



ACR South Africa

Production Acceptance and Test Specification

Company :	ACRSA a division of CHELTON AVIONICS (Pty) Ltd.
Document Title :	PATS: Electronics MK II Final Assembly
Document Number :	PH0200-0064-DPA
Issue :	One
Release Date :	18.07.2000
Change Note No. :	First issue
Originator :	CP Joubert
Approval (CEO) :	DR DF Frost

Applicable Documentation

Document numbers	Document titles
ISO 9001:1994	Quality Systems - Model for quality assurance in design, development, production, installation and servicing
PH0000-0053-DQM	ACRSA TelluSART Quality Plan
PH0000-0054-DQM	ACRSA TelluSART MRI
PH0200-0064-DTS	Test Results Sheet: SART Electronics Final Assembly

DISTRIBUTION LIST

<u>Copy No.</u>	<u>Holder</u>
Master	Quality Manager
One	Production Manager
Two	ACR Electronics (Florida) – information copy ✓

AMENDMENT RECORD

This document is issued under the control of the Quality Manager, ACRSA. Amendments will only be circulated to registered holders recorded on the distribution list held by the Quality Manager. Unauthorized copies of this document may not be produced. Any queries or requests for controlled copies are to be addressed in writing to the Quality Manager of ACRSA. Holders are responsible for incorporating amendments, to the manual(s) they control, immediately they receive them. After incorporation, the instruction sheet should be signed by the registered holder and returned to the Quality Manager, ACRSA, and the amendment entered below.

Amendment No.	Page Nos.	From Issue	To Issue	Date	Incorporated By
ORIGINAL adapted from Halleria PH0200-001-2	ALL	-	1	18.07.2000	CP Joubert

УДК 62-50:62-50:62-50

BU0000 0004 DBA	ACB04 B... .. A... .. T... .. B... ..	B... .. 0... ..
-----------------	---------------------------------------	-----------------

1 PART 1 : INTRODUCTION

1.1 General Description

This document identifies the Production Acceptance and Test Specification (PATS) for the TelluSART MK II Electronics Final Assembly.

The receiver sensitivity and output power specifications relate to EIRP, or Effective Isotropically Radiated Power, or the radiated power expressed in dBm over an isotropic antenna.

Figure 1 is the block diagram of the Electronic Assembly Type 3A.

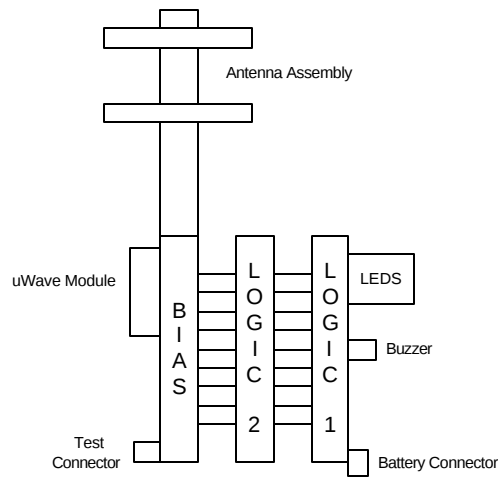


FIGURE 1: ELECTRONICS ASSEMBLY

1.1.1 List of Electronic Sub-Assemblies

PH0200-0026-AP3 : Microwave Bias Assembly

PH0200-0027-AP3 : Logic 1 Assembly

PH0200-0028-AP3 : Logic 2 Assembly

PH0200-0029-AA1 : Antenna and Bracket Assembly

1.1.2 Next Higher Assembly

PH0200-0064-AA1 : TelluSART MK II Assembly

CONFIDENTIAL

a. **Battery supply connector**

The connection to the battery assembly is via a 3-pin, R/A, PCB mount, 0.1" spacing, MOLEX connector, PL4, located on the logic 1 pcb of the logic assembly.

pin 1	0V VBAT
pin 2	RAMP (for test purposes)
pin 3	VBAT

b. **Test connector**

A vertical, PCB mount, 4 pin, 0.1" spacing, MOLEX connector, PL3, is provided on the bias PCB assembly to facilitate further test features. Refer to para 2.3.1.d for further details.

pin 1	GND2
pin 2	RX INHIBIT
pin 3	EXT TRIGGER
pin 4	RAMP VOLTAGE

1.2 Circuit Description

The circuitry for the Electronic Assembly Type 3A can be divided into three main sub-assemblies:

- Logic assembly
- Microwave bias assembly
- Antenna assembly

1.2.1 Overall Operation

When the unit is switched on, both the yellow and green LEDs flash quickly and the buzzer gives a rapid pulsed sound for about one second indicating that the unit has woken up, and the battery voltage is above 10.5 V. The unit then goes into the RECEIVE MODE, where the yellow LED flashes slowly, the green LED goes out, and the unit waits to receive a trigger pulse. In RECEIVE MODE, only the receiver section is powered, to minimize current consumption. The current consumption in this mode is approximately 40mA.

If the unit receives a single trigger pulse, the unit switches to STANDBY MODE. In this mode, current consumption increases to approximately 75mA, and the Transmitter and VCO section is enabled to reply within 500ns to the next trigger pulse received.

Any further trigger pulse received will cause the unit to switch to REPLY MODE. Again both LEDs flash quickly and the buzzer gives a rapid pulsed sound for about one second. In this mode, the unit replies to each trigger pulse by transmitting a series of 12 sawtooth shaped sweeps across the 9.2 to 9.5 GHz frequency band in a time of $\leq 100 \mu\text{s}$. After each reply is completed, the unit will return to STANDBY MODE. If the unit is repetitively triggered with a period of less than one second, then the indicators will indicate REPLY MODE continually. If no more trigger pulses are received for a period of 10s, the unit returns to the RECEIVE MODE.

1.2.2 Logic Assembly

Refer to PATS, Logic 1 and Logic 2 Assembly, PH0200-0027-DPA.

The logic assembly performs all the control functions of the SART unit and provides interfacing signals to the microwave circuitry, which is part of the microwave bias assembly. The following functions are performed:

- a. -7,5 V bias circuitry supply voltage to the microwave bias assembly.
- b. +2,5 V LNA supply voltage.
- c. +6,5 V switched supply to provide fast switch on and off of VCO and power amplifier chain of the microwave assembly.
- d. -2 V negative bias supply voltage to the microwave assembly.
- e. +8,5 V supply to provide bias to the video amplifier.
- f. Provides a DC ramp voltage (in REPLY mode) with manual adjustment of offset voltage and range, as the tuning voltage for the VCO. (Nominal voltage range of 0 V to +4 V.)
- g. Provides temperature compensation to the ramp voltage to accommodate temperature changes of the VCO.
- h. In REPLY MODE, provides control so that 12 sawtooth shaped ramps are applied to the VCO. Each ramp consists of an up ramp and a down ramp.
- i. Provides visual and audio indication of the mode in which the unit is presently operating.
- j. Provides indication of flat battery.
- k. Provides dead-time after the end of a reply pulse to prevent self-triggering.
- l. Provides drive signals to operate the TX/RX diode switch.

The logic assembly interfaces with the hybrid bias assembly via a 12-way square pin header, soldered into position on each side, i.e., at each assembly. Provision is made so that a connector can be fitted in place of the direct solder method, if the need for easier re-work is required.

1.2.3 Microwave Bias Assembly

Refer to PATS, Microwave Bias Assembly, PH0200-0026-DPA. The Microwave bias assembly provides the following functions:

- a. VCO and power amplifier to generate frequency in the range 9,14 to 9,56 GHz, at a power level ≥ 26 dBm.
- b. A receive chain consisting of limiter, LNA, and detector diode to provide DC envelope pulses of received RF pulses.
- c. A video amplifier to amplify the DC envelope pulses, and a high speed comparator to detect and latch the pulses.
- d. TX/RX diode switch to provide isolation of the transmit and receive paths from the same antenna.
- e. Microstrip to coaxial transition for antenna connection.

The antenna and bracket assembly is essentially a slotted waveguide antenna that interfaces to the Microwave bias assembly, via the coaxial transition pin. The antenna is fixed in position via the bracket and 2 studs that protrude from the bottom of the Microwave Bias Assembly.

Operating temperature range:	-20°C to +55°C
Storage temperature range:	-30°C to +65°C
Relative humidity:	Not applicable.
Operational altitude:	Not applicable.
Vibration:	MIL-STD-810D Transport vibration method 514.3.

PETP, Production Electrical Test Plan, TelluSART MK II, PH0200-0001-DPP

PATS, Logic 1 and Logic 2 Assembly, PH0200-0027-DPA

PATS, Microwave Bias Assembly, PH0200-0026-DPA

Assembly drawing, Electronics MK II Final Assembly, PH0200-0064-DM0

Burn-in Specification, TelluSART MK II, PH0200-0001-DPB

WARNING: DO NOT ALLOW EYES WITHIN 20 CENTIMETRES OF THE ANTENNA WHEN THE SART UNIT IS TRANSMITTING.

2 PART 2 : PRODUCTION ACCEPTANCE

2.1 Test Conditions

2.1.1 General

- a. All tests are to be carried out at room temperature ($+20^{\circ}\text{C} \pm 3^{\circ}\text{C}$) unless otherwise specified
- b. Personnel must heed the warning in para. 1.5
- c. The tests are to be carried out in a shielded anechoic area
- d. Test Signal Description. There are a number of stimulus signals required during the tests. These are described in Appendix A - Description of Stimulus Signals
- e. The received sensitivity and output power specifications are specified according to EIRP (refer to Appendix C).
- f. The radome referred to in the specification refers to the top section (just above the window) cut off a standard plastic housing, CASE MOULDING, Pt.No. PH0200-0069-AM0-0. This is placed over the antenna of the UUT. Refer to part 3 for test equipment number of standard test part.

2.1.2 Test Sequence

The following sequence shall be followed when performing the tests on the unit.

- a. Frequency Range Adjustment. Refer to para. 2.3.1.a (ii)
- b. Acceptance Testing.

2.2 Power Requirements

The unit requires power supplies for VBAT of 10,5 V to 16,0 V, at 1 A. The supply must be able to deliver full voltage (≤ 500 mVp-p ripple) with 100 μs current pulses of 1 A at a PRF of 1 kHz. (This can be achieved by connecting a suitable reservoir capacitor across the supply terminals.) The power supply is to have an adjustable current limit.

2.3 Performance Requirements

2.3.1 Electrical

The following specifications must be met at room temperature ($20^{\circ}\text{C} \pm 3^{\circ}\text{C}$) when the unit is triggered with Test Signal 1 (refer to Appendix A) and a supply voltage VBAT of $12\text{ V} \pm 1\text{ V}$, or unless otherwise specified.

a. Transmitted signal parameters

- i. Sweep characteristics

These measurements can only be performed with a calibrated frequency discriminator set as follows:

Number of sweeps: 12

Sweep frequency: Each sweep to cover the range:
 Bottom: 9,140 to 9,200 GHz
 Top: 9,500 to 9,560 GHz.

Forward sweep time: 7,5 μ s $\pm$ 1 μ s

Return sweep time: 400 ns $\pm$ 100 ns

ii. Transmitted frequency range

This measurement can be performed using a spectrum analyzer. The unit should be initially set up with the following frequency range:

Bottom frequency: 9,140 GHz to 9,200 GHz

Top frequency: 9,500 GHz to 9,560 GHz

The frequencies are measured at the -3 dB points relative to the average peak amplitude. Refer to Appendix B.

NOTE: This adjustment is to be performed at an ambient temperature of 20°C $\pm$ 3°C.

iii. Output power

The output power specification relates to the average pulse power (averaged over the pulse width) expressed in terms of EIRP, transmitted by the UUT, on the horizontal plane, centrally between the two discs of the UUT antenna.

Average pulse power: > 26 dBm (with radome)

iv. Antenna characteristics

Polar average pulse power variation:

≤ 4.0 dB $\pm$ 0.1 dB calculated from the (maximum - minimum) power levels recorded through a rotation of 360°.

b. **Received signal parameters**

i. Sensitivity

The receiver sensitivity is defined as that RF power (EIRP) at the UUT antenna (when interrogated with Test Signal 1, Appendix A), that causes the average UUT transmission to drop to 75% of the value at the 100% reply rate, using an averaging time constant of 0,755 – 0,255 s.

The sensitivity specification relates to power received on the horizontal plane, centrally between the two discs, of the UUT antenna. The measurement is to be done at the position of lowest sensitivity found through a rotation of the UUT through 360°.

Specification:

9,200 GHz $\pm$ 0,005 GHz
 - 51,5 dBm $\pm$ 1,5 dBm with radome

9,350 GHz $\pm$ 0,005 GHz
 - 51,5 dBm $\pm$ 1,5 dBm with radome

9,500 GHz $\pm$ 0,005 GHz
 - 51,5 dBm $\pm$ 1,5 dBm with radome

CONFIDENTIAL

- d. **Operation of the test connector**

- i. Inhibit triggering of the unit via the receiver

- ii. Allow external triggering of the unit, using a dc trigger pulse.

The external pulse should have the following specifications:

PW: 500 ns to 1 μ s

- iii. These features are most likely to be of use during burn-in, where the units need to be exercised, but the triggering of one SART by another is to be prevented.

- ### 2.3.2 Mechanical

2.3.3 Interchangeability

2.3.4 Installation

The Electronics MK II Final Assembly to be tested requires a test housing in which it is inserted before testing. This housing provides mechanical support and also allows easy access to the various trimpots that need to be adjusted. This practice also allows direct follow through with burn-in (when required), as the burn-in is performed with the assembly NOT assembled into the housing.

CONFIDENTIAL AND UNCLASSIFIED

CONFIDENTIAL AND UNCLASSIFIED

UNIVERSITÄT ZÜRICH

UNIVERSITÄT ZÜRICH

UNIVERSITÄT ZÜRICH

UNIVERSITÄT ZÜRICH

- CONFIDENTIAL AND PROPRIETARY



CONFIDENTIAL AND UNCLASSIFIED

- CONFIDENTIAL AND UNCLASSIFIED

CONFIDENTIAL AND PROPRIETARY

- UNIVERSITÄT ZÜRICH

UNIVERSITÄT ZÜRICH

3.3 Production Acceptance Test Procedures

3.3.1 Supply Current Test

1. Monitor the current in the supply leads to the UUT.
2. Switch the unit on with NO trigger pulses.
3. Adjust RV on Microwave Bias Assembly to set $I_{\text{receive}} = 40 \text{ mA} \pm 2 \text{ mA}$
4. Record the average supply current I_{receive} on the test result sheet.
5. Interrogate the unit with test signal 1.
6. Switch off the test signal. Record the average supply current I_{standby} within 5 secs on the test result sheet.
7. Interrogate the unit with test signal 1.
8. Record the average power supply current I_{reply} on the test result sheet.

3.3.2 Transmit Power Measurement

1. Switch the interrogation signal on ($f = 9,350 \text{ HGz}$)
2. Measure the output power on the power meter and record the result on the test result sheet.
3. Rotate the UUT through $+ 90 \text{ deg}$. Measure the output power on the power meter and record the result on the test result sheet.
4. Rotate the UUT through $+ 180 \text{ deg}$. Measure the output power on the power meter and record the result on the test result sheet.
5. Rotate the UUT through $+ 270 \text{ deg}$. Measure the output power on the power meter and record the result on the test result sheet.
6. Rotate the unit back to 0 degrees.

3.3.3 Receive Sensitivity Measurement

1. Set the interrogator frequency to 9,350 GHz.
2. Reduce the interrogation signal strength until the reply rate begins to drop. This is observed by a sudden drop of 0,2 dB or more in the reading on the power meter and by the onset of the "breaking up" of the spectrum observed on the spectrum analyser.
3. Note the output signal level (S_{meas}) of the RF generator.
4. Calculate the actual sensitivity as follows:

$$S_{\text{actual}} = S_{\text{meas}} - P_{\text{cable}} - P_{\text{path}}$$

$$= S_{\text{meas}} - 3 \text{ dB (approx.)} - 50 \text{ dB (approx.)}$$

$$= S_{\text{meas}} - 53 \text{ dB (approx.)}$$
5. Record the actual sensitivity on the result sheet.
6. Set the RF signal generator to 9,200 GHz and repeat the sensitivity measurement and calculation and record the result on the result sheet.

The following is the recommended method for performing frequency range measurement using a spectrum analyser (Hewlett Packard HP8569A):

Centre frequency:	9,35 GHz
Span:	2 GHz (750 MHz)
Resolution BW:	2 MHz
Video BW:	2 MHz
Sweep time:	1 second
Amplitude scale:	5 dB/DIV

Measure the bottom and top frequencies at the -3 dB point. Using the display line in the TRACES menu does this. Set the display line to run through the approximate average value of the top of the signal. Bring the display line down by 3 dB using the step down button. Use the marker to determine the frequency at which the display line cuts the signal at the bottom and top points.

CONFIDENTIAL

The formula for such a calculation is as follows:

Frequency = f [GHz], Path Loss = P_{loss} [dB],

For power measurement, take the frequency as being the average frequency, which is $f = 9.35$ GHz. For sensitivity measurements the path loss can be calculated for each of the three frequencies 9.20, 9.35, 9.50 GHz. The table below shows the path loss at 1.0 m for frequencies of 9.20, 9.35, 9.50 GHz.

f [GHz]	L _{meas} [m]	P _{loss} [dB]
9,2	0,8	-49,77
9,35	0,8	-49,92
9,50	0,8	-50,05

It gives the equivalent power transmitted or received by a system if it had a perfect isotropic antenna with gain 0 dB.

CONCLUSIONS AND FUTURE RESEARCH

STEP 1. To determine the available RF power levels at the RF source output.

Set the signal source attenuators to 0.

On the HP Modulator (HP 11720) disconnect the TTL input and select COMPL on the MODE Switch. (This enables the modulator to pass a CW signal unhindered)

Connect the Power Probe of the HP Power Meter (HP 437B) directly to the OUTPUT of the Modulator. (TP1). Ensure that the Power Meter is calibrated for CW mode and zero offset. Terminate the unused output of the 3dB splitter to 50 ohm.

Record the RF power levels at the three available frequencies, 9,2 GHz, 9,35 GHz, and 9,5 GHz on the **Calibration Result Sheet**. Typical values are -10dBm to -12dBm.

STEP 2. To determine the RF power at the input to the Transmit Antenna (+15dB Horn Antenna)

Disconnect the cable to the antenna (TP2).

Connect the Power Meter probe (still calibrated for CW mode) at TP2 and record the RF power levels at the three test frequencies, 9,2; 9,35; 9,5GHz.

STEP 3. Determine the cable loss from Modulator to Antenna (TP1 to TP2)

Calculate the cable loss at each frequency by determining the difference between the RF power available at the modulator output port (Step 1) and the RF power available at the antenna (Step 2).

Record these values of cable loss. Typical value: -3 dBm.

STEP 4. Power Level at Power Sensor

Connect the poer sensor to TP3 (normal position). Connect the antenna cable TP2 to the modulator output. Measure the available power at the power sensor and record the result on the test results sheet.

STEP 5. Cable loss from Antenna to Power Meter (TP2 to TP3)

Calculate the cable loss from the modulator to the power sensor (TP2 to TP3) by determining the difference between the power output of the modulator (Step 1) and the power at the power sensor (Step 4). The typical value is approximately 9 dB. As the power meter averages the reading across the frequency band, use the values at 9.35 GHz.

STEP 6. Setup the Power Meter for pulsed RF measurement, and taking into account the signal loss due to a finite transmission path (air and cable)

The duty cycle is determined by the on / off ratio of the transmitted RF. In this instance it is 9.45%

Air loss over 0,8m (– 49,9 dB) + antenna gain (+ 15dB) + cable loss (eq. – 8,5 dB)

Offsett : $-49,9 \text{ dB} + 15 \text{ dB} - 8,5 \text{ dB} = -43,4 \text{ dB}$

Setup for Power meter for pulsed RF and transmission loss:

DUTY CYCLE = 9,45%
OFFSETT = 43,4 dB

Note: Signal loss through air is determined by

$$P_{\text{loss}} = 20 \log_{10} (\quad / (4 \quad L_{\text{meas}})) \text{ dB}$$

Where $\lambda = (0,3\text{m}) / f \text{ (GHz)}$

By knowing the value of the transmitted RF power at the antenna (Horn) output, it is easy to determine what the value is of the RF power that is received by the SART antenna. This received RF at the SART antenna may be altered by introducing more or less attenuation in the RF transmit path. The amount of attenuation that is introduced above that which is necessary to set the received RF level to the -50 dBm threshold gives the margin that the receiver is better than the -50 dB threshold that is specified.

	CALIBRATION RESULTS SHEET				
	CalibrationSteps	Unit	Frequency (GHz)		
			9,2	9,35	9,5
Step 1	RF Power available at Modulator output (TP1)	dBm			
Step 2	RF Power level at 15dB Horn Antenna input port (TP2)	dBm			
Step 3	Cable Loss : TP1 to TP2 (TP2 – TP1)	dB			
Step 4	RF Power level at Power Meter (TP3)	dBm			
Step 5	Cable Loss : TP2 to TP3 (TP3 – TP1)	dB			