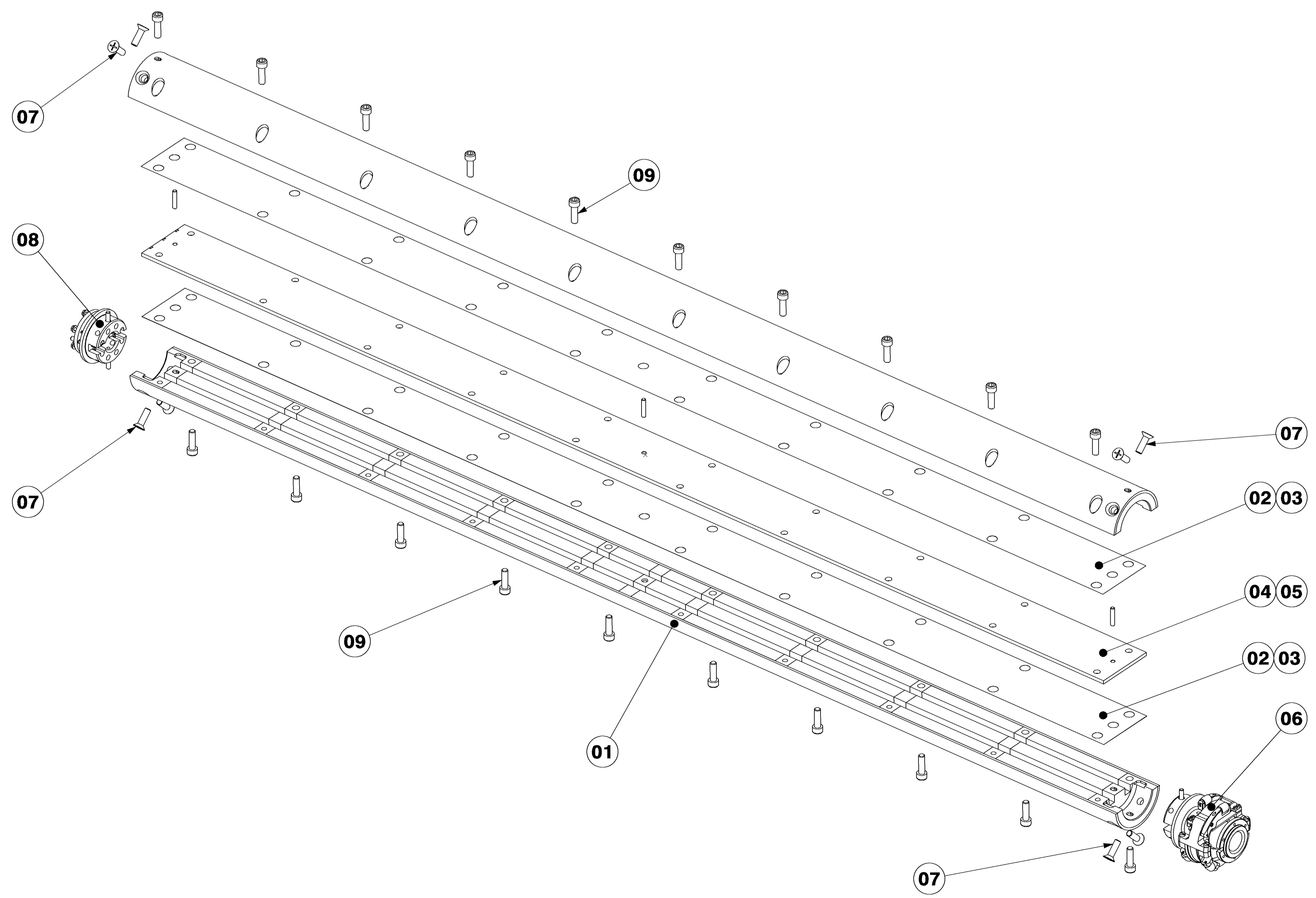


PCB alignment process :

- 1\_ Mounting all the components except : PCB (POS.4) and shims (POS.2 and POS.3).
- 2\_ Measuring the gap "X" between the main half sandwich tubes face (2x POS.1).
- 3\_ Measuring the PCB thickness "Y" (POS.4).
- 4\_ Calculating the value "W", using  $W=(X-Y) / 2$
- 5\_ Assembling the components adding the best stacks of shims (POS.2 and POS.3) in order to approach the value "W".
- 6\_ Measuring the alignment between the medium plane of the PCB (POS.4) and the rotation axis resulting from the 2x Ø45H7. (adding/removing shims (POS.2 and POS.3) if necessary).
- 7\_ Verifying that the ISO specification is respected (view B-B). Repeating the operation if it is not the case.



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BILL OF MATERIALS				
POS.	QUANT.	DESIGNATION	REFERENCE	MATERIAL
01	2	HALF SANDWICH TUBE Ø66 GLASS FIBER - SPECIFICATION	CRNMMMH_AL0003 ST1437290	
02	1	KAPTON® SHIM Th.0.125mm PCB D2	CRNMMMH_AL0005 ST1439375	KAPTON IN # (P1)
03	1	KAPTON® SHIM Th.0.075 PCB D2	CRNMMMH_AL0006 ST1439377	KAPTON IN # (P1)
04	1	PCB PLATE 1200mm D2	CRNMMMH_AL0004	Epoxy
05	3	PARALLEL PIN Ø4 h6 x 20	DOCERAM : 14051 ST1059989	Ceramic
06	1	D2 INTER-SEGMENT WITH ROLLING DEVICE	CRNMMMH_AL0010 ST1470833	
07	8	COUNTERSUNK SCREW M6x20	MISUMI : RENV/FH-M6-L20 ST1446194	Steel Fiber 1024
08	1	D2 INTER-SEGMENT WITH FLEXIBLE JOINT	CRNMMMH_AL0007 ST1474767	
09	20	SOCKET HEAD SCREW M6 X 20	MISUMI : SFA-M6-20-C ST1079752	Steel Fiber 1024

NAME: 3.20 kg    MAREC: CRNMMMH\_AL0001    (DATE: 2023-10-05 10:20:21)

DESIGNER: F. COFFIGNI    CHECKED: G. VILLIGER    DRAWN: AO

RELEASED: L. FISICARELLI    SCALE: 1:2

APPROVED:    RELEASED: 2023-10-05

EQUIPMENT CODE: CRNMMMH\_AL0001    TO BE REFUSED

REFERENCES: Doc No: ST1437290\_02    LABEL: FOR INFORMATION    SHEET: 1/1

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