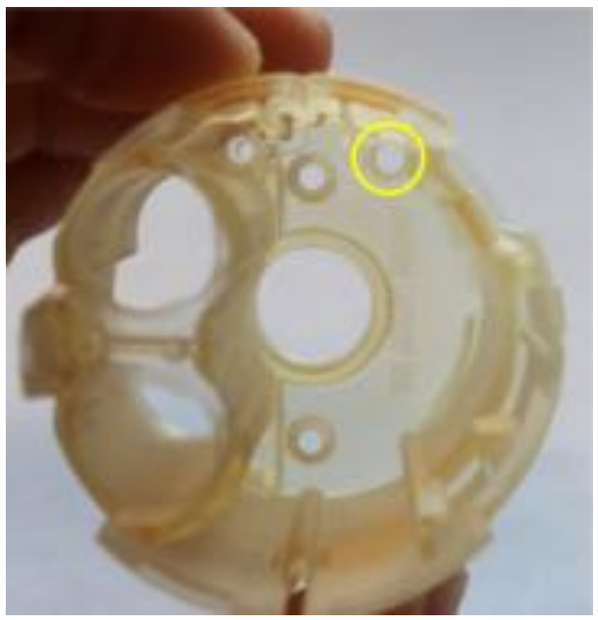
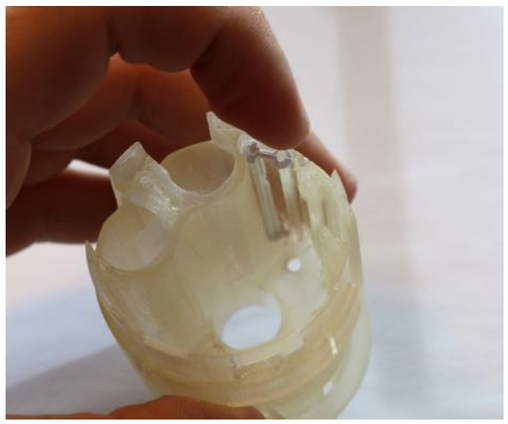
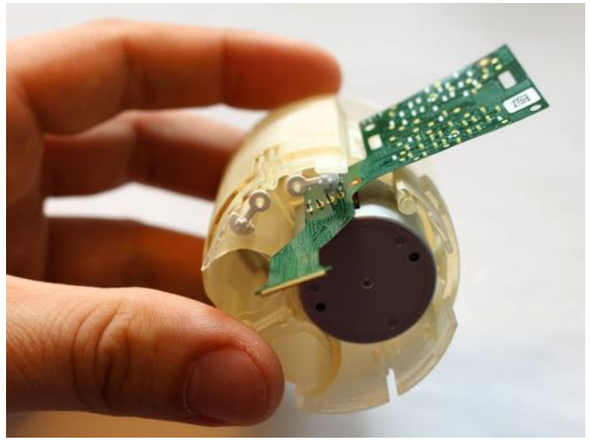
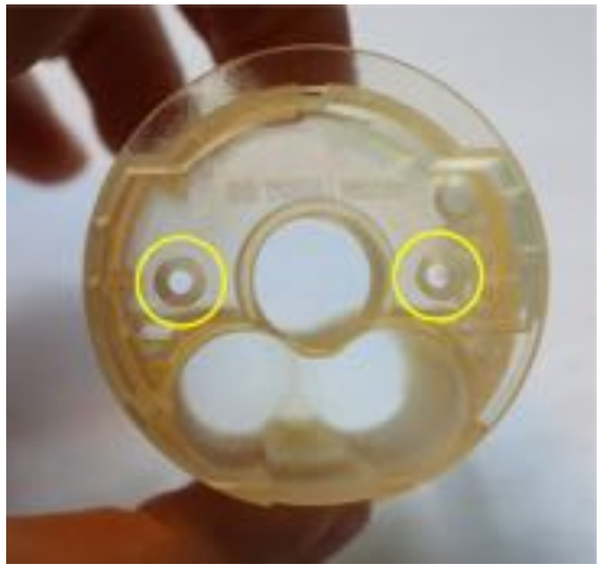
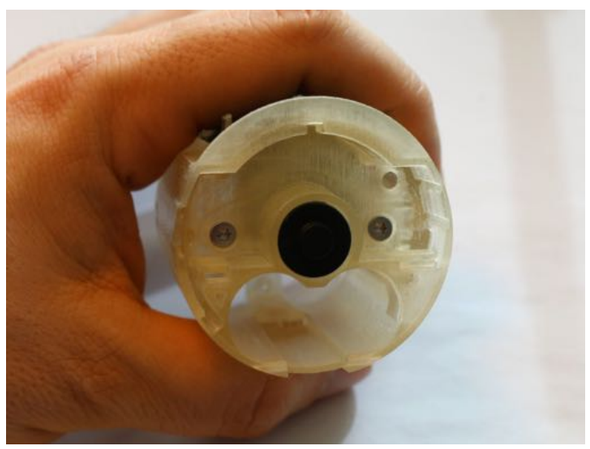
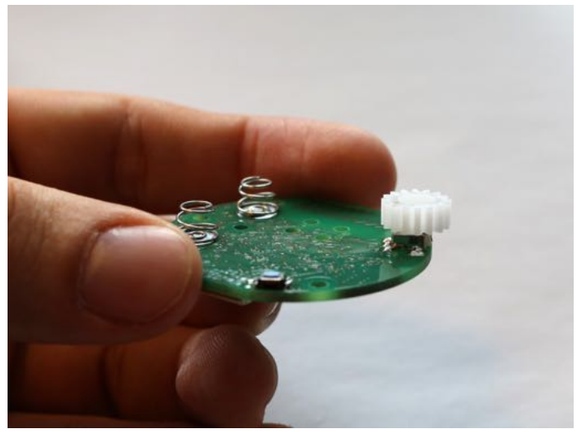
DVA02: Assembly Instructions - Device

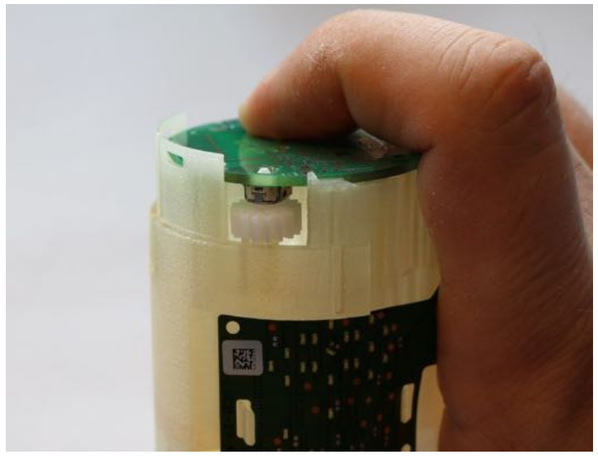
Document	Revision	Status	Authors	Changelog
Current Version				
103230	A	Released	Gepperth Jürgen	Added Protective Foil to the assembly process
Document History				
102964	B	Released	Johannes Schwarz	Removed the foil wrapping step as this is now part of the kitting instructions
102964	A	Released	Jonas Huber Matthias Bösl Johannes Schwarz	Initial version

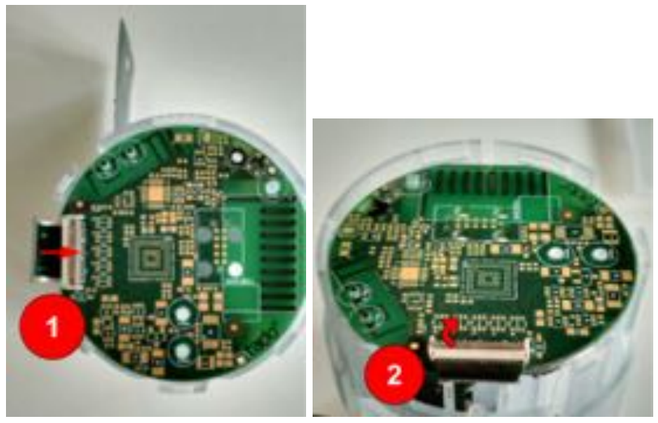
Step	Description	Picture	Comments
1	**Picking the Mounting Bracket** Take MOUNTING_BRACKET_ASSEMBLY.		

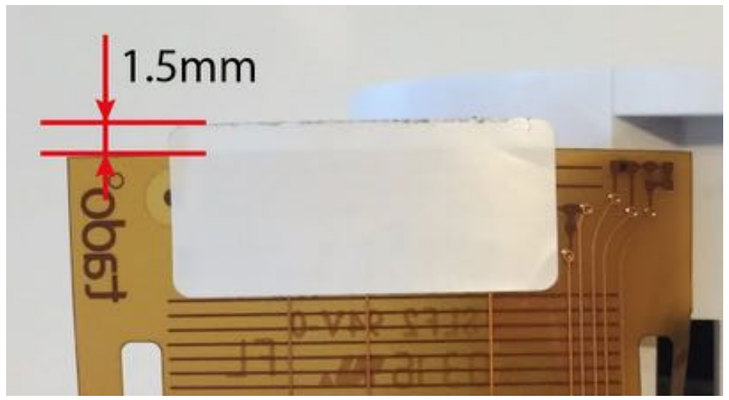
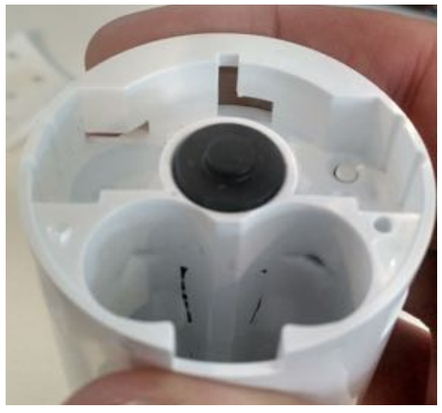
2	**Inserting Reset Button Extension** Insert the BUTTON_EXTENSION for the reset button into the MAIN_BODY.	 	

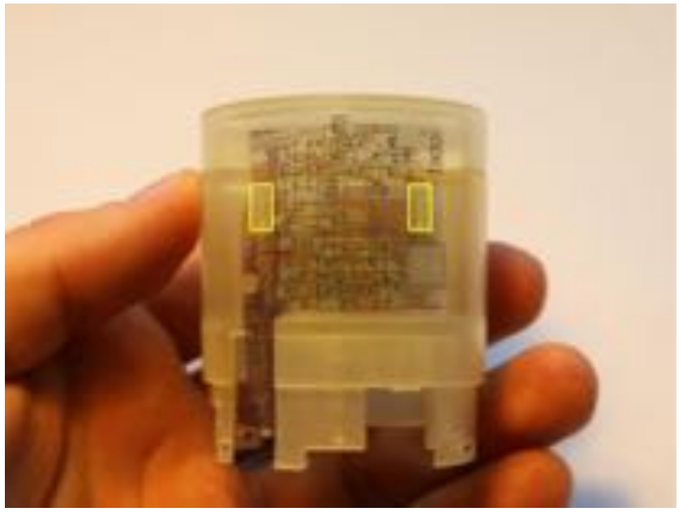
3	**Inserting Motor and Flexible PCBA into Housing** Insert MOTOR_FPBCA_ASSEMBLY into the MAIN_BODY. The motor is kept in position by 2 screws coming from of the main body. 1. Insert Motor with flexible PCBA halfway into the main body. 2. Insert button extension half way into the Main body. 3. Afterwards the motor can be pushed down to his final position as well as the button extension. 4. Attach the motor and FPCBA to the housing by inserting the two MOTOR_SCREWs	  	**<u>Attention</u>:** MOTOR_FPBCA_ASSEMBLY differs depending on target SKU.

4	**Inserting Mounting Button Extension** Insert MOUNTING_BUTTON_EXTENSION for the mounting button into MAIN_BODY.		
5	**Assembling the Gear** Put GEAR into the opening of the rotary encoder on PPCBA.		

6	**Placing the PPCBA in Main Body** Make sure that the PPCBA is positioned in the MAIN_BODY such that the gear sits in the opening of the main body and that the plastic domes sit in the corresponding openings of the rigid PCB.		
7	**Insert PCB_SCREWs** Attach the rigid PCB to the housing by inserting the two PCB_SCREWs.		

7A	**Checking Mounting Quality** Make sure the PCB cannot move at all after the insertion of the screws.		  
8	**Connecting Flexible PCB to PPCBA** 1. Put the flex PCB into the connector 2. Flip the fastener to lock the PCB		
9	**Positioning the White Sticker** Place the WHITE_STICKER on the back of the flexible PCB.		**Max. 1,5mm over PCBA:**

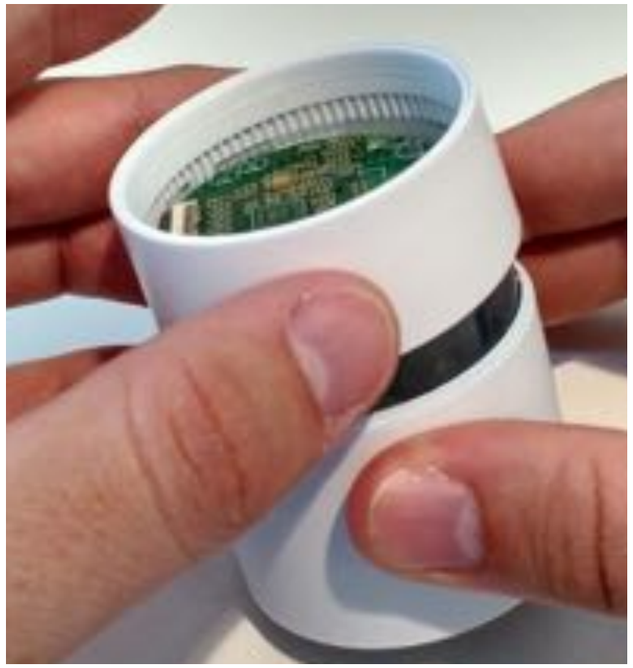
			  
10	**Scanning of PCBA Serial** Scan EMS assigned PCBA serial number (sticker or engraved).		

11	**Printing of Device Labels** Print the DEVICE_LABEL in accordance with the label printing instructions DEVICE_LABEL_LPI.		
12	**Attaching the Device Label** Attach the printed DEVICE_LABEL into the back of the main body.		
13	**Positioning Flexible PCB** Position the flexible PCBA in display area using the yellow marked 2 locators. Make sure the FPCBA slides under the green marked edge		

			
14	**Positioning the Light Blocker** Position the LIGHT_BLOCKER in display area using the 2 locators.		**Attention:** LIGHT_BLOCKER differs depending on target SKU.

15	**Pushing Display Ring onto Main Body** Push DISPLAY_RING onto MAIN_BODY. Make sure the display engraving (can be seen on the inside of the display ring) sits on the same side as the flex pcb.		**Attention:** DISPLAY_RING differs depending on target SKU.
16	**Attaching Battery Cover** Attach BATTERY_COVER to MAIN_BODY.		

17	**Inserting Hinge** Put HINGE into hole to hold the BATTERY_COVER.		
18	**Pushing the Display Ring Down** Push the DISPLAY_RING completely down.		

19	**Attaching the Wheel** Push the WHEEL onto the main body.		
20	**Snapping on the Front Cap** Snap the FRONT_CAP onto the MAIN_BODY.	 	**Attention:** The opening must be placed over the infrared temperature sensor.
23	**Printing of Setup Labels** Print the SETUP_LABEL in accordance with the label printing instructions SETUP_LABEL_LPI.	 	

24	**Attaching the Setup Label** Place the SETUP_LABEL on the WHEEL.		**Attention:** SETUP differs depending on target SKU. **Orientation** / **Orientation** **Horizontal**  **Vertical** 

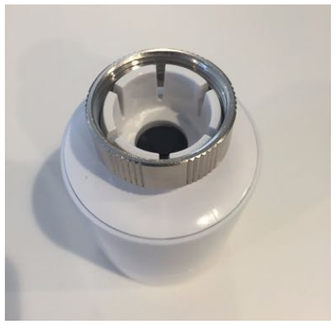
25	**Remove the Mounting Bracket**		
26	**Scan the Rear Serial Number** The station starts the EOL procedure		

27	**Scan the Front Serial Number**		
28	**Insert Batteries** Open the battery compartment cover. Insert the AA_BATTERIES. Close the battery compartment cover.		

29	**Wait for EOL on display.** 1) If DUT shows FAI, don't proceed, station should show FAIL.		
30	**Press the pairing button** 1) DUT shows 00		

31	**Turn the wheel to the right until all LEDs turn on** 1) DUT counts up 2) DUT turns on all LEDs above maximum		
32	**Turn wheel to the left until all LEDs turn off** 1) DUT counts down 2) DUT turns off all LEDs below minimum		

33	**Attach the Mounting Bracket**		
34	**Mount DUT using its adapter on the stand** 1) DUT shows CAL 2) DUT performs calibration	 	

35	**Wait for PA or FAI on DUT** 1) The station should show PASS or FAIL	 	
36	**Remove DUT from stand**		

37	**Remove the Mounting Bracket from the device main body.**		
38	**Open & Close the battery cover to interrupt the power supply**		

39	**Checking for Customer Mode** Check that the display shows the **temperature** when turning the wheel. **Attention:** If the device shows “EOL”, the EOL test has not been completed.		
40	**Placing the Battery Tab** Open the battery compartment again. Place the BATTERY_TAB as shown. Close the battery compartment cover back. **Attention:** The battery tab must break the electric contact.		

41	**Close battery door**		
42	**Check Wheel on Torque Meter - Max allowed: 40mNm**		

43	**Wrapping the Device(s) in Protective Foil** Wrap the Device(s) in PROTECTIVE_FOIL.		

Instructions for Opening DVA02 for Rework:

1	Get between the Front Cap and the Wheel with a plastic tool at the red marked area. Note: DO NOT USE METAL. It will damage the wheel		
2	Push the Front Cap up with the plastic tool until the lift side is fully lift.		
3	Now you can pull up the Front cap with your hands. Throw the Front Cap away.