

(X) Manufacturing Requirements

() *pre* Manufacturing Requirements

Sub-assembly-description:

OmniAssure Touch Mullion

OT3200BHONG, OT3212BHONG, OT3300BHONG, OT3312BHONG

Sub-assembly-number:

SA_GRSMCMG0B, SA_GRSMCMG12B, SA_GRSPMCMG0B, SA_GRSPMCMG12B

PCB-numbers:

Created:

R&D-HW *)

T. Finke

Checked:

OP *)

Released:

Project leader *)

Comments:

The change are marked.

*) Approvals will be done with Agile workflow. No hand signature required on this document.

In general the standard manufacturing methods and processes which comply with "Quality Manual" have to be applied. The following document only covers special operations and workflows which were not defined in process descriptions and operating instructions or diverge from it.

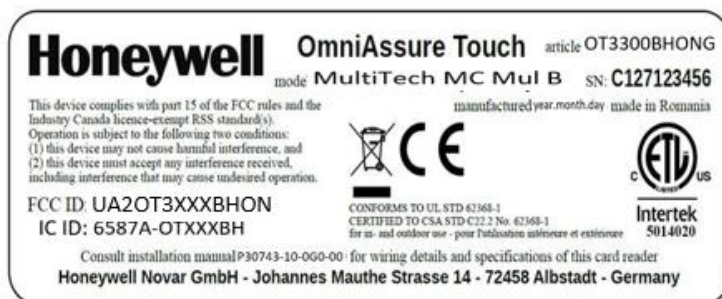
Production workflow

Visual incoming inspection for all OmniAssure Touch parts.

The following parts should be delivered by INID:

- 2D label
- type label
- wall plate
- reader + module

Incoming inspection of reader, BLE module and 2D label position:



Type label (example)

Non-removable, white, material UL compliant, specification 000-00628, dimensions (length/height): 70mmx37mm

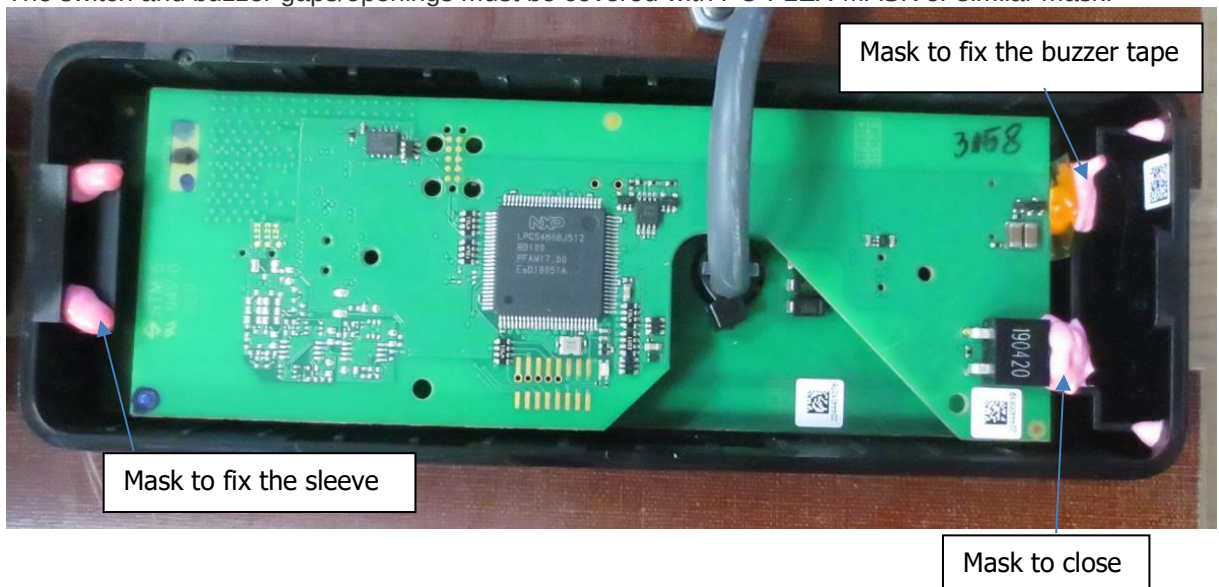


2D label position

Please assemble the rubber sleeve:



The switch and buzzer gaps/openings must be covered with PC-FLEX-MASK or similar mask.



Wait until PC-FLEX-MASK is cured (12hours).

Fill up the enclosure with potting until the height of the rubber sleeves.
Follow the following steps:

- Fill the cavity between main PCB and keyboard through the fill hole next to the wire, use a tight-fitting nozzle and a very low flow rate (suggested: 0.25 ml/s). Approx. 22 ml is required.
- Watch out for potting coming up through the edge openings prematurely, pause a second or two if necessary.
- Fill the rest of the reader to the required fill height from the middle of the reader using a suitable flow rate, avoid bubbles forming (e.g. on corners of components).
- On top cover all electronic parts with a thin layer of potting.

Afterwards the potting must cure. During that time, do not move the device. Keep the device in a stable horizontal position.

Cure time of the potting is at least 24 hours. (hardening at higher temperature is forbidden)

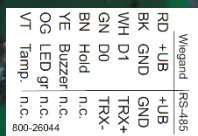
Remove PC-FLEX-MASK from switch and buzzer.

Remove tape for buzzer protection.

Test in according with the test requirements.

Remove the clamp terminal block (if available).

The product label, type label and connection label should be stick on the potting in compliance with the picture.



Put in the manual, the wall plate and accessory bag under the inlay in the packaging box. Afterwards the inlay and reader on top as shown in the picture (example for square).



See document 800-16060 "Labeling Gift-Boxes Albstadt" for label placement on the outer packaging.



Pull over the slip case.