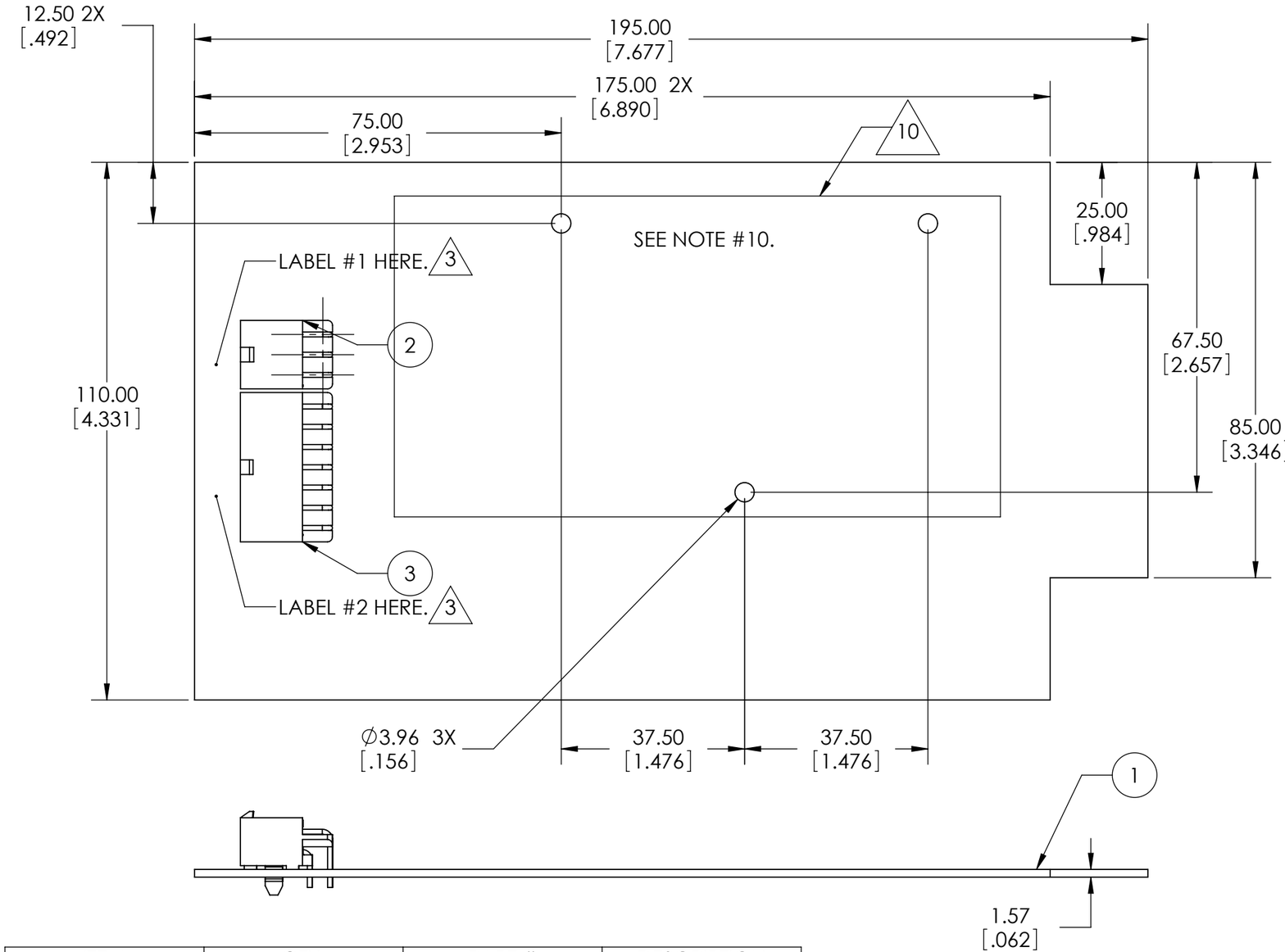


BUILD NOTES:

1) ASSEMBLY TO BE BUILT USING QPL BILL OF MATERIAL: **BOM1212102rvA.**

2) WORKMANSHIP STANDARD PER: IPC-J-STD-001D, IPC-A-610 OR NEWER. SOLDERING AND ELECTRICAL CONNECTIONS PER: IPC-S-815B OR NEWER.

3) LABEL #1: APPLY WITH THE FOLLOWING INFORMATION:
- TENNANT PART NUMBER AND REVISION.
EXAMPLE: **1212102-00**. NOTE: THIS NUMBER AND REVISION SHOULD MATCH THE RELEASED TENNANT DRAWING.
LABEL #2: APPLY WITH THE FOLLOWING INFORMATION:
- MANUFACTURER'S LABEL WITH SERIAL NUMBER.

4) FUNCTIONAL TEST: REFER TO BENCHMARK FUNCTIONAL TEST PROCEDURE: ECH2O FUNCTIONAL TEST 12-7-2012.

5) ITEM #2: TYCO, #1-770969-0, 6 PIN, 90 DEGREE HEADER, 2x3, QPL #Q15015-015.
ITEM #3: TYCO, #1-770979-0, 14 PIN, 90 DEGREE, HEADER, 2x7, QPL #Q15015-019.

6) THIS ASSEMBLY WILL BE USED IN THE T17 EC-H20 MODULE 1212103.

7) APPLY RTV AND CONFORMAL COATING AS PER NOTES ON PAGE 2 OF 2.

8) ASSEMBLY TO BE MANUFACTURED PER RoHS/LEAD FREE STANDARDS.

9) DRAWING DIMENSIONS ARE FOR REFERENCE ONLY. REFER TO GERBER FILES FOR EXACT PCB DIMENSIONS.

10) NO SOLDER BUMPS ON THE BACK SIDE OF THE PCB IN THIS AREA. REFER TO SIL PAD DRAWING (TENNANT # 1038890) FOR DIMENSIONS.

| ITEM | QTY. | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 1 | SEE NOTE #1 | PC BOARD |
| 2 | 1 | SEE NOTE #5 | 6 PIN HEADER |
| 3 | 1 | SEE NOTE #5 | 14 PIN HEADER |

**PENDING RELEASE**

| REV | ECO |
|---|---|
| 00 | |

CHANGED BY: JOHN HAEG — DATE: 01/30/2014
MDR: — 01/30/2014
DES: JOHN HAEG — 11/21/2013

MATERIAL SPECIFICATIONS:
OTHER TREATMENTS AND FINISHES
PAINT - COLOR
GLOSS | PERFORMANCE | ACCEPTANCE
PART NAME: CIRCUITBOARD ASSY [EC-H2O, MOD-E, T17]

WELDING NOTATION IN ACCORDANCE WITH AWS A2.4-98

UNLESS OTHERWISE SPECIFIED DIMENSION TOLERANCING IN ACCORDANCE WITH ASME Y14.5M-2009 ALL UNTOLERANCED DIMENSIONS ARE BASIC AND CONTROLLED BY:

| | | |
|---|---|---|
| X.X | ±0.8 | ±[.03] |
| X.XX | ±0.25 | ±[.010] |
| X.XXX | ±0.125 | ±[.0049] |
| ANGLES | ±0.5° | |

GENERAL NOTES

PRIMARY DIMENSIONS ARE METRIC, REFERENCE DIMENSIONS WITH BRACKETS ARE INCH. UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE AFTER TREATMENTS AND FINISHES.



SHEET 1 OF 2

TENNANT

DWG B SIZE

PART NUMBER 1212102

CONFORMAL COATING AND RTV NOTES:
1) CONFORMAL COATING MATERIAL:
DYMAX CORP. #9-20557.
APPLIED COATING TO BE 91-112(MIC) THICK.
2) MASK OFF THE FOLLOWING AREAS ON THE TOP SIDE
OF THE ASSEMBLY:
- CONNECTORS J1, J3, J4, J5.
- 6MM FROM THE PCB EDGE. THIS AREA IS FOR GASKETS THAT WILL BE APPLIED AS PART OF THE EC-H2O ASSEMBLY.
- 6MM AROUND CONNECTORS J4 AND J5. REFER TO GASKET #1044794 FOR MASKING OUTLINE.
3) MASK OFF THE FOLLOWING AREAS ON THE BOTTOM SIDE
OF THE ASSEMBLY:
- 6MM FROM THE PCB EDGE. THIS AREA IS FOR GASKETS THAT WILL BE APPLIED AS PART OF THE EC-H2O ASSEMBLY.
- 6MM AROUND CONNECTORS J4 AND J5. REFER TO GASKET #1044794 FOR MASKING OUTLINE.
4) APPLY NON-CORROSIVE PCB SAFE RTV (LOCTITE 5145 OR EQUIVALENT) AROUND THE FOLLOWING COMPONENTS FOR VIBRATION PROTECTION:
C36, C46, C47, C74, X1. MINIMUM RTV BEAD DIAMETER TO BE 3MM.

**PENDING RELEASE**

| REV | ECO |
|---|---|
| 00 | |

CHANGED BY: JOHN HAEG DATE: 01/30/2014
MDR: 01/30/2014
DES: JOHN HAEG 11/21/2013

| MATERIAL SPECIFICATIONS: | OTHER TREATMENTS AND FINISHES | PAINT - COLOR | | |
|---|---|---|---|---|
| PART NAME: CIRCUITBOARD ASSY [EC-H2O, MOD-E, T17] | | GLOSS | PERFORMANCE | ACCEPTANCE |

WELDING NOTATION IN ACCORDANCE WITH AWS A2.4-98

UNLESS OTHERWISE SPECIFIED DIMENSION TOLERANCING IN ACCORDANCE WITH ASME Y14.5M-2009 ALL UNTOLERANCED DIMENSIONS ARE BASIC AND CONTROLLED BY:

| | | |
|---|---|---|
| X.X | ±0.8 | ±[.03] |
| X.XX | ±0.25 | ±[.010] |
| X.XXX | ±0.125 | ±[.0049] |
| ANGLES | ±0.5° | |

GENERAL NOTES
PRIMARY DIMENSIONS ARE METRIC, REFERENCE DIMENSIONS WITH BRACKETS ARE INCH. UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE AFTER TREATMENTS AND FINISHES.





TENNANT

DWG B SIZE

PART NUMBER 1212102