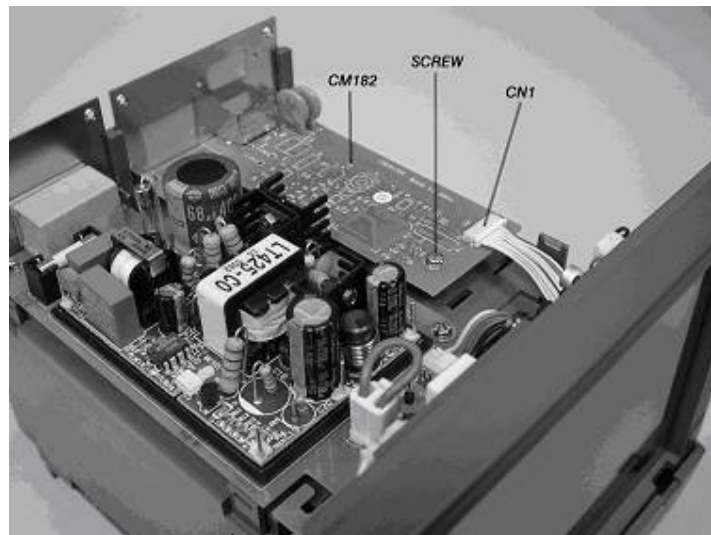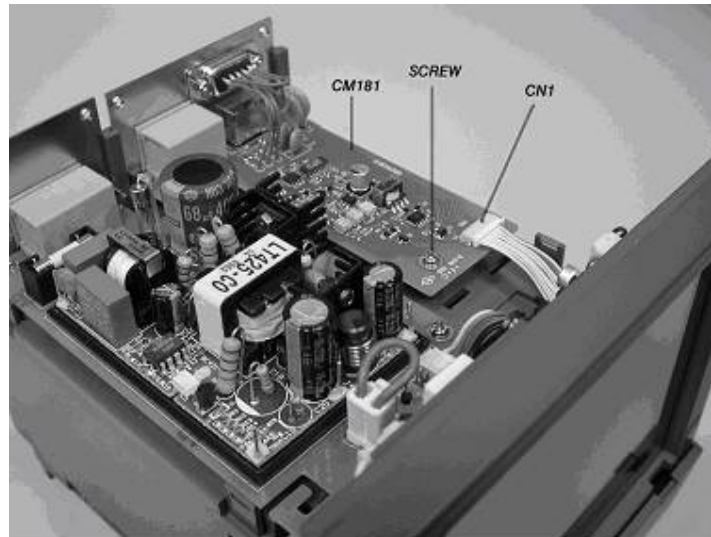**Procedure of Installing VR18 RS232/485 Modbus Communication Module**
Communication Module Part Number is CM181

1. Turn off the power, disconnect all power & communication cords and remove I/O cards located in the rear slots.

2. If it is panel-mount style, remove the mounting clamp. If it is bench top/portable style, remove the handle, two ears and two feet as described below; figure references may be found in the VR18 Manual.
   a. The handle: Remove it in a reverse way as Figure 2-11, 2-10 & 2-9.
   b. Two ears: Remove them by pulling toward the backside.
   c. Two feet: Remove them in a reverse way as Figure 2-14, 2-13 & 2-12.

3. Remove six screws in the back, then take off the metal housing

4. Carefully discount cable of CN1 located on the CM182 Ethernet Interface Module, and then remove the screw

5. Take off the CM182 Ethernet Interface Module, and then insert the CM181 Comm Module.

6. Fix the screw on the CM181 Comm Module.

7. Carefully connect the cable of CN1. Beware the blue cable must be matched with one end of CN1 socket marked with " BLUE".

8. Turn the main part upside down. Put on the metal housing and then fix it by six screws.

9. If it is panel-mount style, put the mounting clamp back. If it is bench top/portable style, put the handle, two ears and two feet as described below; figure references may be found in the VR18 Manual.
   a. The handle: Follow the instructions as Figure 2-9, 2-10 & 2-11.
   b. Two ears: Follow the instructions as Figure 2-6, 2-7 & 2-8.
   c. Two feet: Follow the instruction as Figure 2-12, 2-13 & 2-14.

10. Reinstall I/O cards, connect power and any communication cords. Turn on the power.