

# TMC SPECIFICATION

N . S1400-1

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SHEET 4 OF 4

TITLE:

INSPECTED BY \_\_\_\_\_

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APPROVED BY \_\_\_\_\_

DATE \_\_\_\_\_

# TMC SPECIFICATION

NO. S1400-1

REV:

COMPILED: DW RU

CHECKED: RU

APPD:

SHEET

OF

TITLE:

IN PROCESS INSPECTION

FOR

4079992-1 SERIAL NO. \_\_\_\_\_

SIDEBAND GENERATOR ASSEMBLY

# TMC SPECIFICATION

N . S1400-1

REV:

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OF 4

TITLE:

## IN PROCESS INSPECTION

IN PROCESS INSPECTION FOR SIDEBAND GENERATOR PRINTED WIRING BOARD  
ASSEMBLY 4079992-1

SERIAL NO. \_\_\_\_\_.

### REQUIRED DRAWINGS

PC 825  
WORKMANSHIP MANUAL WORKSHEET 61, 51.  
A5793

- 1.0 INSPECTION OF UNASSEMBLED PRINTED WIRING BOARD PC 825.
- 1.1 ALL DIMENTIONS MUST CONFORM TO DRAWING NO. PC 825-1. ALL DIMENTIONS MUST BE WITHIN A TOLERANCE FACTOR OF  $\pm .016$  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 825-3 FOR A PICTORIAL PRESENTATION OF THE PRINTED PATTERN.
- 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 PLATED.
- 1.4 COMPONENT SIDE MUST BE MARKED IN WHITE GOTHIC AS PER DRAWING PC 825-4 CIRCUIT SIDE MUST HAVE A SOLDER MASK COATING, POSITIONED AS PER PC 825-5.

COMMENTS PARAGRAPH 1.0 \_\_\_\_\_

# TMC SPECIFICATION

NO. S1400-1

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TITLE:

- 2.0 INSPECTION OF COMPONENT PLACEMENT FOR ASSEMBLED PRINTED WIRING BOARD A 5793.
- 2.1 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 POSITIONED 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 POLORIZING 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

COMMENTS PARAGRAPH 2.0 \_\_\_\_\_

# TMC SPECIFICATION

NO. S1400-1

REV:

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TITLE:

- 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.

COMMENTS PARAGRAPH 3.0 \_\_\_\_\_



# TMC SPECIFICATION

NO. S1400-2

REV:

COMPILED:

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TITLE:

## IN PROCESS INSPECTION

IN PROCESS INSPECTION FOR CARRIER GENERATOR PRINTED WIRING BOARD  
ASSEMBLY 4079994-1

SERIAL NO. \_\_\_\_\_

### REQUIRED DRAWINGS

PC 826

WORKMANSHIP MANUAL WORKSHEET 61, 51.

A 5794

- 1.0 INSPECTION OF UNASSEMBLED PRINTED WIRING BOARD PC 826.
- 1.1 ALL DIMENSIONS MUST CONFORM TO DRAWING NO. PC 826-1, ALL DIMENSIONS MUST BE WITHIN A TOLERANCE FACTOR OF  $\pm .016$  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 PATTERN.
- 1.3 ALL HOLES MUST BE PLATED THROUGH UNLESS OTHERWISE SPECIFIED. ALL EDGE BOARD CONNECTOR FINGERS (15 COMPONENT SIDE) AND (15 CIRCUIT SIDE) MUST BE GOLD PLATED.
- 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 AS PER PC 826-5.

COMMENTS PARAGRAPH 1.0 \_\_\_\_\_

# TMC SPECIFICATION

N . S1400-2

REV:

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SHEET 2 OF 4

TITLE:

- 2.0 INSPECTION OF COMPONENT PLACEMENT FOR ASSEMBLED PRINTED WIRING BOARD A 5794.
- 2.1 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, NOTICE 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

COMMENTS PARAGRAPH 2.0 \_\_\_\_\_







# TMC SPECIFICATION

NC. S1400-3

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TITLE:

IN PROCESS INSPECTION

FOR

4079993-2 SERIAL NO. \_\_\_\_\_

FREQUENCY SHIFT GENERATOR ASSEMBLY

# TMC SPECIFICATION

NO. S1400-3

REV:

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TITLE:

## 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 UNASSEMBLED PRINTED WIRING BOARD PC827.
- 1.1 ALL DIMENSIONS MUST CONFORM TO DRAWING NO. PC827-1. ALL DIMENSIONS MUST BE WITHIN A TOLERANCE FACTOR OF  $\pm .016$  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 PC827-3 FOR A PICTORIAL PRESENTATION OF THE PRINTED PATTERN.
- 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.

COMMENTS PARAGRAPH 1.0 \_\_\_\_\_

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NO. S1400-3

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2.0 INSPECTION OF COMPONENT PLACEMENT FOR ASSEMBLED 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 ELECTROLITIC CAPACITORS. T1 AND T2 MUST BE POSITIONED WITH RESPECT TO THE BLACK POLORIZING DOT WHICH APPEARS ON THE SIDE OF THE TRANSFORMER 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 PER DRAWING A5795.

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.

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

COMMENTS PARAGRAPH 2.0 \_\_\_\_\_



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NO. S1400-3

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