



406390A-00500

Sailor 6390 Navtex Receiver

406390A

Navtex Receiver

Assembly Instruction

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REVISION HISTORY

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1. Overview

This instruction describes in pictures and words, how to assemble Sailor 6390 Navtex Receiver.

2. Tooling list

#T1: El-screwdriver 0.8 Nm \pm 0.1Nm. Torx 10 and 20. Rotational speed: 600 \pm 50 rpm.
#T2: El-screwdriver 1.15 Nm \pm 0.1Nm. Special nut tool for TNC connector.

3. Extra materials

#M1: Type label part no. 48-124727.

4. Enclose

#E1:

5. Reference documents

#R1: Test Instruction, Navtex Unit Test part no. 96-139310.

6. General guidelines

Assembly must take place in an antistatic environment. All soldering irons must be connected to earth (GND) and persons handling PCBs and components must use antistatic bracelets or similar protection.

All assembly has to follow the standard IPC-A-610D.

Important:

This instruction is the basis for all local instructions. All pictures and illustrations must be reproduced in colours to show the details.

7. Navtex receiver assembly.

7.1. Assembly of Navtex chassis.

Place Navtex Main Unit part no. 60-135754 on Chassis for Navtex Receiver part no. 41-136668.

Make sure the two chassis guide pins are aligned with the two main unit holes.

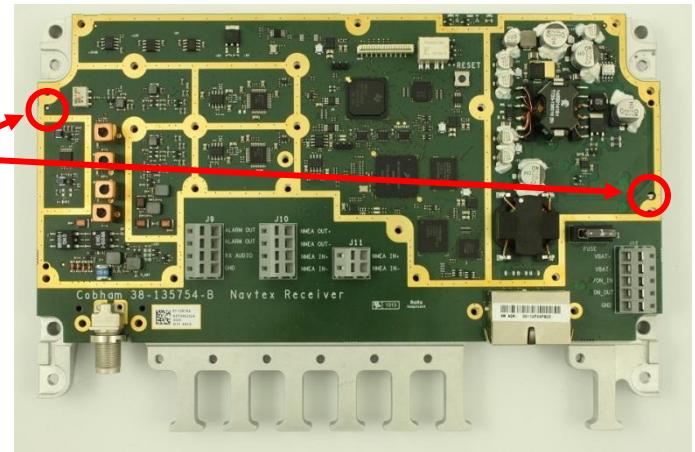


Figure 1

Mount 3 x screw part no. 51-205390-308 to fixate main unit on the chassis.

#T1: El-screwdriver 0.8 Nm \pm 0.1 Nm Torx 10.
Rotational speed: 600 \pm 50 rpm.

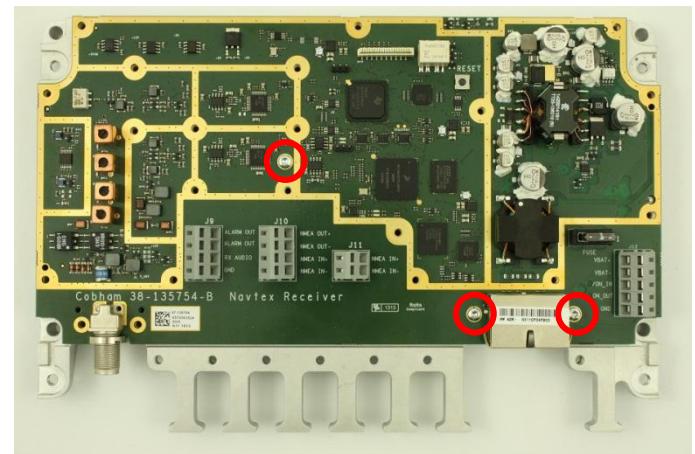


Figure 2

Place Connector Base part no. 41-136674 on TNC connector J6.

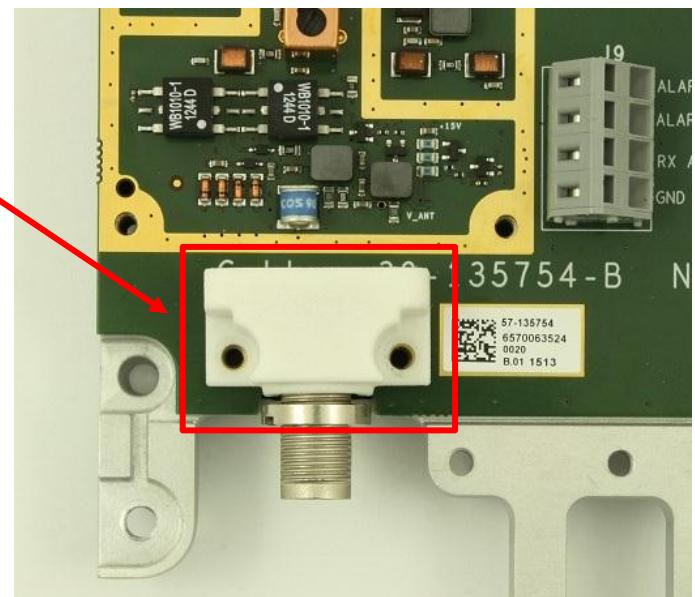


Figure 3

Fixate the connector base with 2 x screw part no. 51-205390-308.

Make sure the connector base still is loose after applying the two screws.

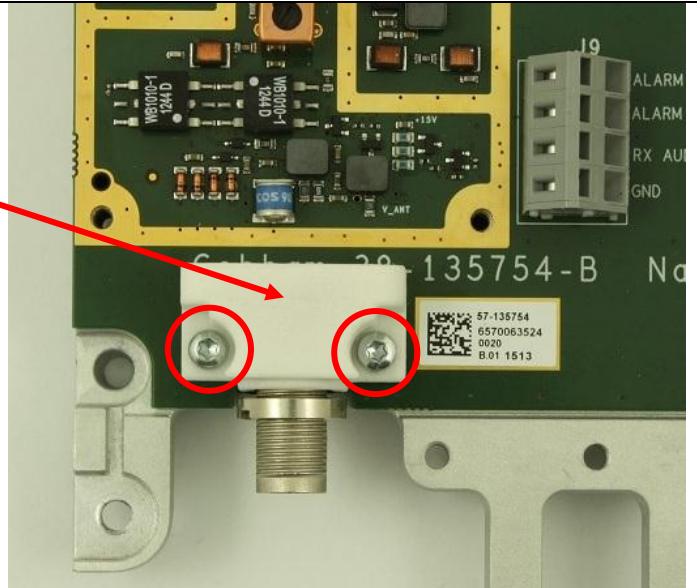


Figure 4

Tighten TNC connector nut.

#T2: EI-screwdriver 1.15 Nm \pm 0.1 Nm. Special nut tool for TNC connector.

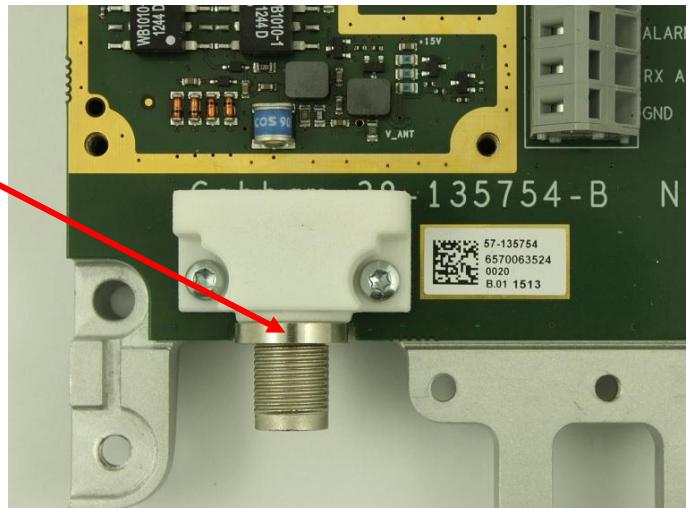


Figure 5

Tighten the two screws.

#T1: El-screwdriver 0.8 Nm \pm 0.1 Nm Torx 10.
Rotational speed: 600 \pm 50 rpm.

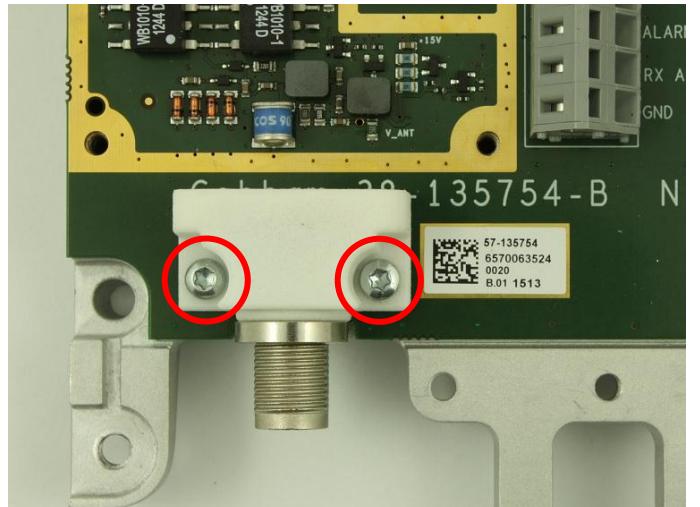


Figure 6

7.2. Shield assembly.

Place Shield for Navtex part no. 41-136670 on Navtex main unit.

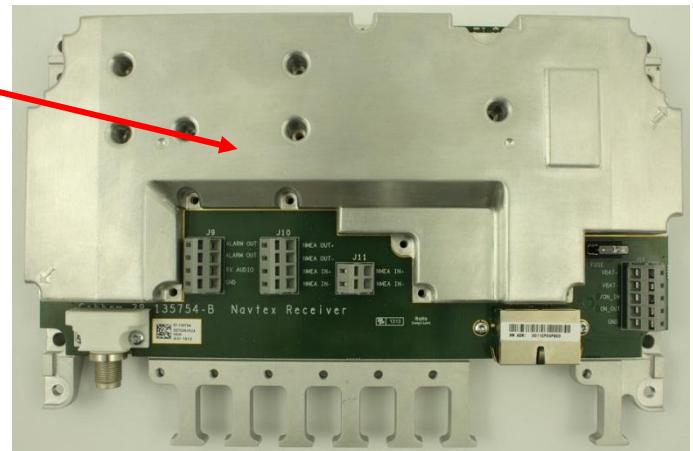


Figure 7

Mount 2 x screw part no. 51-205390-308 to fixate shield on the chassis.

Make sure the shield is still loose after applying the screws.

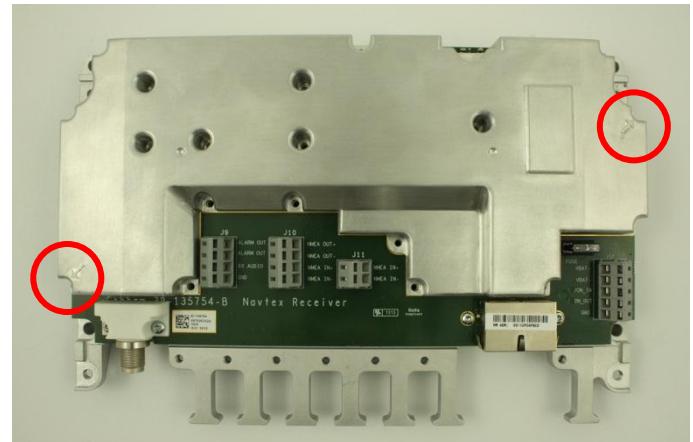


Figure 8

Mount 17 x screw part no. 51-205390-308 on the shield.

Make sure to follow the order, starting with screw marked as number 1.

#T1: El-screwdriver 0.8 Nm \pm 0.1 Nm Torx 10.
Rotational speed: 600 \pm 50 rpm.

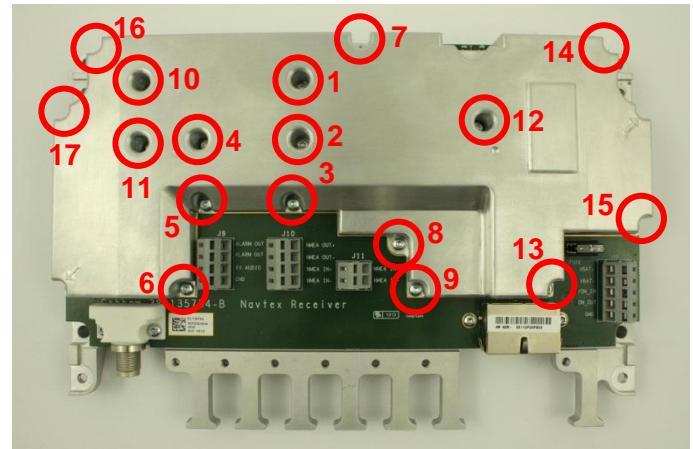


Figure 9

7.3. Mounting of ground screws.

Place Washer Serrated Lock part no. 53-200166-004 on Screw part no. 51-205286-408.

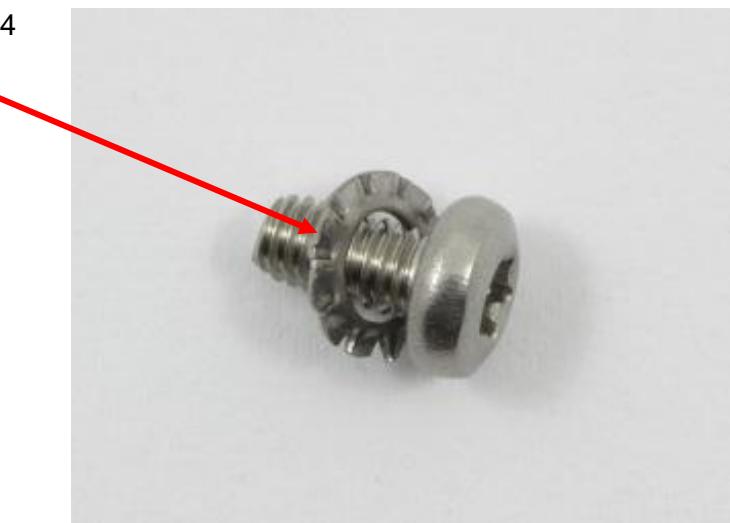


Figure 10

Place Washer part no. 53-206184-004 on Screw part no. 51-205286-408.

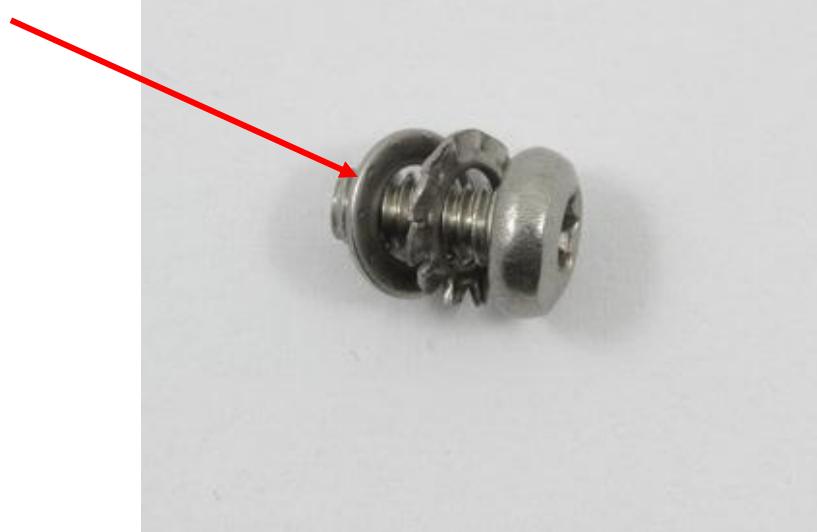


Figure 11

Mount 4 x Screws with washers from above on chassis for navtex.

#T1: El-screwdriver 0.8 Nm \pm 0.1 Nm Torx 20.
Rotational speed: 600 \pm 50 rpm.

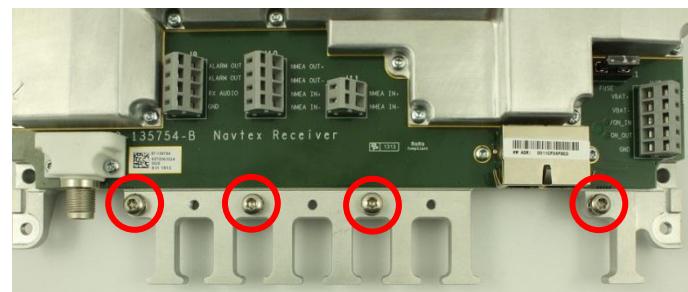


Figure 12

7.4. Navtex Unit Test.

The Navtex receiver is now ready for unit test.

#R1: Test Instruction, Navtex Unit Test part no. 96-139310.

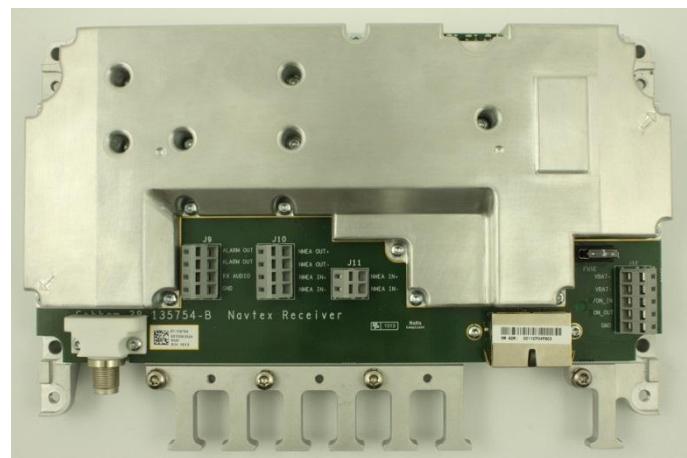


Figure 13

7.5. Cover assembly.

Place Light Guide part no. 41-135847 in Cover For Navtex Receiver part no. 87-136721.

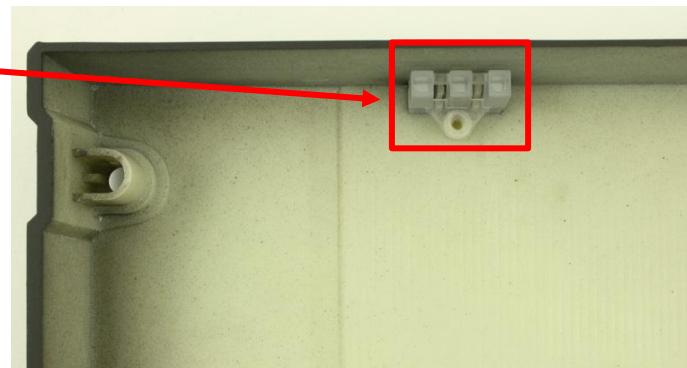


Figure 14

Mount light guide with Screw part no. 51-204304-038.

#T1: EI-screwdriver 0.8 Nm \pm 0.1 Nm Torx 10.
Rotational speed: 600 \pm 50 rpm.

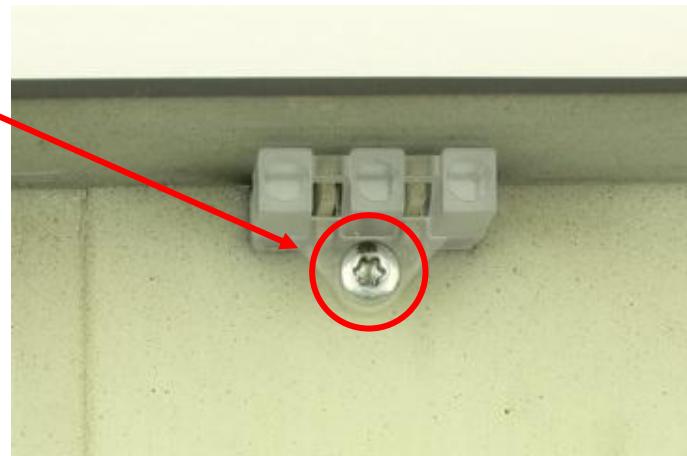


Figure 15

Place Screw part no. 51-207120-525 in cover for Navtex receiver.

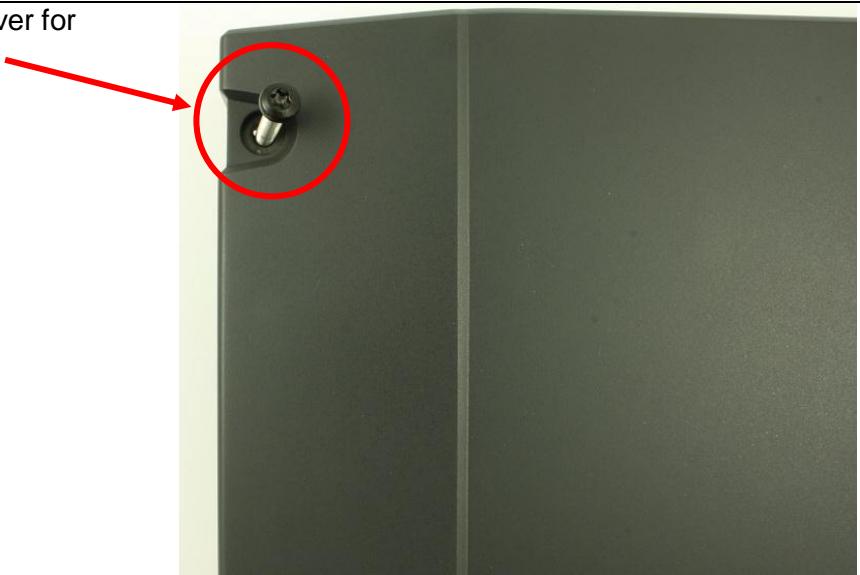


Figure 16

Flip the cover for Navtex receiver while still holding the screw in place and then mount O-ring part no. 45-207099-415 on the screw threads.

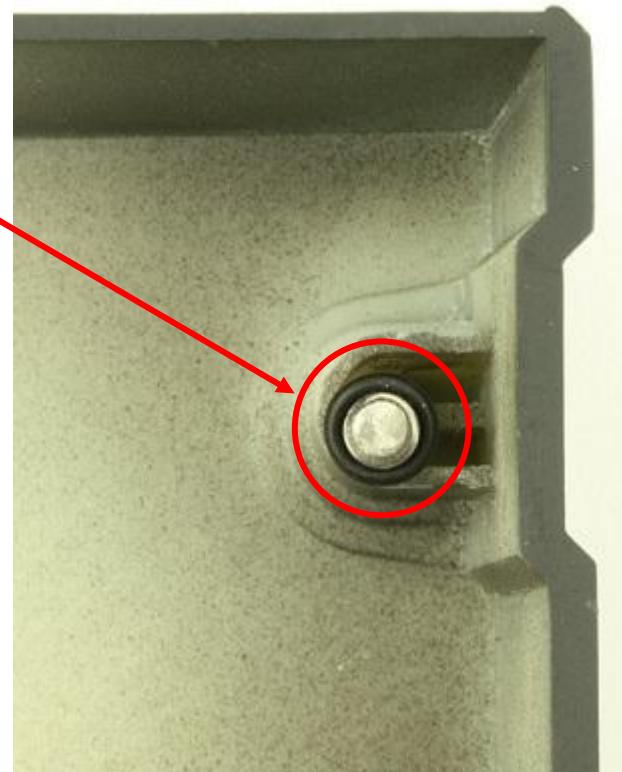


Figure 17

Place 3 x screws and o-rings like above in cover for Navtex receiver.



Figure 18

Place and center Cover For Navtex with screws and o-rings from above on the chassis for Navtex receiver. Tighten the four screws.

#T1: El-screwdriver 0.8 Nm \pm 0.1 Nm Torx 20.
Rotational speed: 600 \pm 50 rpm.



Figure 19

7.6. Place type label.

Place Type label with layout part no. 99-137283 on Navtex receiver.

#M1: Type label part no. 48-124727.



Figure 20

7.7. Further handling.

The Navtex receiver is now ready for further handling.



Figure 21