



VERIFY



CAUTION

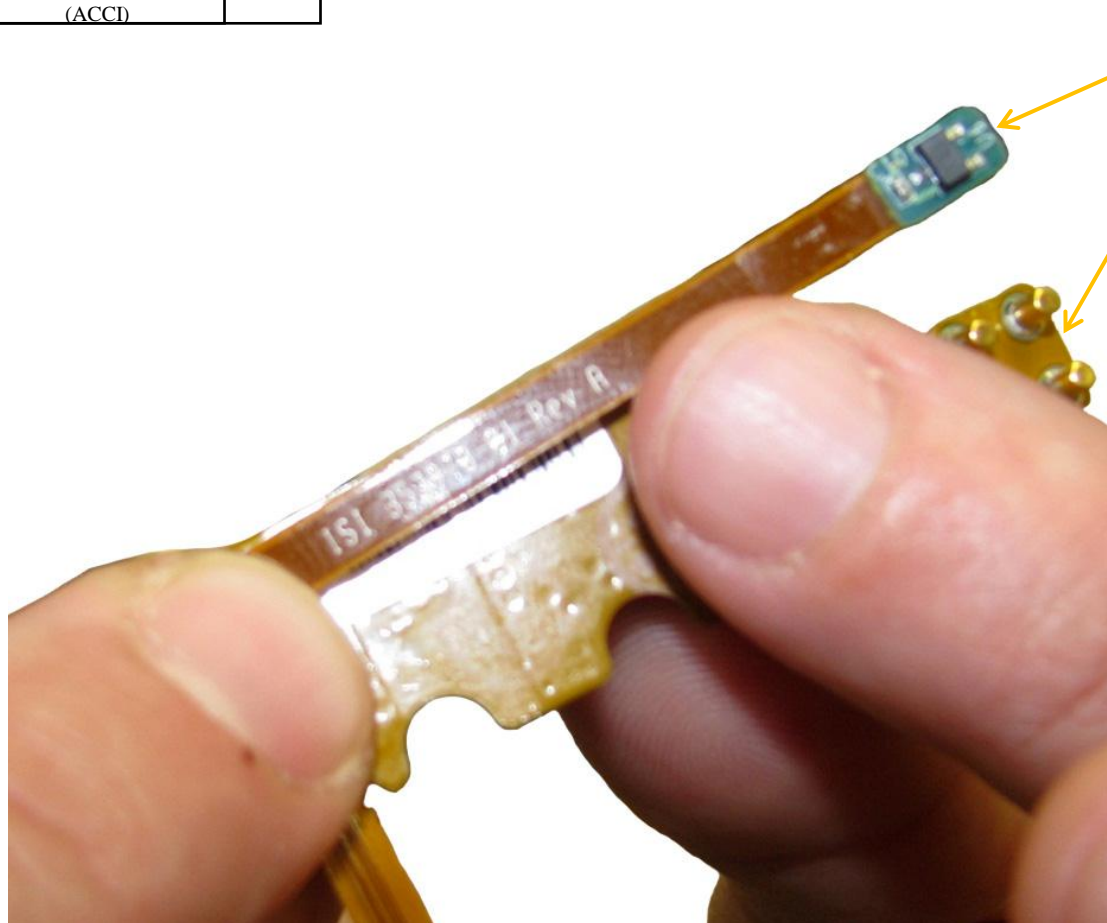
**ACCI Pod Assembly**

ITEM	PART #	DESCRIPTION	QTY
A	353970	PCA, AXESCONTROLLER CARRIAGE INSTRUMENT (ACCI)	1

1. Fold ACCI PCA (A) Flex Circuit as shown below. Do not crease Flex Circuit.  
**ESD precautions required.**



**ESD  
Precautions  
Required**



Trim board to be flush here if needed.

Users of any printed hard copy of this document must verify that it represents the most current revision prior to use.



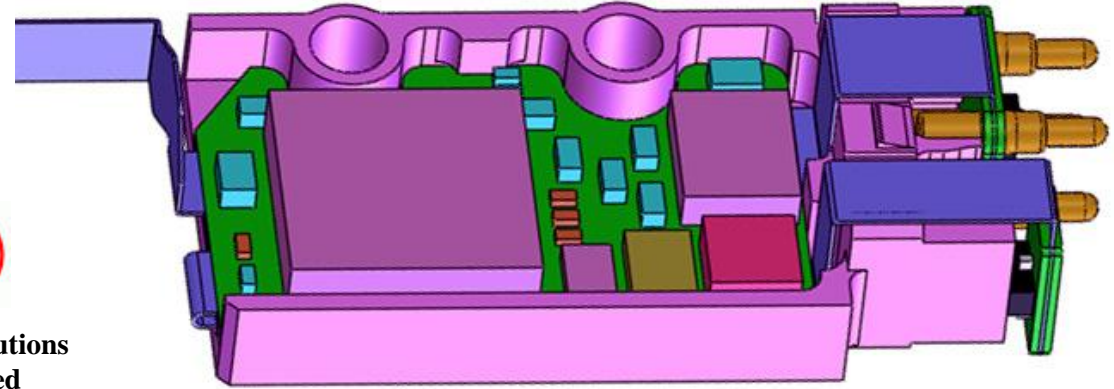
VERIFY



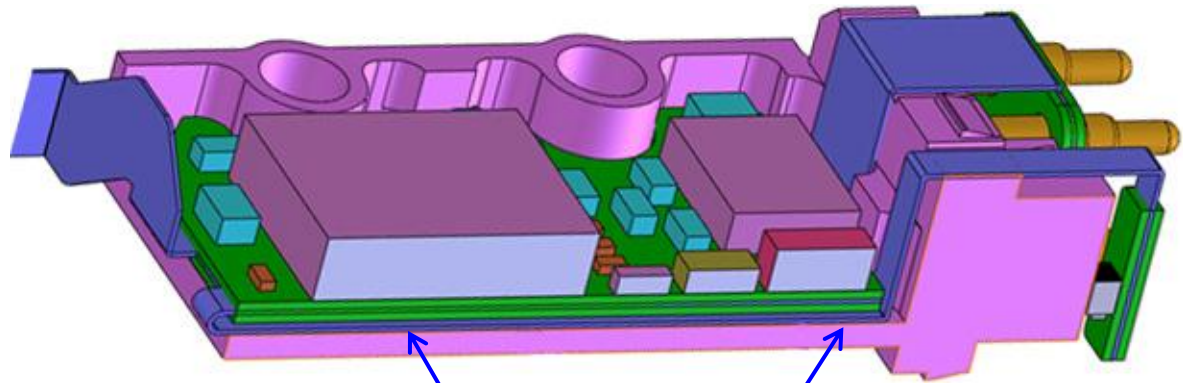
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2. Snap ACCI to Board Support (A). Note that part of the ACCI Flex Circuit goes between the PCA and the Board Support as shown. **ESD precautions required.**

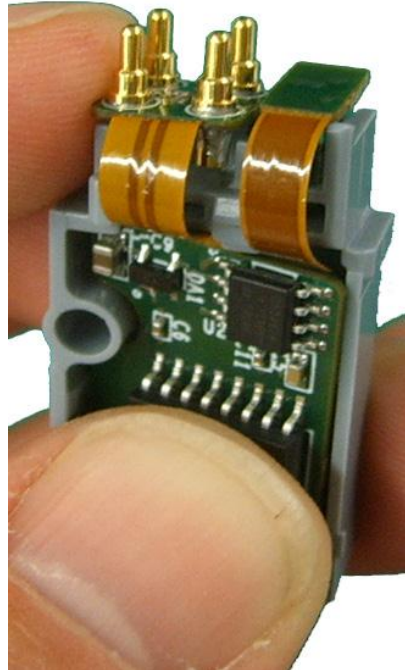
ITEM	PART #	DESCRIPTION	QTY
A	318229	BOARD SUPPORT, ACCI,IS4000 CARRIAGE	1




ESD Precautions Required



FFC goes under here



 VERIFY

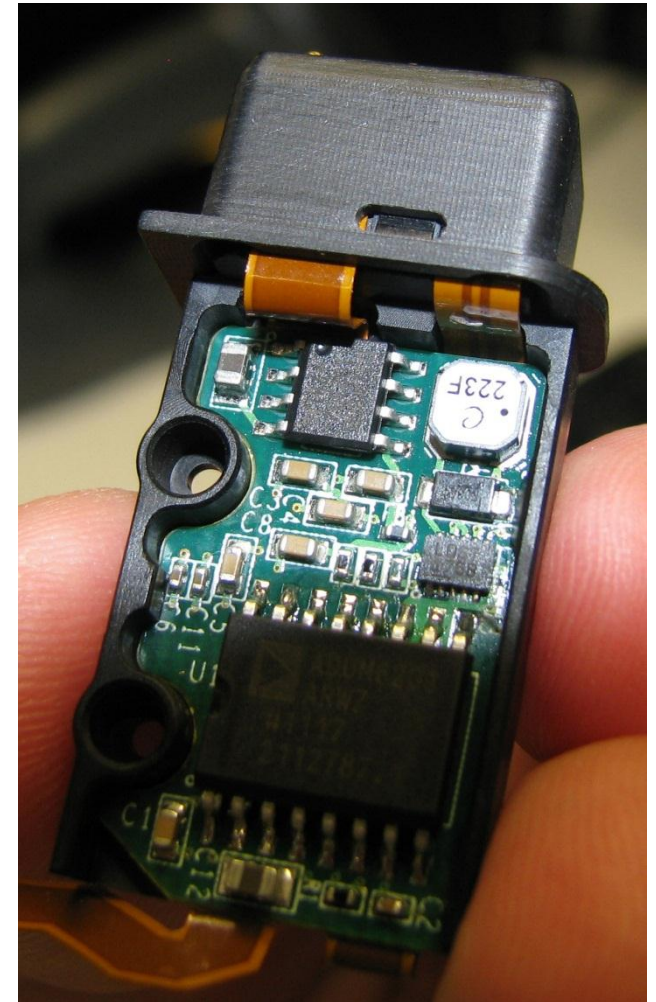
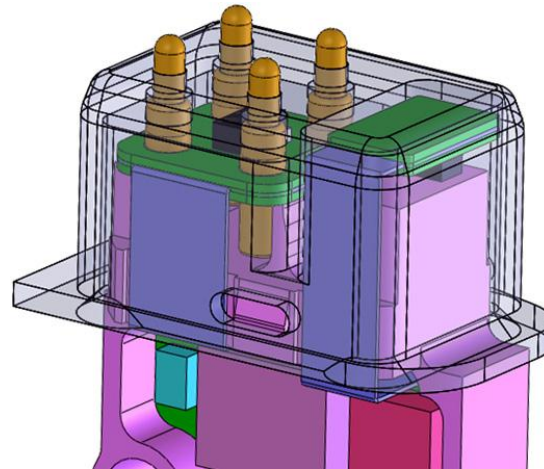
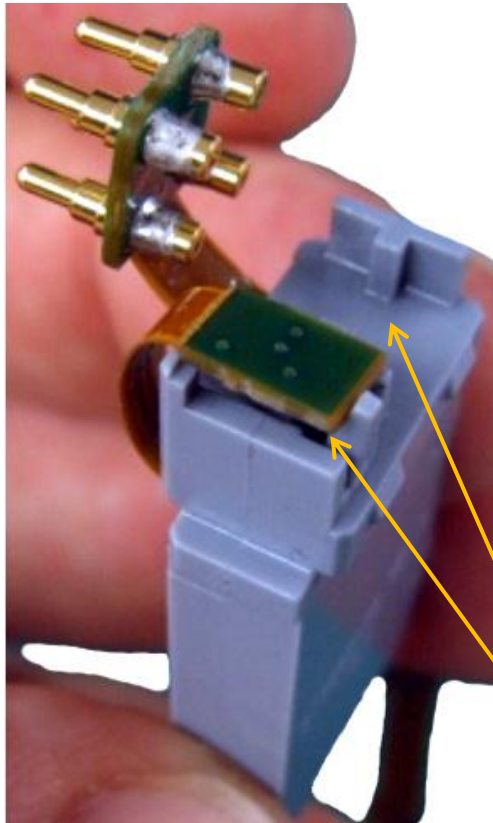
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ITEM	PART #	DESCRIPTION	QTY
A	318272	POD,DALLAS, IS4000 CARRIAGE	1
B	963013	DOUBLE SIDED ADHESIVE FOAM	AR

- Cut and place a small piece of **Tape (B)** onto **Board Support** to hold both boards down. Fold sub-boards into position and attach **Dallas Pod Cover (A)** to **Board Support** as shown. Do not crease **Flex Circuit**. **ESD precautions required.**



**ESD Precautions  
Required**





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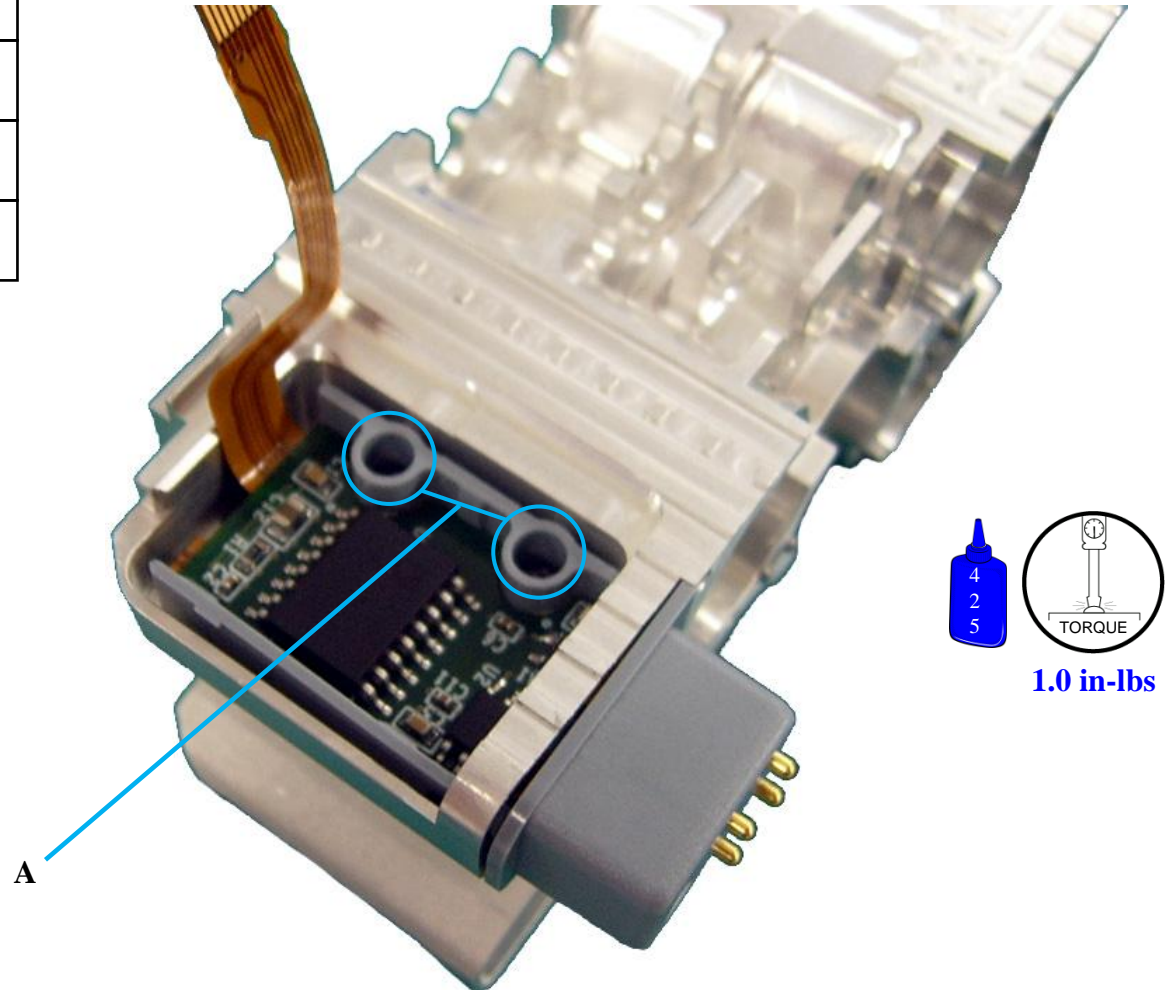
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4. Install ACCI Pod into Main Block (B) using Screws (A) and Loctite 425. Torque to 1.0 in-lbs using (C).

ITEM	PART #	DESCRIPTION	QTY
A	902462	SCREW,PHPH, M1.6X3,STST	2
B	318215	MAIN BLOCK,IS4000 CARRIAGE	1
C	721916	EFT, TORQUE WRENCH, 1.0 IN-LBF, 1/4" FEM HEX ADAPTER	NA





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ITEM	PART #	DESCRIPTION	QTY
A	181141	CABLE,FFC,11-PIN, 75MM,0.5MM P, SHLD,AU,USM,IS4000	1
B	353240	PCA,AXES CONTROLLER CARRIAGE RFID (ACCR)	1
C	318230	BOARD SUPPORT, ACCR,IS4000 CARRIAGE	1
D	319770	FOAM DOT,ACCRA RETAIN,IS4000 CARRIAGE	2

**ACCR Pod Assembly**

5. Connect **FFC (A)** to **ACCR (B)** with ground bump on the end away from the board.  
**ESD precautions required for the all the following steps.**

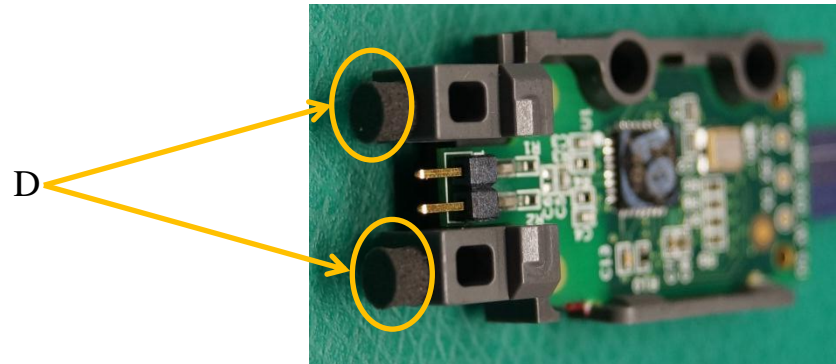


6. Snap **ACCR** into **Housing (C)**.



**WARNING!!! ESD precautions required.**

7. Put Qty: 2 **Foam Dots (D)** on top of **Housing** as shown.





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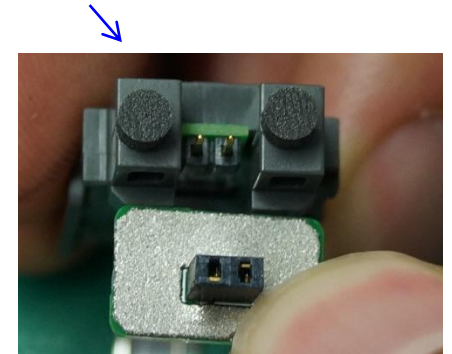
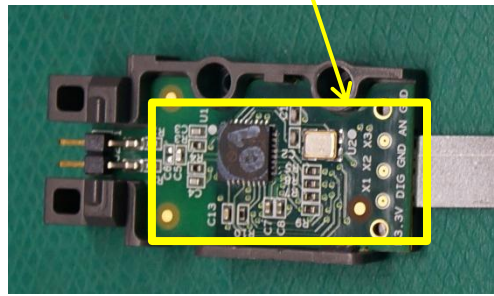


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ITEM	PART #	DESCRIPTION	QTY
A	353460	PCA,ACCRA,AXES CONTROLLER CARRIAGE RFID ANTENNA	1
B	318273	POD,RFID,IS4000 CARRIAGE	1
C	902462	SCREW,PHPH, M1.6X3,STST	2
D	721916	EFT, TORQUE WRENCH, 1.0 IN-LBF, 1/4" FEM HEX ADAPTER	NA

8. Put **ACCRA PCA (A)** into housing. **Orientation Shown**

9. Add **Kapton Tape** here (1x)



10. Snap **RFID Pod (B)** on, keeping flat edge on right side.

**⚠ WARNING!!! ESD precautions required.**

11. Insert into **Carriage Housing** and attach with Qty: 2 Screws (C) and Loctite **425**. **Torque to 1.0 in-lbs using (D).**

