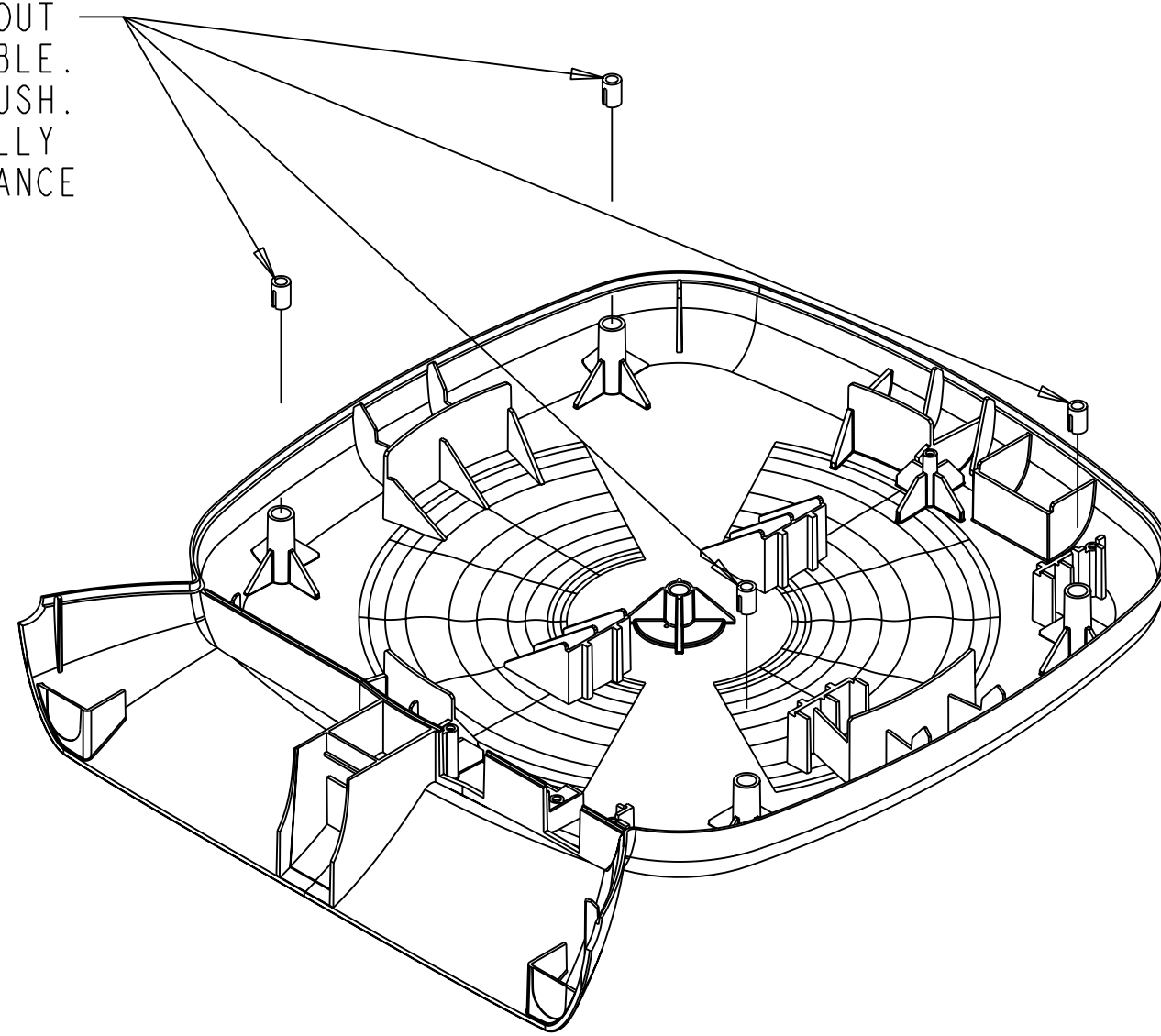


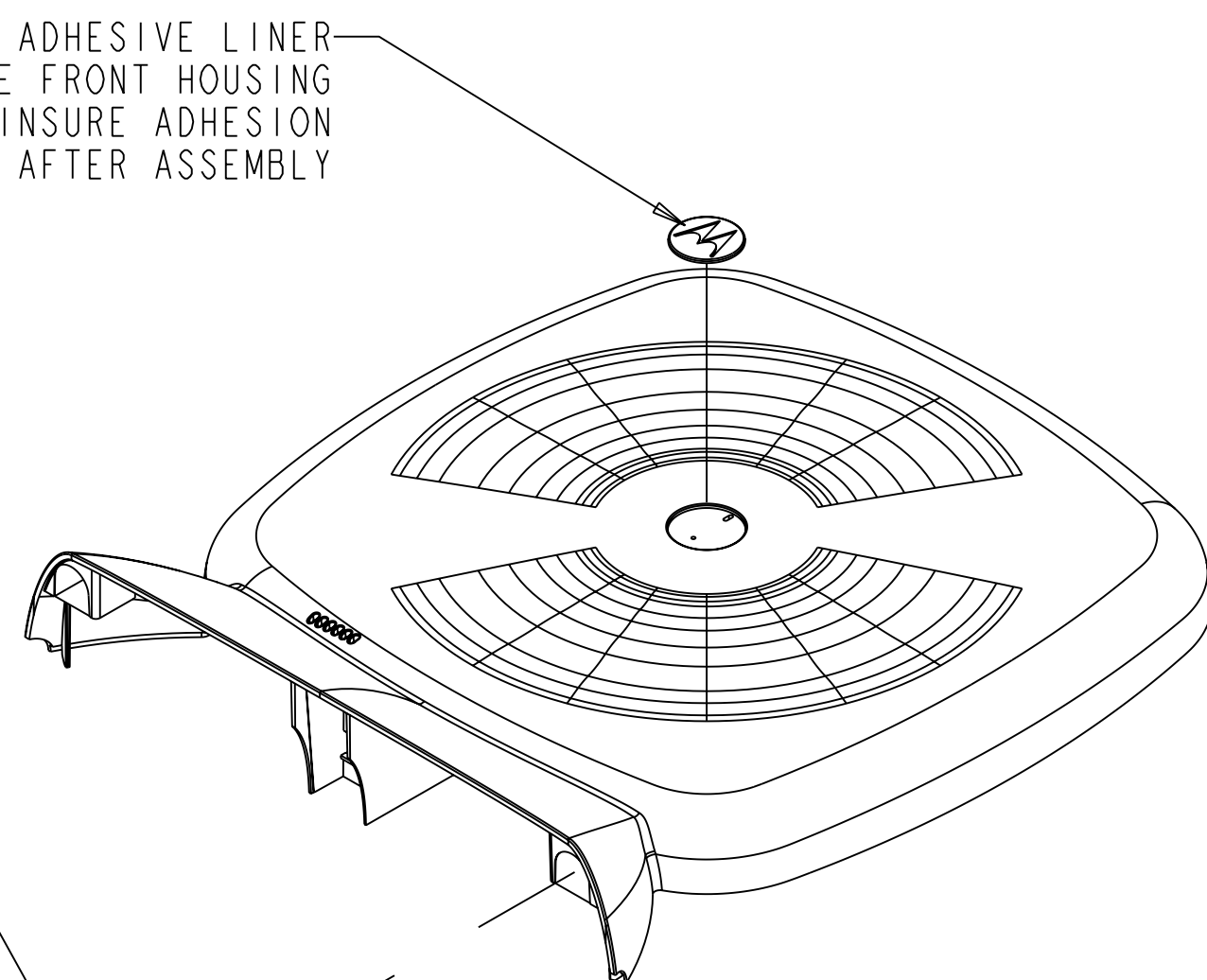
STEP 1

M4 INSERTS (4X) ULTRASONIC WELDED INTO BOSSES WITH MIN PULLOUT
FORCE OF 8 KG. DEFORMATION OF BOSS SHAPE IS UNACCEPTABLE.
INSERTS MUST BE FLUSH TO 0.25 MM SUB-FLUSH.
AFTER INSERTATION AN M4 SCREW MUST THREAD FULLY
WITHOUT RESISTANCE



STEP 3

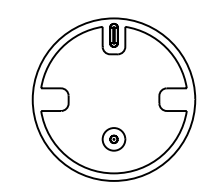
PEEL OFF ADHESIVE LINER
ALIGN POSTS ON MEDALLION TO THE HOLES IN THE FRONT HOUSING
FIRMLY PRESS LOGO TO INSURE ADHESION
LOGO MUST BE FLUSH TO SUB-FLUSH AFTER ASSEMBLY



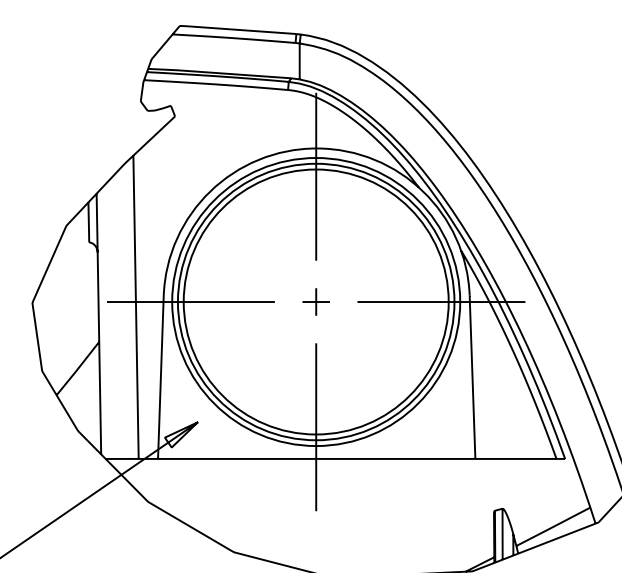
ALIGN BUMPER TO CENTER OF CUTOUT AREA (SEE DETAIL A)
FIRMLY PRESS DOWN FEET TO INSURE ADHESION



RUBBER BUMPER SHALL BE COMPLETELY INSIDE CUTOUT



BACKSIDE VIEW OF LOGO
SCALE 1.000



DETAIL A
SCALE 3.000

ITEM #	MOTOROLA P/N	DESCRIPTION	QTY.
--	0114704B01	ASSY, FRONT HOUSING	1
1	1588998D01	HOUSING, FRONT	1
2	6189010D01	LIGHT GUIDE, 900 INDOOR	1
3	1389011D01	MEDALLION, M LOGO	1
4	4389954D01	THREADED INSERT, STAKED M4	4
5	7589955D01	BUMPER, RUBBER, 12.7mm X 1.5 mm HIGH	2
6	0389970D01	SCREW, DELTA PT 25 x 8 mm	1

0114704B01	ASSY. FRONT HOUSING	ACTIVE	C114
MOTOROLA P/N	DESCRIPTION	P/N STATUS	PRODUCT ID

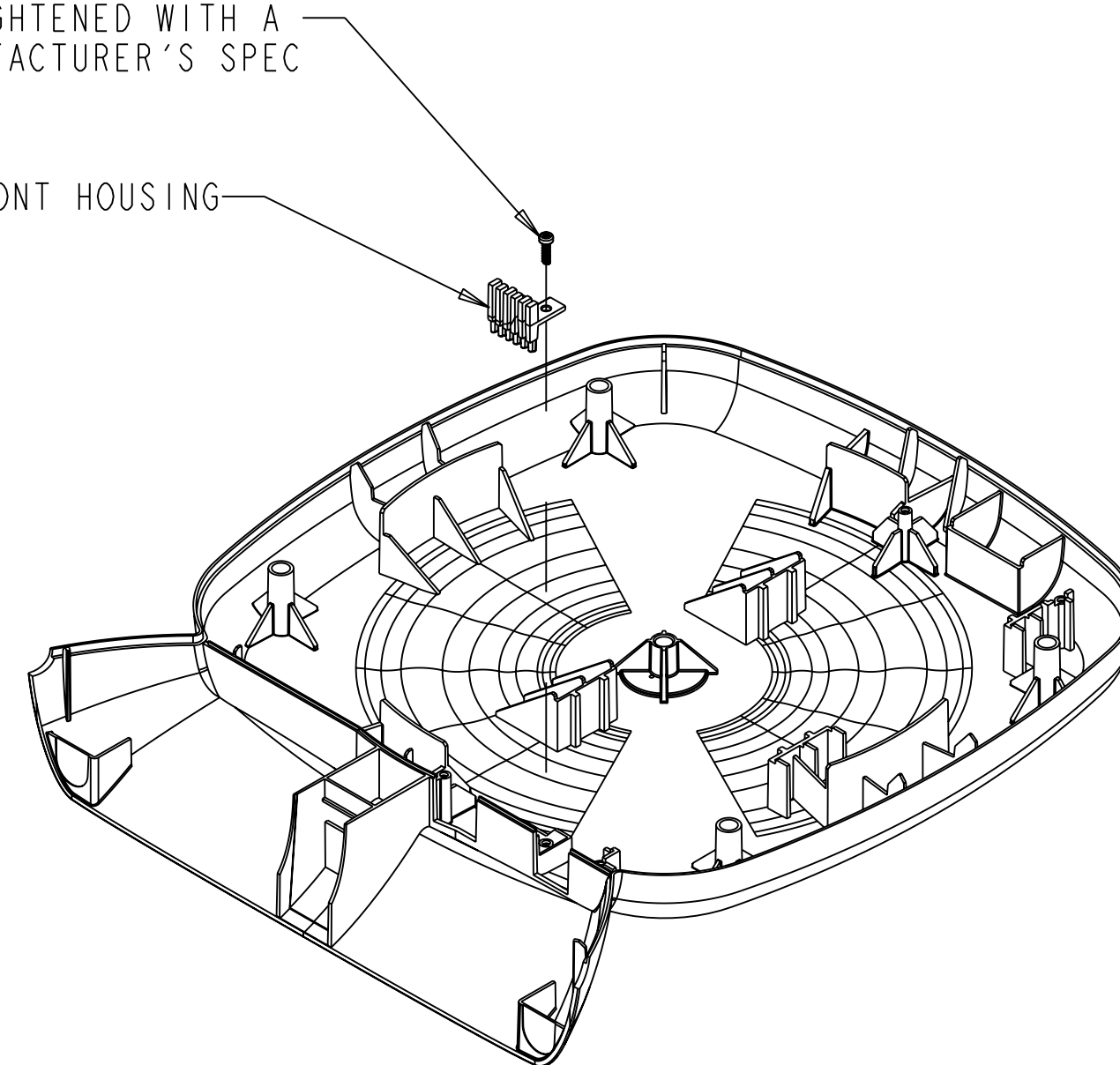
TABLE 1: MODEL INFORMATION

TABLE 1: MODEL INFORMATION

STEP 2

M2 THREAD FORMING SCREW, TIGHTENED WITH A
TORQUE VALUE PER MANUFACTURER'S SPEC

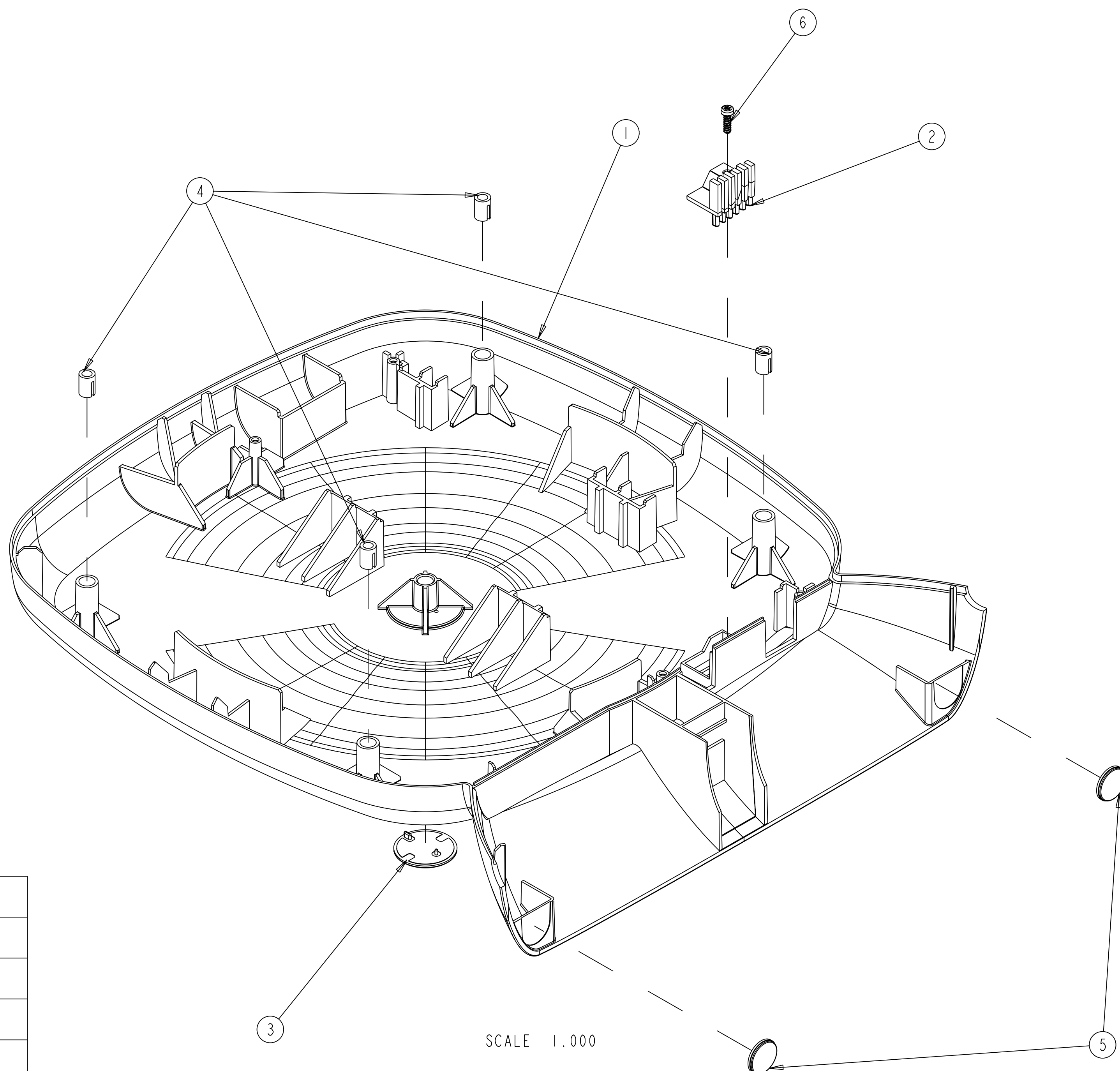
INSERT LIGHT GUIDE INTO SLOT AT BOTTOM OF FRONT HOUSING





NOTES:

- I. DESCRIPTION 3 APPLICATION
A. TOP LEVEL PCB ASSEMBLY FOR USE IN CANOPY WIRELESS SYSTEMS OVER A TEMPERATURE RANGE OF -40C TO +85C IN AN INDOOR / OUTDOOR ENVIRONMENT.
- II. APPLICABLE DOCUMENTS
A. 12G02897W18 CONTROLLED AND REPORTABLE MATERIALS DISCLOSURE
B. 12G13933A01 MOTOROLA RECEIVING BAR CODE SPECIFICATION
C. 12M09162A44 MOTOROLA SUPPLIER CORRECTIVE ACTION REQUEST PROCEDURE
D. 12M80957B70 MOTOROLA TOOLING APPROVAL AND CONSTRUCTION
E. 12M80967A78 MOTOROLA SUPPLIER MATERIAL QUALITY CONTROL
F. 12S10601A SUPPLIER PACKAGING SPECIFICATION
- III. MATERIALS
A. ASSEMBLY SHALL CONSIST OF PARTS INDICATED IN ATTACHED TABLE.
- IV. CHARACTERISTICS
A. WORKMANSHIP: CARE MUST BE TAKEN DURING ASSEMBLY AS NOT TO DAMAGE THE ORIGINAL PIECE PARTS.
B. PARTS SHALL BE CLEAN AND FREE FROM FLASH AND FROM ALL FOREIGN MATERIAL.
C. ALL DIMENSIONS SHOWN MUST BE WITHIN TOLERANCES SPECIFIED.
D. ENVIRONMENTAL:
1. OPERATING TEMPERATURE RANGE: -40C TO +85C
2. OPERATING HUMIDITY RANGE: 10% RH TO 80% RH
3. STORAGE TEMPERATURE RANGE: -40C TO +85C
- V. QUALITY CONTROL REQUIREMENTS
A. WHERE THERE IS A CONFLICT BETWEEN THE PRINT NOTES AND AN APPLICABLE DOCUMENT NOTE, THE PRINT NOTE SUPERSEDES.
B. SAMPLES PRODUCED FROM A PRODUCTION PROCESS FLOW SHALL BE SUBMITTED FOR QUALIFICATION WITH DATA FOLLOWING THE GUIDELINES IN MOTOROLA SPECIFICATION 12M80967A78, SUPPLIER MATERIAL QUALITY CONTROL STANDARD, AND THE SUPPLIER MUST SUBMIT A MARK-UP DRAWING SHOWING THE SERIALIZED MEASURED PART DIMENSIONS NEXT TO THE CORRESPONDING PRINT DIMENSIONS PER MOTOROLA STANDARD 12M80957B70. MINIMAL DATA REQUIREMENTS ARE (i) MEASUREMENTS ON THIRTY-FIVE (35) SERIALIZED SAMPLES, FROM EACH CAVITY, FOR EACH PARAMETER DENOTED AS PROCESS CONTROL ALONG WITH A PROCESS CAPABILITY STUDY (Cp>2.0/Cpk>1.5), (ii) MEASUREMENTS ON FIVE (5) SERIALIZED PARTS, FROM EACH CAVITY, FOR ALL OTHER PARAMETERS/DIMENSIONS DENOTED ON THE PRINT, AND (iii) DOCUMENTATION OF CONFORMANCE TO ALL NOTES IN THIS SPECIFICATION AS WELL AS ANY TESTS SPECIFIED IN THE SUPPORTING DOCUMENTS (e.g. PLATING THICKNESS, HARDNESS, GRAPHICS WEAR TEST, ETC.). MOTOROLA MAY ADD PROCESS CONTROL PARAMETERS LATER, IF THE TEST RESULTS DEFICIENCIES DENOTED WITH THE SYMBOL "<ST>" REQUIRE Cp/Cpk DATA FOR PART QUALIFICATION/FIRST ARTICLE SUBMISSIONS ONLY.
A "<ST> = ALL" DENOTES THAT Cpk DATA IS REQUIRED ON ALL PARAMETERS FOR PART QUALIFICATION/FIRST ARTICLE SUBMISSIONS ONLY.
C. PRODUCTION LOT DATA AS DESCRIBED IN MOTOROLA SPECIFICATION 12M80967A78, SUPPLIER MATERIAL QUALITY CONTROL STANDARD, SECTION VI-B, SHOULD BE SUPPLIED WITH PRODUCTION LOTS UNTIL THREE (3) CONSECUTIVE SHIPMENTS DEMONSTRATING A Cpk OF 1.5 OR GREATER FOR ALL PROCESS CONTROL DIMENSIONS, HAS BEEN ACHIEVED, AND NO SCAR'S FROM MOTOROLA, RELATED TO ANY ISSUE WITH THIS PART EXIST. FUTURE LOTS WILL THEN NO LONGER REQUIRE DATA SHIPPED WITH SUPPLIED MATERIAL. HOWEVER, THE SUPPLIER MUST CONTINUE TO GENERATE THE DATA AND MAINTAIN IT ON FILE FOR MOTOROLA REVIEW FOR A MINIMUM PERIOD OF 2 YEARS.
D. IF THE Cpk VALUE ON ANY DEFINED PROCESS CONTROL PARAMETER SHOULD FALL BELOW 1.5 AT ANY TIME DURING THE MANUFACTURE OF THIS PART, THEN THE SUPPLIER MUST 100% SCREEN ALL PARTS TO THOSE SPECIFIED PARAMETERS. MOTOROLA SUPPLIER QUALITY ENGINEERING IS TO BE NOTIFIED IF SUCH A CONDITION EXISTS. THIS SHOULD BE DONE THROUGH THE USE OF A CORRECTIVE ACTION RESPONSE FORM USING THE 8D FORMAT. AN INITIAL NOTIFICATION SHOULD BE SUBMITTED NO MORE THAN 12 HOURS AFTER PROBLEM HAS BEEN IDENTIFIED, STATING THE IMMEDIATE CONTAINMENT ACTION. AFTER ANALYSIS OF ROOT CAUSE OF DISCREPANCY, A PLAN DEFINING PERMANENT CORRECTIVE ACTION SHALL BE SUBMITTED WITH SAMPLES AND SUPPORTING DATA TO MOTOROLA QUALITY ENGINEERING FOR APPROVAL.
- VI. PACKAGING REQUIREMENTS
A. PARTS ARE TO BE PACKAGED SO AS TO PREVENT DAMAGE IN SHIPMENT AND HANDLING AND MEET MOTOROLA STANDARD 12S10601A.
B. PACKAGE LABELING MUST MEET THE MOTOROLA RECEIVING BAR CODE LABEL SPECIFICATION 12G13933A01 REQUIREMENTS. IDENTIFICATION BY DATE CODE IS ALSO REQUIRED.
- VII. SUPPLIER REQUIREMENTS
A. NO CHANGES SHALL BE ALLOWED ON PRODUCTION MATERIALS, PROCESSES, OR MANUFACTURING LOCATIONS, REGARDLESS OF WHETHER SUCH CHANGES AFFECTS CHARACTERISTICS SPECIFIED, WITHOUT PRIOR EXPLICIT WRITTEN APPROVAL BY MOTOROLA'S DEVELOPMENT, QUALITY, AND PURCHASING DEPARTMENTS. SUPPLIER MUST REQUEST A "SUPPLIER REQUEST FOR ENGINEERING APPROVAL" FORM AS IDENTIFIED IN MOTOROLA SPECIFICATION 12M80967A78, SECTION 3.
B. IT IS THE SUPPLIER'S RESPONSIBILITY TO PROVIDE MOTOROLA COMPONENT ENGINEERING, DEVELOPMENT ENGINEERING, AND SUPPLIER QUALITY ENGINEERING WITH PROOF OF COMPLIANCE TO ALL DIMENSIONS PER NOTES IV, AND TO ALL SPECIFICATIONS CONTAINED IN THIS DRAWING.
C. PRIOR TO PART QUALIFICATION, THE SUPPLIER MUST DISCLOSE ANY CONTROLLED AND REPORTABLE MATERIALS IN THEIR PRODUCT AS INDICATED IN MOTOROLA DOCUMENT 12G02897W18 (SEE APPLICABLE DOCUMENTS SECTION). SUPPLIERS ARE REQUIRED TO SUBMIT DISCLOSURES OF CONTROLLED AND REPORTABLE MATERIALS USING THE ELECTRONIC TOOL REFERENCED IN THE 12G02897W18 DOCUMENT CALLED "AIAG" COMPLIANCE CONNECT. THE ELECTRONIC TOOL ALONG WITH USER GUIDE AND TRAINING MATERIAL CAN BE DOWNLOADED FROM: <http://www.motorola.com/EHS/environment/supplier/disclosure.html>. APPENDIX C, SECTION 2: EU/CHINA COMPLIANCE ACCEPTANCE CRITERIA AS INDICATED IN 12G02897W18 SHALL APPLY.

W.I.P.



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THIRD ANGLE PROJECTION 				TITLE ASSY, FRONT HOUSING			
				SIZE A0		CAGE CODE	
				DRAWING NUMBER 1588998D		REV A	
				SCALE 0 5.00		PRODUCT JD SHEET OF	