DWG No.	68-00078-20	SHT 1

REVISION HISTORY

REV	DESCRIPTION	DATE	APPROVED
A	INITIAL RELEASE - SEE ECO No.C02175	4/23/04	EBC
B	SEE ECO No.C02202	5/21/04	EBC
C	LABELING INSTR. ADDED - SEE ECO No.C02388	10/21/04	EBC

NOTE:

1. THIS DRAWING, TOGETHER WITH THE SEPARATE BILL OF MATERIAL (BOM) COMPRISE ALL INFORMATION REQUIRED TO CONSTRUCT, INSPECT, AND TEST THIS ASSEMBLY. SEE THE SEPARATE BOM FOR COMPONENT PART NUMBERS, QUANTITIES, AND OTHER ASSOCIATED REQUIREMENTS.

   THIS DRAWING IS NOT AN ASSEMBLY PROCESS.

2. WORKMANSHIP, INCLUDING BUT NOT LIMITED TO SOLDER AND ESD/EOS PROTECTION, SHALL COMPLY WITH ALL APPLICABLE PORTIONS OF IPC-A-610 FOR A CLASS 2 DEVICE.

3. PAGE 1 ILLUSTRATES THE COMPLETE ASSEMBLY. SEE PAGE 2 FOR ASSEMBLY DETAILS. NON-ESSENTIAL DETAIL IS OMITTED FOR CLARITY FROM EACH VIEW. DETAIL VIEW LIST:

   DETAIL "A": LH FOAM/CLAMSHELL DETAIL;
   DETAIL "B": RH FOAM/CLAMSHELL, KNOCK-OUT DETAIL;
   DETAIL "C": LH ANTENNA ASSEMBLY;
   DETAIL "D": RH ANTENNA ASSEMBLY;
   DETAIL "E": LCD INSTALLATION DETAIL;
   DETAIL "F": PATCH ANTENNA/DIELECTRIC FOAM DETAIL;
   DETAIL "G": PCA/DIPOLE/ACTUATOR INSTALLATION;
   DETAIL "H": FINAL ASSEMBLY/LABELS DETAIL;

4. WHERE THE APPLICABLE ASSEMBLY IS THE ETHERNET-VERSION CPE, REMOVE THE KNOCK-OUT TAB FROM ITEM 2, CLAMSHELL. RESULTING PLASTIC EDGES SHALL BE FREE OF BURRS.

5. DURING ALL STEPS OF THE ASSEMBLY PROCESS, PROTECT THE LIQUID CRYSTAL DISPLAY (LCD), ADJOINING FLEX CIRCUIT AND THE FLEX CIRCUIT SOLDER JOINT OF ITEM 1, PCA/LCD, FROM DAMAGE DUE TO HANDLING, ETC.

6. REMOVE THE BACKING PAPER LINER OF ITEMS 7 AND 8, FOAM BACKING, BEFORE APPLYING TO THE HEAT SINK OF ITEM 1, PCA/LCD, AND ITEMS 701/801, PATCH ANTENNAS. METAL PATCH ANTENNAS SHALL NOT BE IN CONTACT WITH THE ALUMINUM HEAT SINK OF ITEM 1, PCA/LCD.

7. SOLDER THE PATCH LEAD PER IPC-A-610, CLASS 2, WHERE INDICATED.

   TEST: RESISTANCE MEASURED ACROSS EACH OF ITEMS 7 OR 8, PATCH ANTENNAS, AND THE HEAT SINK (GND) OF ITEM 1 SHALL BE GREATER THAN 500 K-OHMS (OPEN CIRCUIT).

8. APPLY FOAM BACKING, ITEM 11, TO THE BACK SIDE OF THE LCD OF ITEM 1, PCA/LCD. FOAM BACKING SHALL BE CENTERED ON THE BACK OF THE LCD.

9. APPLY FOAM INSULATION, ITEMS 10, TO THE PLASTIC CLAMSHELLS, ITEMS 2 AND 3, AS ILLUSTRATED.

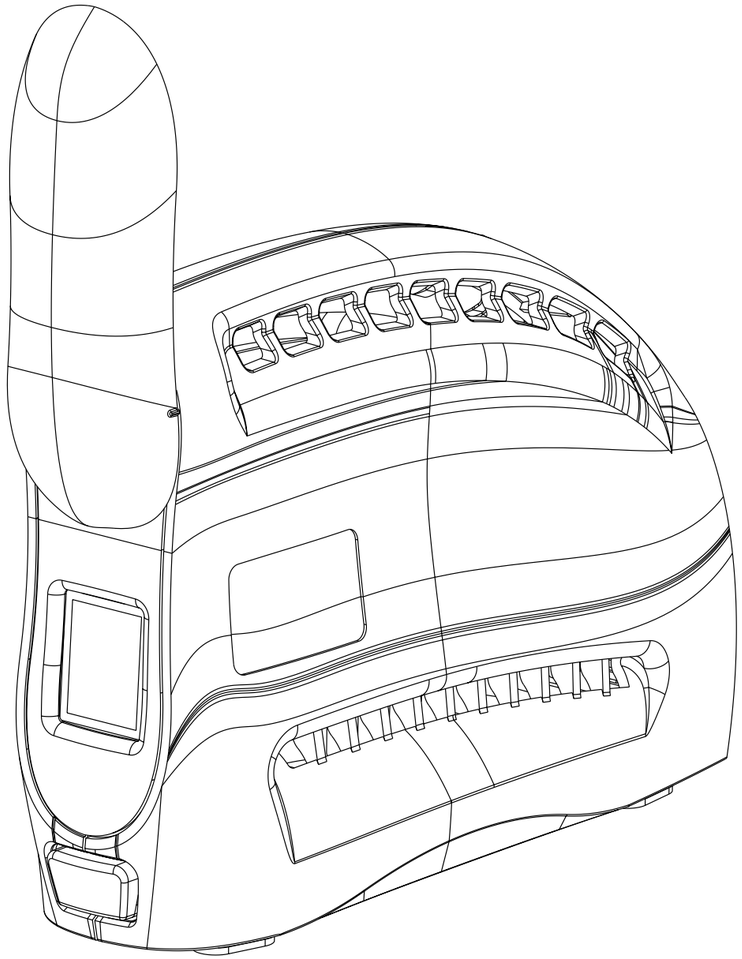
10. ROUTE THE FLEX CIRCUIT OF ITEM 1, PCA/LCD, AROUND THE PLASTIC POST OF ITEM 2, CLAMSHELL, AS ILLUSTRATED.

11. AFTER ITEMS 2 AND 3, CLAMSHELLS, ARE SNAPPED TOGETHER, THE POWER ACTUATOR, ITEM 4, SHOULD MOVE FREELY AND NOT BIND OR STICK.

12. APPLY LABELS TO THE LOCATION INDICATED. ALL LABELS ILLUSTRATED MAY NOT BE PRESENT ON THE SEPARATE BOM.

14. INSTALL CUSTOMER LOGO, WHERE INDICATED. CUSTOMER LOGO MAY NOT BE PRESENT ON THE SEPARATE BOM.

15. TEST THIS ASSEMBLY PER APPLICABLE PROCEDURES. SEE THE SEPARATE BOM FOR TEST PROCEDURES AND INSTRUCTIONS.



PART No. SEE SEPARATE BOM

UNLESS OTHERWISE SPECIFIED

DO NOT SCALE DRAWING

DIMENSIONS AND TOLERANCE PER ANSI Y14.5M-1982

DIMENSIONS ARE IN INCHES AND APPLY TO THE FINISHED PART

WELD SYMBOLS PER ANSI Y32.3

CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

INITIAL APPLICATION	LCD CPE
DRAWN	EBC 4/23/04
APPROVED	
ENGINEER	BCO 4/23/04
AUTHORITY	EBC 4/23/04

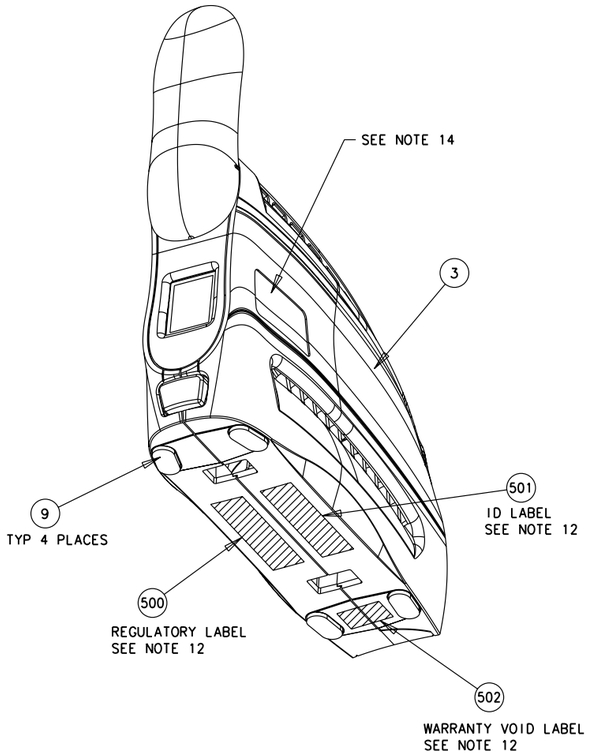
NAVINI NETWORKS
2240 CAMPBELL CREEK BLVD.
SUITE 110
RICHARDSON, TEXAS 75082

TITLE

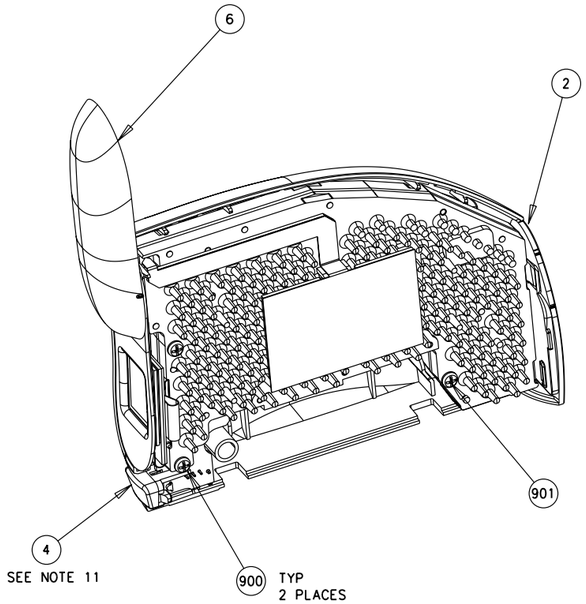
DRAWING, ASSY, LCD CPE

SIZE	DWG No.	REV
D	68-00078-20	C

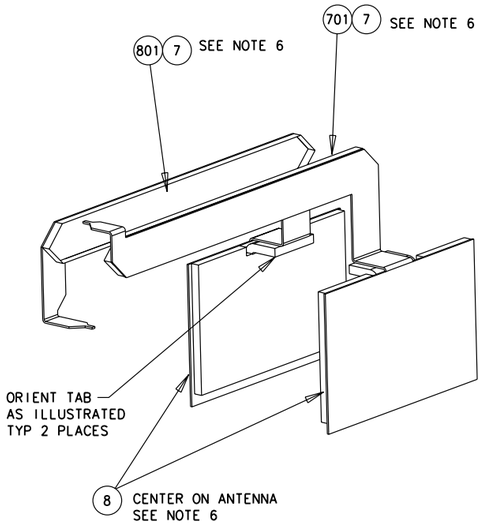
SCALE: 2:1 | TYPE:SDRC I-DEAS | SHEET 1 OF 2



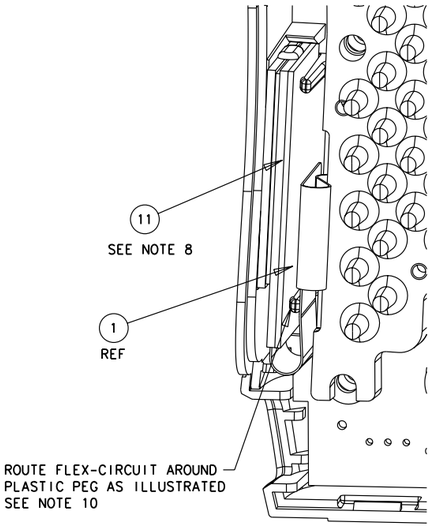
DETAIL "H"



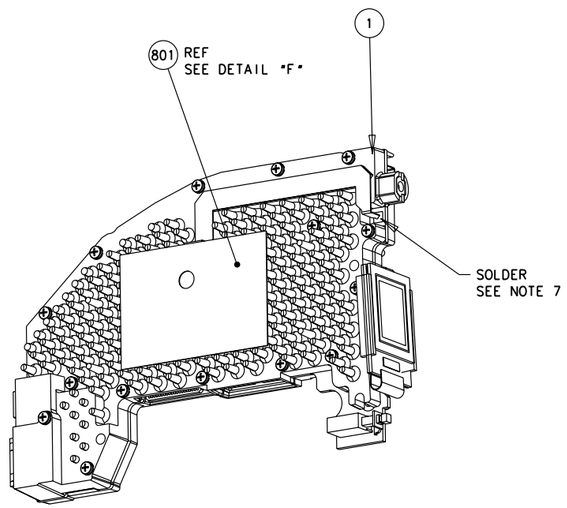
DETAIL "G"



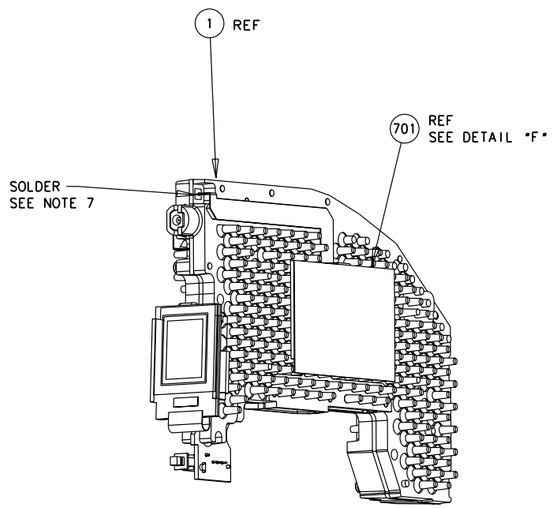
DETAIL "F"
SCALE 2:1



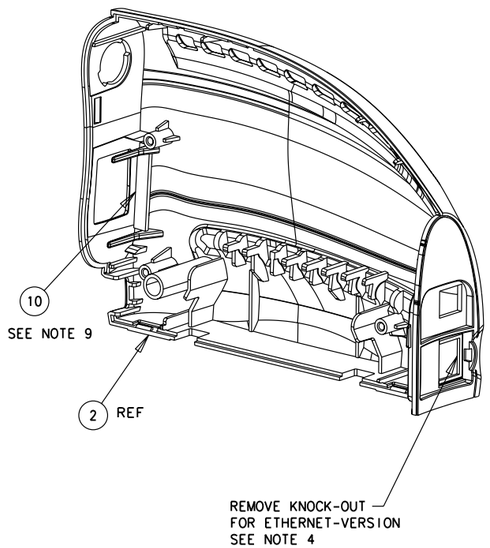
DETAIL E"
SCALE 2.5 :1
NON-ESSENTIAL DETAIL OF ITEM 1
OMITTED FOR CLARITY



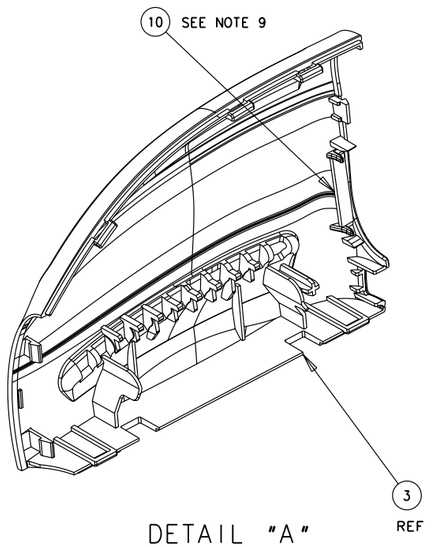
DETAIL "D"



DETAIL "C"



DETAIL "B"



DETAIL "A"

NAVINI NETWORKS
2240 CAMPBELL CREEK BLVD.
SUITE 110
RICHARDSON, TEXAS 75082

TITLE
DRAWING, ASSY, LCD CPE

SIZE	DWG No.	REV
D	68-00078-20	C

SCALE: 1:1	TYPE:SDRC I-DEAS	SHEET 2 OF 2