This document is written for the following area(s) checked below:			
☒ R&D	☒ Production	☐ Repair & Maintenance	☐ Customer

1.0 PURPOSE

The purpose of this document is to present the step-by-step procedures required to successfully assemble/inspect/report on the FlowStat 2 chassis, **P/N 61211**.

2.0 REFERENCES

For more information, see the latest versions of the following documentation:

- **AP-10006:** Loctite Application Procedure

3.0 TOOLS

Use the following tools and equipment for this assembly procedure:

- Allen Hex Key Driver (5/64 inch)
- Soldering Iron

4.0 MATERIALS AND SUPPLIES

Gather the following items prior to assembling the FlowStat chassis:

- Acetone
- Kapton Tape (1 inch wide)

5.0 SAFETY CONSIDERATIONS

Use all common work shop safety procedures, practices and equipment in accordance with local and national regulations, such as safety glasses, latex gloves, and protective shoes. APS employees should also refer to **DOC-HSE-10097** Personal Protective Equipment (PPE).

6.0 PROCEDURES

Use these procedures to install prepare the [redacted] chassis (P/N [redacted]).

1. Fly Leads, uphole direction ([redacted] Chassis side view)
2. Battery is located at the center of the PCB (side view - wire terminal side)
3. Pigtail (wires covered with [redacted])
4. [redacted] (top view - electrical PCB side)

Figure 1: SAMPLE - [redacted] Assembly

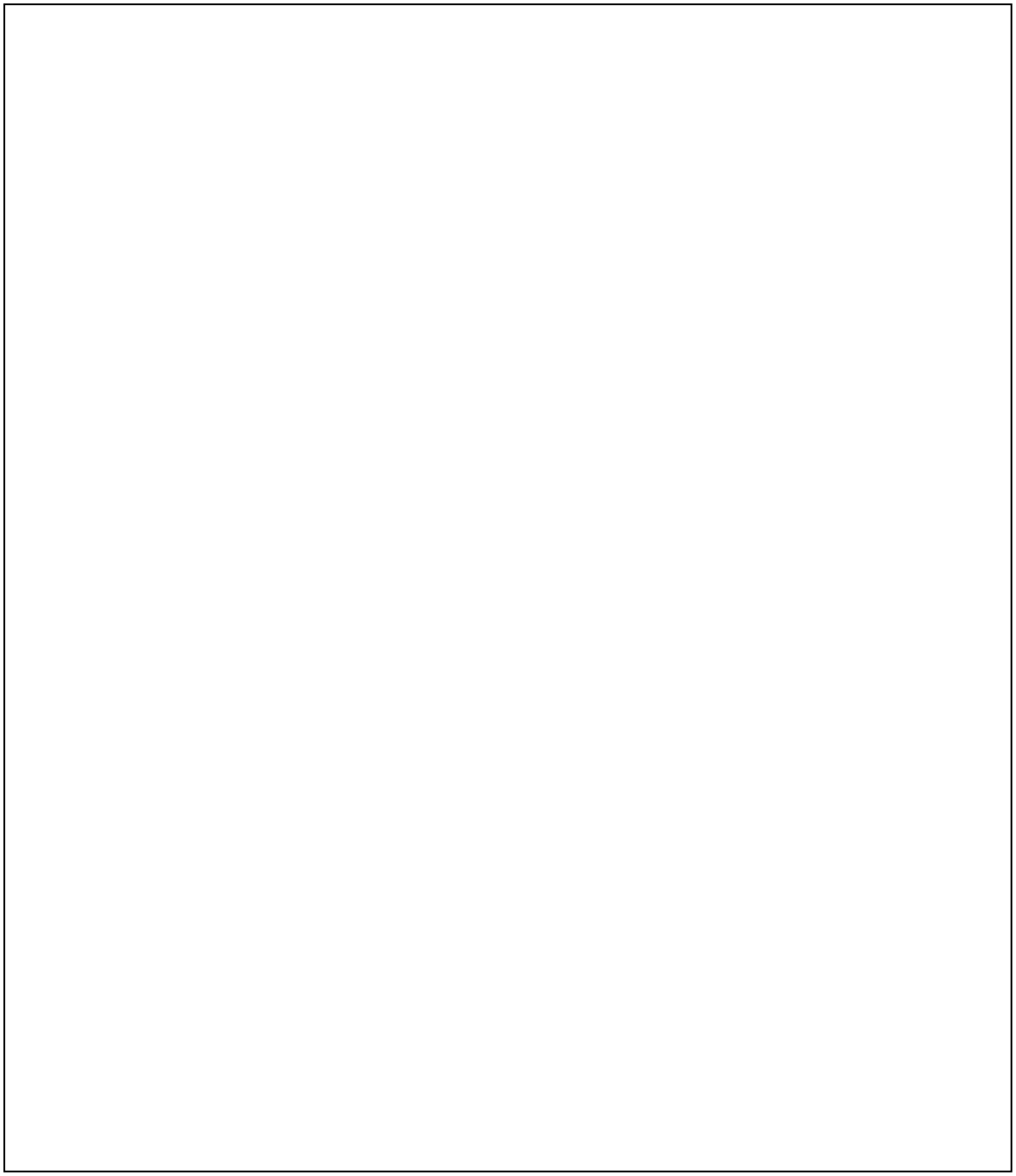


Figure 2: SAMPLE BOM for the [redacted] *Chassis Assembly* ***<UPDATE with final from Lynn>***

✓ All steps in the procedure that require a technician's initials on the Quality Check-off Data Sheet are designated with ☑ at the end of that procedure step.

6.1 Perform an Inventory Check

Verify that all required parts for assembly are correctly identified on the Bill of Material (BOM). Contact your supervisor to resolve discrepancies.

6.2 Install Studs into the Chassis

6.2.1 Apply Loctite.

Apply a dab of Loctite[redacted] to the center of each stud (P/N [redacted].

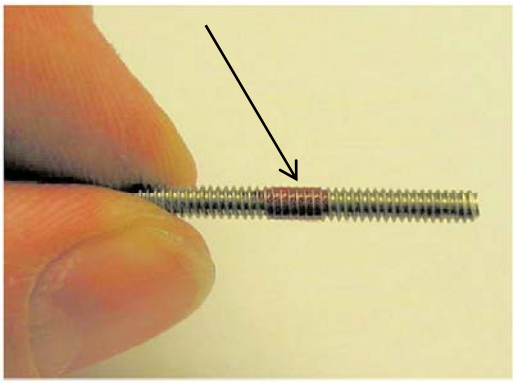


Figure 3: Lubricate Studs

6.2.2 Insert studs.

Thread a stud into each hole of the chassis housing.

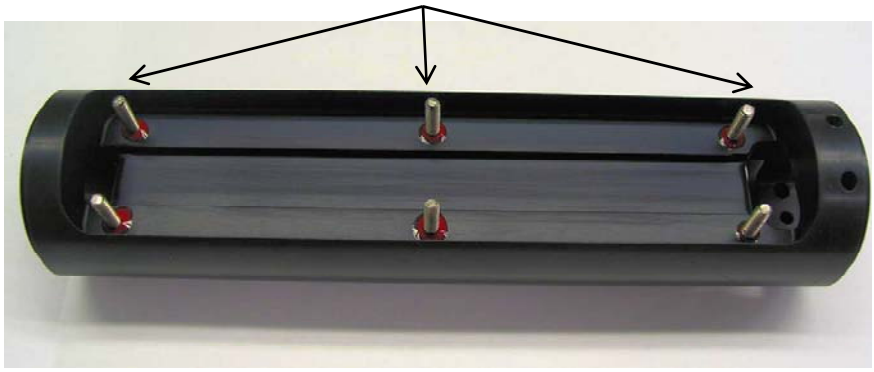


Figure 4: Insert Studs into Chassis

6.2.3 Remove excess Loctite from unit.

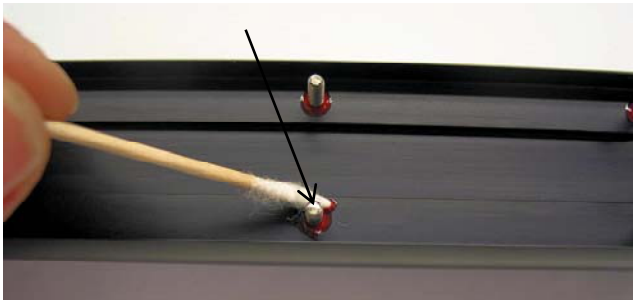


Figure 5: Remove Excess Loctite from Unit

6.2.4 Thread stud into the center of each hole (side view of chassis).

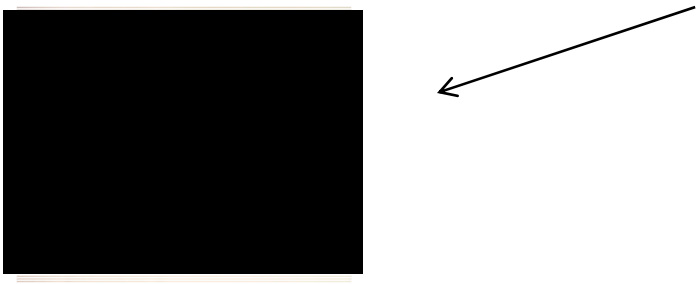

[redacted]

Figure 6: A Centered Stud

6.3 Install Strain Relief into the Chassis

Thread brass set screw into one strain relief clamp. Assemble the chassis as shown using the arbor press or vice to press in the 1/8 inch dowel pins.

1. Brass Screw
2. Strain Relief

Figure 7: Strain Relief Mechanism

6.4 Install Spacers and two PCBs

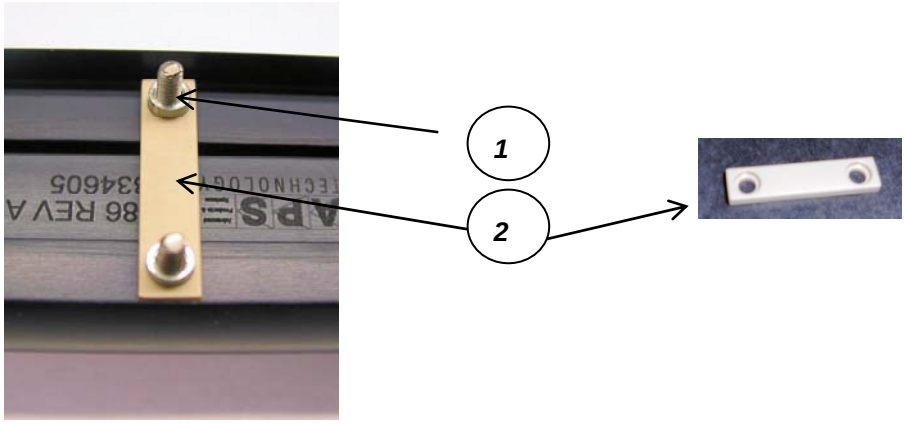
There are two printed circuit boards (PCB):

- A Terminal side for wire connections and the battery
- An Electronic side for the capacitor, etc.

6.4.1 Install Spacers.

Insert the spacers as shown for both sides (Terminal PCB, Electrical PCB) of the chassis.

Figure 8: [redacted] *with Spacers Installed*



1. Circular Spacer, P/N [redacted] ***(quantity = 6)***

2. Bar Spacer, P/N 11437 (quantity = 3)

Quantity is for one side of the chassis.

8.0 ATTACHMENTS - SAMPLE DRAWINGS

NOTE: Before starting the assembly procedure, check for the most recent BOM that will show the latest Part Number Revisions and the latest drawing. It is also important to check the "*Engineering Pending Change*" report in Vantage to see if any parts have a pending change status.

9.0 DOCUMENT REVISION HISTORY

Table 1: Documentation Revision History

Rev	Date	Changed By	Description	ECO No.	Checked By
X1	12/7/2011	[redacted]	Initial Release for R&D to support the pending ECO-10-444. Outstanding questions are in red.	11-258	[redacted]
A	03/2/2012	J. Thomas	Change name from Next Gen to [redacted] clear outstanding questions; release to Production.	12-XXX	[redacted]

Related Product Lines: [redacted]

10.0 QUALITY SIGN-OFF DATA SHEET(S)

NOTE: The completed Sign-off Sheet(s) should be removed by Quality Control and filed with all associated job documents.

[redacted] ASSEMBLY CHASSIS

Quality Check-off Sheet

Part Number _____ **Rev** _____

Production Date _____

Serial Number _____

Step	Sign-off Items	Assembler/Date	Inspector/Date
Step 6.2, on page 4	Install Studs into the Chassis		Not Required
Step 6.3, on page 5	Install Strain Relief into the Chassis		Not Required
Step 6.4, on page 5			Not Required
Step 6.5, on page 7			Not Required
[redacted] **not found.**, on page **Error! Bookmark not defined.**			Not Required
Step **Error! Reference source not found.**, on page **Error! Bookmark not defined.**			Not Required
	Continuity Test and functional testing is described in the Test Procedure for the upper level assembly (61212-TP).	Not Required	