

(x) Manufacturing Requirements

() *pre* Manufacturing Requirements

Sub-assembly-description:

OmniAssure Touch Square

OT4716BHONG, OT4700BHONG, OT4800BHONG, OT4816BHONG

Sub-assembly-number:

SA_GRSMCSG16B, SA_GRSMCSG0B, SA_GRSPMCSG0B, SA_GRSPMCSG16B

PCB-numbers:

Created:

R&D-HW *)

T. Finke

Checked:

OP *)

Released:

Project leader *)

Comments:

The change are marked.

800-24814

*) Approvals will be done with Agile workflow. No hand signature required on this document.

In general the standard manufacturing methods and processes which comply with "Quality Manual" have to be applied. The following document only covers special operations and workflows which were not defined in process descriptions and operating instructions or diverge from it.

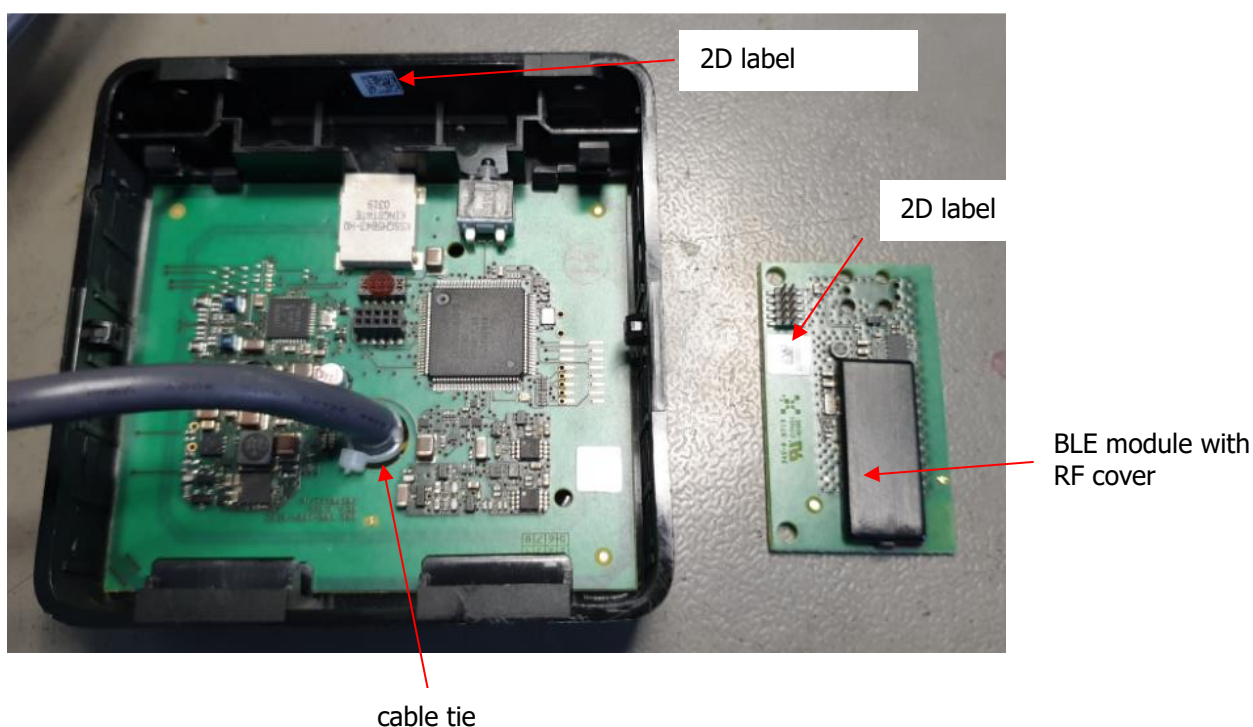
Production workflow

Visual incoming inspection for all OmniAssure Touch parts.

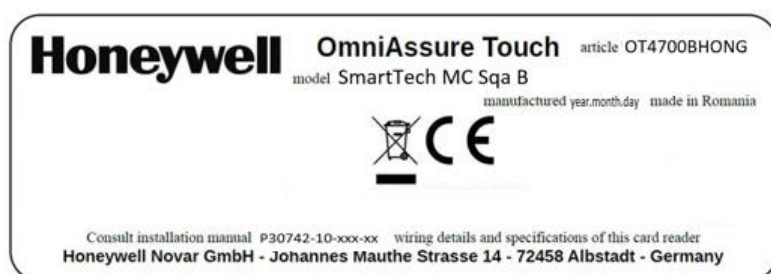
The following parts should be delivered by INID:

- 2D label
- type label
- wall plate
- reader + module

Incoming inspection of reader, BLE module and 2D label position:

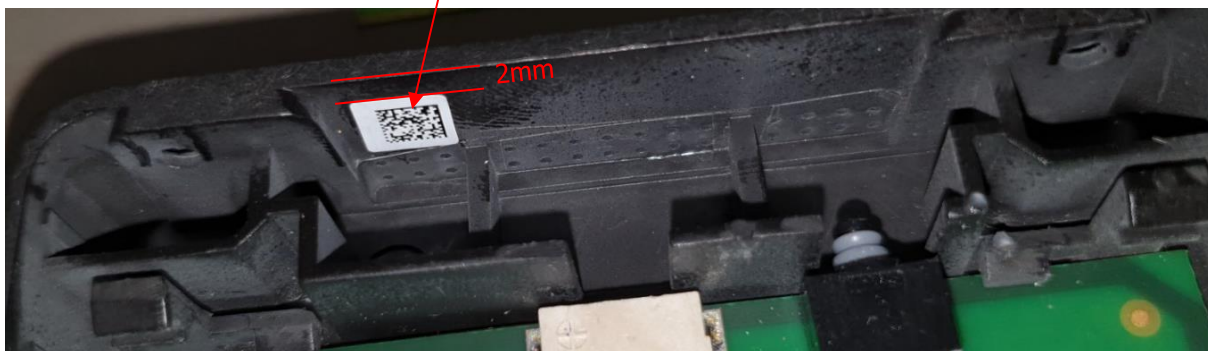


wall plate

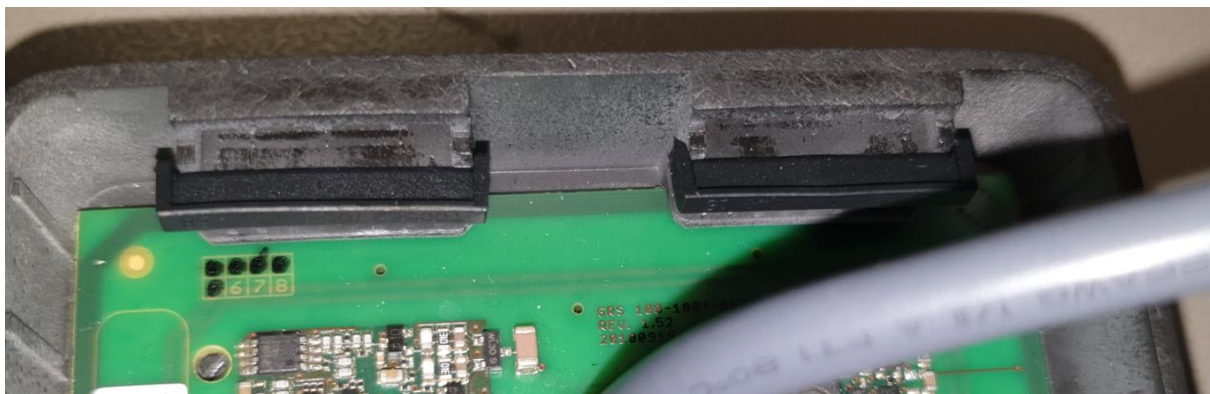


Type label (example)

2D label position



Please assemble the two rubber sleeves:

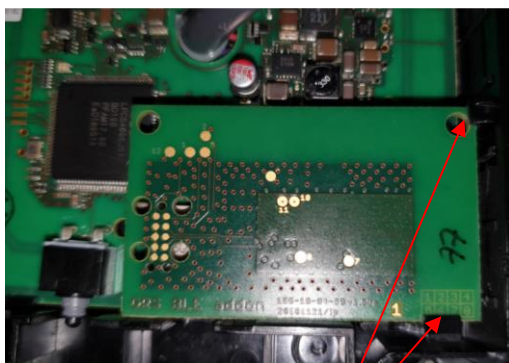


The switch and buzzer gaps/openings must be covered with PC-FLEX-MASK (or similar technics) as shown in the picture:

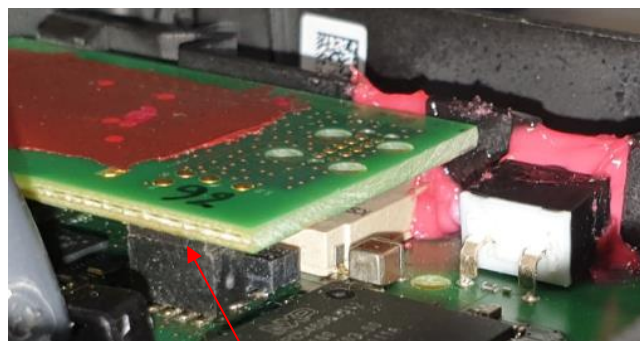


Wait until PC-FLEX-MASK is cured (12hours).

Check the correct assembly of the BLE module:



Check the BLE module is mounted here correctly on that position with that pattern



Make sure the BLE module plugs in correctly between multi-pin connector <-> socket terminal

Fill up the enclosure with potting until the height of the rubber sleeves.
Follow the following steps:

- Fill the cavity between main PCB and keyboard through the fill hole next to the buzzer, use a tight-fitting nozzle and a very low flow rate (suggested: 0.25 ml/s). Approx. 11 ml is required.
- Watch out for potting coming up through the cable opening prematurely, pause a second or two if necessary.
- Leave potting to settle into all voids, verify that the potting fills the holes above the BLE module and in the top left corner from below; this can take up to 30 seconds depending on initial flow rate.
- Fill the rest of the reader to the required fill height from the middle of the reader using a suitable flow rate, avoid bubbles forming (e.g. on corners of components).
- Verify that the space between the main PCB and the BLE module is filled by checking the opening in the bottom right corner between the BLE module and the housing.
- Cover the BLE module with a thin layer of potting, several drops should suffice.

Afterwards the potting must cure. During that time, do not move the device. Keep the device in a stable horizontal position.

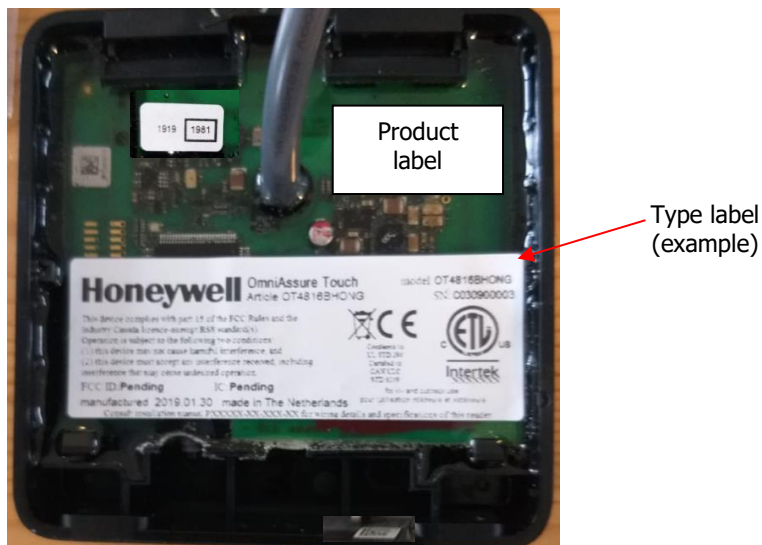
Cure time of the potting is at least 24 hours (hardening at higher temperature is forbidden).

Remove PC-FLEX-MASK from switch and buzzer.

Test in according with the test requirements.

Remove the clamp terminal block (if available).

The product label and type label should be stick on the potting in compliance with the picture.



Put in 4 screw covers (INID) in the accessory bag.
Put in the manual, the wall plate and accessory bag under the inlay in the packaging box.
Afterwards the inlay and reader on top as shown in the picture (example for square).



Remove the protection (manufacture) foil on top. Close the box with the packaging label in place (uncertainty in ± 1 cm).
See document 800-16060 "Labeling Gift-Boxes Albstadt" for label placement on the outer packaging.



Pull over the slip case.