

Backwall Reader (Tower) Q/A Checklist

BD Part # 355467-01

VR Serial Number

Start Date:

Final
Q/A

Interface Board & 16 Antennas

Reference In-Process Q/A Sheet (ISO-IPQA-02) for details of Inspection points.

Reference Drawing:

VR102601-Interconnect Diagram_Rev A

Family Tree:

SRA-16_Tower Antenna_Family-Tree

Process #	Initials	Checklist
1		Record Lot # of plastic being used. [iQA1] LOT # _____
1a		Verify that top side HDPE plastic has been routed per M001.
2		Verify that bottom side of HDPE plastic has been routed per M002.
3		Verify that edges of routed Top & Bottom plastics have been deburred.

In Process Inspection_01

Q/A
01

4		Ensure aluminum sheet has been cut.
5		Ensure aluminum sheet has been applied to bottom side of HDPE.
6		Record Lot # of FR4 being used. [iQA2] LOT # _____
6a		Ensure that FR4 antenna panels and HDPE have been glued with sprayer @ 80 PSI.
7		Pass FR4 and HDPE through heat process and adhere together.
8		Verify Mux Boards installed to HDPE per (VR102601 - Interconnect Diagram).
9		Ensure solder from cut aluminum backplane has not gotten further then provided exposed ground plane of the mux boards.
10		Ensure filament feedlines solder joints are not much bigger then 1/8" and cleaned off.

In Process Inspection_02

Q/A
02

11		Verify thermal tape has been applied to the bottom plate of the ThingMagic M6e module.
12		Install ThingMagic M6e module to routed HDPE.
13		Verify that Interface Board has been installed per (VR102601 - Interconnect Diagram).
14		Build all associated wire & cable assemblies. Per drawings located at M:\\$\$-CUSTOMERS\Carefusion\Phase 3\ISO\Tower Project\Cable Diagrams
15		Verify that all (In-House) built cables have been tested by an identifying green dot.
16		Ensure RF cables are installed between Mux boards and ThingMagic Reader per Interconnect diagram VR102601.
17		Ensure Data & GPIO cables are installed between Mux boards and ThingMagic Reader per Interconnect diagram VR102601.
17a		Record Lot #'s of wire/cable assemblies → [iQA6]

LOT # _____	VR102664 - Mux to M6e/Interface
LOT # _____	VR102665 - 55"
LOT # _____	VR102666 - 11.25"
LOT # _____	VR102667 - 12"
LOT # _____	VR102668 - 44.75"
LOT # _____	VR102669 - 46"

In Process Inspection_03

Q/A
03

18		(If Copper or Aluminum back plane) Perform an ohms test between Mux and end of antenna to insure low resistance.
18a	SWR Test	↔ SWRTest TestID

In Process Inspection_04

Q/A
04

Affix SWR Test Label Here

Continue on Page 2

19 Ensure RF cables are connected to ThingMagic Reader.

20 **SYSTEM Test** ⇐ SystemTest TestID

Affix System Test Label Here

21 **Open FAR FIELD Test**
 ⇐ Far Field TestID

Affix Far Field Test Label Here

22 Verify the RF cable(s), GPIO cable, and all connectors are hot glued down to prevent them sticking from up and disconnecting.

In Process Inspection_05 Q/A 05

23 Verify 1/16" Bottom ABS has been routed per **M004**.

[iQA7] Record Lot #

24 Verify 1/8" Top ABS has been routed per **M003**.

[iQA8] Record Lot #

25 Ensure Bottom ABS panel & HDPE Bottom are glued per Engineering Glue Process procedures.

26 Pass panels through heat process.

27 Place panel on Assembly fixture.

28 Ensure Top ABS panel & HDPE Top are glued per Engineering Glue Process procedures.

29 Pass panels through heat process.

30 Place panel on Assembly fixture.

31 Pass panel through pressing process

32 Verify edges have have rounded on top and bottom side per Engineering procedures.

33 Verify mounting holes have been drilled per Engineering drawing **M006**.

In Process Inspection_06 Q/A 06

34 Verify Connector plate has been routed per drawing **M005**.

35 Ensure that the diagnostic panel is aligned and secured with Qty.2 #4 x 1/4" SS FPH screws.

35a Verify that the VRSerial # of unit label is applied to the diagnostic panel.

36 **FAR FIELD Test**
 ⇐ Far Field TestID

Affix Far Field Test Label Here

37 **PREBOX Test** ⇐ PreBoxTest TestID

Affix PreBox Test Label Here

38 Verify that FCC & Certification labels have been applied to unit.

FINAL Q/A When Final Q/A has been completed stamp at Top of First Page where designated