

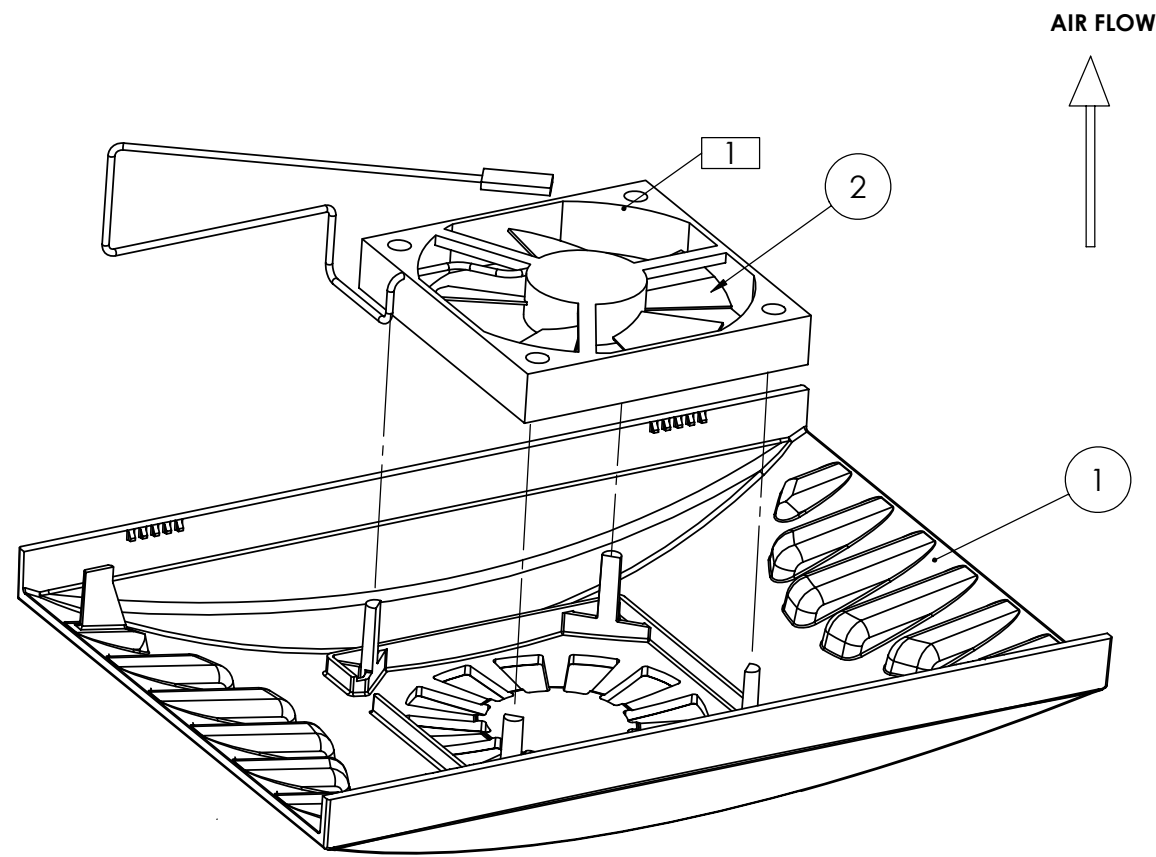
REVISIONS					
REV	ECO	ZONE	DESCRIPTION	DATE	APPROVED
03			RELEASE FOR PROTOTYPE	07-10-04	
A	10072		RELEASE FOR PRODUCTION	09-7-04	

ITEM NO.	PART NUMBER	NOTE
1	FAN HOUSING	1
2	FAN	1
3	POWER BOARD	1
4	THERMAL INTERFACE MATERIAL	1
5	GROUNDING CLIP	1
6	HEATSINK	1
7	INPUT BOARD	1
8	SPACER	1
9	SCREW	1
10	SCREW	1
11	BASE	1
12	LABEL, DATA	1
13	SCREW	1
14	LABEL, LOGO	1
15	LABEL, WARRANTY	1
16	HARDWARE ID LABEL	1

NOTE:  
 1. REFER TO SPECIFIC MODULE ASSEMBLY BOM FOR PART NUMBER AND DESCRIPTION ASSOCIATED WITH EACH ITEM NUMBER.  
 2. USE ONLY PARTS REQUIRED BY A SPECIFIC BOM.  
 3. NOT ALL PARTS MAY BE REQUIRED.

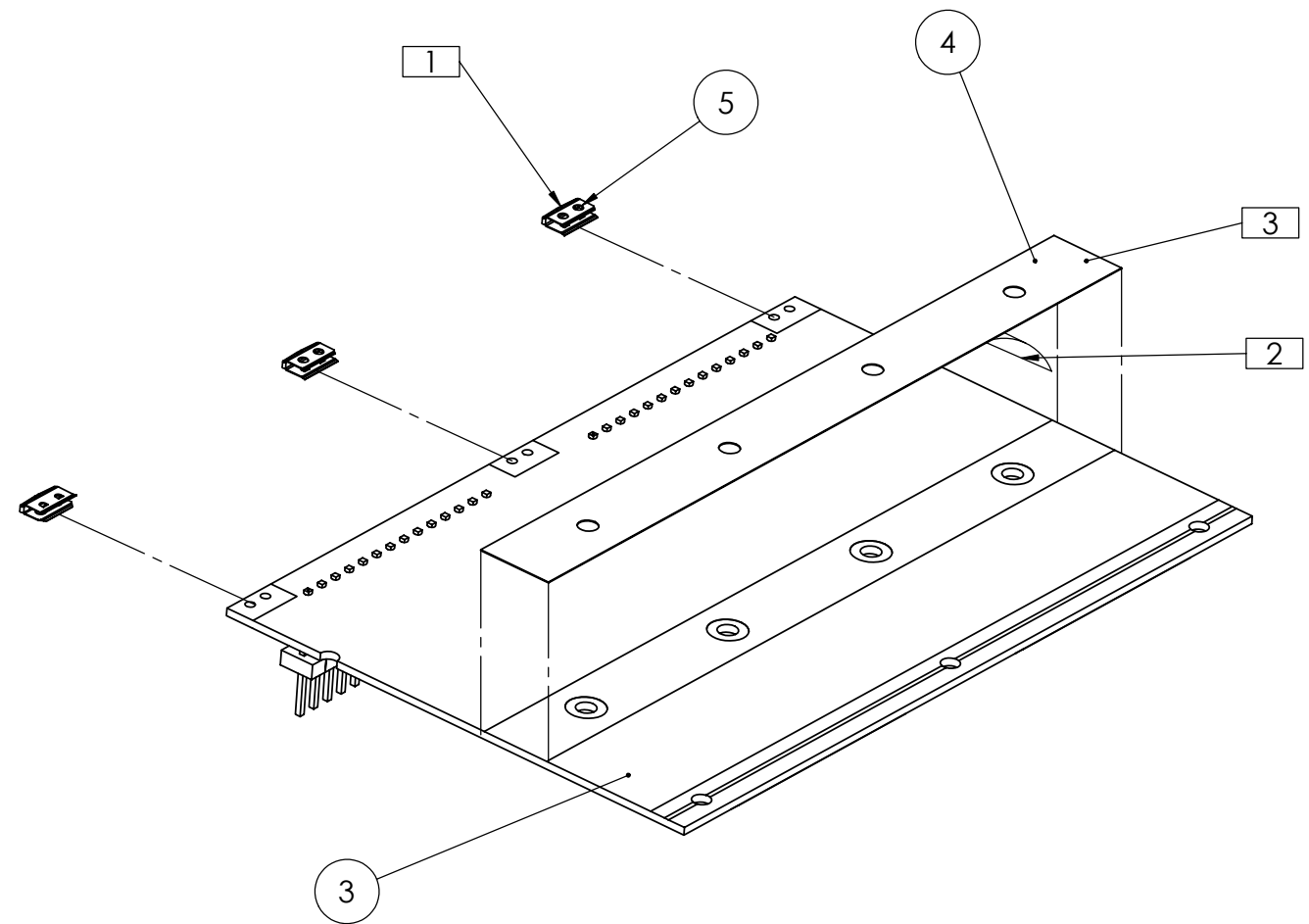
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		PROJECT		<b>D2AUDIO</b>
TOLERANCES ARE:		APPROVALS	DATE	
FRACTIONAL	DECIMAL	ANGULAR		<b>MODULE ASSY, X-SERIES, 8 CHANNEL</b>
X ± 1/32	.XX ± 0.01	± 1°	5-18-04	
	.XXX ± 0.005			
MATERIAL		CHECKED	5-18-04	
FINISH		APPROVED		
NEXT ASSY	USED ON			SIZE DWG NO.
				<b>0901-000001-000</b>
APPLICATION		DO NOT SCALE DRAWING		REV <b>A</b>
				SCALE: 1.5:1 FILE NAME SHEET 1 OF 5

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NOTES FOR FAN HOUSING SUB-ASSEMBLY:

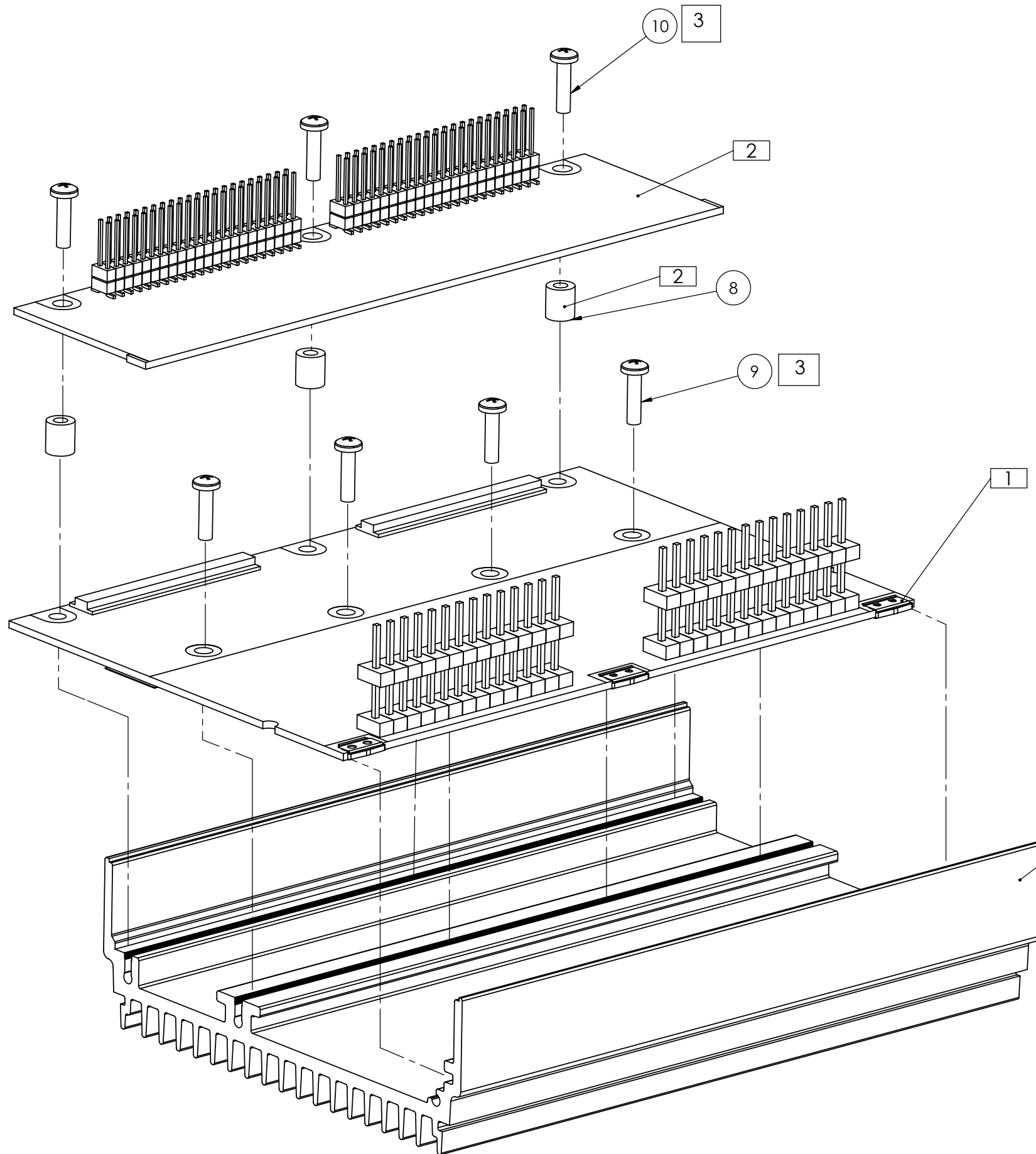
1. PLACE THE FAN OVER THE 4 MOLDED POSTS. HEAT STAKE THE FAN IN PLACE USING A HOT IRON OR SONIC WELD. BE SURE TO ORIENT THE FAN FOR PROPER AIR FLOW DIRECTION.



NOTES FOR POWER PCB SUB ASSEMBLY:

1. INSERT 3 ea. GROUNDING CLIPS (ITEM 5) ON THE PCB, BEING SURE THAT THE 2 TABS ENGAGE IN THE HOLES PROPERLY.
2. REMOVE THE PAPER BACKING FROM THE THERMAL INTERFACE MAT'L. AND INSTALL THE ADHESIVE SIDE ON THE PCB AS SHOWN. USE THE HOLES TO ALIGN.
3. IF A MISTAKE IS MADE AND THE THERMAL INTERFACE MAT'L HAS TO BE REPLACED, BE SURE TO CLEAN OFF ALL THE REMNANTS FROM THE BOARD AND HEATSINK BEFORE INSTALLING A NEW THERMAL INTERFACE STRIP. REFER TO PART MANUFACTURERS RECOMMENDATION.

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MATERIAL: SEE NOTES/BOM		TITLE: <b>MODULE ASSY X-SERIES, 8-CHANNEL SUB-ASSEMBLY</b>	
FINISH: SEE NOTES/BOM		DWG. NO.	REV.
DO NOT SCALE DRAWING		<b>0901-000001-000 A</b>	
		SCALE: 1:1	SHEET 2 OF 5



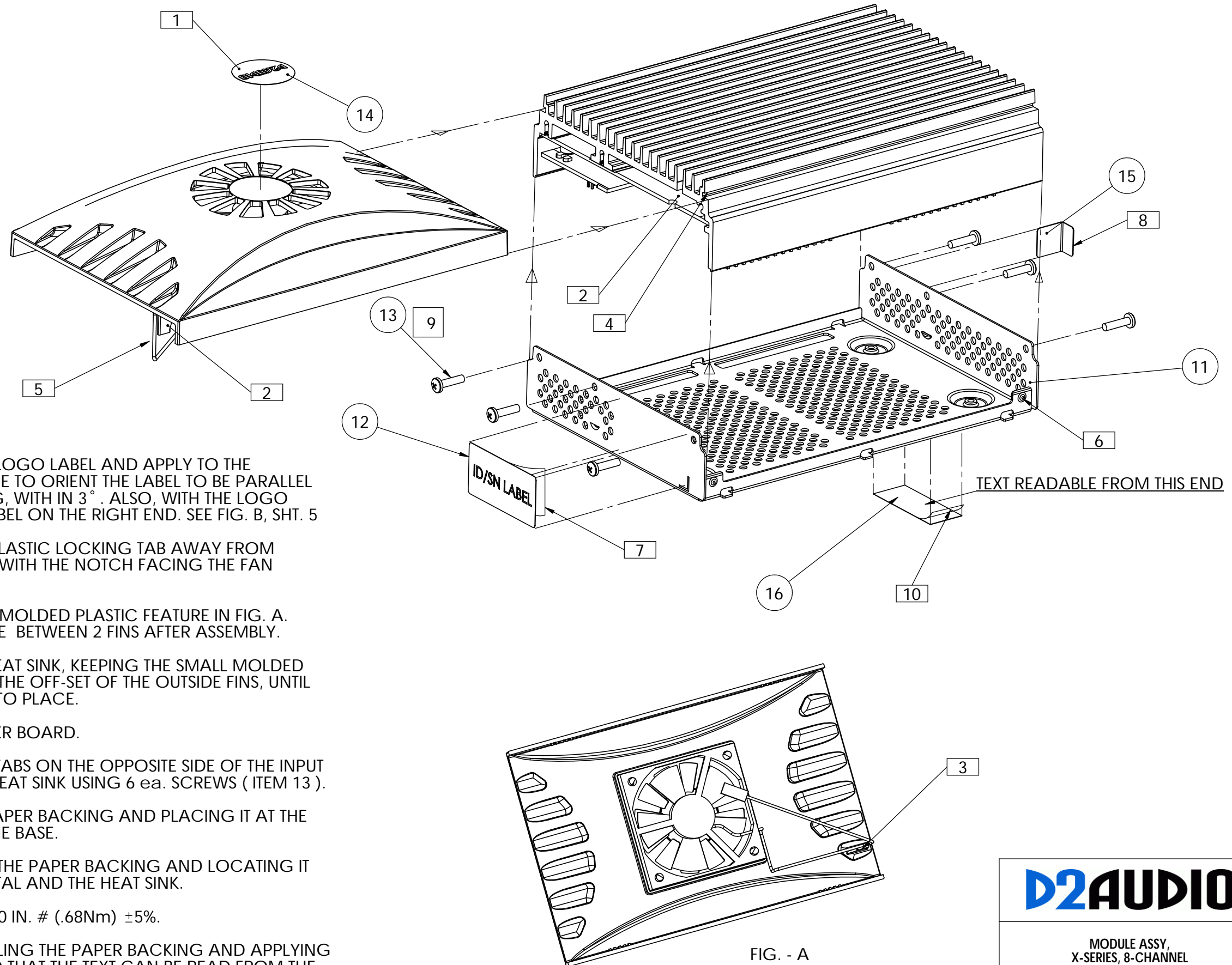
NOTES FOR PCB ASSEMBLY TO HEAT SINK:

1. INSERT THE EDGE OF THE POWER PCB WITH THE CLIPS AT A SLIGHT ANGLE INTO THE CHANNEL OF THE HEAT SINK. ROTATE THE BOARD TOWARD THE HEAT SINK UNTIL IT RESTS ON THE SHELF AT THE OPPOSITE SIDE. SECURE WITH 4ea. SCREWS (ITEM 9).
2. INSTALL INPUT BOARD ADDING 3ea. SPACERS (ITEM 8) BETWEEN THIS BOARD AND THE POWER PCB. SECURE WITH 3ea. SCREWS (ITEM 10).
3. TORQUE SCREWS (ITEM 9 & 10) TO 8 IN. LBS. (.91 Nm) ± 5%.
4. IF DISASSEMBLY OF THE PCB FROM THE HEATSINK IS REQUIRED, THE THERMAL INTERFACE MATERIAL (TIM) MUST BE REPLACED, AND BOTH BOARD AND HEATSINK MUST BE FREE OF ANY TIM REMNANTS.



MODULE ASSY,  
X-SERIES, 8-CHANNEL  
TEST LEVEL ASSY.

SIZE D	DWG NO. 0901-000001-000	REV A
FILE NAME		SHEET 3 OF 5



NOTES FOR FINAL ASSEMBLY:

1. PEEL THE PAPER BACKING FROM THE LOGO LABEL AND APPLY TO THE CENTER OF THE FAN HOUSING. BE SURE TO ORIENT THE LABEL TO BE PARALLEL WITH THE LONG SIDE OF THE HOUSING, WITH IN 3°. ALSO, WITH THE LOGO BEING READABLE, HAVE THE ID/SN LABEL ON THE RIGHT END. SEE FIG. B, SHT. 5
2. ORIENT THE FAN HOUSING WITH THE PLASTIC LOCKING TAB AWAY FROM THE HEAT SINK. ORIENT THE HEAT SINK WITH THE NOTCH FACING THE FAN HOUSING.
3. ARRANGE THE FAN CABLE INSIDE THE MOLDED PLASTIC FEATURE IN FIG. A. THIS WILL ALLOW THE CABLE TO RESIDE BETWEEN 2 FINS AFTER ASSEMBLY.
4. SLIDE THE FAN HOUSING ONTO THE HEAT SINK, KEEPING THE SMALL MOLDED BARBS ON THE FAN HOUSING UNDER THE OFF-SET OF THE OUTSIDE FINS, UNTIL THE MOLDED LOCKING TAB SNAPS INTO PLACE.
5. ATTACH THE FAN CABLE TO THE POWER BOARD.
6. ORIENT THE BASE WITH THE 2 DETENT TABS ON THE OPPOSITE SIDE OF THE INPUT BOARD. ASSEMBLE THE BASE TO THE HEAT SINK USING 6 ea. SCREWS ( ITEM 13 ).
7. APPLY DATA LABEL BY PEELING THE PAPER BACKING AND PLACING IT AT THE STAMPED "LOCATION" FEATURE ON THE BASE.
8. APPLY WARRANTY LABEL BY PEELING THE PAPER BACKING AND LOCATING IT ON THE CORNER OVER THE SHEET METAL AND THE HEAT SINK.
9. TORQUE THE SCREWS ( ITEM 13 ) TO 6.0 IN. # (.68Nm) ±5%.
10. APPLY HARDWARE I.D. LABEL BY PEELING THE PAPER BACKING AND APPLYING IT TO THE UNDERSIDE OF THE BASE SO THAT THE TEXT CAN BE READ FROM THE OUTSIDE AND END OF THE UNIT. PLACE THE LABEL BETWEEN THE 2 BOSS'S AND ABOUT 1/4 INCH FROM THE EDGE. BE CAREFUL NOT TO COVER ANY VENT HOLES.

FIG. - A

<b>D2AUDIO</b>		
MODULE ASSY, X-SERIES, 8-CHANNEL FINAL ASSEMBLY		
SIZE D	DWG NO. 0901-000001-000	REV A
FILE NAME		SHEET 4 OF 5

LOGO ORIENTATION

ID/SN LABEL

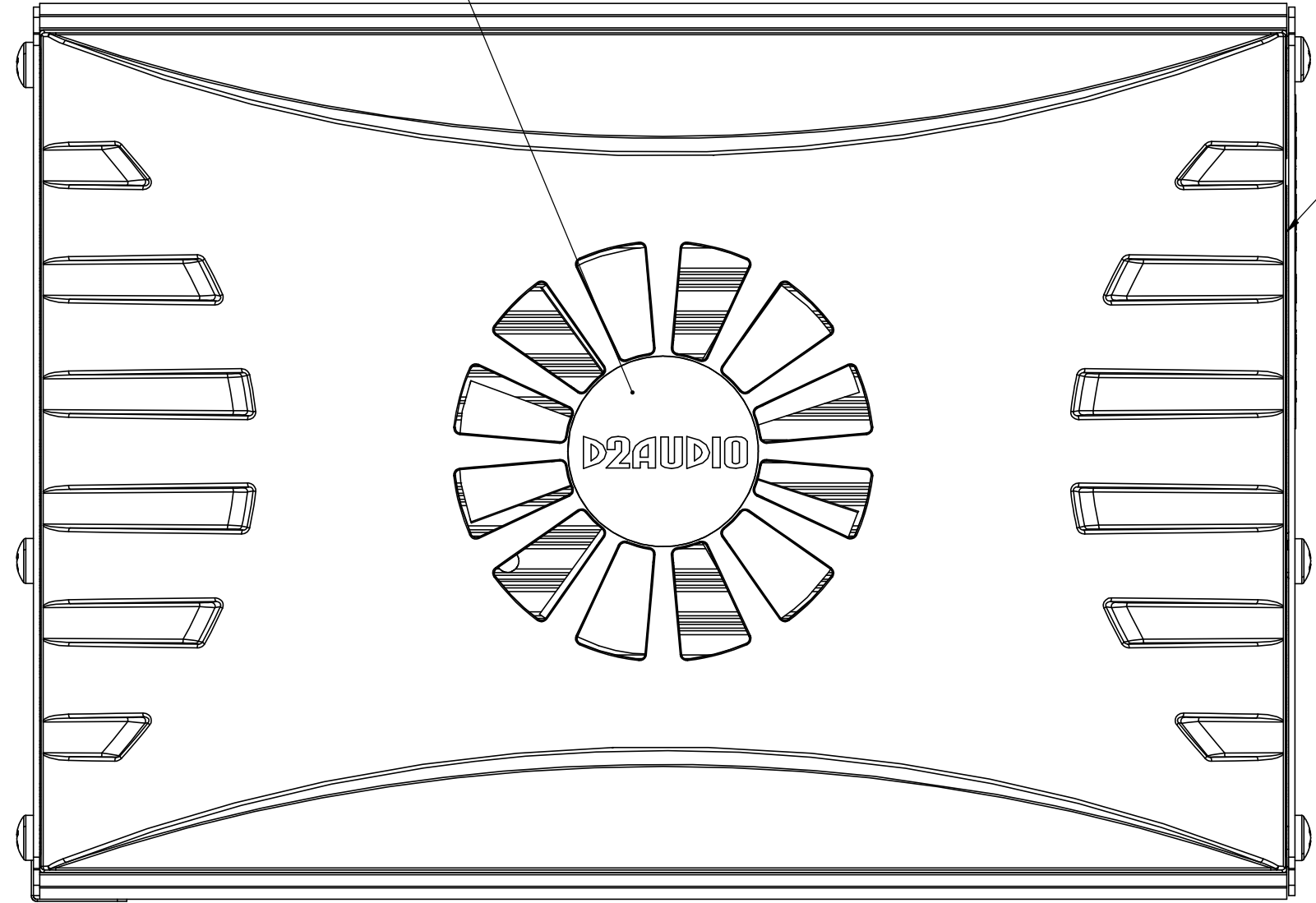


FIG. B

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MATERIAL: SEE NOTES/BOM		TITLE: <b>MODULE ASSY., X-SERIES, 8-CHANNEL FINAL ASSEMBLY</b>	
FINISH: SEE NOTES/BOM		DWG. NO. 901-000001-000	REV. A
DO NOT SCALE DRAWING		SCALE: 1:1	SHEET 5 OF 5

XSeries\_8\_chnl Assy view\_sh14