	Client: VotingWorks	Doc. No.: VWX-001-D015
	Project: Ballot Receptacle	Revision: X01
	Doc. Title: Scissor Link Assembly Instruction	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 Scissor Link Assembly (VX~01-10055).

2.0 PARTS & ASSEMBLIES

2.1 Made-To-Spec (MTS)

Item Number	Description
VX~02-10056	LINK SCISSOR, STRAIGHT
VX~02-10057	LINK SCISSOR, BENT


2.2 Off-The-Shelf (OTS)

Item Number	Description
VX~99-10054	SPACER, SEMI-TUBULAR RIVET, 3/16 IN
VX~99-10058	SEMI-TUBULAR RIVET, 3/16 IN X 7/16 IN, AL

3.0 TOOLS

3.1 Made-To-Spec (MTS)

Item Number	Description

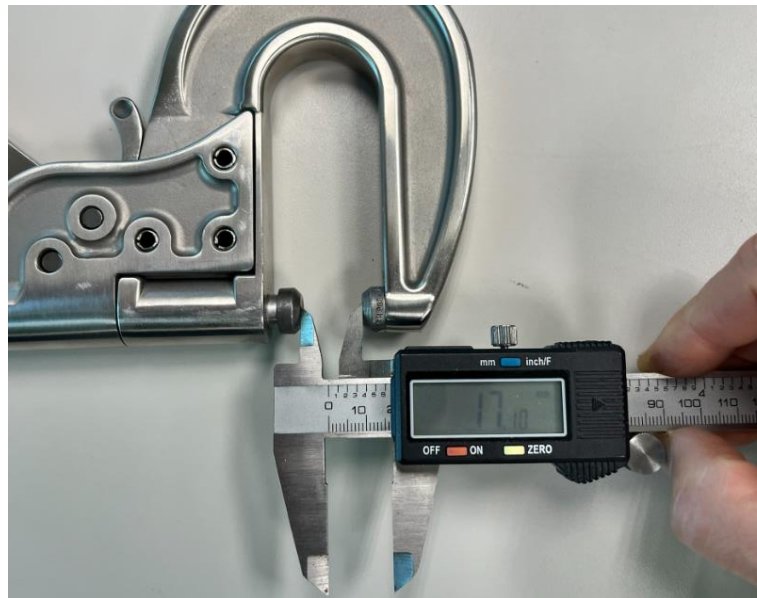
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3.2 Off-The-Shelf (OTS)

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

4.0 PREPARATION

Adjust the rivet squeezer to 17.1 mm




5.0 ASSEMBLY PROCESS

Assemble the Scissor Link Assembly (VX~01-10055) as defined in the following steps.

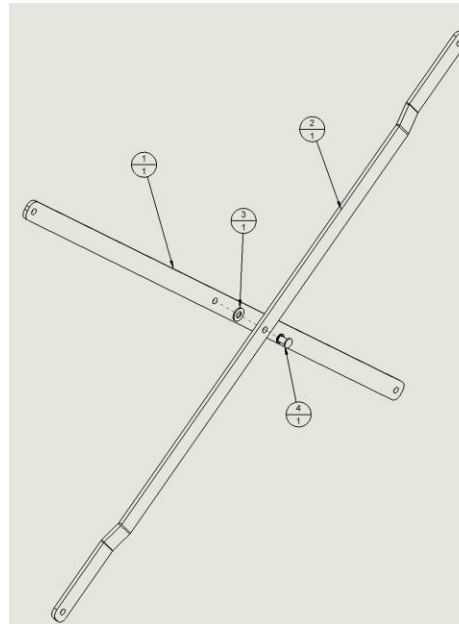
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STEP 1 ASSEMBLE SCISSOR LINK


1.1 Assemble all the parts as shown in figure 1.



PARTS LIST			
ITEM	P/N	DESCRIPTION	QTY
1	VX-02-10056	LINK, SCISSOR, STRAIGHT	1
2	VX-02-10057	LINK, SCISSOR, BENT	1
3	VX-99-10054	SPACER, SEMI-TUBULAR RIVET, 3/16 IN	1
4	VX-99-10058	SEMI-TUBULAR RIVET, 3/16 IN x 7/16 IN, AL	1

1.2 Using the rivet squeezer, crimp the semi-tubular rivet.

1.3 Verify that the scissor links move freely.

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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		