

COMPANY OPERATING PROCEDURE

Battery Retaining Strap VM3/COP/45.02

Date: 20-Feb-04

Revision Date: 11-Jul-11

Issue: 1



N.B. Only “Authorised” personnel are allowed to use the Band Saw And the Pillar Drill

Equipment Required:

“G” clamp, Engineers Rule, Scribe, Bench vice, Rubber hammer, Set-square, [3.5mm](#) drill bit, Smooth file.

1. Preparation

1. Place the sheet aluminium on the workbench and grip with “G” clamp. Mark-off “14mm” divisions, at both ends, until the whole sheet is done (14 divisions approximately). Scribe straight lines between each end to show the individual strips.
2. Bring down the blade guard on the band saw till it is just above the thickness of the plate. Ensure that the speed is correct for aluminium.
3. Cut the strips to the required widths. File the edges and ends to remove all sharp edges.
4. From one end, mark off the [3.5mm](#) diameter hole, central to the strip width.
5. Ensure the drill is on the correct speed, for aluminium, drill the hole through. Remove all sharp edges.

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2. Assembly to DL3000

1. From the Drilled end, mark off the four bend centres, using the dimension guides on the [Viamed drawing](#).
2. Place the strip in the vice with the bend centre close to the vice top. Using the rubber hammer, gently bend the strip at the bend mark, till the strip is at 90°.
3. Repeat the process for the other three bends ensuring that the bends are the correct direction.
4. At each bend, offer the strip to the battery to ensure that the bend is able to retain the battery when it is situated in the DL3000 case.
5. The last bend should then be offered up to the DL3000 case to ensure that it encapsulates the battery, while at the same time entering the groove in the side of the case. This should then allow encapsulation, without tilting or twisting, of the battery from its true location.
6. Remove all bending abrasions and sharp edges.
7. [Apply ?? wide](#) heat shrink over the whole strip except for the two restraining ends bends.
8. Place the battery into its location within the PCB cut out, and retain with the strap, affixed in the side groove, and screwed down to the PCB.

