

Technical Bulletin

Routing of Internal Busbars on M24 New Generation

This bulletin is to notify the user of Flux Power M24 New Generation battery models on how to route the most positive and most negative internal busbars to prevent the shaving of the busbars against the top cover of the battery.

Batteries Affected

Battery Item # 100280-XX (Model: M24 New Generation) with a manufacturing date older than 1/10/2023. The battery model name, Item # and Manufacturing date is located on the battery's I.D. plate which is located on the top of the battery pack. If the date listed on the I.D. tag is older than 1/10/2023, contact Flux Support.



Figure 1: Example of data label



Figure 2: Location of the data label on the pack.

Identifying the Issue

We have identified that some of our M24 New Generation packs, were assembled in a way that would expose the most positive busbar and most negative busbar coming out of our modules, to rub against the top cover. This eventually leads to the cover cutting into the insulation and causing the copper mesh to be exposed. The way to find this issue, is by opening the cover of your battery and looking into the busbars shown below:

Known Incorrect way of routing the busbars and the damage the it can cause:

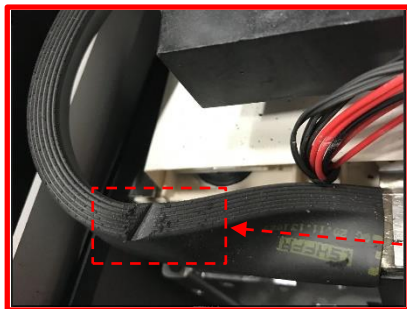


Figure 2: Left most negative busbar

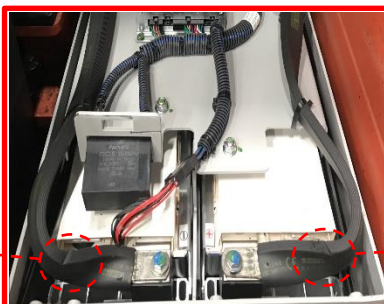


Figure 3: Busbars affected from front



Figure 4: Right most positive busbar

Correct way to route the busbars to fix the issue:

Items needed per Flux Part number:

- Service Kit 131167 M24 BUSBAR TIE DOWN_SERVICE KIT
- 3/8 Driver Wrench
- 3/8 Torque wrench set to 6 FT-LBS.
- 3/8 Torque wrench set to 13 FT-LBS.
- 10 MM socket

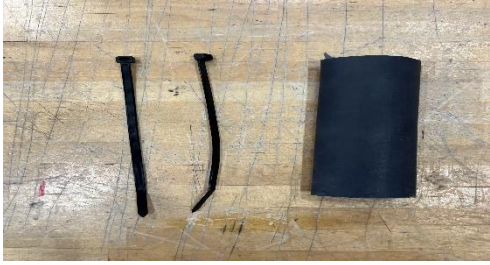


Figure 5: Part of SK 131167



Figure 6: Cut heat shrink in sections of 1.5 in

Step 1) Loosen up the following Power connections:



FRONT OF PACK

Step 2) Add heat shrink to cover the damaged insulation.



Damage usually isolated to this section

FRONT OF PACK

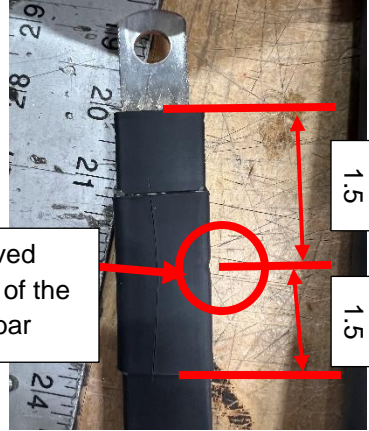


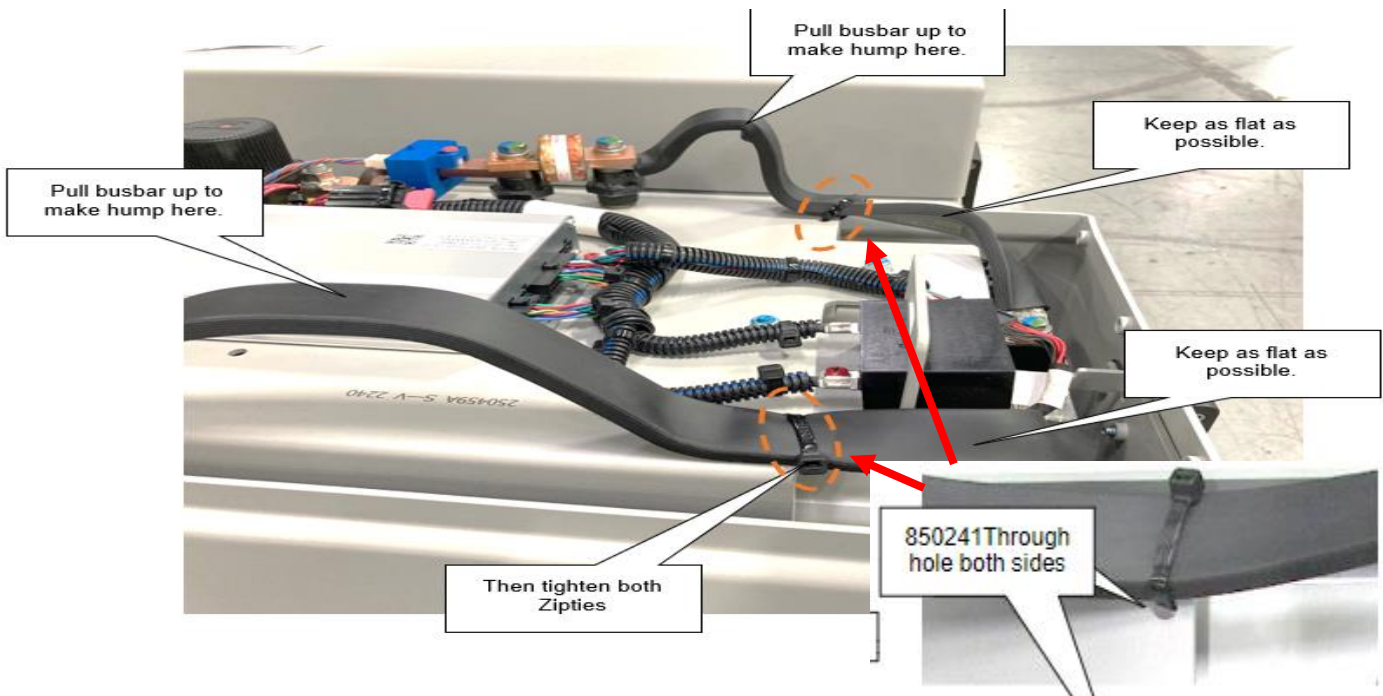
Figure 7: Left Most Negative Busbar

Figure 8: Shaved Busbar w/ insulation

Figure 9: Right Most Positive Busbar

Step 3) Secure the power connections and route the busbars as shown below:

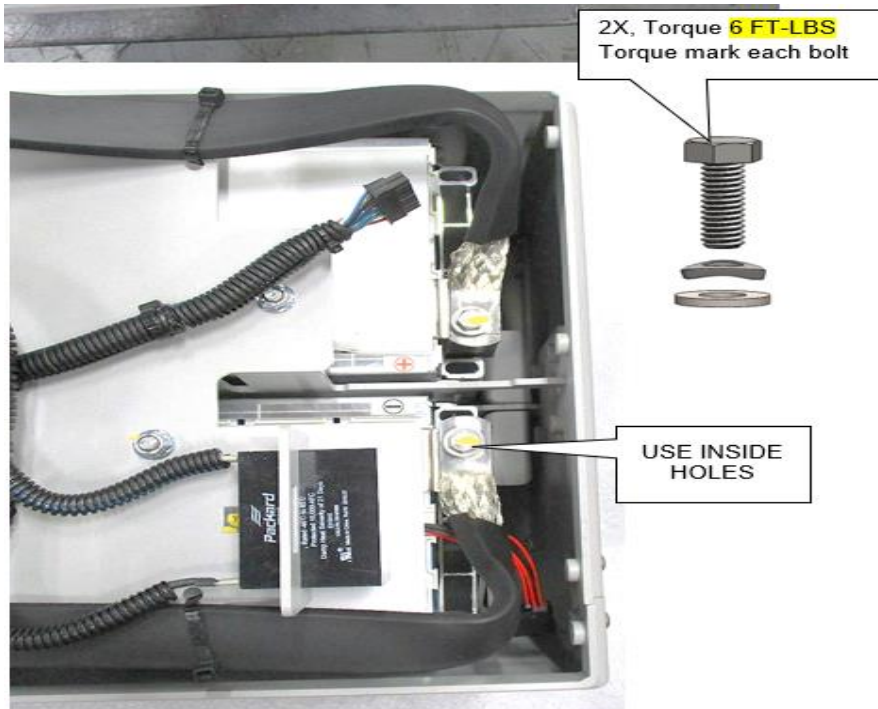
- Routing of Busbars:



- Secure connections:



Connection 1:



****END OF INSTRUCTIONS****

Flux Power Contact Details

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