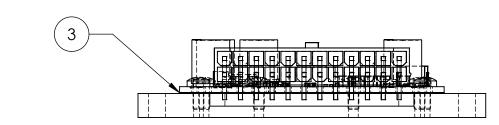
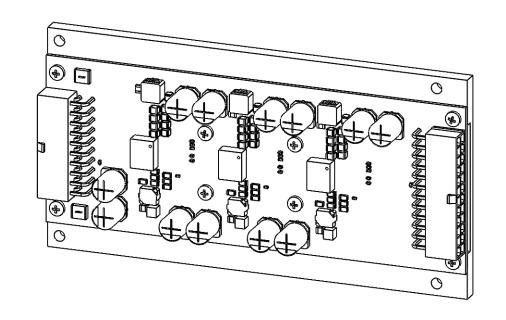




ITEM NO.	QPL BOM NUMBER	DESCRIPTION	QTY.
1	Q25094-001	CIRCUIT BOARD, PCB (SEE NOTE #1)	1
2	1247727	heat sink	1
3	1247722	SIL PAD	1
4	SEE QPL BOM	SCREW, PAN, PHL, M3 X 0.50 X 6, 4.8. (SEE NOTE #10)	8





- 1) BUILD BOARD USING THE FOLLOWING QPL BOM: BOM1247720revB.xls.
- 2) THIS BOM IS LOCATED ON THE TENNANT ELECTRICAL ENGINEERING WEBSITE.
- 3) WORKMANSHIP STANDARD, SOLDERING AND ELECTRICAL CONNECTIONS PER: IPC-J-STD-001D OR LATEST REVISION - CLASS 2.
- 4) APPLY TWO LABELS ON THE TOP SIDE OF THE PCB WITH THE FOLLOWING INFORMATION: LABEL #1: TENNANT PART # WITH CURRENT REVISION: **1247720-E.** (SHOULD MATCH THIS DRAWING.)
 LABEL #2: MANUFACTURER SERIAL NUMBER WITH
 BAR CODE FOR TRACEABILITY.
- 5) ICT AND FUNCTIONAL TESTING IS REQUIRED FOR EACH BOARD.
 FUNCTIONAL TEST PER SPEC "FCT REV 1 MAKO DC_DC BOARD" - CONTINUITY TEST BETWEEN HEATSINK AND TP3 (GROUND -COMMON) PASS = OPEN FAIL = ANY MEASURABLE RESISTANCE
- 6) ASSEMBLY TO BE MANUFACTURED PER ROHS/LEAD FREE STANDARDS.
- 7) REFER TO THE GERBER FILES FOR PCB MANUFACTURING NOTES.
- 8) THIS ASSEMBLY REPLACES 1058963.
- 9) DIMENSIONS FOR REFERENCE ONLY.
- 10) APPLY NON-CORROSIVE PCB SAFE RTV AROUND C1-C6. -C9-C14 AND L10-L12. MOMENTIVE RTV-108 OR EQUIVALENT. MINIMUM BEAD DIAMETER = 3 MM.
- 11) TORQUE THE (8) M3 SCREWS (ITEM #4) TO 43-56 Ncm.

REV ECO 00 32407 CHANGED BY: PAUL HENDERSON DATE: 12/16/2019 OTHER TREATMENTS AND FINISHES PAINT - COLOR MATERIAL SPECIFICATIONS: NOTED NONE STACY GAHLON 12/09/2019 X.XXXGLOSS PERFORMANCE | ACCEPTANCE | DES: CIRCUITBOARD ASSY [DC TO DC CONV.] ANGLES ±0.5° DAN WORKMAN 04/11/2014

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] ±0.25 ±[.010] X.XX

±0.125 ±[.0049]

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

PROPRIETARY INFORMATION MAY NOT BE REPRODUCED OR DISCLOSED TO OTHERS WITHOUT WRITTEN PERMISSION OF TENNANT COMPANY.

SHEET 1 OF 1

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SIZE

TENNAN1 DWG PART NUMBER 1247720