

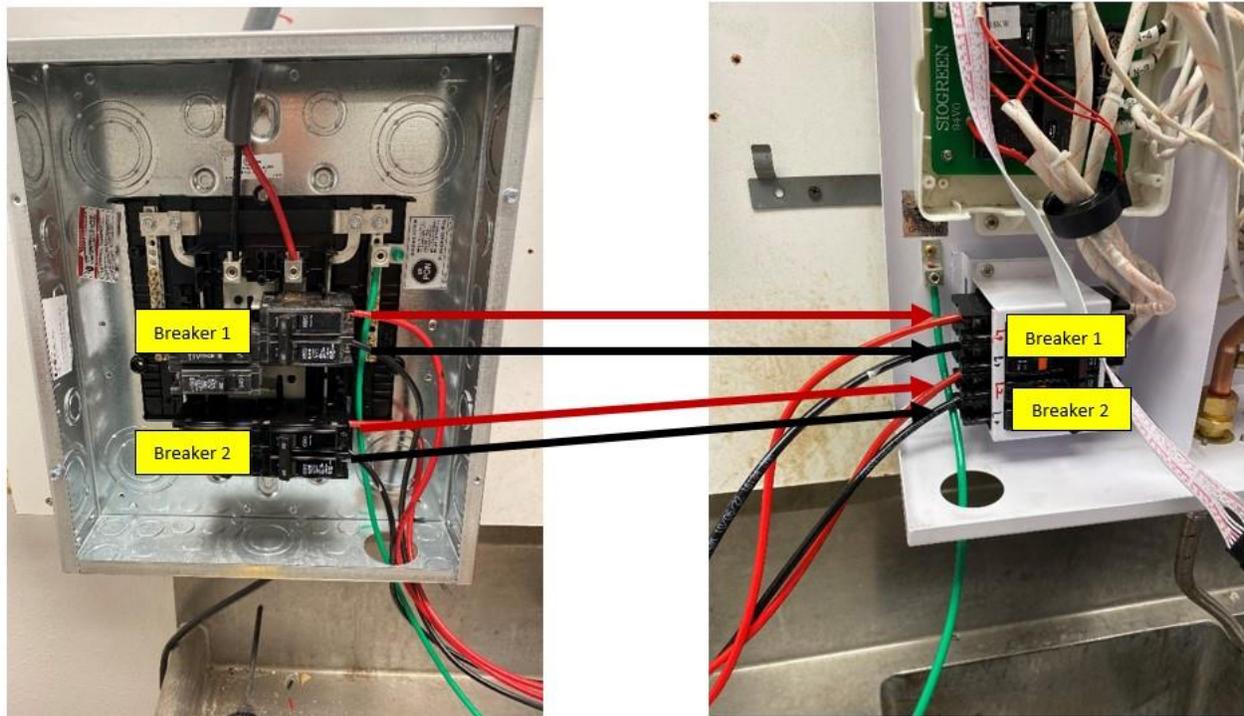
SIO 18 Pro Flex Wiring Requirements

Proper wiring is critical for the SIO 18 Pro Flex to operate correctly. The SIO 18 Pro Flex uses a frequency based electrical system which means the legs of each breaker must be in sequence or “phase” with the corresponding breaker. If you fail to wire the unit properly, it will not activate or function at full power.

To simplify the wiring process, we will refer to the leg/pole as “**Line**”. This is the proper way to wire the SIO 18 Pro Flex.

- **Line 1** (Leg 1) in Panel Breaker 1 (Red) must be connected to the corresponding **Line 1** in the SIO 18 Breaker 1
- **Line 2** in Panel Breaker 1 (Black) must be connected to the corresponding **Line 2** in the SIO 18 Breaker 1
- Repeat for Panel Breaker 2 to SIO 18 Breaker 2
- Complete wiring with a single ground

SIO 18 Pro Flex Proper Wiring Diagram





To confirm and verify the SIO 18 Pro Flex is properly wired, you should perform the following tests. The key to confirming a proper installation is to **test and verify the voltage and phase** to each breaker on the SIO 18 Pro Flex internal breaker.

Voltage Test – Voltage on Individual Breakers

Voltage on Breaker 1 **Line 1 (Red)** to **Line 2 (Black)** - **Confirm 240 Volts**

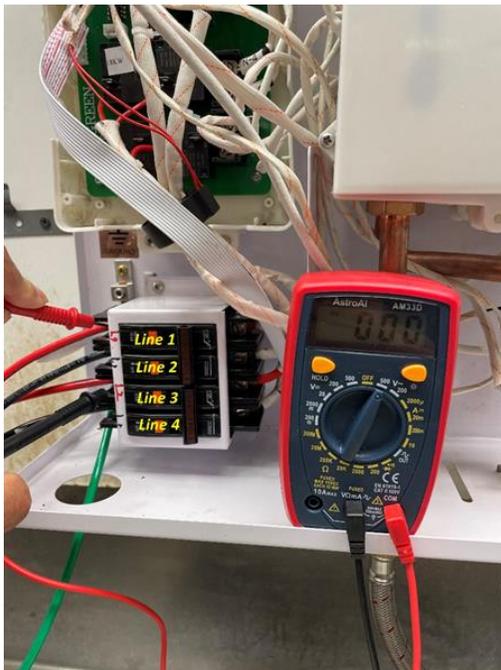
Voltage on Breaker 2 **Line 3 (Red)** to **Line 4 (Black)**- **Confirm 240 Volts**

Phase Test – Voltage on Combined Breakers

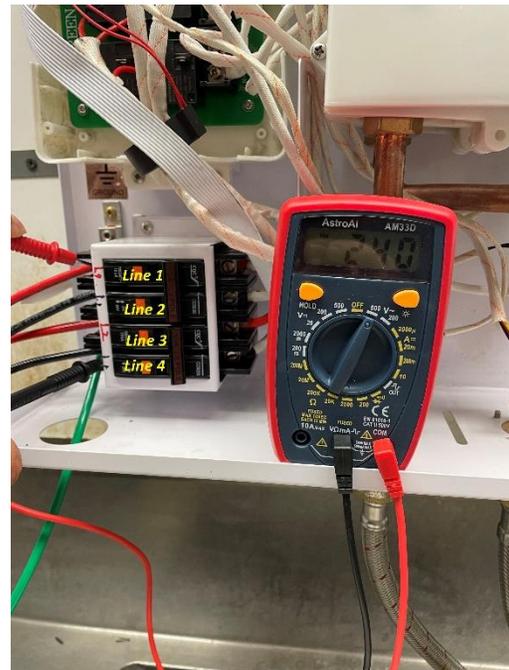
Voltage on Breaker 1 **Line 1 (Red)** to Breaker 2 **Line 3 (Black)** - **Confirm 0 Volts**

Voltage on Breaker 1 **Line 1 (Black)** to Breaker 2 **Line 4 (Red)** - **Confirm 240 Volts**

Phase Test 1



Phase Test 2



(If either test is out of phase, the unit will not activate. Reverse the wires on Breaker 1 and retest.)

See complete **Wiring and Phase Testing** videos here:

<https://www.siogreenpro.com/installation-and-wiring-guides>

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