



- BUILD NOTES:
- 1) ASSEMBLY TO BE BUILT USING QPL BILL OF MATERIAL: **BOM1254501_revA**.
 - 2) WORKMANSHIP STANDARD PER: IPC-J-STD-001E, IPC-A-610E CLASS 2 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: **1254501-02**. 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 FUNCTIONAL TEST PROCEDURE **1254501_DCCS_rev01_FunctionalTest.xlsx**
 - 5) ASSEMBLY TO BE MANUFACTURED PER RoHS/LEAD FREE STANDARDS.
 - 6) DRAWING DIMENSIONS ARE FOR REFERENCE ONLY. REFER TO GERBER FILES FOR EXACT PCB DIMENSIONS.
 - 7) NO SOLDER BUMPS ON THIS SIDE OF PCB INSIDE THE INCLOSED AREA.
 - 8) U14 IS PROGRAMMED WITH FILE: Q30091-005_DC_ECH20_PRODUCTION_IMAGE_2_26.bin
 - 9) AFFECTS UL LISTINGS, DO NOT SUBSTITUTE
 - 10) CERTIFICATE OF COMPLIANCE TO BE INCLUDED WITH EACH SHIPMENT PER TENNANT DOCUMENT 1270315.

- CONFORMAL COATING AND RTV NOTES:
- 1) CONFORMAL COATING MATERIAL: **Q50000-001** ON COMPONENT SIDE OF PCB
 - 2) MASK OFF THE FOLLOWING AREAS ON THE TOP SIDE OF THE ASSEMBLY:
- CONNECTOR BODY AND LEADS: J1, J2, J10, J11, J12.
- 8.5MM FROM THE PCB EDGE. THIS AREA IS FOR GASKET THAT WILL BE APPLIED AS PART OF THE EC-H2O ASSEMBLY.
 - 3) APPLY NON-CORROSIVE PCB SAFE RTV (Q50001-001) AROUND THE FOLLOWING COMPONENTS FOR VIBRATION PROTECTION: L3, L4, B1, C11 AND C12. MINIMUM RTV BEAD DIAMETER TO BE 3MM.

- REV 02 CHANGES:
- 1. CHANGED TO 1254501 REV A BOM
 - 2. UPDATED RTC BATTERY AND CRYSTAL OSCILLATOR
 - 3. ADDED NOTES 9 AND 10 FOR UL COMPLIANCE
 - 4. IN CONFORMAL COATING NOTES REPLACED LOCTITE SPEC WITH QPL PART NUMBER
 - 5. IN CONFORMAL COATING NOTESCHANGED CR1 TO B1

ECO CONSULTATION

MATERIAL SPECIFICATIONS: NOTED		OTHER TREATMENTS AND FINISHES NOTED		PAINT - COLOR NONE		CHANGED BY: KEN BITTNER	DATE: 09/17/2024
PART NAME: CIRCUITBOARD ASSY [EC-H2O, DC]		GLOSS		PERFORMANCE	ACCEPTANCE	MDR:	12/11/2020
						DES: DAN WORKMAN	02/01/2018

REV		ECO	WELDING NOTATION IN ACCORDANCE WITH AWS A2.4-98			GENERAL NOTES		
02			UNLESS OTHERWISE SPECIFIED DIMENSION TOLERANCING IN ACCORDANCE WITH ASME Y14.5-2009 ALL UNTOLERANCED DIMENSIONS ARE CONTROLLED BY:			PRIMARY DIMENSIONS ARE METRIC. REFERENCE DIMENSIONS WITH BRACKETS ARE INCH. UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE AFTER TREATMENTS AND FINISHES.		
			DATE: 09/17/2024	X.X	±0.8	±[.03]	PROPRIETARY INFORMATION MAY NOT BE REPRODUCED OR DISCLOSED TO OTHERS WITHOUT WRITTEN PERMISSION OF TENNANT COMPANY.	
			12/11/2020	X.XX	±0.25	±[.010]		
				X.XXX	±0.125	±[.0049]		
			02/01/2018	ANGLES	±05°			
				SHEET 1 OF 1				

TENNANT	
PART NUMBER	1254501