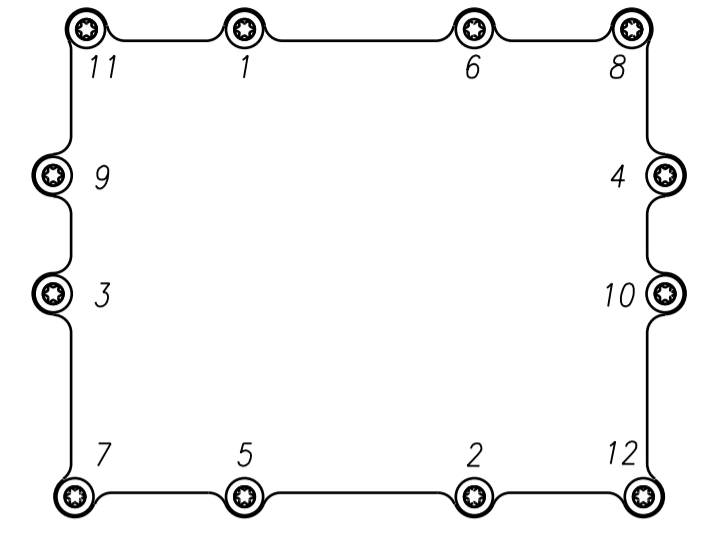


PROD NR	VERSION/PRODUCT NAME	ART. NO ASSEMBLY	POS 5 PA	POS 7 BTS	POS 4 LNF	POS 6 DC	POS 22 NUM	POS 29 NUM	POS 30 NUM	POS 31 NUM	POS 32 NUM	POS 39 NUM
9256.01	PCS 1930-1950 TX BYP, NO TTA	82559.01	82581.11	82080.62	82490.01	82085.02	1	1	1	0	1	1
9256.02	PCN 1950-1970 TX BYP, NO TTA	82559.02	82581.12	82080.62	82490.02	82085.02	1	1	1	0	1	1
9256.03	PCN 1970-1990 TX BYP, NO TTA	82559.03	82581.13	82080.62	82490.03	82085.02	1	1	1	0	1	1

**Mounting sequence**

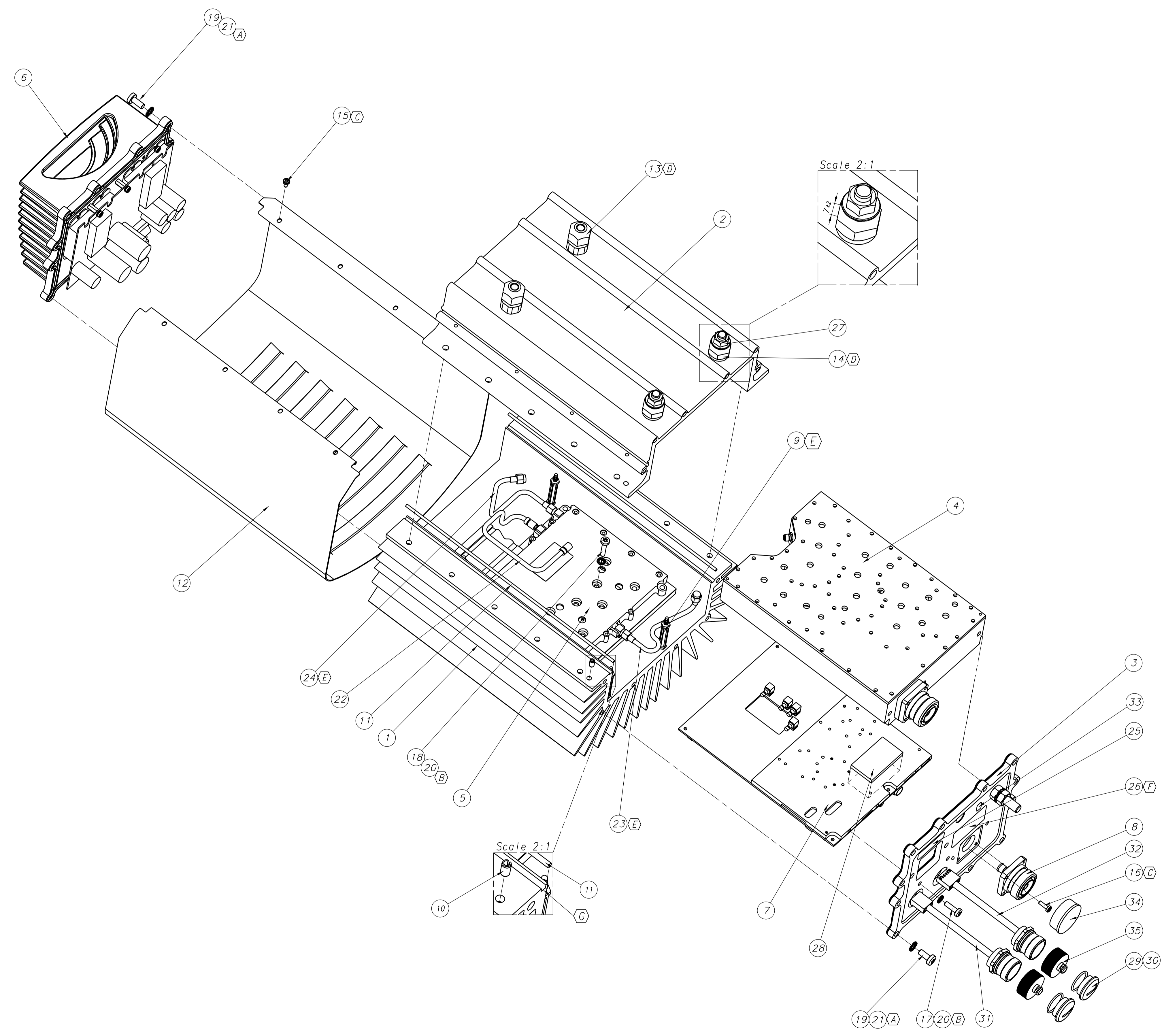
For M5 screws in the bottom- and the top lid.  
The first tightening sequence is 1,2...12 T=0.3±0.2Nm  
The second tightening sequence is 1,2...12 T=5.7±0.3Nm

The same method of approach is used for the mount of the LNF-filter block (82490) and the PA-block (82581).  
Torque for first sequence, T=0.3±0.2Nm



**Notes**

- (A) T=5.7Nm, see Mounting sequence above
  - (B) T=2.9Nm, see Mounting sequence above
  - (C) T=1.1Nm
  - (D) T=8Nm  
Apply loctite 601
  - (E) T=0.45Nm
  - (F) Label text acc to TBK902 chapter 3
  - (G) Silicone must be applied at the T-crossings (4x) before assembly.  
Use Dow Corning 3140 RTV or equivalent.
- Burn-in of TTPA TBK1038  
Final test of TTPA TBK1037



35	X	Contact cover M23x1	90992	See table above
34	2	Contact cover 7/16	57277	.
33	1	Label CE	57141	.
32	X	Cable alarm TTPA	82475	See table above
31	X	Cable DC TTPA	82477	See table above
30	X	O-ring 19x1.5 EPDM	90994	See table above
29	X	Packing screw pr 20.4 PS	90993	See table above
28	1	Tape foamed plastic	90963	.
27	2	Flange lock nut	90957	.
26	1	Label	90137	.
25	1	Label	45869.1	Antenna
24	1	Cable LNF-PA	82453	.
23	1	Cable BTS-PA	82290	.
22	X	Cable by-pass	82578	See table above
21	34	Washer	90948	AZ 5.3 A4
20	14	Washer	90949	AZ 4.3 A4
19	37	Screw	90944	MRT 5x14 A4
18	11	Screw	90946	MRT 4x20 A4
17	3	Screw	90945	MRT 4x12 A4
16	4	Screw	90943	MRT 3x10 A4
15	8	Screw	90889	MRT 3x6 A4
14	2	Mounting stud threaded	82240	.
13	2	Mounting stud conical	82239	.
12	1	Sun protection cover	82230	.
11	0.5m	Gasket O-ring string	90887	Length 252mm/piece
10	2	Spring pin FRP 4x8 A2	90958	.
9	4	Stacking spacer	90941	.
8	1	Connector 7/16-TNC	82276	.
7	1	BTS block	82080.XX	See table above
6	1	DC-block	82085.XX	See table above
5	1	PA block	82581.XX	See table above
4	1	LNF block	82490.XX	See table above
3	1	Bottom lid	82188	.
2	1	Housing back	82227	.
1	1	Housing front	82226	.

Pos	NUM	NAME	MATERIAL / DRAW	NOTE
1	1	Housing front	82226	

Scale	Drawn	Sharp edge chamfer	Finish	Weight
1:2 A1	990604 MIAS	0.1-0.3		

General Tolerances acc to	Fundamental tolerancing	Form and location tol.	Maximum material principle	Reference and reference system
SS-ISO 2768-1 medium	principal acc to SS-ISO 8015	acc to SS-ISO 1101	acc to SS-ISO 2692	acc to SS-ISO 5459

Checked El.	Checked Mek.	Surface treatment
		Acc to TBKxxx

REV	CH.O. NUMBER	DATE	SIGN	ZONE

Page	Title	Revision	File
1(1)	Assembly TTPA PCN 1900	1(1)	pa

Document number
82559

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