| DRAWING No. | ADVG22AA | SHT 1 |
|---|---|---|

REVISIONS

| STREAM | ISSUE | EVENT | DATE | DRAWN | APPROVED |
|---|---|---|---|---|---|
| 00 | 01 | SEE EC No.102-20786 | 000512 | IML | KH |

NOTE:

1. ITEMS 1-499 IDENTIFIED ON THIS DRAWING ARE FOR GENERIC STOCK LIST SLVG0301. ITEMS 500 AND UP ARE FREQUENCY DEPENDENT. REFER TO TOP LEVEL CTR RADIO STOCK LIST. THIS DRAWING DEPICTS THE ASSEMBLY OF ALL CTR PLUMBED WR42 RADIOS.

2. IDENTIFY AS PER LABEL IDENTIFICATION MARKINGS ON SHEET 6, ZONE A7. PLACE LABELS AS INDICATED. REFER TO TOP LEVEL RADIO PEC CODE FOR MODEL AND PEC #.

3. INSTALL ALL HARDWARE TO SPECIFICATION PER TORQUE TABLE 1, ZONE B1.

4. ASSEMBLE ITEMS 515 AND 516 USING A QUANTITY 4 OF ITEM 517.

5. APPLY A THIN LAYER OF THERMAL COMPOUND PASTE, ITEM 75 (CPC #R0999451) TO ITEMS 501 AND 513 BEFORE ATTACHING TO ITEM 6 USING ITEMS 34, 38, 39 AND 40. ALSO APPLY BETWEEN ITEMS 502 AND 28.

6. APPLY A THIN LAYER OF THERMAL COMPOUND PASTE, ITEM 75 (CPC #R0999451) TO ITEM 6 BEFORE ATTACHING TO ITEM 1.

7. USE A 1/2" LENGTH OF TEFLON SLEEVING (ITEM 43) TO ISOLATE THE TWO LEADS OF THE CAPACITOR (ITEM 14).

8. USE A 1" LENGTH OF THE 3/16 INCH HEAT SHRINK (ITEM 44) TO COVER THE ENTIRE LENGTH OF THE MAG (ITEM 13) AND THE CONNECTING WIRE.

9. COVER UP THE HEATSINK MOUNTING SCREWS AND CAVITIES, 4 PLACES FROM OUTSIDE OF HOUSING (ITEM 1) WITH RTV ADHESIVE SEALENT 3165 (EXPENSE ITEM). ENSURE A SMOOTH FINISH (REFER TO SHEET 3, ZONE B6).

10. APPLY CSM,LOCTITE 242,THREADLOCKER (CPC #R0000170) TO ITEM 41 TO SECURE ITEM 6 TO ITEM 7 (REFER TO SHEET 4, ZONE C8).

11. CLEAN HOUSING ITEM 1, AROUND ITEM 41 AND OVER RTV ADHESIVE SEALENT 3165 (EXPENSE ITEM), WITH ALCOHOL BEFORE APPLYING WARRANTY LABEL.

13. DETAIL C, (SEE SHEET 6, ZONE B3) PROVIDES ASSEMBLY INSTRUCTIONS FOR NTVG16AA, NTVG16AC, NTVG16AD, NTVG16AG, NTVG04AE AND NTVG04AD. FOR NTVG22AA THESE COMPONENTS ARE PROVIDED PRE-ASSEMBLED BY THE ANTENNA VENDOR.

14. USE VIEW L-L FOR DRO (CPC #A0790971), SHEET 5, WHICH IS APPLICABLE TO NTVG22AA PRODUCT ONLY.

15. APPLY A THIN LAYER OF RTV ADHESIVE SEALANT 3165 (EXPENSE ITEM) ON HEX NUT OF ITEM 18 PRIOR TO MOUNTING ON TO ITEM 1. WIPE OFF AND CLEAN ANY EXCESS RTV.

16. AFFIX THE INDICATED QUANTATY OF HEAT TRANSFER STRIPS (ITEM 46) TO BOTTOM OF THE MOUNTING PLATE (ITEM 28) AFTER ATTACHING THE DRO (ITEM 502) TO IT. HEAT TRANSFER STRIPS, ITEM 46, SHALL BE EVENLY SPACED ACROSS UNDERSIDE OF DRO, ITEM 502. TRIM TO LENGTH. SEE DETAIL F SHT 5.

17. APPLY LOCTITE (ITEM 75) TO THE THREADS OF THE SHOULDER HEAD CAPSCREW (ITEM 81) AS INDICATED AND TIGHTEN SCREW TO COMPRESS THE HEAT TRANSFER STRIPS (ITEM 46).

18. APPLY THE GORTEX PATCH (ITEM 76) OVER THE ARRAY OF HOLES ON THE INSIDE OF HOUSING (ITEM 1) PER THE MANUFACTURERS INSTALLATION INSTRUCTIONS.

19. INSTALL ITEMS AS IN DETAIL M, SHEET 5. NOTE GROUND CABLE TO BE CRIMPED TO ITEM 58 IS NOT PROVIDED WITH THIS ASSEMBLY.

20. REMOVE OMT FROM THE ANTENNA (SAVE SCREWS) AND ATTACH IT TO RX AND TX WAVEGUIDES USING ITEMS 38 AND 30, 8X.

21. ATTACH ITEM 29 TO ITEM 7 USING ITEM 80, 8X, AS SHOWN ON SHEET 5, SECTION N-N.

22. RE-ATTACH OMT WITH THE RADIO SUB-ASSEMBLY TO THE ANTENNA USING HARDWARE FROM NOTE 20.

23. POSITION GASKET ITEM 20 IN THE HOUSING GROOVE, THEN SECURE HOUSING TO BASE PLATE ITEM 7 USING HARDWARE ITEMS 77, 38 AND 39, 8X.
NOTE: ENSURE THAT THE HOUSING AND THE BASE PLATE ARE IN CONTACT AFTER TORQUING THE SCREWS DOWN.

24. ATTACH THE ANTENNA TO HOUSING USING HARDWARE ITEMS 38, 39 AND 36, 8X.

25. INSTALL ITEM 78 ON HOUSING (ITEM 1) WITH ITEM 79 AS SHOWN ON SHEET 2, ZONE B3.

TORQUE TABLE

| THREAD | TORQUE (IN-LBS) |
|---|---|
| 2-56 | 2-3 |
| 4-40 | 5-6 |
| 6-32 | 10-12 |
| 8-32 | 18-20 |
| SMA | 7-10 |
| N-CONNECTOR | 12-15 |

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DWG No. ADVG22AA

UNLESS OTHERWISE SPECIFIED

SURFACE ROUGHNESS MAX. 63 PER ANSI B46.1

HOLE, CBORE, CSK ØTOLERANCE:

| Ø.085 TO Ø.250 | Ø.251 TO Ø.500 |
|---|---|
| +.003 -.002 | +.005 -.003 |

TOLERANCE ON DIMENSIONS:

| .XX | .XXX | ANGLES |
|---|---|---|
| ± .02 | ± .010 | ±1° |

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 CTR, 31-01P

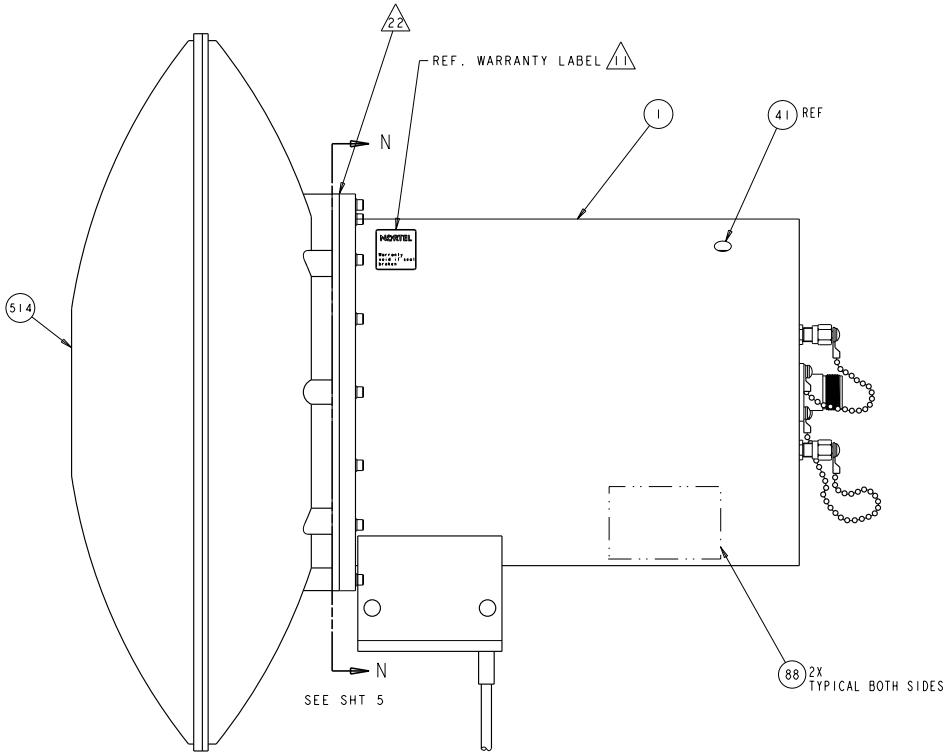
| | | |
|---|---|---|
| DRAWN | IML | 000512 |
| APPROVED | KFH | 000512 |
| ENGINEER | PHF | 000512 |
| AUTHORITY | Z.OU | 981005 |

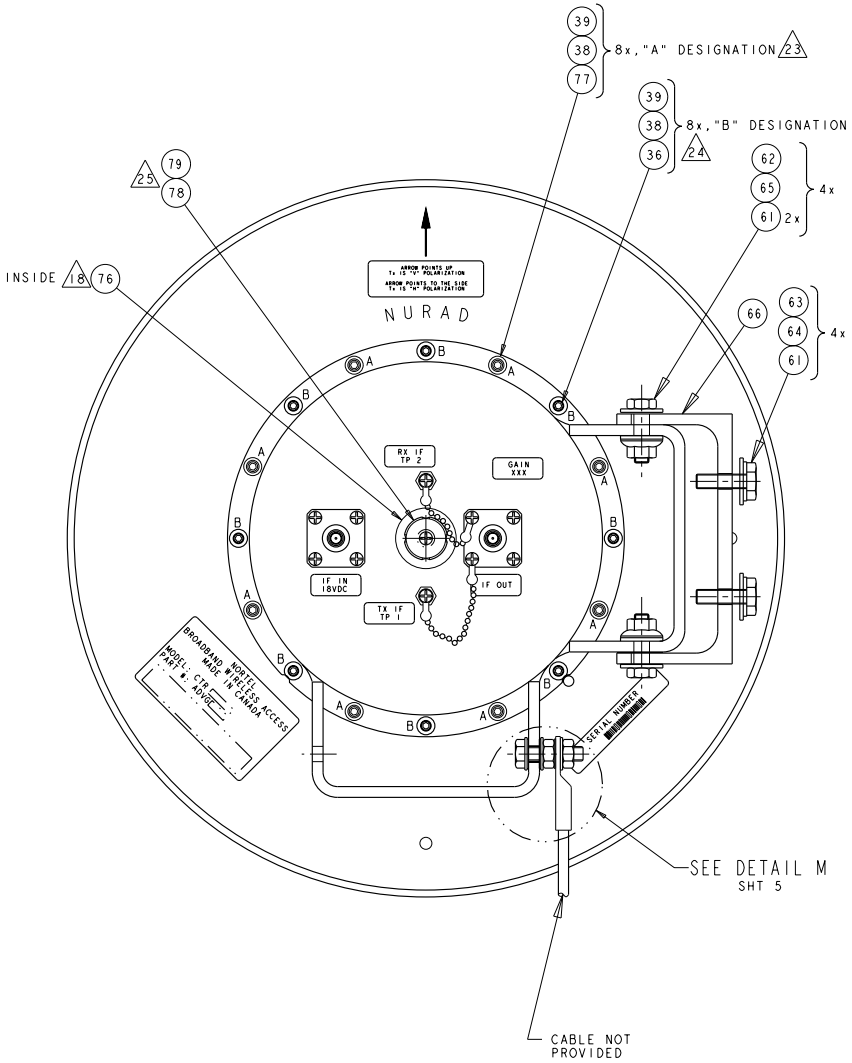
NORTEL NETWORKS
BROADBAND WIRELESS ACCESS
14 FULTZ BOULEVARD
WINNIPEG, MANITOBA
CANADA R3Y 1V3

TITLE
CTR,P,WR28, ASSEMBLY
(CTR, 31-01P)

| SIZE | DRAWING No. | STREAM | ISSUE |
|---|---|---|---|
| D | ADVG22AA | 00 | 01 |

SCALE NONE | TYPE: SDRC I-DEAS | SHEET 1 OF 7




| SIZE | DRAWING No. | STREAM | ISSUE |
|---|---|---|---|
| D | ADVG22AA | 00 | 01 |
| SCALE 1:1 | TYPE: SDRC I-DEAS | SHEET 2 OF 7 | |