	Client: VotingWorks	Doc. No.: VWX-001-D013
	Project: Ballot Receptacle	Revision: X01
	Doc. Title: Frame 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 Frame Assembly (VX~01-10001).

2.0 PARTS & ASSEMBLIES

2.1 Made-To-Spec (MTS)


Item Number	Description
VX~01-10002	ASSY, REAR FRAME
VX~01-10034	ASSY, FRONT FRAME
VX~01-10148	ASSY, FLOOR
VX~01-10055	ASSY, SCISSOR LINK
VX~02-10129	SPACER, FLOOR PIVOT

2.2 Off-The-Shelf (OTS)

Item Number	Description
VX~99-10059	SEMI-TUBULAR RIVET, 3/16 IN X 11/16 IN, AL
VX~99-10054	SPACER, SEMI-TUBULAR RIVET, 3/16 IN
VX~99-10122	SEMI-TUBULAR RIVET, 3/16 IN X 3/8 IN, AL

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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-888-2	Solid rivet Semi-tubular Rivet Squeezer 2" Reach, 2" Gap
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

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4.0 PREPARATION

Adjust the 2" gap rivet squeezer (TO-TP-888-2) to 24.5 mm



Adjust the 1-1/4" gap rivet squeezer (TO-TP-888-3) to 15.9 mm




5.0 ASSEMBLY PROCESS

Assemble the Frame Assembly (VX~01-10001) as defined in the following steps.

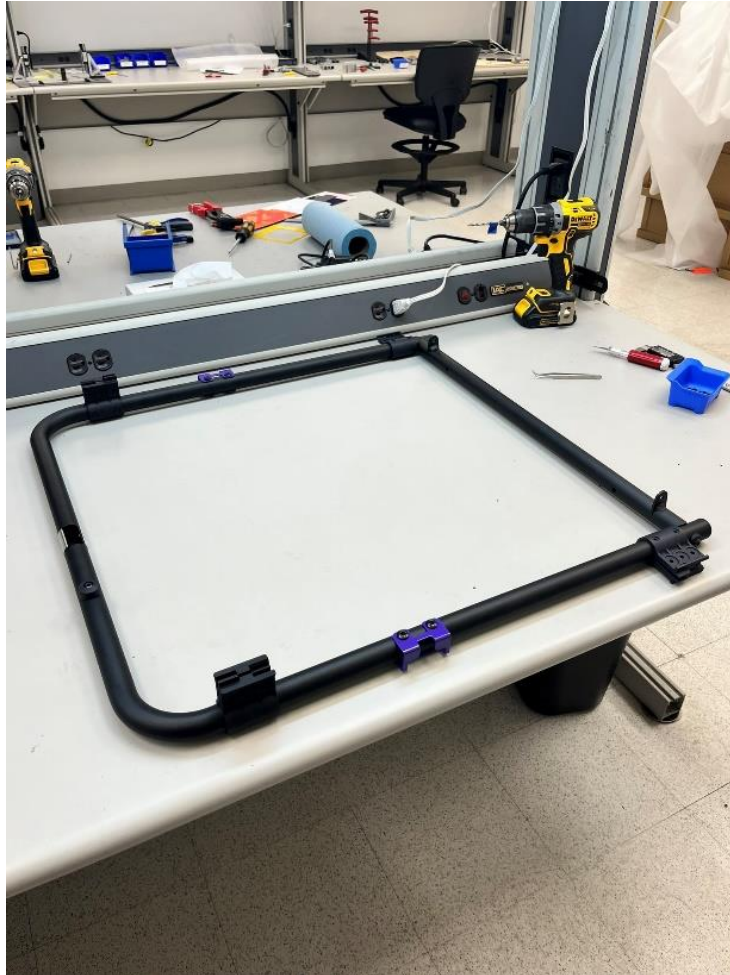
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STEP 1 INSTALL SCISSOR LINK ASSEMBLIES


1.1 Place the Front Frame Assy on the bench front side down.



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- 1.2 Position a Scissor Link Assy (VX~01-10055) into the Front Frame Assy so that the flat scissor link interfaces with the fixed slider and the Scissor Link Assy's rivet head faces outward. Use the longer semi-tubular rivets (VX~99-10059) to capture the Scissor Link Assy in both the fixed and free slider as shown with their heads facing outward. These rivets will be crushed later.



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1.3 Repeat step 1.2 to place the remaining Scissor Link Assy (VX~01-10055) onto the other side of the front frame assy



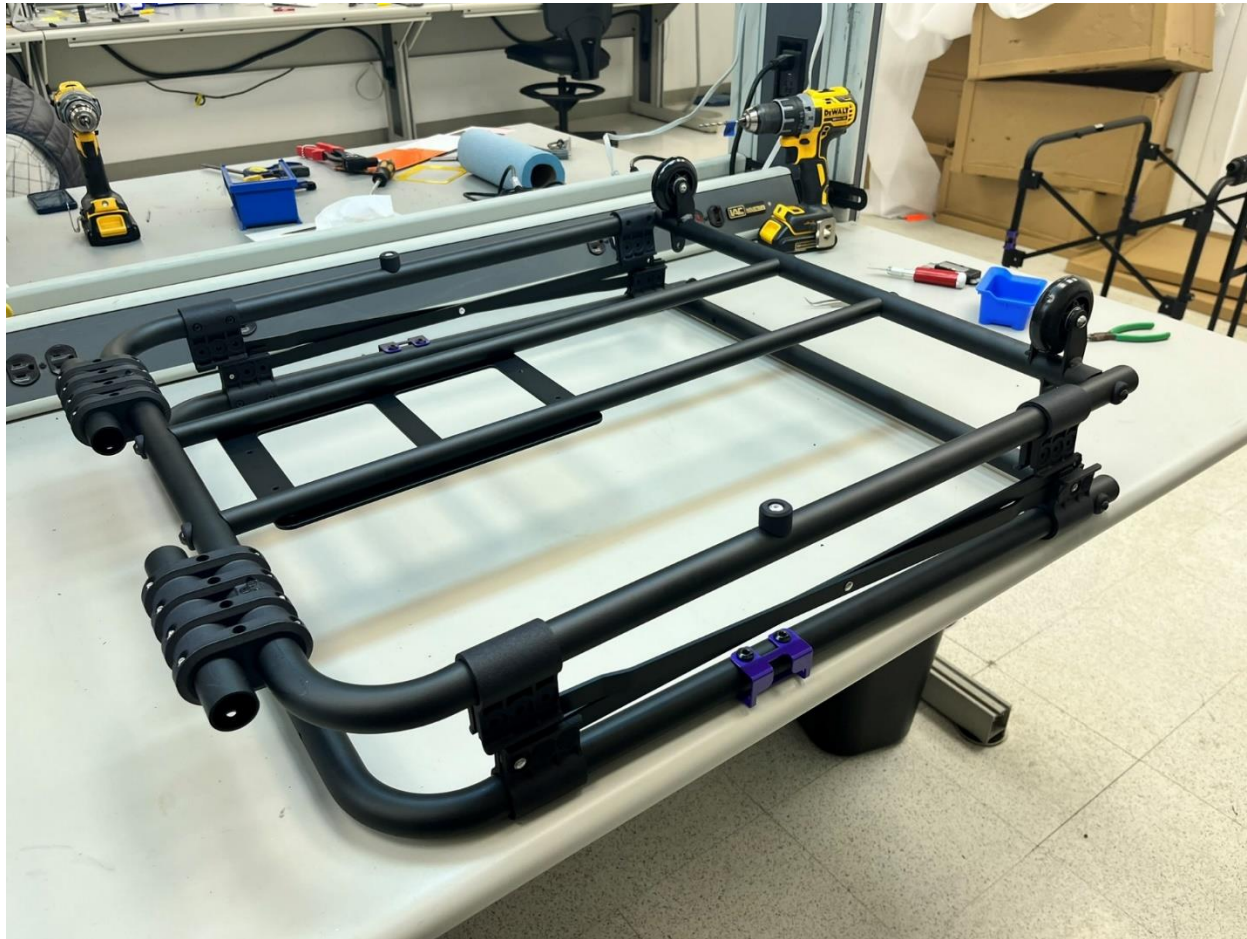
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- 1.4 Place the Rear Frame Assy (VX~01-10002) on top while positioning all 4 of its slider's over the free ends of the attached scissor links as shown.

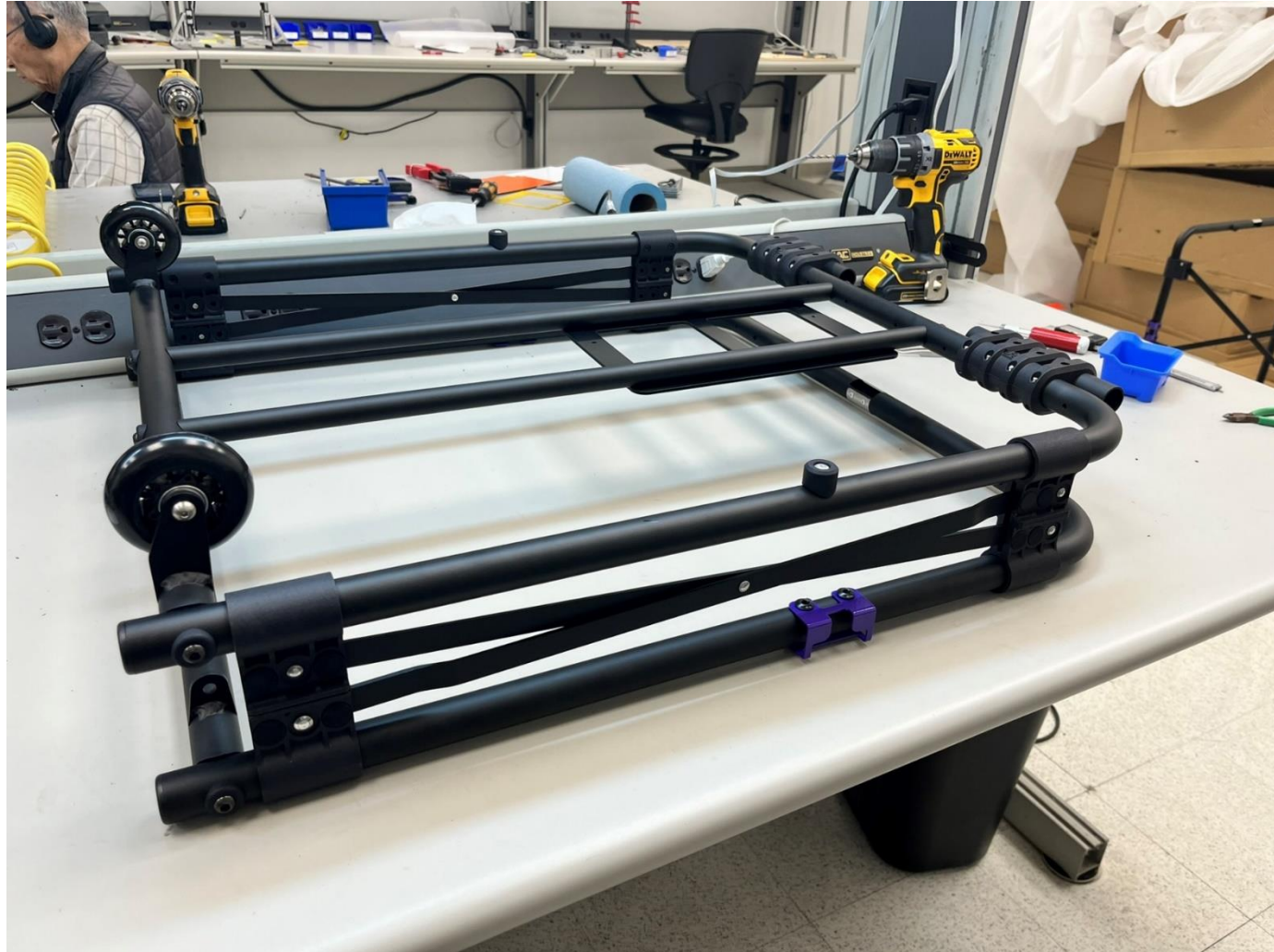


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- 1.5 Use the longer semi-tubular rivets (VX~99-10059) to capture the free ends of the Scissor Link Assy in both the fixed and free slider as shown with their heads facing outward.



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- 1.6 Crush all 8 semi-tubular rivets with the 2" gap rivet squeezer. Start with crushing the 4 closest, then reposition the assembly 180 degrees and crush the remaining 4.



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STEP 2 INSTALL FLOOR ASSEMBLY

2.1 Lift the assembly upright on its feet and extend it as shown.

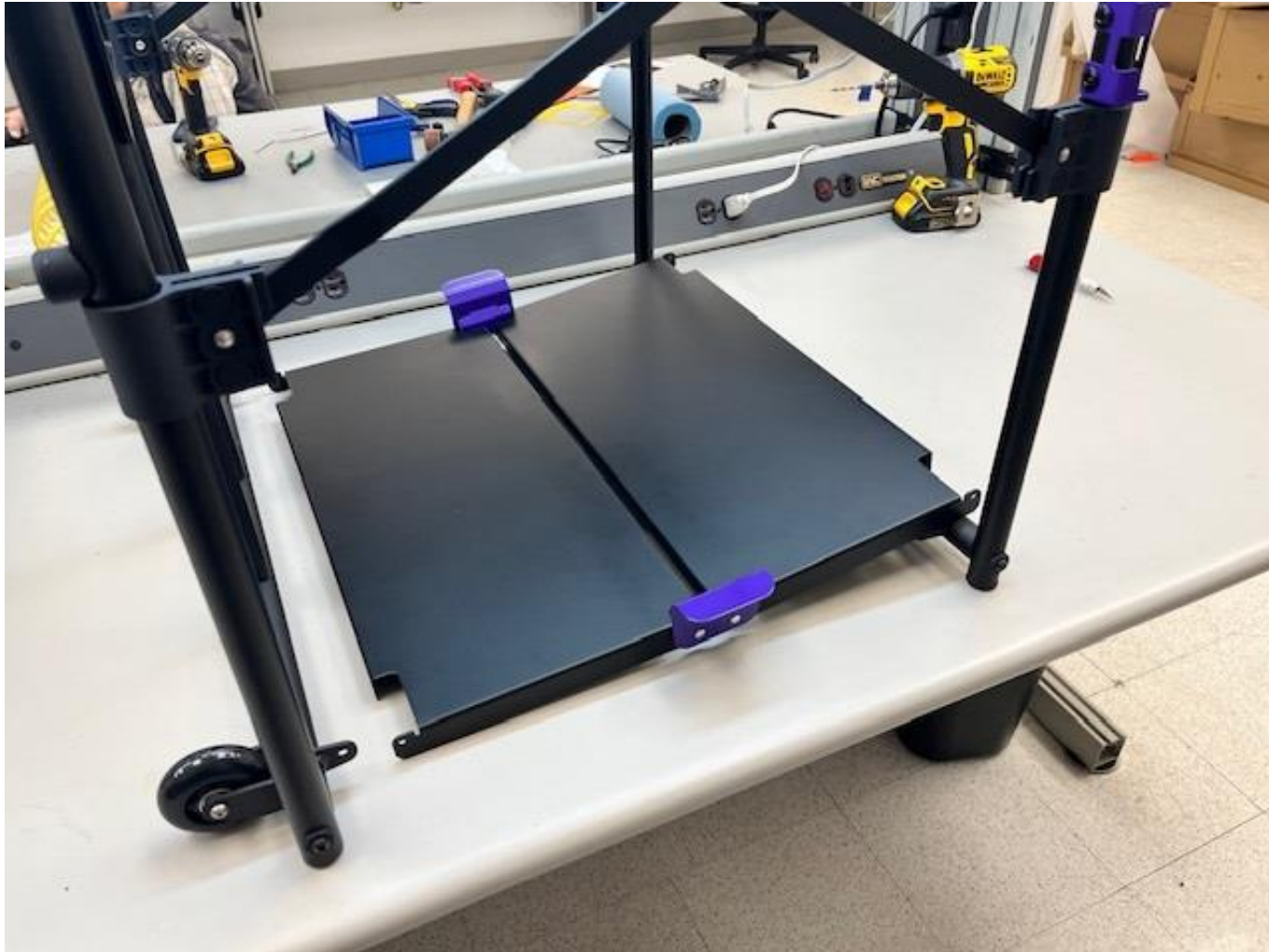


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2.2 Place the Floor Assy into position on the bench.



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2.3 Insert a Floor Pivot Spacer (VX~99-10129) into each floor pivot holes of each of the Rear and Front Frame Assy.



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- 2.4 Place the Floor Assy onto the frame using a Semi-tubular Rivet Spacer (VX~99-10054) and the shorter of the two Semi-tubular rivets (VX~99-10122) at each pivot as shown. Note that the Semi-tubular Rivet Spacer is positioned between the Frame's welded tab and Floor.



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- 2.5 Affix the Floor Assy to the Frame but crushing each of the installed semi-tubular rivets with the 1-1/4" Gap Rivet Squeezer (TO-TP-888-3).



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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		