

ESD Precautions Required

# MPI, Carriage Housing Assembly, USM, IS4000

MPI #: 1001924

*REV. E* 1 of 6

SURGICAL Users of any

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VERIFY A CAUTION			ON
ITEM	PART #	DESCRIPTION	QTY
A	353970	PCA,AXESCONTROLLER CARRIAGE INTRUMENT	1

#### **ACCI Pod Assembly**

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



Trim board to be flush here if needed.

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MPI Template: 800103 Rev. E



# MPI, Carriage Housing Assembly, USM, IS4000

MPI #: 1001924

*REV. E* 2 of 6

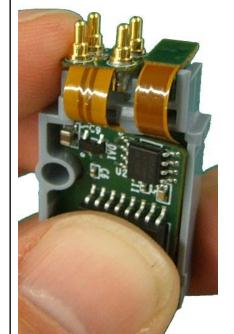
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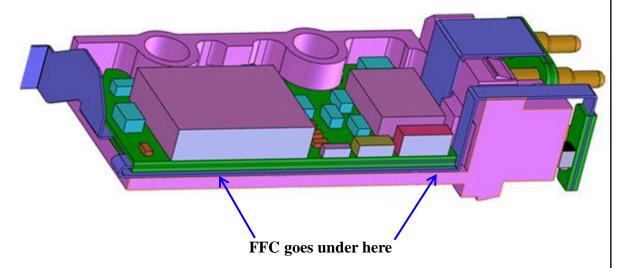
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VERIFY A CAUTION			
ITEM	PART #	DESCRIPTION	QTY
A	318229	BOARD SUPPORT, ACCI,IS4000 CARRIAGE	1

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.







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# MPI, Carriage Housing Assembly, USM, IS4000

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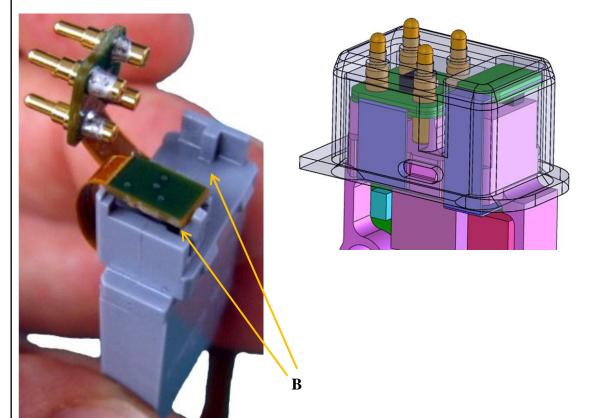
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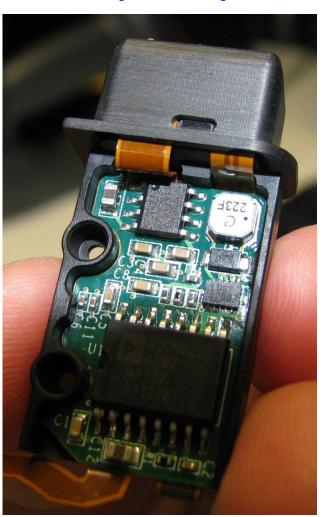
VERIFY		<b>A</b> CAUTION	
ITEM	PART#	DESCRIPTION	QTY
A	318272	POD,DALLAS, IS4000 CARRIAGE	1
В	963013	DOUBLE SIDED ADHESIVE FOAM	AR

3. 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** 







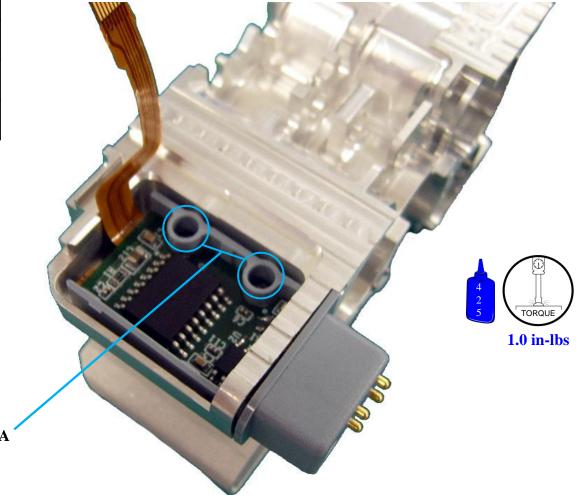
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### MPI, Carriage Housing Assembly, USM, IS4000 MPI#: 1001924 REV. E 4 of 6

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

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



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## MPI, Carriage Housing Assembly, USM, IS4000

MPI #: 1001924

REV. E

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#### SURGICAL

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

#### **ACCR Pod Assembly**

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.

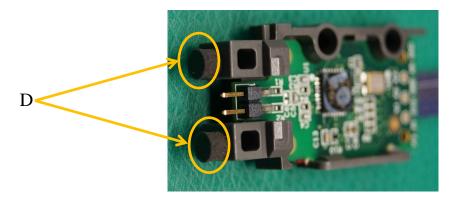


Snap **ACCR** into **Housing** (C).



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

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





SURGICAL

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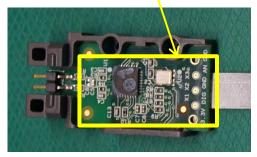
REV. E

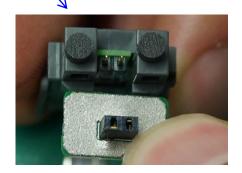
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VERIFY		<b>A</b> CAUTION	
ITEM	PART #	DESCRIPTION	QTY
A	353460	PCA,ACCRA,AXES CONTROLLER CARRIAGE RFID ANTENNA	1
В	318273	POD,RFID,IS4000 CARRIAGE	1
С	902462	SCREW,PHPH, M1.6X3,STST	2
D	721916	EFT, TORQUE WRENCH, 1.0 IN-LBF, 1/4" FEM HEX ADAPTER	NA

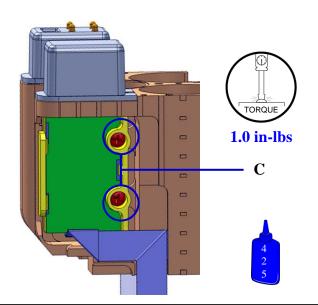
- 8. Put ACCRA PCA (A) into housing. Orientation Shown
- 9. Add **Kapton Tape** here (1x)





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**).

