


REV.	DESCRIPTION	DATE

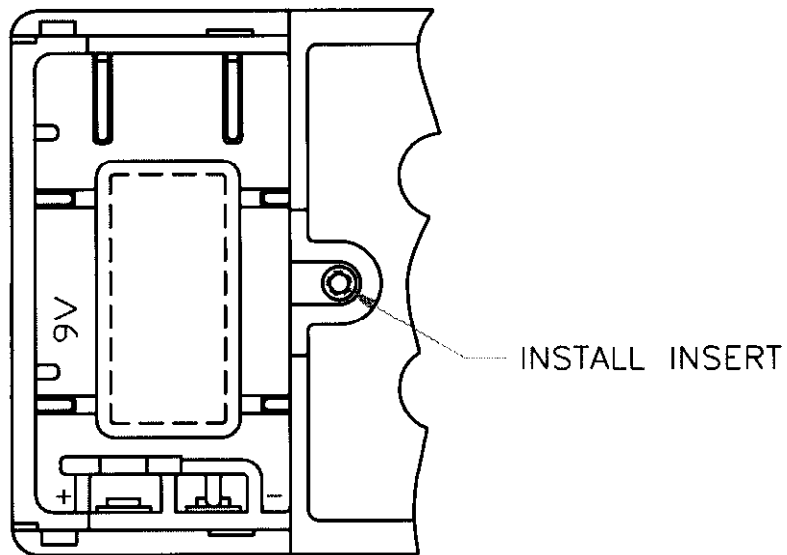
PRELIMINARY

NEXT HIGHER ASSEMBLY	DESCRIPTION
	418MHz RADIO TRANSMITTER

<p>⚠ WARNING: P-Q Controls, Inc. products are intended as general purpose switches. They are NOT safety devices and as with any general purpose devices, malfunctions may occur. If P-Q products are used to initiate an operation where false operation could be dangerous, POINT-OF-OPERATION GUARDING DEVICES must be installed and maintained to meet all appropriate OSHA and ANSI machine safety standards. P-Q Controls, Inc. shall not accept responsibility for installation, application or safety of systems.</p>	 <p>P-Q Controls, Inc. 95 Dolphin Rd. Bristol, CT 06010 PHONE: (860) 583-6994 FAX: (860) 583-6011</p>	DWG. NO. A-10331	REV.
		SHEET 1 OF 9	SCALE N/A
ASSEMBLY PROCEDURE – TRANSMITTER ASSY. 418 MHz			
DRAFTSMAN RBP	CHECK	PROJECT ENGINEER	DATE 08-12-98



1. INSTALL INSERT INTO HOUSING



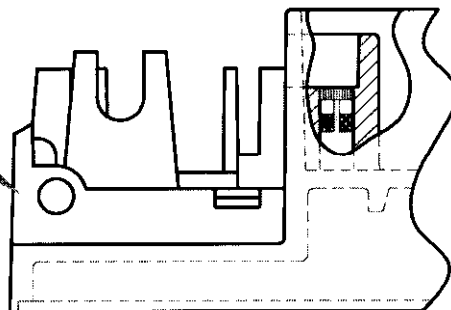
USE PUNCH (B-10041)
WITH ARBOR PRESS
TO INSTALL INSERT



THREADED INSERT
A-10334-632



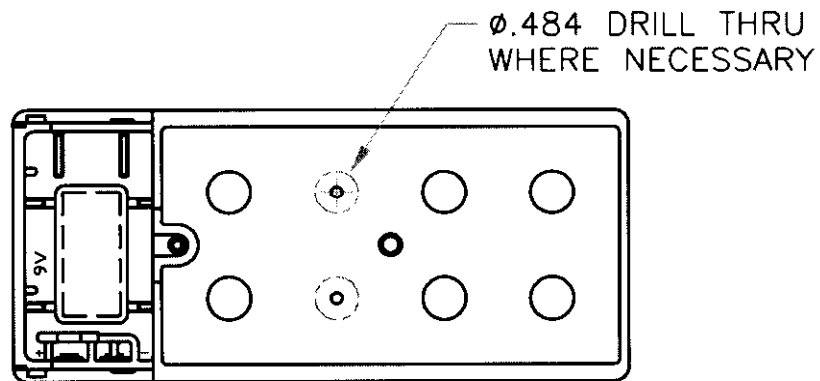
HOUSING
D-09960



INSTALL AN INSERT, WITH AN ARBOR PRESS, FLUSH OR SLIGHTLY BELOW INTO THE HOUSING AS SHOWN.

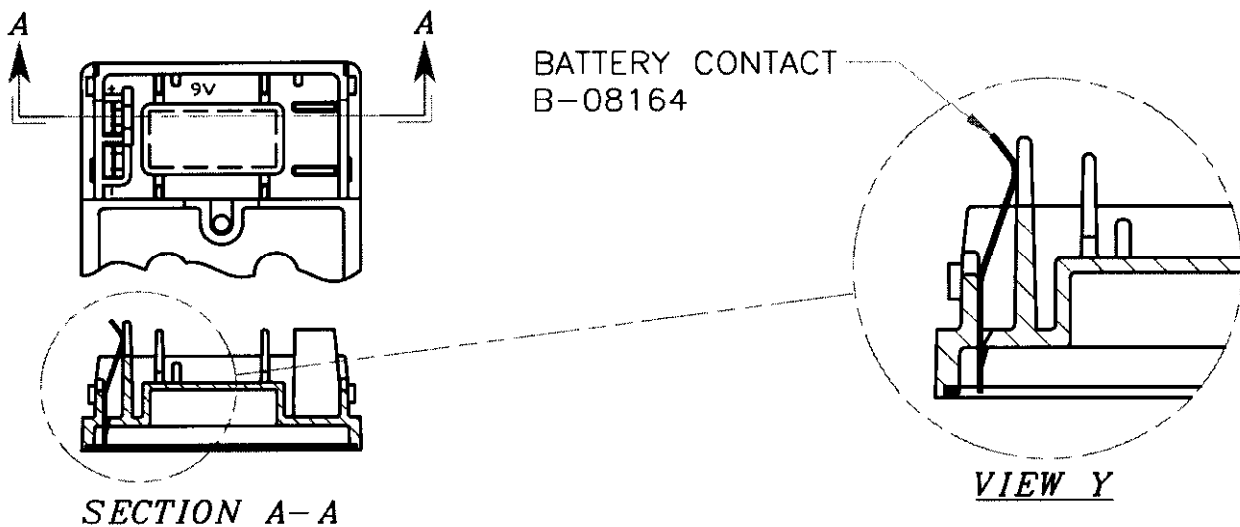


2. DRILL OUT HOLES ON THE SWITCH POSITIONS NOT YET OPENED.



ON HOUSINGS NEEDING MORE SWITCH POSITIONS, DRILL OUT THE HOLES NEEDED BY CENTERING THE DRILL OVER THE COUNTER BORE AND DRILLING OUT THE HOLES IN THE POSITIONS NEEDED.

3. INSTALL BATTERY CONTACTS.

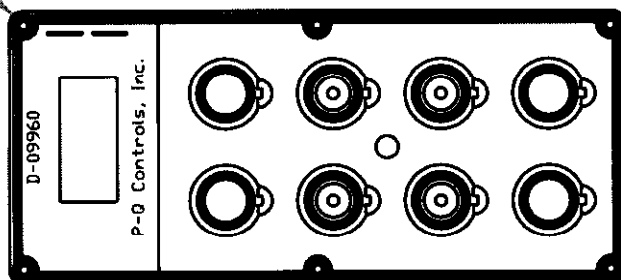


INSERT THE 2 BATTERY CONTACTS INTO THE SLOTS IN THE HOUSING AS SHOWN.



4. APPLY GASKET TO THE HOUSING

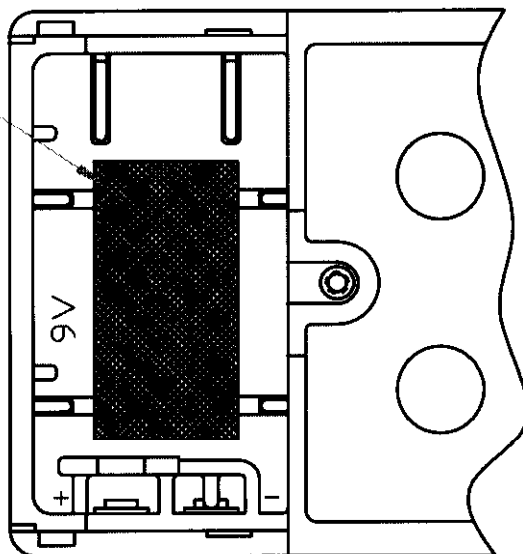
GASKET
B-09935



CLEAN GASKET CAVITY WITH DENATURED ALCOHOL REMOVE ADHESIVE BACKING FROM THE GASKET, AND APPLY THE GASKET TO THE HOUSING AS SHOWN.

5. APPLY BATTERY CASE LID GASKET TO THE HOUSING

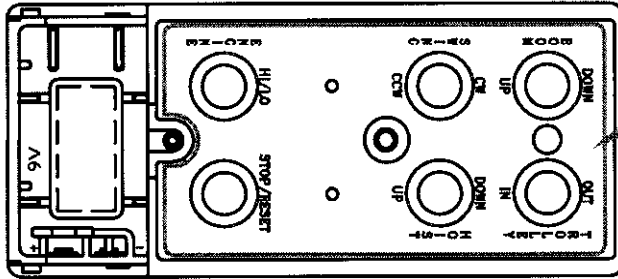
GASKET
B-03342



CLEAN GASKET AREA WITH DENATURED ALCOHOL. REMOVE ADHESIVE BACKING FROM THE GASKET, AND APPLY THE GASKET TO THE HOUSING AS SHOWN.



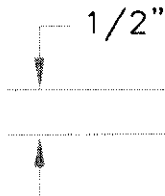
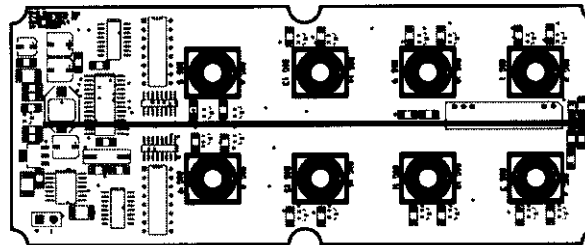
6. INSTALL DECAL ONTO HOUSING



PANEL DECAL
PART # VARIES
WITH ORDER

CLEAN DECAL APPLICATION AREA WITH DENATURED ALCOHOL. REMOVE THE ADHESIVE BACKING FROM THE DECAL, AND APPLY THE DECAL TO THE HOUSING AS SHOWN.

7. INSTALL ANTENNA



ANTENNA
B-10390

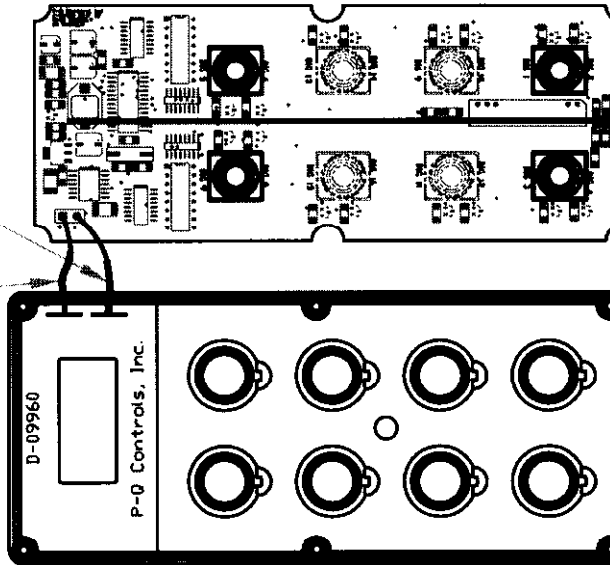
SOLDER ANTENNA ONTO BOARD AS SHOWN.



8. ATTACH THE BATTERY WIRES

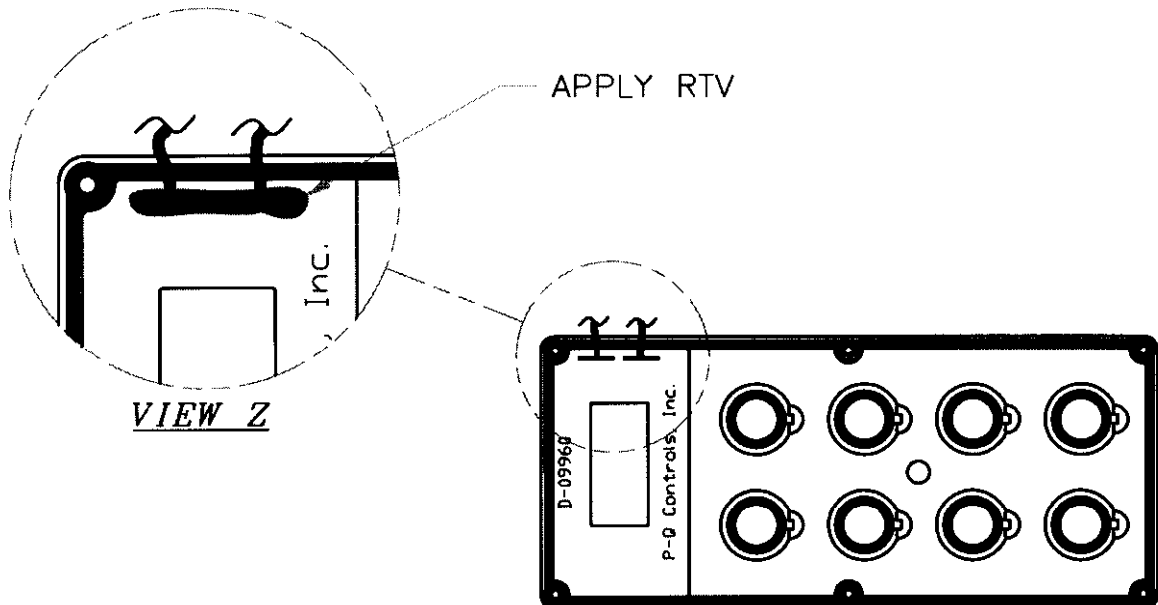
BLACK WIRE
A-00438-03-BK

RED WIRE
A-00438-03-RD



PREPARE AND SOLDER THE BATTERY WIRES FROM THE BATTERY TERMINALS TO THE PC BOARD AS SHOWN.

9. APPLY RTV TO BATTERY CONTACTS



APPLY LOCTITE SELF LEVELING RTV #5140 TO THE CONTACTS AS SHOWN IN VIEW Z. THE OBJECTIVE OF THE RTV IS TO SEAL THE SPACE BETWEEN THE CONTACTS AND THE SLOTS IN THE HOUSING.

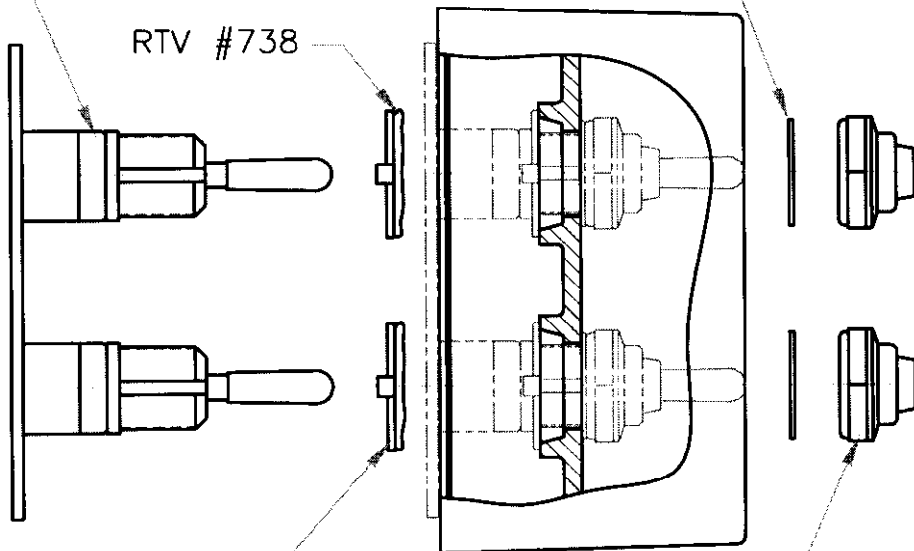


10. INSTALL PC BOARD

PC BOARD
ASSY.

INT. TOOTH WASHER
(SUPPLIED WITH SWITCH)

RTV #738



WASHER WITH DOG
(SUPPLIED WITH SWITCH)

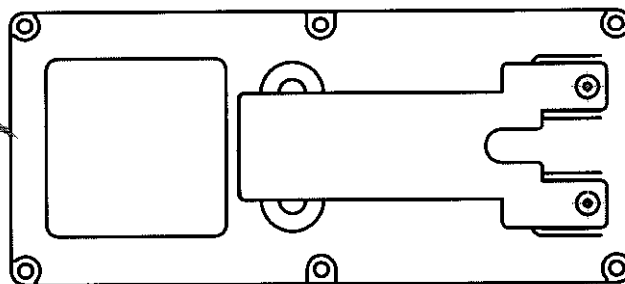
SWITCH BOOT
A-07349-01

PLACE A BEAD OF RTV (#738) AROUND THE WASHER WITH THE DOG (TAB POSITIONED TOWARD PC BOARD). INSERT SWITCHES THROUGH HOLES, AND PRESS THE ASSEMBLY TOGETHER. BE SURE NO WIRES ARE CAUGHT BETWEEN THE SWITCHES AND THE HOUSING. ASSEMBLY AND TIGHTEN THE WASHERS AND THE BOOTS ONTO THE OTHER SIDE OF THE HOUSING AS SHOWN.

11. INSTALL BELT CLIP

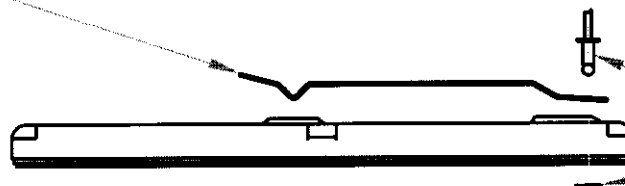
BASE
C-09961

BELT CLIP
C-09963



POP RIVET
A-04080-02

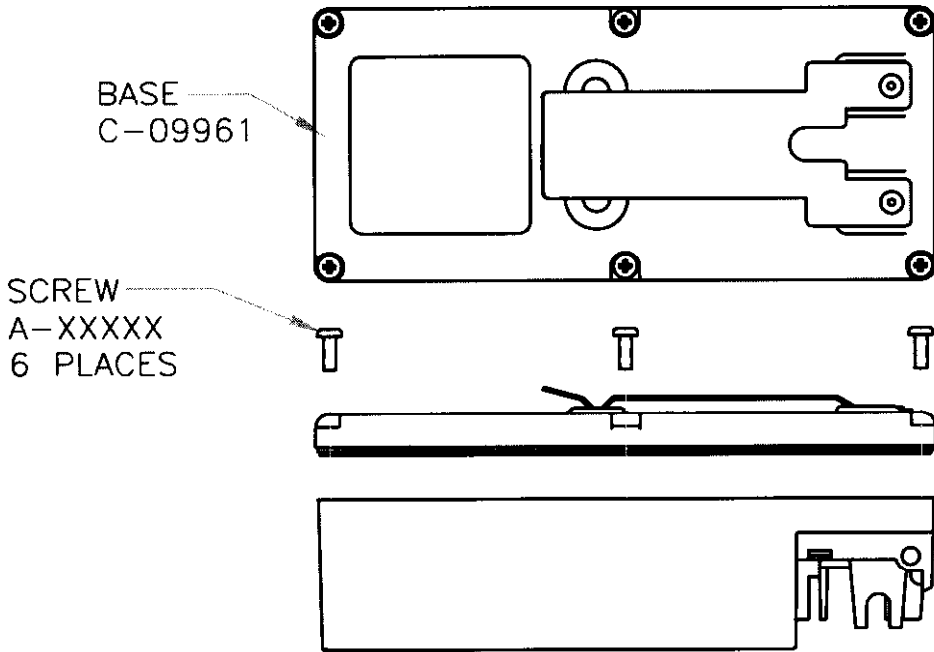
FLAT WASHER
A-04082-04



POT RIVET THE BELT CLIP TO THE BASE USING THE PARTS SHOWN.

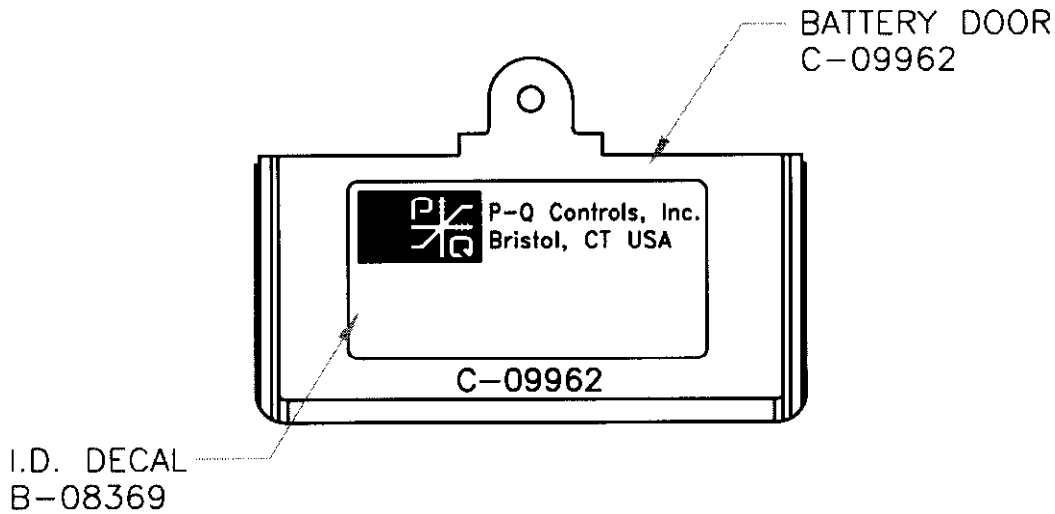


12. ATTACH THE BASE TO THE HOUSING



ATTACH THE BASE ASSEMBLY TO THE HOUSING ASSEMBLY WITH THE SCREWS AS SHOWN. TIGHTEN SCREW TO A NOMINAL TORQUE OF: XX in-lb AND AN ACCEPTABLE RANGE OF : XX in-lb MIN. AND: XX in-lb MAX.

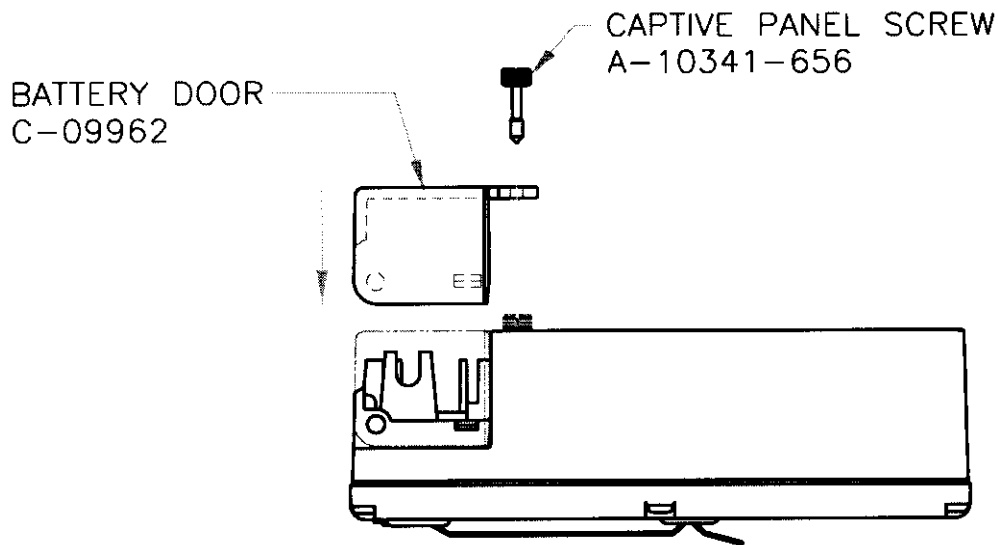
13. INSTALL DECAL ONTO BATTERY DOOR



CLEAN DECAL APPLICATION AREA WITH DENATURED ALCOHOL. REMOVE THE ADHESIVE BACKING FROM THE DECAL, AND APPLY THE DECAL TO THE BATTERY DOOR AS SHOWN.

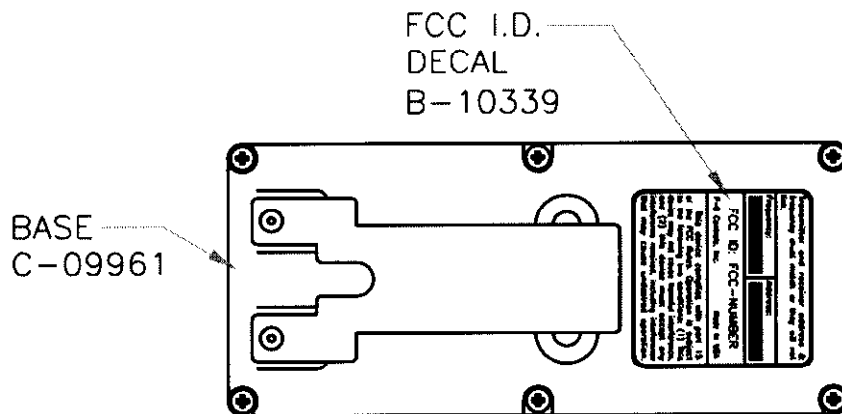


14. ATTACH THE BATTERY DOOR



THREAD THE CAPTIVE PANEL SCREW ONTO THE BATTERY DOOR, AND SNAP THE BATTERY DOOR ONTO THE HOUSING AS SHOWN.

15. ATTACH DECAL TO THE BASE



REMOVE THE ADHESIVE BACKING FROM THE DECAL, AND APPLY THE DECAL TO THE BASE AS SHOWN.