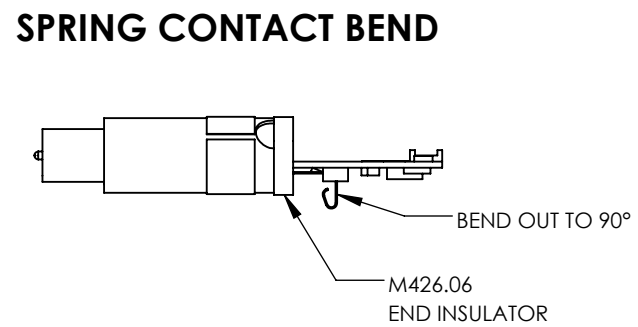
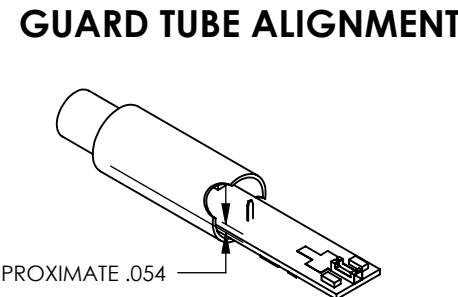
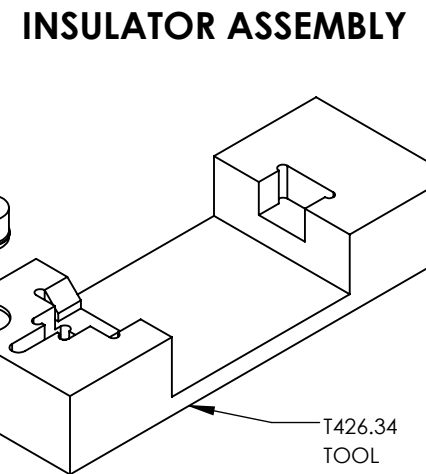
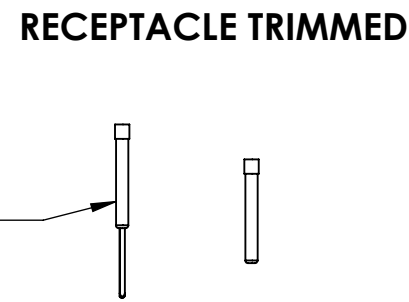
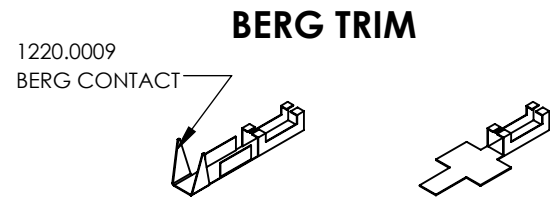


REV.	DESCRIPTION	DATE	BY	ECO
F	ADDED NOTE 2 AND 1220.0221	05-18-2011	L. HARBAUGH	4018
G	ADDED STEP 17 AND 3900.0020; REMOVED SECOND SHEET AND CHANGED TO B TYPE SHEET; CONDENSED ALL S426 DRAWINGS AND PARTS INTO THIS FILE. CHANGED ASSEMBLY INSTRUCTIONS	6/2/2016	D. ANDERSON	4466



S426 ASSEMBLY	DESCRIPTION	M426.XX	A426.XX
S426.01	1/2" ICP PREAMPLIFIER	M426.0101	A426.1

S426 ASSEMBLY INSTRUCTIONS

PART 1

1. TRIM 1220.0009 BERG PV CONTACT TO FIT PAD (**SEE BERG TRIM**).
2. SOLDER MODIFIED 1220.0009 BERG PV CONTACT (J1) TO PCB. BERG CONTACT CANNOT EXTEND BEYOND THE EDGE OF THE BOARD. SOLDER MUST REMAIN AS FLAT AS POSSIBLE TO NOT INTERFERE WITH THINTERFACING BUS WIRE.
3. REMOVE A SINGLE PIN OUT OF THE 1220.0221.
4. SOLDER 1220.0221 (H1) ON BOTTOM OF PCB POINTED TOWARD THE CR4 COMONENT. TRIM LEAD.
5. TRIM EXCESS OFF 1470.0012 POGO RECEPTACLE (**SEE RECEPTACLE TRIMMED**).
6. PRESS 1470.0011 POGO INTO 1470.0012 POGO RECEPTACLE.
7. USING T426.34 ALIGN M426.05 INSULATOR WITH THE LINE ON THE BOTTOM. PRESS POGO INTO POGO RECEPTACLE.
8. POSITION M426.05 INNER INSULATOR WITH RESPECT TO THE POGO/RECEPTACLE BY INSERTING ASSEMBLY INTO T426.34 SOLDER FIXTURE UNTIL IT BOTTOMS OUT IN FIXTURE (**SEE INSULATOR ASSEMBLY**).
9. PRESS SMALL END OF 1470.0012 POGO RECEPTACLE INTO SMALL END OF THE M426.05 INNER INSULATOR (**SEE INSULATOR ASSEMBLY**).
10. USING THE T426.34 SOLDER FIXTURE MOVE A426.X PCBd TO POGO END OF CAVITY IN FIXTURE. PUSH THE ASSMEBY AGAINST THE INSULATOR AND BOARD THEN SOLDER IN PLACE (**SEE PCBd ASSEMBLY**).
11. CLEAN PCBd POINTING THE POGO UP SO CLEANING SPRAY DOES NOT GET INTO POGO ASSEMBLY.
12. INSERT PCBd ASSEMBLY INTO GUARD TUBE USING INSERTION BAR, PRESS, AND USE A 0.150" LONG SPACER (5595.0020) AS A STOP INSIDE GUARD. PCBd ASSEMBLY MUST BE ALL THE WAY INTO THE GUARD TUBE. NOTE: POGO SHOULD EXTEND PAST GUARD TUBE BY ABOUT 0.03" (**SEE GAURD TUBE ALIGNMENT**).
13. SOLDER M426.03 GUARD TUBE TO PCBd. ONLY ONE SOLDER JOINT IS REQUIRED.
14. CLEAN PCBd ASSEMBLY ACCORDING TO D0001.7034 BOARD CLEANING INSTRUCTIONS.

PART 2

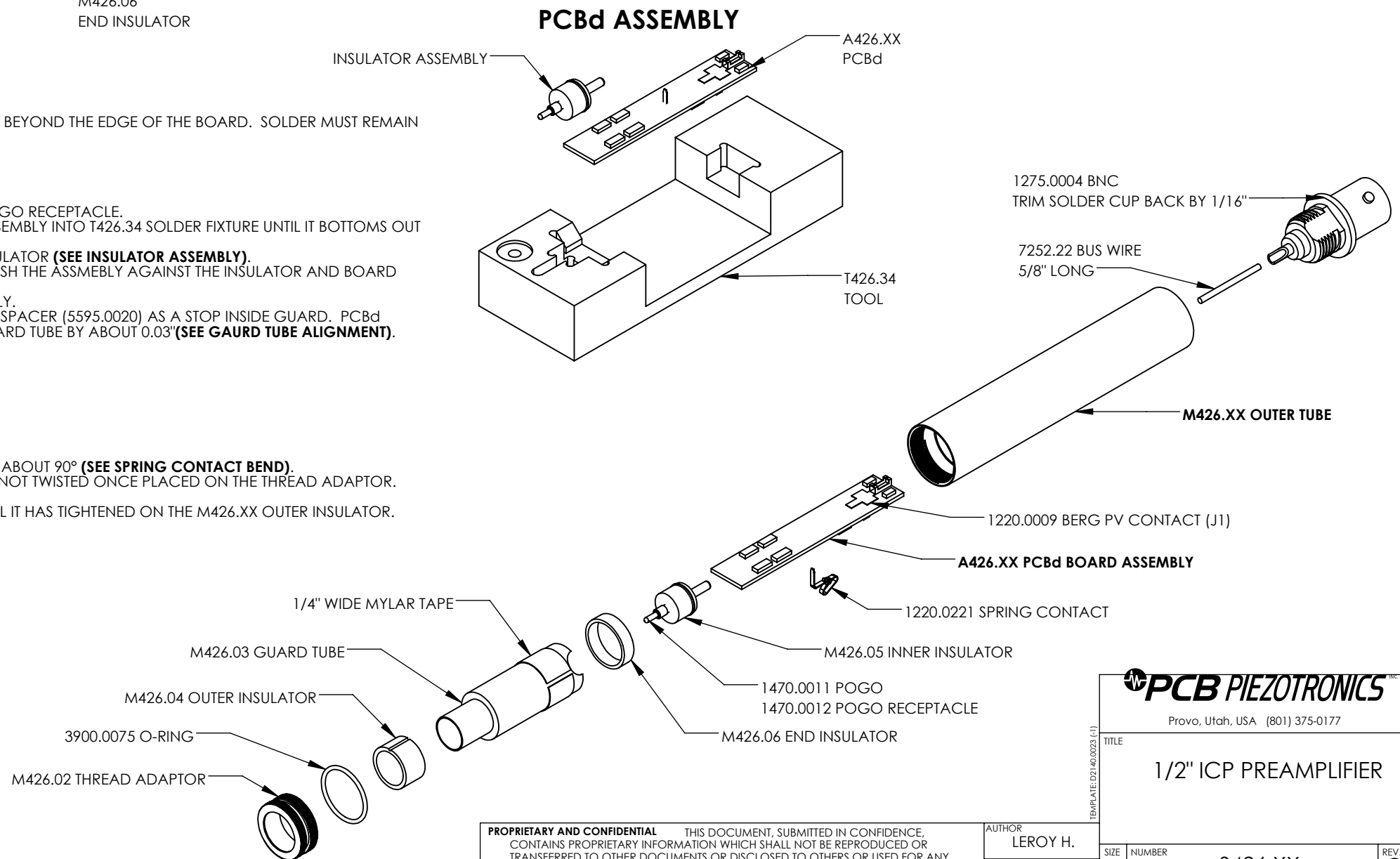
15. ADD MYLAR TAPE (2 TO 3 OVERLAPPING WRAPS) TO M426.03 GUARD TUBE.
16. PLACE M426.04 OUTER INSULATOR OVER M426.03 GUARD TUBE.
17. PLACE M426.06 END INSULATOR INTO THEM426.XX OUTER TUBE. BEND SPRING CONTACT OUT TO ABOUT 90° (**SEE SPRING CONTACT BEND**).
18. PLACE 3900.0075 O-RING INTO GROOVE ON M426.02 THREAD ADAPTOR. ENSURE THE O-RING IS NOT TWISTED ONCE PLACED ON THE THREAD ADAPTOR.
19. PUT THE PREAMP ASSEMBLY WITH GUARD TUBE AND INSULATORS INTO THE OUTER TUBE.
20. SCREW THE M426.02 THREAD ADAPTOR INTO THE OUTER TUBE. LARGE END FIRST. TURN IT ON UNTIL IT HAS TIGHTENED ON THE M426.XX OUTER INSULATOR. CAN USE A PIECE OF THICK RUBBER FOR THIS.
21. TRIM 1275.0004 BNC SOLDER CUP BACK 1/16".
22. SOLDER THE 7252.22 BUS WIRE ON THE 1275.0004 BNC CONNECTOR.
23. START THE WIRE INTO 1220.0009 POGO CONTACT THEN SCREW THE BNC INTO THE OUTER TUBE.
24. TIGHTEN BNC CONNECTOR TO 17 IN-LBS.
25. LOCK BNC AND THREAD ADAPTOR THREADS WITH LOCTITE 222 (PURPLE).
26. TIGHTEN THREAD ADAPTOR HAND TIGHT.

PART 3

27. PERFORM METCAL TEST ICP PREAMP.

Notes:

1. All equivalencies must be approved by PCB Engineering.
2. All components and processes must be ROHS compliant.
3. First article to be approved by PCB Engineering.



PROPRIETARY AND CONFIDENTIAL THIS DOCUMENT, SUBMITTED IN CONFIDENCE, CONTAINS PROPRIETARY INFORMATION WHICH SHALL NOT BE REPRODUCED OR TRANSFERRED TO OTHER DOCUMENTS OR DISCLOSED TO OTHERS OR USED FOR ANY OTHER PURPOSE WITHOUT THE WRITTEN PERMISSION OF PCB PIEZOTRONICS, INC.
 COPYRIGHT © PCB PIEZOTRONICS, INC. FILE NAME: S426.XX Preamp Assemblies

AUTHOR LEROY H.
 DATE 4/15/2011

PCB PIEZOTRONICS
 Provo, Utah, USA (801) 375-0177

TITLE
1/2" ICP PREAMPLIFIER

SCALE 1:1

REVISIONS
 REV. G
 NUMBER S426.XX
 SHEET 1 OF 1