Steps for install electric board into back cover

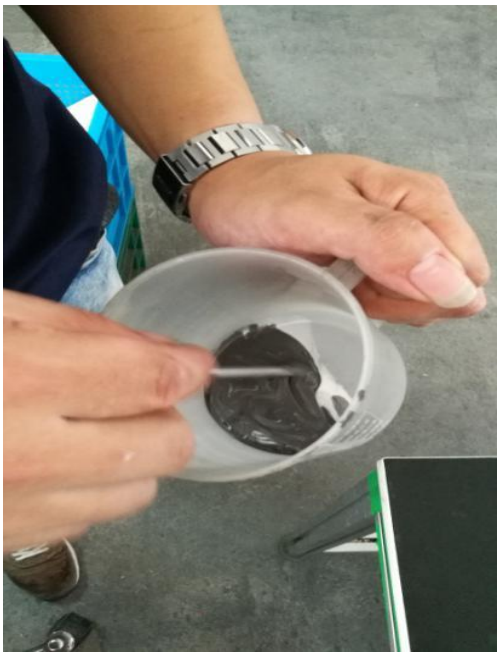
This is silicone solids elastomer, after using, tighten the opening cap and store for 6 months.

1. Clear up the back cover before potting. Make sure it is clean and dry.

2. 1st weighing and 1st mixing white thermal silicone with the black by ration 1:1 .

1pcs motor needs 10-15g(0.35oz-0.53oz) mixed dosage for 1st potting. Considering there is residue in container after potting, weight white silicone 10g/0.35oz and black thermal silicone 10g/0.35oz, and then mix them. The mix dosage is total 20g/0.7oz. Make sure the container is clean.

3. Stirring. Please stir evenly. (The silicone turns into gray after 10 minutes' stirring.) Make sure the tool is clean before stirring.



4. 1st potting: Pour 10-15g(0.35oz-0.53oz) to back cover. Spread the bottom surface evenly and completely cover the bottom surface, no bottom surface is bare. Attentions not pour/leak the silicone to ball bearing hole. Keep the bottom cover flat, wait till glue dried (become gel).

Temperature	Longest Gel time
20℃/77℉	24 hours
35℃/95℉	4 hours

Clean the residue in container, as it will also dry, can't be used for 2nd potting.

5. Put electric board on dried glue as pictures below:

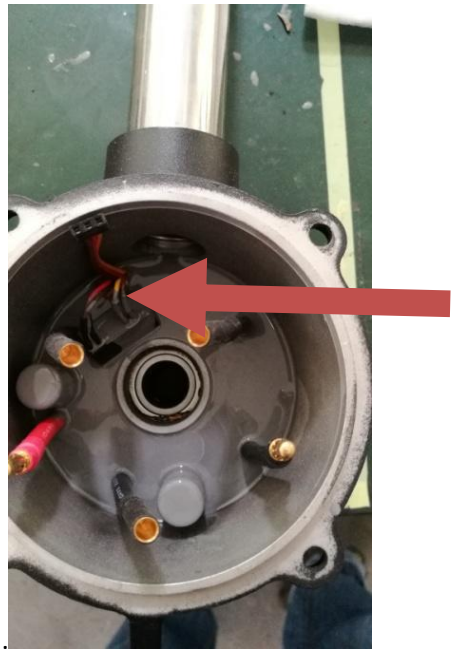
6. 2nd weighing and 2nd mixing white silicone with the black by ration 1:1 .

1pcs motor needs 30g mixed dosage for 2nd potting. Considering there is residue in container after potting, weight white silicone 20g/0.7oz and black thermal silicone 20g/0.7oz, and then mix them. The mix dosage is total 40g/1.4oz. Make sure the container is clean.

7. 2nd Stirring: Please stir evenly. (The silicone turns into gray after 10 minutes' stirring.) Make sure the tool is clean before stirring.

8. 2nd potting: Pour 30g(1.06 oz) on electric board. Evenly pour silicone on electric board and make sure all electronic components totally glued. Attentions not get silicone into terminals. Keep the electric board flat, wait till silicone dried (become gel).

Temperature	Longest Gel time
20℃/77℉	24 hours
35℃/95℉	4 hours



Note: for 36v&48v controller this component should be fixed by glue.

After the silicone becomes gel and controller is sealed, use multimeter to test if there is short circuit between the controller plug and uncoated aluminum back cover. If there is short circle, take out controller and seal it again. If no short circle, go next steps to assemble the whole motor house.

Thermal silicone elastomer:

Usually it's two-components, with higher thermal dissipation, and a little bit lower shrinkage.

It's used as potting protection for high-power electronic components, module power supply and circuit boards with higher requirements for cooling and temperature resistance, such as switching power supply, driving power, module power supply for automobile HID lights.