

ST-8000A PRODUCTION ASSEMBLY PROCEDURES  
TOTAL REVISION  
MARCH 11, 1991

The attached is a completely new set of production assembly procedures. All procedures have been revised and some new procedures have been added.

1. Circuit Board Assembly Procedures:

These are revisions that incorporate all known changes to previous versions. These procedures assume that new revisions of the following circuit boards are used:

MODEM (A1, 930-08005): Circuit Board 1241, REV B  
CONTROL (A2, 932-08005): Circuit Board 1240, REV B  
F PAN DISP (A3A, 920-08003): Circuit Board 1243, REV A  
F PAN LOGIC (A3B, 920-08004): Circuit Board 1244, REV A  
POWER SUPPLY (A4, 950-08005): Circuit Board 1242, REV A

The MODEM, CONTROL, and POWER SUPPLY circuit boards are new versions since last construction. The FRONT PANEL DISPLAY and LOGIC circuit boards have not changed since last use.

2. Cables:

These are new procedures that should reflect how the cables have been manufactured. They require close checking for proper order and procedures. Cable A5W13 (960-80013) has been eliminated as it is combined with Cable A5W12 (960-80012) when the harness board is used. Portions of the previous Cable A5W12 and A5W13 parts lists have been shifted to cabinet assembly steps.

3. Cabinet:

Cabinet procedures are also new and written to reflect the stated preferred order of assembly. The cabinet assembly steps are:

910-08005: PRELIMINARY CABINET ASSEMBLY (A5):

1. Attach AC components to rear panel & attach harness A5W12 to these components.
2. Attach Cables A5W1, A5W3, and A5W4 to rear panel.
3. Construct interior circuit board and transformer bars; attach to left side-panel.
4. Install lower set of PCB mounting spacers.

5. Attach right side-panel and rear panel.

In line with the desire that this assembly not require ESD handling, the +5V Regulator (A5W11) and Front Panel (A3C, 920-08005) are not attached at this time.

905-08004: PCB INSTALLATION (A6A)

1. Install MODEM Board (A1, 930-08005) and spacers to support CONTROL Board.
2. Install CONTROL Board (A2, 932-08005).
3. Install +5V REG (A5W11, 960-80011).
4. Install Power Transformer (A5T1, 960-80014).
5. Install Power Supply (A4, 950-08005).
6. Connect cables A5W1, A5W3, & A5W4.
7. Install cables A5W5, A5W8, & A5W9.
8. Install AC Power Switch on Front Panel.
9. Attach Front Panel (A3C, 920-08005)
10. Install cables A5W6, A5W7, & A5W10.
11. Install cable clamps.
12. Attach bottom cover
13. Lay top cover on cabinet.

905-08005: FINAL ASSEMBLY (A6B):

1. Screw-down CONTROL Board.
2. Inspect interior.
3. Attach top cover.
4. Attach Rack Handles
5. Clean cabinet exterior surfaces.

6. Attach ESD, MIL-130, and WARRANTY labels.

All related parts lists have been revised to reflect the above order of assembly. Please check all procedures to make sure that all required operations are included and in the desired order.

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