

	Proprietary Information - Confidential				DO001152	
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Oleg Einem	Nimrod Tenne			Sharon Ashkenazi		

Revision History

Revision	Date	Changes	Modified By	Approved By
1.0	09.12.13	Release Work Procedure	Oleg Einem	Nimrod Tenne
1.1	06.01.14	Fixed	Oleg Einem	Sharon Ashkenazi

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1. Introduction

This document describes in detail the assembly process of the GoBeam-8000 Top level Systems.

2. Required Tools

- Automatic screw drivers with torque (for example “Delvo” DLV-7333 and DLV-7140).
- Philips screw head bits size 1 and 2.
- Hexagon head bit size 5mm.
- PLCC Instructor.

3. General Instructions

- Before assembling verify that all required items are in following conditions:
 - Parts are in correspondence with proper part numbers and revisions.
 - All items are in good condition, not damaged and fully clean.
 - Each component has relevant certificate, test report and approval.
 - Tools are calibrated, tested in time and approved for use.
 - Working place is properly equipped, clean and free of extraneous objects.
- All assembly executors must carefully follow these instructions.
- Unless otherwise specified use Soudure NET 9418 (Go P/n: MS000010) for cleaning and degreasing.
- Unless otherwise specified screws bit size and closing torque should be in accordance with the following table:

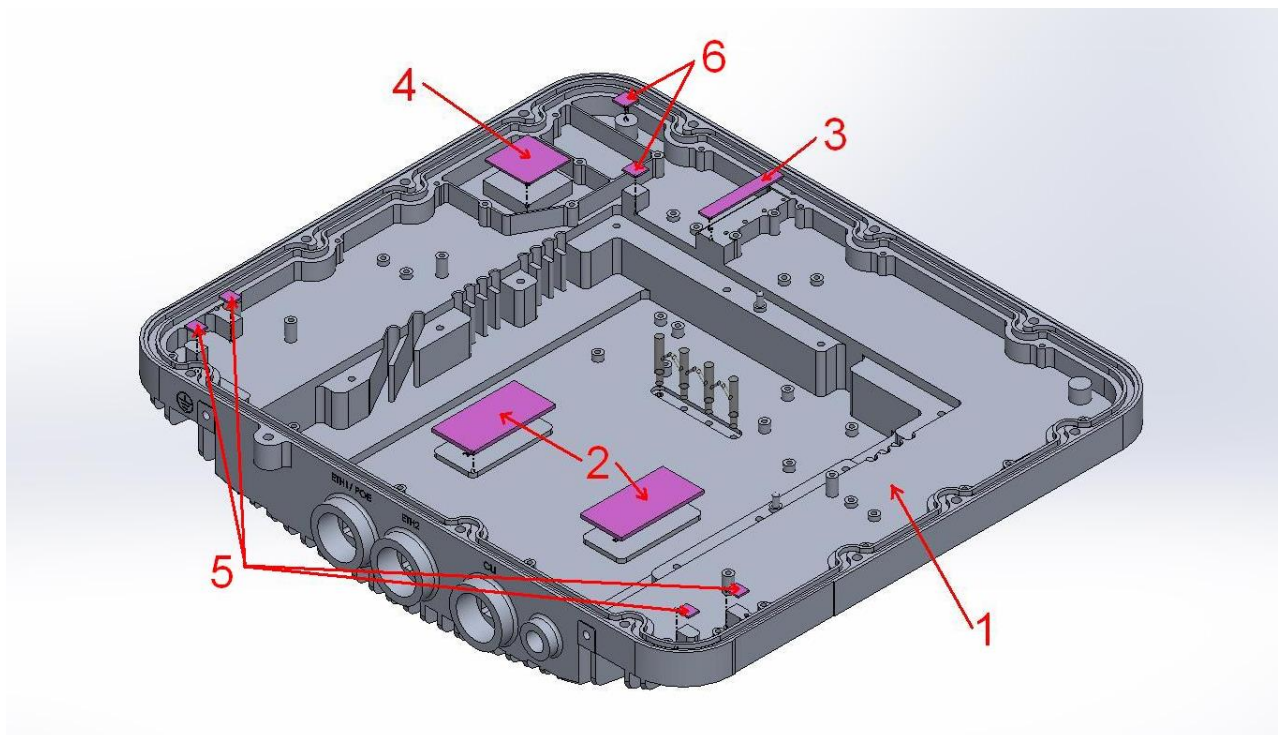
Screw Size	M2	M3	M3 Nylon	M4	M5
Bit size	1		2		
Required Torque	4 kg-cm 3.5 lb-In	6.9 kg-cm 6 lb-In	3.5 kg-cm 3 lb-In	17 kg-cm 14.8 lb-In	30 kg-cm 26 lb-In

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4. Mechanical Assembly

4.1. Heat Conductive Gap Fillers Gluing

4.1.1. Stick items 2...6 to item 1 after previously cleaning related surfaces of item 1.

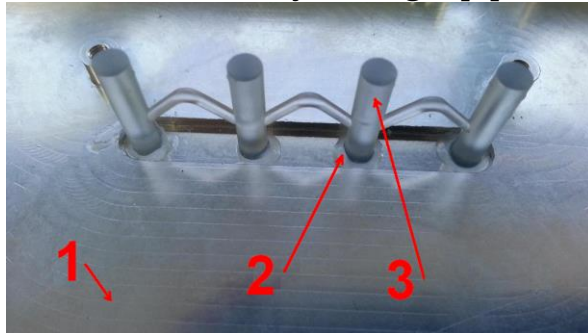


Item	Description	Part No	QTY
1	Base	MC000471	1
2	Thermal Pad 50x25x2 mm	MC000500	2
3	Thermal PAD(45*7*1t)	MC000477	1
4	Thermal PAD(26*26*1t)	MC000478	1
5	Thermal PAD(7.5*6.5*1t)	MC000479	4
6	Thermal PAD(8*8*1t)	MC000480	2

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4.2. Light pipes

4.2.1. Paste the light pipes (item 3) to the item 1 by item 2 without holes between body and light pipes.

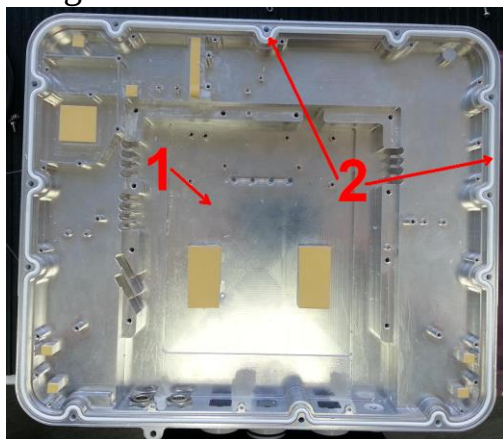


Item	Description	Part No	QTY
1	Base	MC000471	1
2	Silicon	MS000022	0.08mL
3	Light Pipe	MC000483	1

4.3. Sealing Gasket.

Fit the Sealing Gasket (item 2) into the Body's groove after previously applying Grease MS000008.

Ensure that the gasket seats proper along the groove and any of its particles do not get out.

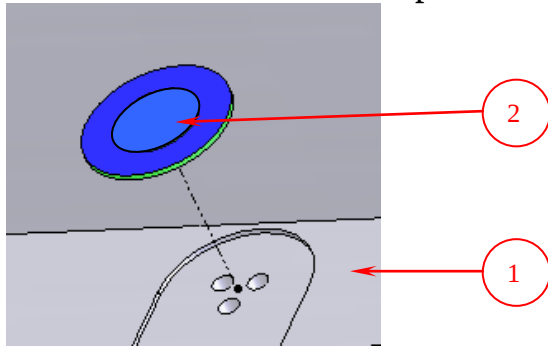


Item	Description	Part No	QTY
1	Base	MC000471	1
2	O-Ring	MC000495	1

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4.4. Adhesive Membrane Vent Gluing

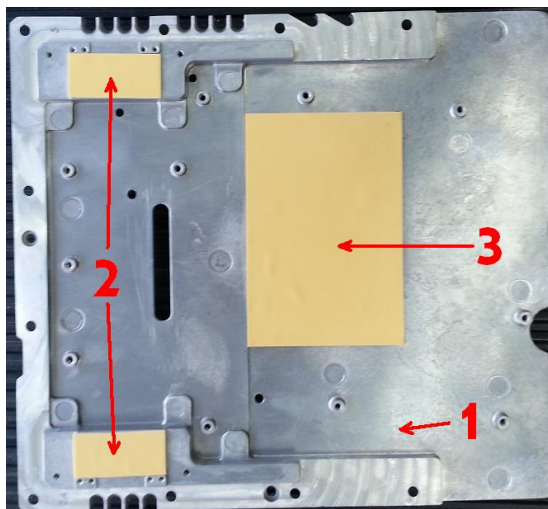
Stick item 2 to item 1 after previously cleaning related surface of item 1.



Item	Description	Part No	QTY
1	Base	MC000471	1
2	Adhesive Membrane Vent	MC000030	1

4.5. CPU board.

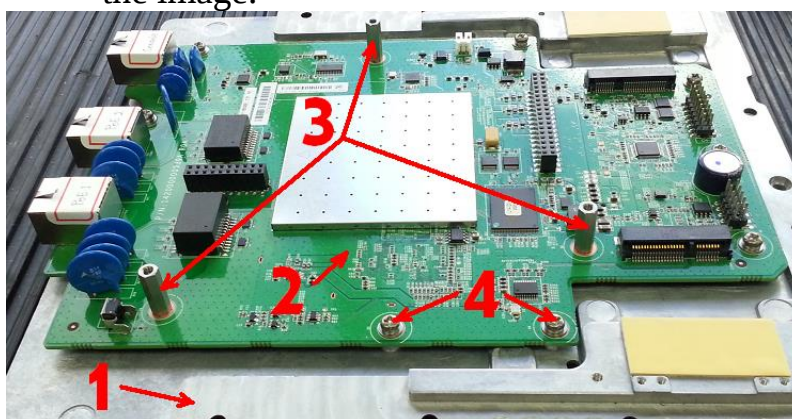
4.5.1. Stick items 2, 3 to item 1 after previously cleaning related surfaces of item 1.



Item	Description	Part No	QTY
1	PCB Holder	MC000472	1
2	Thermal PAD(38*18*1t)	MC000475	2
3	Thermal PAD(67*100*1t)	MC000476	1

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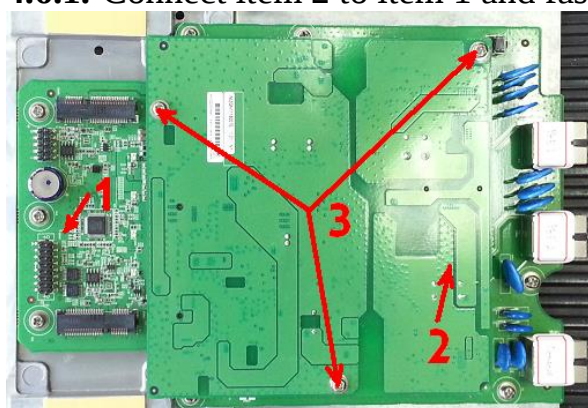
4.5.2. Connect item 2 to item 1 and fasten it by item 3 and item 4 as shown in the image.



Item	Description	Part No	QTY
1	PCB Holder	MC000472	1
2	CPU board	BM000001-01	1
3	STAND OFF(M3x16L)	FS000122	3
4	SCREW (M3*8)	FS000080	8

4.6. PS board.

4.6.1. Connect item 2 to item 1 and fasten it by item 3 as shown in the image.

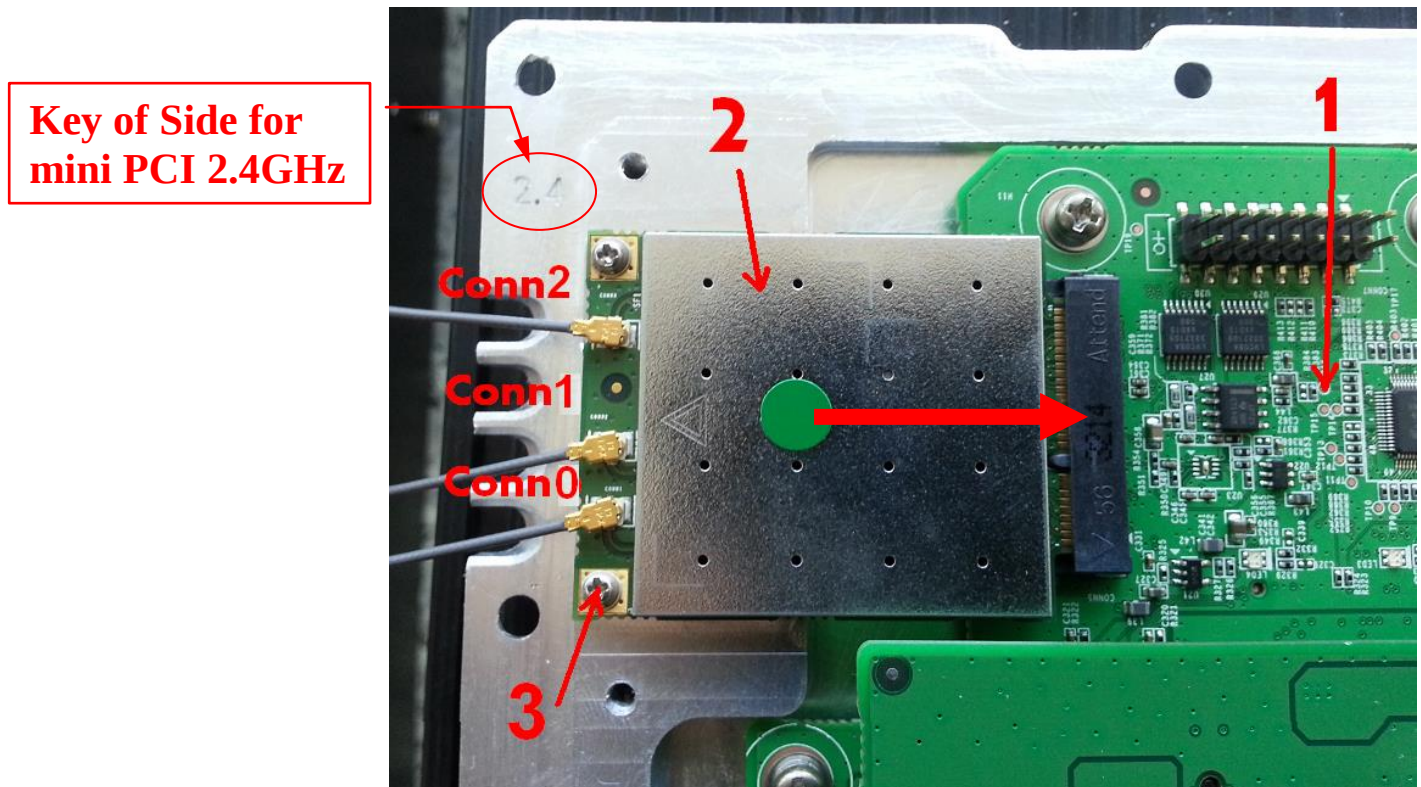


Item	Description	Part No	QTY
1	CPU board	BM000001-01	1
2	Power Supply board	BM000002-01	1
3	SCREW (M3*8)	FS000080	3

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4.7. Wireless mini PCI Boards 2.4GHz, 5GHz.

- 4.7.1. Remove the Product label from mini PCI Boards. (on PS side).
- 4.7.2. Connect item 2 to item 1 and fasten it by item 3 as shown. (also Mini PCI 2.4GHz and also Mini PCI 5GHz)



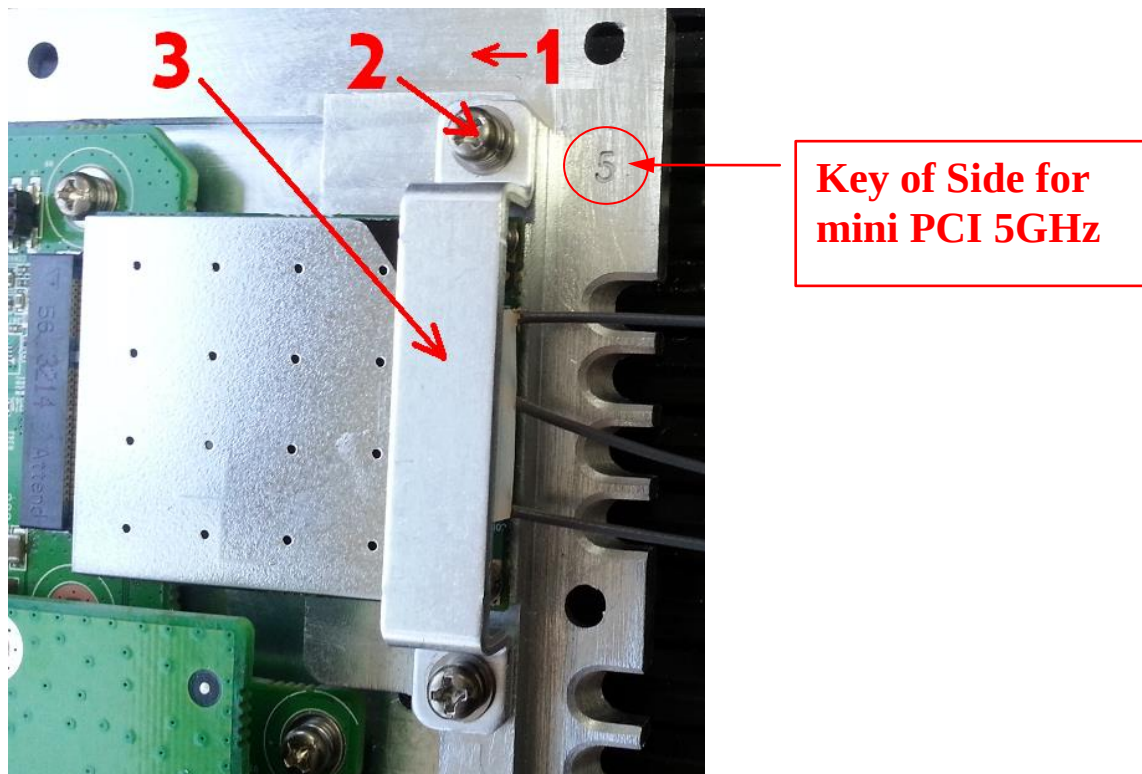
Item	Description	Part No	QTY
1	CPU board	BM000001-01	1
2	Mini PCI 2.4GHz (on left side of CPU)	WL000012	1
2	Mini PCI 5GHz (on right side of CPU)	WL000013	1
3	SCREW (M2*6)	FS000073	4

- 4.7.3. Connect 5 RF cables CB000272 to Conn 0-2 of Mini PCI 2.4GHz and Mini PCI 5GHz.

Note: Only one RF cable that connected to Conn 2 of Mini PCI 2.4GHz must be LONG: CB000273.

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4.7.4. Connect item 3 to item 1 and fasten it by item 2 as shown. (also for Mini PCI 2.4GHz and also for Mini PCI 5GHz)

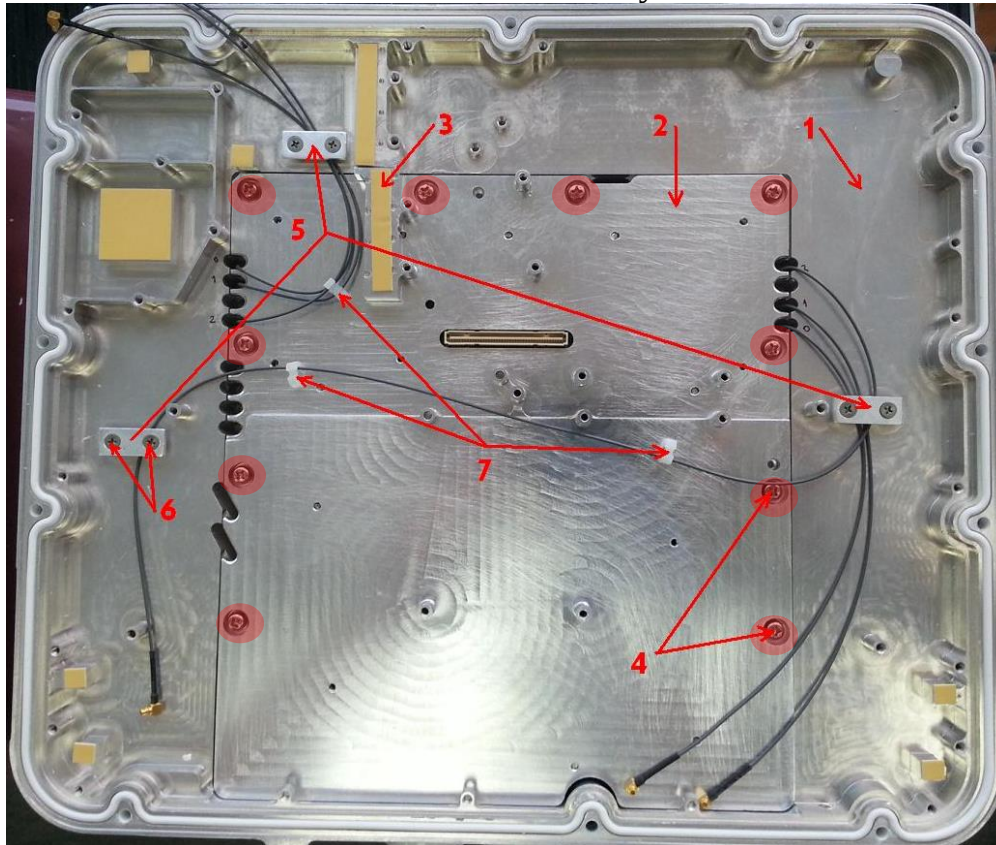


Item	Description	Part No	QTY
1	PCB Holder	MC000472	1
2	SCREW (M3*8)	FS000080	4
3	PCIE HOLDER	MC000482	2

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4.8. Mechanical Assembly.

4.8.1. Place item 2 on item 1 and fasten by items 4.



Item	Description	Part No	QTY
1	Base	MC000471	1
2	PCB Holder	MC000472	1
3	Thermal PAD(45*7*1t)	MC000477	1
4	SCREW (M4*8)	FS000123	10
5	Cable Holder	MC000484	3
6	SCREW (M3*5)	FS000126	6
7	CABLE HOLDER(MWS1)	MC000485	3

4.8.2. Stick items 3 to item 2 as shown in the image after previously cleaning related surfaces of item 2.

4.8.3. Insert item 7 in item 2 as shown in the image.

4.8.4. Position RF cables in items 7 and fix them with item 5 and item 6 as shown in the image.

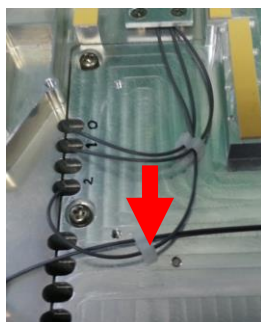
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4.9. Beam Forming.

4.9.1. Position Beam Forming board on back side of body and connect RF cables of 5GHz as shown in the image.



4.9.2. After connecting cables 5GHz, shift longest RF cables of 5GHz and fix in another holder as shown in the image.

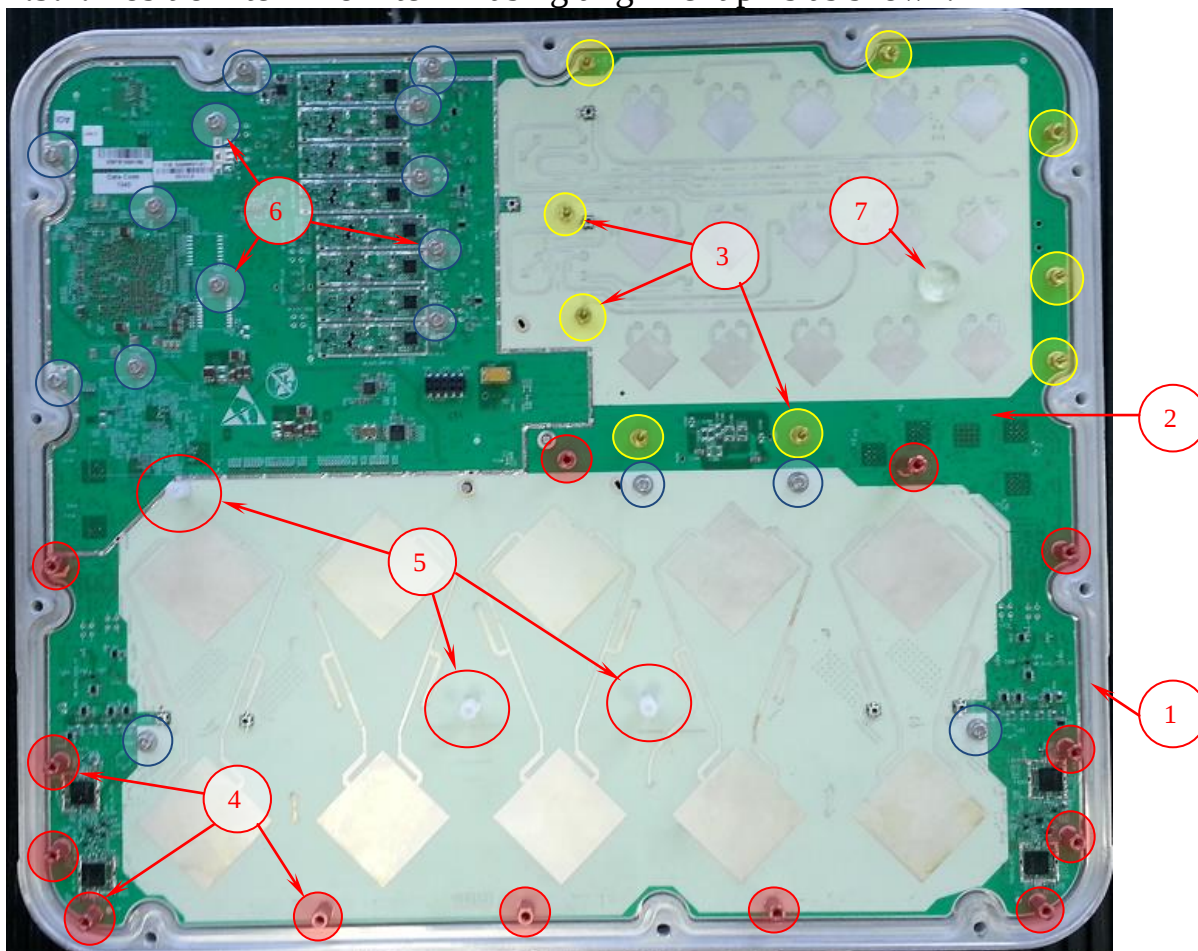


4.9.3. Connect RF cables of 2GHz as shown in the image.



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4.9.4. Position item 2 on item 1 using alignment pins as shown.



Item	Description	Part No	QTY
1	Base	MC000471	1
2	Beam Forming board	BA000041-01	1
3	STAND OFF (M3*3.5)	FS000128	9
4	Standoff M3x8	FS000127	13
5	Standoff Nylon M-F M3x8 Hex 4.5	FS000129	3
6	SCREW (M3*8)	FS000080	16
7	Rubber Pad(D12.7*3.5t)	MC000494	1

4.9.5. Fasten Beam Forming Board (item 2) with item 6, item 3 and item 4 as shown in the image.

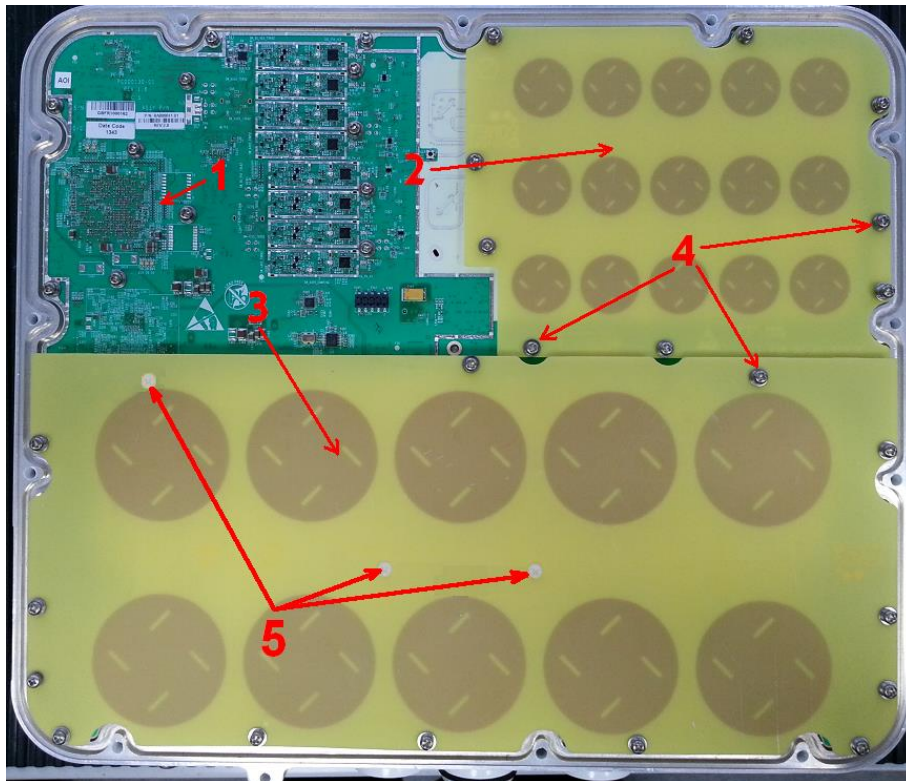
4.9.6. Screw item 5 in item 2.

4.9.7. Stick item 7 to item 2 as shown in the image.

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4.10. Antennas.

4.10.1. Position item 2 and item 3 on item 1 and tighten items 4.



Item	Description	Part No	QTY
1	Beam Forming board	BA000041-01	1
2	RF director 5GHz	PC000126	1
3	RF director 2GHz	PC000127	1
4	Screw Pan M3x5	FS000125	22
5	Screw Nylon Pan Phi Head M3x5	FS000130	3

4.10.2. Fasten item 3 by item 5 as shown in the image.

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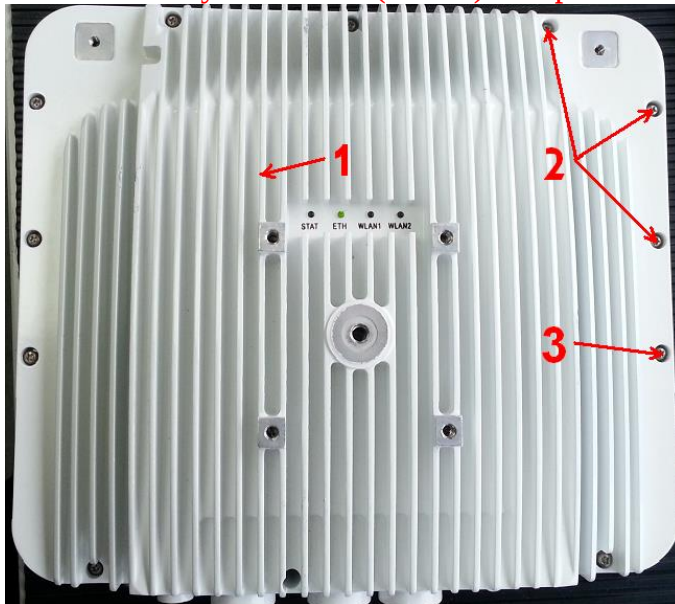
4.11. Radom.

4.11.1. Position Cover (MC000473) on the unit and invert the unit with Cover.



4.11.2. Screw items 2 into item 1.

Note: Only one screw (item 3) that placed as shown in the image must be keyed.



Item	Description	Part No	QTY
1	Base	MC000471	1
2	SCREW (M4*14)	FS000070	12
3	Screw with key	FSxxxxxxx(TBD)	1

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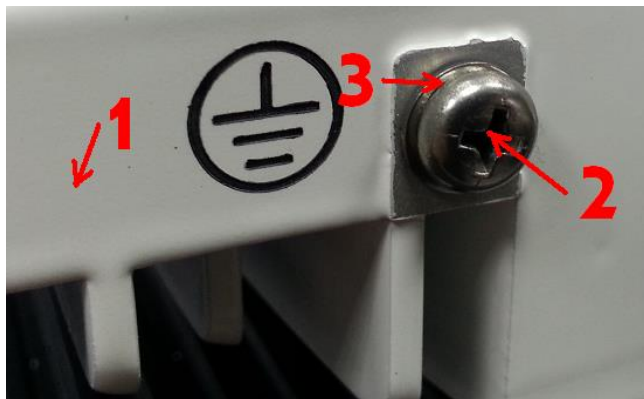
4.12. Sealing screw.

After sealing test (if passed) plug up tapped hole in Body by Self Sealing Screw FS000004.



4.13. Ground Screw

Screw items 2 with item 3 into item 1.



Item	Description	Part No	QTY
1	Base	MC000471	1
2	Screw M5x10	FS000005	1
3	Toothed Lock M5	FS000020	2

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4.14. Plug for ETH2 and CLI.

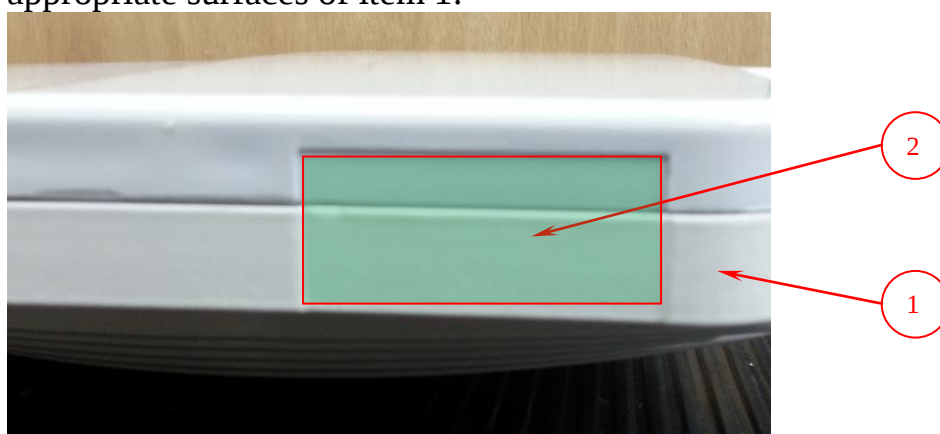
Manually screw items 2 into item 1 in place of ETH2 and CLI.



Item	Description	Part No	QTY
1	Base	MC000471	1
2	Plug for ETH2 and CLI	CNxxxxxx(TBD)	2

4.15. Labels Sticking

Stick Labels (items 2) on two sides of item 1 after previously cleaning appropriate surfaces of item 1.



Item	Description	Part No	QTY
1	Base	MC000471	1
2	Label	LBxxxxxx(TBD)	2