



Title: FlexIsolator Assembly
(P/N 900/810-240-031-015) Procedure

Document Number: 123-240-030-030

Department: Manufacturing

Revision History

Rev.	Description of Change	Originator	Date
A	As Issued per ECO-000974.	M. Miyasaki	4/7/2017

Step:

Title: **FlexRadio Assembly**

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Tools List

Item	Description	Quantity
N/A	Wrench	1
N/A	3"-lbs torque driver with Phillips screwdriver bit	1
N/A	4"-lbs torque driver with Phillips screwdriver bit	1
N/A	5"-lbs torque driver with Phillips screwdriver bit	1
N/A	5/8" deep socket with 3/8" square drive adapter	1
N/A	9"-lbs 3/8" torque wrench	1
N/A	Screwdriver with Phillips head	1
N/A	Alcohol based cleaner	A/R

References

Item	Description
121-240-030-015	Procedure, Test, Program/Functional, FlexRadio Cabinet
121-240-030-016	Procedure, Test, System/Final, FlexRadio Cabinet
122-240-030-004	P/N and HW Rev Marking Instructions, APCC
122-240-001-007	Instructions, Marking, Label, Product ID, Packaging, Non-serialized

Step:

Title: **FlexRadio Assembly**

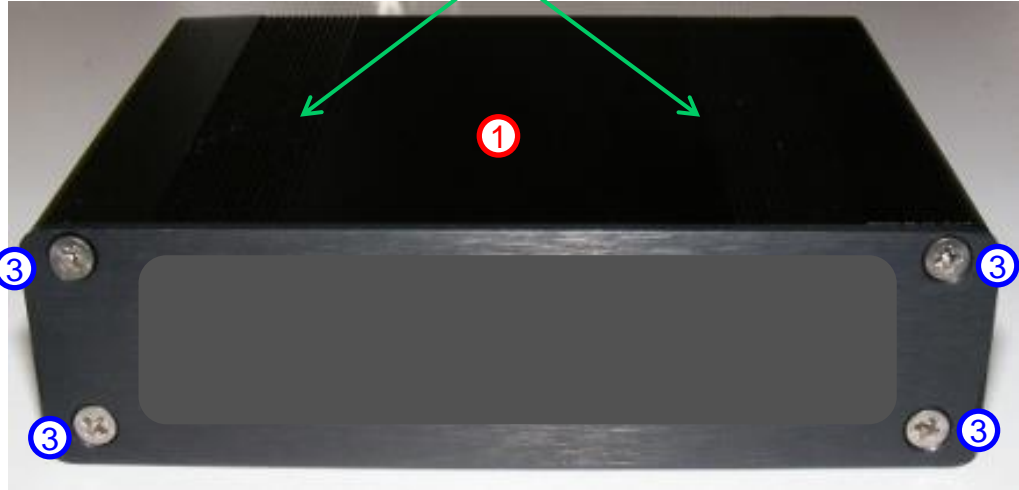
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Torque Requirement: 4"-lbs

NOTE: TOP of enclosure has GROOVES



②

④

Ensure minimal gap



Item	Description	Qty
320-240-030-055	Faceplate,Rear,Black	1
321-240-030-044	Screw,M3x10mm,PFH	4
320-240-030-051	Enclosure,Copper	1

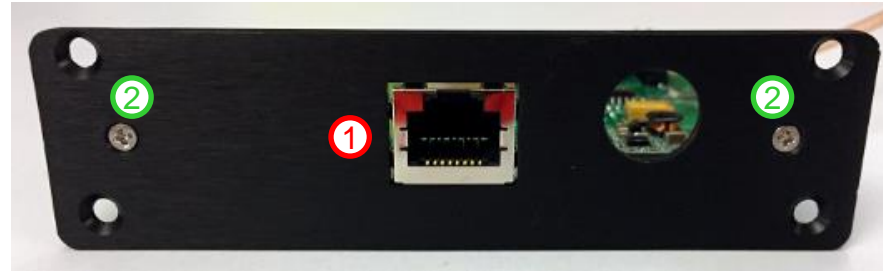
Assembly Steps	
①	Remove enclosure from packaging and discard provided hardware.
②	Align rear faceplate to end of enclosure as shown. Notice grooves on top of enclosure.
③	Assemble faceplate with flathead screws (4) torqued to 4"-lbs.
④	Ensure minimal gap between faceplate and enclosure
⑤	⑤

Tool	Description	Qty
N/A	Torque driver, Phillips bit	1

Notes:

Torque Requirement: 3"-lbs for screws
9"-lbs for SMA connector

Item	Description	Qty
320-240-030-054	Faceplate,Front,Black	1
321-240-030-043	Screw,2-56x1/4",PFH	2
350-240-020-017	Cable,Assy,SMA-RPTNC	1

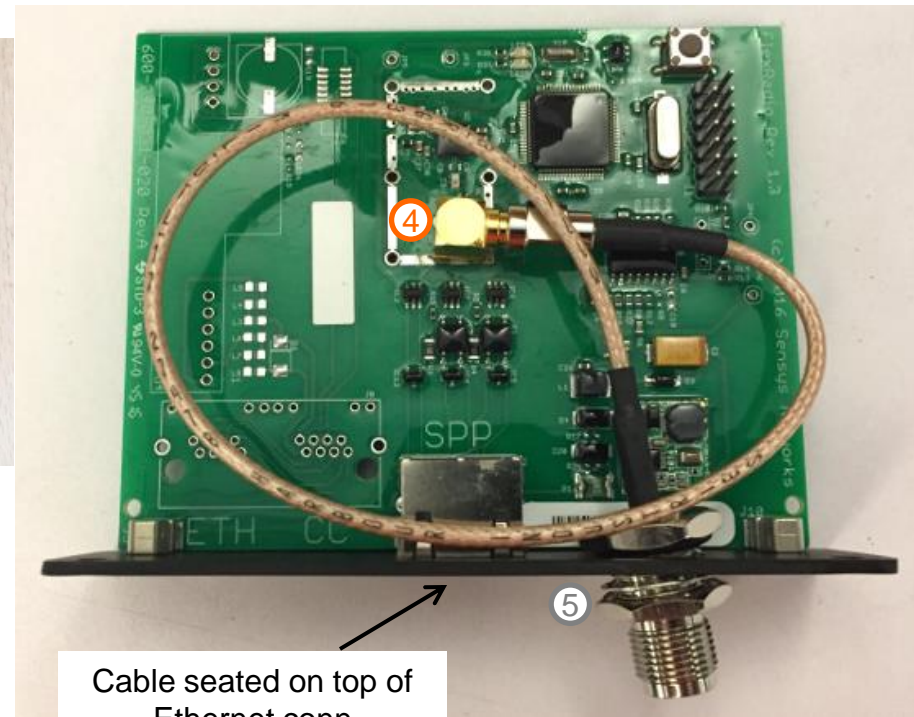


Assembly Steps

- ① Align front faceplate onto board aligning Ethernet jack.
- ② Assemble with 2-56 screws (2) torqued to 3"-lbs.
- ③ Place gasket (included with cable assy) onto RPTNC connector.
- ④ Assemble cable onto SMA Jack on board and torque to 9"-lbs.
- ⑤ Route cable as shown and insert into hole on front faceplate ensure gasket is on connector

Tool	Description	Qty
N/A	Torque driver, Phillips bit	1
N/A	9"lb torque wrench	1

Notes:



Step: **Assembly of Front Faceplate**

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Torque Requirement: 4"-lbs

NOTE: TOP of enclosure has GROOVES

Item	Description	Qty
321-240-030-044	Screw,M3x10mm,PFH	4
360-240-001-013	Lbl,weatherproof,1.75x.5	1

Assembly Steps

- ① Slide PCBA into enclosure along bottom groove as shown.
- ② Assembly faceplate to enclosure with flathead screws (4) torqued to 4"-lbs.
- ③ Ensure minimal gap between faceplate and enclosure.
- ④ Keep star washer and nut included with cable assembly until later in process.
- ⑤ Print and apply serial number as shown on bottom of unit.

Tool	Description	Qty
N/A	Torque driver, Phillips bit	1

Notes:

Ensure serial number on label matches board serial number.

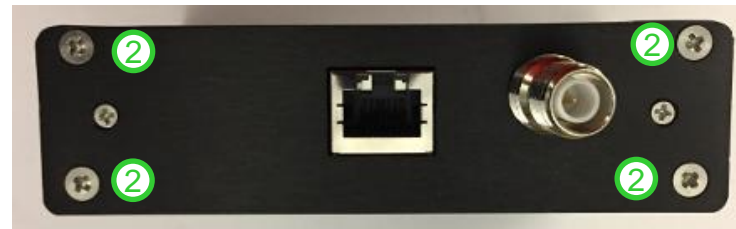
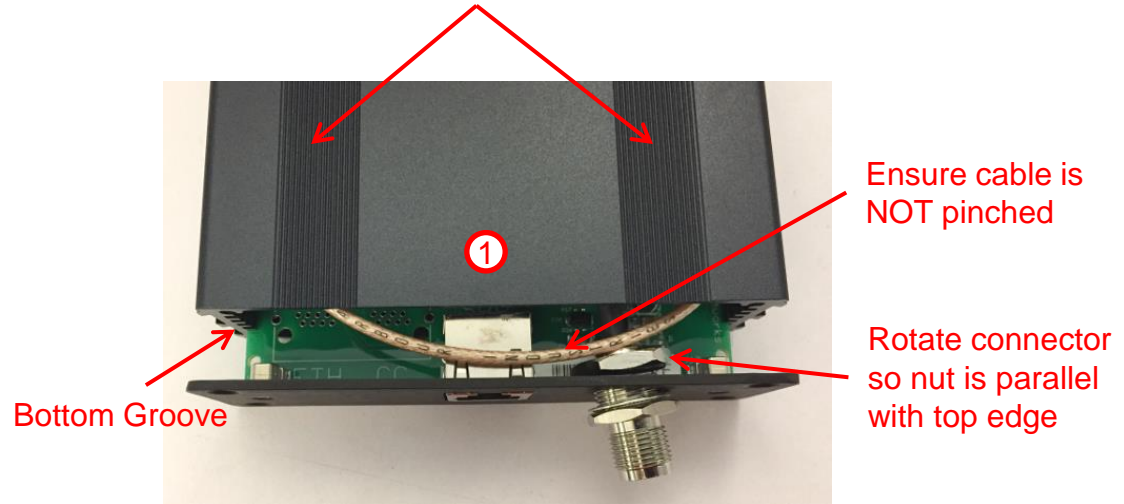
Step: **Assembly of Front Faceplate**

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FRONT



③ Ensure minimal gap



REAR

This concludes the mechanical subassembly. Continue with Final Test (see document P/N 121-240-030-XXX).

Clean surface with alcohol-based cleaner

After Final Test has been completed:

Item	Description	Qty
360-240-030-034	Front overlay	1
360-240-030-035	Rear overlay	1
Included w/cable	Star washer	1
Included w/cable	Nut	1



TOP (with grooves)

BOTTOM

Assembly Steps	
①	Adhere rear overlay ensuring copper side is on bottom of unit
②	Adhere front overlay aligning connector holes.
③	Place star washer and nut (included with cable assy) onto TNC connector.
④	Torque nut to 12"-lbs.
⑤	⑤

Tool	Description	Qty
N/A	5/8" deep socket	1

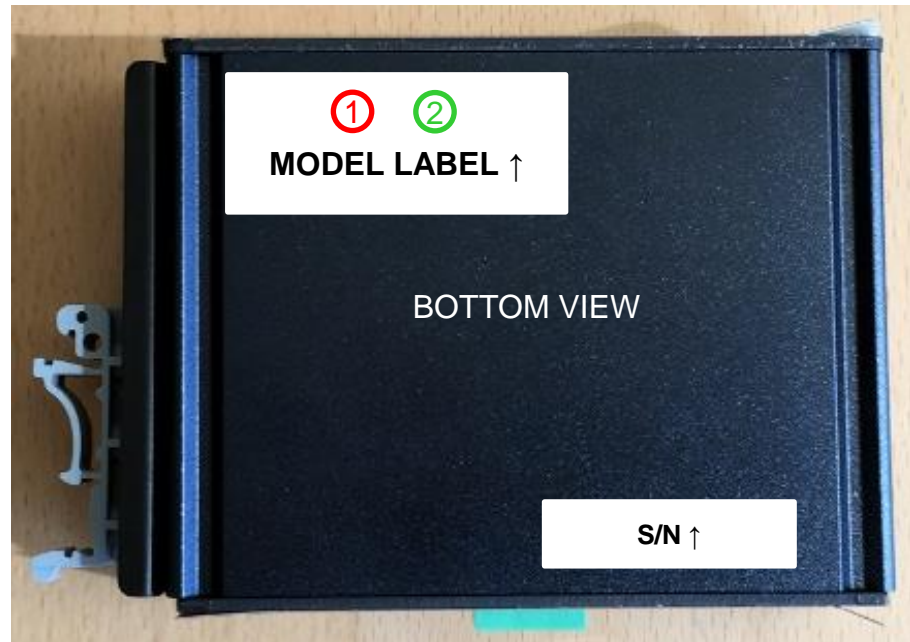
Notes:



③ ④

Clean surface with alcohol-based cleaner

FRONT



BACK

Item	Description	Qty
360-240-015-004	Lbl,weatherproof,2.63x1	1

Assembly Steps		
①	Print Model number label per 122-240-015-001 on weatherproof 2.63" x 1" label.	
②	On BOTTOM side of unit, adhere Model number label as shown.	
③		③
④		④
⑤		⑤

Tool	Description	Qty
N/A	Alcohol based cleaner	A/R

Notes: