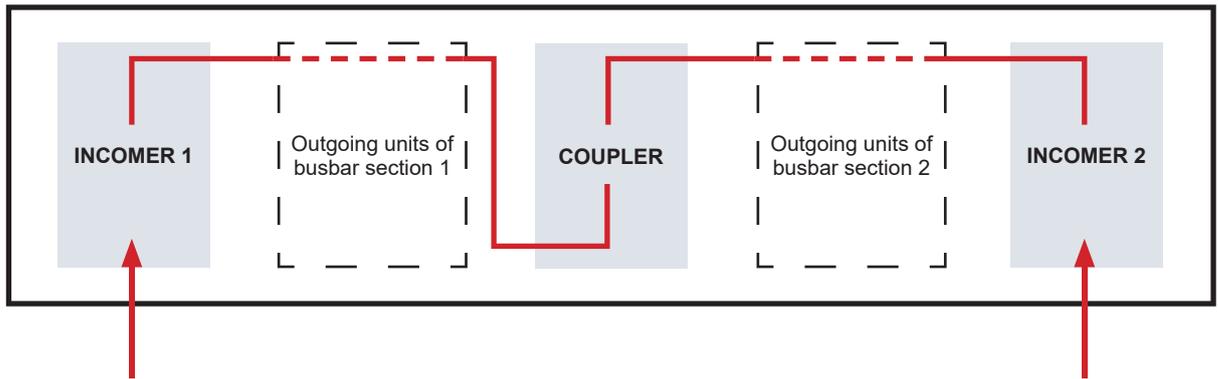
Panels must be on an even surface.



## MAIN BUSBAR ARRANGEMENT EXAMPLE

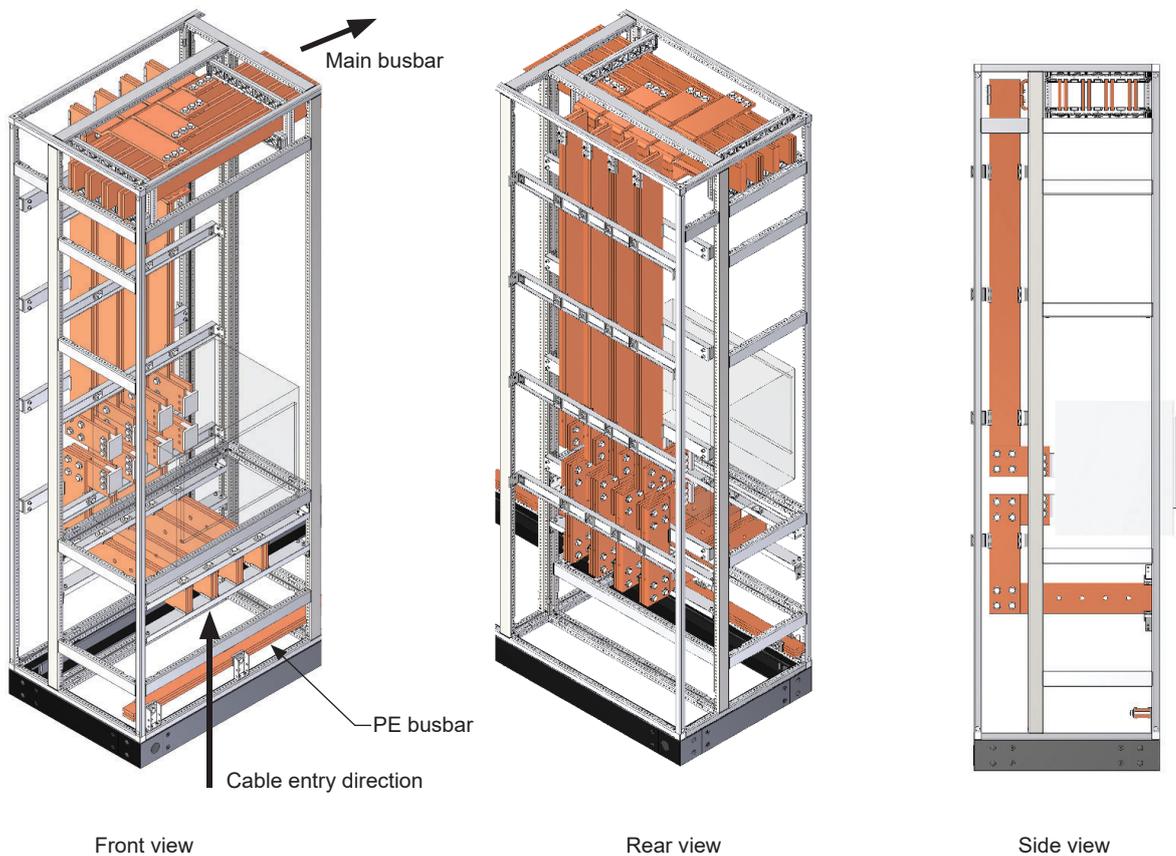
### TECHNICAL PROPERTIES

Main Busbar location	- Top
Type of main busbar holder	- BH/ OMH
Cable entry direction	- Bottom



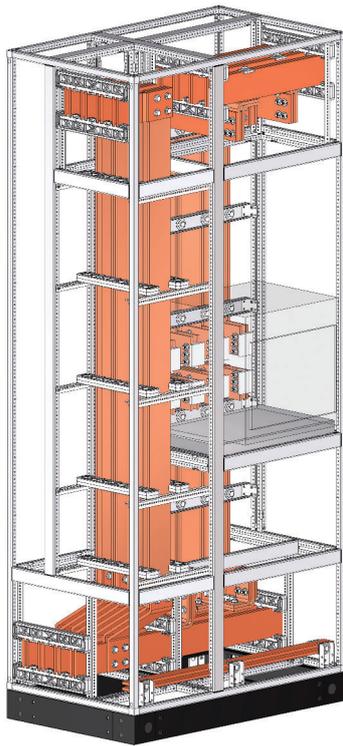
Techno Module panel configuration

### Incomer 1

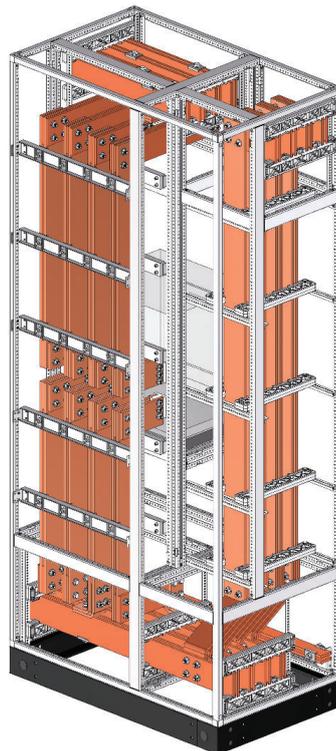


\* Separation plates, Doors, Covers are not shown

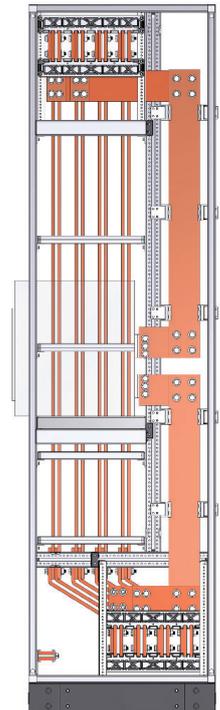
## Coupler



Front view

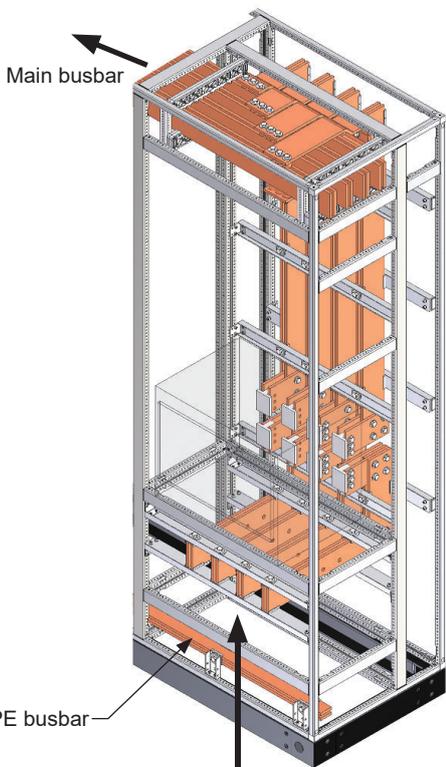


Rear view



Side view

## Incomer 2

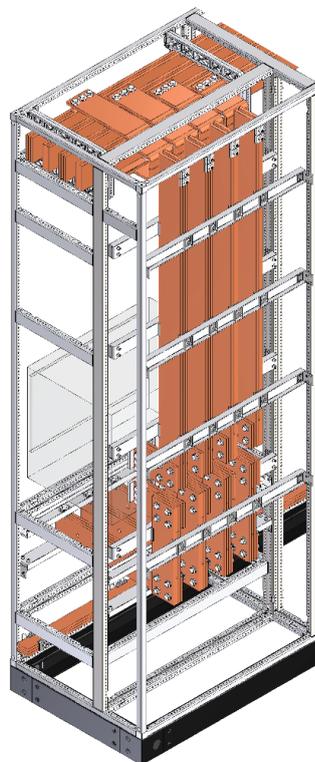


Main busbar

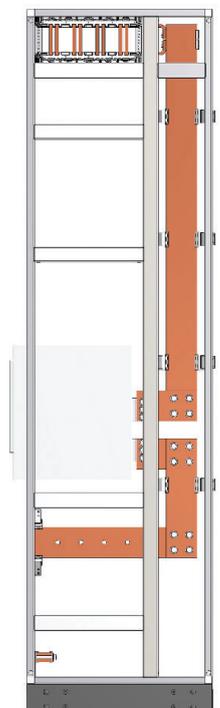
PE busbar

Cable entry direction

Front view



Rear view



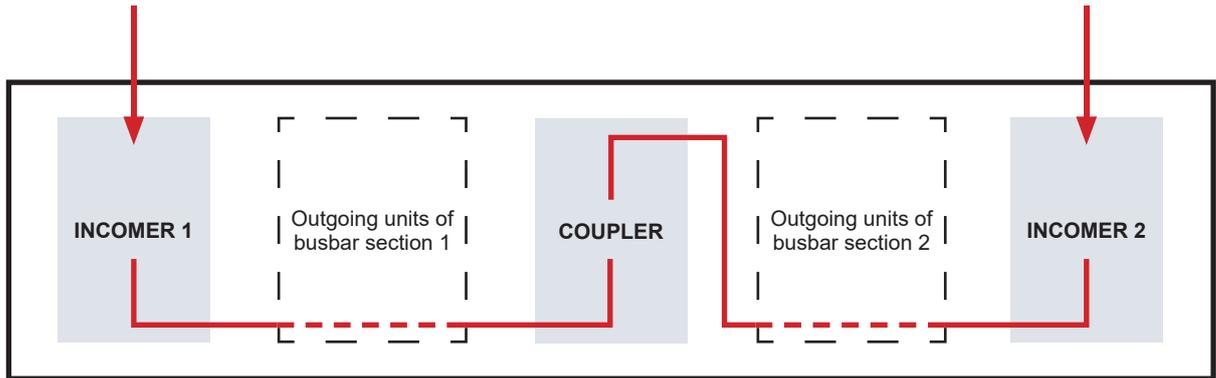
Side view

\* Separation plates, Doors, Covers are not shown

## MAIN BUSBAR ARRANGEMENT EXAMPLE

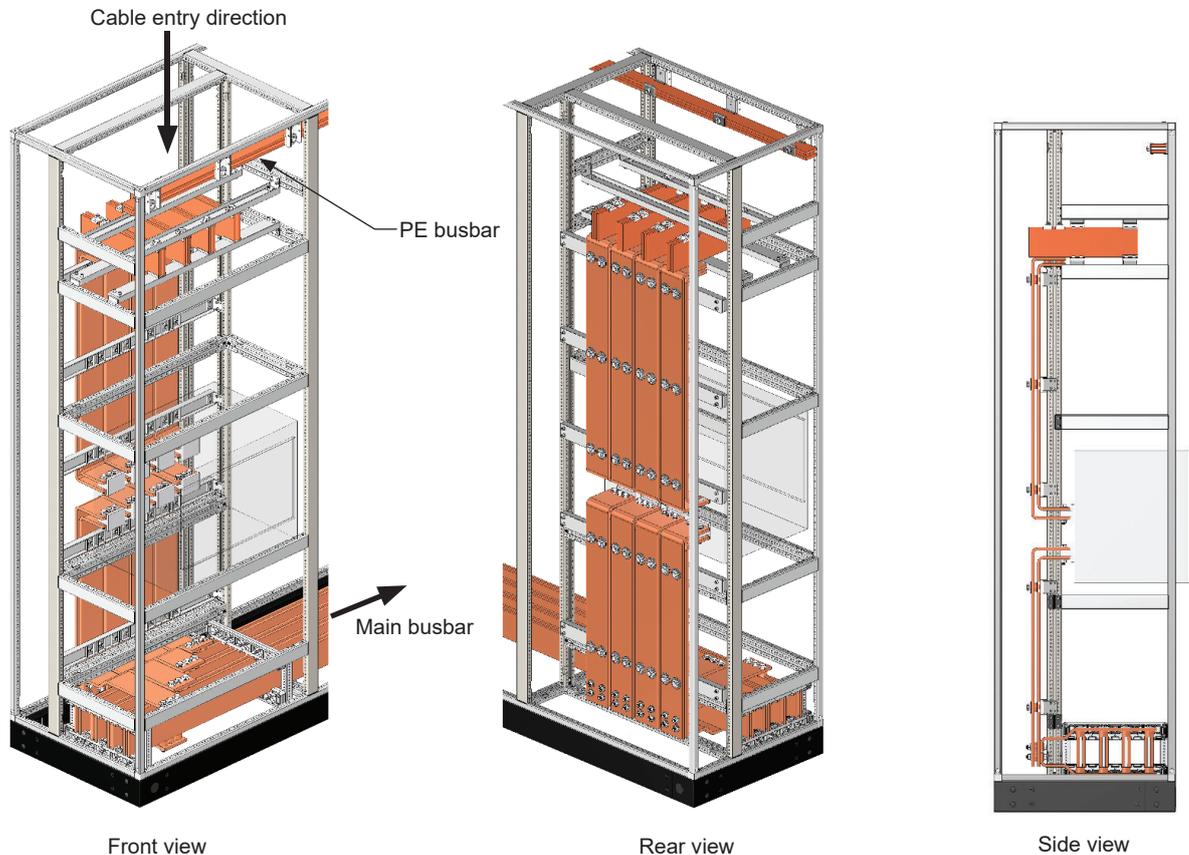
### TECHNICAL PROPERTIES

Main Busbar location	- Bottom
Type of main busbar holder	- BH/ OMH
Cable entry direction	- Top



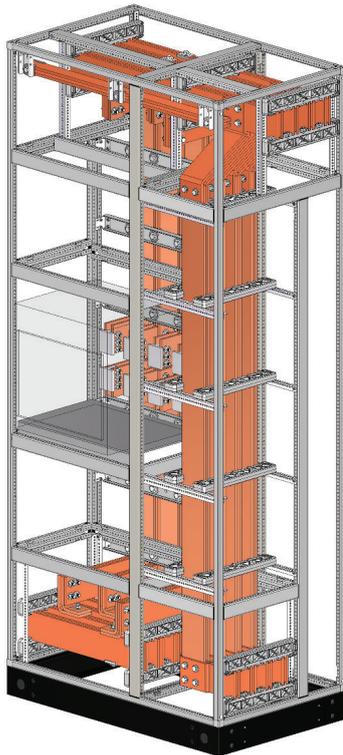
Techno Module panel configuration

### Incomer 1

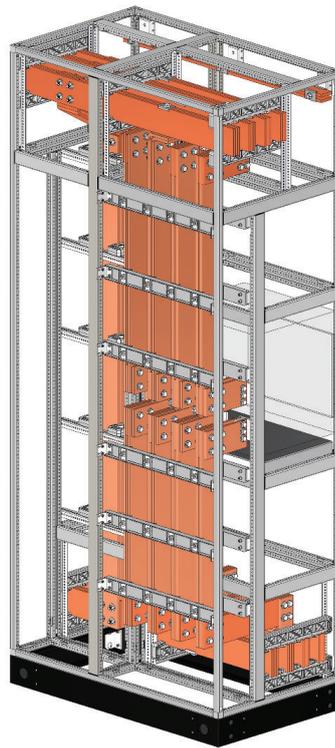


\* Separation plates, Doors, Covers are not shown

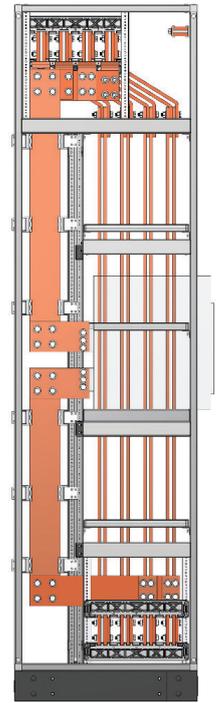
## Coupler



Front view



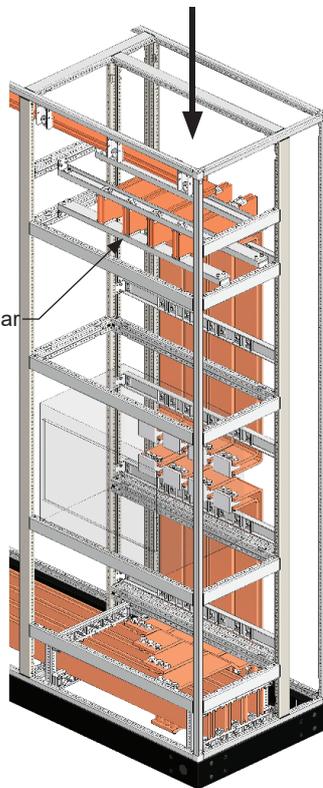
Rear view



Side view

## Incomer 2

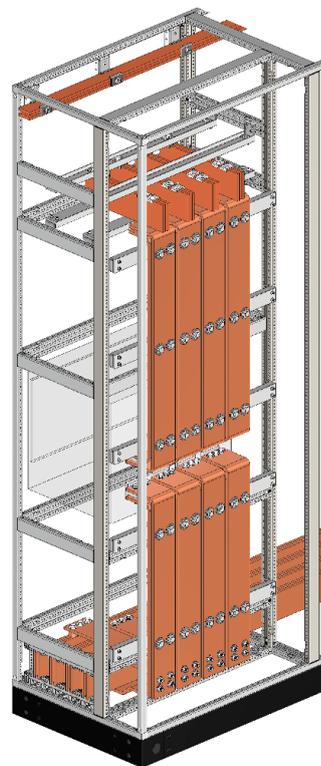
Cable entry direction



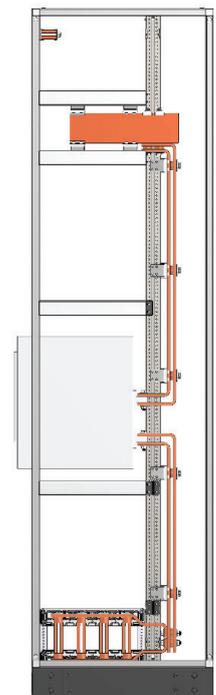
PE busbar

Main busbar

Front view



Rear view



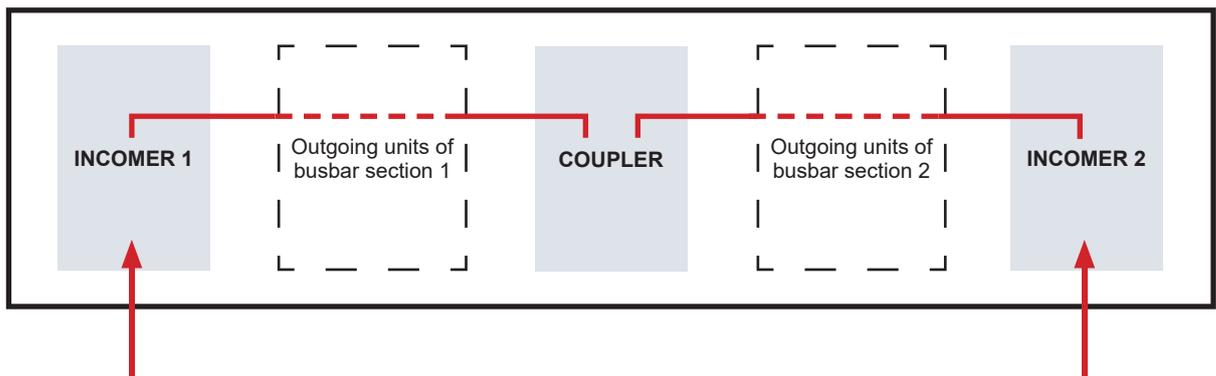
Side view

\* Separation plates, Doors, Covers are not shown

## MAIN BUSBAR ARRANGEMENT EXAMPLE

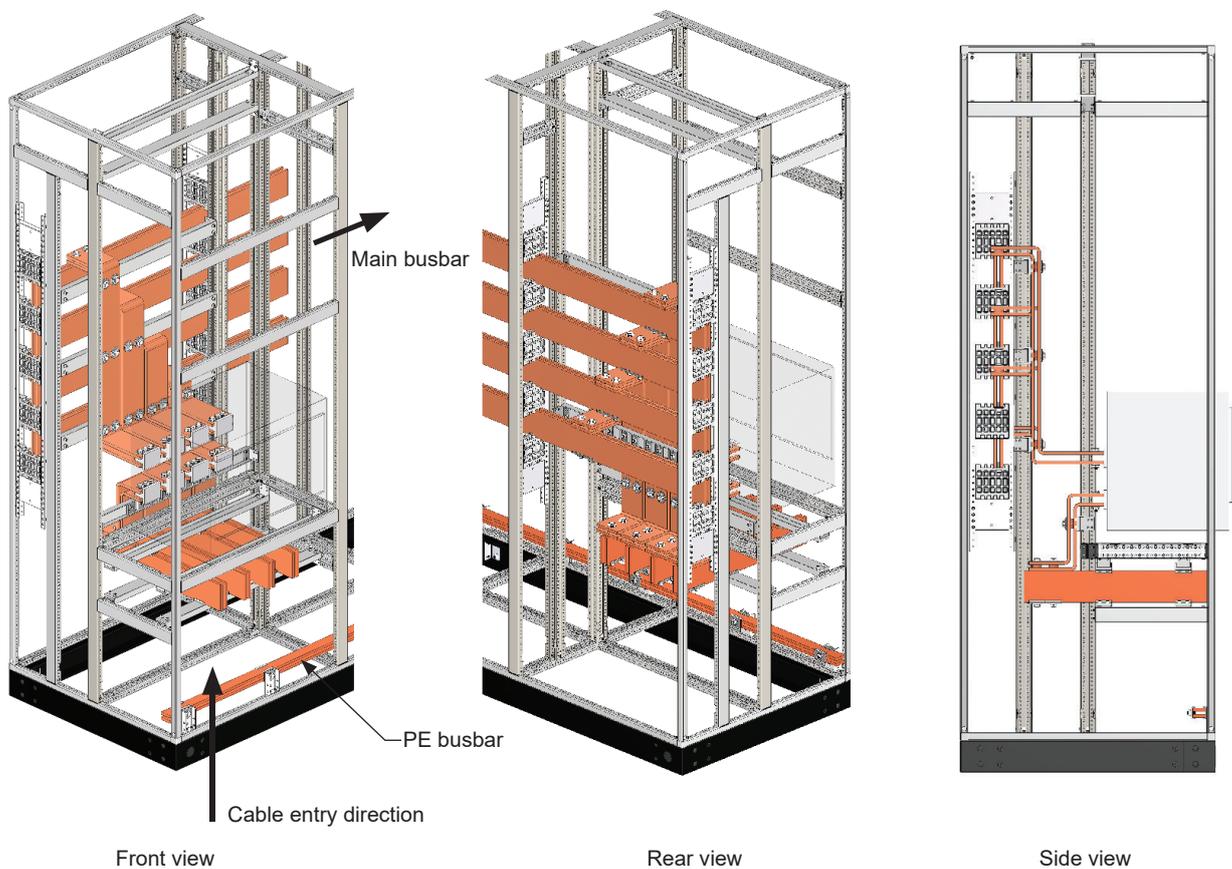
### TECHNICAL PROPERTIES

Main Busbar location	- Rear
Type of main busbar holder	- MAB/ BH
Cable entry direction	- Bottom



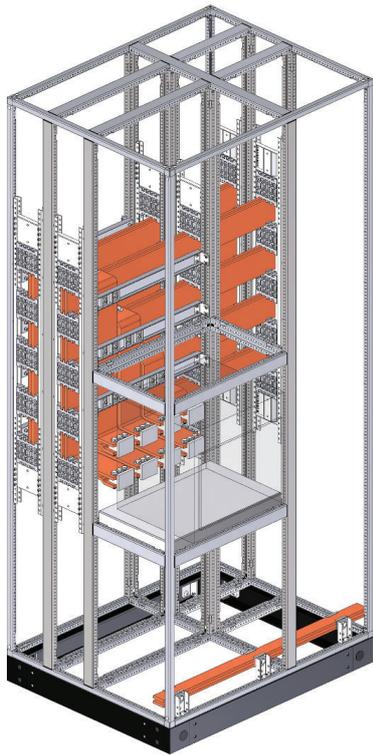
Techno Module panel configuration

### Incomer 1

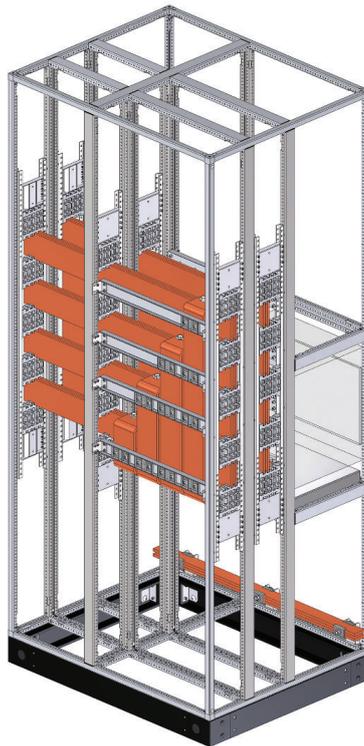


\* Separation plates, Doors, Covers are not shown

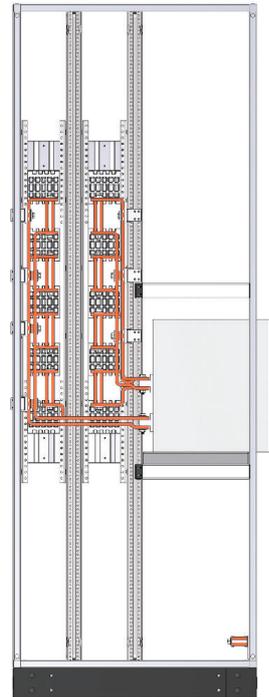
## Coupler



Front view

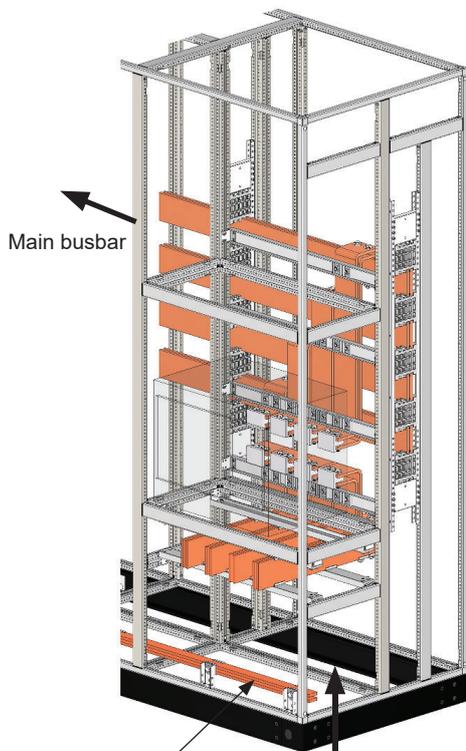


Rear view

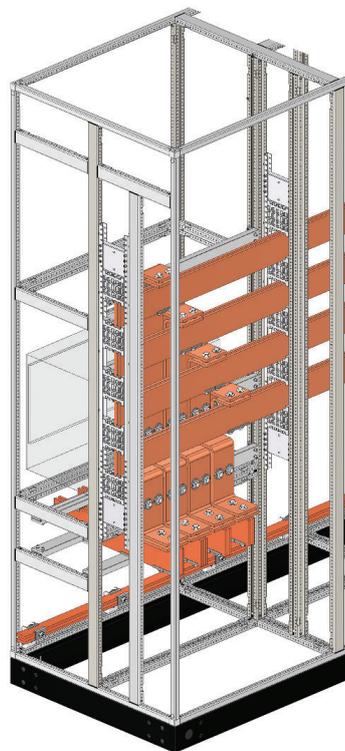


Side view

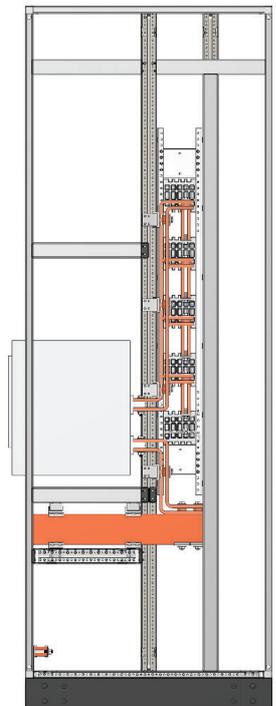
## Incomer 2



Front view



Rear view



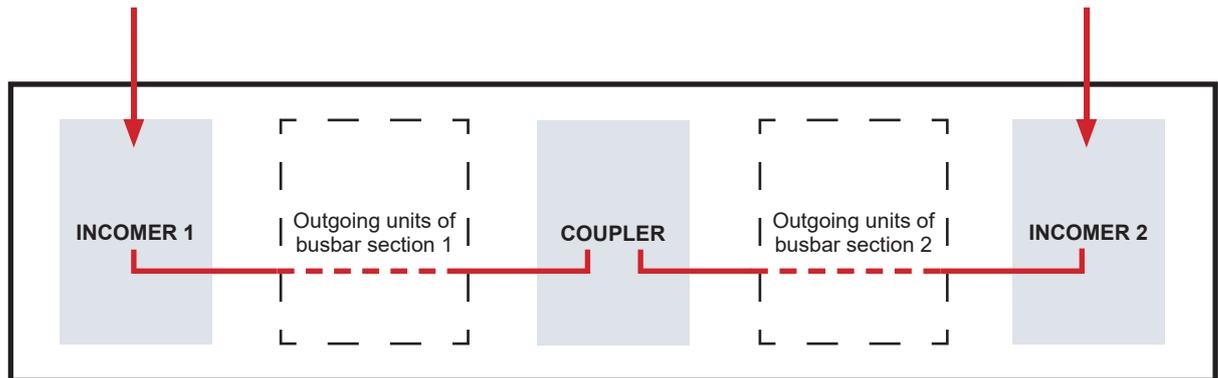
Side view

\* Separation plates, Doors, Covers are not shown

## MAIN BUSBAR ARRANGEMENT EXAMPLE

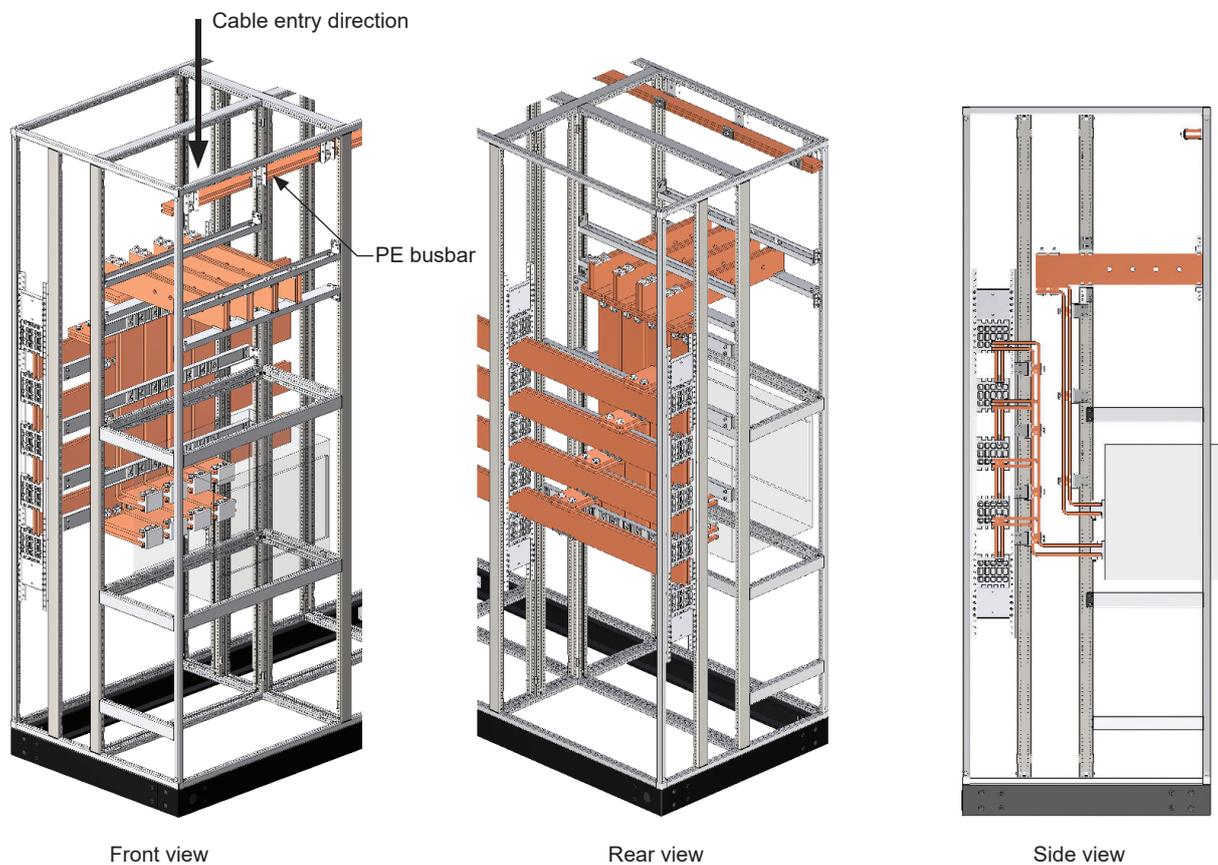
### TECHNICAL PROPERTIES

Main Busbar location	- Rear
Type of main busbar holder	- MAB/ BH
Cable entry direction	- Top



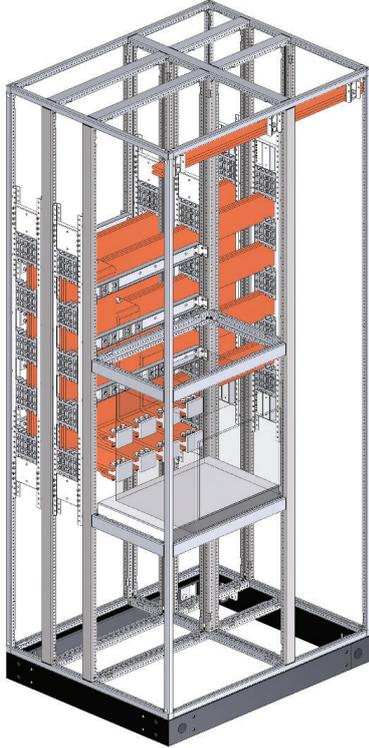
Techno Module panel configuration

### Incomer 1

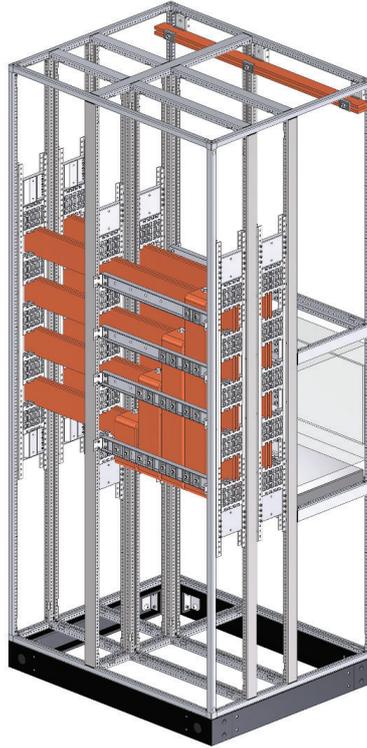


\* Separation plates, Doors, Covers are not shown

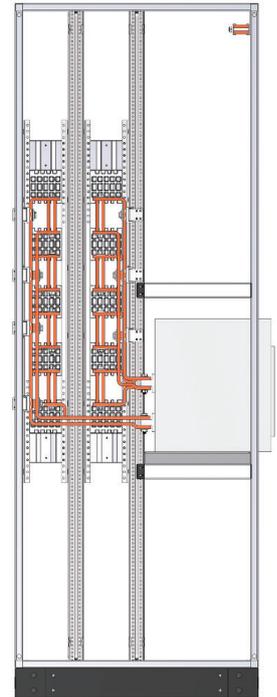
## Coupler



Front view



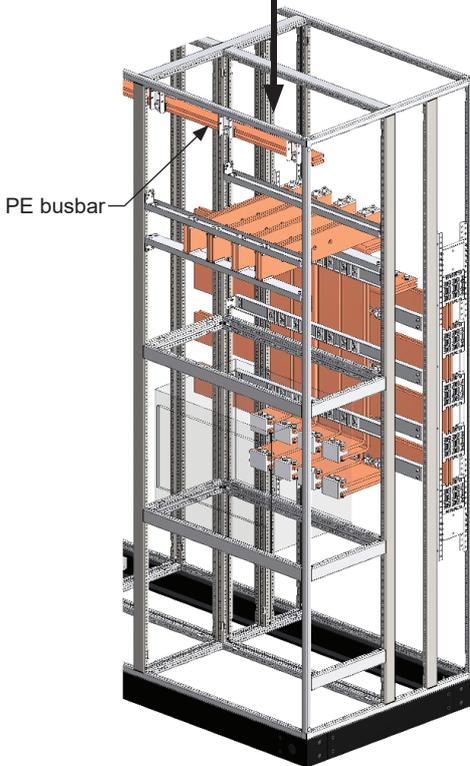
Rear view



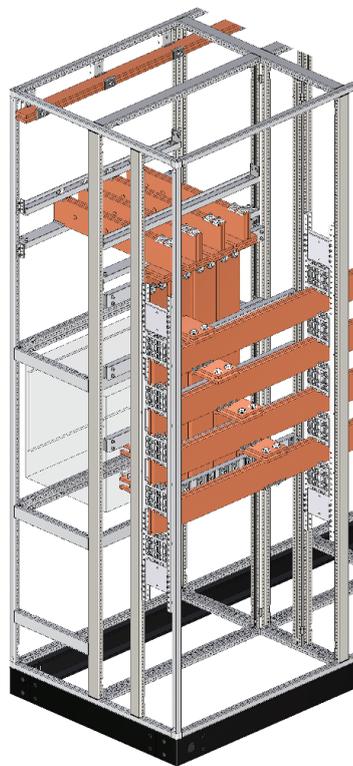
Side view

## Incomer 2

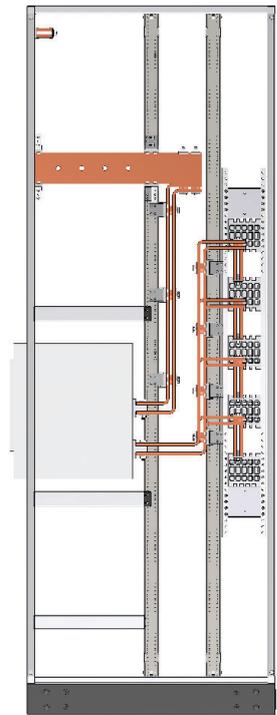
Cable entry direction



Front view



Rear view



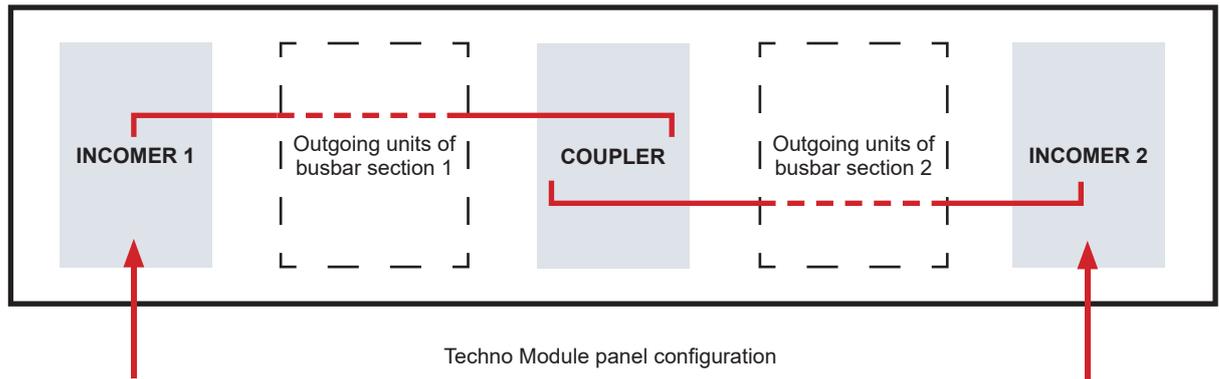
Side view

\* Separation plates, Doors, Covers are not shown

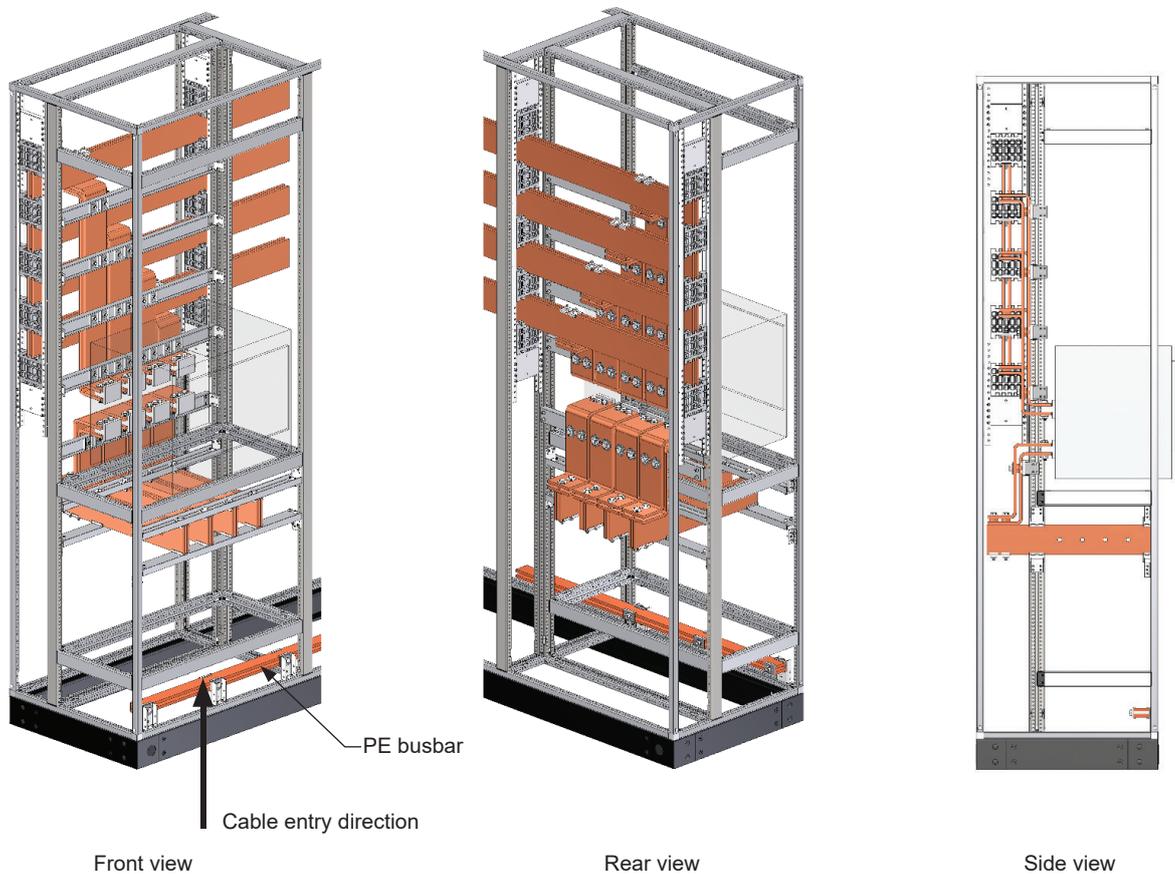
## MAIN BUSBAR ARRANGEMENT EXAMPLE

### TECHNICAL PROPERTIES

Main Busbar location	- Rear
Type of main busbar holder	- MAB/ BH
Cable entry direction	- Bottom

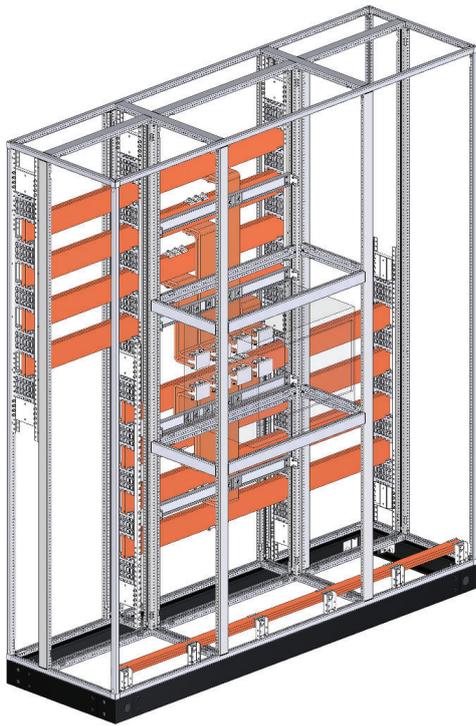


### Incomer 1

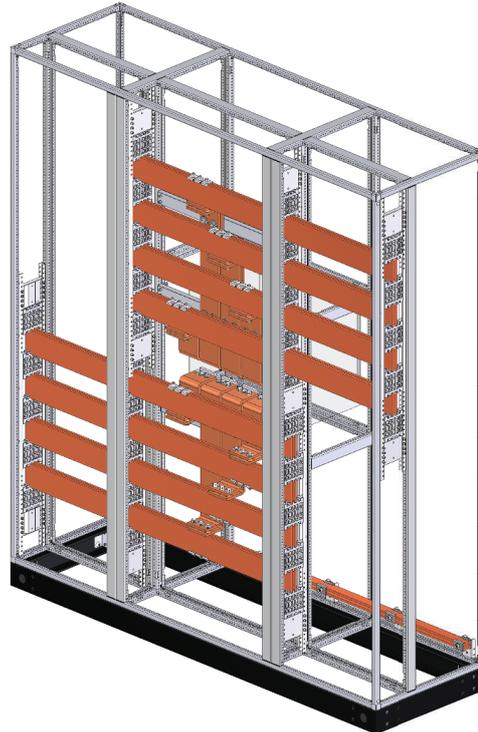


\* Separation plates, Doors, Covers are not shown

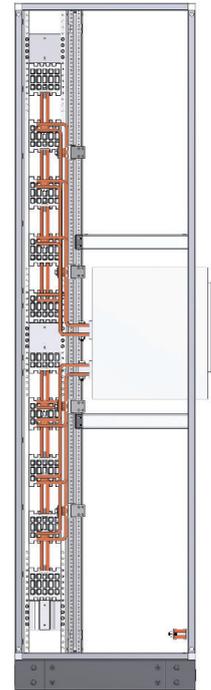
## Coupler



Front view

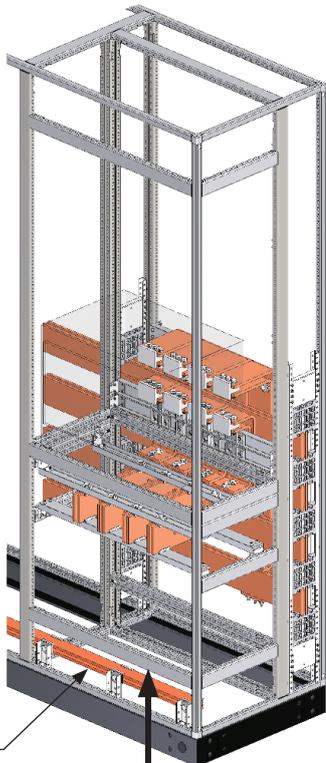


Rear view



Side view

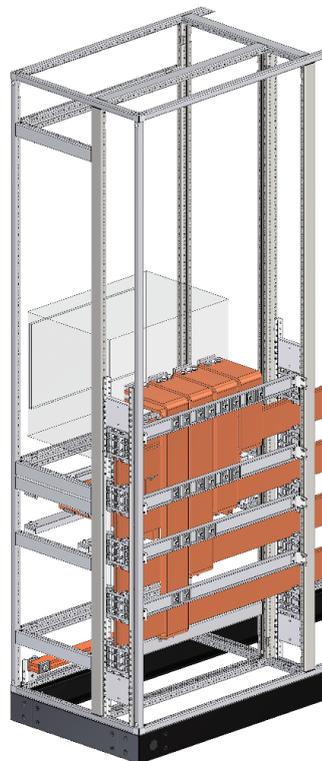
## Incomer 2



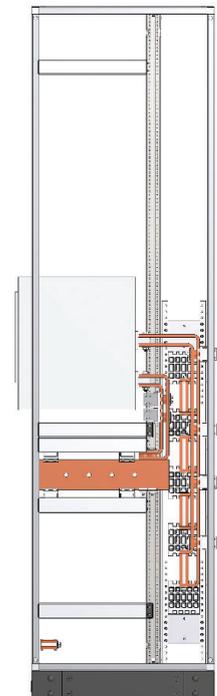
PE busbar

Cable entry direction

Front view



Rear view



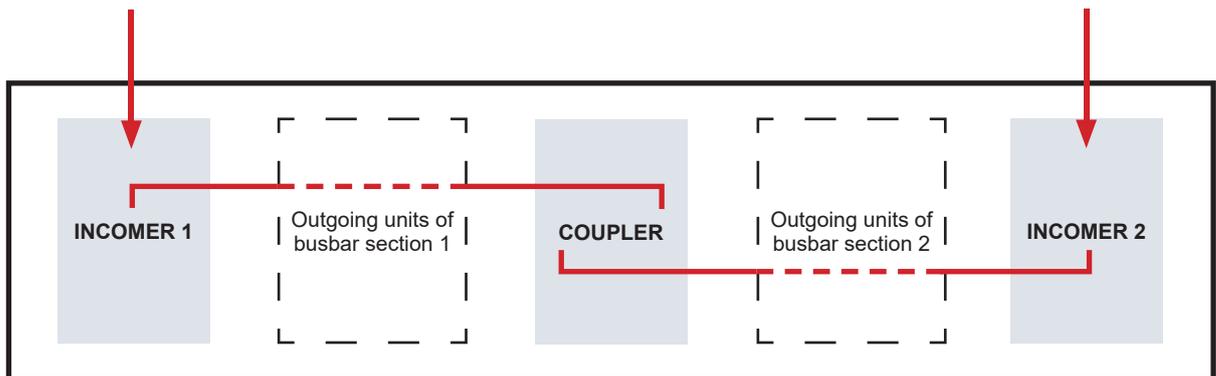
Side view

\* Separation plates, Doors, Covers are not shown

## MAIN BUSBAR ARRANGEMENT EXAMPLE

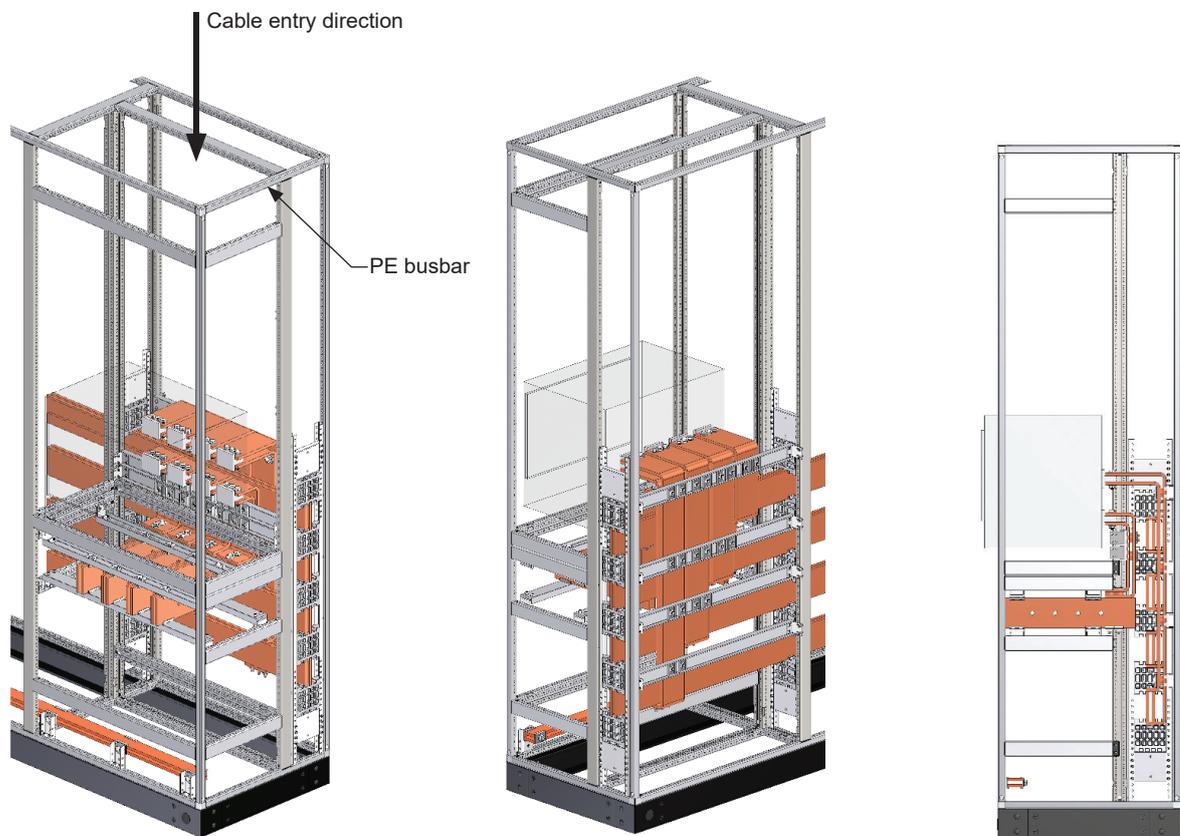
### TECHNICAL PROPERTIES

Main Busbar location	- Rear
Type of main busbar holder	- MAB/ BH
Cable entry direction	- Top



Techno Module panel configuration

### Incomer 1



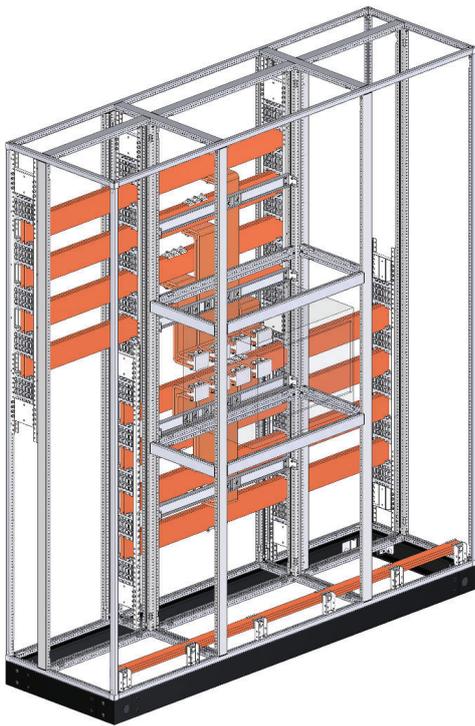
Front view

Rear view

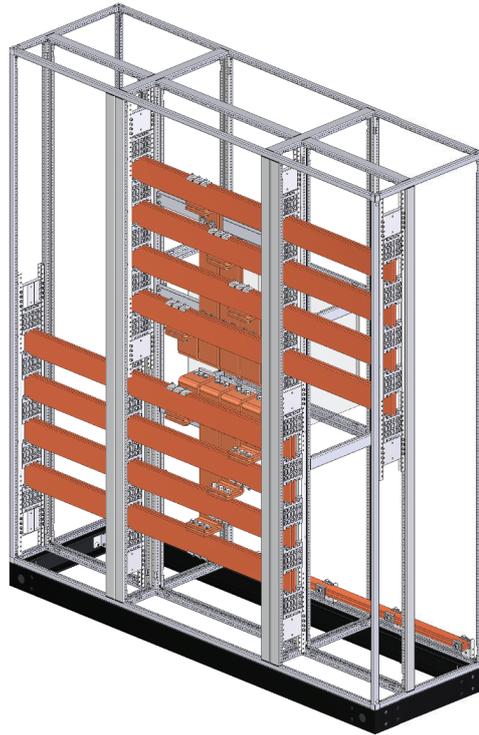
Side view

\* Separation plates, Doors, Covers are not shown

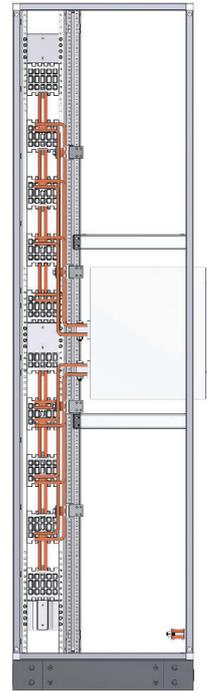
## Coupler



Front view

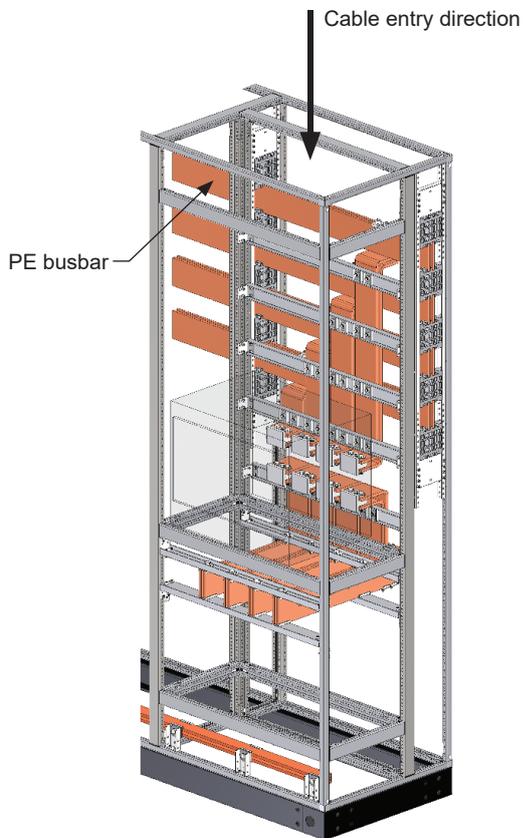


Rear view

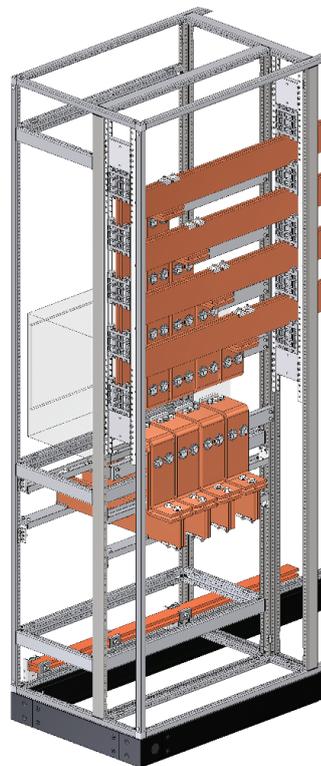


Side view

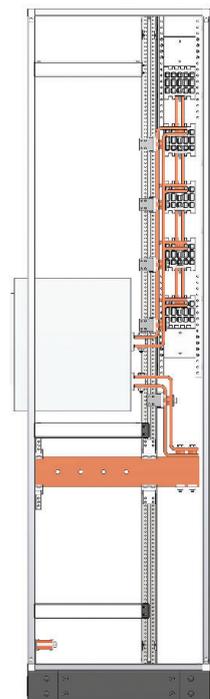
## Incomer 2



Front view



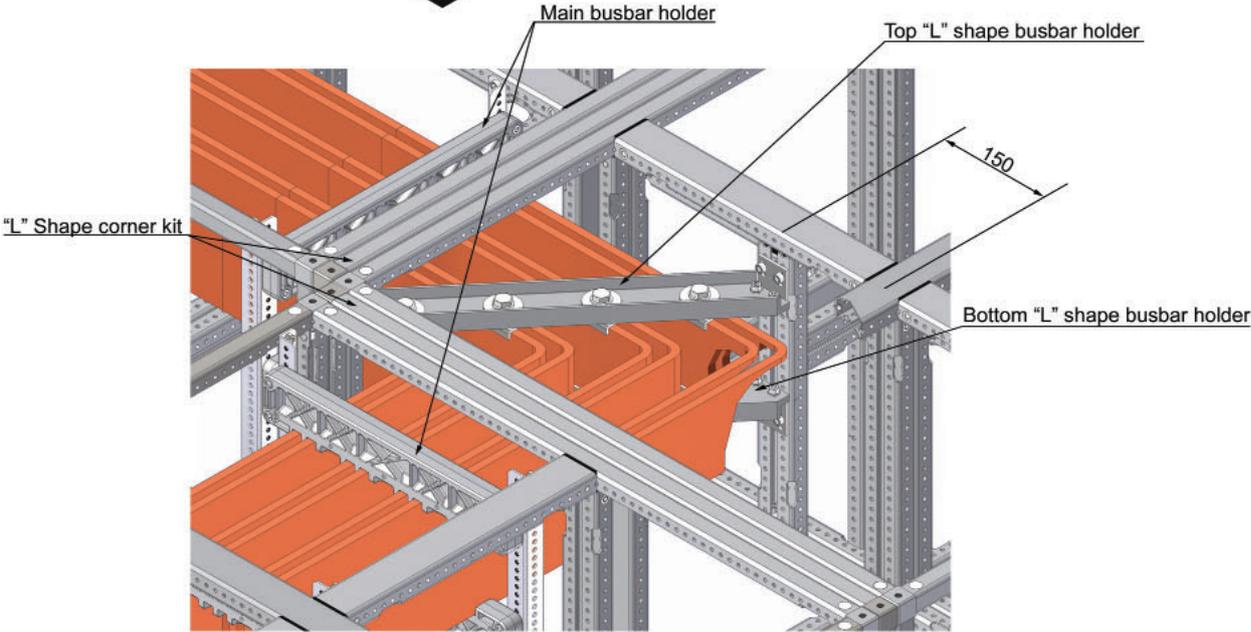
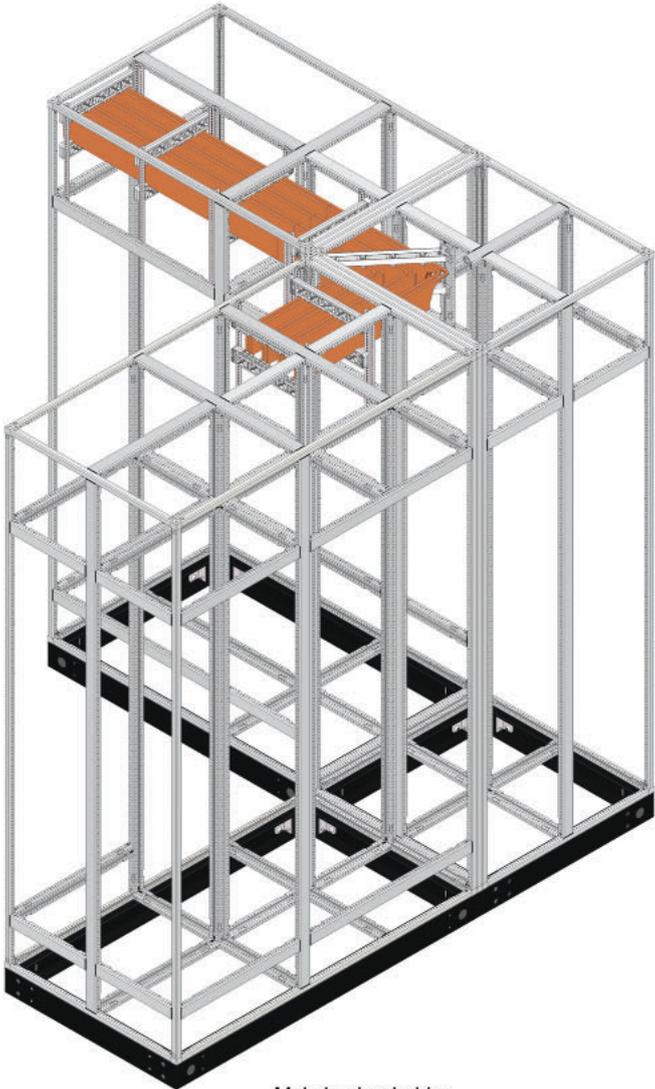
Rear view



Side view

\* Separation plates, Doors, Covers are not shown

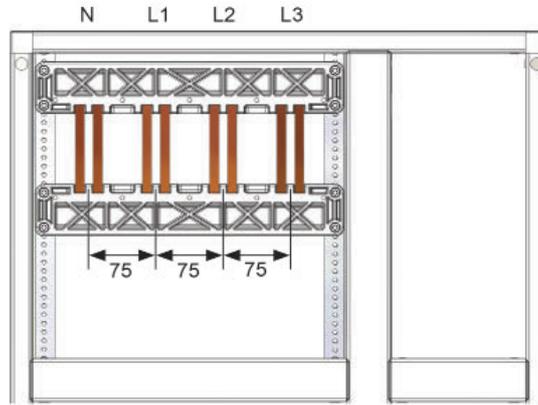
"L" SHAPE PANEL EXAMPLE



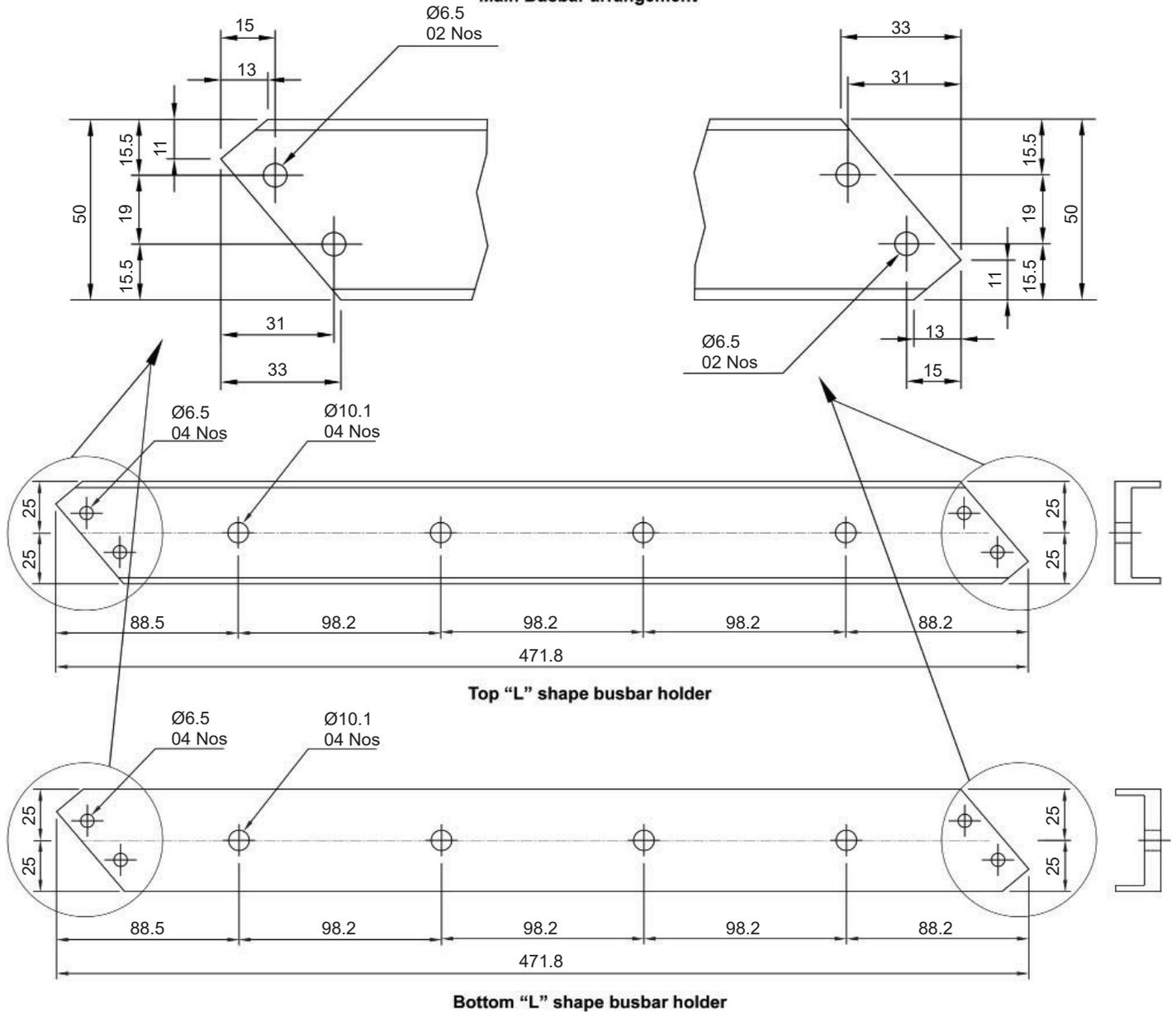
\* Separation plates, Doors, Covers are not shown

## TECHNICAL PROPERTIES

- Type of Main Busbar Holder - OMH 400
- Quantity of Cu bars - 02 Cu bars per phase



**Main Busbar arrangement**

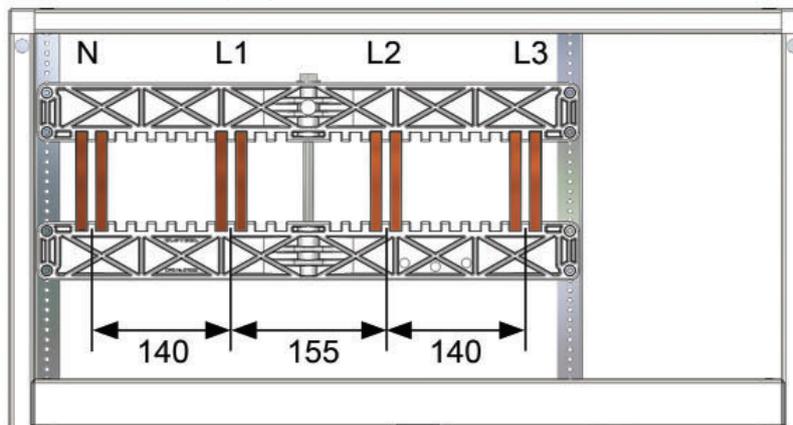


Note : To manufacture "L" shape busbar holders please use Isolation Profile (20650).

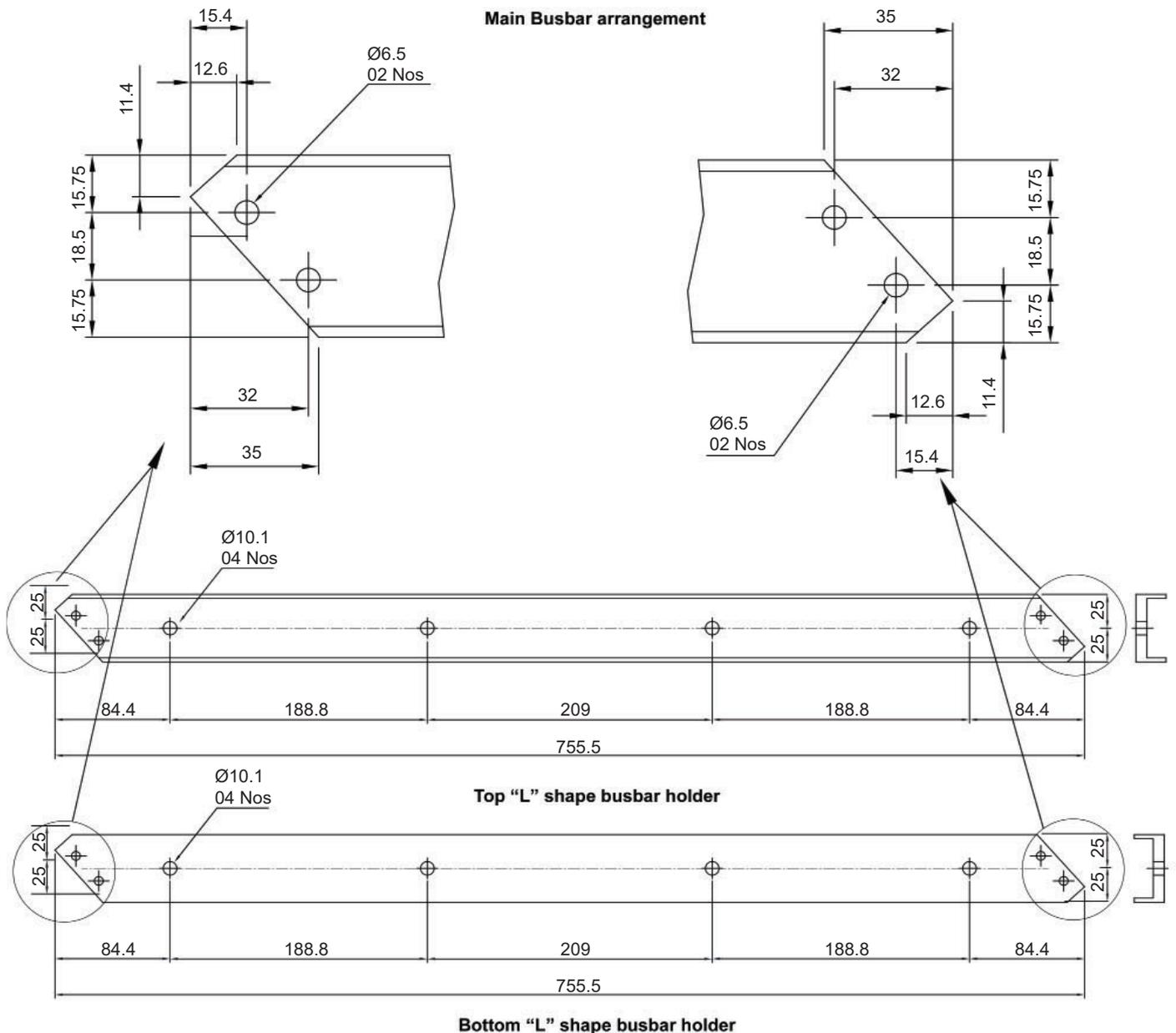
## TECHNICAL PROPERTIES

Type of Main Busbar Holder - OMH 600

Quantity of Cu bars - 02 Cu bars per phase



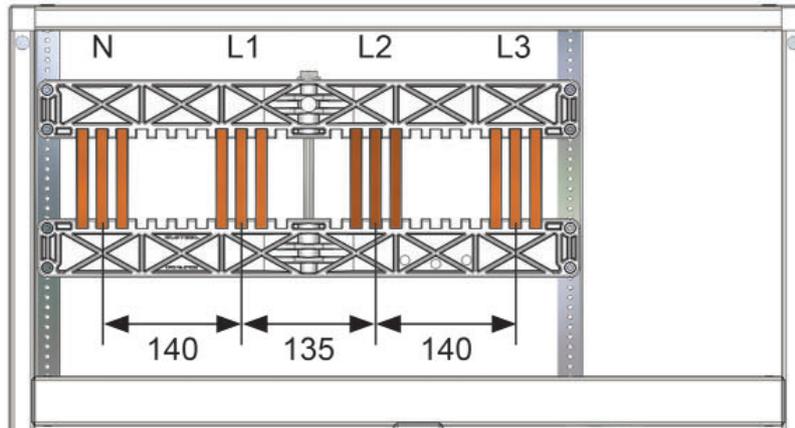
**Main Busbar arrangement**



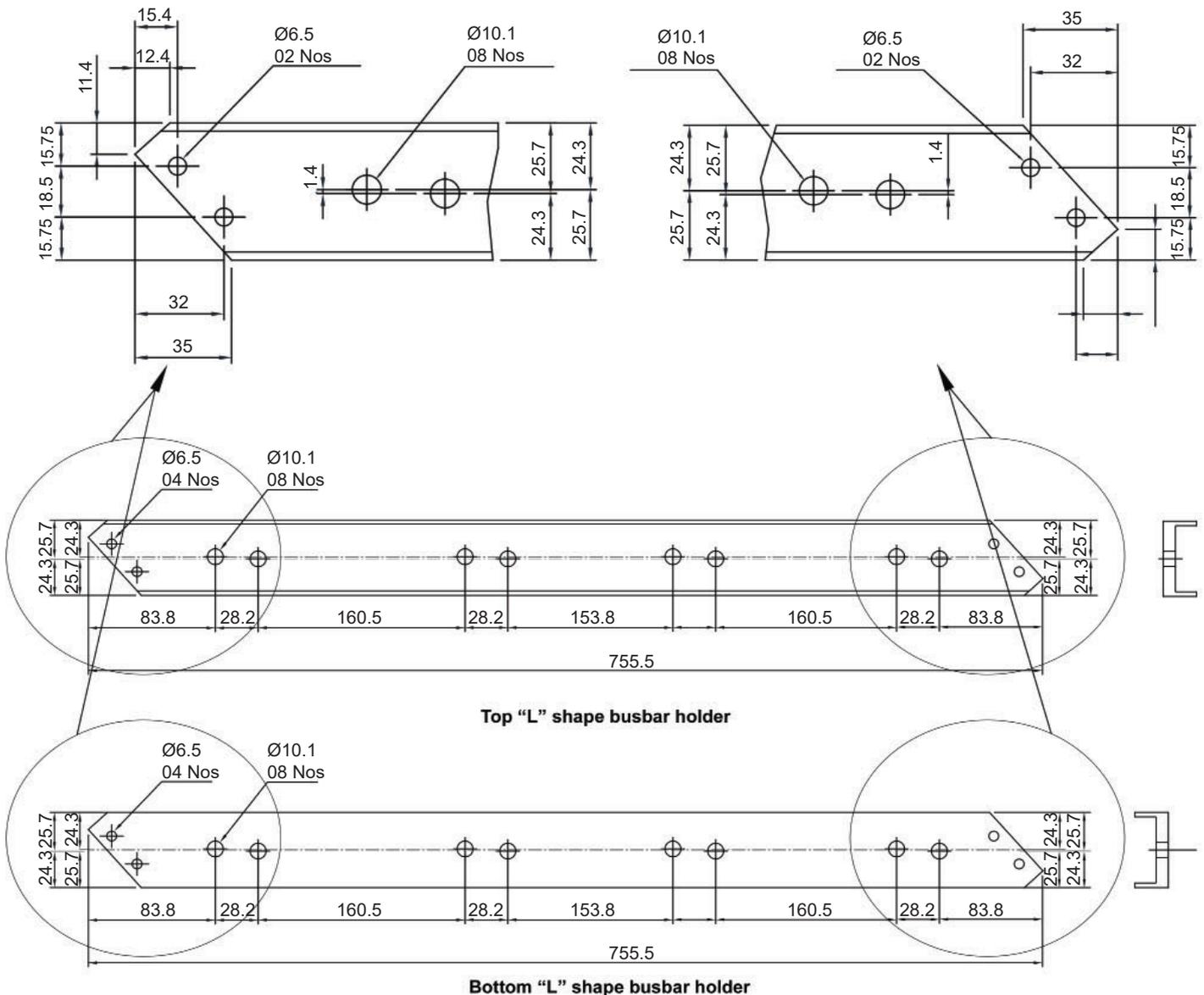
Note : To manufacture "L" shape busbar holders please use Isolation Profile (20650).

## TECHNICAL PROPERTIES

- Type of Main Busbar Holder - OMH 600
- Quantity of Cu bars - 03 Cu bars per phase



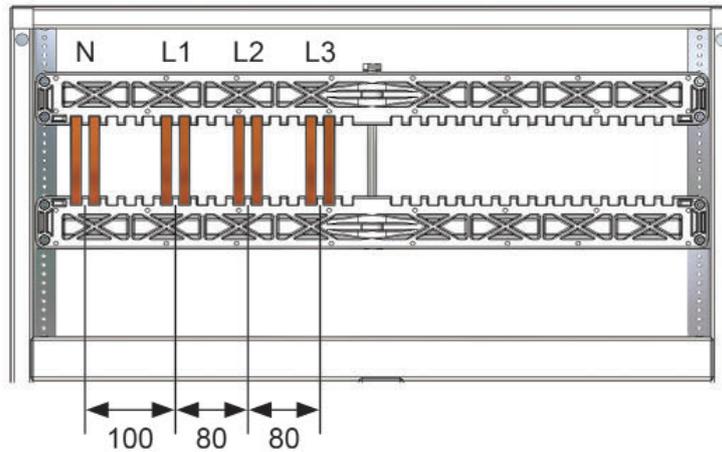
**Main Busbar arrangement**



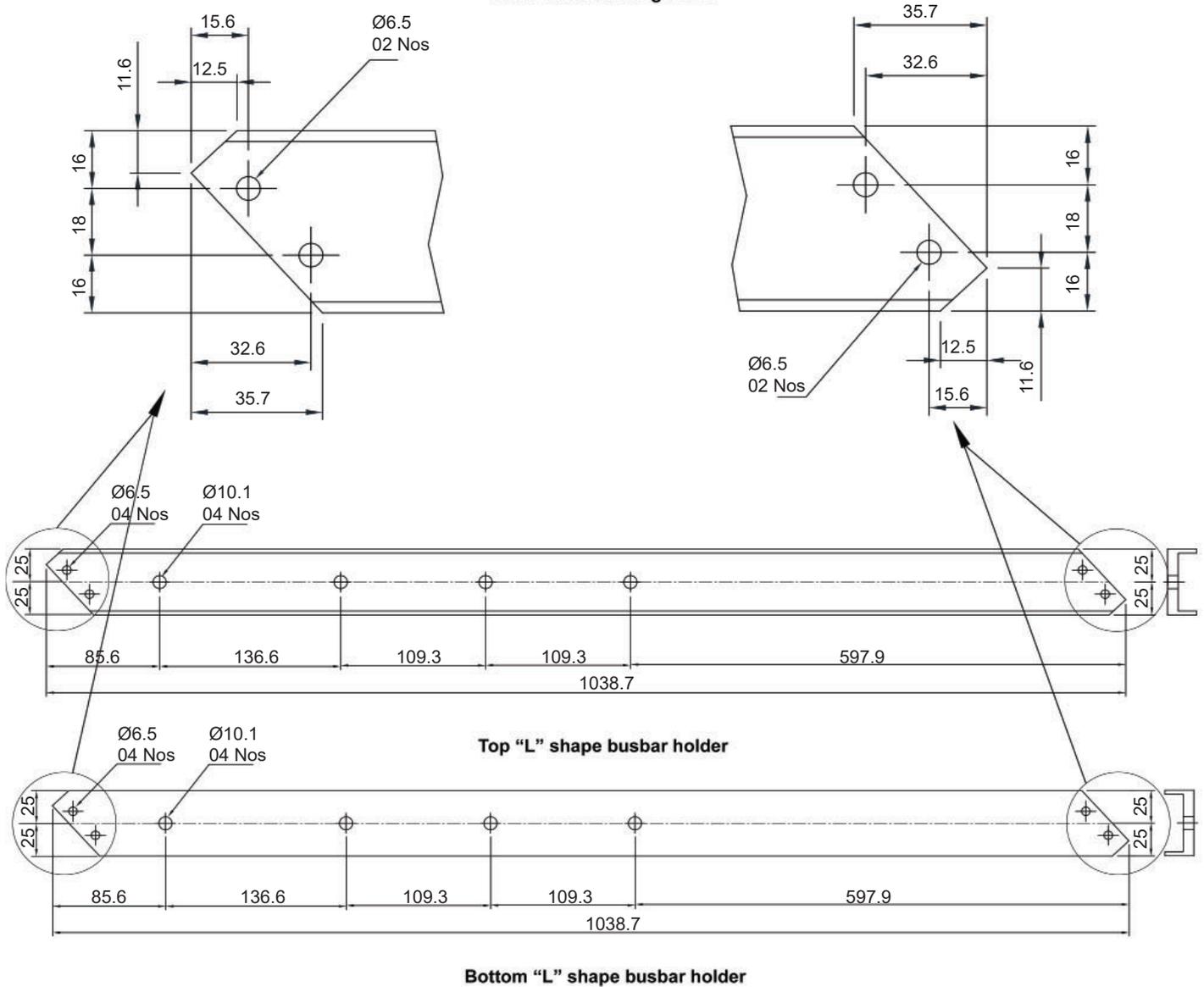
Note : To manufacture "L" shape busbar holders please use Isolation Profile (20650).

## TECHNICAL PROPERTIES

- Type of Main Busbar Holder - OMH 800
- Quantity of Cu bars - 02 Cu bars per phase



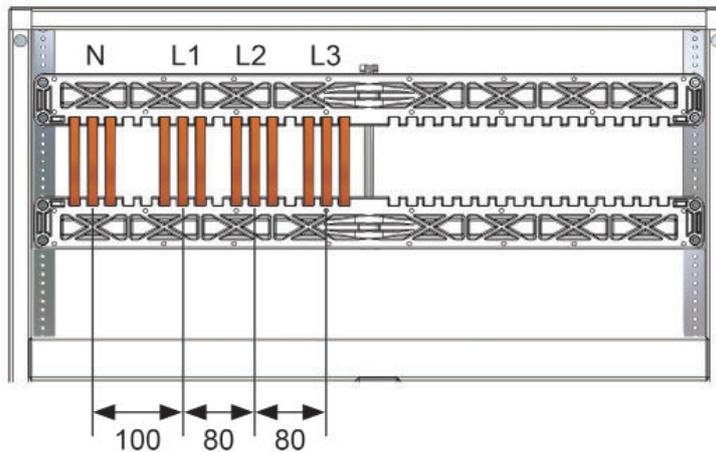
**Main Busbar arrangement**



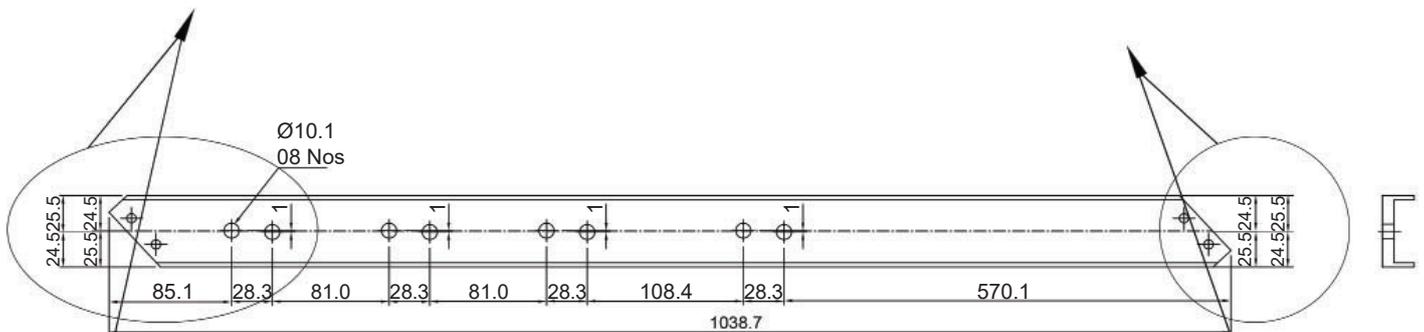
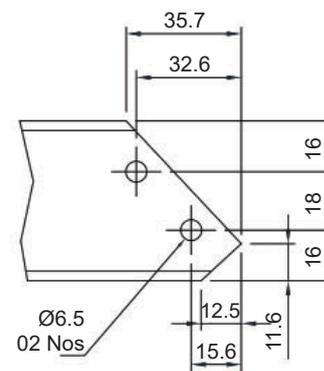
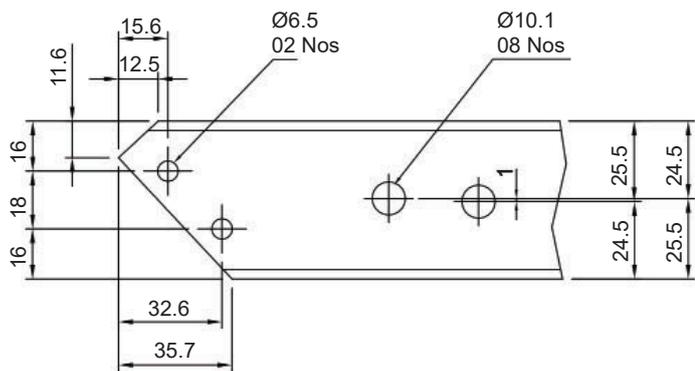
Note : To manufacture "L" shape busbar holders please use Isolation Profile (20650).

## TECHNICAL PROPERTIES

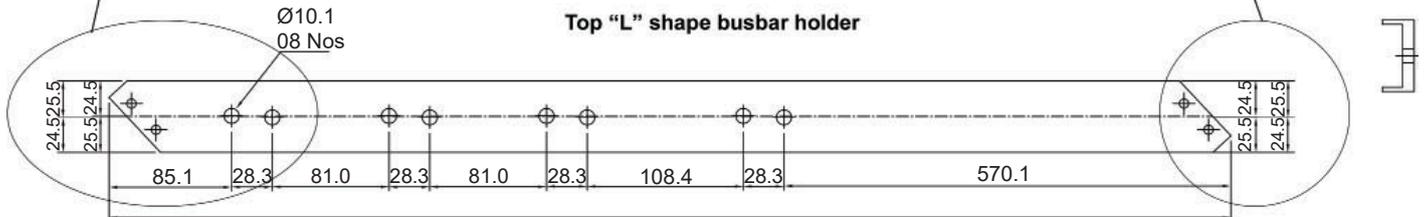
- Type of Main Busbar Holder - OMH 800
- Quantity of Cu bars - 03 Cu bars per phase



Main Busbar arrangement



Top "L" shape busbar holder

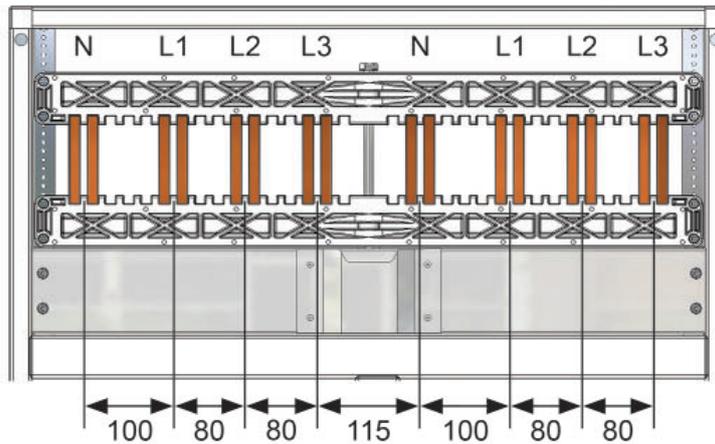


Bottom "L" shape busbar holder

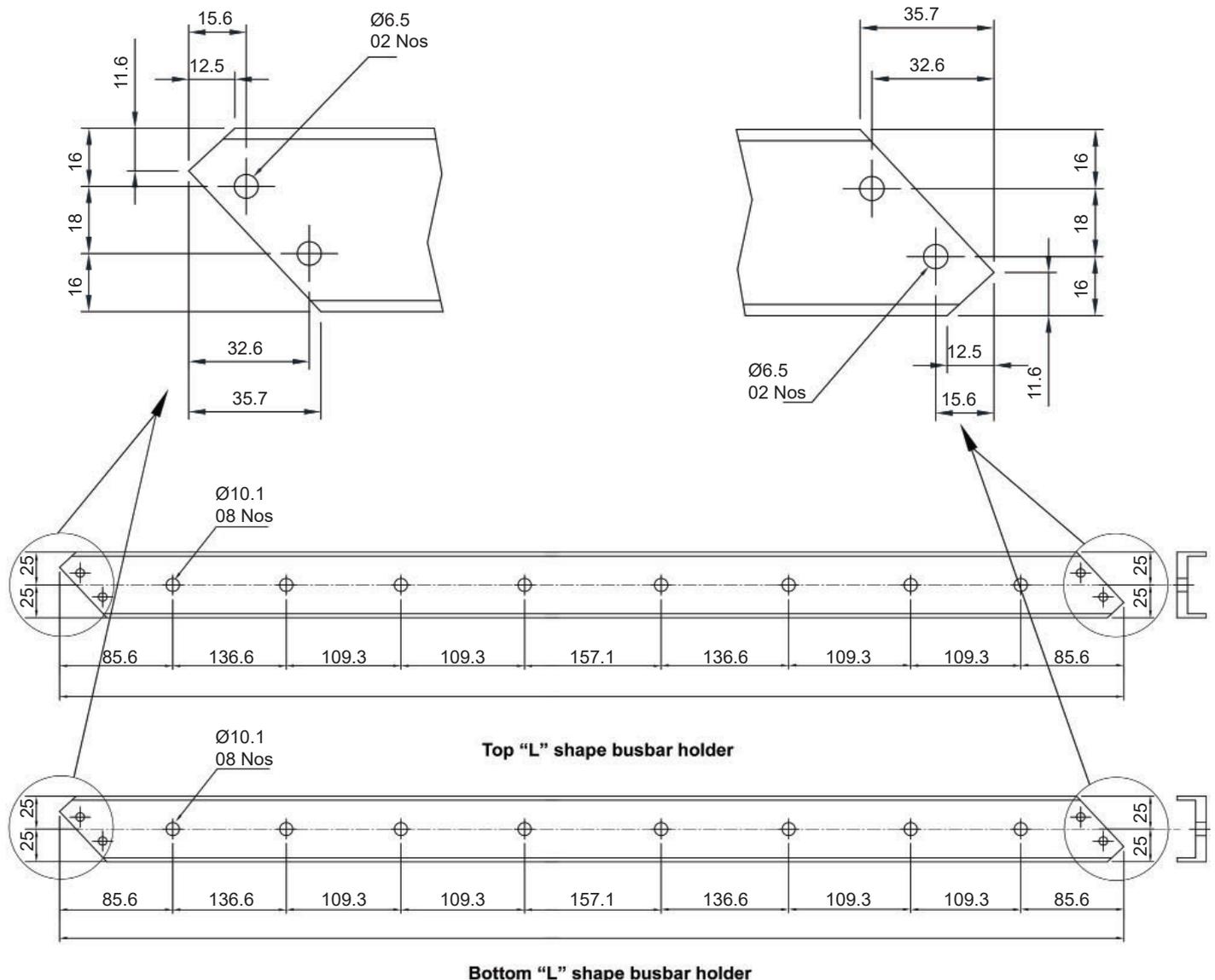
Note : To manufacture "L" shape busbar holders please use Isolation Profile (20650).

## TECHNICAL PROPERTIES

- Type of Main Busbar Holder - OMH 800
- Quantity of Cu bars - 04 Cu bars per phase



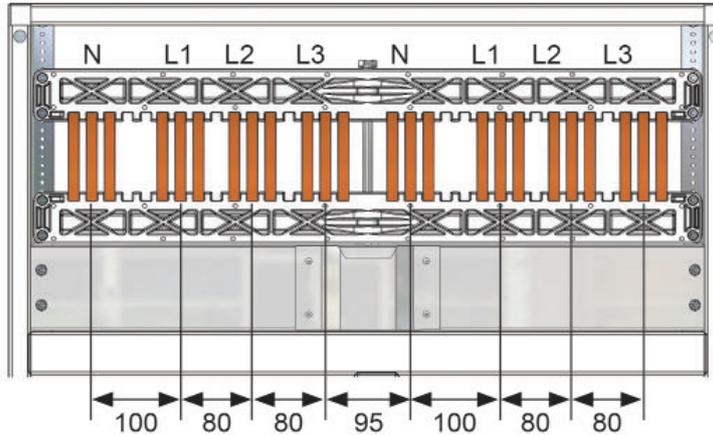
**Main Busbar arrangement**



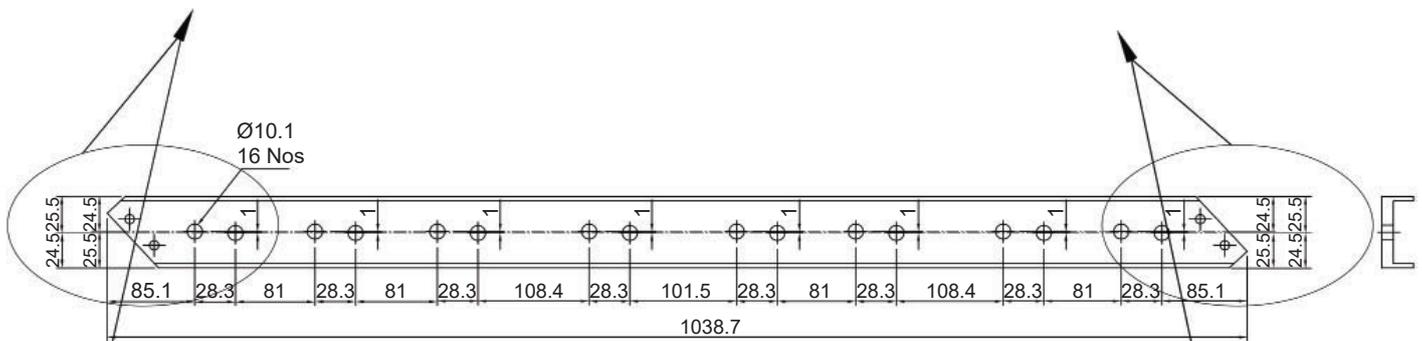
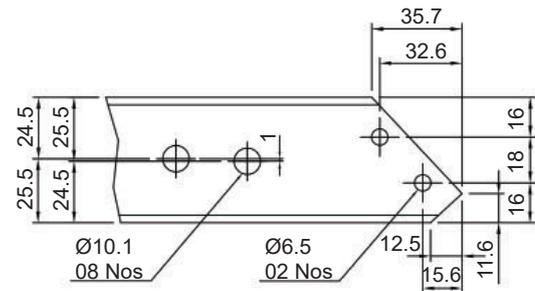
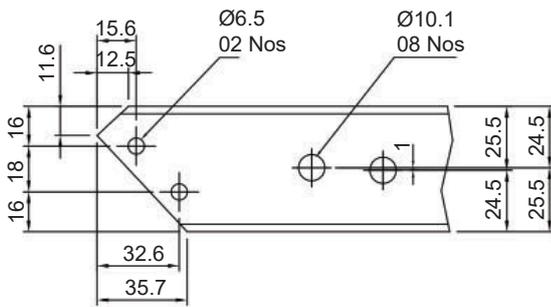
Note : To manufacture "L" shape busbar holders please use Isolation Profile (20650).

## TECHNICAL PROPERTIES

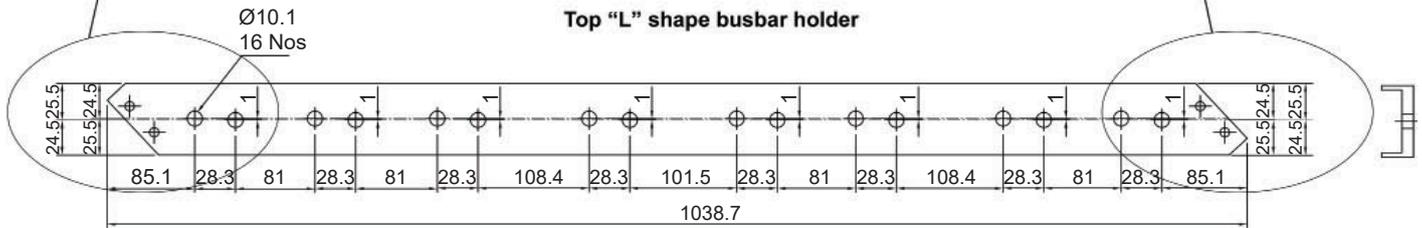
- Type of Main Busbar Holder - OMH 800
- Quantity of Cu bars - 06 Cu bars per phase



Main Busbar arrangement



Top "L" shape busbar holder



Bottom "L" shape busbar holder

Note : To manufacture "L" shape busbar holders please use Isolation Profile (20650).

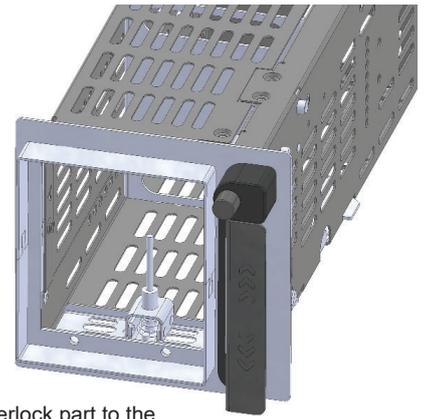
**SMALL UNITS**  
(WU 1.1-5.4, WU 1-5.1-5.4)

①



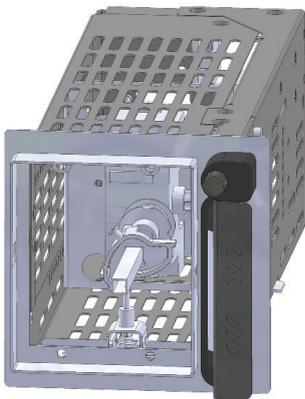
Parts of the interlock mechanism.

②



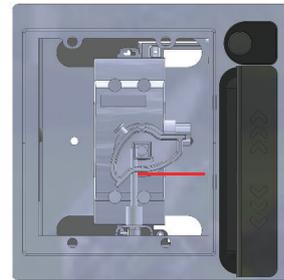
Attach the assembled interlock part to the bottom of the front end with screws.

③



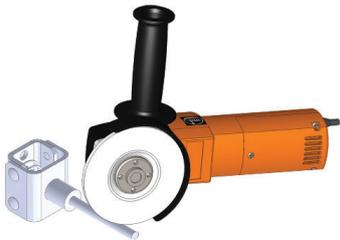
Insert the breaker rod through the interlock cam and tight the screw.

④



Make a mark the level of touching moving rod with interlock cam.

⑤



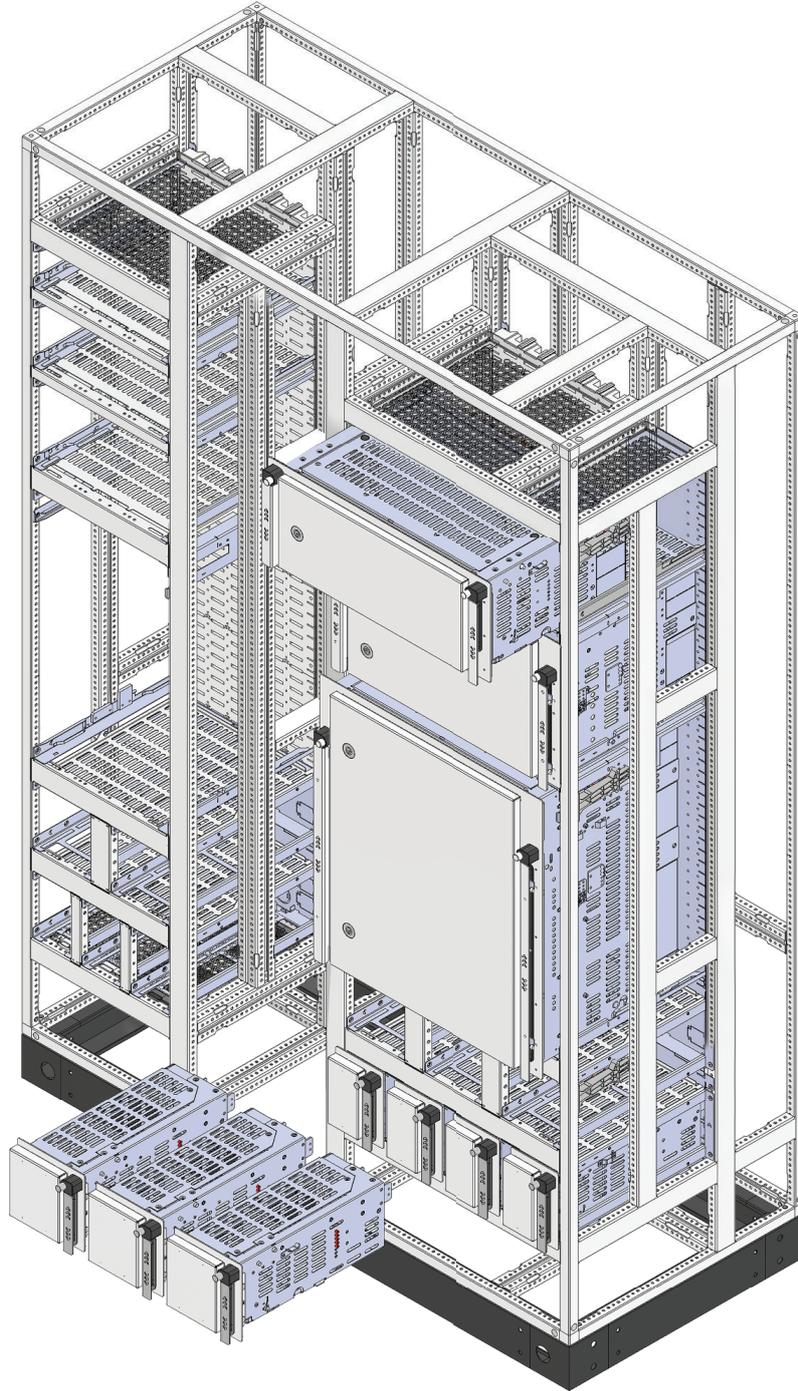
Then remove screws and take out the bottom interlock part and cut the moving rod at the mark. Make sure to radius the end of the rod.



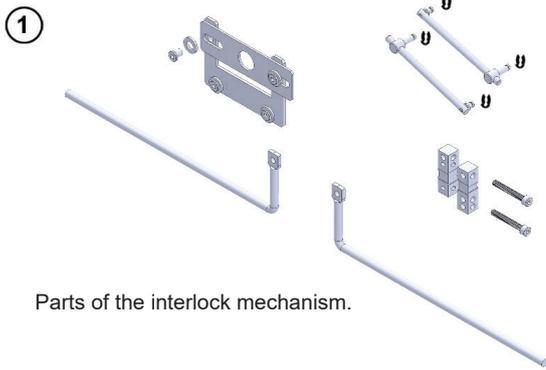
⑥



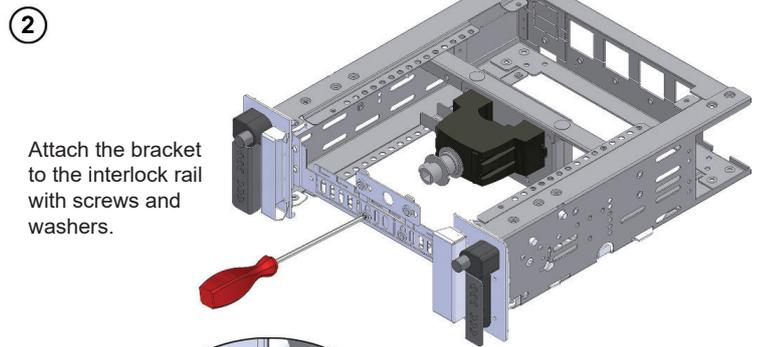
Again attach the bottom interlock part as the step 2.



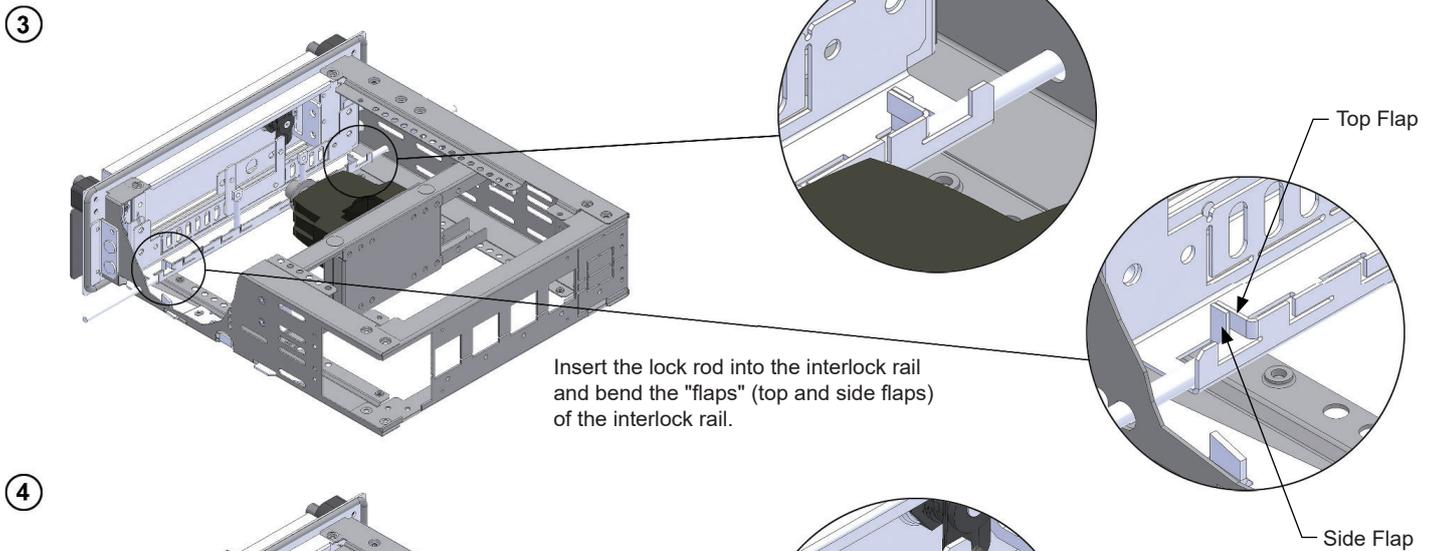
**UNITS UP TO 200 H**  
**(WU 4.1.4, WU 4.1-5.4, WU 4.2.4, WU 6.1.4, WU 6.1-5.4, WU 6.2.4)**



Parts of the interlock mechanism.



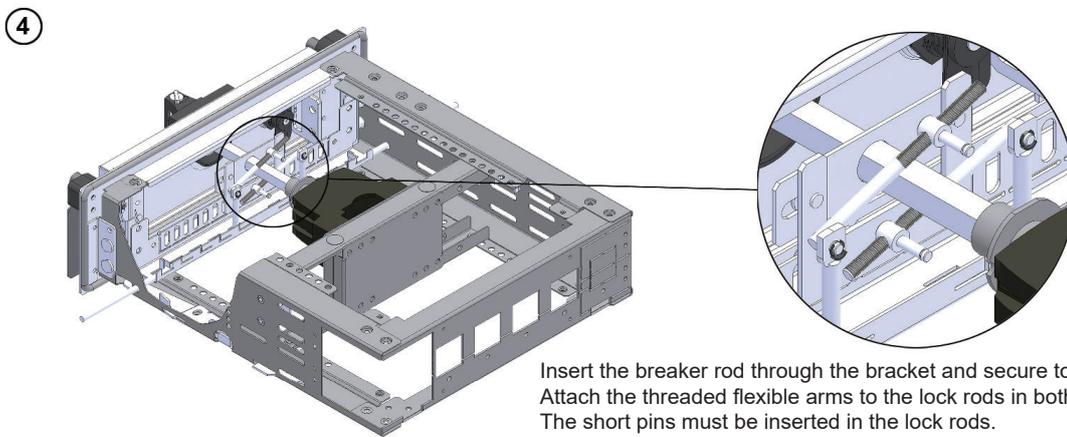
Attach the bracket to the interlock rail with screws and washers.



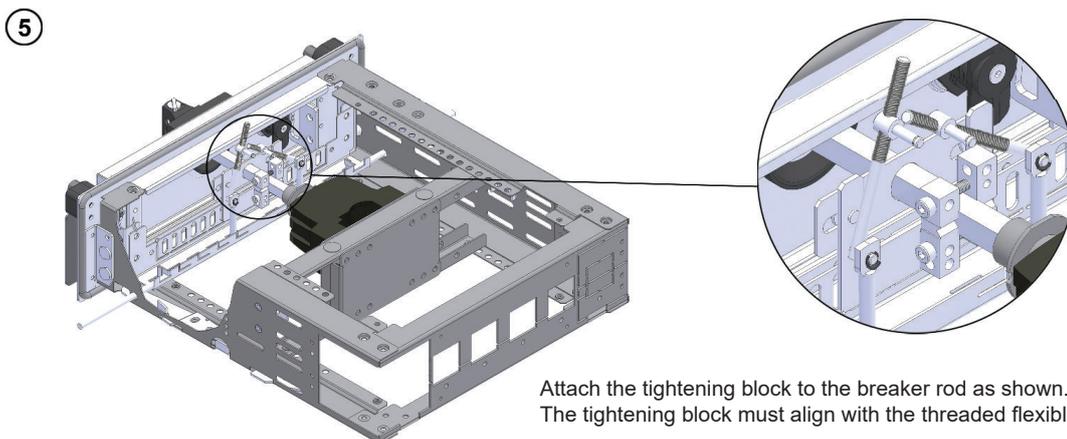
Insert the lock rod into the interlock rail and bend the "flaps" (top and side flaps) of the interlock rail.

Top Flap

Side Flap

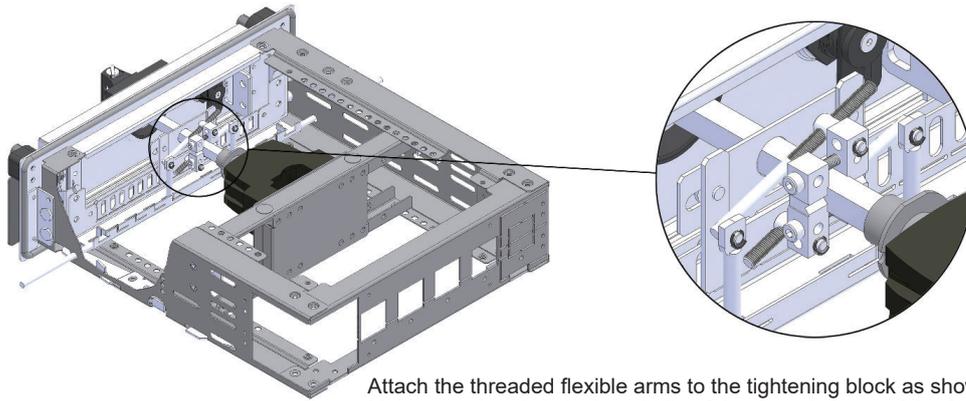


Insert the breaker rod through the bracket and secure to the breaker. Attach the threaded flexible arms to the lock rods in both sides. The short pins must be inserted in the lock rods.



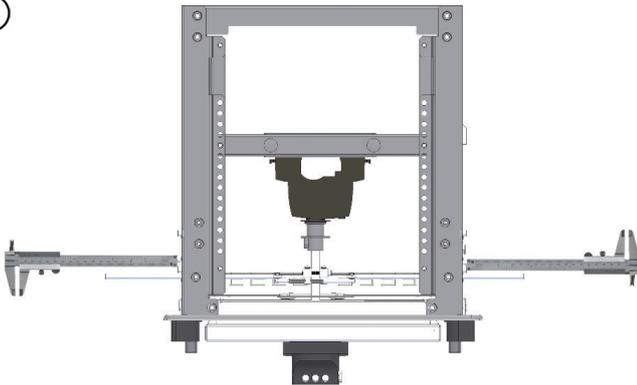
Attach the tightening block to the breaker rod as shown. The tightening block must align with the threaded flexible arm.

6



Attach the threaded flexible arms to the tightening block as shown. Make sure the pin is in the middle of the threaded part of the flexible arms.

7



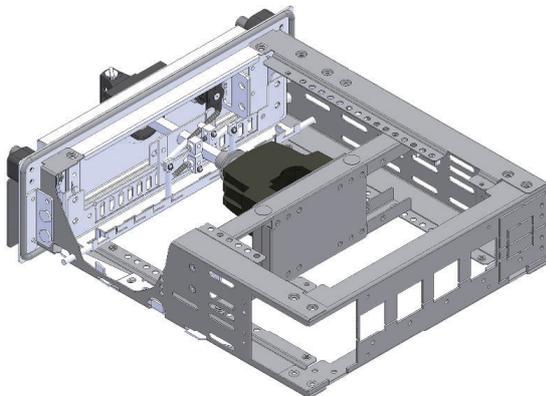
Turn the rotary handle to the ON position. Make a mark on the bended interlock rod approximately 10-11mm from the edge.

8



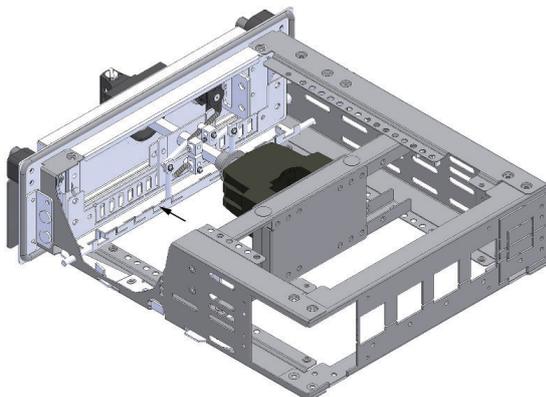
Remove cir-clips of the shorter pins and take out the bended interlock rods. Cut at the mark. Make sure to chamfer (atleast 2mm) the end of the rod.

9



Put the bended interlock rods back into the interlock rail and secure them with the cir-clips.

10

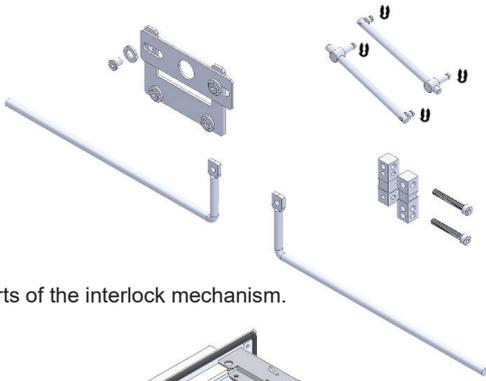


Now bend the rest of the "lock rod guiding flaps" (top & side flaps) as needed for smooth operation of interlock mechanism.

**UNITS ABOVE 200 H**

(WU 4.3.4, WU 4.4.4, WU 4.6.4, WU 4.8.4, WU 6.3.4, WU 6.4.4, WU 6.6.4, WU 6.8.4)

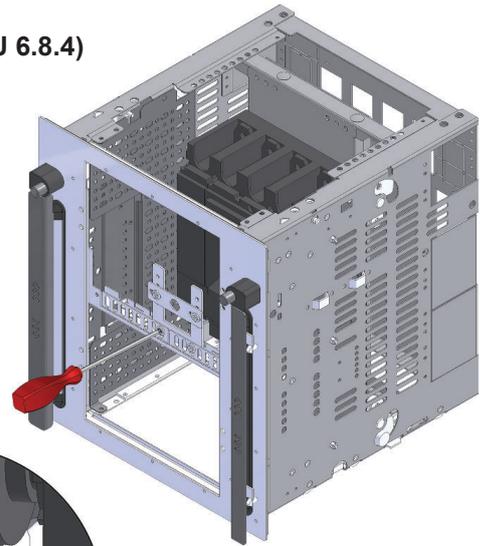
①



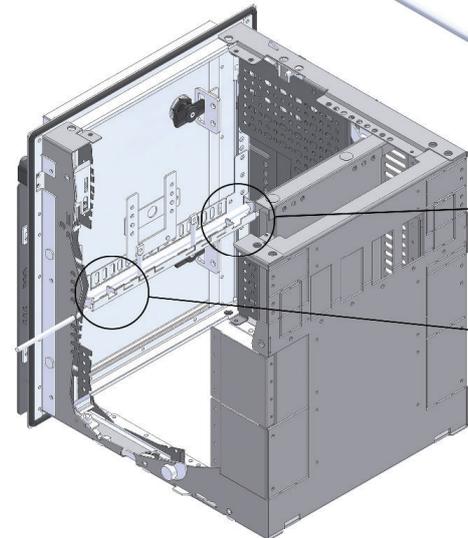
Parts of the interlock mechanism.

②

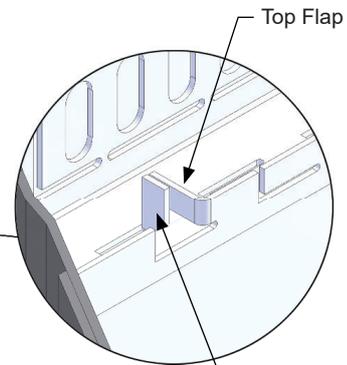
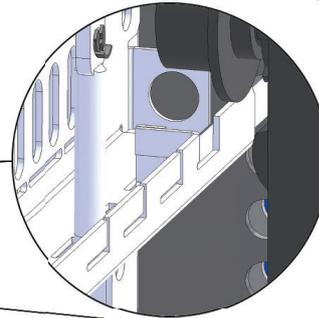
Attach the bracket to the interlock rail with screws and washers.



③



Insert the lock rod into the interlock rail and bend the "flaps" (top and side flaps) of the interlock rail.

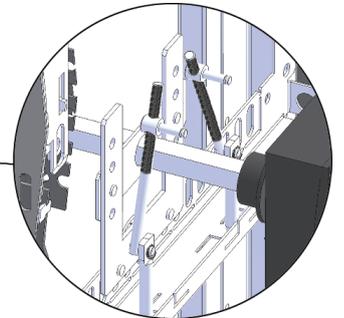
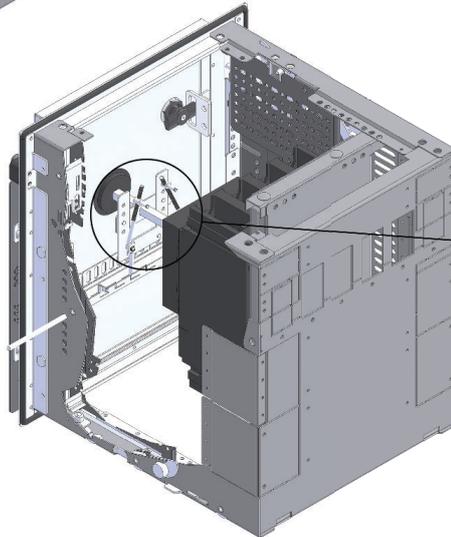


Top Flap

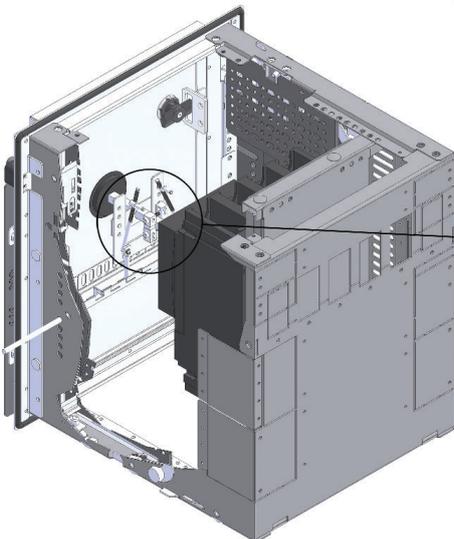
Side Flap

④

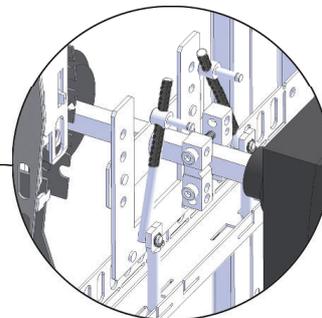
Insert the breaker rod through the bracket and secure to the breaker. Attach the threaded flexible arms to the lock rods in both sides. The short pins must be inserted in the lock rods.



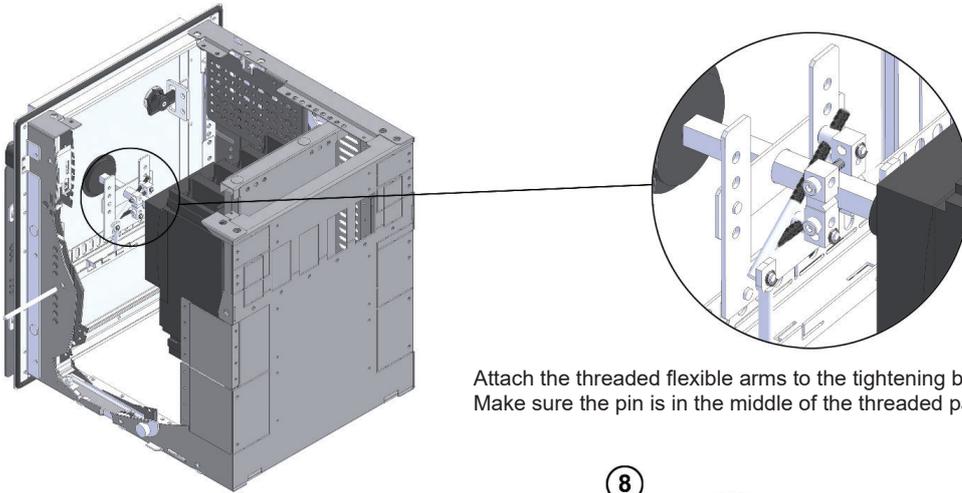
⑤



Attach the tightening block to the breaker rod as shown. The tightening block must align with the threaded flexible arm.

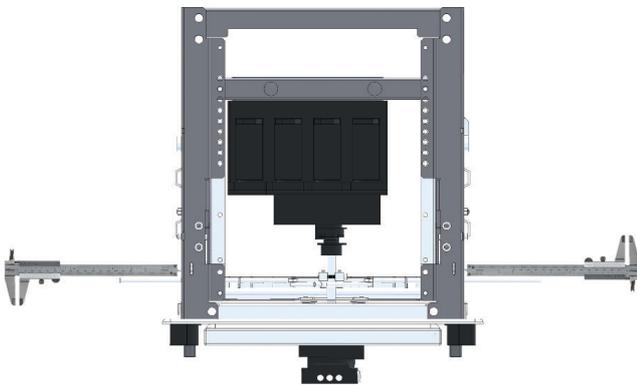


6



Attach the threaded flexible arms to the tightening block as shown. Make sure the pin is in the middle of the threaded part of the flexible arms.

7



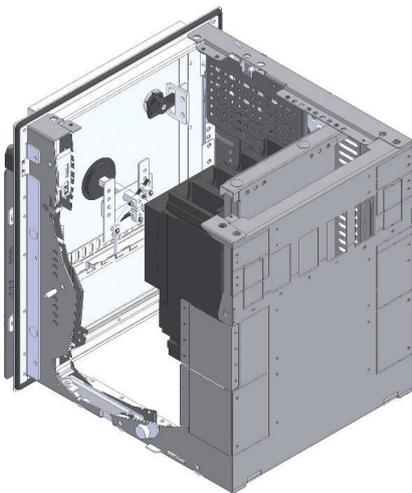
Turn the rotary handle to the ON position. Make a mark on the bended interlock rod approximately 5-7mm from the edge.

8



Remove cir-clips of the shorter pins and take out the bended interlock rods. Cut at the mark. Make sure to chamfer (atleast 2mm) the end of the rods.

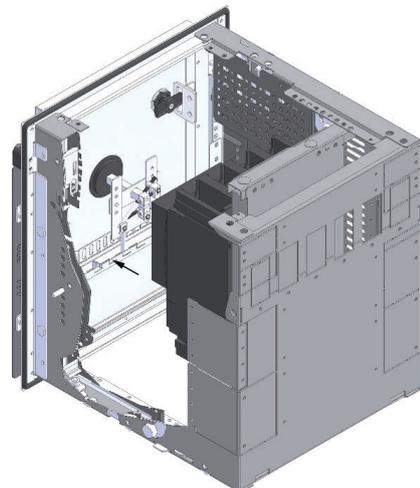
9



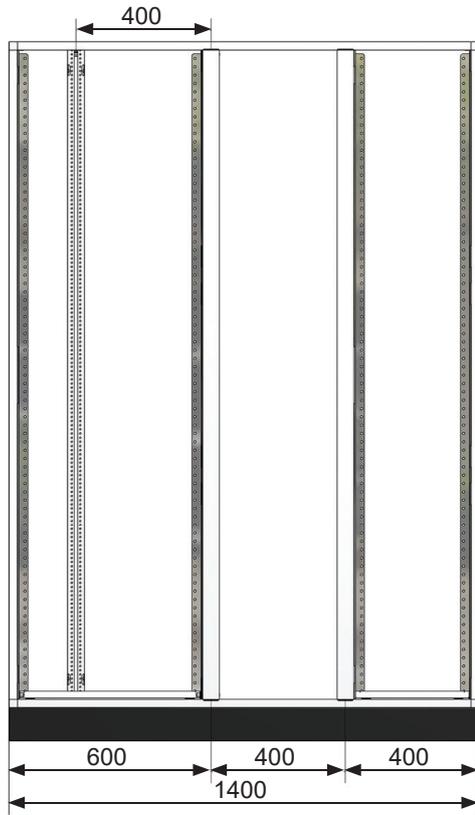
Put the bended interlock rods back into the interlock rail and secure them with the cir-clips.

Now bend the rest of the "lock rod guiding flaps" (top & side flaps) as needed for smooth operation of interlock mechanism.

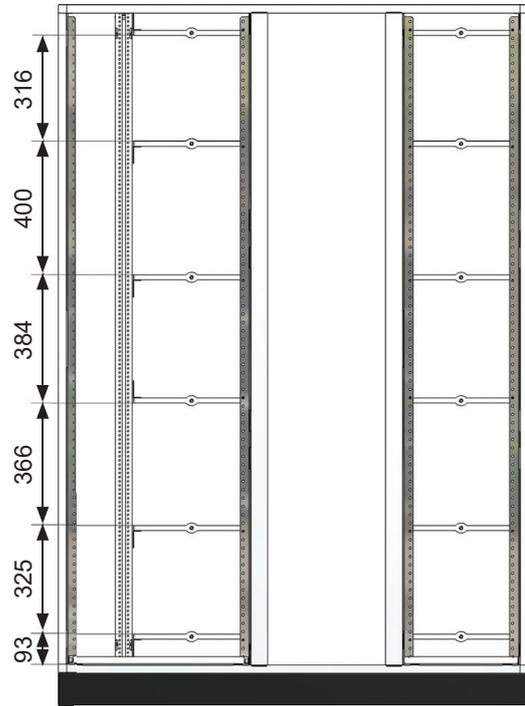
10



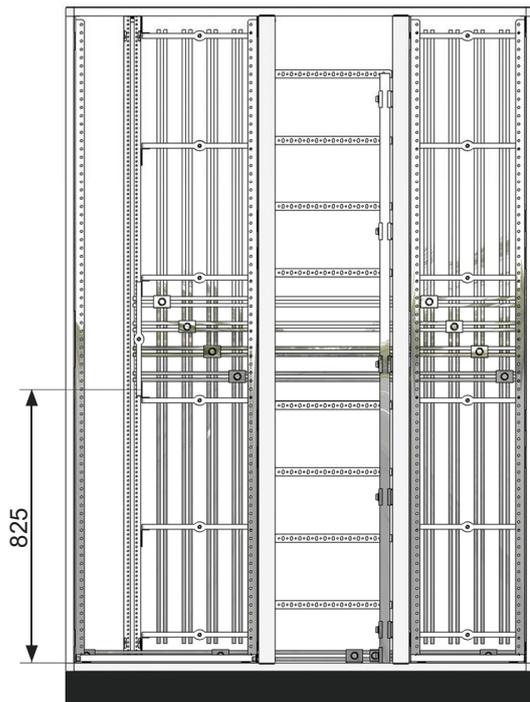
POSSIBLE TECHNO MODULE LIGHT ARRANGEMENT FOR TYPICAL MCCB UP TO 630A



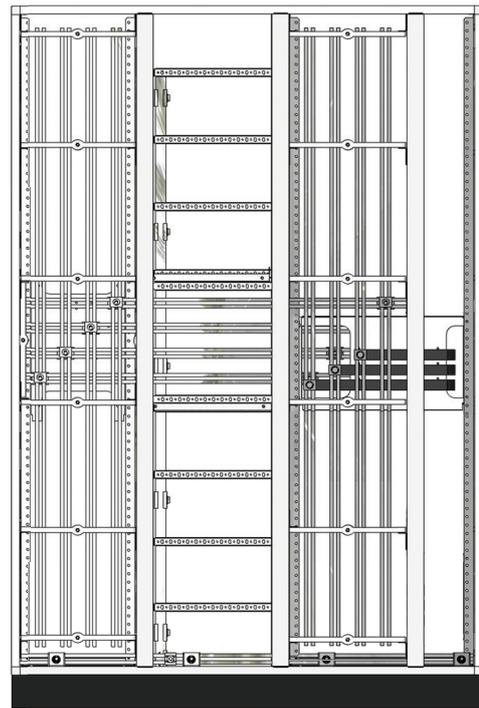
Front View



Front View

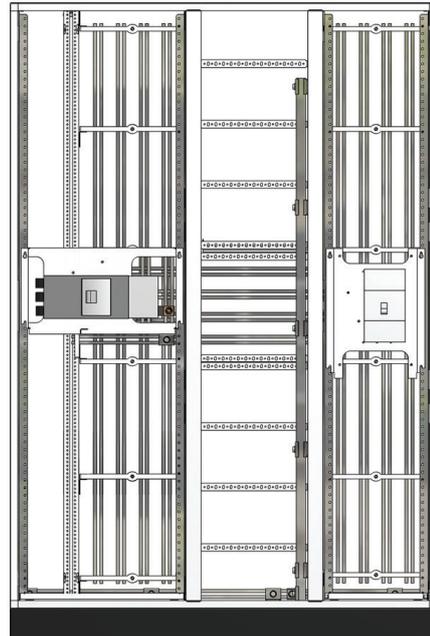


Front View

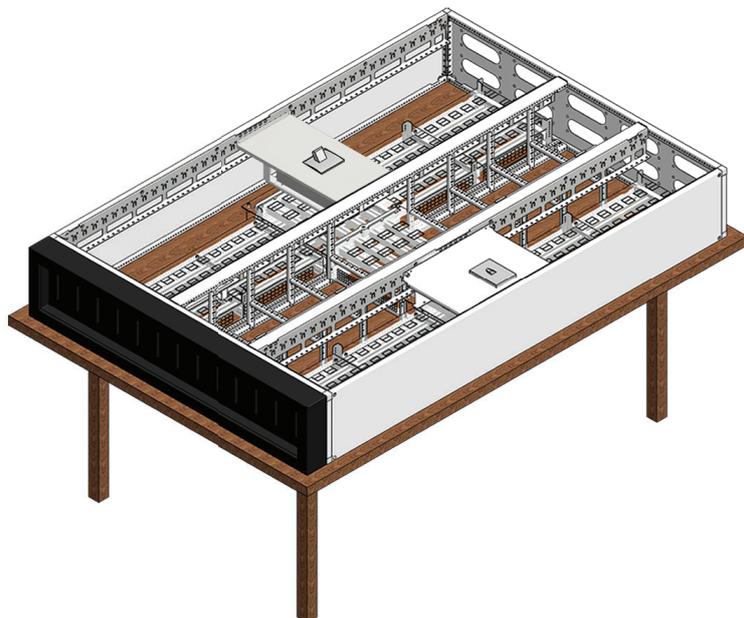
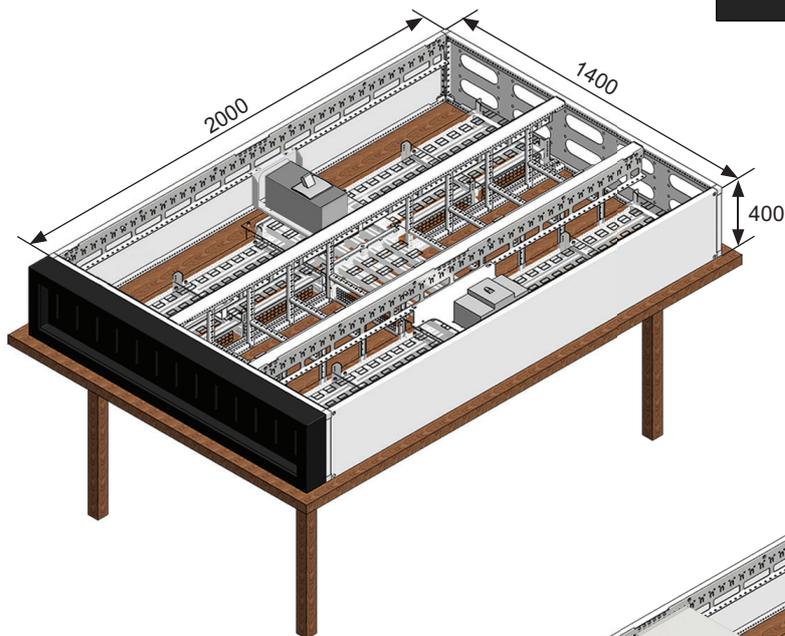


Rear View

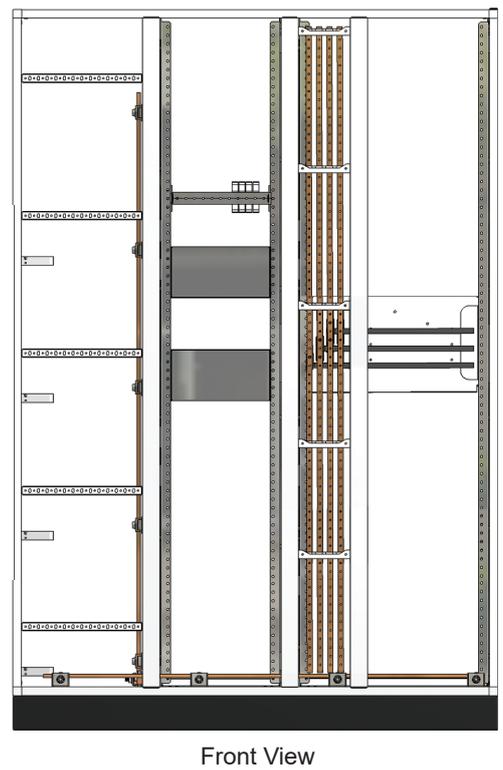
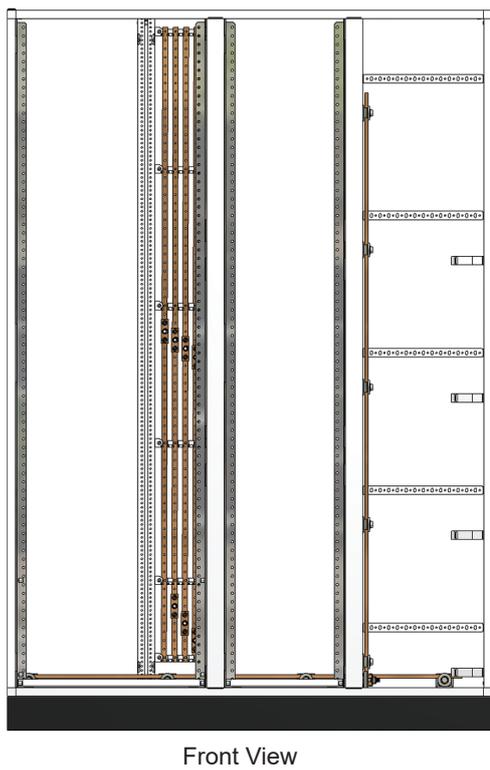
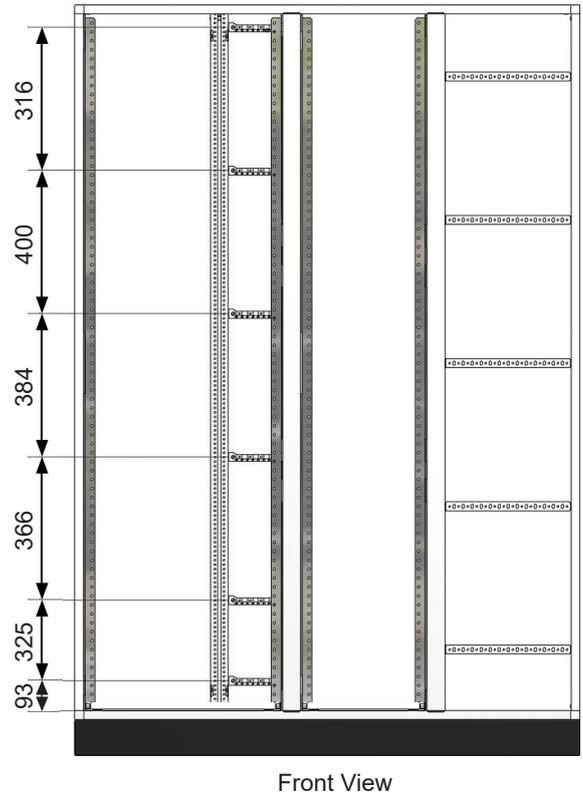
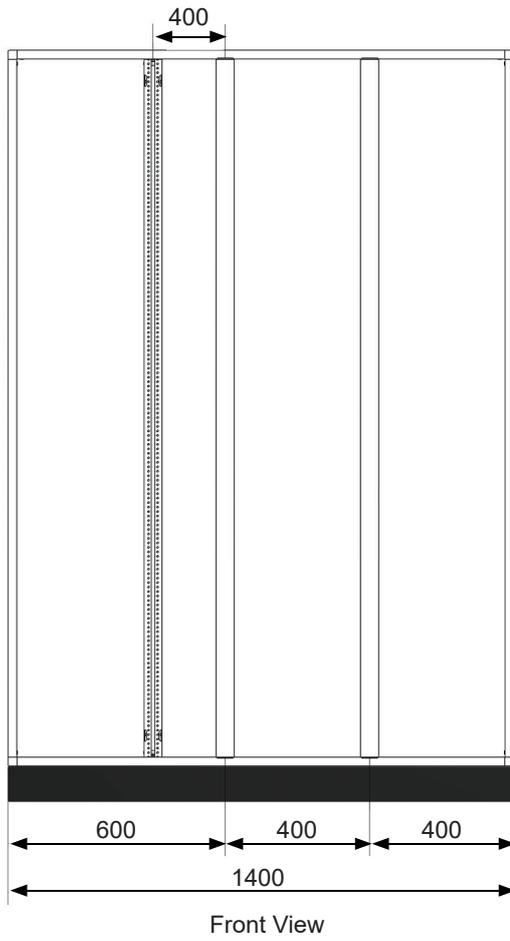
POSSIBLE TECHNO MODULE LIGHT ARRANGEMENT FOR TYPICAL MCCB UP TO 630A



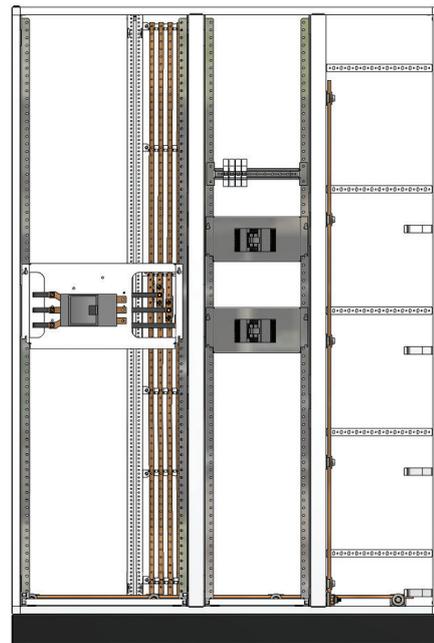
Front View



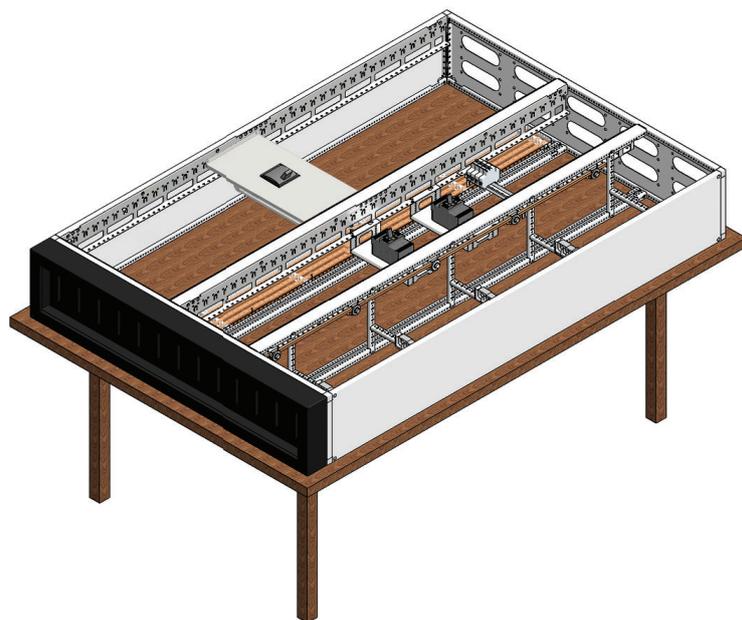
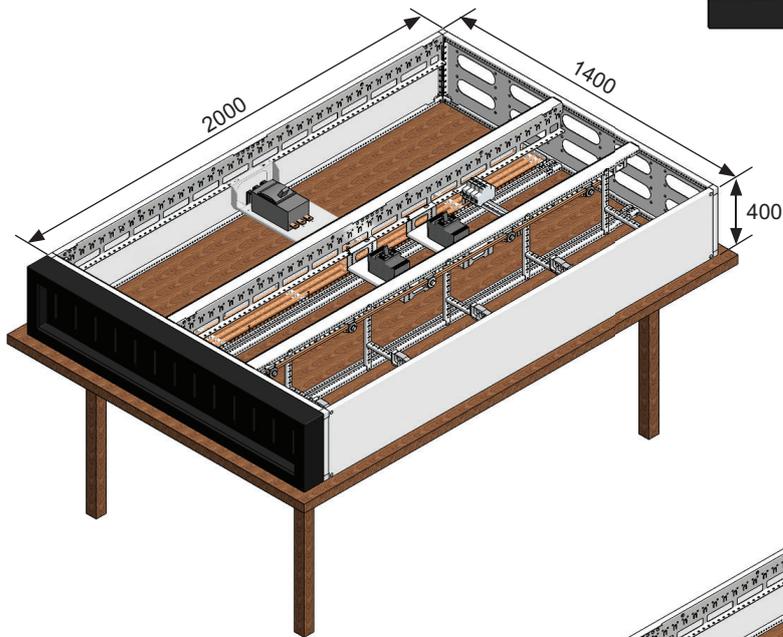
POSSIBLE TECHNO MODULE LIGHT ARRANGEMENT FOR TYPICAL MCCB UP TO 250A



POSSIBLE TECHNO MODULE LIGHT ARRANGEMENT FOR TYPICAL MCCB UP TO 250A



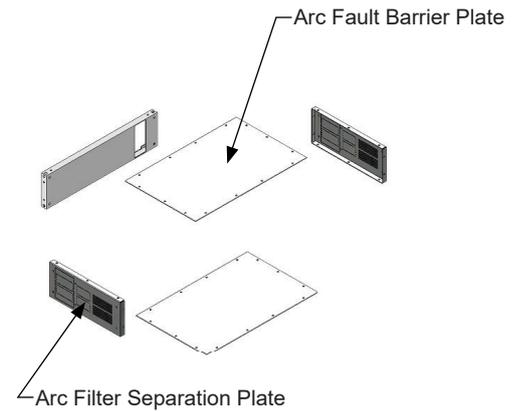
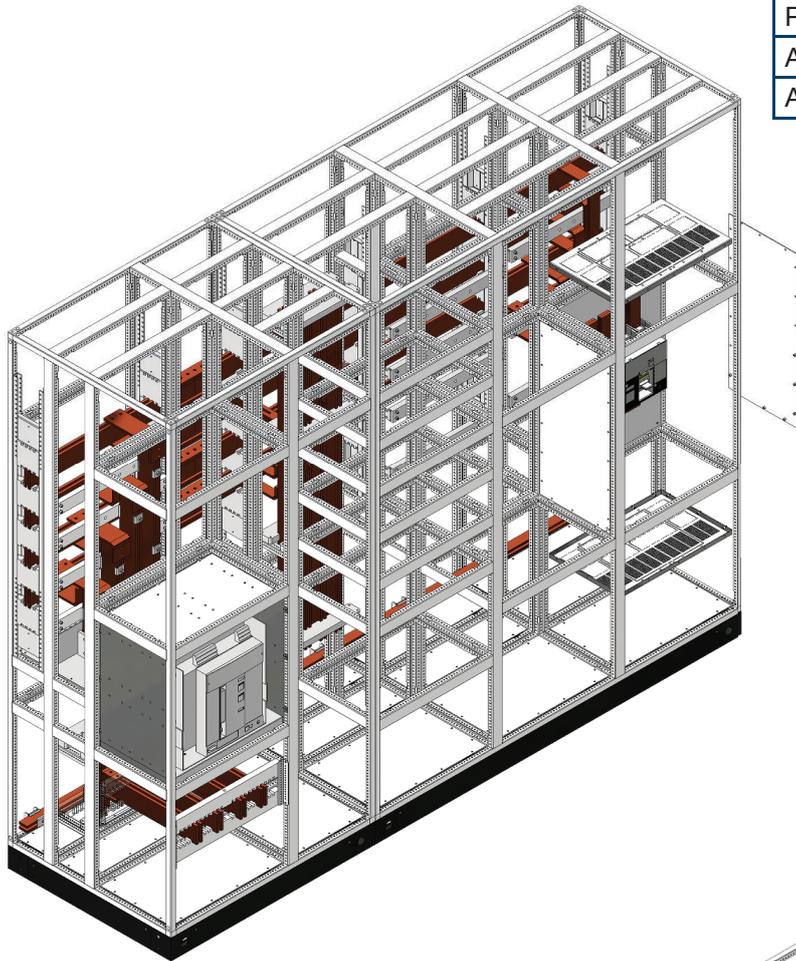
Front View



**PANEL CONSTRUCTION INCORPORATING ARC FILTER SEPARATION PLATES & ARC FAULT BARRIER PLATES.**

**Recommendations for 415 V**

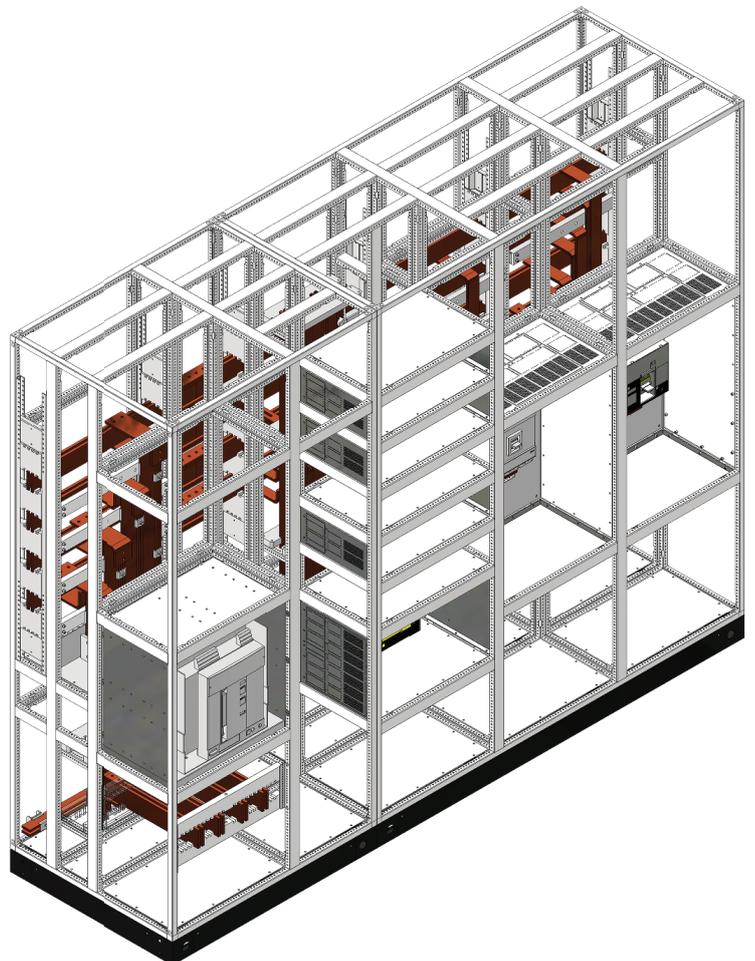
Rated operational voltage (Ue)	415 V
Permissible arcing current (I <sub>p arc</sub> )	up to 100 kA
Arc duration (t <sub>arc</sub> )	500 ms
Arcing Class	C



**PANEL CONSTRUCTION INCORPORATING FIXED TYPE COMPARTMENTS**

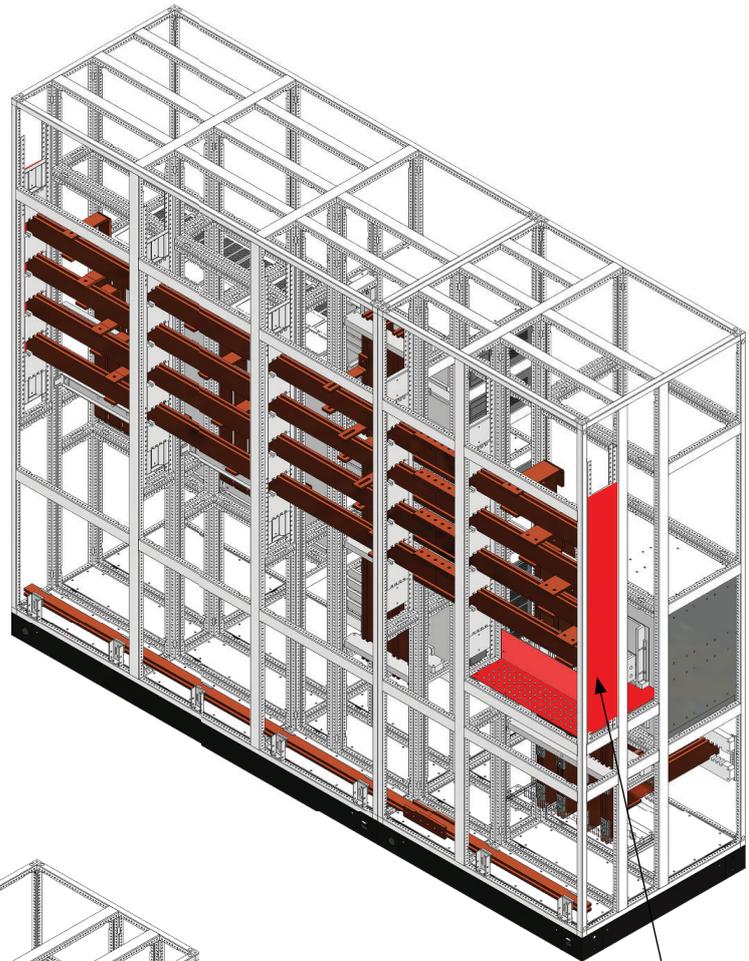
**Recommendations for 415 V**

Rated operational voltage (Ue)	415 V
Permissible arcing current (I <sub>p arc</sub> )	65 kA
Arc duration (t <sub>arc</sub> )	100 ms
Arcing Class	C

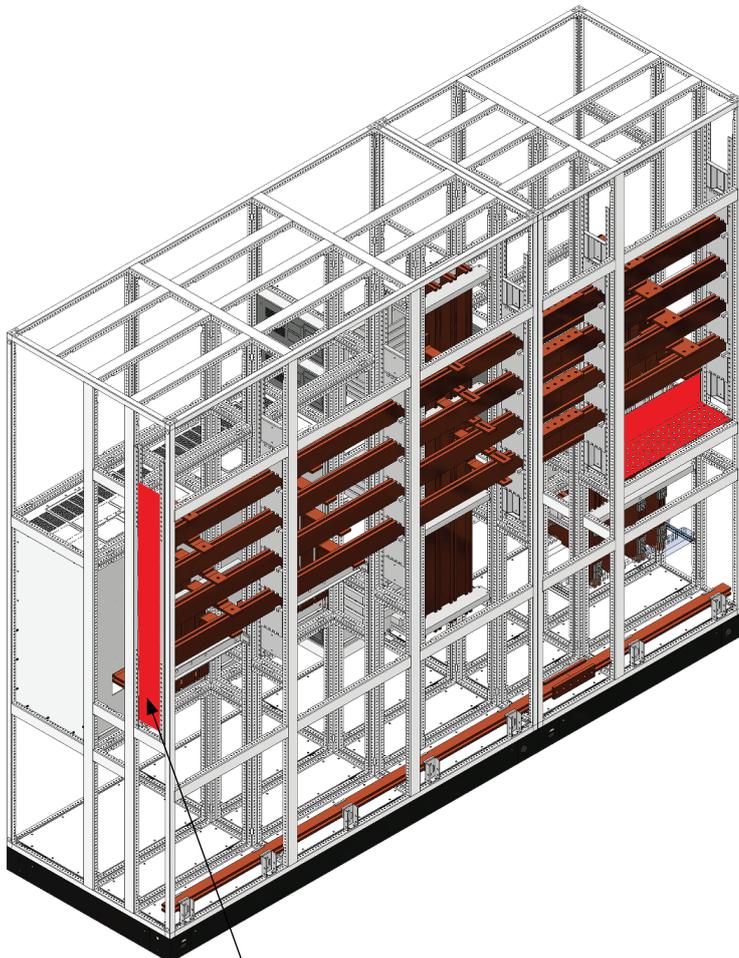


## GPO3 Material should be positioned at several locations:

- \* The end of the main busbars
- \* Between supply & load side of ACB's



GPO3 material



GPO3 material

MODULAR  
**ELSTEEL**  
ENCLOSURES



100% Danish  
Technology

Møllevej 9 C · 2990 Nivå · Denmark  
Tel +45 49 22 33 44 · [elsteel@elsteel.dk](mailto:elsteel@elsteel.dk)  
[www.elsteel.com](http://www.elsteel.com)