

BFX-UA300

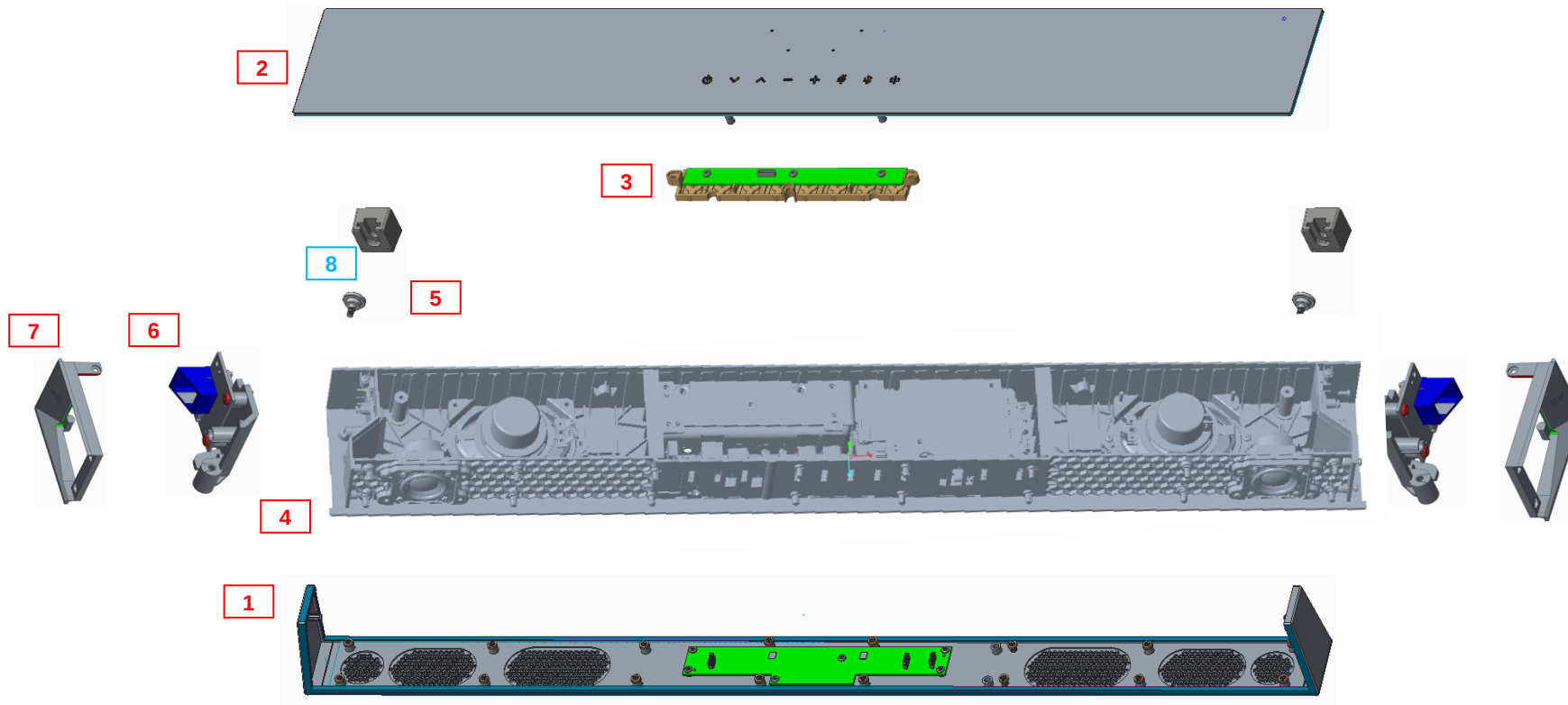
Assembly guide for control run + Pre-MP

			SH, SON
First Update	2020.09.22	Last Update	2021.09.13

Overall structure

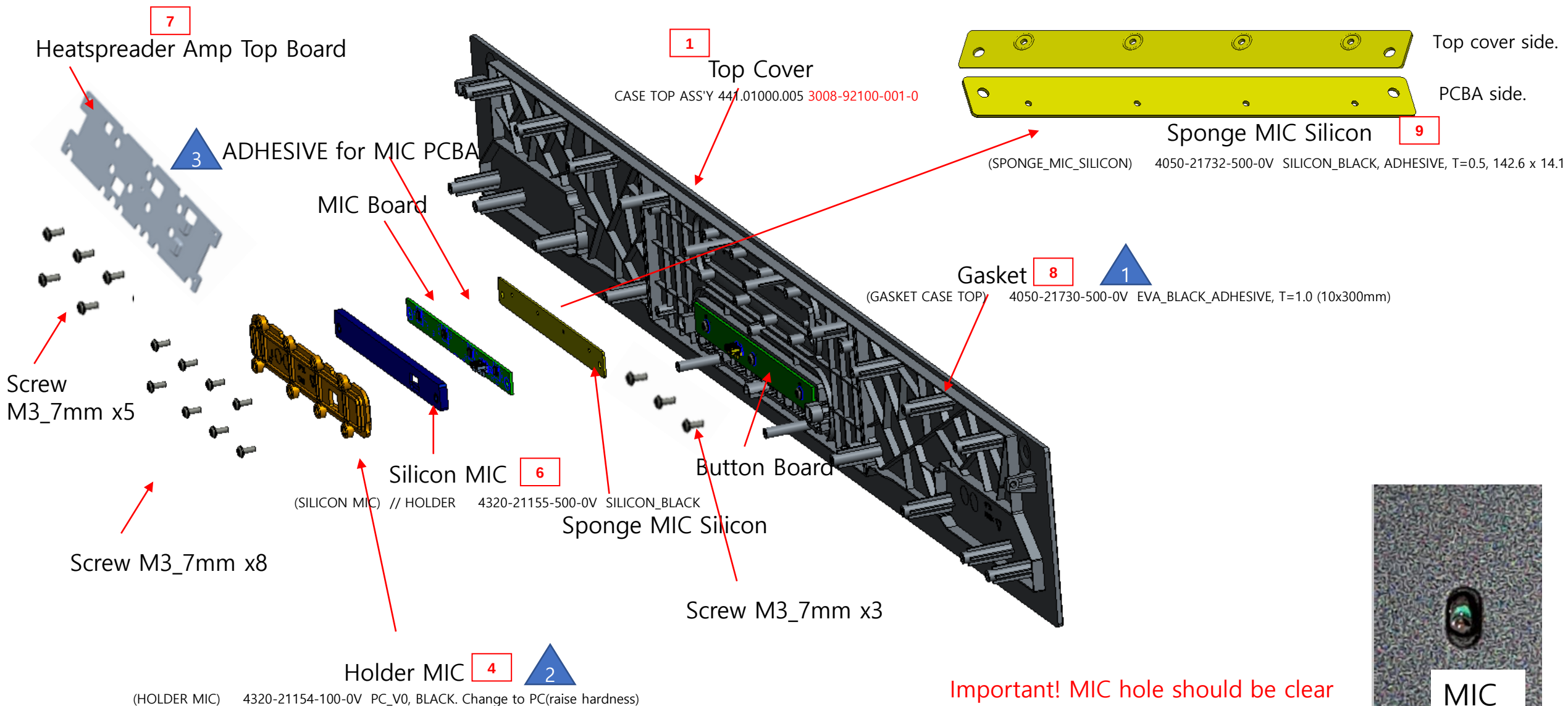
Exploded View (Total Ass'y)

$$\text{SET} = 1 + 2 + 3 + 4 + 5 + 6 + 7 + 8$$



Sub assembly

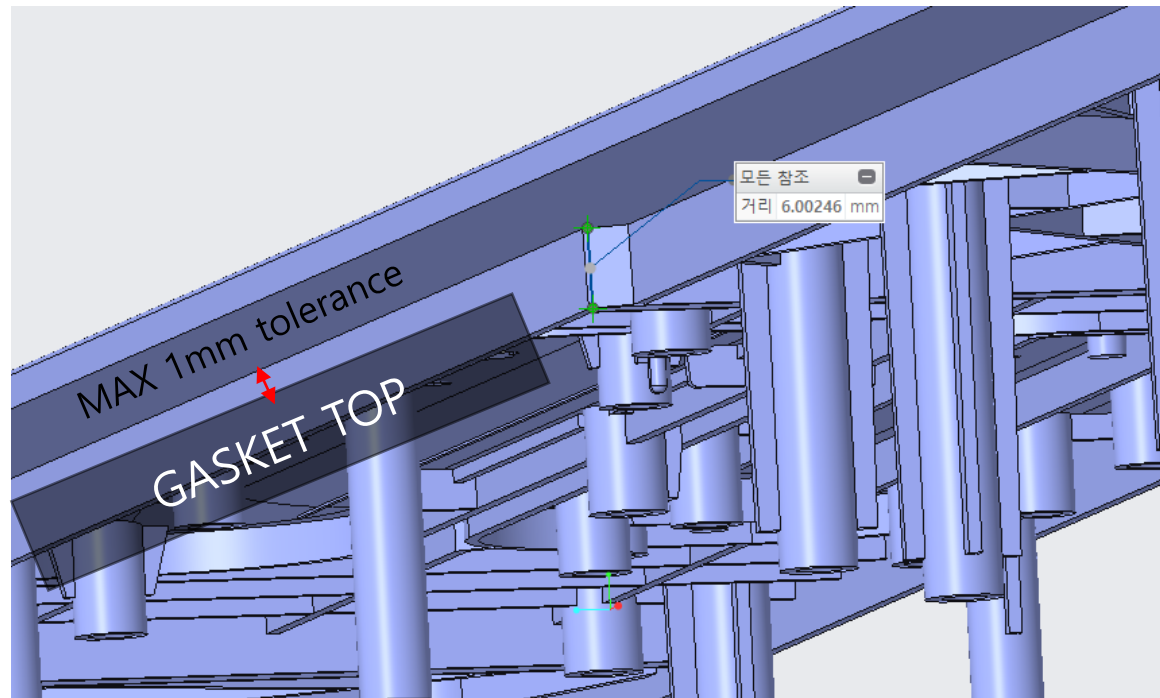
BFX-UA300 Part List – 1. CASE TOP ASS'Y



1

Gasket
Critical To Quality for Acoustic performance

Attachment tolerance : Max +1mm

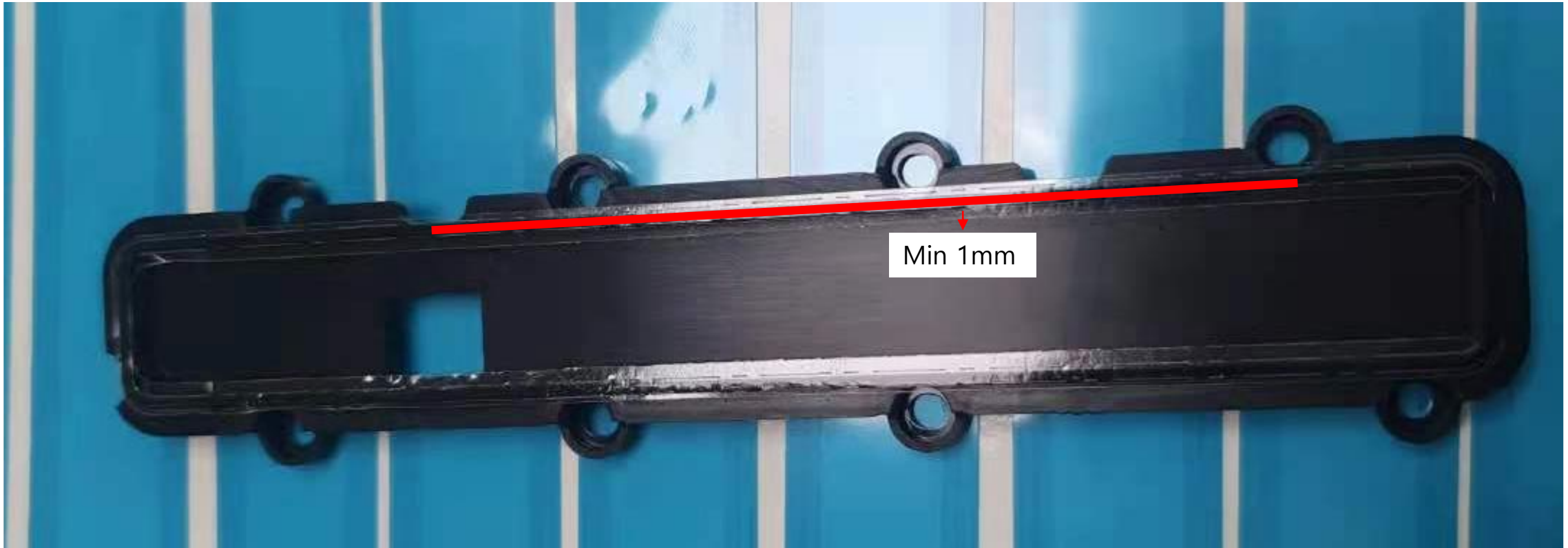


2

Holder MIC

Critical To Quality for MIC Sealing performance

Attachment from the rib end : Min 1mm to inside



3

Adhesive For MIC PCBA
Critical To Quality for MIC Sealing performance

MIC Hole must be clear



Sub assembly

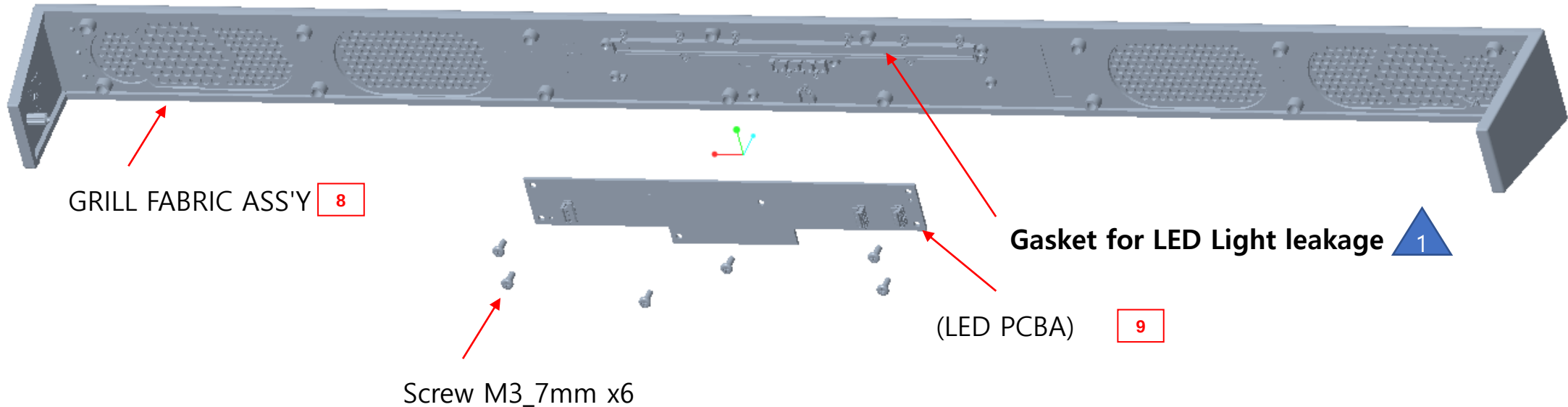
BFX-UA300 Part List – 1. CASE TOP ASS'Y

[illegible]

Sub assembly

BFX-UA300 Part List – 8. GRILL FABRIC ASS'Y

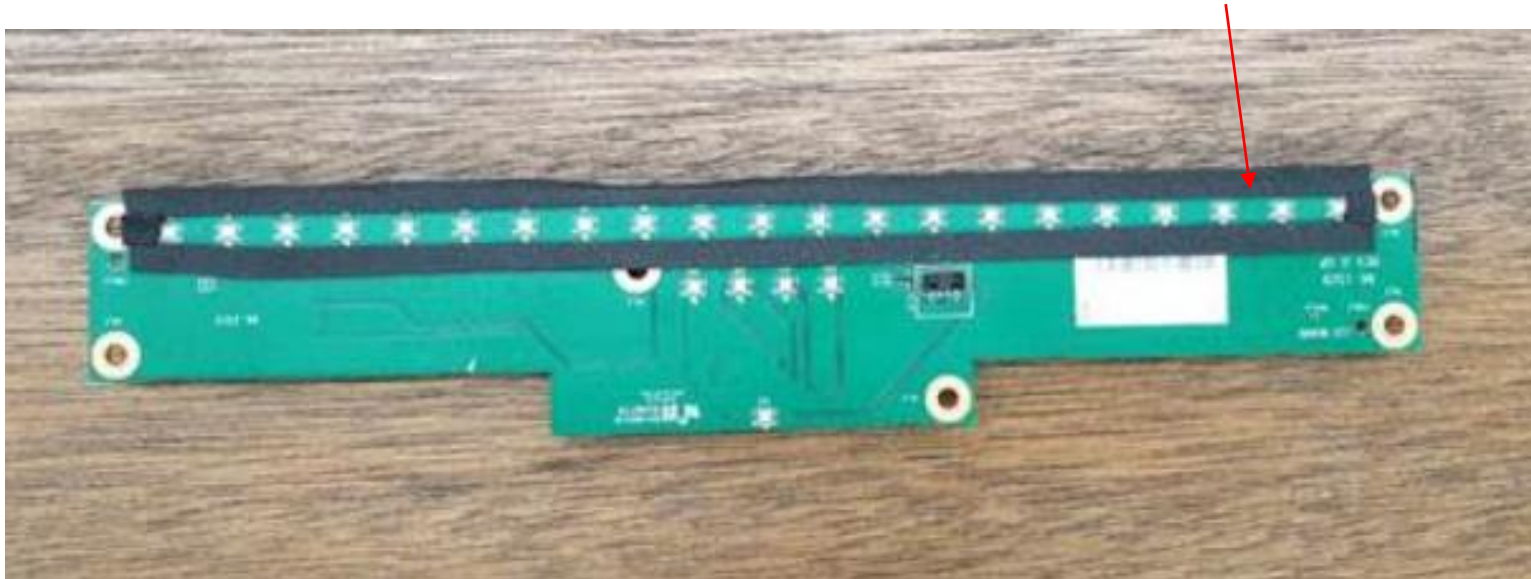
8			GRILL FABRIC ASS'Y	441.00994.005	3218-91300-001-0		1	EA		Inkel	Foxconn
1			(NET FRAME_MIDDLE)	#N/A	3210-21259-100-0V	ABS_V0_BLACK, ULTRASONIC WELDING	1	EA			
2			(NET FRAME_SIDE_RIGHT)	#N/A	3210-21260-100-0V	ABS_V0_BLACK, ULTRASONIC WELDING	1	EA			
3			(NET FRAME_SIDE_LEFT)	#N/A	3210-21261-100-0V	ABS_V0_BLACK, ULTRASONIC WELDING	1	EA			
4			(FABRIC_JERSEY)	#N/A	1260-21015-900-0V	POLYESTER, COLOR: TBD	1	EA			
5			(LENS_LED_STATUS)	#N/A	3710-21169-300-0V	PC_MILKY	1	EA			
6			(LENS_LED_GOOGLE)	#N/A	3710-21170-300-0V	PC_MILKY	1	EA			
7			(LENS_LED_NUGU)	#N/A	3710-21171-300-0V	PC_MILKY	1	EA			
8			(GLUE_FABRIC_JERSEY + NET FRAME ASS'Y)	#N/A		접착제도포 금지영역_LED 3종, IR 수신부		g			
10			(BADGE)	#N/A	5630-21100-800-0V	AL_HAIR LINE	1	EA			
9			(LED_PCBA)	#N/A		ALT社 기록 요망	1	EA		Foxconn	
				484.00479.005		Gasket for LED Light leakage				Foxconn	



1

Gasket

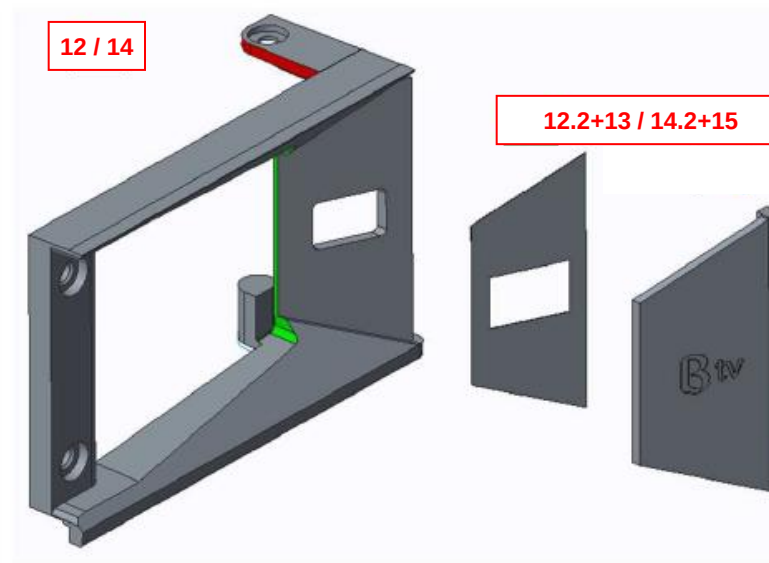
Note. Do not cover the LED



Sub assembly

BFX-UA300 Part List –12. Side Deco_Left / Right Ass'y

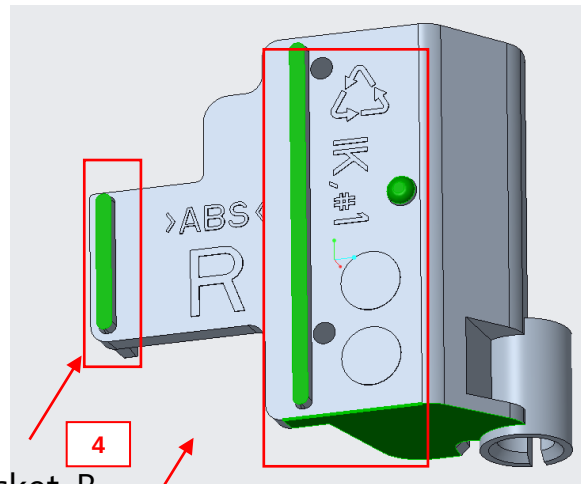
12				SIDE DECO RIGHT ASS'Y	#N/A	5128-91200-03-0		1	EA		Inkel	Foxconn
	1			(DECO SIDE RIGHT)	462.00055.005	5120-21107-100-0V	ABS_V0_BLACK, SPRAY	1	EA	Sub assembled	Inkel	
	2			(ADHESIVE DOUBLE SIDE RIGHT)	#N/A	1220-21258-900-0V	ADHESIVE_DOUBLE SIDED, T=0.2, BLACK, 3M社	1	EA			
13				PLATE BTV LOGO RIGHT	462.00057.005	3710-21172-300-0V	PC_MILKY, SPRAY_OUTER, LASER MARKING	1	EA		Inkel	
14				SIDE DECO LEFT ASS'Y		5128-91200-004-0		1	EA		Inkel	Foxconn
	1			(DECO SIDE LEFT)	462.00056.005	5120-21108-100-0V	ABS_V0_BLACK, SPRAY	1	EA	Sub assembled	Inkel	
	2			(ADHESIVE DOUBLE SIDE LEFT)		1220-21257-900-0V	ADHESIVE_DOUBLE SIDED, T=0.2, BLACK, 3M社	1	EA			
15				PLATE BTV LOGO LEFT	462.00058.005	3710-21173-300-0V	PC_MILKY, SPRAY_OUTER, LASER MARKING	1	EA		Inkel	



Sub assembly

BFX-UA300 Part List -16. SIDE LED RIGHT ASS'Y / 17. SIDE LED LEFT ASS'Y

16		SIDE LED RIGHT ASS'Y				1	EA		Foxconn
1		(BRACKET SIDE LED RIGHT)	446.00182.005	4010-21682-100-0V	ABS_V0_BLACK	1	EA	Inkel	
2		(SIDE LED PCBA)			ALT社 기록 요망	1	EA	Foxconn	
3		(LIGHT PIPE)	448.00328.005	1810-21003-100-0V	ABS_V0_BLACK	1	EA	Inkel	
4		(GASKET_A)	484.00429.005	4050-21740-500-0V	EVA_BLACK_ADHESIVE, T=1.0, 55 x 15	1	EA	Inkel	
5		(GASKET_B)	484.00430.005	4050-21741-500-0V	EVA_BLACK_ADHESIVE, T=1.0, 15 x 10	1	EA	Inkel	
17		SIDE LED LEFT ASS'Y				1	EA		Foxconn
1		(BRACKET SIDE LED LEFT)	446.00183.005	4010-21683-100-0V	ABS_V0_BLACK	1	EA	Inkel	
2		(SIDE LED PCBA)			ALT社 기록 요망	1	EA	Foxconn	
3		(LIGHT PIPE)	448.00328.005	1810-21003-100-0V	ABS_V0_BLACK	1	EA	Inkel	
4		(GASKET_A)	484.00429.005	4050-21740-500-0V	EVA_BLACK_ADHESIVE, T=1.0, 55 x 15	1	EA	Inkel	
5		(GASKET_B)	484.00430.005	4050-21741-500-0V	EVA_BLACK_ADHESIVE, T=1.0, 15 x 10	1	EA	Inkel	

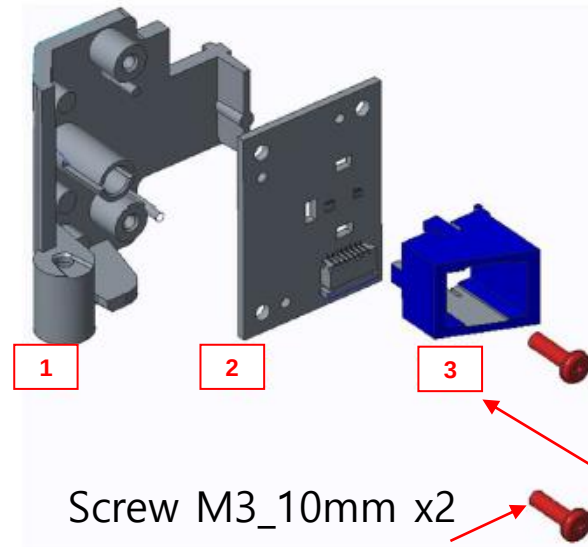


Gasket_B

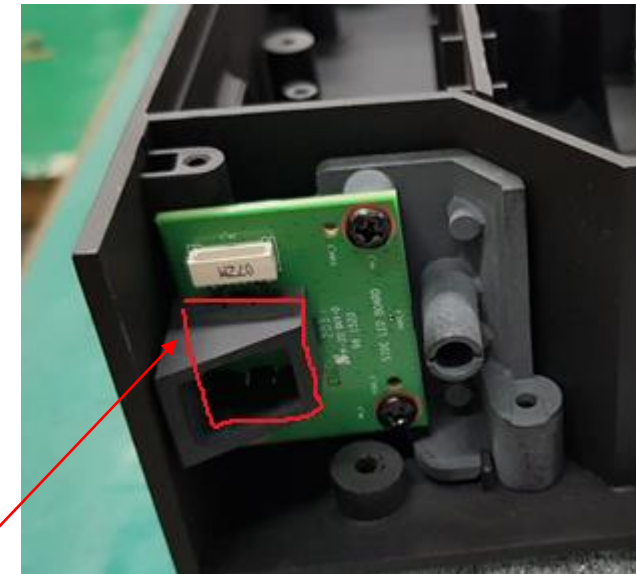
Gasket_A

5

Gasket Note : Should be cover green area



Screw M3_10mm x2

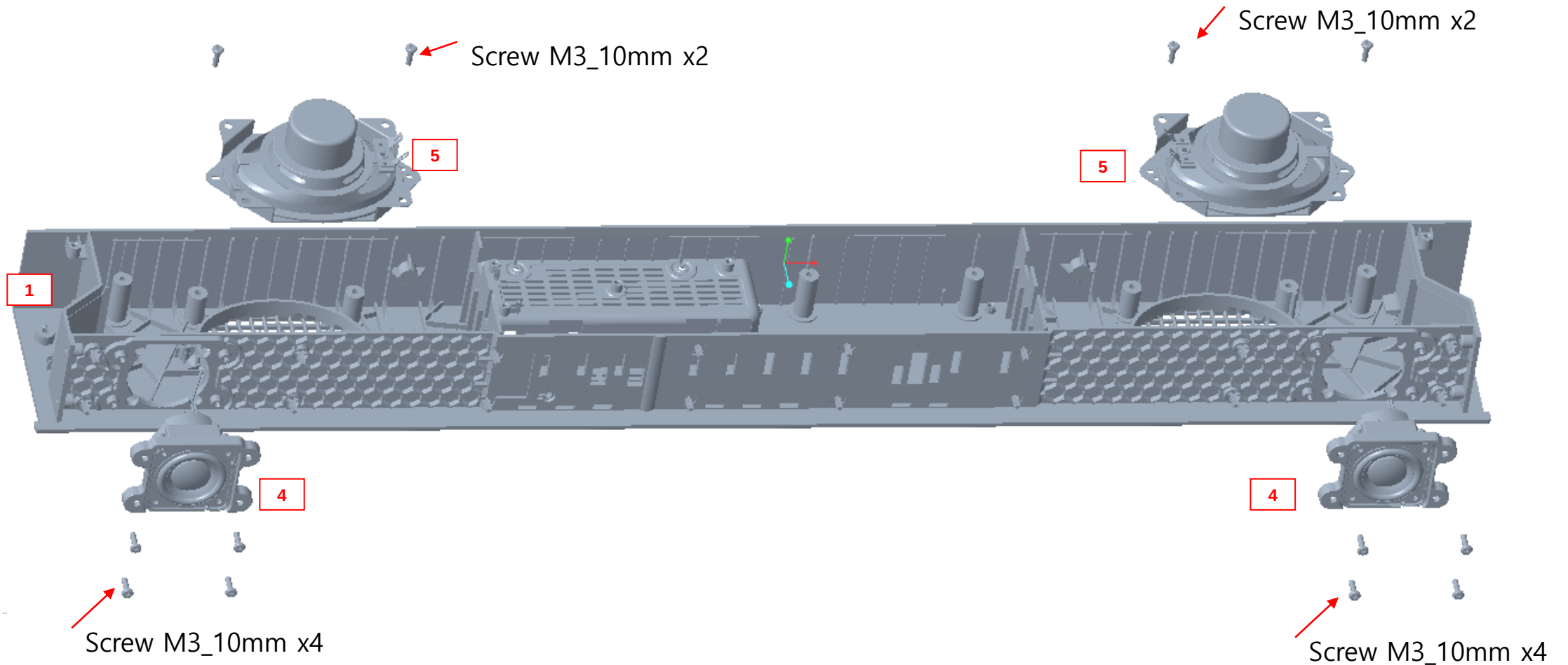


LIGHT PIPE Note : Should be apply glue on PCB side

Final assembly

1. Install the speaker and cables

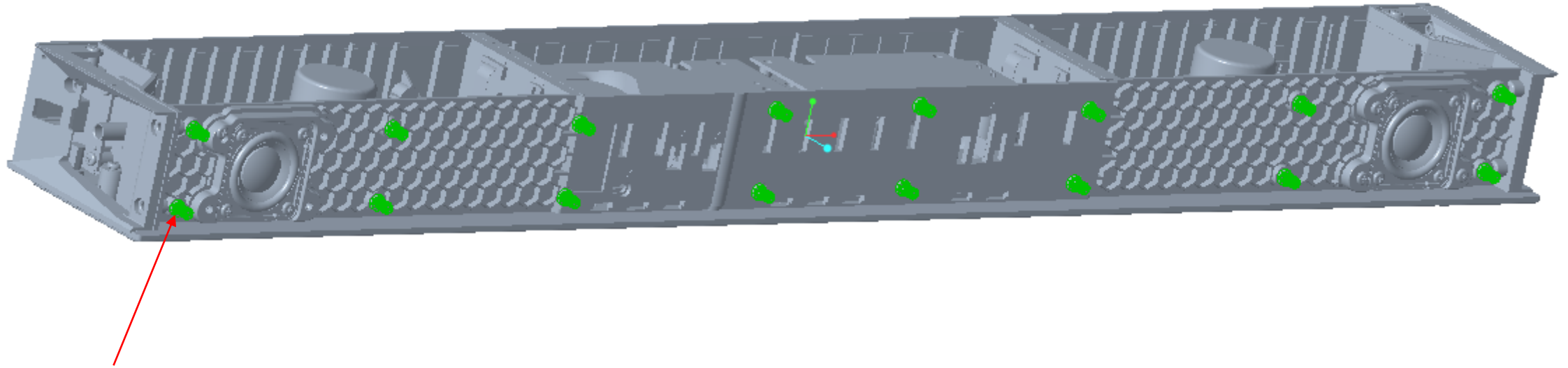
2			CASE BOTTOM ASS'Y	443.00726.005	3008-91100-001-0		1	EA
	1		(CASE BOTTOM)	#N/A	3030-21211-100-0V	ABS_V0_BLACK, SILK PRINT 1도, SPRAY	1	EA
	4		AI2MAX Full range	352.00192.005LT	4AI20-CMXX03	ALT社 기록 요망, COVER_PC Black_난연	2	EA
	5		AI2MAX Woofer	352.00191.005LT	4AI20-CMXX02	ALT社 기록 요망	2	EA
	9		AI2MAX R ch cable ass'y	377.00346.005LT	4AI20-CMXX05	내부포선_BUSHING, SPONGE포함	1	EA
	10		AI2MAX L ch cable ass'y	377.00347.005LT	4AI20-CMXX04	내부포선_BUSHING, SPONGE포함	1	EA



Final assembly

1. Install the speaker and cables

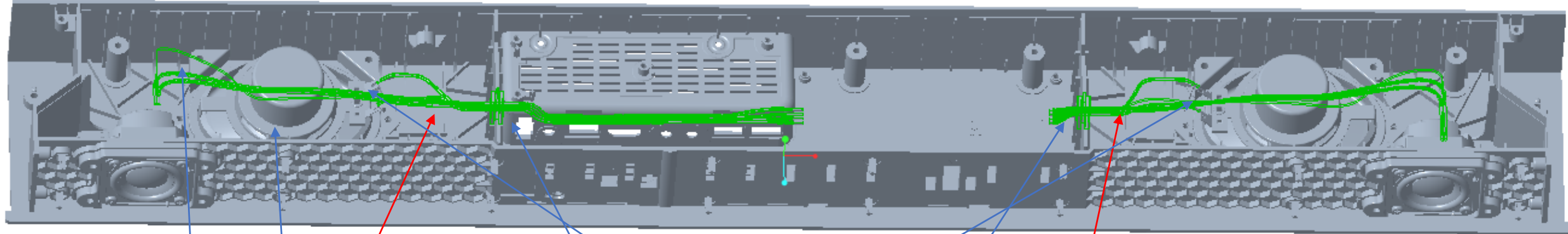
2	(HOLDER GRILL)	#N/A	4320-21156-500-0V	TPE_BLACK, HARDNESS 20
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Holder grill Note : this part is sub assembled from Inkel. Please be careful not to lose parts

Final assembly

1. Install the speaker and cables

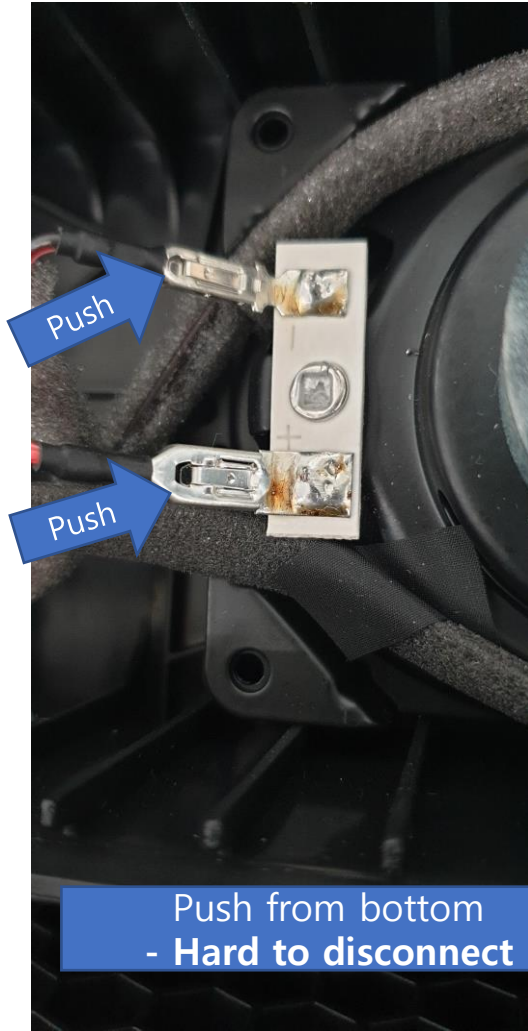


10	AI2MAX L ch cable ass'y	377.00347.005LT	4AI20-CMXX04
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9	AI2MAX R ch cable ass'y	377.00346.005LT	4AI20-CMXX05
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1

Insert pin direction
More easy disconnect, push pin is upper side.



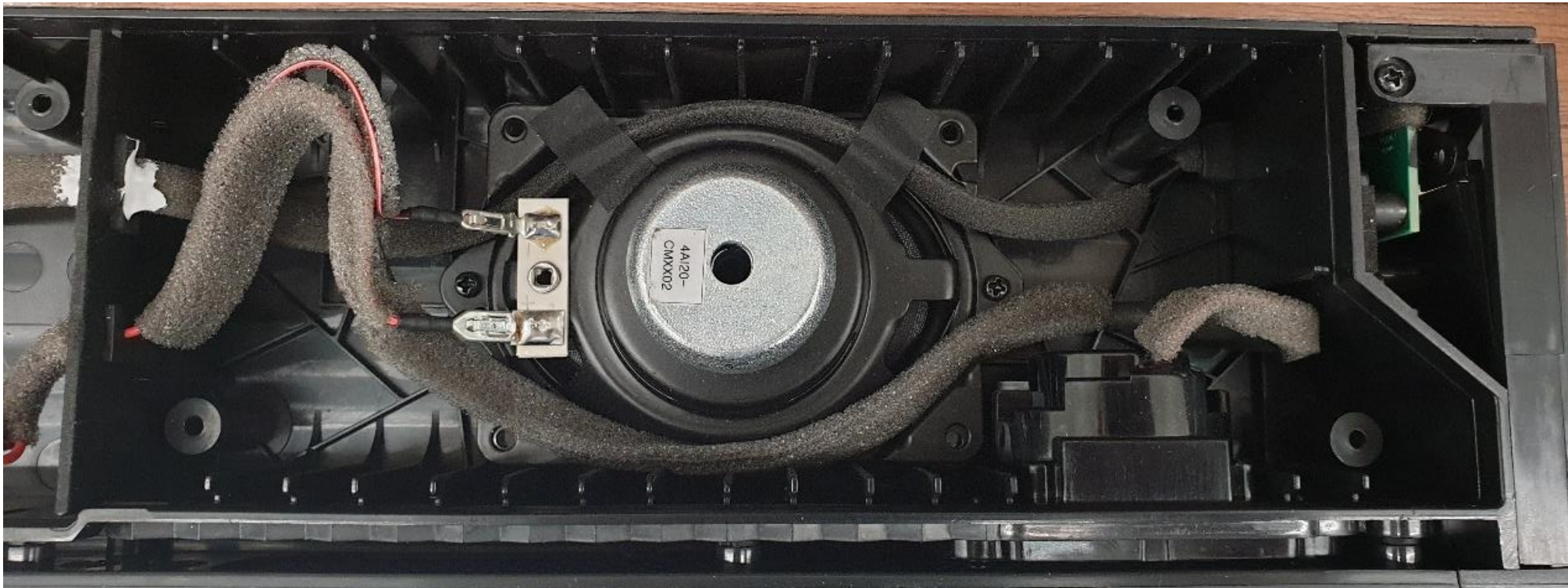
2

Glue application method suggestion
To avoid air leakage through the bushing



3

Good example for cable routing around woofer





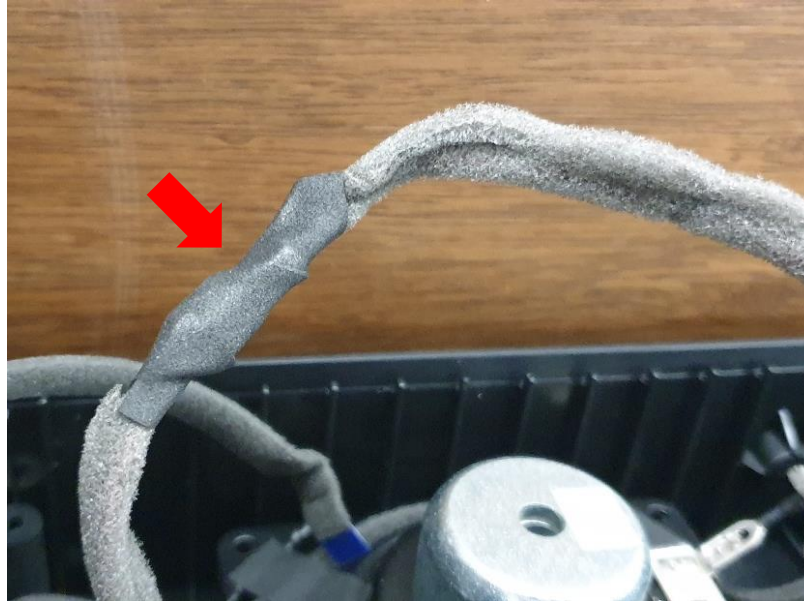
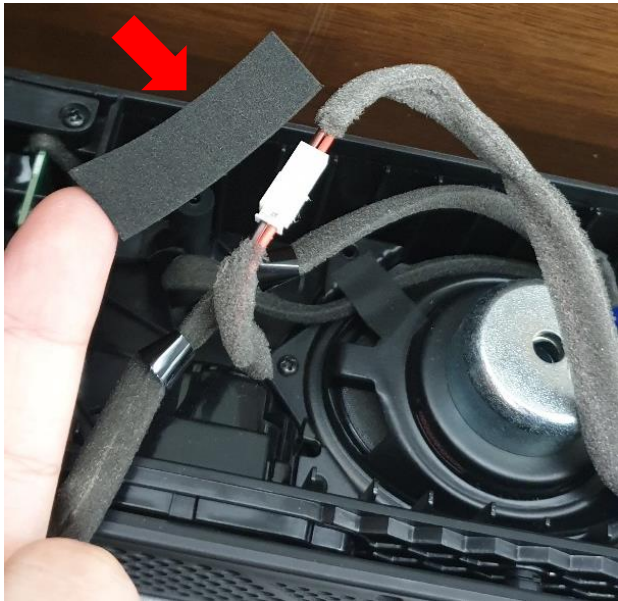
Connector should be warp using gasket due to avoid acoustic noise

: control run + Pre-MP : 1.1K

-> use Gasket A

: After MP

-> use new code



: control run + Pre-MP : 1.1K

SPONGE 55*15mm REV.0 GP EVA (484.00429.005)

: 2pcs -> for each side LED bracket, 2pcs -> for Speaker cable

: After MP

-> 484.00492.005LT 10x100x1mm, Qty:3 pcs

: 2pcs -> for speaker cable, 1pcs -> For top cover

Final assembly

2. assemble Side LED bracket

12					SIDE DECO RIGHT ASS'Y	#N/A	5128-91200-03-0
14					SIDE DECO LEFT ASS'Y	#N/A	5128-91200-004-0

Screw M3_10mm x1

16					SIDE LED RIGHT ASS'Y
17					SIDE LED LEFT ASS'Y

16 17

Side led bushing

Screw M3_10mm x1

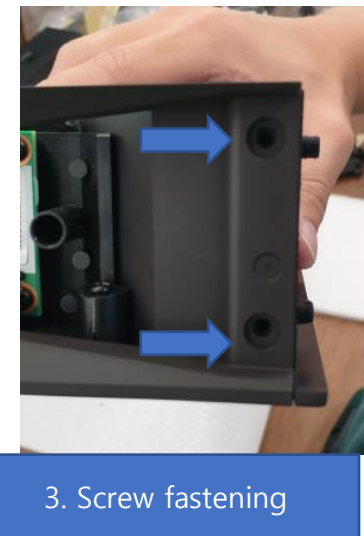
1

12 14

Side LED cable Note : the bushing should be tighten to prevent air leakage.

1

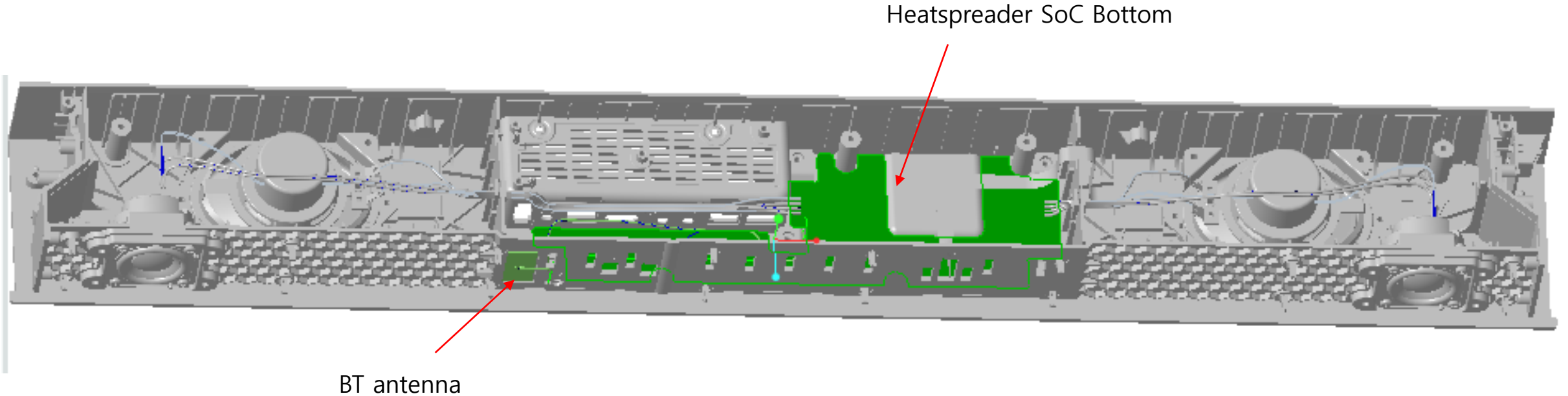
Standard assembly sequence for side bracket
: The assembly gap can be minimized by screw sequence in this order.



Final assembly

3. Prepare PCBA assembly

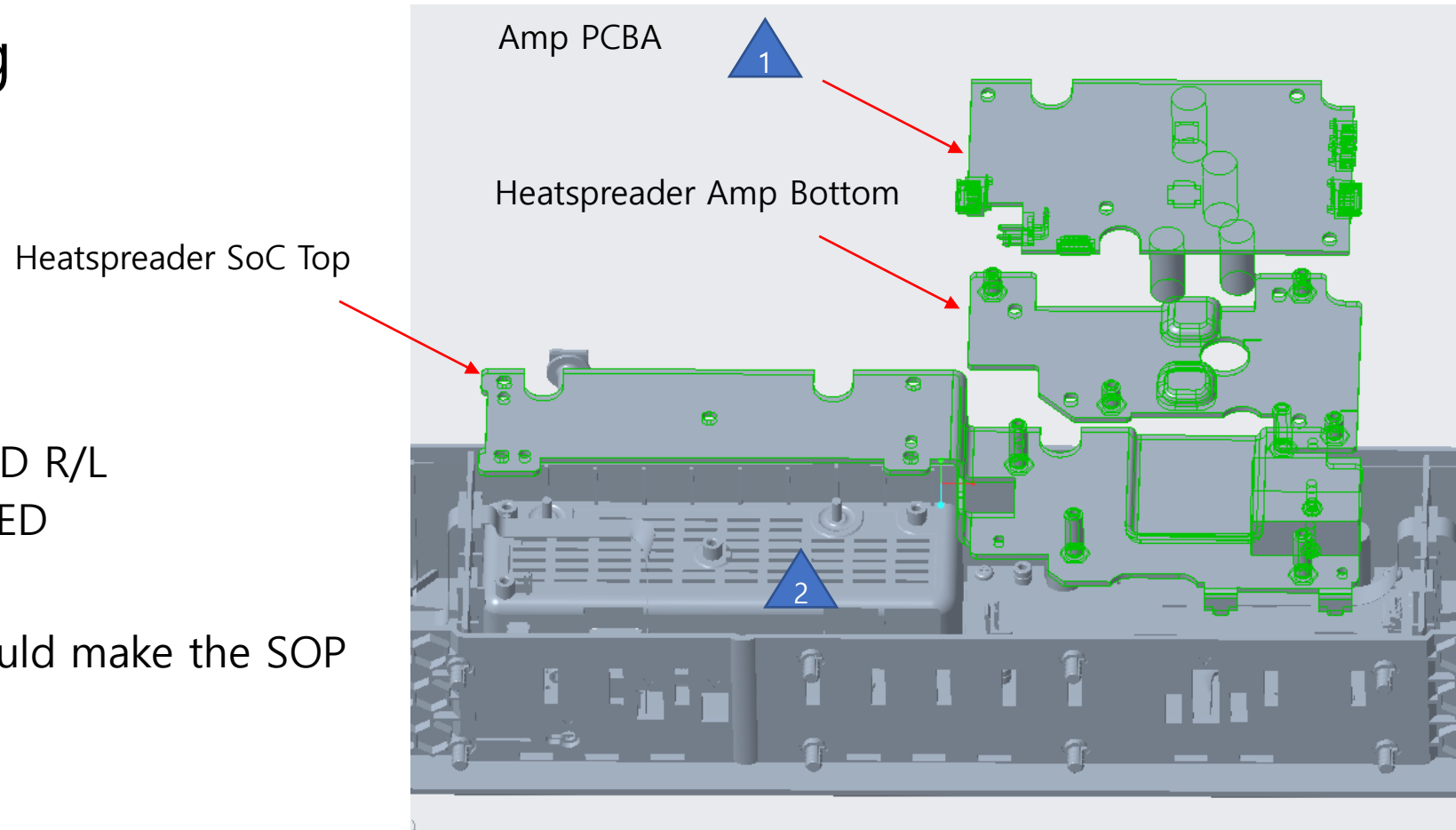
- Assembly
 1. SoC Bottom heat spreader
 2. PCBA SOC
 3. Bluetooth antenna



Final assembly

4. PCBA assembly

- PCBA and Heatspreader assembly
- Cable routing
 - Speaker R/L
 - FFC
 - Mic
 - Button
 - LED
 - Side LED R/L
 - Front LED
 - Amp
- More details, Fii should make the SOP

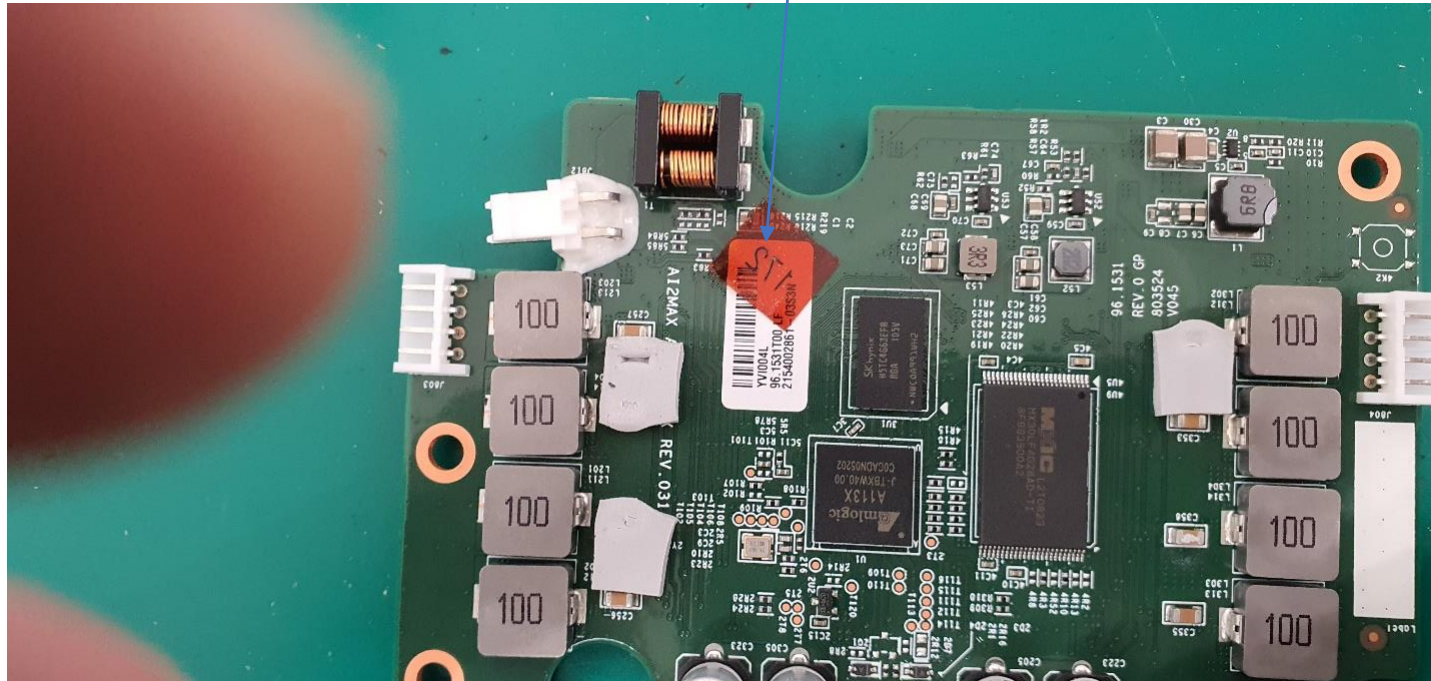


1

Amp PCBA

Remove the capton tape from the common mode filter

This tape may make some noise



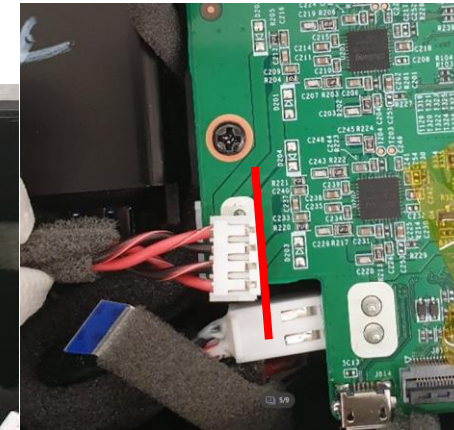
2

Until ~15K production, Speaker cable twist **rework by hand**, twist length may vary

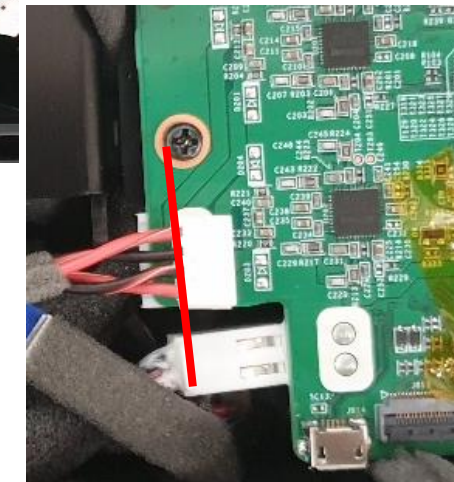
- The speaker connector should be placed on the silk area
 - if the speaker connector is not placed on the silk area, please twist the cable
 - See below min / max cable length example



twisted condition,
(pre MP)



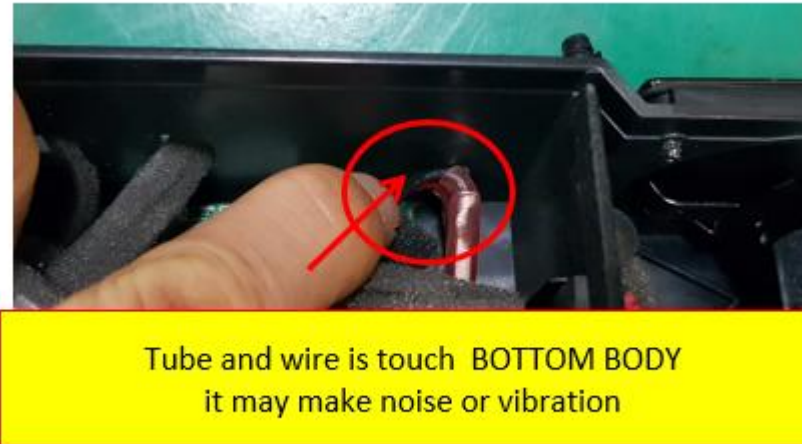
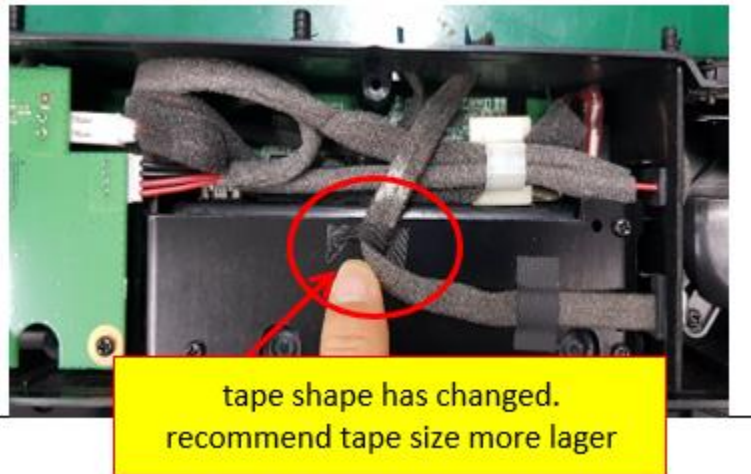
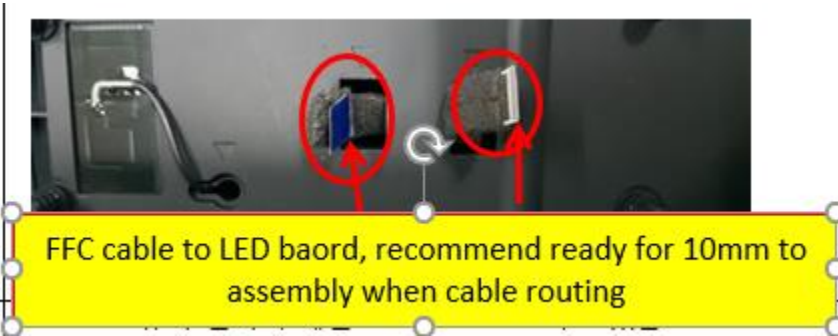
Cable length
minimum line



Cable length
maximum line

Final assembly

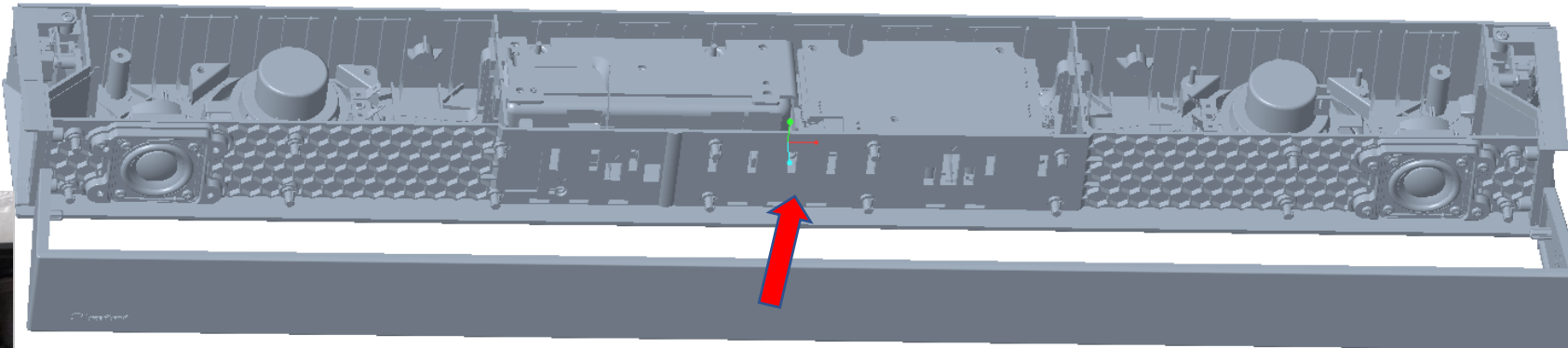
4. PCBA assembly Note



Final assembly

5. front grill assembly

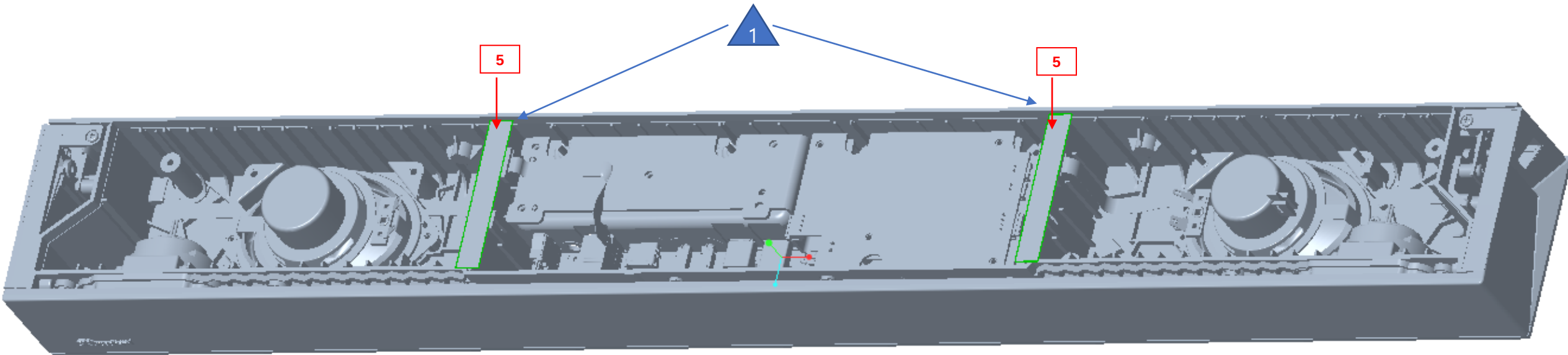
- Assembly with Bottom housing and Front assy (Grill Fabric)
 - Insert the FFC cable : LED PCBA



Final assembly

6. attach gasket

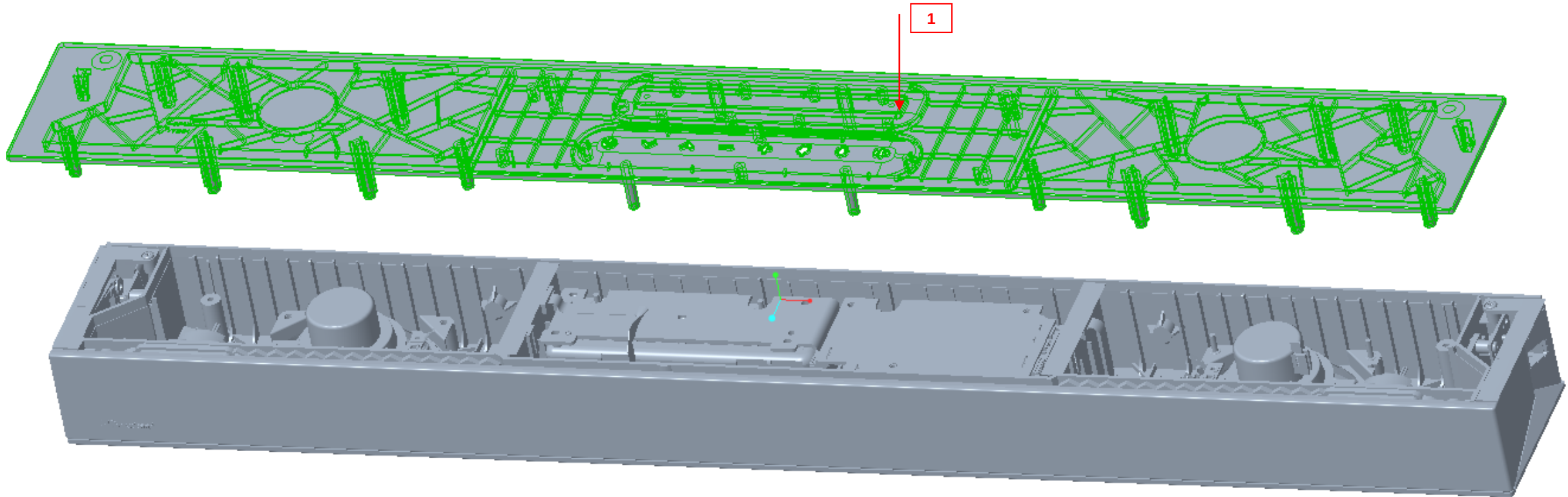
5					NONWOVEN TAPE_BLACK,ADHESIVE, T=0.2, 77 x 12	484.00424.005	1210-21377-900-0V



Final assembly

7. Top cover assembly

LEVEL	Part Name	FXN PN	MPN	Spec.	Q'ty	Unit	sub assy	vender	Final assembly
1	CASE TOP ASS'Y	441.01000.005	3008-92100-001-0		1	EA		Inkel	Foxconn



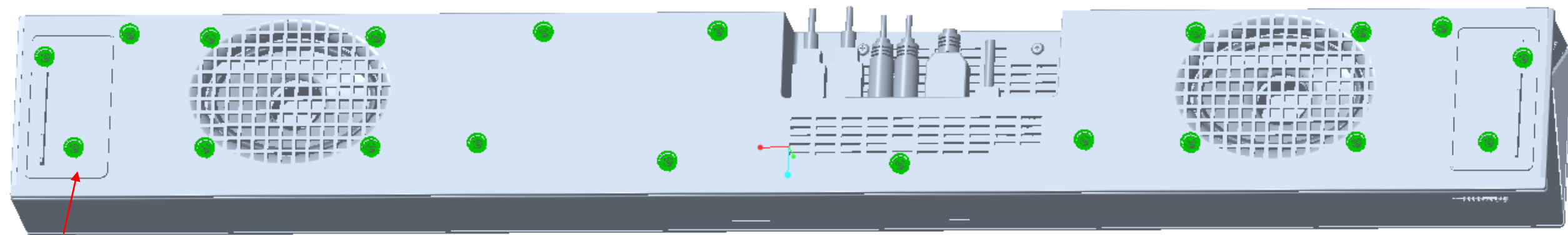
Top Cover Note : be careful "GASKET CASE TOP" does not face outward on the Top cover,

484.00422.005 4050-21730-500-0V EVA_BLACK_ADHESIVE, T=1.0 (10x300mm)

Final assembly

7. Top cover assembly

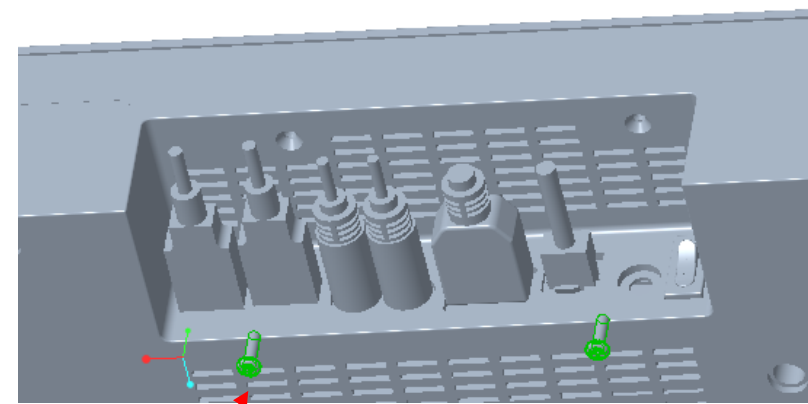
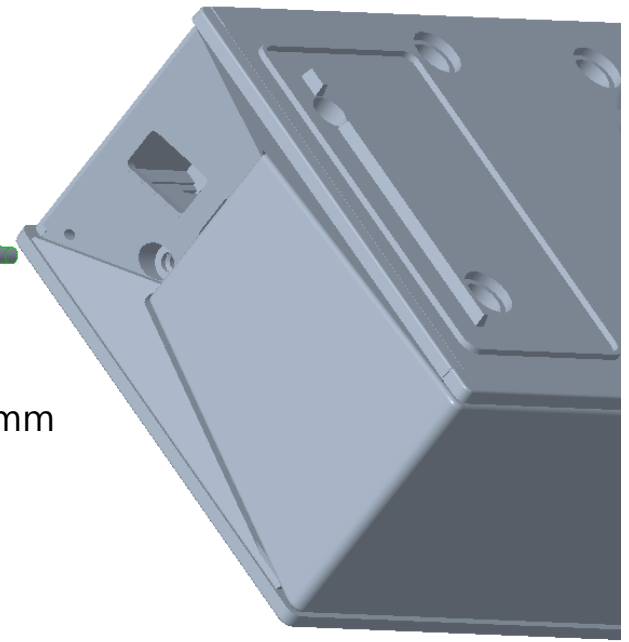
2



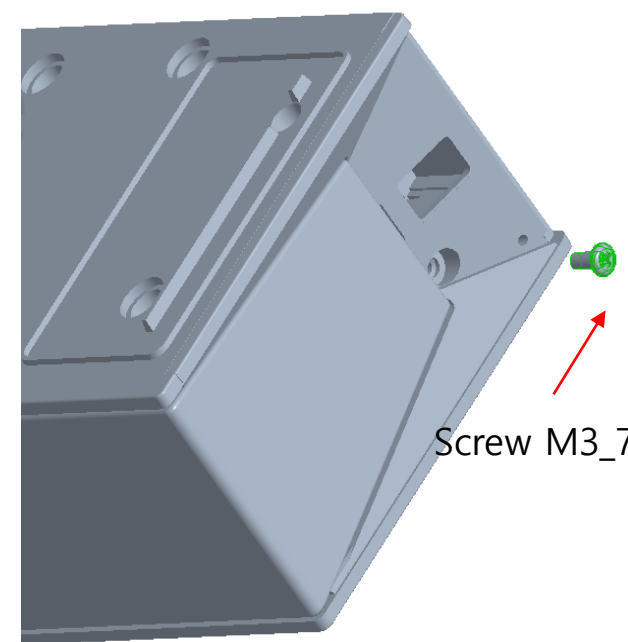
Screw M3_10mm x20

1

Screw M3_7mm



Screw FH M3_10mm



Screw M3_7mm

1

Standard assembly sequence for Top cover

: First fastening screw : each side screw on the SIDE LED

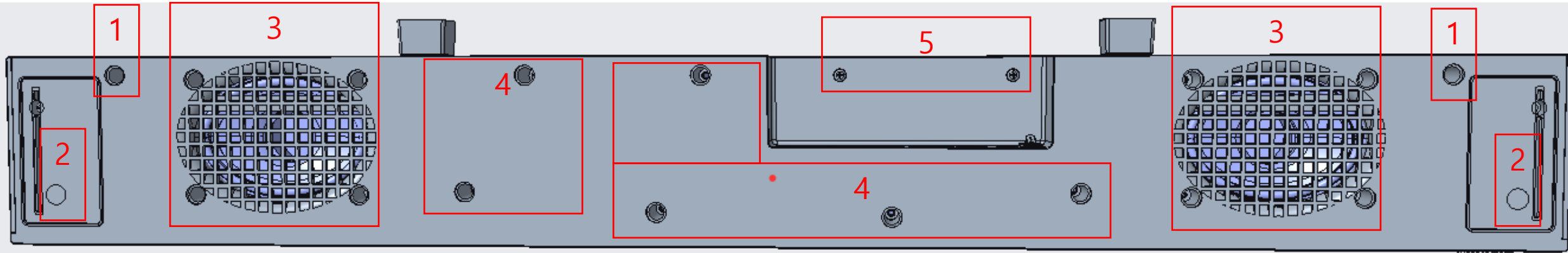
: The assembly gap can be minimized by screw sequence in this order.



2

Standard assembly sequence for Top cover

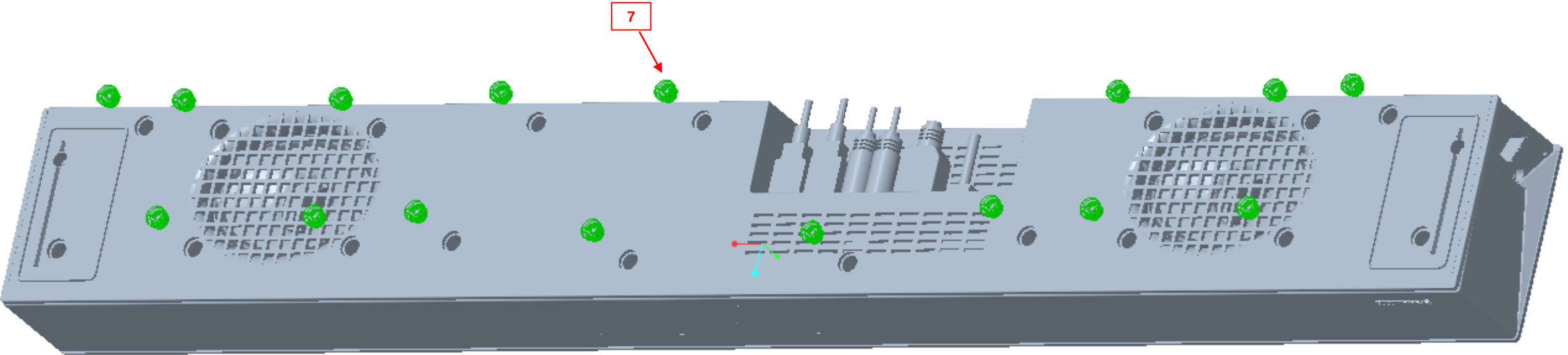
: The assembly gap can be minimized by screw sequence in this order.



Final assembly

7. Top cover assembly

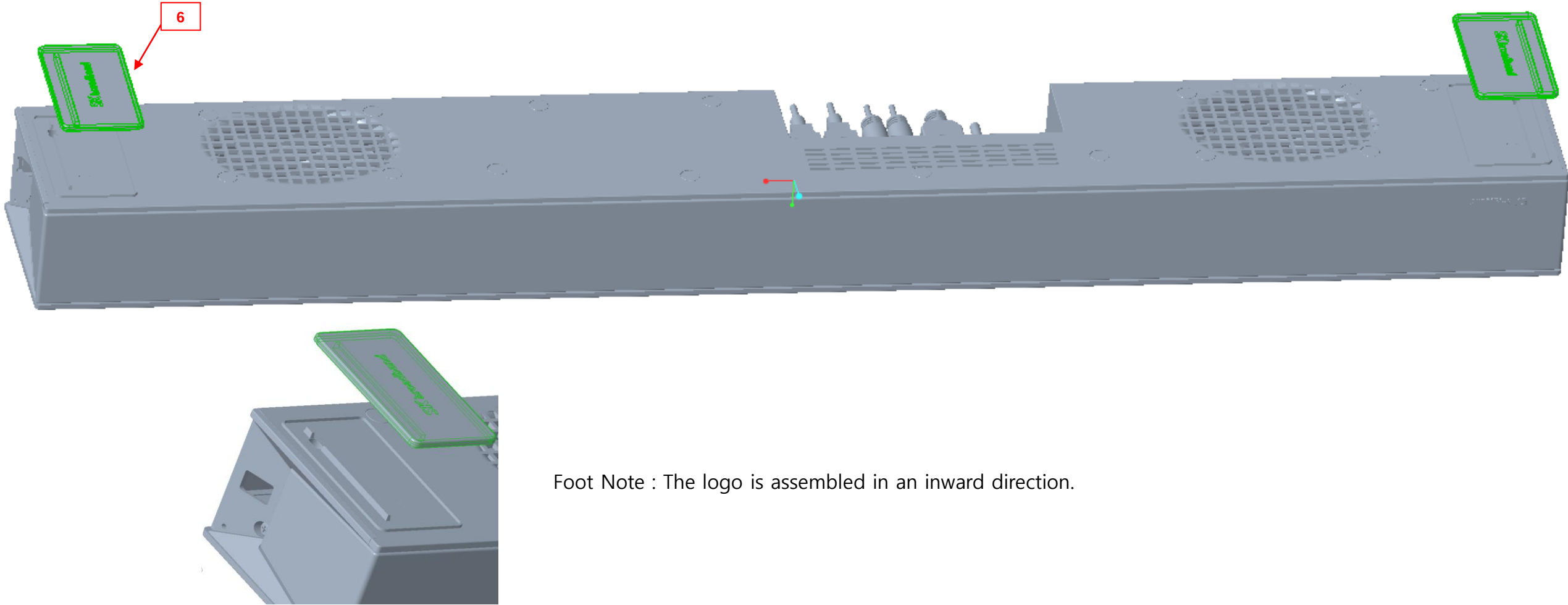
LEVEL					Part Name	FXN PN	MPN	Spec.	Q'ty	Unit	sub assy	vender	Final assembly
7					(COVER SCREW)	477.00474.005	4310-21709-500-0V	TPE_COLOR: TBD, HARDNESS 50	16	EA		Inkel	Foxconn



Final assembly

7. Top cover assembly

LEVEL					Part Name	FXN PN	MPN	Spec.	Q'ty	Unit	sub assy	vender	Final assembly
6					(FOOT)	481.00594.005	4000-21105-500-0V	TPE_COLOR: TBD,	2	EA		Inkel	Foxconn

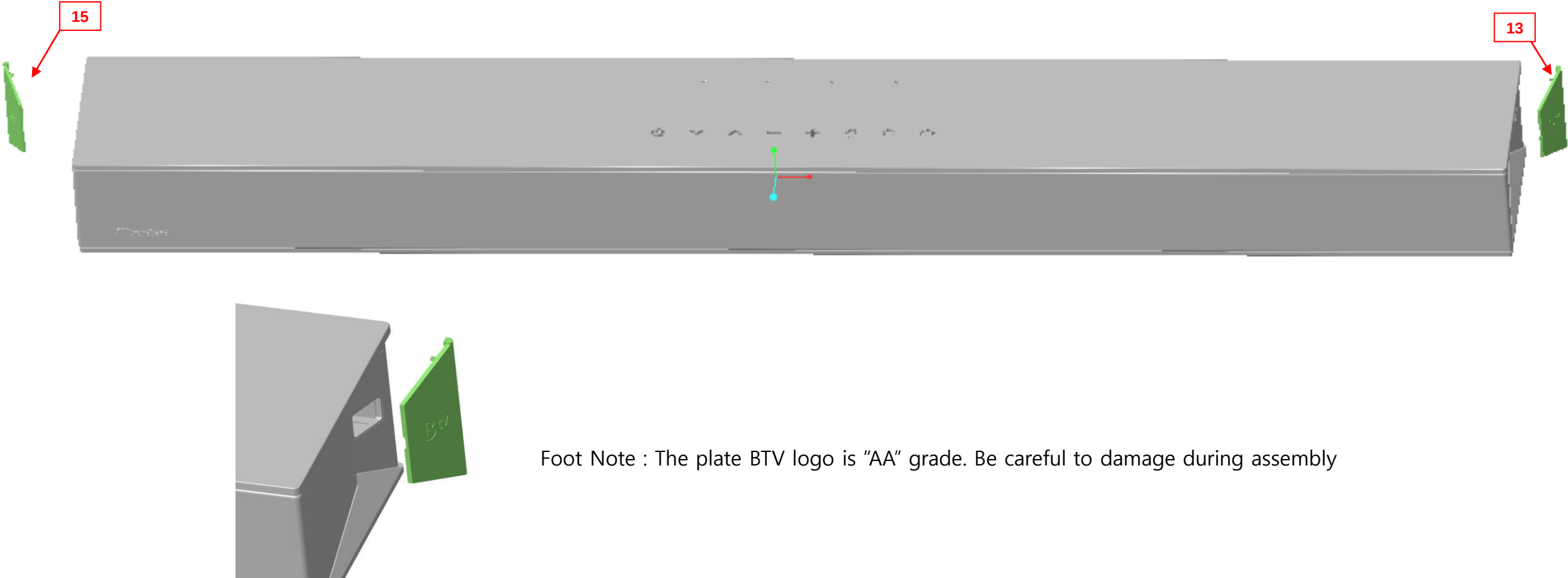


Foot Note : The logo is assembled in an inward direction.

Final assembly

7. BTV LOGO Plate assembly

LEVEL					Part Name	FXN PN	MPN	Spec.	Q'ty	Unit	sub assy	vender	Final assembly
13					PLATE BTV LOGO RIGHT	462.00057.005	3710-21172-300-0V	PC_MILKY, SPRAY_OUTER, LASER MARKING	1	ea		Inkel	Foxconn
15					PLATE BTV LOGO LEFT	462.00058.005	3710-21173-300-0V	PC_MILKY, SPRAY_OUTER, LASER MARKING	1	ea		Inkel	Foxconn



- EOD