

Purchasing Specification Template for Electro Mechanical Assemblies - Boeblingen



Revision: C

Number: A-Q2920-00491-T4

Tier: 3

Element: Purchasing Controls and Receiving
Acceptance Activity

Quality System Document

for Electro Mechanical Assembly: **453564521801**

Assembly Description: IV2-TRANS ASSY Antenna WLAN IIT 1.4

Document Number: 453564521801-Y-SPEC Revision: 2211

Notice

UNCONTROLLED IN PRINTED FORM UNLESS STAMPED IN RED

Rev.	Change Summary	Owner
1701	As issued	Stephan Walter
2211	Change to new Template	Uwe Sevecke

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1 Purpose

This document is the Purchasing Specification for the manufacture of an Electro Mechanical Assembly.

2 Scope

This is a Philips Boeblingen DMR document.

3 General Specifications

Refer to document A-Q2920-00491, “Generic PCA Requirements” for all the general requirements that apply to printed circuit assemblies.

The assembly shall comply with the IPC-A-610 Workmanship Standards, Class 2 unless specified otherwise within this document.

Refer to the optional document A-Q<MR>-00490-<BU>-<VC> “BU – Manufacturer Specific Processes” for specific agreements a Philips business unit may define with specific manufacturer (sites) if applicable.

(MR: Internal document designator; BU: Philips Business unit; VC: Vendor Code as specified in A-5971-0901-2).

Refer to CoMo document A-Q2920-00459 “EM Collaboration Model Description – Overview” for the overarching collaboration model between Philips and it’s external manufacturers.

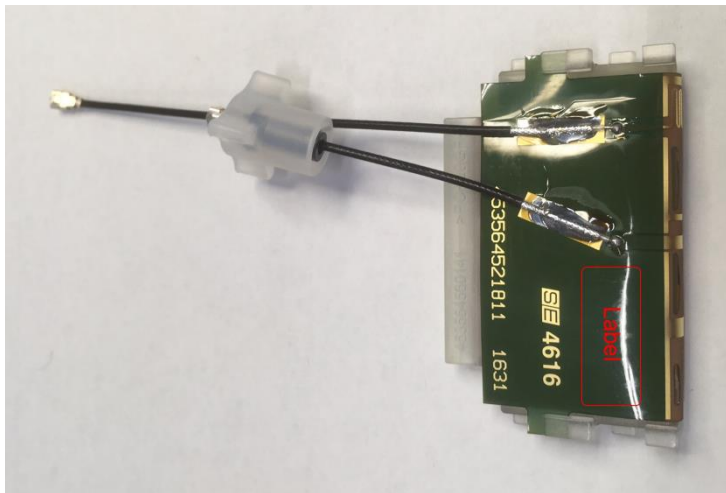
Use only components from manufacturers that are listed on the part’s Approved Manufacturer List (AML).

This part specific Purchasing Specification supersedes any generic specification.

4 Part Specifications

4.1 Labeling

- Content: each assembly must have a bar code label applied, printed in accordance to Label Specification A-5971-0901-1 and the type of raw label specified in the Bill of Material of this PCA.
- 7121-8049 LBL LABEL-BLANK 9.5 X 9.5mm or 7121-8048 LBL LABEL-BLANK 18X7.5 mm can be used
- Location: place the assembly label in the following location:



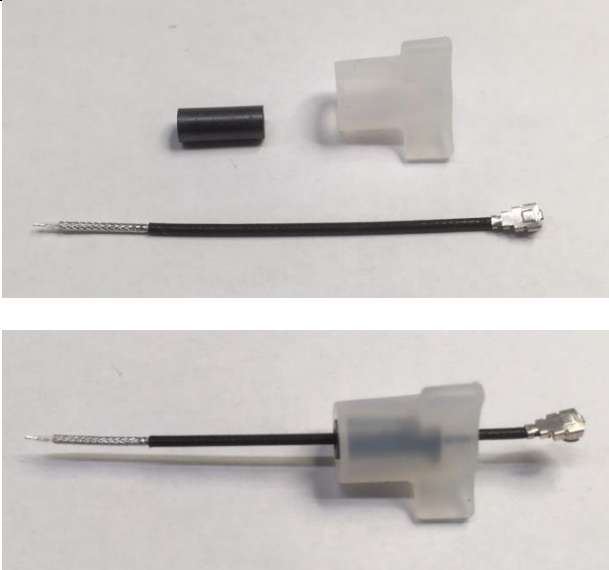

4.2 Programming, Software load

- N/A

5 Process Requirements

5.1 Mechanical requirements

LEADFREE, NO-CLEAN built and labeled

Prepare Antenna Cable		<p>Insert ferrite bead (Part No. 453564674461) into the holder (Part No 453564675481) up to the end.</p> <p>Ferrite should not drop out from the holder.</p> <p>Insert the antenna cable (Part No. 453564590411).</p> <p>Ferrite should be not cracked or chipped. No cosmetic requirements for this assembly.</p>
Soldering Antenna Cables		<p>The two antenna cables (Part No. 453564590401 and 453564590411) needs to be soldered to the flex PCB as shown on the picture. Ensure that the closed part of the connector at the end of the cable is facing upwards during soldering (exact angle is not critical).</p> <p>Note that the inner conductor of the coaxial cable has to be soldered to the small quadratic pad, while the shielding mesh is soldered to the larger rectangular pad.</p> <p>By visual inspection, ensure that there is no short circuit between the inner conductor and the shielding mesh.</p>

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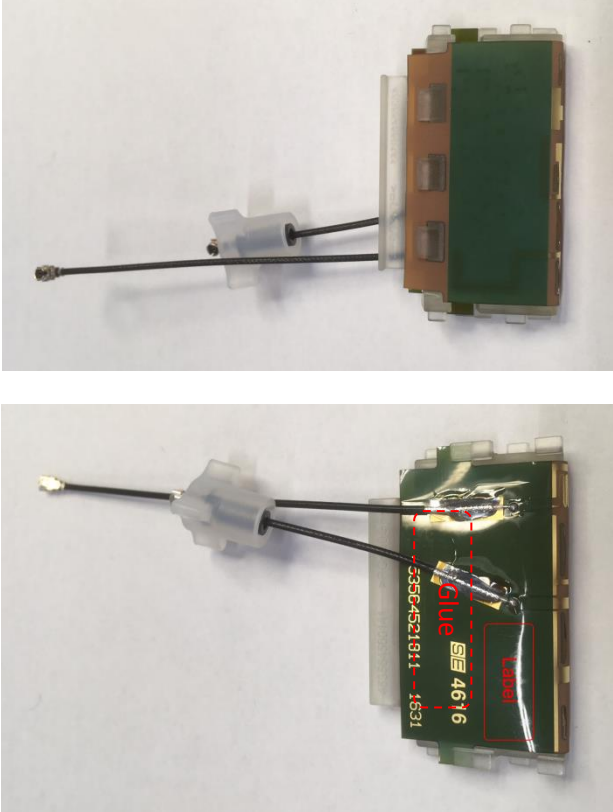
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Mechanical Assembly		<p>Wrap the flexible antenna PCB around the plastic holder. Apply glue (Momentive RTV-160 or adhesive transfer tape 3M 467MP or equivalent) between the flexible PCB and the holder.</p> <p>Flex should be not bent with 90deg in the corners.</p> <p>Keep the PCB in place until the glue is harden.</p> <p>Ensure no glue leaks out to the sides of the holder.</p> <p>Apply the label.</p> <p>Flex Board should be between side hooks of the 453564560141 IV2-TRANS PLAST Holder Antenna</p>
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5.2 Test and inspection

- Check for a proper fit of the parts
- Check for mechanical damage of any parts
- Check for completeness of all parts

5.3 ESD requirements

Assemblies shall be manufactured and shipped according to ESD standards defined in the CoMo documents applicable for their critical subcomponents (e.g. Generic PCA Requirements A-Q2920-00491 chapter "Packaging and Shipment").

5.4 Packaging and Shipping Standard

- Manufacturer defines appropriate packaging according to its internal quality system procedures. Packaging must fulfill ESD and stability requirements.
- Regarding shipping labeling specification refer to the respective CoMo documents (e.g. Generic PCA Requirements A-Q2920-00491 chapter "Packaging and Shipment").

5.5 Assembling requirements

- N/A

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5.6 Other requirements

- N/A

6 Document Information

Records This document does not result in any records.

Components This document contains no additional components in DMS.

Template This document was based on template A-Q2920-00491-T4 revision B.