1.0 PURPOSE

The purpose of this document is to describe the required parts, assemblies, tools, preparation, and process to assemble the E-Ballot Bin Assembly (VX~01-10085).

2.0 PARTS & ASSEMBLIES

2.1 Made-To-Spec (MTS)

Item Number	Description	Reference Name
VX~02-10087	TUBE, E-BALLOT HINGE	HINGE TUBE
VX~02-10094	BIN, E-BALLOT	BIN
VX~02-10101	HANDLE, E-BALLOT LATCH	HANDLE
VX~02-10102	BASEPLATE, E-BALLOT LATCH	BASEPLATE
VX~02-10137	DOWEL NUT, HINGE TUBE	DOWEL NUT

2.2 Off-The-Shelf (OTS)

Item Number	Description	Reference Name
VX~99-10078	WASHER, RIVET, 5/32 IN, 18-8 SS	RIVET WASHER
VX~99-10106	POP RIVET, 5/32 IN X 0.30 IN, LARGE FLANGE	BASEPLATE RIVET
VX~99-10107	POP RIVET, 5/32 IN X 0.55 IN, LARGE FLANGE	HANDLE RIVET
VX~99-10109	WASHER, E-BALLOT LATCH	UPPER WASHER
VX~99-10112	SPRING, RETURN, E-BALLOT LATCH	RETURN SPRING

Item Number	Description	Reference Name
VX~99-10124	WASHER, BEARING, E-BALLOT LATCH	LOWER WASHER
VX~99-10144	SHIM, E-BALLOT HANDLE	ROUND SHIM
	MULTI-PURPOSE SYNTHETIC GREASE	GREASE

3.0 TOOLS

3.1 Made-To-Spec (MTS)

Item Number	Description
VWX-001-A015	ASSY, E-BALLOT RIVET FIXTURE

3.2 Off-The-Shelf (OTS)

Supplier	Part Number	Description
ZIPP	ZT1017VS	PNUEMATIC BLIND RIVET TOOL
-	-	Needle-Nose Pliers
-	-	M8 Hex Key
-	-	Q-TIP

4.0 PREPARATION

The blind rivet tool requires a 5/32" tip.

5.0 ASSEMBLY PROCESS

Assemble the E-Ballot Bin Assembly (VX~01-10085) as defined in the following steps.

STEP 1   INSTALL LATCH BASEPLATE

1.1   Place BASEPLATE into shallow pocket on top of BIN.
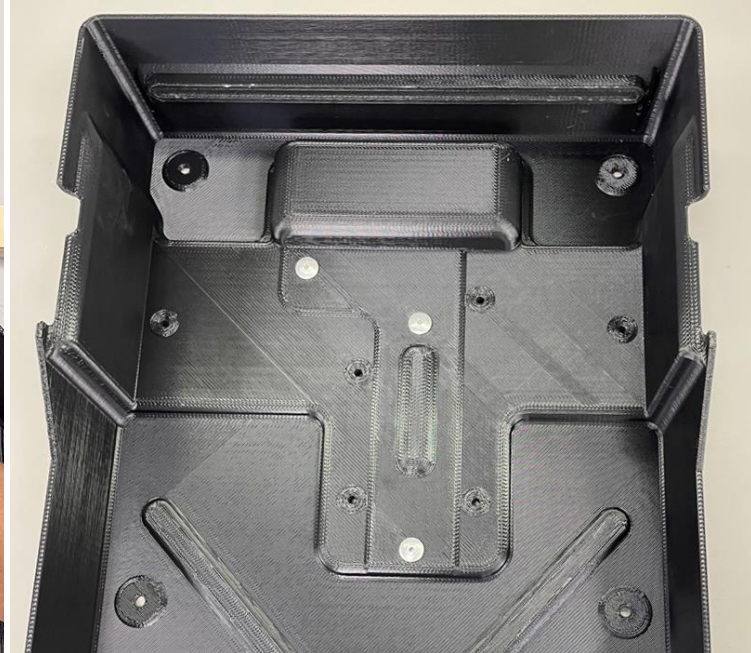
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Client:	VotingWorks	Doc. No.: VWX-001-D021
Project:	Ballot Receptacle	Revision: X01
Doc. Title:	E-Ballot Bin Assembly Instruction	Date: 2024-10-16

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1.2   Install 3 BASEPLATE RIVETS through the back of the E-BALLOT BIN into the holes in the E-BALLOT LATCH BASEPLATE.
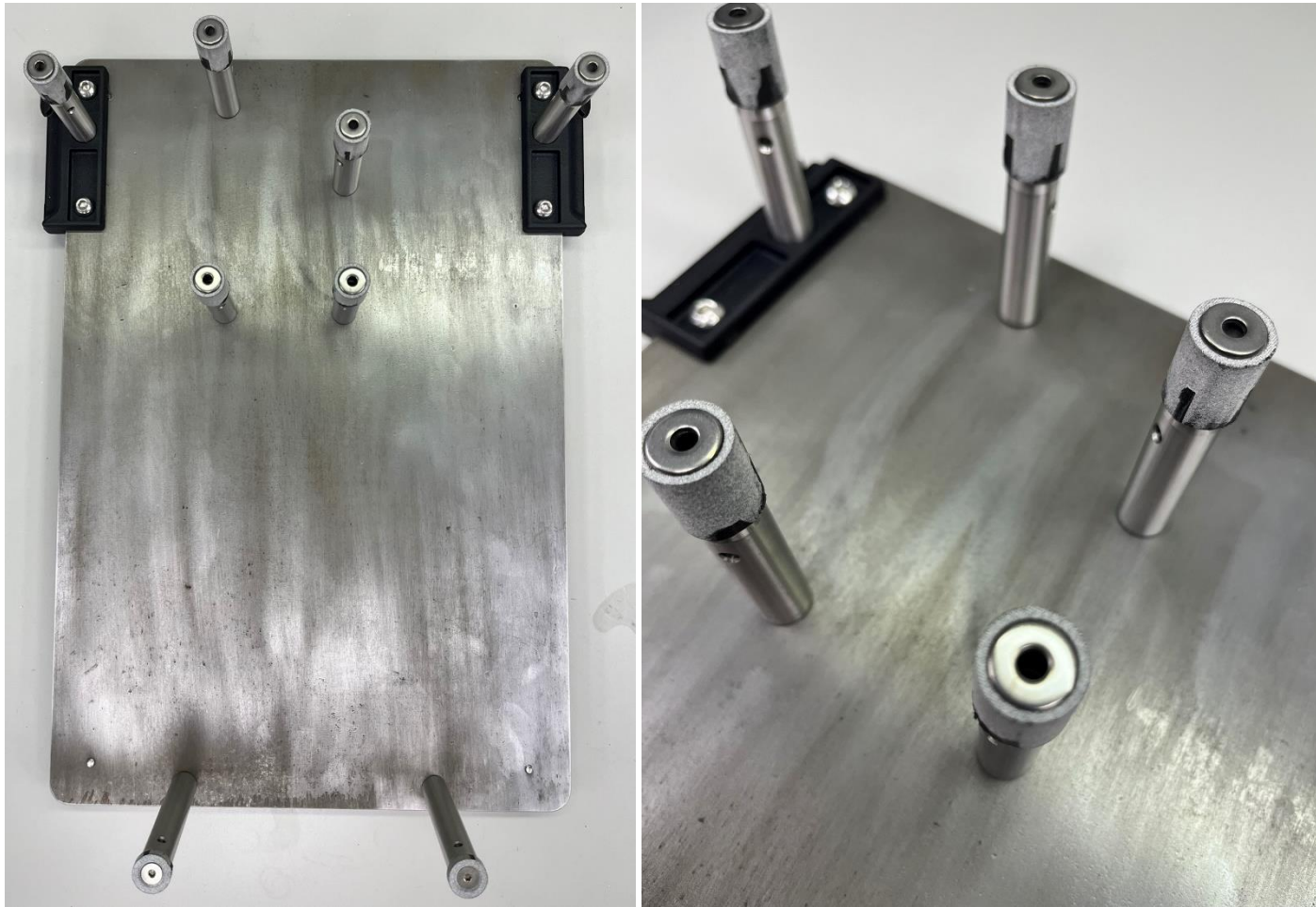
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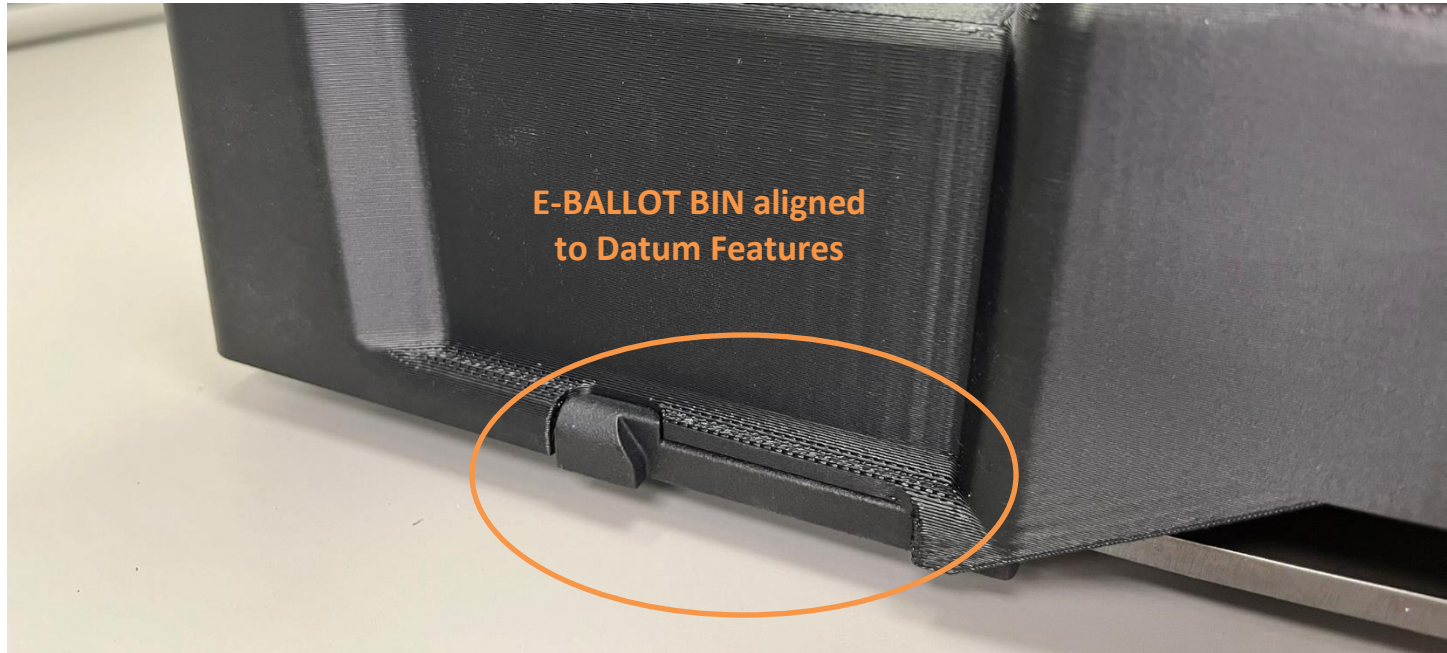1.3   While holding parts firmly together, cinch BASEPLATE RIVETS with RIVET GUN, securing BASEPLATE in place.

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STEP 2   INSTALL LATCH HANDLE

2.1   Place one RIVET WASHER onto each post in the E-BALLOT ASSEMBLY FIXTURE.
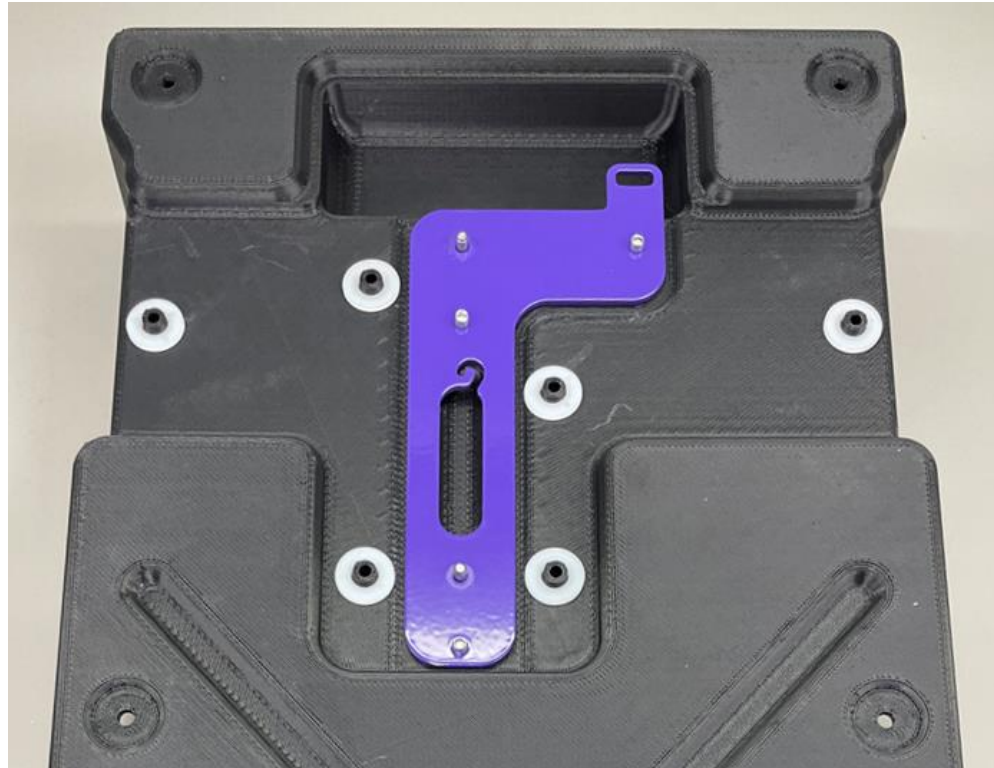

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2.2   Place the BIN on top of the E-BALLOT ASSEMBLY FIXTURE, ensuring that it is properly aligned to datum features.

E-BALLOT BIN aligned
to Datum Features

2.3 Place one LOWER WASHER around each of the six formed posts on top of the BIN.
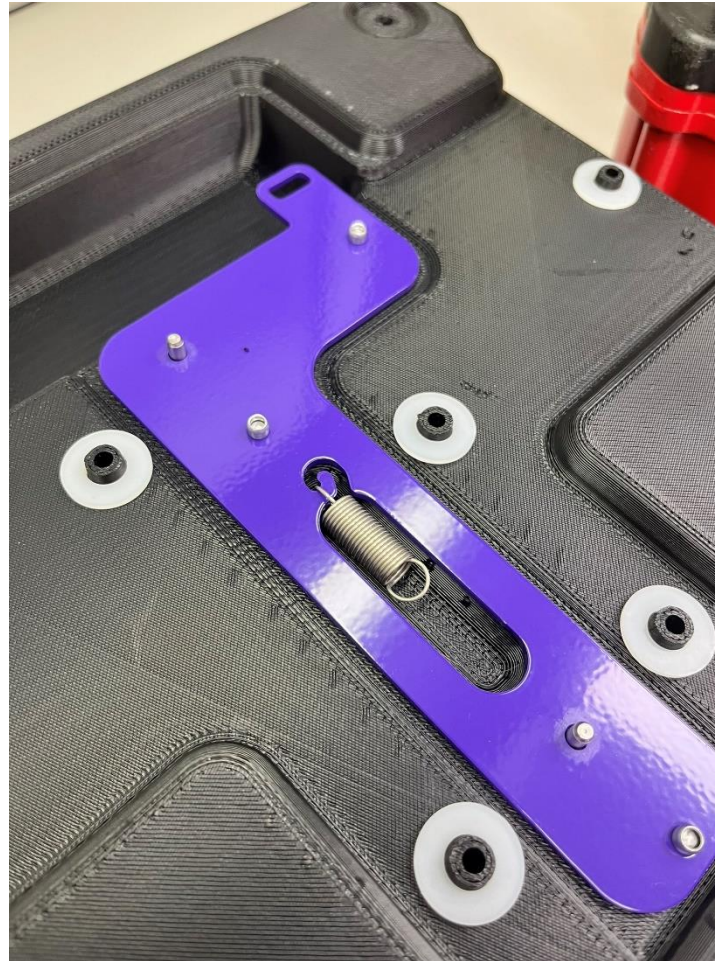
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2.4 Hook one end of RETURN SPRING around hook in BASEPLATE.

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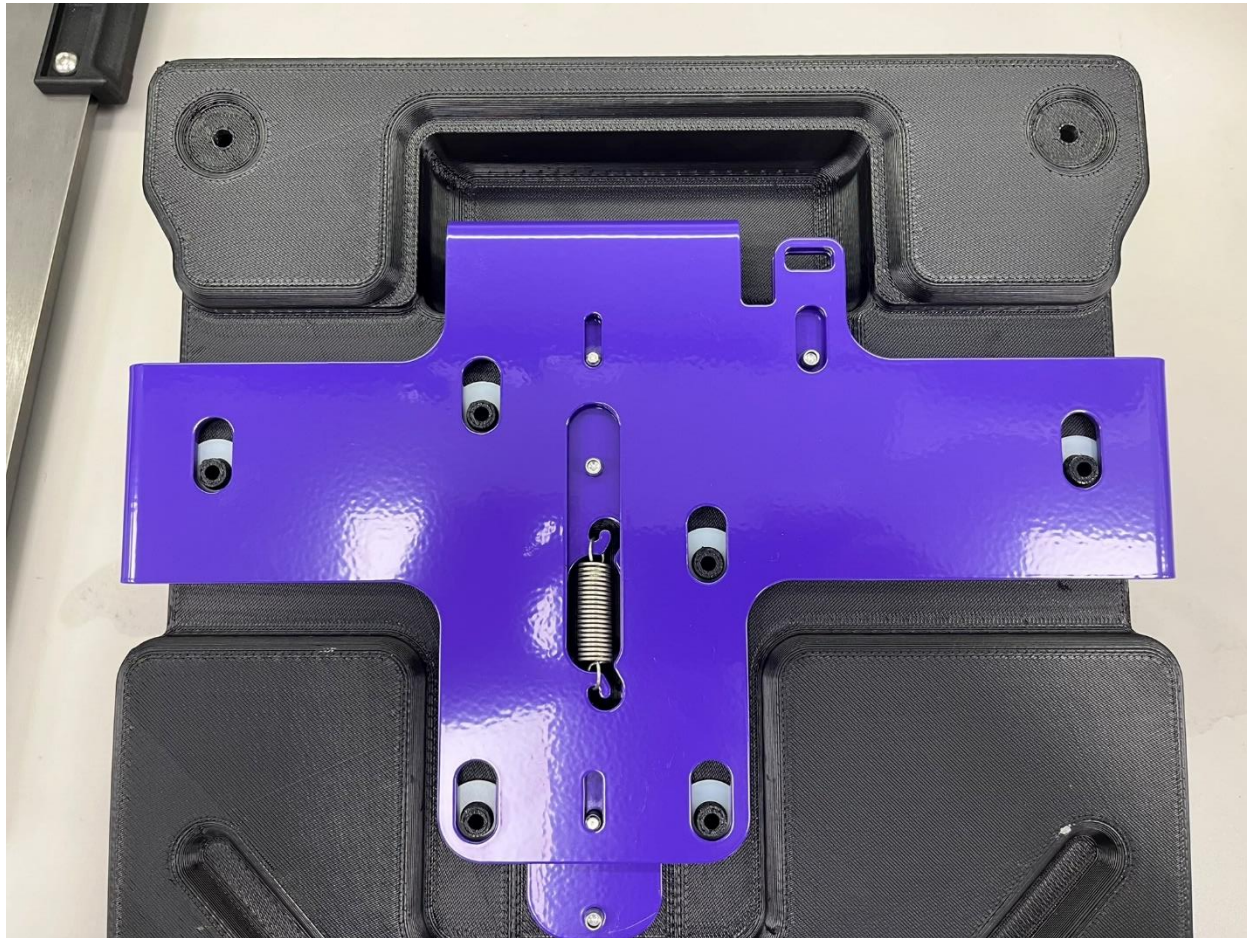2.5   Holding HANDLE above E-BALLOT BIN, install the other end of RETURN SPRING around hook in HANDLE.

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2.6   Place HANDLE on top of the BIN with the six large slots in the HANDLE aligned over the six formed posts on top of the BIN.
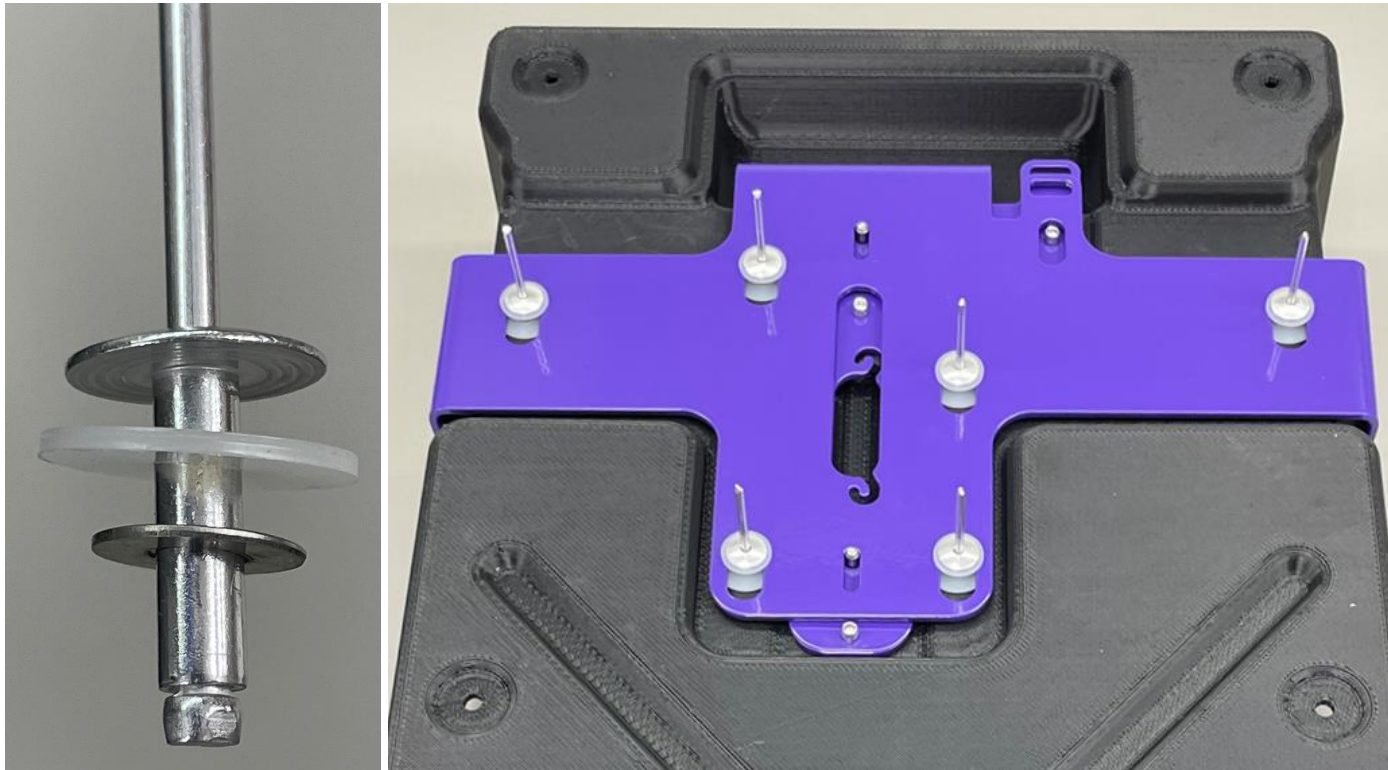
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2.7   Place one HANDLE RIVET and one UPPER WASHER into the top of each formed post on top of the BIN.

NOTE: After placing each HANDLE RIVET, press down firmly on the HANDLE RIVET and verify that the HANDLE can still translate freely.

2.8   For each HANDLE RIVET that is too tight, add a SHIM between the UPPER WASHER and the BIN post for that rivet.

2.9   Cinch HANDLE RIVETS with RIVET GUN, securing HANDLE in place.
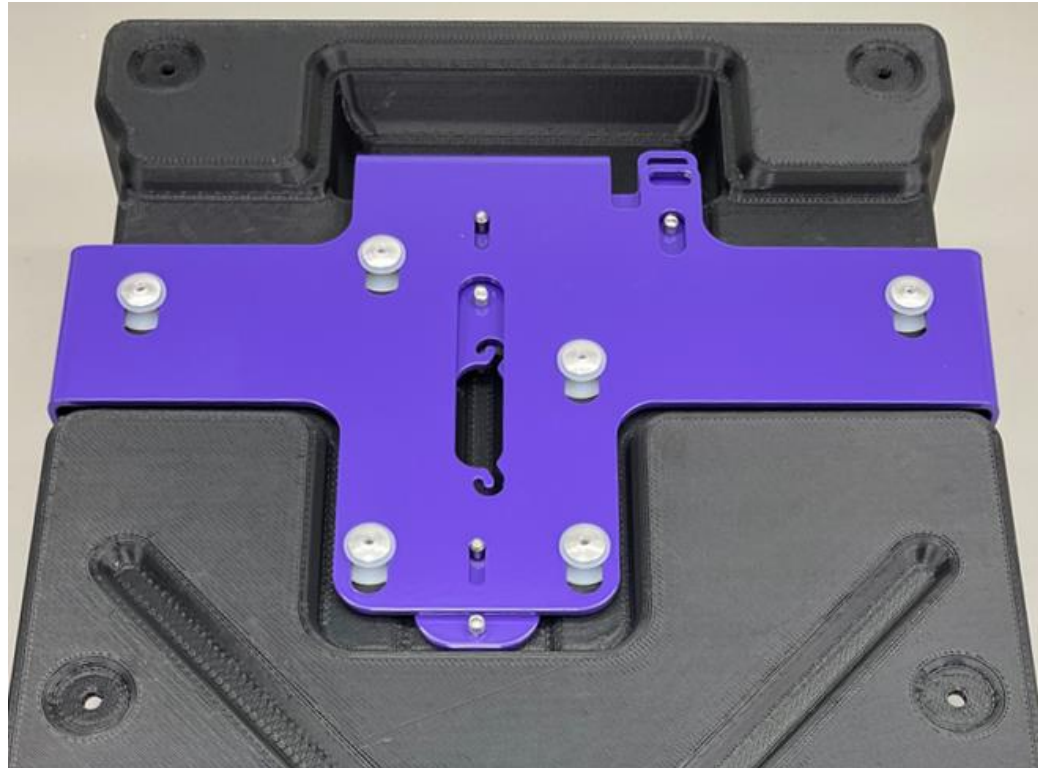
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2.10 Using Q-TIP, apply GREASE around both alignment slots in HANDLE.
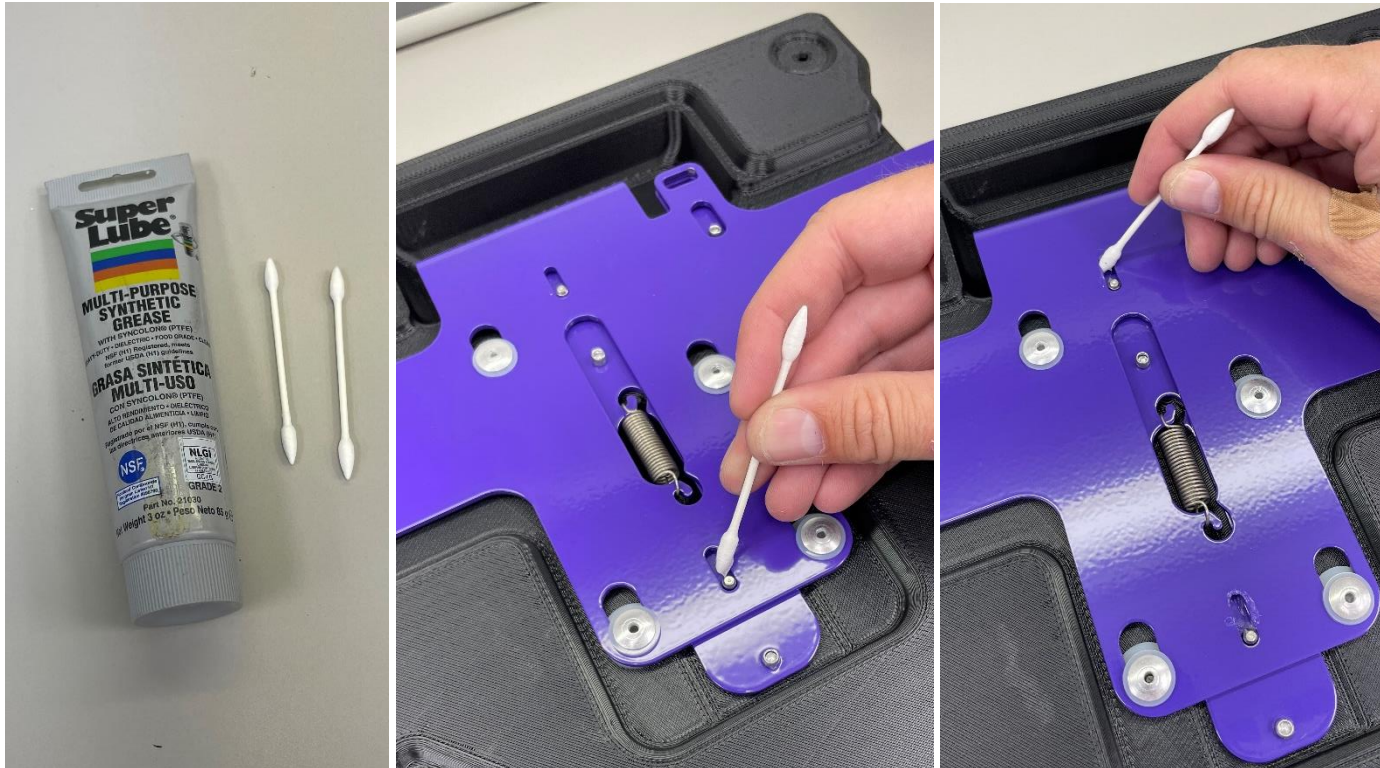
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STEP 3 INSTALL HINGE TUBE

3.1 Using M8 HEX KEY, install DOWEL NUTS into HINGE TUBE. Rotate DOWEL NUTS so that holes in DOWEL NUTS align with holes in HINGE TUBE

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3.2 Slide HINGE TUBE through the large bore at the base of the BIN

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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		