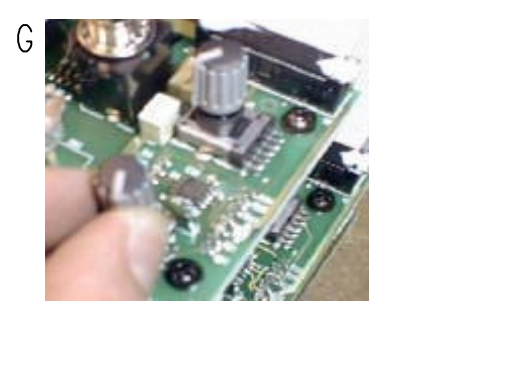
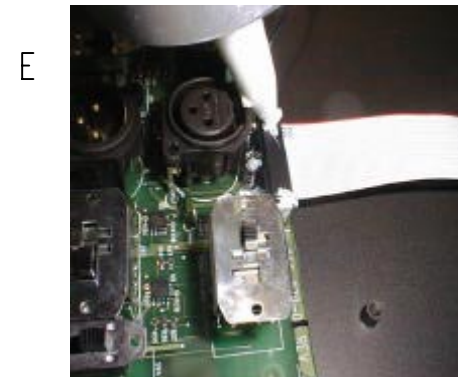
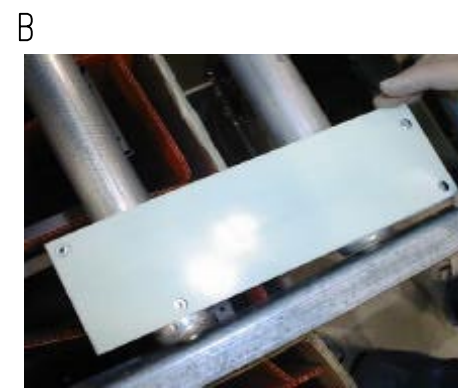
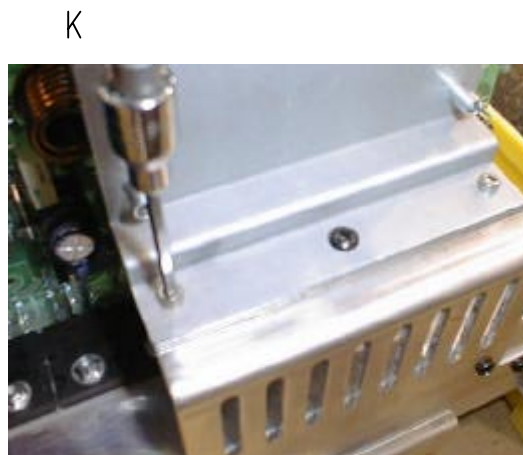


STEP	TASK
A	CLEAN WORK PALLET TO PREVENT DIRT FROM SCRATCHING CHASSIS DURING ASSEMBLY.
B	INSTALL ITEM ① INSULATIVE MYLAR (1X) ONTO ITEM ② INPUT SHIELD (1X).
C	INSTALL ITEMS ① MYLAR SHIELD AND ② INPUT SHIELD ONTO ITEM ③ INPUT PCB (1X) USING ITEM ④ SCREWS (4X).
D	INSTALL ITEM ⑤ AND ⑥ RIBBON CABLES (1X EA.) AS SHOWN.
E	APPLY ITEM ⑦ RTV 162 ADHESIVE TO RIBBON CABLE CONNECTIONS.
G	INSTALL ITEM ⑨ INPUT KNOBS (2X).
H	INSPECT CHASSIS CAREFULLY BRFORE PROCEEDING. LOOK FOR MISSING PEMS, SCRATCHES AND SILKSCREEN ERRORS.
I	PLACE ITEM ③ INPUT PCB INTO ITEM ⑩ CHASSIS AND SECURE WITH ITEMS ⑪ WASHER AND ⑫ NUT (2X EA.)
J	SOFT START PCB's ARE INSTALLED IN THE 100V AND 220/240V VERSIONS ONLY
K	ATTACH ITEM ⑬ SOFT START BRACKET (1X) TO ITEM ⑳ HEATSINK ASSY USING ITEM ⑭ SCREWS (2X)
L	ATTACH APPROPRIATE SOFT START PCB ⑮ OR ⑯ (SEE TABLE J) TO BRACKET USING ITEM ⑰ SCREWS (4X)
M	PLACE ITEM ⑱ 240V LABEL ON ALL 220/240V MODELS 090-137-(01, 04, 05, 06, 07) PLACE ITEM ⑲ 100 VOLT LABEL ON JAPANESE MODELS 090-137-02 PLACE ITEM ㉑ 220 VOLT LABEL ON 090-137-03
N	NO VOLTAGE LABEL IS REQUIRED FOR 120 VOLT MODELS.

ITEM	DESCRIPTION	PART NUMBER	QTY	TORQUE IN LBS
1	MYLAR SHIELD	780-042-00	1	
2	INPUT SHIELD	550-247-00	1	
3	INPUT PCB	055-253-00-01	1	
4	SCREW SEMS 6-32x5/16	700-028-01	4	10
5	4.25" RIBBON CABLE	040-062-00	1	
6	18" RIBBON CABLE	040-062-02	1	
7	RTV 162	730-026-00	A/R	
9	GREY/BLACK KNOBS	760-048-04	4	
10	M1400 CHASSIS	550-470-00	1	
11	CHROME FLAT WASHER	710-002-00	2	
12	CHROME NUT	705-003-00	2	17
13	SOFT START BRACKET	550-294-00	1	
14	SCREW SKT 6-32x3/8	700-083-01	2	10
15	100V SOFT START (SEE ABOVE)	055-162-02	1	
16	240V SOFT START (SEE ABOVE)	055-162-01	1	
17	SCREW SEMS 6-32x5/16	700-028-01	4	10
18	240V LABEL (SEE ABOVE)	840-079-00	1	
19	100V LABEL (SEE ABOVE)	840-073-00	1	
20	MAIN HEATSINK ASSEMBLY	080-149-00	1	
21	220V LABEL (SEE ABOVE)	840-059-00	1	

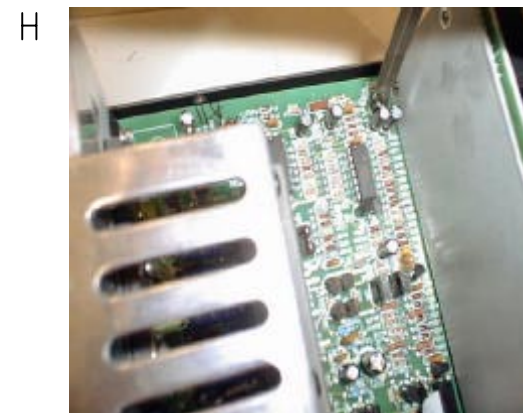
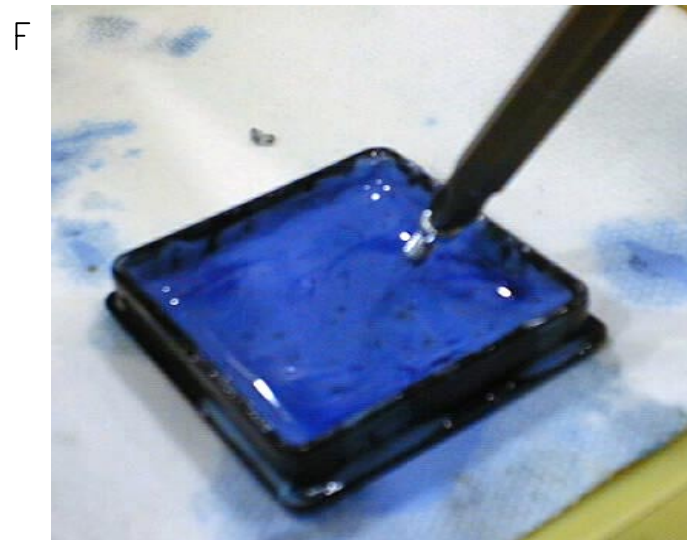
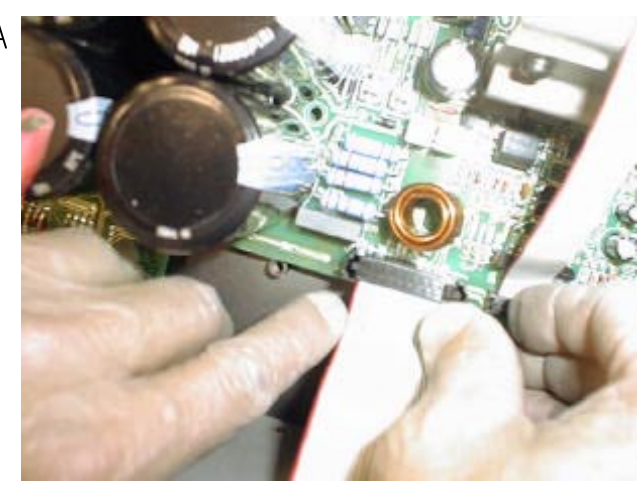


SOFT START GUIDE		
ASSEMBLY	ITEM	SOFT START
090-137-02	⑮	100 VOLT SOFT START
090-137-01 -03, -04, -05, -06, -07	⑯	240 VOLT SOFT START



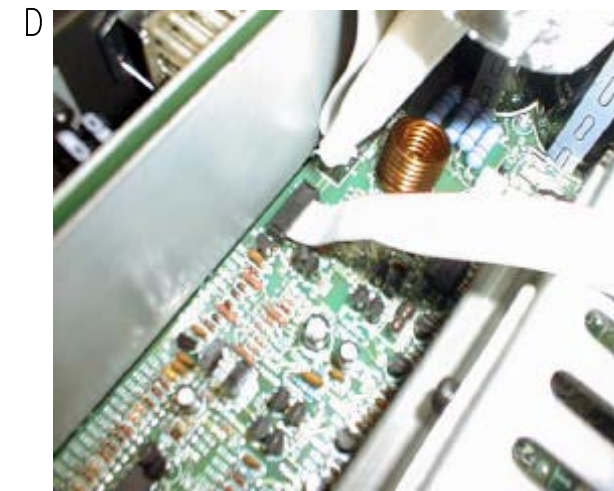
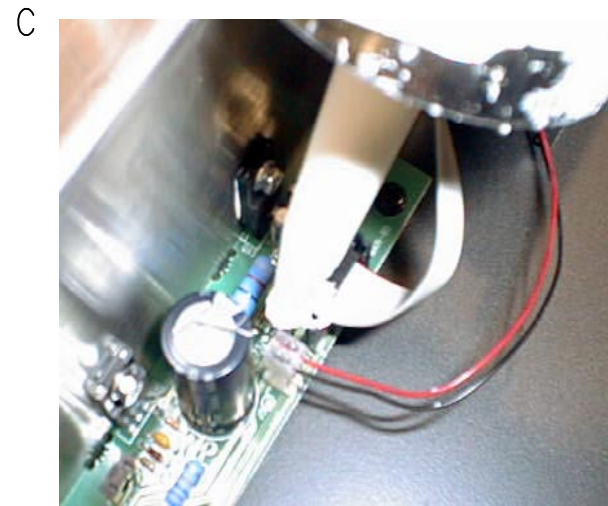
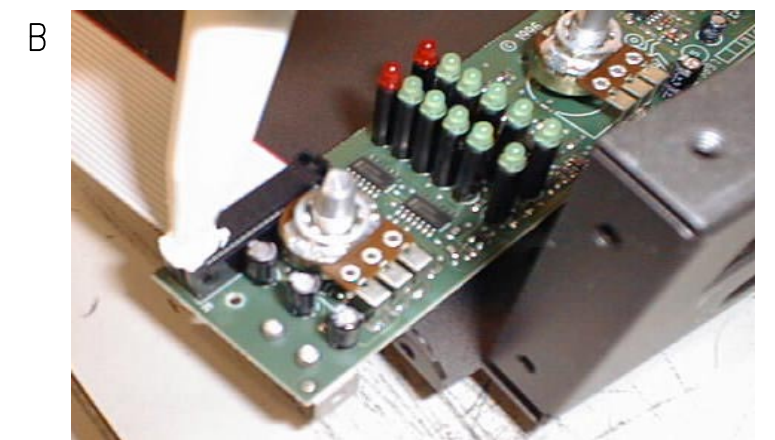
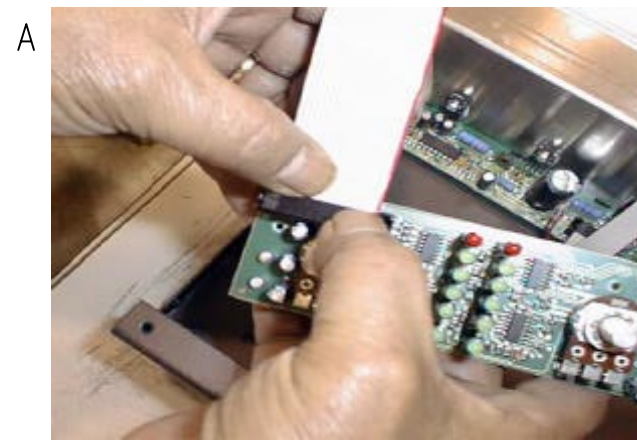
STEP TASK

- A CONNECT INPUT RIBBON CABLE TO MAIN PCB.
- B CONNECT BLACK WIRE FROM INPUT PCB TO MAIN PCB.
- C START ITEM ① SCREWS (4X) INTO BANANA JACK AND THEN TIGHTEN.
- D START ITEM ⑧ SCREWS (4X) INTO SPEAKERS AND THEN TIGHTEN.
- E START ITEM ② SCREWS (8X) INTO XLR JACKS AND THEN TIGHTEN.
- F/G APPLY ITEM ③ LOCKTITE TO ITEM ④ SCREWS (2X) AND INSTALL INTO LOCATIONS NEAR LARGE FILTER CAPACITORS.
- H INSTALL REMAINING SCREWS, ITEM ⑦ (5X) HOLDING PCB TO CHASSIS.
- I **SOFT START MODELS ONLY:** INSTALL ITEMS ⑤ BLUE WIRE (1X) AND ⑥ BROWN WIRE (1X) AS SHOWN.



ITEM	DESCRIPTION	PART NUMBER	QTY	TORQUE IN. LBS.
1	M3 SCREW	700-085-03	4	10
2	#5 SCREW	701-016-00	8	10
3	LOCTITE BLUE 242	730-016-00	A/R	
4	SCREW 6-32 FILLSTER	700-050-04	2	10
5	BLUE WIRE (SEE ABOVE)	040-152-00	1	
6	BROWN WIRE (SEE ABOVE)	040-153-00	1	
7	SCR #6-32x5/16 SEMS	700-028-01	5	10
8	#4X3/8 PHP2 TYP B BLK	701-022-02	4	5

STEP	TASK
A	PLUG IN RIBBON CABLE FROM INPUT PCB INTO ITEM ① DISPLAY PCB (1X).
B	PUT ITEM ② ADHESIVE ON BOTH ENDS OF HEADER/CABLE CONNECTION TO SECURE PART.
C	PLACE ITEM ② ADHESIVE ON FAN SUPPLY PCB CONNECTION.
D	PLACE ITEM ② ADHESIVE ON MAIB PCB HEADER/CABLE CONNECTION.
E	PLACE DISPLAY PCB INTO CHASSIS AND SECURE USING ITEM ③ SCREWS (6X).
F	PUSH ITEM ④ VOLUME KNOBS (2X) INTO VOLUME POTS.
G	SECURE ITEM ⑤ RIGHT SIDE (1X) USING ITEM ⑥ SCREWS (8X).



ITEM	DESCRIPTION	PART NUMBER	QTY	TORQUE IN LBS
1	DISPLAY PCB	055-254-00	1	
2	ADHESIVE RTV 162	730-026-00	A/R	
3	SCREW 4-40X1/4 BTN	700-011-00	6	
4	VOLUME KNOB	760-061-00	2	
5	RIGHT SIDE	550-566-00	1	
6	SCREW 6-32 x 5/16	700-028-01	10	10

STEP	TASK
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- A INSTALL ITEM ① SCREWS (3X) SECURING HEATSINK.
- B INSTALL ITEM ② LEFT SIDE USING ITEM ③ SCREWS (8X). START ALL SCREWS FIRST, BEFORE FULLY TIGHTENING.
- C PLACE ITEM ⑦ STRAIN RELIEF ONTO APPROPRIATE LINE CORD AND INSERT INTO CHASSIS.

USE TABLE BELOW TO DETERMINE PROPER LINE CORD.

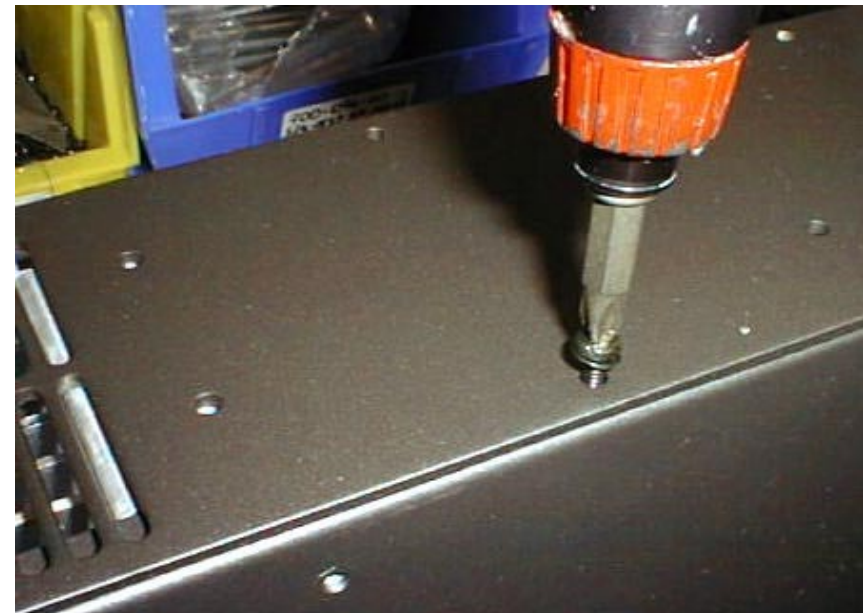
LINE CORD TABLE	
MODEL	CORD
090-137-00	640-006-00 STANDARD 120 VOLT
090-137-01 090-137-03	640-007-01 STANDARD EUROPEAN
090-137-02	640-007-02 JAPANESE
090-137-04	640-007-03 UK/ENGLAND
090-137-05	640-007-04 ITALY
090-137-06	640-007-05 AUSTRALIA
090-137-07	640-007-06 SWISS

ITEM	DESCRIPTION	PART NUMBER	QTY	TORQUE IN LBS
1	TF 6-32x3/8 SCREW	700-086-00	3	15
2	LEFT SIDE	550-568-00	1	
3	SCREW SEMS 6-32x5/16	700-028-01	10	10
4	STRAIN RELIEF	740-004-00	1	

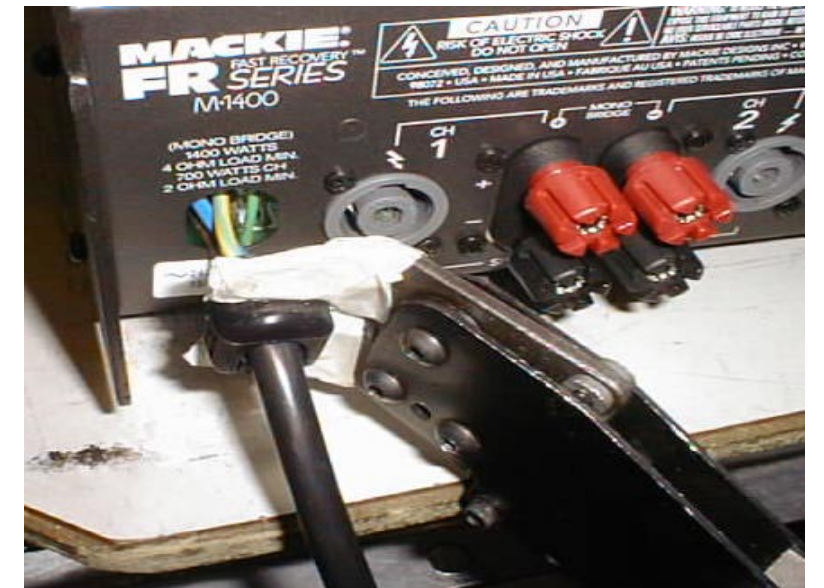
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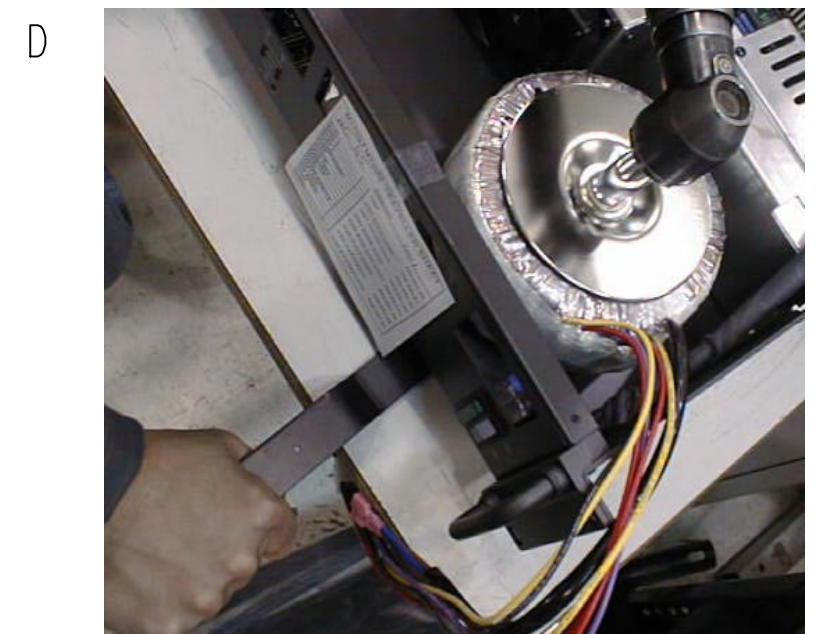
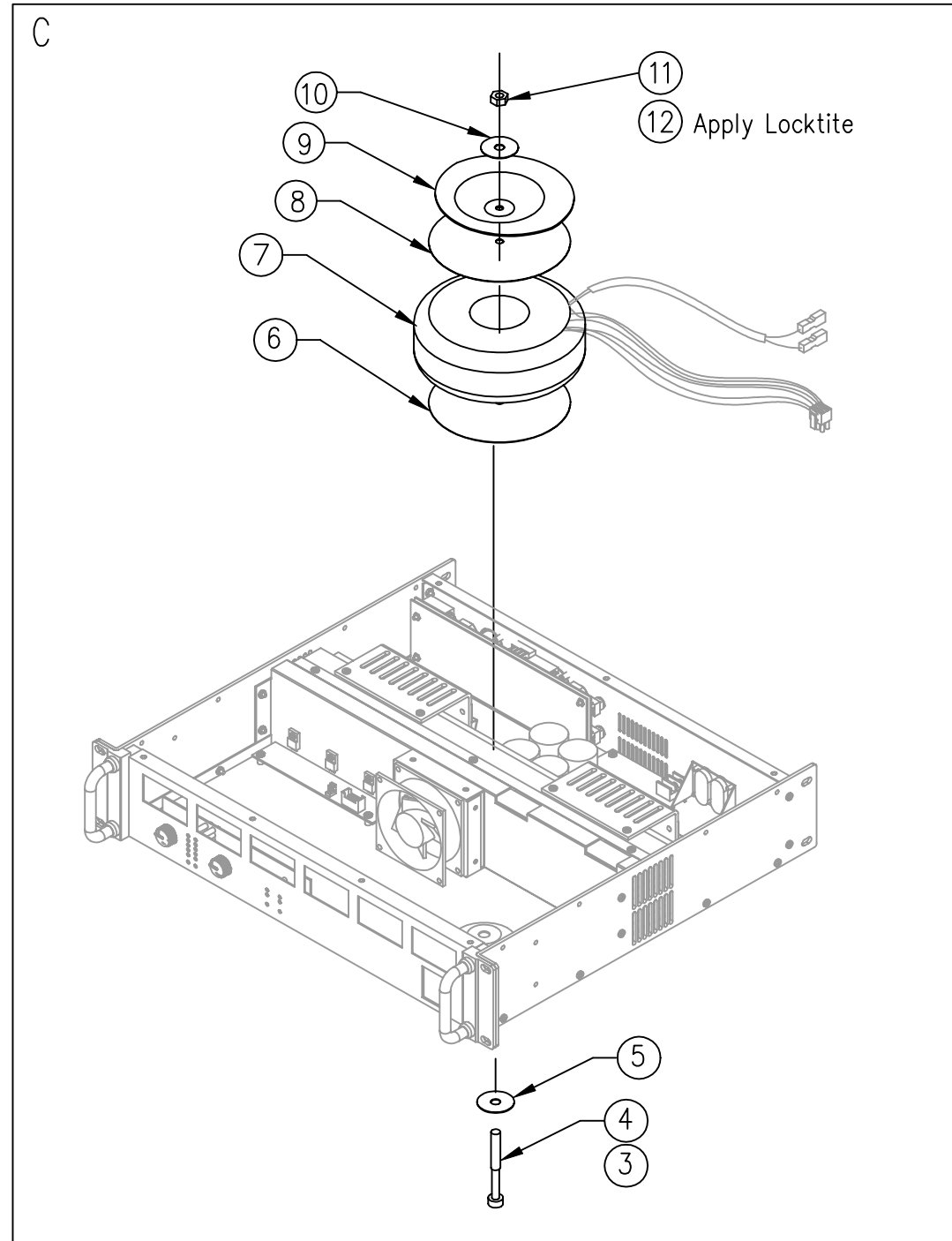
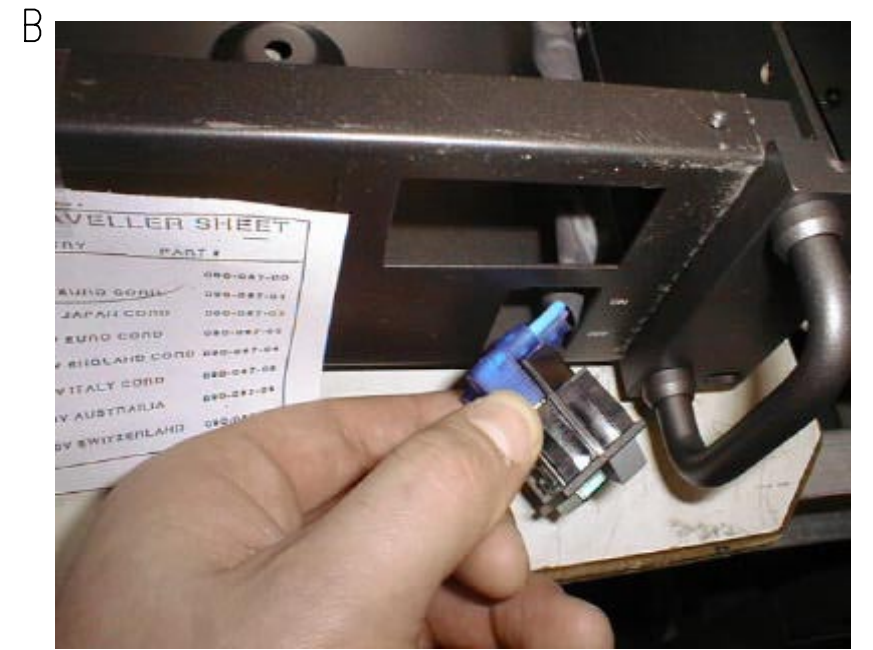


B



C



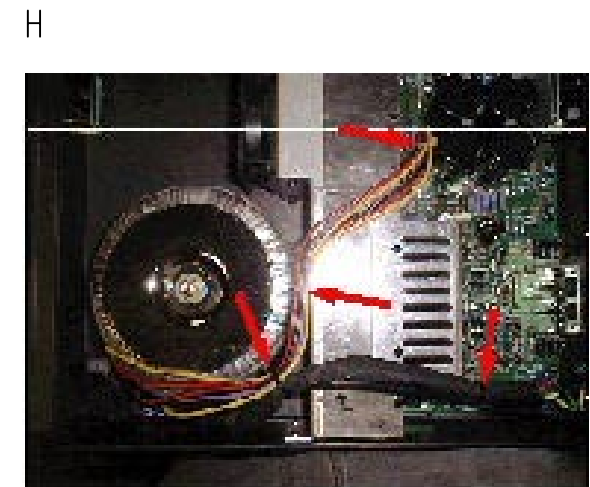
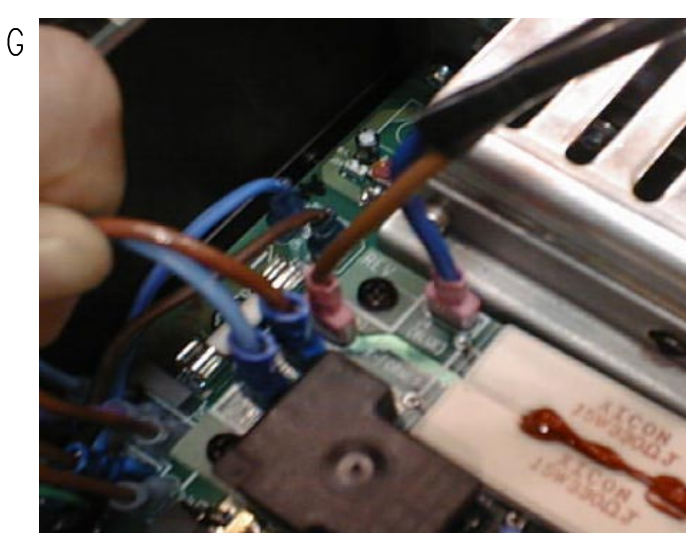
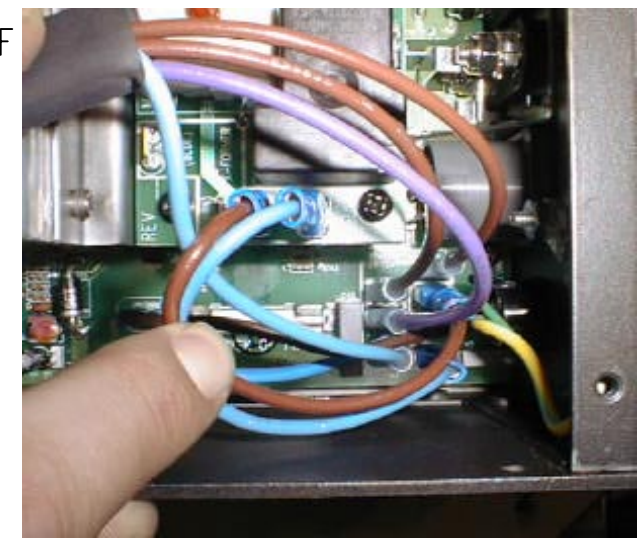
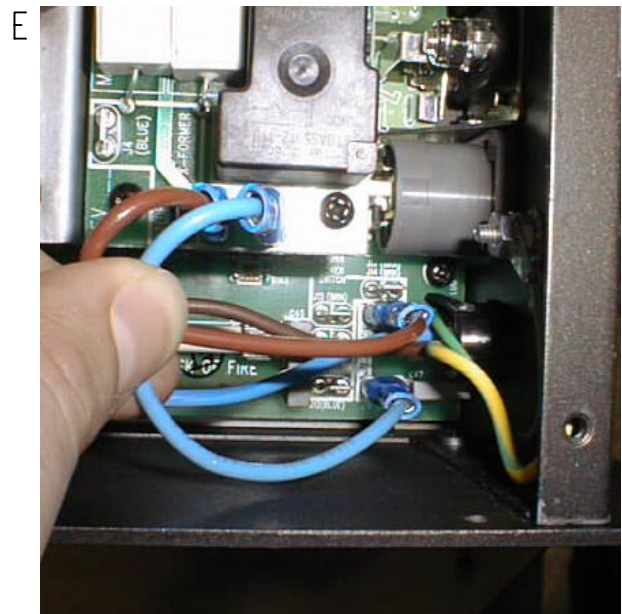
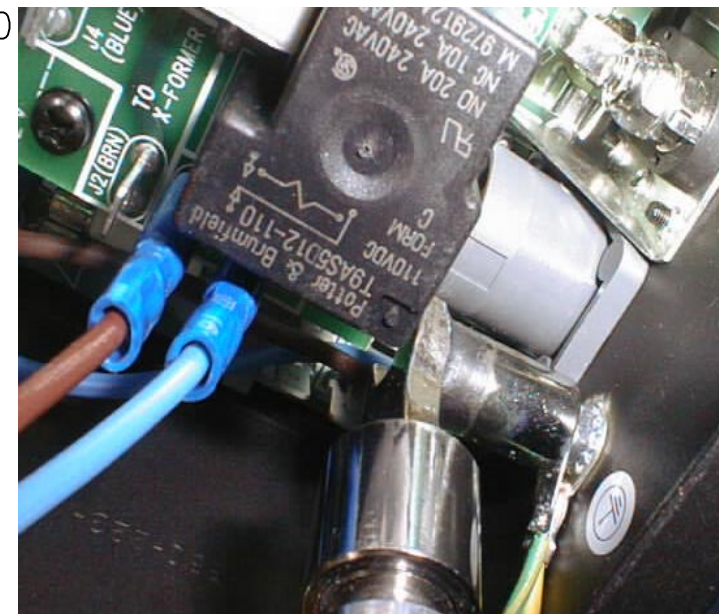
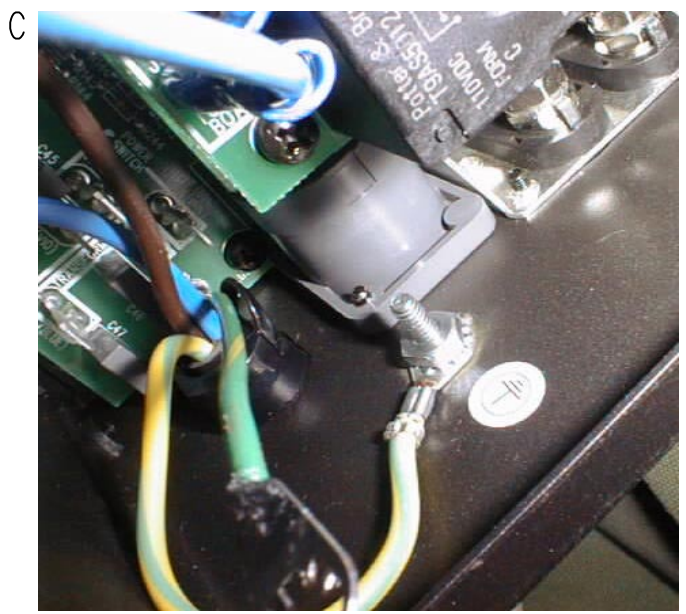
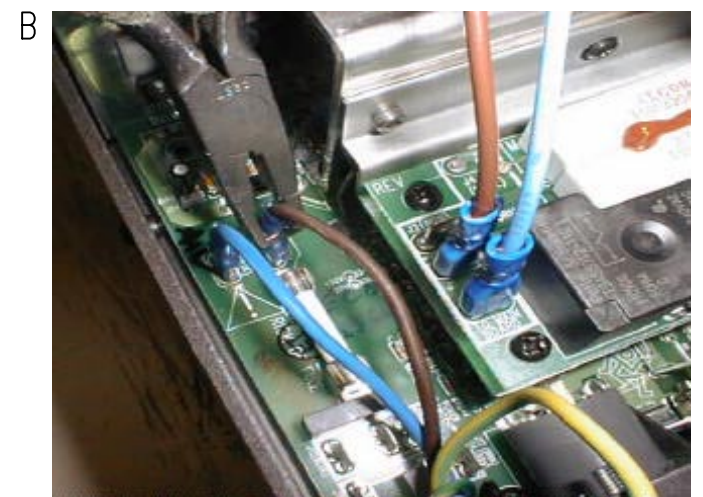


STEP	TASK
A	INSTALL ITEM ① WIRE HARNESS (1X) ONTO ITEM ② SWITCH (1X). <b>NOTE: GENTLY BEND ONE OF THE CONTACT TABS THAT THE BROWN WIRE PLUGS INTO. THIS WILL ALLOW BOTH WIRES TO BE PLUGGED ON AS SHOWN.</b>
B	INSTALL ITEM ② SWITCH INTO CHASSIS.
C	INSTALL ITEM ⑦ TRANSFORMER AND ALL HARDWARE SHOWN IN DIAGRAM IN CHASSIS.
D	ITEM ④ 3" BOLT IS USED ON 230 VOLT VERSIONS ONLY [090-137-(01, 03, 04, 05, 06, 07)]. ITEM ③ 2 3/4" BOLT IS USED ON 100 VOLT AND 120 VOLT MODELS [090-137-(00 AND 02)].
E	USE TRANSFORMER TABLE TO DETERMINE PROPER TRANSFORMER
F	BE SURE PRIMARY WIRES (BLACK INSULATED WIRES) EXIT THE TRANSFORMER PERPENDICULAR TO THE RIGHT SIDE. TIGHTEN TRANSFORMER.
G	APPLY ITEM ⑫ LOCTITE (A/R) TO TRANSFORMER NUT AND BOLT THREADS.

ITEM	DESCRIPTION	PART NUMBER	QTY	TORQUE IN LBS
1	SWITCH HARNESS	080-035-00	1	
2	SWITCH	500-022-00	1	
3	5/16 x 2 3/4 BOLT	700-106-00	1	
4	5/16 x 3 BOLT	700-059-00	1	
5	5/16 WASHER	710-024-00	1	
6	RIBBER DISC	780-111-00	1	
7	TRANSFORMER	USE TABLE "E"	1	
8	RUBBER DISC	780-111-00	1	
9	METAL DISC	550-249-00	1	
10	5/16 WASHER	710-024-00	1	
11	5/16 STOVER NUT	705-019-00	1	145
12	LOCTITE BLUE 242	730-016-00	A/R	

TRANSFORMER TABLE	
MODEL	TRANSFORMER
090-137-00	600-016-00 120 VOLT
090-137-02	600-016-02 100 VOLT
090-137-01 (-03, -04, -05, -06, -07)	600-016-01 230 VOLT

STEP	TASK								
A	<p><b>CAUTION: BEFORE INSTALLING FUSE, BE ABSOLUTELY SURE YOU ARE USING THE PROPER FUSE FOR THE MODEL YOU ARE ASSEMBLING. DO NOT TRUST PART NUMBERS ON BINS. PHYSICALLY LOOK AT FUSE AND VERIFY VALUE. BE SURE FUSE IS HELD TIGHT WITH FUSE CLIPS.</b></p> <table border="1"> <thead> <tr> <th>MODEL</th> <th>FUSE</th> </tr> </thead> <tbody> <tr> <td>090-067-00 (120V) 090-067-02 (100V)</td> <td>510-017-00/20 AMP SLO BLO</td> </tr> <tr> <td>090-097-01, 03, 04 05, 06, 07 (240V)</td> <td>510-023-00/8 AMP SLO BLO</td> </tr> </tbody> </table>			MODEL	FUSE	090-067-00 (120V) 090-067-02 (100V)	510-017-00/20 AMP SLO BLO	090-097-01, 03, 04 05, 06, 07 (240V)	510-023-00/8 AMP SLO BLO
MODEL	FUSE								
090-067-00 (120V) 090-067-02 (100V)	510-017-00/20 AMP SLO BLO								
090-097-01, 03, 04 05, 06, 07 (240V)	510-023-00/8 AMP SLO BLO								
B	CONNECT LINE CORD WIRES AS SHOWN.								
C	CONNECT LINE CORD GROUND WIRE TO STUD USING ITEM ① KEPNUT (1X). TIGHTEN BEFORE PROCEEDING.								
D	CONNECT PCB GROUND WIRE TO STUD USING ITEM ① KEPNUT (1X).								
E	<b>SOFT START MODELS ONLY:</b> PLUG BLUE AND BROWN WIRES FROM SOFT START TO MAIN PCB LABELED J34:BLUE, J:35 BROWN.								
F	PLUG IN SWITCH WIRES AS LABELED ON PCB J31:BLUE, J32:VIO, J33:BRN, J36:BRN.								
G	SOFT START MODELS: PLUG PRIMARY WINDINGS FROM TRANSFORMER INTO SOFT START AS SHOWN. OTHER MODELS: PLUG DIRECTLY INTO MAIN PCB J34:BLUE, J:35 BROWN.								
H	INSTALL ITEM ③ BLACK TYWRAPS (2X) AS SHOWN ON TRANSFORMER/SWITCH WIRES. INSTALL ITEM ④ WHITE TYWRAPS (2X) ON TRANSFORMER SECONDARY WIRES: ONE ON EACH SIDE OF THE HEATSINK.								
ITEM	DESCRIPTION	P/N	QTY						
1	#6 KEPNUT	705-001-00	2						
2	8" BLACK TYWRAP	740-003-00	2						
3	WHITE TYWRAP	740-001-00	2						



STEP	TASK
A	INSTALL ITEM ② BEZEL (1X) AND ITEM ③ TOP COVER (1X). START ITEM ④ SCREWS (8X) INTO SIDES. INSTALL ITEM ① TOP SCREWS (7X).
B	TIGHTEN SCREWS ONLY AFTER ALL SCREWS HAVE BEEN STARTED.

A



B



ITEM	DESCRIPTION	PART NUMBER	QTY	TORQUE IN LBS
1	MCH SCREW #6 FLAT	700-041-04	7	7
2	M1400 FRONT BEZEL	551-029-10	1	
3	TOP COVER	550-564-00	1	
4	6-32 x 5/16 SEMS SCREW	700-028-01	8	7