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TN DI	ROCESS INSPECTION FOR SIDEBAND		DDINMED WIDING DOADD
•	MBLY 4079992-1	GENERATOR	
	AL NO.		
	IRED DRAWINGS		
KEQU:			
	PC 825 WORKMANSHIP MANUAL WORKSHI	EET 61, 51.	
	A5793		
1.0	INSPECTION OF UNASSEMBLIED P	RINTED WIRI	NG BOARD PC 825.
1.1	ALL DIMENTIONS MUST CONFORM !	TO DRAWING	NO. PC 825-1. ALL
	DIMENTIONS MUST BE WITHIN A	FOLERANCE F	ACTOR OF ± .016 UNLESS
	OTHERWISE SPECIFIED.		
1.2	CONDUCTIVE PATTERN MUST BE F	REE OF HAIR	LINE FRACTURES, UN-
	WANTED BRIDGING, THE PATTERN	EDGES MUST	BE CLEARLY DEFINED AND
	SHALL NOT BE RAGGED. NICKS OF	R PINHOLES	EXPOSING THE BASE MAT-
	ERIAL SHALL NOT BE ACCEPTABLE	E. REFER T	O PC 825-3 FOR A PICTOR
	IAL PRESENTATION OF THE PRINT	TED PATTERN	•
1.3	ALL HOLES MUST BE PLATED THRO	OUGH UNLESS	OTHERWISE SPECIFIED.
	ALL EDGE BOARD CONNECTOR FINO	GERS (15 CO	MPONENT SIDE) AND
	(15 CIRCUIT SIDE) MUST GOLD	PLATED.	
1.4	COMPONENT SIDE MUST BE MARKET	O IN WHITE	GOTHIC AS PER DRAWING
	PC 825-4 CIRCUIT SIDE MUST HA	AVE A SOLDE	R MASK COATING, POSITIO
	ED AS PER PC 825-5.		
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COMMENTS PARAGRAPH 1.0 \_\_\_\_\_\_

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- 2.0 INSPECTION OF COMPONENT PLACEMENT FOR ASSEMBLIED PRINTED WIRING BOARD A 5793.
- ALL COMPONENT PLACEMENTS MUST CONFORM TO DRAWING A 5793.

  ALL ELECTROLITIC CAPACITOR POLORIZATION C5, C6, C9, C12, C13,

  C14, C15, C17, C33, C34, C36, C8 C11, C49, C2, MUST BE POSITION—

  ED AS PER THE MARKING GUIDE STAMPED ON THE PRINTED WIRING BOARD.

  A 5793 ALSO DETAILS THE POSITION OF THE ELECTROLITIC CAPACITORS.

  T1 AND T2 MUST BE POSITIONED WITH RESPECT TO THE BLACK POLORIZ—

  ING DOT WHICH APPEARS ON THE SIDE OF THE TRANSFORMER CASE. REFER

  TO A 5793 FOR PROPER POSITION.

ALL TRANSISTORS Q1 THROUGH Q13 HAVE PADS WITH TABS REFLECTING
THE EMITTER OF THE TRANSISTOR. ALL TABS MUST BE POSITIONED AS
PER DRAWING A 5793.

- 2.2 ALL SIDEBAND GENERATOR ASSEMBLY COMPONENT LEADS SHALL BE TERMINATED DIRECTLY AT THE CIRCUIT PAD EXTEND THROUGH THE BOARD
  AND BENT OVER A MINIMUM OF THE PAD RADIUS AND A MAXIMUM OF THE
  PAD DIAMETER. COMPONENT LEADS SHALL BE CLINCHED IN THE DIRECTION
  OF, PARALLEL TO AND IN CONTACT WITH THE CIRCUIT PATTERN.
  REFER TO WORKMANSHIP MANUAL, NOTICE NO. 51
- 2.3 ALL SOLDER CONNECTIONS FOR THE SIDEBAND GENERATOR ASSEMBLY MUST HAVE A UNIFORM LAYER OF SOLDER, AND INSPECTED TO INSURE THERE ARE NO COLD SOLDER CONNECTIONS.

THE PRESENCE OF OXIDE RESIDUE OR ANY OTHER FOREIGN MATTER ON THE SURFACE OF THE SOLDER IS UNACCEPTABLE.
REFER TO WORKMANSHIP MANUAL, NOTICE NO. 60

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- 3.0 INSPECTION FOR BONDING OF HIGH PROFILE COMPONENTS.
- 3.1 THE FOLLOWING COMPONENTS C2, C21, C56, C40, R60, R54, R34, R28, R9, T4, L1, L2, L3, L4, REQUIRE BONDING TO THE PRINTED WIRING BOARD.

INSPECTION IS PERFORMED AT THIS POINT TO INSURE THAT THE BONDING MATERIAL HAS CURED PROPERLY AND THAT THE WORKMANSHIP IS CLEAN AND NEAT.

AFTER THE ABOVE MENTIONED COMPONENTS ARE BONDED TO THE PRINTED WIRING BOARD, A CONFORMAL COATING IS APPLIED (ACRYLIC) WITH TOLUENE THINNER. INSPECT TO INSURE THE ASSEMBLY IS COMPLETELY CLEAN AND FREE FROM ANY EVIDENCE OF FLUX, MASKING MATERIAL OR OTHER CONTAMINATES.

3.2 PLACE COMPLETED BOARD INTO CLEAN POLYETHYLENE BAGS FOR STORAGE OR SHIPMENT.

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	IN PROCESS INSPECTION
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ASSEN	MBLY 4079994-1
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REQUI	RED DRAWINGS
	PC 826 WORKMANSHIP MANUAL WORKSHEET 61, 51. A 5794
1.0	INSPECTION OF UNASSEMBLIED PRINTED WIRING BOARD PC 826.
1.1	ALL DIMENTIONS MUST CONFORM TO DRAWING NO. PC 826-1, ALL
	DIMENTIONS MUST BE WITHIN A TOLERANCE FACTOR OF + .016 UNLESS
	OTHERWISE SPECIFIED.
1.2	CONDUCTIVE PATTERN MUST BE FREE OF HAIR LINE FRACTURES, UNWANTED
·	BRIDGING, THE PATTERN EDGES MUST BE CLEARLY DEFINED AND SHALL
	NOT BE RAGGED. NICKS OR PINHOLES EXPOSING THE BASE MATERIAL
	SHALL NOT BE ACCEPTABLE.
	REFER TO PC 826-3 FOR A PICTORIAL PRESENTATION OF THE PRINTED
	Dammeron

1.3 ALL HOLES MUST BE PLATED THROUGH UNLESS OTHERWISE SPECIFIED.

ALL EDGE BOARD CONNECTOR FINGERS (15 COMPONENT SIDE) AND

1.4 COMPONENT SIDE MUST BE MARKED IN WHITE GOTHIC AS PER DRAWING

PC 826-4 CIRCUIT SIDE MUST HAVE A SOLDER MASK COATING, POSITIONED

(15 CIRCUIT SIDE) MUST BE GOLD PLATED.

COMMENTS PARAGRAPH 1.0

AS PER PC 826-5.

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- 2.0 INSPECTION OF COMPONENT PLACEMENT FOR ASSEMBLIED PRINTED WIRING BOARD A 5794.
- ALL COMPONENT PLACEMENTS MUST CONFORM TO DRAWING A 5794.

  ALL ELECTROLITIC CAPACITOR POLORIZATION C13, C17, C18, C50, C32, C33, C35, C36, C51, C19, and C20, MUST BE POSITIONED AS PER THE SYMBOL (+) STAMPED ON THE PRINTED WIRING BOARD. A5794 ALSO DETAILS THE POSITION OF THE ELECTROLITIC CAPACITORS.T1, T2, T3, T4, AND T5 MUST BE POSITIONED WITH RESPECT TO THE BLACK POLORIZING DOT WHICH APPEARS ON THE SIDE OF THE TRANSFORMER CASE. REFER TO A 5794 FOR PROPER POSITION.

ALL TRANSISTORS Q1 THROUGH Q14 HAVE PADS WITH TABS REFLECTING THE EMITTER OF THE TRANSISTOR. ALL TABS MUST BE POSITIONED AS PER DRAWING A 5794.

- 2.2 ALL CARRIER GENERATOR ASSEMBLY COMPONENT LEADS SHALL BE TERMINATED DIRECTLY AT THE CIRCUIT PAD EXTEND THROUGH THE BOARD AND BENT
  OVER A MINIMUM OF THE PAD RADIUS AND A MAXIMUM OF THE PAD DIAMETER. COMPONENT LEADS SHALL BE CLINCHED IN THE DIRECTION OF,
  PARALLEL TO AND IN CONTACT WITH THE CIRCUIT PATTERN.
  REFER TO WORKMANSHIP MANUAL, MOTICE NO. 51
- 2.3 ALL SOLDER CONNECTIONS FOR THE CARRIER GENERATOR ASSEMBLY MUST
  HAVE A UNIFORM LAYER OF SOLDER, AND INSPECTED TO INSURE THERE ARE
  NO COLD SOLDER CONNECTIONS. THE PRESENCE OF OXIDE RESIDUE OR ANY
  OTHER FOREIGN MATTER ON THE SURFACE OF THE SOLDER IS UNACCEPTABLE.
  REFER TO WORKMANSHIP MANUAL, NOTICE NO. 60

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- 3.0 INSPECTION FOR BONDING OF HIGH PROFILE COMPONENTS.
- 3.1 THE FOLLOWING COMPONENTS C5, C9, C39, C51, C33, C32, C50, C17, R47, R20, R27, R69, T6 REQUIRE BONDING TO THE PRINTED WIRING BOARD.

INSPECTION IS PERFORMED AT THIS POINT TO INSURE THAT THE BONDING MATERIAL HAS CURED PROPERLY AND THAT THE WORKMANSHIP IS CLEAN AND NEAT.

AFTER THE ABOVE MENTIONED COMPONENTS ARE BONDED TO THE PRINTED WIRING BOARD, A CONFORMAL COATING IS APPLIED (ACRYLIC) WITH TOLUENE THINNER. INSPECT TO INSURE THE ASSEMBLY IS COMPLETELY CLEAN AND FREE FROM ANY EVIDENCE OF FLUX, MASKING MATERIAL OR OTHER CONTAMINATES.

3.2 PLACE COMPLETED BOARD INTO CLEAN POLYETHYLENE BAGS FOR STORAGE OR SHIPMENT.

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IN PROCESS INSPECTION
IN PROCESS INSPECTION FOR FREQUENCY SHIFT GENERATOR PRINTED WIRING
BOARD ASSEMBLY 4079993-2
SERIAL NO
REQUIRED DRAWINGS
PC827 WORKMANSHIP MANUAL WORKSHEET 61, 51. A5795
1.0 INSPECTION OF UNASSEMBLIED PRINTED WIRING BOARD PC827.
1.1 ALL DIMENTIONS MUST CONFORM TO DRAWING NO. PC827-1. ALL
DIMENTIONS MUST BE WITHIN A TOLERANCE FACTOR OF + .016 UNLESS

ONDUCTIVE PATTERN MUST BE FREE OF HAIR LINE FRACTURES, UNWANTED BRIDGING, THE PATTERN EDGES MUST BE CLEARLY DEFINED
AND SHALL NOT BE RAGGED. NICKS OR PINHOLES EXPOSING THE BASE
MATERIAL SHALL NOT BE ACCEPTABLE. REFER TO PC827-3 FOR A PICTORIAL PRESENTATION OF THE PRINTED PATTERN.

OTHERWISE SPECIFIED.

- 1.3 ALL HOLES MUST BE PLATED THROUGH UNLESS OTHERWISE SPECIFIED.

  ALL EDGE BOARD CONNECTOR FINGERS (15 COMPONENT SIDE) AND

  (15 CIRCUIT SIDE) MUST GOLD PLATE.
- 1.4 COMPONENT SIDE MUST BE MARKED IN WHITE GOTHIC AS PER DRAWING
  PC827-4 CIRCUIT SIDE MUST HAVE A SOLDER MASK COATING, POSITIONED IN SUCH A MANNER SO THAT ALL AREAS NOT USED FOR SOLDERING
  HAS A SOLDER RESISTENT COATING.

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- 2.0 INSPECTION OF COMPONENT PLACEMENT FOR ASSEMBLIED PRINTED WIRING BOARD A5795.
- 2.1 ALL COMPONENT PLACEMENTS MUST CONFORM TO DRAWING A5795.

  ALL ELECTROLITIC CAPACITOR POLORIZATION C34, C29, C36, MUST

  BE POSITIONED AS PER THE MARKING GUIDE STAMPED ON THE PRINTED

  WIRING BOARD. A5795 ALSO DETAILS THE POSITION OF THE ELECTRO
  LITIC CAPACITORS. T1 AND T2 MUST BE POSITIONED WITH RESPECT TO

  THE BLACK POLORIZING DOT WHICH APPEARS ON THE SIDE OF THE TRANS
  FORMER CASE. REFER TO A5795 FOR PROPER POSITION.

  ALL TRANSISTORS Q1 THROUGH Q10 HAVE PADS WITH TABS REFLECTING

  THE EMITTER OF THE TRANSISTOR. ALL TABS MUST BE POSITIONED AS
- 2.2 ALL FREQUENCY SHIFT GENERATOR ASSEMBLY COMPONENT LEADS SHALL BE TERMINATED DIRECTLY AT THE CIRCUIT PAD AND EXTEND THROUGH THE BOARD. REFER TO WORKMANSHIP MANUAL NOTICE NO. 51.

PER DRAWING A5795.

2.3 ALL SOLDER CONNECTIONS FOR THE FREQUENCY SHIFT GENERATOR ASSEMBLY MUST HAVE A UNIFORM LAYER OF SOLDER, AND INSPECTED TO INSURE THERE ARE NO COLD SOLDER CONNECTIONS.

THE PRESENCE OF OXIDE RESIDUE OR ANY OTHER FOREIGN MATTER ON THE SURFACE OF THE SOLDER IS UNACCEPTABLE.

REFER TO WORKMANSHIP MANUAL, NOTICE NO. 60

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- 3.0 INSPECTION FOR BONDING OF HIGH PROFILE COMPONENTS.
- 3.1 THE FOLLOWING COMPONENTS T3, T4, C29, C34, C36, REQUIRE BOND-ING TO THE PRINTED WIRING BOARD.

INSPECTION IS PERFORMED AT THIS POINT TO INSURE THAT THE BOND-ING MATERIAL HAS CURED PROPERLY AND THAT THE WORKMANSHIP IS CLEAN AND NEAT.

AFTER THE ABOVE MENTIONED COMPONENTS ARE BONDED TO THE PRINTED WIRING BOARD, A CONFORMAL COATING IS APPLIED (ACRYLIC) WITH TOLUENE THINNER. INSPECT TO INSURE THE ASSEMBLY IS COMPLETELY CLEAN AND FREE FROM ANY EVIDENCE OF FLUX, MASKING MATERIAL OR OTHER CONTAMINATES.

3.2 PLACE COMPLETED BOARD INTO CLEAN POLYETHYLENE BAGS FOR STORAGE OR SHIPMENT.

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