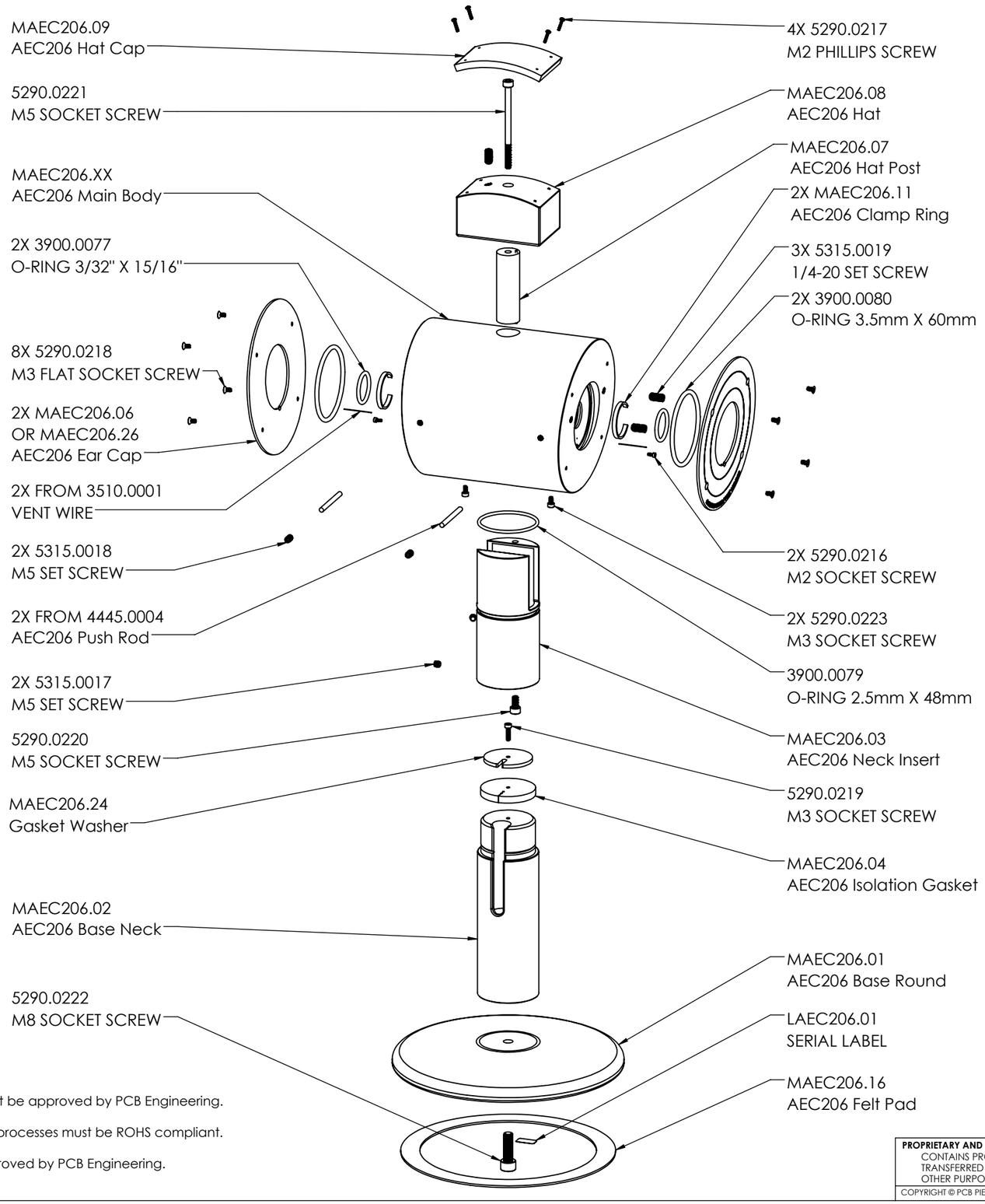
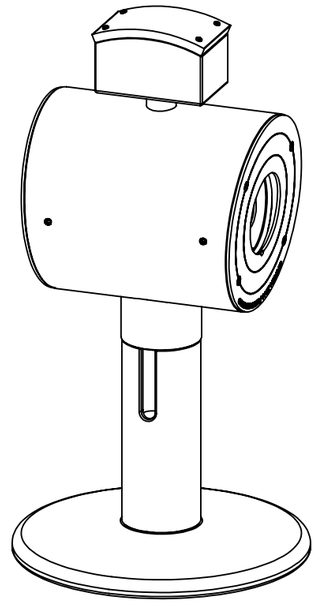
REV.	DESCRIPTION	DATE	BY	ECO
A	INITIAL RELEASE	6/12/2017	D. ANDERSON	4578
B	CHANGED ASSEMBLY STEPS	6/28/2017	D. ANDERSON	4584
C	INSTRUCTIONS UPDATE	7/17/2017	D. ANDERSON	4590
D	ADDED SET SCREWS	7/31/2018	D. WILDING	4721





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.

AUTHOR: D. ANDERSON

DATE: 11/16/2016

PCB PIEZOTRONICS INC.

Provo, Utah, USA (801) 375-0177

TEMPLATE: D2140.0023 (-1)

TITLE: AEC206 SUBASSEMBLY

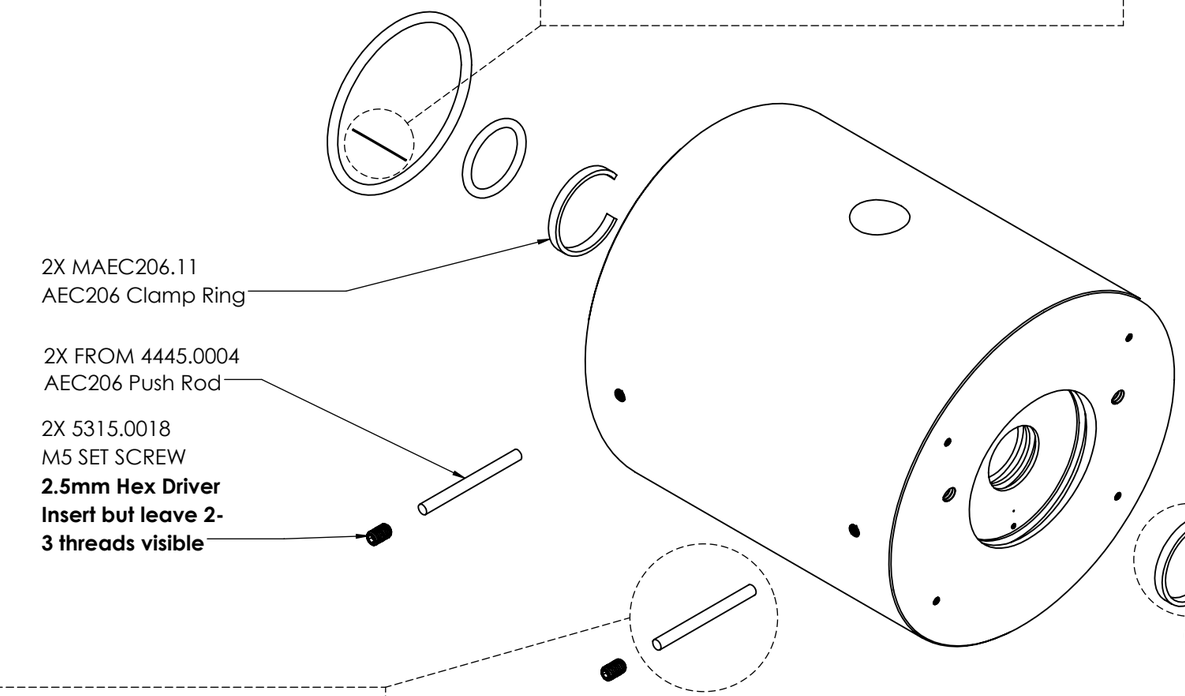
SIZE: B | NUMBER: SAEC206.0X | REV.: D

SCALE 1:4 | SHEET 1 OF 3

STEP 1

2X Vent Wire from 3510.0001
Cut to length shown below
Deburr the ends and ensure the length is correct. Bend the wire slightly and push into the head.

$[25^{\ 0}_{-0.50}]$
$.984^{+.000}_{-.020}$



2X MAEC206.11
AEC206 Clamp Ring

2X FROM 4445.0004
AEC206 Push Rod

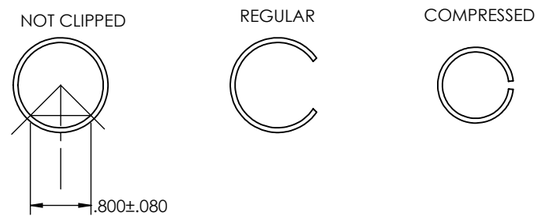
2X 5315.0018
M5 SET SCREW
2.5mm Hex Driver
Insert but leave 2-
3 threads visible

2X FROM 4445.0004
AEC206 Push Rod
Cut to length shown below
Make sure the rod is round, the ends do not need to be square

$[45.10\pm1.50]$
$1.776\pm.059$

CLIP THE MAEC206.11 CLAMP RING AS SHOWN BELOW.

COMPRESS THE RING TO FIT IT INTO THE SECOND INNER GROOVE; YOU WILL HAVE TO PUT HALF OF IT INTO THE CAVITY AND THEN FORCE THE REST TO SLIDE IN. MAKE SURE THE BREAK IN THE RING IS OPPOSITE THE SIDE OF THE PUSH ROD.



2X 5315.0019
1/4-20 X 1/2" SET SCREW
ENSURE SET SCREWS DON'T PROTRUDE FROM FACE AFTER INSERTION.

2X FROM 3510.0001
VENT WIRE

2X 3900.0077
O-RING 23mm X 3mm
Grease and place into o-ring slot which is the first slot in the main tube

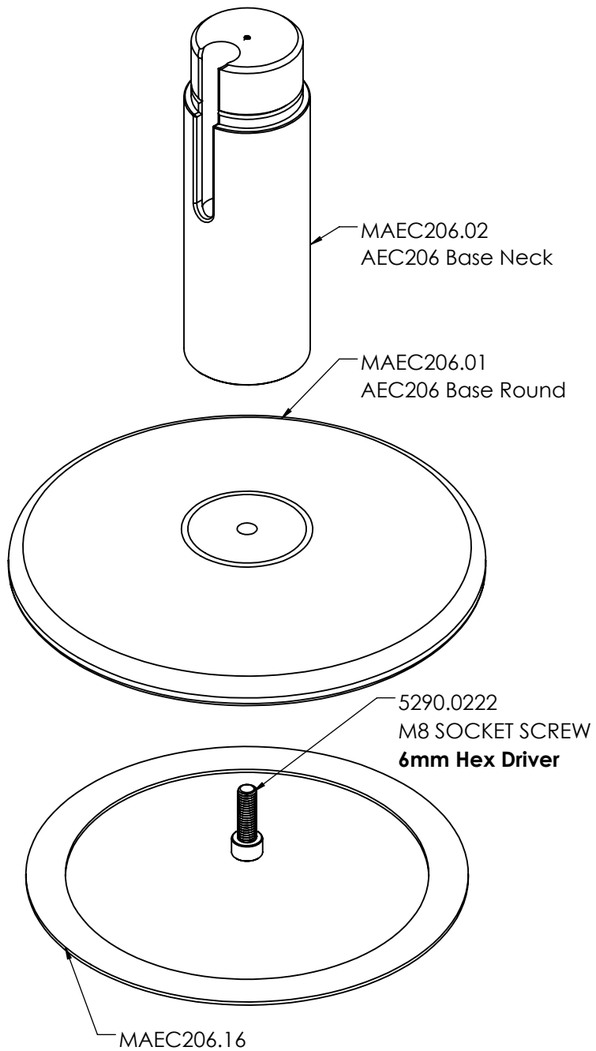
2X 3900.0080
O-RING 3.5mm x 60mm
Grease and place into o-ring slot

SIZE	NUMBER	REV.
B	SAEC206.0X	D

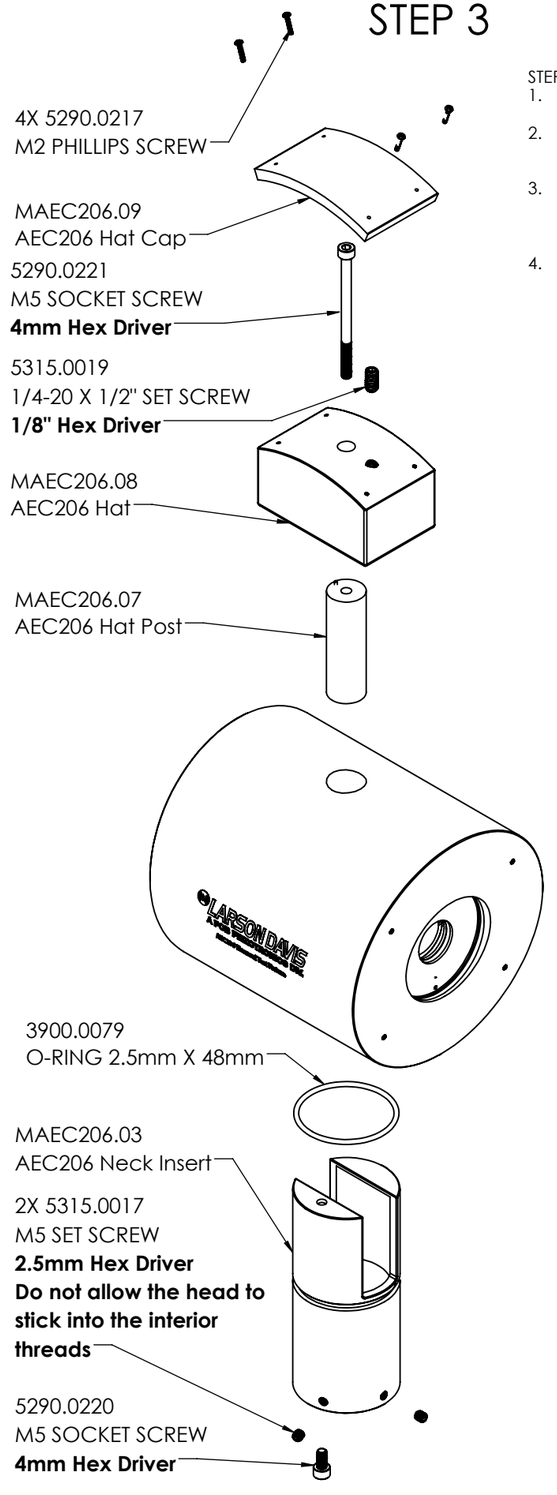
STEP 2

STEP 2 ASSEMBLY:

1. PLACE THE FELT RING ON THE BASE ROUND TRYING TO CENTER IT ON THE RING ON THE BOTTOM.
2. USE THE M8 SCREW WITH THREAD LOCK AND TIGHTEN THE BASE ROUND TO THE BASE NECK.



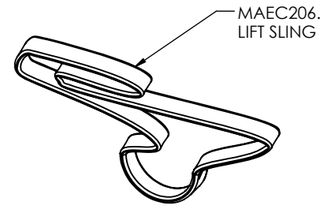
STEP 3



STEP 3 ASSEMBLY:

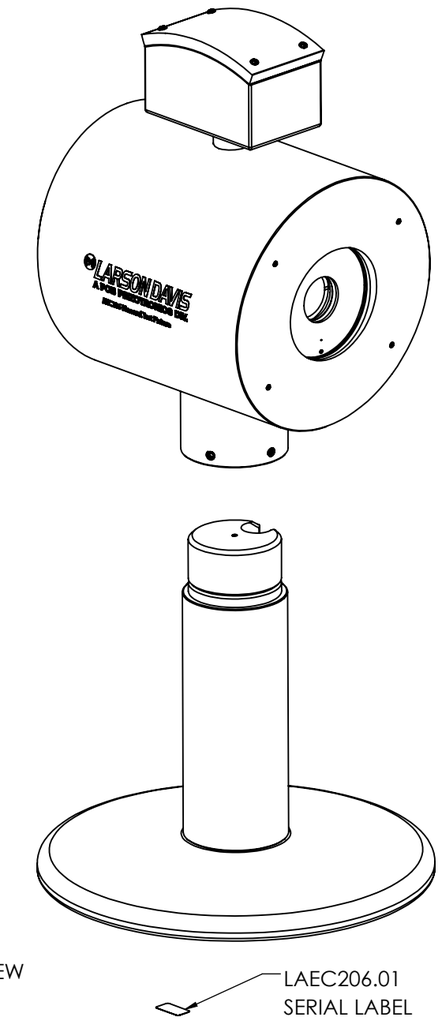
1. GREASE THE O-RING AND PLACE INTO THE GROOVE ON THE NECK INSERT.
2. ALIGN THE HOLE FOR THE NECK INSERT TO THE HEAD ASSEMBLY AND ENSURE THE O-RING GLIDES IN AND DOES NOT GET SHEARED OFF .
3. ALIGN THE PIN FROM THE HAT POST AND INSERT INTO THE HEAD ASSEMBLY AND THE HAT. USE THE M5 SCREW WITH THREAD LOCK AND TIGHTEN THE ASSEMBLY. ENSURE THE HAT IS SQUARE TO THE MAIN HEAD.
4. ATTACH THE HAT CAP USING THE M2 SCREWS. TIGHTEN SO THE HEAD OF THE SCREW IS SUNKEN DOWN AND IS NOT EXPOSED ABOVE THE SURFACE OF THE RUBBER PAD.

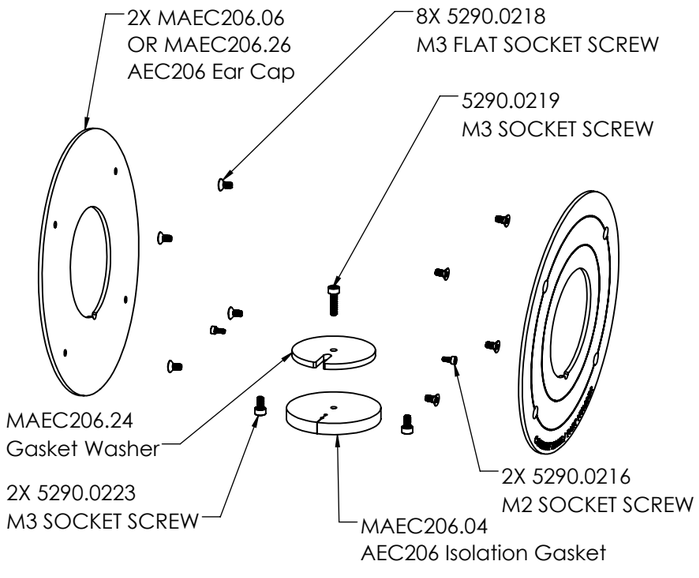
STEP 4



STEP 4 ASSEMBLY:

1. ROCK THE HEAD ASSEMBLY ONTO THE NECK.
2. LOOSELY TIGHTEN BOTH SET SCREWS ONCE ASSEMBLED.
3. PRINT OFF A SERIAL NUMBER FROM THE APPROPRIATE MODEL YOU ARE USING. SAEC206.01 (LD MODEL) START AT: 1000 AND SAEC206.02 (AP MODEL) START AT: 1000.
4. PLACE SERIAL NUMBER STICKER ON THE BOTTOM OF THE DEVICE IN THE OPEN CUTOUT RING.
5. CUT THE SLIT IN THE GASKET BACK TO THE 2ND HOLE FROM THE OUTSIDE USING A RAZOR BLADE; DO NOT CUT BACK TO THE CENTER.
6. BAG THE FOLLOWING PARTS FOR USE LATER: ALL SCREWS SHOWN BELOW, GASKET WASHER, ISOLATION GAKSET. KEEP THE EAR CAP WRAPPED IN THE FOAM, OR REPLACE WITH A COVERING BEFORE BAGGING THE RING.
7. USE THE SLING TO PLACE THE HEAD INTO THE STORAGE FOAM TO AWAIT FINAL ASSMEBLY.





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