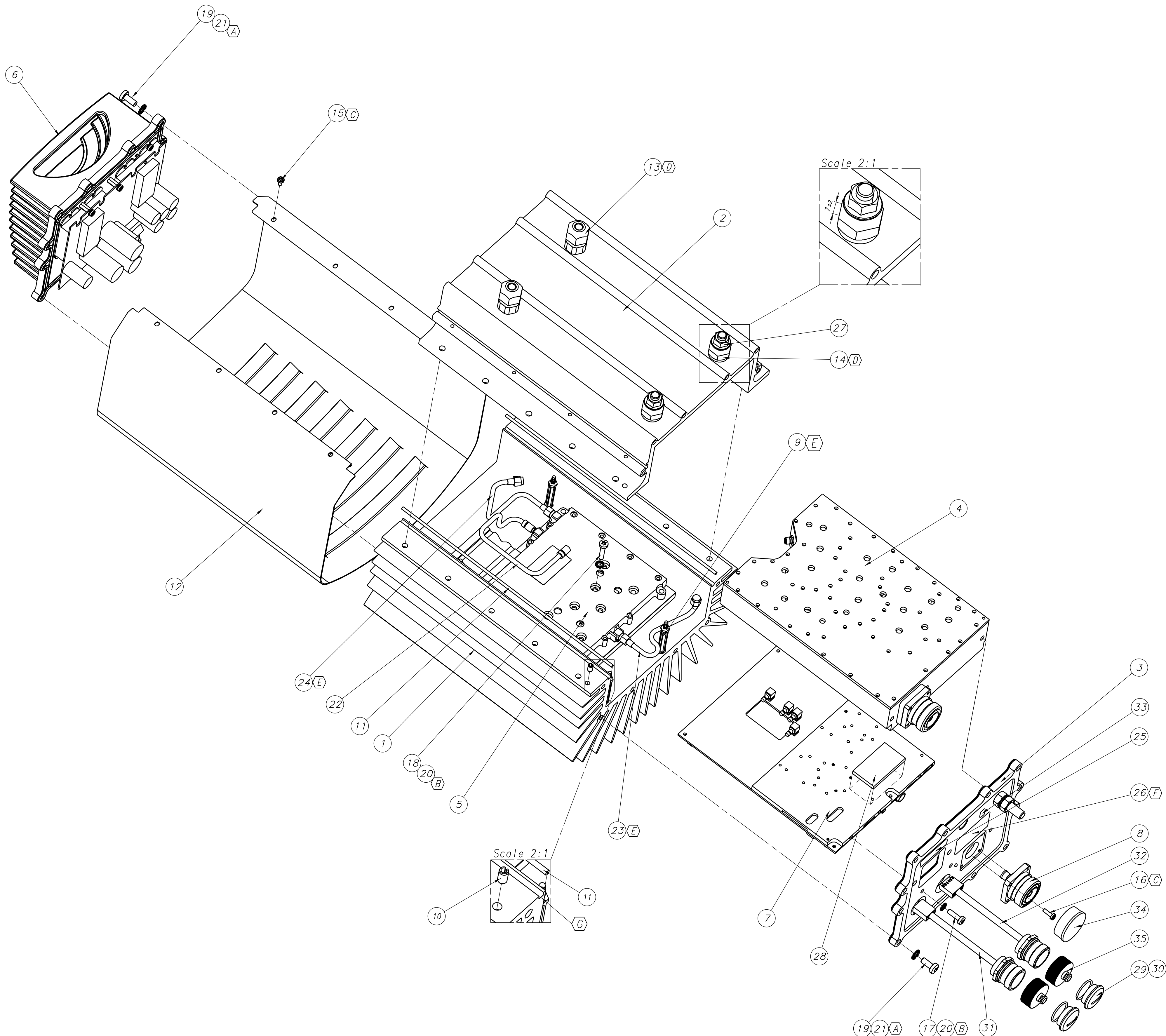


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REV	CH.O.	NUMBER	DATE	SIGN	ZONE

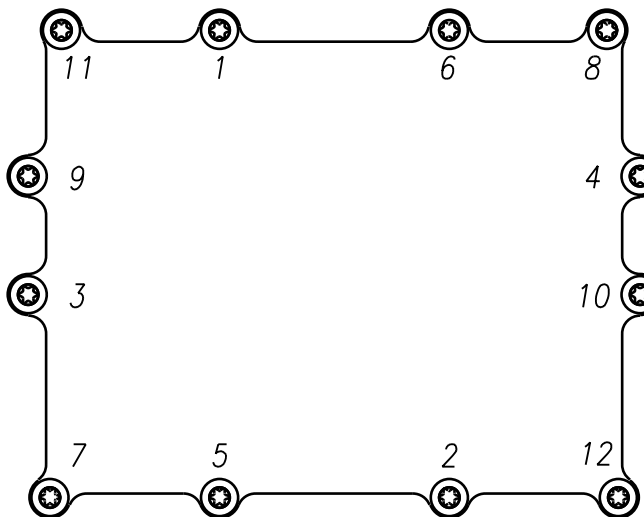
PROD NR	VERSION/PRODUCT NAME	ART.NO ASSEMBLY	POS 5 PA	POS 7 BTS	POS 4 LNF	POS 6 DC	POS 22 NUM	POS 29 NUM	POS 30 NUM	POS 31 NUM	POS 32 NUM	POS 39 NUM
9256.01	PCS 1930-1950 TX BYP, NO TTA	82559.01	82581.11	82080.62	82490.01	82085.02	1	1	1	0	1	1
9256.02	PCN 1950-1970 TX BYP, NO TTA	82559.02	82581.12	82080.62	82490.02	82085.02	1	1	1	0	1	1
9256.03	PCN 1970-1990 TX BYP, NO TTA	82559.03	82581.13	82080.62	82490.03	82085.02	1	1	1	0	1	1



Mounting sequence

For M5 screws in the bottom- and the top lid.
The first tightening sequence is 1,2,...12 T=0.3±0.2Nm
The second tightening sequence is 1,2,...12 T=5.7±0.3Nm

The same method of approach is used for the mount of the
LNF-filter block (82490) and the PA-block (82581).
Torque for first sequence, T=0.3±0.2Nm



Notes

- A T=5.7Nm, see Mounting sequence above
- B T=2.9Nm, see Mounting sequence above
- C T=1.1Nm
- D T=8Nm
Apply loctite 601
- E T=0.45Nm
- F Label text acc to TBK902 chapter 3
- G Silicone must be applied at the
T-crossings (4x) before assembly.
Use Dow Corning 3140 RTV or equivalent.

Burn-in of TTPA TBK1038

Final test of TTPA TBK1037

35	X	Contact cover M23x1	90992	See table above
34	2	Contact cover 7/16	57277	.
33	1	Lable CE	57141	.
32	X	Cable alarm TTPA	82475	See table above
31	X	Cable DC TTPA	82477	See table above
30	X	O-ring 19x1.5 EPDM	90994	See table above
29	X	Packing screw pr 20.4 PS	90993	See table above
28	1	Tape foamed plastic	90963	.
27	2	Flange lock nut	90957	.
26	1	Label	90137	.
25	1	Label	45869.1	Antenna
24	1	Cable LNF-PA	82453	.
23	1	Cable BTS-PA	82290	.
22	X	Cable by-pass	82578	See table above
21	34	Washer	90948	AZ 5.3 A4
20	14	Washer	90949	AZ 4.3 A4
19	37	Screw	90944	MRT 5x14 A4
18	11	Screw	90946	MRT 4x20 A4
17	3	Screw	90945	MRT 4x12 A4
16	4	Screw	90943	MRT 3x10 A4
15	8	Screw	90889	MRT 3x6 A4
14	2	Mounting stud threaded	82240	.
13	2	Mounting stud conical	82239	.
12	1	Sun protection cover	82230	.
11	0.5m	Gasket Oring string	90887	Length 252mm/piece
10	2	Spring pin FRP 4x8 A2	90958	.
9	4	Stacking spacer	90941	.
8	1	Connector 7/16-TNC	82276	.
7	1	BTS block	82080.XX	See table above
6	1	DC-block	82085.XX	See table above
5	1	PA block	82581.XX	See table above
4	1	LNF block	82490.XX	See table above
3	1	Bottom lid	82188	.
2	1	Housing back	82227	.

POS	NUM	NAME	MATERIAL	DIM	NOTE
1	1	Housing front	82226		
General Tolerances acc to SS-ISO 2768-1 medium					
Fundamental tolerancing principal acc to SS-ISO 8015					
Form and location tol. acc to SS-ISO 1101					
Maximum material principle acc to SS-ISO 2692					
Reference and reference system acc to SS-ISO 5459					
Scale 1:2 A1					
Drawn 990604 MIAS					
Sharp edge chamfer 0.1-0.3					
Finish					
Weight					
Checked El. Checked Mek. Surface treatment					
Acc to TBKxxx					
Title Assembly TTPA					
PCN 1900					
Page 1(1)					
Revision PA					
File					
Document number 82559					