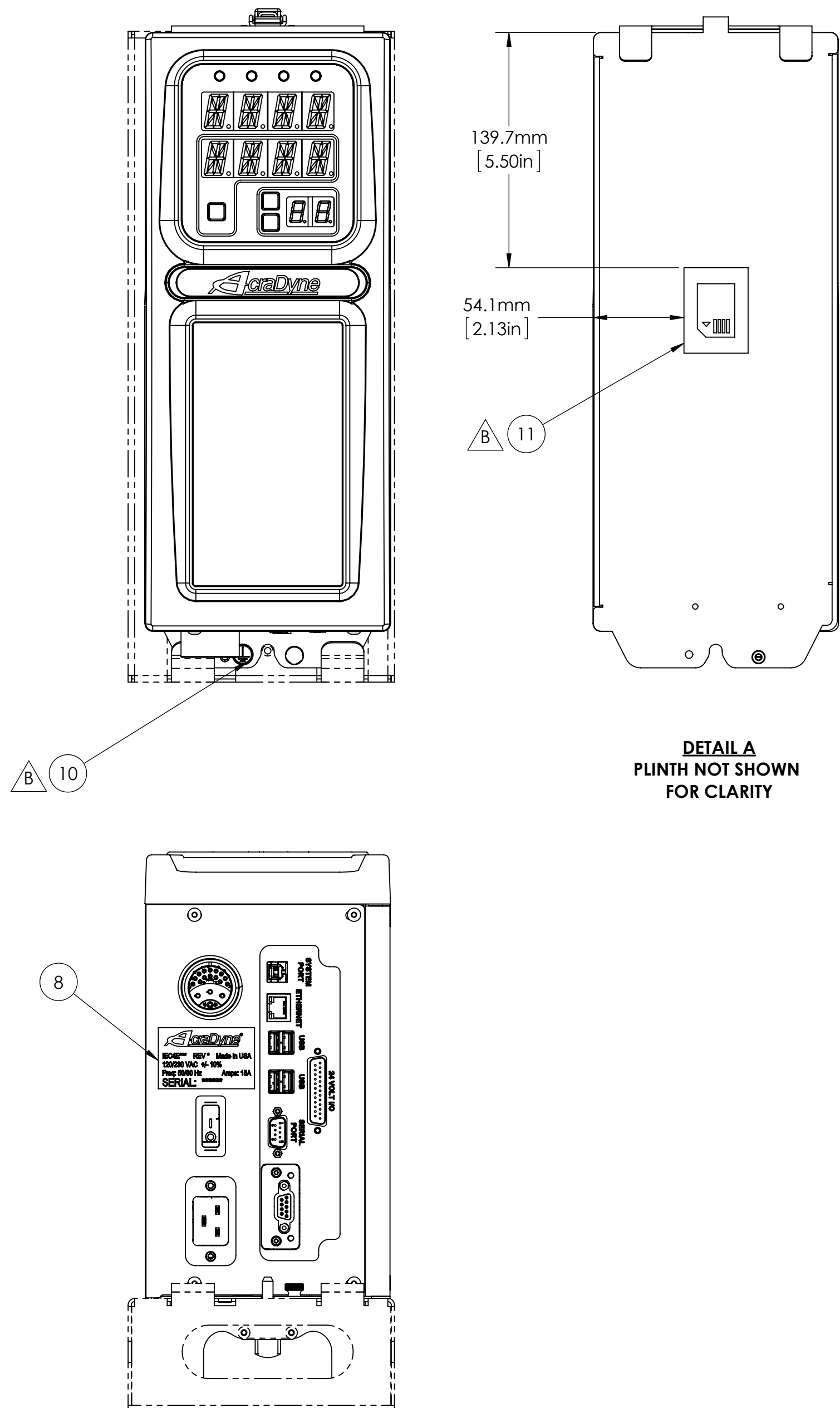
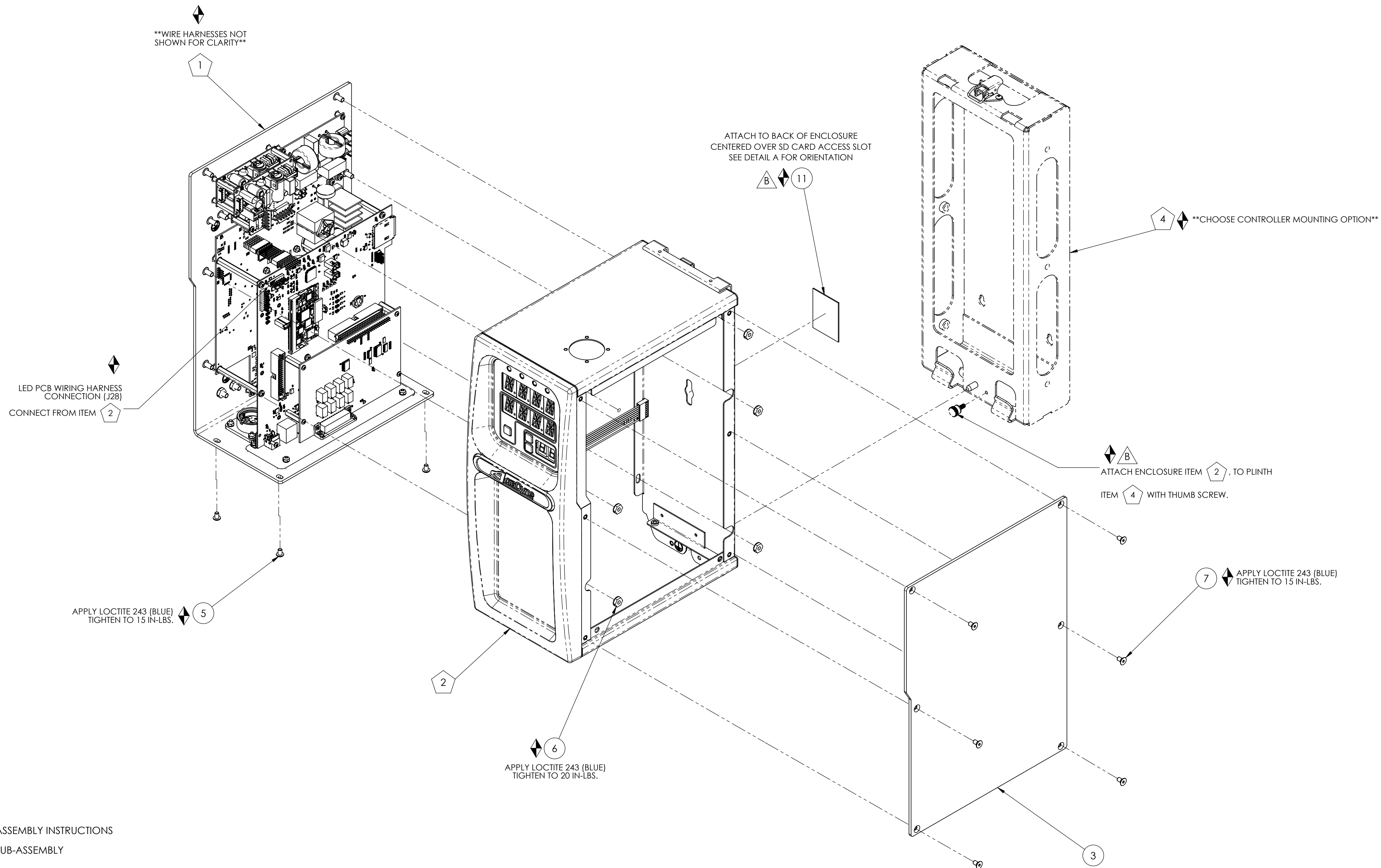













MODEL NO.	MAINBOARD ASSEMBLY
iEC4EV	28139.001
iEC4EVI	28139.002
iEC4EVT	28139.003
iEC4EVD	28139.004
iEC4EVP	28139.005

COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	SEE CHART	1	MAINBOARD ASSY, W/ I/O
	2	28137	1	ENCLOSURE ASSEMBLY
	3	27802	1	ENCLOSURE PANEL SIDE COVER
	4	27801	1	CHOOSE MOUNTING
	5	26088	4	SCREW, BHC 8-32X.25, STEEL, BLACK OXIDE
	6	23482	6	KEPS NUT, HEX 10-32, ZINC-PLATED
	7	26363	6	SCREW, FHSC 8-32x5/16, STEEL, BLACK OXIDE
	8	28294	1	LABEL, SERIAL NUMBER AND DESCRIPTION
NOT SHOWN; TO SHIP LOOSE WITH ASSEMBLY	9	28292	1	CABLE, USB 2.0, MALE A TO B, 3M
	10	28293	1	DECAL, EARTH GROUND
	11	28615	1	DECAL, SD CARD, GEN 4 CONTROLLER



-  ASSEMBLY INSTRUCTIONS  
 SUB-ASSEMBLY

- 1) INSTALL ENCLOSURE ASSEMBLY, ITEM  2 . OVER SERVO ASSEMBLY, ITEM  1 .
- 2) CONNECT LED PCB WIRING HARNESS TO MAINBOARD. CONNECT TOOL CABLE TO ENCLOSURE, IF NEEDED.
- 3) INSTALL FASTENERS, ITEM  5 AND THEN HEX NUTS ITEM  6 .
- 4) INSTALL COVER PLATE, ITEM  3 WITH FASTENERS ITEM  7 .
- 5) INSTALL DECAL, ITEM  11 .
- 6) ATTACH MOUNTING PLINTH, ITEM  4 IF REQUIRED.
- 7) PRINT AND INSTALL LABELS, ITEM  8 &  10 .
- 8) SHIP USB CABLE, ITEM  9 , LOOSE WITH CONTROLLER.



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<b>REVISION LEVEL</b>	<b>REVISION RELEASE DATE</b>	<b>DESCRIPTION OF CHANGES MADE TO PART</b>	<b>ECN #</b>	<b>APPROVAL</b>
<b>REVISION BLOCK</b>				

**UNLESS OTHERWISE SPECIFIED,  
DIMENSIONS ARE IN INCHES**  
DIMENSIONS AND TOLERANCING PER ANSI Y14.5  
SURFACE ROUGHNESS PER ANSI Y14.36

**BLOCK TOLERANCING PER DECIMAL:**  
 $.X = \pm .030$   $.XX = \pm .010$   $.XXX = \pm .005$   $.XXXX = \pm .0005$   
 ANGLE =  $\pm 0^{\circ} 30'$

REMOVE BURRS AND SHARP EDGES: R.015 MAX  
MACHINE SURFACE FINISH: 125 RMS OR BETTER

DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:  
**ACRADYNE MECHANICAL ENGINEERING**

## CONTROLLER ASSEMBLY WITH I/O

## GEN 4

SIZE <b>D</b>	PART / DRAWING NUMBER <b>iEC4EV_</b>	REVISION <b>B</b>
SCALE 2:5	DO NOT SCALE DRAWING	SHEET 1 OF 2

