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Production Step	Guideline	Hint
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1	Cell's placement	Place cells into the base of non portable tray separating them using rib plates of 10mm thickness. The height of the rib plate depends on the cell type.	In case of double row, at least 10mm distance between rows must be kept.
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1 row

2 rows

Pos	Description
1	Base
2	Support Plate
3	Stud Bolt M10
4	Rib plate
5	Flat Washer M10
6	Hexagon Nut M10
7	Plastic Head Bolt M10
8	Connector

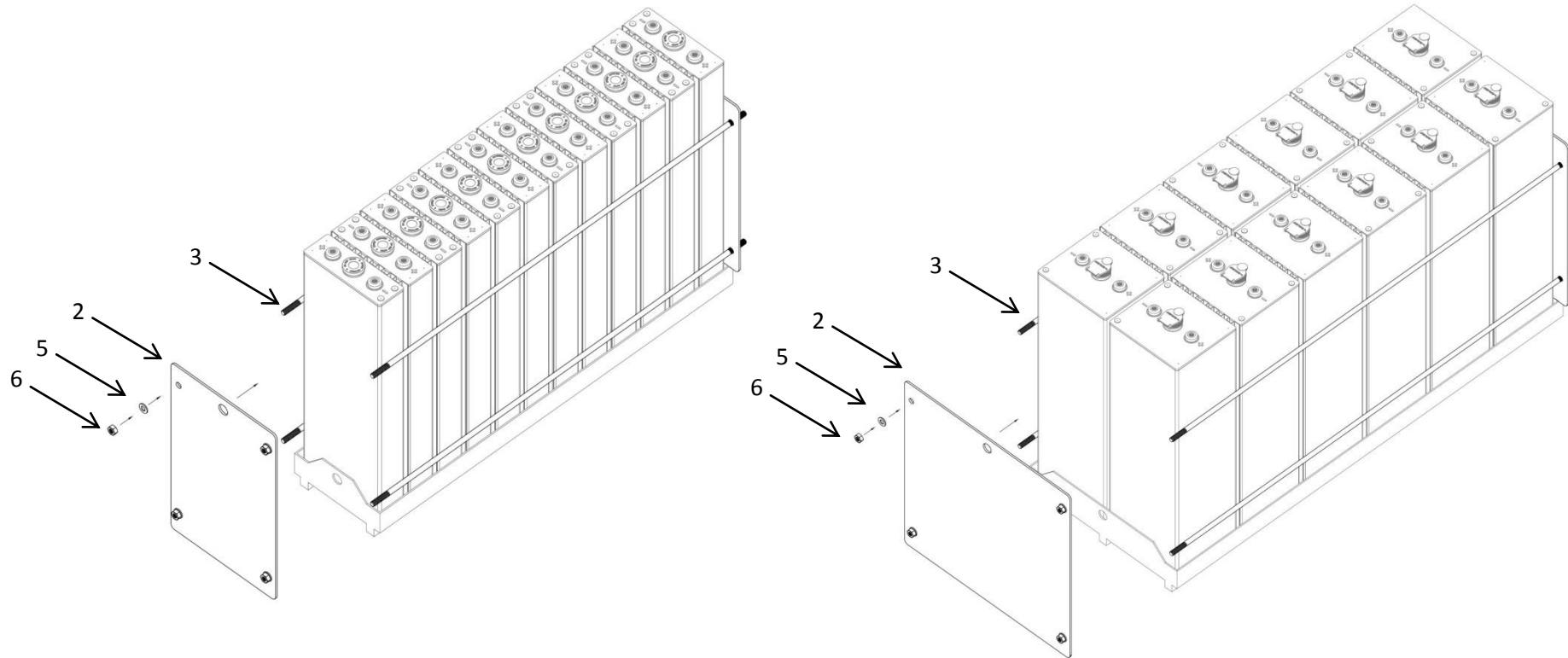
Made by Stavros Chatziavramidis Technical Design on	Checked Quality Assurance Dimitris Bollas Quality Supervisor on	Checked Production George Giapoutzis Production Manager on	Checked Engineering Dept Konstantinos Paspalas Engineering Manager on	Approved by Product Development Othon Monachos Product Development Manager on
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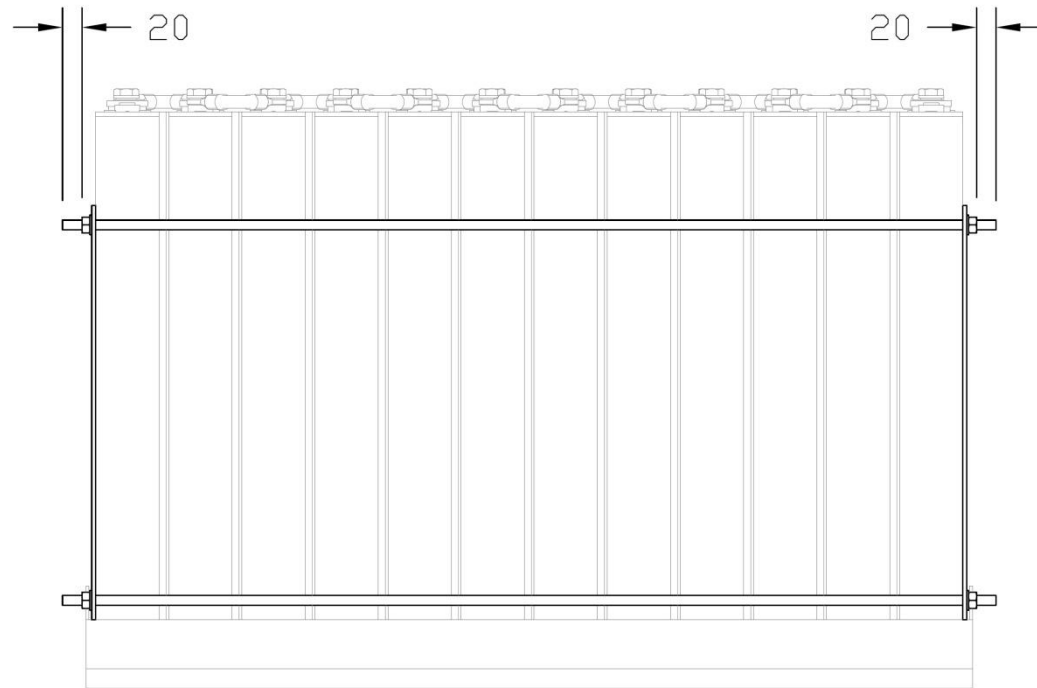
2

Cell's fastening

Place a support plate at both ends of the stack as well as the bolts that connect the support plates. Screw the nuts in order to stabilize the cells' stack. The nuts must exceed the support plates as shown in below figure.

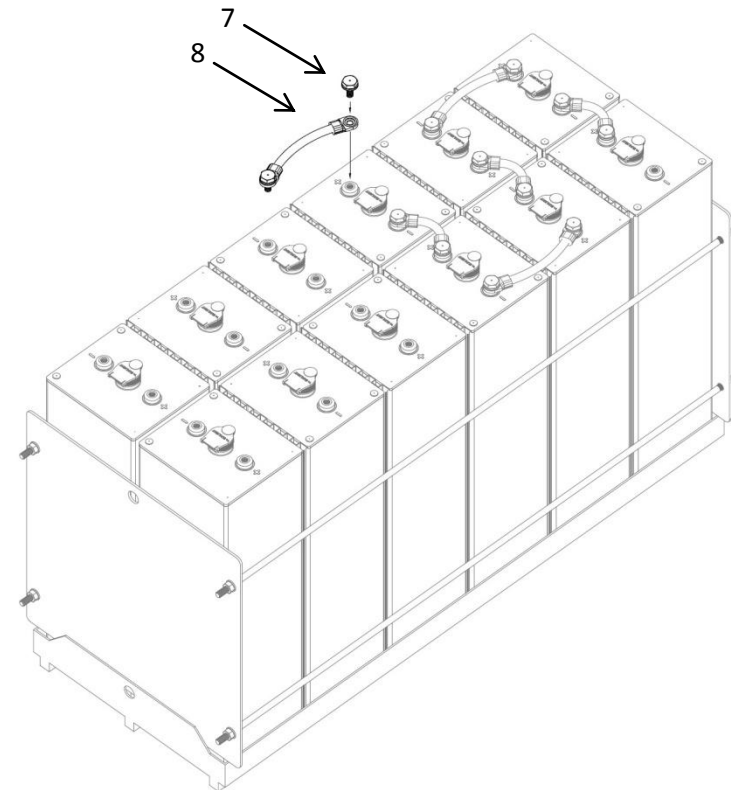
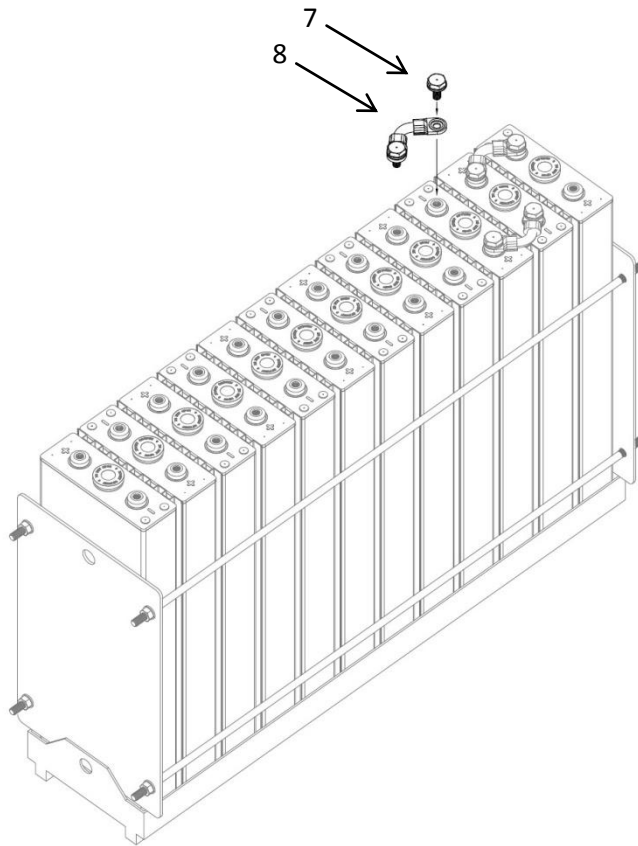


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3	Cells' connection	Connect cells using supplied connector and plastic head bolts. Bolt tightening torque must be 23 Nm	Particular attention must be paid to the polarity of the cells to avoid short circuits.
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