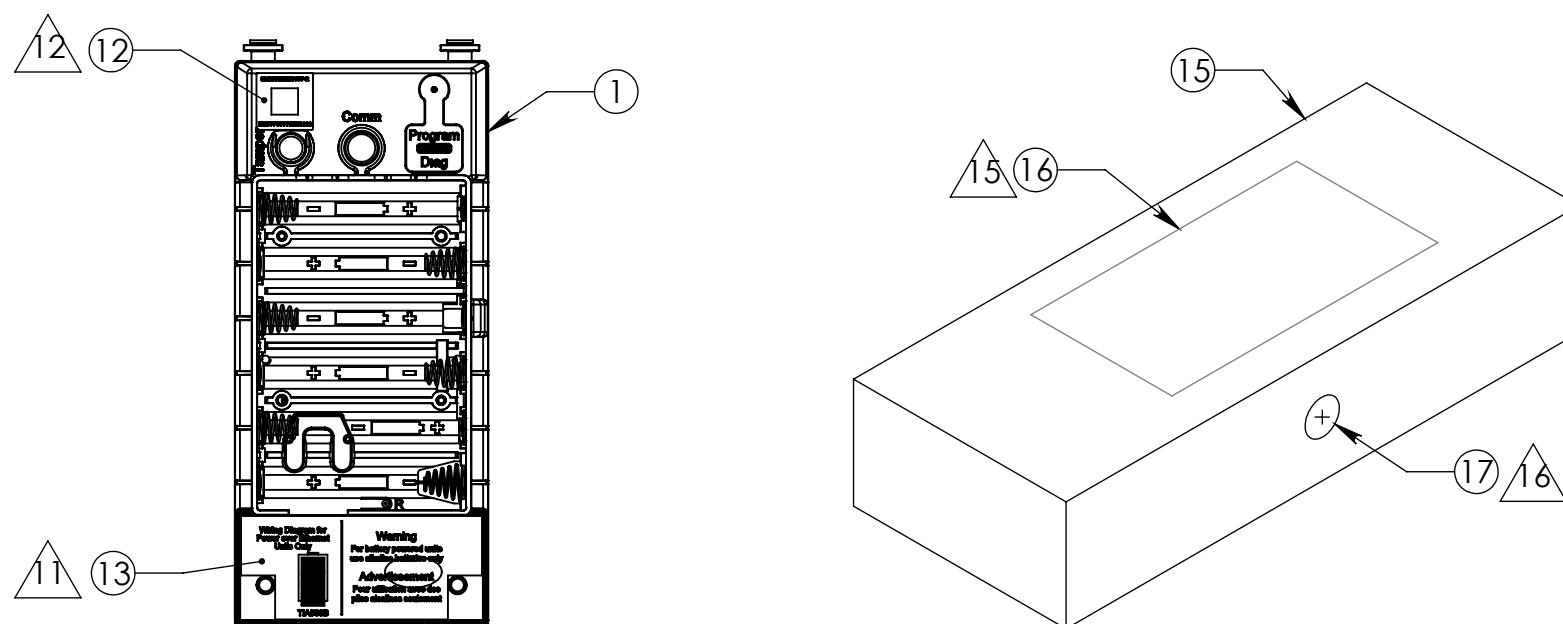
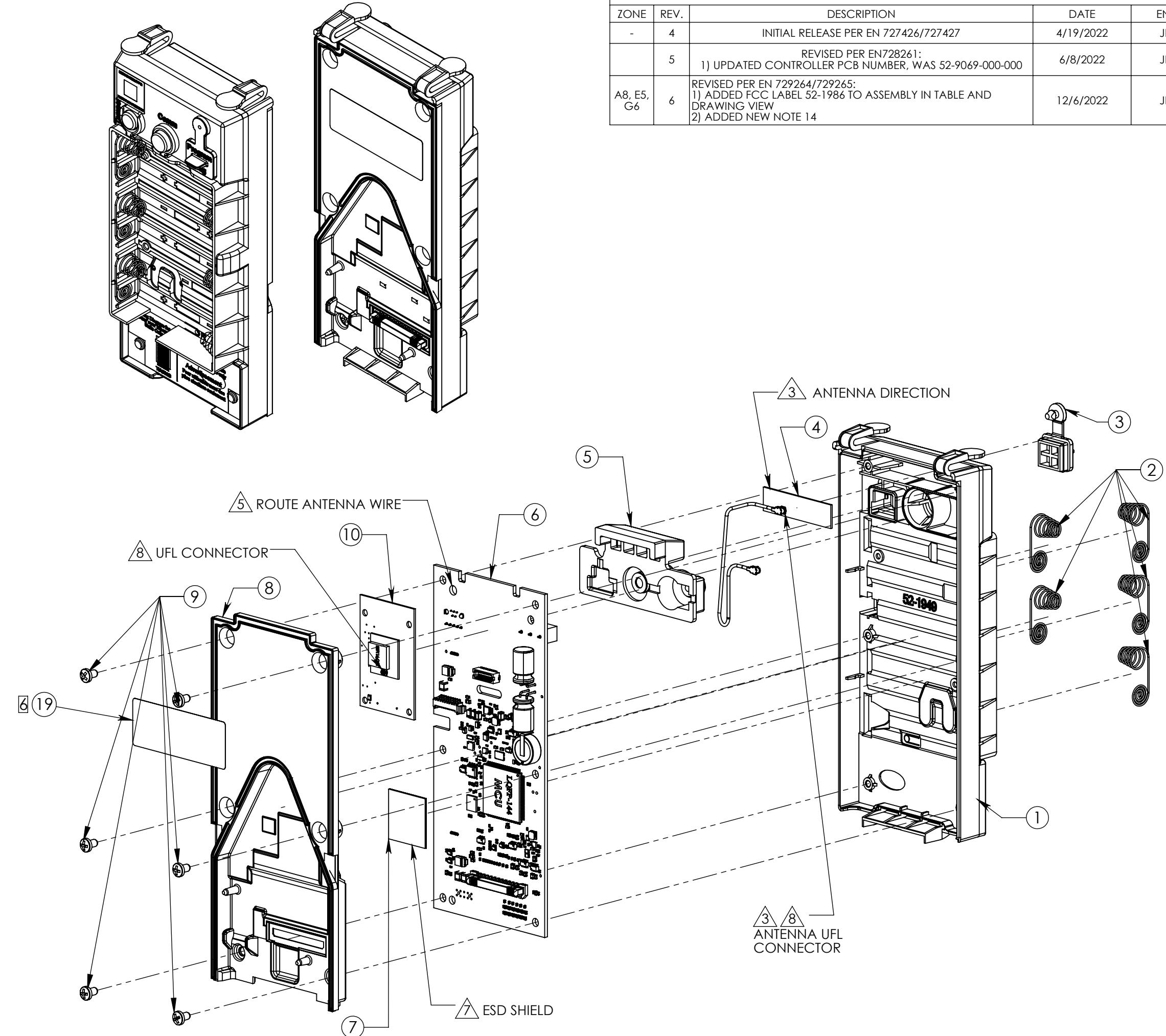


ITEM	DRAWING NO.	PART NO.	DESCRIPTION	SARGENT P/N	52-6214
				CORBIN RUSSWIN P/N	874F28
				COMMUNICATION TYPE	WIFI
1	-	52-1949	CONTROLLER HOUSING		1
2	-	52-1477	BATTERY CONTACT		5
3	-	52-1781	BATTERY & USB COVER		1
4	-	52-9152	WIFI PATCH ANTENNA W/WIRE		1
5	-	52-1951	TAMPER / PRIVACY ACTUATOR		1
6	52-9069	52-9069-0000-002	WIFI CONTROLLER PCB ASSEMBLY		1
7	-	52-1849	ESD SHIELD		1
8	-	52-1950	CONTROLLER COVER		1
9	-	01-9560	#4 X 3/16" PHILLIPS PAN HEAD PLASTITE SCREW		6
10	-	52-9134	WIFI RADIO MODULE		1
12	-	52-1661	ELECTRONIC ASSEMBLY IDENTIFICATION LABEL		1
13	-	52-1848	TIA568-B (ETHERNET/BATTERY) LABEL		1
14	-	-	ANTI-STATIC BAG (NOT SHOWN)		1
15	-	52-1542	MODULE BOX		1
16	52-1540TAB	52-1540	MODULE LABEL		1
17	52-1792TAB	52-1792	COLORED ID LABEL (RED)		1
18	-	-	SILICON SEALANT DOWSIL 3-1944 OR EQUIVALENT		A/R
19	52-1634TAB	52-1986	FCC LABEL		1



MODULE BOX & LABEL PLACEMENT



NOTES.

- 1.** SLIDE 5X BATTERY CONTACTS **②** INTO CONTROLLER HOUSING **①** , WITH COILS FACING OUT OF THE NEGATIVE POSITIONS.
ASSEMBLE USB PLUG **③** TO HOUSING **①** , BY PRESSING NUB INTO HOLE IN HOUSING.
- 2.** PLACE WIFI PATCH ANTENNA **④** INTO OPENING OF HOUSING **①** FACING THE DIRECTION SHOWN, WITH WIRE FACING UP.
PLACE TAMPER / PRIVACY ACTUATOR **⑤** INTO HOUSING **①** . BE SURE TO ROUTE ANTENNA WIRE **④** ALONG SLOT IN TAMPER / PRIVACY ACTUATOR **⑤**
ROUTE WIRE OF WIFI ANTENNA **④** THROUGH SPECIFIED HOLE IN CONTROLLER PCBA **⑥** AND PULL ALL WIRE SLACK THROUGH.
ASSEMBLE CONTROLLER PCBA **⑥** INTO HOUSING **①** UNTIL IT SNAPS INTO PLACE.
- 3.** PEEL OFF BACKER, AND APPLY ADHESIVE LAYER OF ESD SHIELD **⑦** OVER MICROCONTROLLER OF THE PCBA **⑥** , AS SHOWN.
PUT WIFI RADIO MODULE **⑩** IN PLACE AND CONNECT TO THE PCBA **⑥** . CONNECT FREE END OF ANTENNA WIRE **④** TO WIFI RADIO MODULE **⑩** CONNECTOR. SECURE SLACK OF WIFI ANTENNA WIRE **④** INTO WIRE CAPTURE FEATURE IN THE CONTROLLER COVER **⑧**.
PLACE CONTROLLER COVER **⑧** OVER PCBA **⑥** AND IN PLACE ON HOUSING **①** .
SECURE CONTROLLER COVER **⑧** TO HOUSING **①** , VIA 6X PLASTITE SCREWS **⑨** .
SCREW TORQUE: 0.45 - 0.68 Nm (4.0 -6.0 INCH-POUND). DO NOT OVER-TIGHTEN.
- 4.** APPLY ETHERNET/BATTERY LABEL **⑬** TO HOUSING **①** IN APPROXIMATE LOCATION SHOWN.
- 5.** APPLY ELECTRONIC ASSEMBLY ID LABEL **⑫** TO HOUSING **①** IN APPROXIMATE LOCATION SHOWN, AFTER TESTING. SEE LABEL DRAWING FOR APPROPRIATE LABEL INFORMATION.
- 6.** PERFORM POST ASSEMBLY SEALING PROCESS ON ASSEMBLED CONTROLLER (SEE SHEET 2 FOR DETAILS).
- 6.** APPLY FCC LABEL **⑯** IN APPROXIMATE LOCATION SHOWN.
PLACE FULLY TESTED ASSEMBLY INTO ANTI-STATIC BAG **⑭** , THEN PLACE BAG IN BOX **⑮** .
- 5.** APPLY MODULE LABEL **⑯** ON BOX **⑮** . SEE LABEL DRAWING FOR APPROPRIATE LABEL INFORMATION.
- 5.** APPLY APPROPRIATE COLORED LABEL DOT **⑯** TO THE SIDE OF BOX **⑮** IN LOCATION SHOWN.
18. REFER TO 3D ASSEMBLY 52-6214TAB.SLDASM (& EMBEDDED CONFIGURATIONS) FOR DETAILED ASSEMBLY VIEWS & PART POSITIONING.
19. MATERIAL AND MANUFACTURING PROCESS MUST COMPLY WITH ASSA ABLOY AMERICAS PRODUCT COMPLIANCE SPECIFICATION DOCUMENT ID# D001117360.

CRITICAL CHARACTERISTICS & ◇ KEY CHARACTERISTICS			
	DESCRIPTION	REQUIREMENT	REASON
◇1	BATTERY CONTACTS	ORIENTED PROPERLY & FULLY RETAINED	ENSURES PROPER BATTERY FUNCTION
◇2	WIFI ANTENNA	ORIENTED PROPERLY & CONNECTED	ENSURES RELIABLE WIFI CONNECTION
◇3	ESD SHIELD	APPLIED TO MICROCONTROLLER	ENSURES ESD PROTECTION
◇4	ETHERNET/SOLAR LABEL	APPLIED IN CORRECT LOCATION	ENSURES WEATHER PROTECTION & INSTALLATION INFORMATION
◇5	ID LABELS	VISIBLE WITH APPROPRIATE INFORMATION	ENSURES CORRECT PRODUCT & WARRANTY INFORMATION
◇6	SEALING PROCESS	FULLY SEALED & MEETS DIMENSIONAL REQUIREMENTS	ENSURES WEATHER PROTECTION & FITMENT

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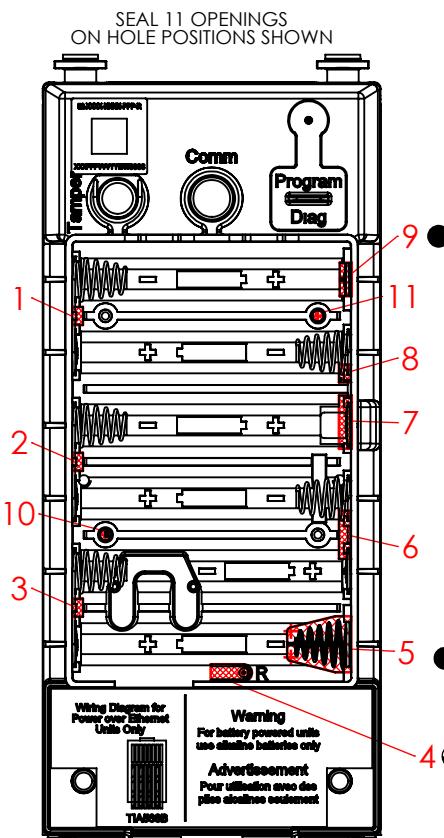
NOTICE TO PERSONS RECEIVING THIS DRAWING AND/OR TECHNICAL INFORMATION		UNLESS OTHERWISE SPECIFIED TOLERANCES		DRAWING COMPLIES WITH ASME Y14.5M - 1994		MATERIAL SEE BOM		CONTROLLER ASSEMBLY ELECTRO-MECHANICAL			
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ASSA ABLOY Sargent Manufacturing Company New Haven, CT		THIRD ANGLE PROJECTION		SURFACE/FINISH		MASS lb	VOLUME in ³	SURFACE AREA 232.762000 in ²	DRAWING NUMBER (ALT ID) 52-6214TAB	SCALE 1:2	SIZE C
Pre-Approved											

8 7 6 5 4 3 2 1

13 POST ASSEMBLY SEALING REQUIREMENTS

- PROCESS APPLIED TO COMPLETED ASSEMBLED CONTROLLER.
- APPLY SEALANT ⑯ TO LOCATIONS INDICATED.
- INSPECT USING UV LIGHT.
- SEALANT TO BE FLUSH OR BELOW SURFACE 0 -.020, UNLESS SPECIFIED OTHERWISE.

52-6214 / 874F28



6 ● SEALANT ON RESET SWITCH TAB MUST BE SMOOTHED FLAT.

8 ● ON ASSEMBLY 52-6214 INSPECT BATTERY TERMINALS
ENSURE THERE IS NO SEALANT ON THE CONTACT
POINTS OF THE BATTERY TERMINALS.

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	ENG
-	-	See Sheet1	-	-

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**UNLESS OTHERWISE
SPECIFIED TOLERANCES**

X.X $\pm .03$
X.XX $\pm .01$
X.XXX $\pm .005$
ANGLES $\pm 0^{\circ}30'$
FRACTIONS $\pm 1/64$
SURFACE FINISH ± 63

DRAWING COMPLIES WITH
ASME Y14.5M - 1994

INCH
MM

THIRD ANGLE
PROJECTION

MATERIAL
SEE BOM

HEAT TREATMENT

SURFACE/FINISH

MASS

VOLUME

SURFACE AREA

DRAWING NUMBER (ALT ID)

DOCUMENT ID

DATE CREATED

DRAWN BY

DESIGNED BY

12/09/2021

RL

jefrod

SCALE

1:2

SIZE

B

REV

6

ASSA ABLOY
Sargent Manufacturing Company
New Haven, CT

**CONTROLLER ASSEMBLY
ELECTRO-MECHANICAL**

Pre-Approved

DATE: 12/09/2021 DOCUMENT ID: D001288455-001 DRAWN BY: RL DESIGNED BY: jefrod

SCALE: 1:2 SIZE: B REV: 6