	Client: VotingWorks	Doc. No.: VWX-001-D018
	Project: Ballot Receptacle	Revision: X01
	Doc. Title: Floor Assembly Instructions	Date: 11/01/2024

1.0 PURPOSE

The purpose of this document is to describe the required parts, assemblies, tools, preparation, and process to assemble the Floor Assembly (VX~01-10048).


2.0 PARTS & ASSEMBLIES

2.1 Made-To-Spec (MTS)

Item Number	Description
VX~02-10059	FLOOR, FRAME
VX~02-10050	TOE KICK OUTER
VX~02-10127	TOE KICK INNER

2.2 Off-The-Shelf (OTS)

Item Number	Description
VX~99-10054	SPACER, SEMI-TUBULAR RIVET, 3/16 IN
VX~99-10053	SEMI-TUBULAR RIVET, 3/16 IN X 11/32 IN, AL
VX~99-10052	POP RIVET, 5/32 IN X 0.55 IN, BLACK, AL
VX~99-10051	FOOT, RUBBER

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3.0 TOOLS

3.1 Made-To-Spec (MTS)

Item Number	Description

3.2 Off-The-Shelf (OTS)

Supplier	Part Number	Description
JAY-CEE	TO-TP-888-3	Solid rivet Semi-tubular Rivet Squeezer 3" Reach, 1-1/4" Gap
JAY-CEE	TO-200-OH05	5/16 (.312) HEAD SET FOR RIVET SQUEEZER
JAY-CEE	TO-200-4506	Roll Over Set for 3/16
ZIPP	ZT1017VS	PNUEMATIC BLIND RIVET TOOL
-	-	FINE TIP TWEEZERS
-	-	HAND DRILL
-	-	#20 DRILL BIT

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4.0 PREPARATION

Adjust the rivet squeezer to 18.4 mm




5.0 ASSEMBLY PROCESS

Assemble the Floor Assembly (VX~01-10048) as defined in the following steps.

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STEP 1 INSTALL RUBBER FEET TO THE FLOOR FRAME

1.1 Place the floor frame part onto the working surface with the bent tabs facing upward



1.2 Chase rubber feet mounting holes with #20 sized drill bit


1.3 Place the rubber foot over the left tab hole (shorter tab)



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1.4 Push the rivet through both the rubber foot and the floor tab.



1.5 Repeat steps 1.2 and 1.3 with the right tab




1.6 Using the pop rivet tool, fully install the pop rivets to affix the rubber feet to the floor tabs.

1.7 Test the rubber foot retention by trying to move it around. The rubber foot should be secured to the floor frame part.

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STEP 2 INSTALL THE TOE KICK TO THE FLOOR FRAME


2.1 Set a floor, with its tabs facing upwards, onto blocks to prop its mounting tabs ~3in above the bench surface.



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2.2 Push the semi-tubular rivet through the outer toe kick



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- 2.3 Slide the semi-tubular rivet into the pivot hole of the Floor with a Semi-tubular rivet spacer (VX~99-10054) between the Outer toe kick and the floor tab and a second Semi-tubular rivet spacer after the Floor tab as shown.



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2.4 Insert the inner toe kick onto the outer toe kick




2.5 Using the rivet squeezer affix the rivet in place

2.6 Repeat for 2.1 through 2.5 for the second floor

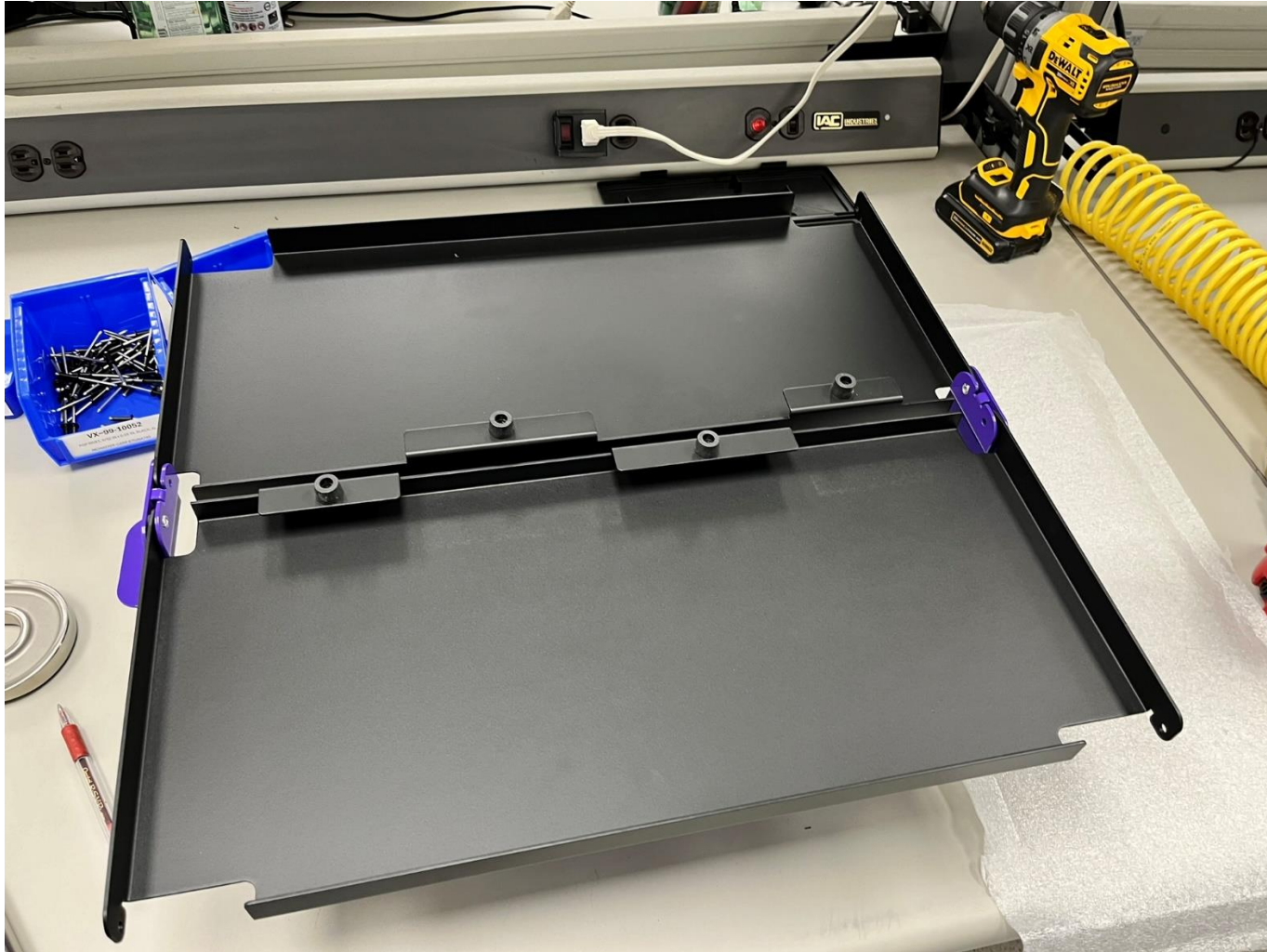
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STEP 3 FINAL ASSEMBLY

3.1 Place both floor parts onto blocks to prop the assemblies ~3in above the bench with their toe kicks interleaved.



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- 3.2 Attach the floor together by sliding a Semi-tubular rivet through each Toe kick with a a Semi-tubular rivet spacer (VX~99-10054) on each side of the floor tab. Use fine tip tweezers to place the rivet spacer in position while installing the rivet.



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3.3 Using the rivet squeezer affix the rivets in place




3.4 Check the final assembly for excessive toe kick play. If necessary, re-squeeze the rivets with a tighter squeezer setup

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REVISION HISTORY AND APPROVALS

If this document is a released alpha-revision, a record of the approvers and specifics of the approval process associated with each released version of this document is contained in the CR# listed in the table, and available for review on NOVO's online CR system.

Rev	Description	CR#	Date	Submitted By
X01	Initial Draft	N/A		