

NOTES: UNLESS OTHERWISE SPECIFIED

SUGGESTED ORDER OF ASSEMBLY :

INSTALL THE TWO .1 SQUARE THERMAL PADS (ITEM 29) TO HEATSINK ON HUB CASTING AS SHOWN.

INSTALL HEATSINK (ITEM 28) TO MODEM BOARD (ITEM 2) AS SHOWN. APPLY 15 LBS OF PRESSURE FOR 30 SECONDS TO HEATSINK TO SET ADHEASIVE.

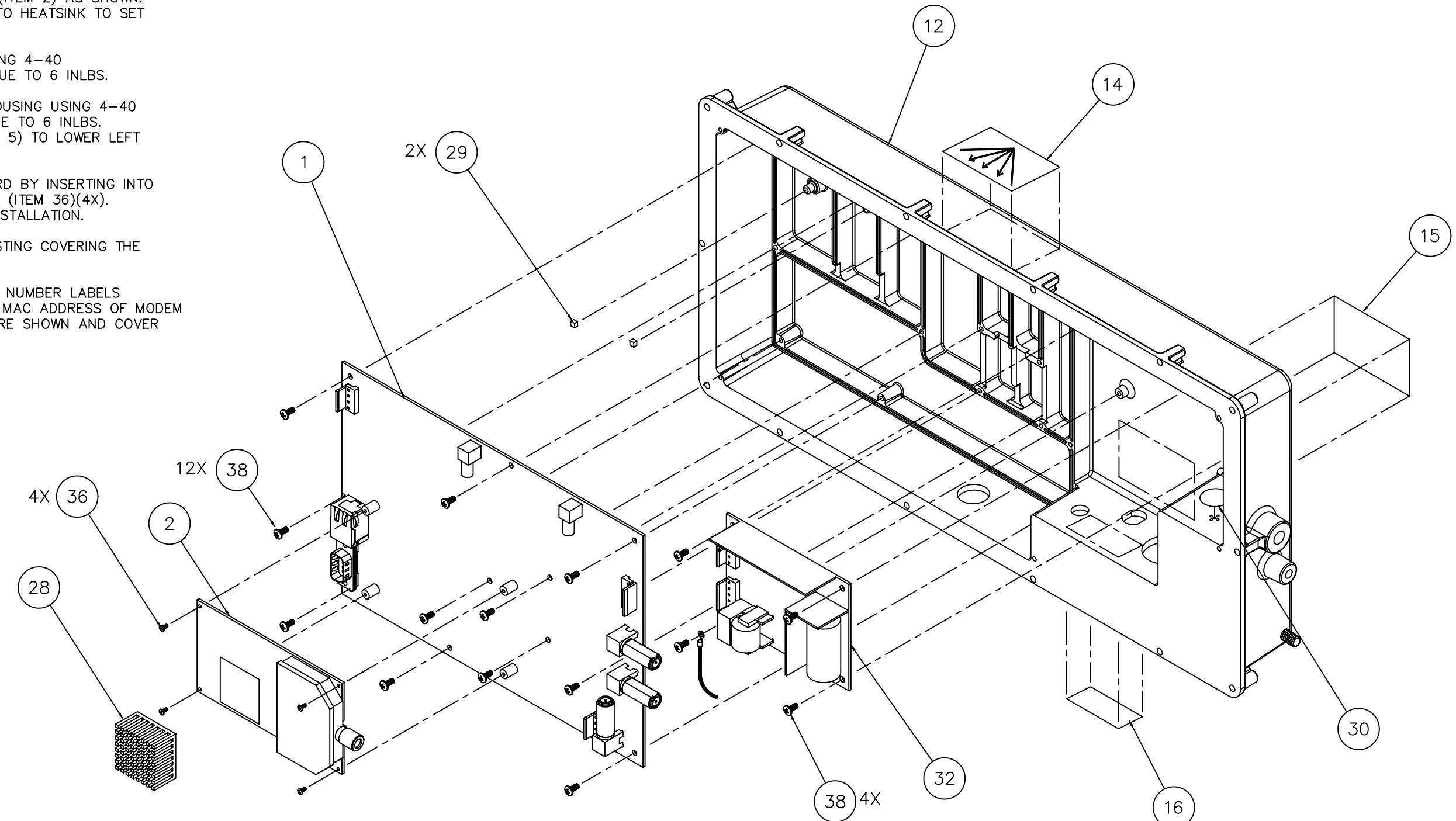
INSTALL AX501 BOARD (ITEM 1) TO HOUSING USING 4-40 THREAD ROLLING SCREWS (ITEM 38)(12X). TORQUE TO 6 INLBS

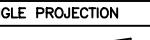
INSTALL POWER SUPPLY BOARD (ITEM 32) TO HOUSING USING 4-40 THREAD ROLLING SCREWS (ITEM 38)(4X). TORQUE TO 6 INLBS. ATTACH GROUND LUG OF ETHERNET CABLE (ITEM 5) TO LOWER LEFT MOUNTING SCREW AT THIS TIME.

INSTALL MODEM BOARD (ITEM 2) TO AX501 BOARD BY INSERTING INTO 50 PIN CONNECTOR, SECURE WITH 2-56 SCREWS (ITEM 36)(4X). APPLY LOCTITE TO SCREW THREADS PRIOR TO INSTALLATION.

INSTALL MEMBRANE VENT (ITEM 30) TO HUB CASTING COVERING THE 5 VENT HOLE PATTERN AS SHOWN.

INSTALL ANTENNA ORIENTATION AND FCC/SERIAL NUMBER LABELS (ITEMS 14 AND 15) AS SHOWN. MAKE NOTE OF MAC ADDRESS OF MODEM AND MAKE LABEL, APPLY TO BOTTOM EDGE WHERE SHOWN AND COVER WITH CHRYSTAL LABEL (ITEM 16).



3RD ANGLE PROJECTION			ITEM NO.	ZONE	MATERIAL/SPECIFICATION	NOMENCLATURE OR DESCRIPTION		PART OR IDENTIFICATION NUMBER	QTY REQD	
			LIST OF MATERIAL OR PARTS LISTS							
 			MATERIAL:	SPECIFICATIONS: ALL DIMENSIONS ARE IN MILLIMETERS. DIMENSIONS IN [XXX] ARE IN INCHES.				 ARROWWAVE <i>THE STANDARD OF EXCELLENCE</i>		
TOLERANCES: ANGLES: $\pm 1^\circ$.X: ± 1.5 [X: $\pm .06$] .X: ± 0.5 [XX: $\pm .020$] .XX: ± 0.15 [XXX: $\pm .005$]										
			FINISH:	ALL SURFACES 63° EXCEPT AS NOTED				ASSEMBLY DRAWING S3 HUB		
				DRAWN: LAC DATE: 12/7/05						
				CHECKED: DATE:						
				ENGINEER: DATE: MFG: DATE: Q.A: DATE:						
			DO NOT SCALE	SIZE		CLASS CODE		DRAWING NUMBER		
DASH NO.	NEXT ASSY	USED ON		D					931-16551-001	2
APPLICATION				SCALE: 1/1		FILE: 931-16551-001_P1		SHEET 1 OF 5		
PROPRIETARY INFORMATION THE INFORMATION CONTAINED HEREIN IS TO BE USED FOR BIDDING/MANUFACTURING PURPOSES TO THE RECIPIENT ONLY. IT SHALL NOT BE DISCLOSED OR DIVULGED TO ANY THIRD PARTY WITHOUT THE PRIOR WRITTEN CONSENT OF ARROWAVE INC.										