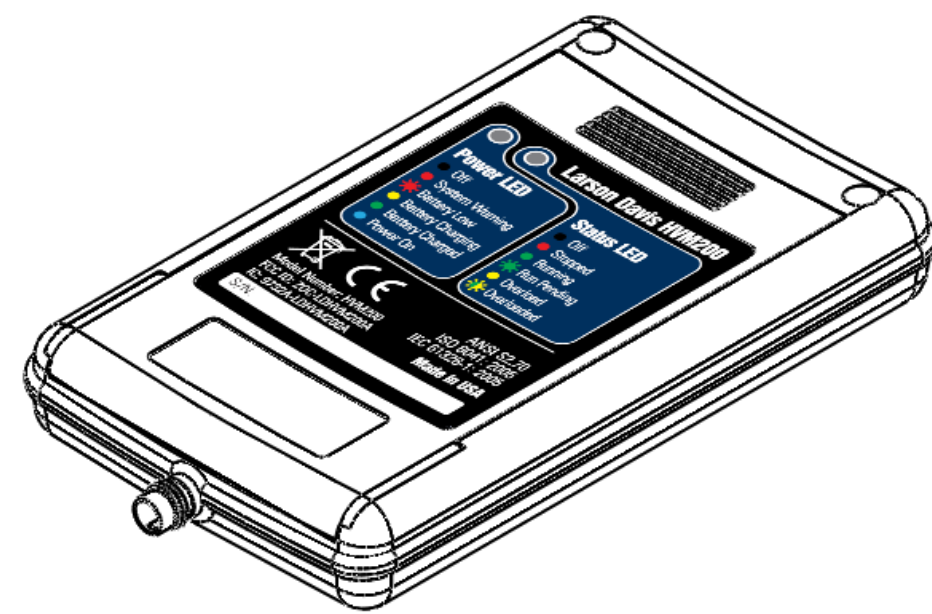
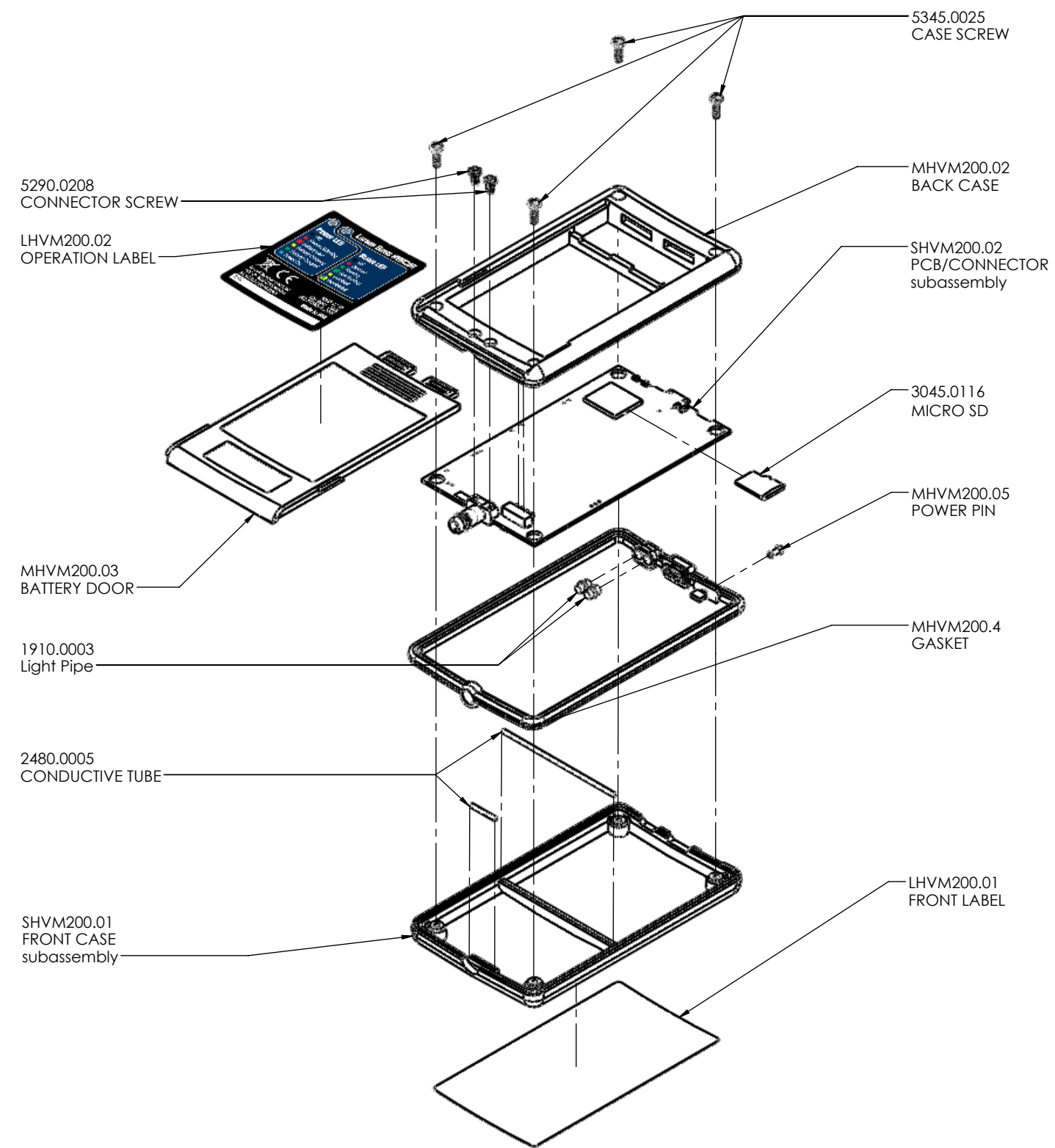


REV.	DESCRIPTION	DATE	BY	ECO
A	INITIAL RELEASE	10-29-2015	D. ANDERSON	4421



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.

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AUTHOR  
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DATE  
4/10/2015

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TITLE  
ASSEMBLED HVM200

SIZE NUMBER  
B SHVM200.03

REV.  
A

SCALE 1:1 SHEET 1 OF 2

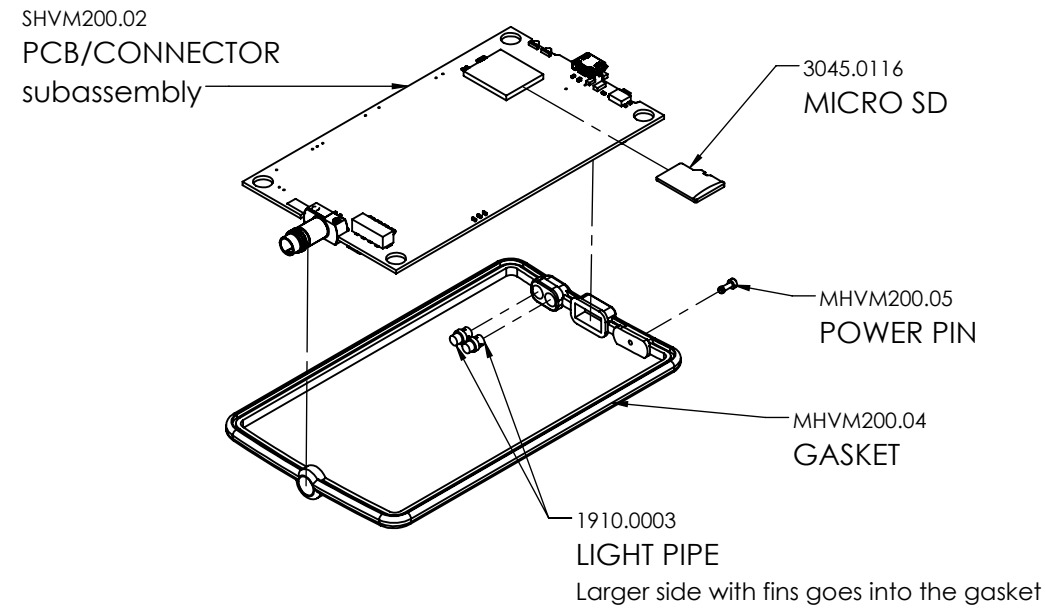
## Step 1

Insert the POWER PIN and 2 LIGHT PIPES into the GASKET

Stretch the GASKET in the longest length direction

Slide the GASKET connector hole over the 4 Pin CONNECTOR and the GASKET USB hole over the micro USB connector

Load MICRO SD to PCB if not already present

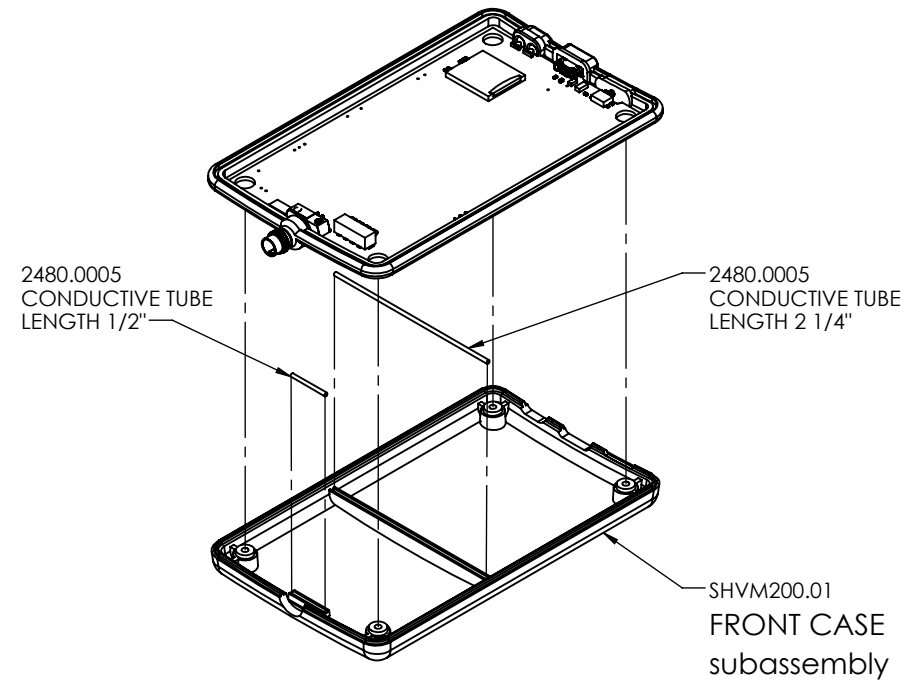


## Step 2

Push CONDUCTIVE TUBE into channels shown below

Align the PCB to the FRONT CASE screw boss locations and press together

Make sure GASKET aligns with FRONT CASE around the connector, you will stretch it into place in Step 4.

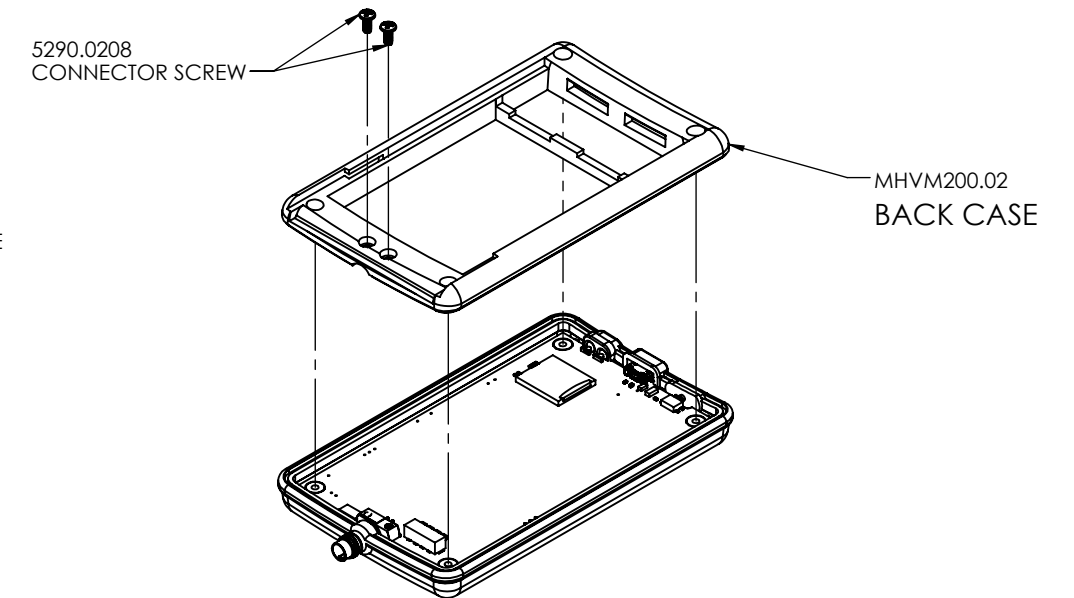


## Step 3

Align the PCB to the BOTTOM CASE and bring the 2 together

Make sure GASKET aligns with BACK CASE

Insert CONNECTOR SCREWS and screw down to a loose fit



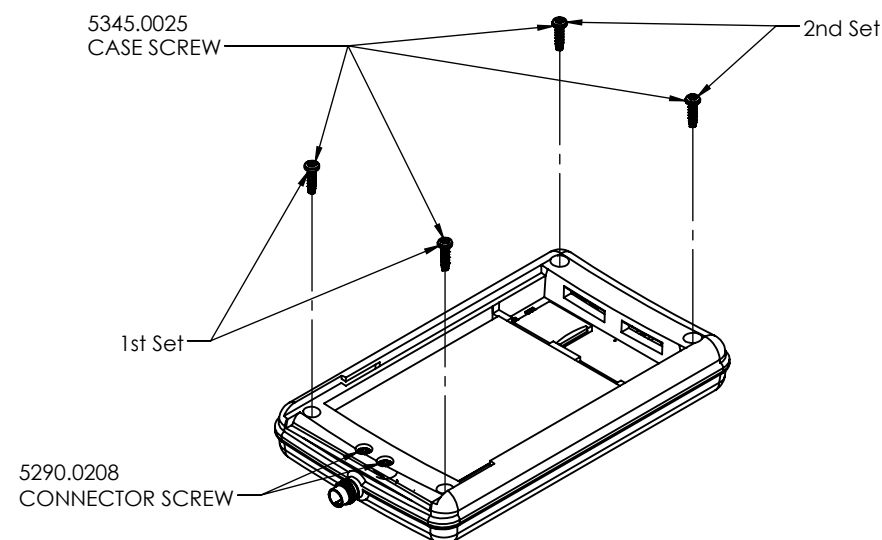
## Step 4

Torque down CONNECTOR SCREWS until tight

Insert 1st set of CASE SCREWS and using a Torx T8 driver torque to 1 ft-lb

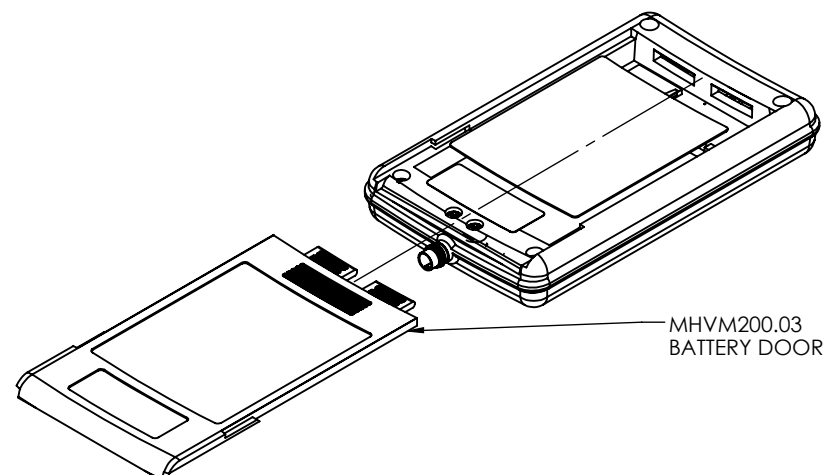
Stretch GASKET into place on remaining side

Insert 2nd set of CASE SCREWS and torque to 1 ft-lb



## Step 5

Slide BATTERY DOOR into BACK CASE until it clicks into place



## Step 6

Attach OPERATION LABEL to BATTERY DOOR

Attach FRONT LABEL to FRONT CASE

