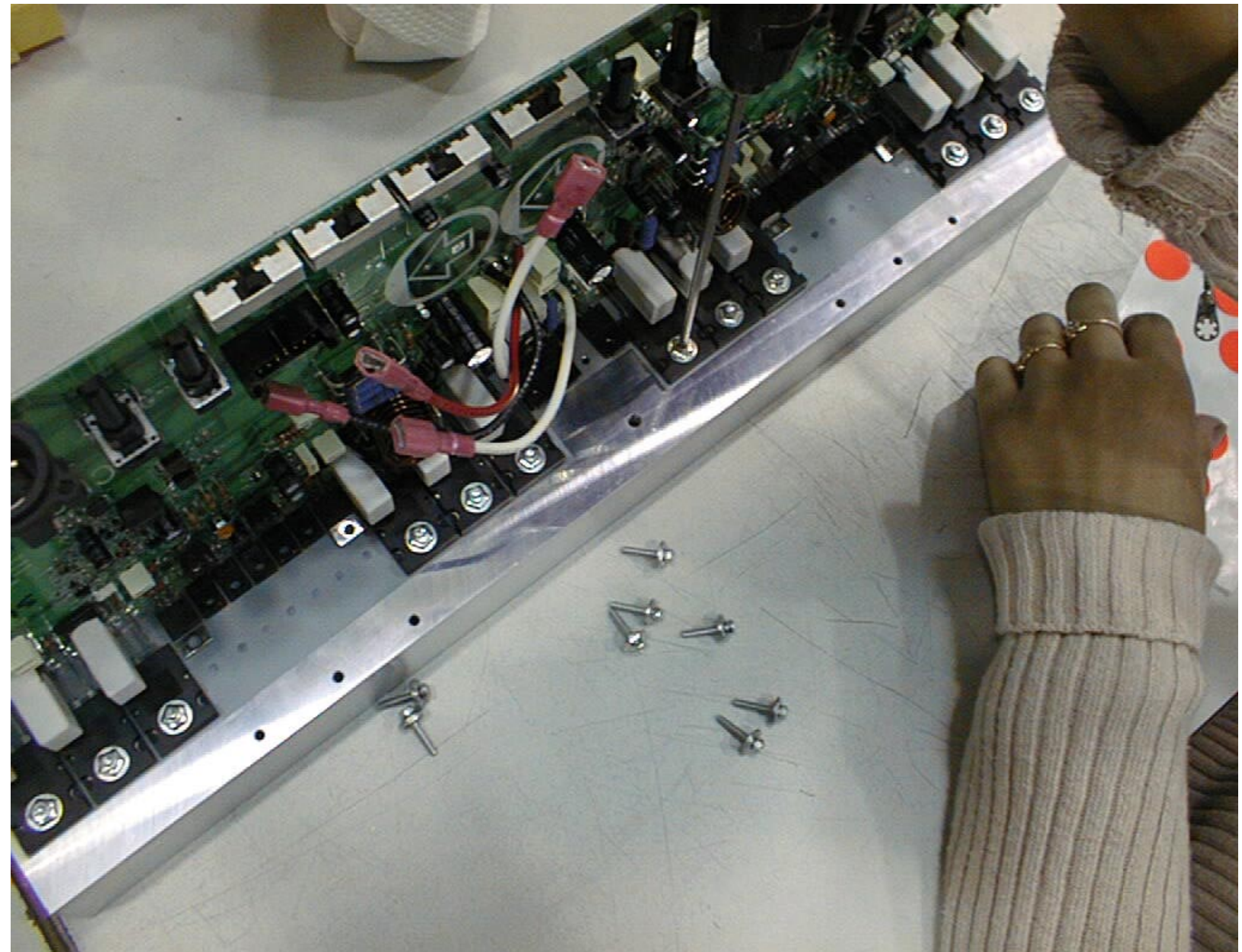


STEP	DESCRIPTION
A	INSPECT ITEM ② PCB (1X) FOR SOLDER BRIDGES, MISSING PARTS, BACKWARD PARTS, LIFTED PARTS, ETC.
B	CLEAN ITEM ① HEATSINK (1X).
C	CLEAN ITEM ③ SILPAD (1X) AND APPLY SMALL AMOUNT OF ITEM ④ THERMALKOTE IN THREE PLACES ON HEATSINK TO HOLD SILPAD.
D	PLACE ITEM ③ SILPAD (1X) ON ITEM ① HEATSINK (1X), CAREFULLY ALIGNING HOLES. NOTE: IT IS ABSOLUTELY CRITICAL THAT ALL DIRT AND DEBRIS HAS BEEN CLEANED OFF OF SILPAD AND HEATSINK.



ITEM	PART NUMBER	PART DESCRIPTION	QTY
1	551-066-00	HEATSINK	1
2	055-212-00	MAIN PCB	1
3	410-016-00	SILPAD	1
4	730-001-00	THERMALKOTE	A/R

STEP	DESCRIPTION
A	INSTALL ITEM ① CAMCAR SCREWS (12X) THROUGH LARGE COMPONENTS IN HEATSINK. TIGHTEN STARTING IN CENTER AND WORKING OUTWARDS. NOTE: BE SURE SCREWS ARE STRAIGHT WHILE TIGHTENING.



ITEM	PART NUMBER	PART DESCRIPTION	QTY	TORQUE IN. LBS.
1	700-088-00	3/8" CAM CAR SCREWS	12	13

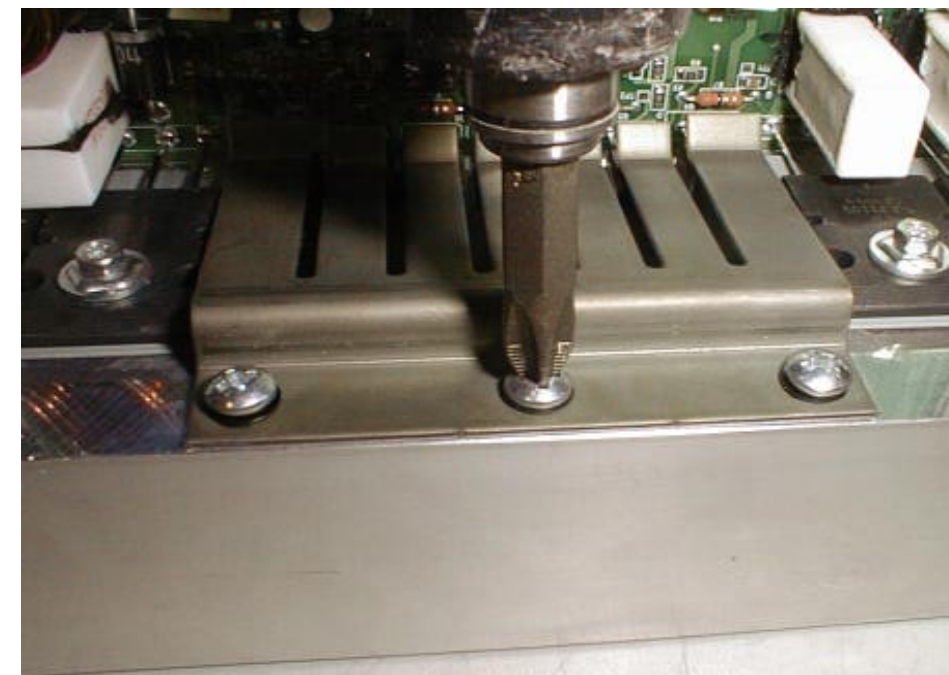
B-2 M800 HEATSINK SUB-ASSEMBLY

STEP	DESCRIPTION
A	INSTALL ITEM ① SPRING CLAMPS (2X) ONTO HEATSINK USING ITEM ② SCREWS (6X). NOTE: START ALL SPRING CLAMP SCREWS FIRST BEFORE TIGHTENING. TIGHTEN EACH SCREW IN SMALL STEPS. LIGHTLY TIGHTEN ALL SCREWS FIRST, THEN FULLY TIGHTEN CENTER SCREW COMPLETELY, FOLLOWED BY THE TWO OUTER SCREWS.
B	GO BACK AND RE-TIGHTEN SCREWS TO VERIFY ALL ARE AT PROPER TORQUE.

A-1



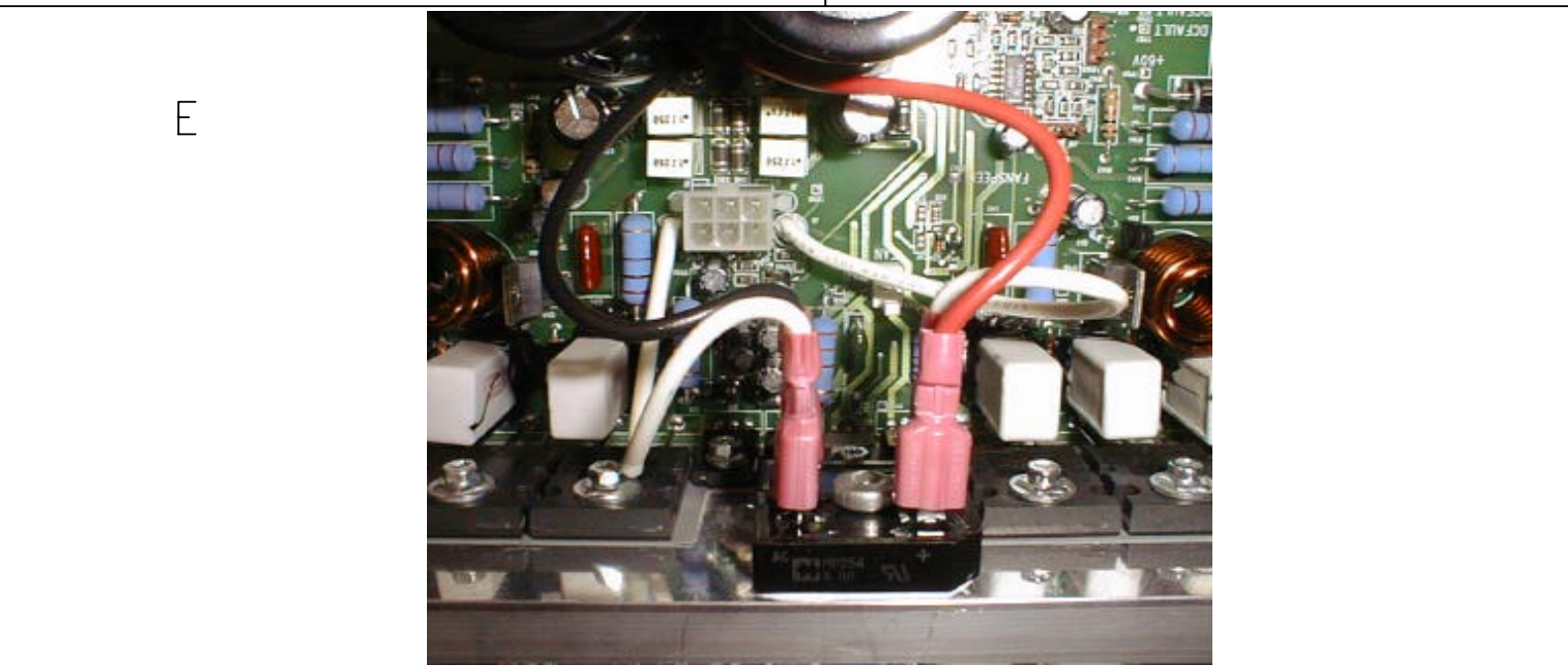
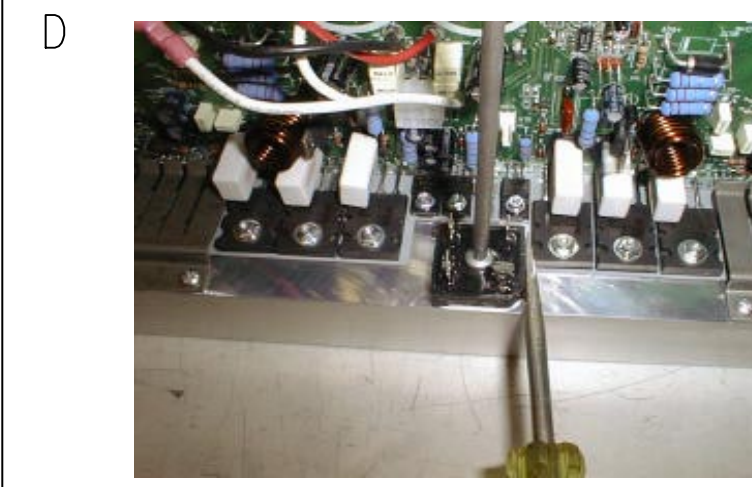
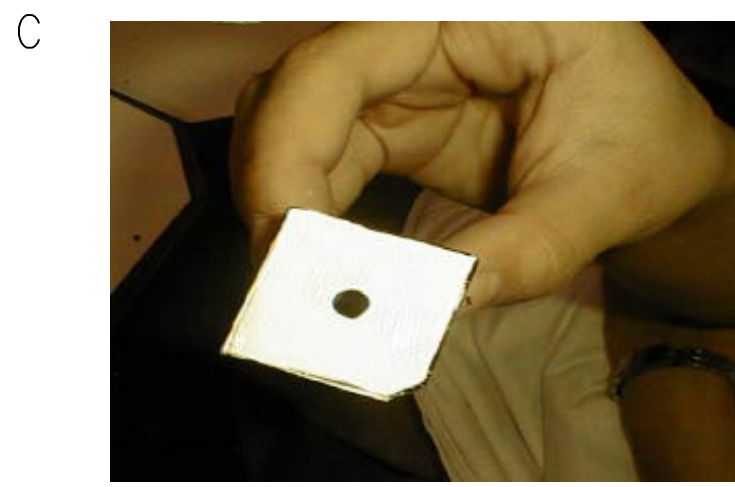
A-2



THEN TIGHTEN
CENTER SCREW

ITEM	PART NUMBER	PART DESCRIPTION	QTY	TORQUE IN. LBS.
1	550-563-00	SPRING CLAMP	2	
2	700-035-04	#6 THREAD FORMING SCREW	6	13
3	710-005-00	#6 STAR WASHER	6	

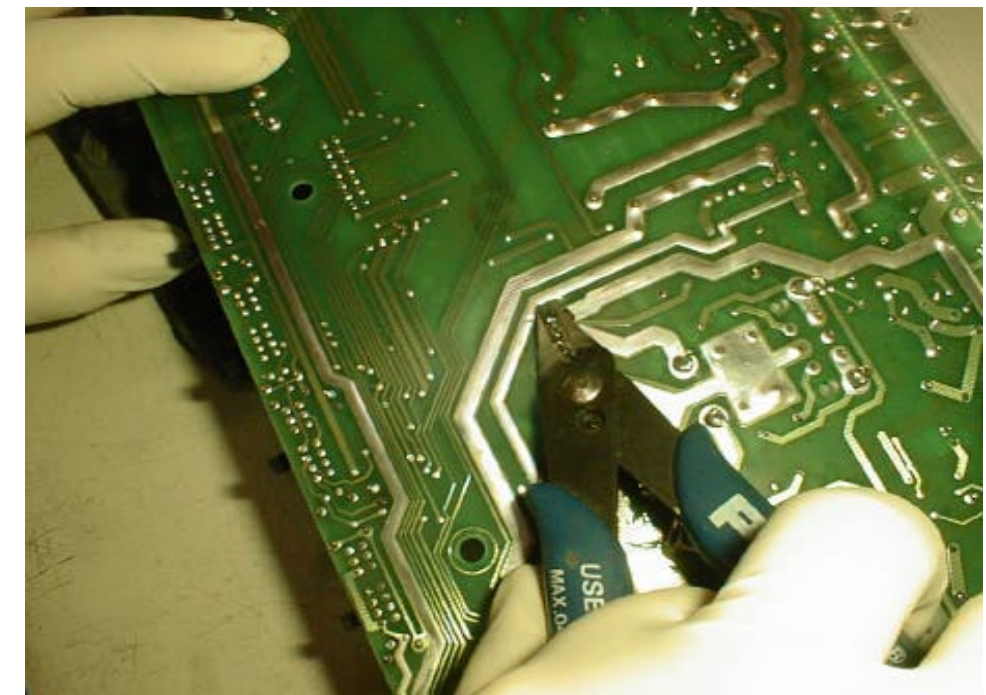
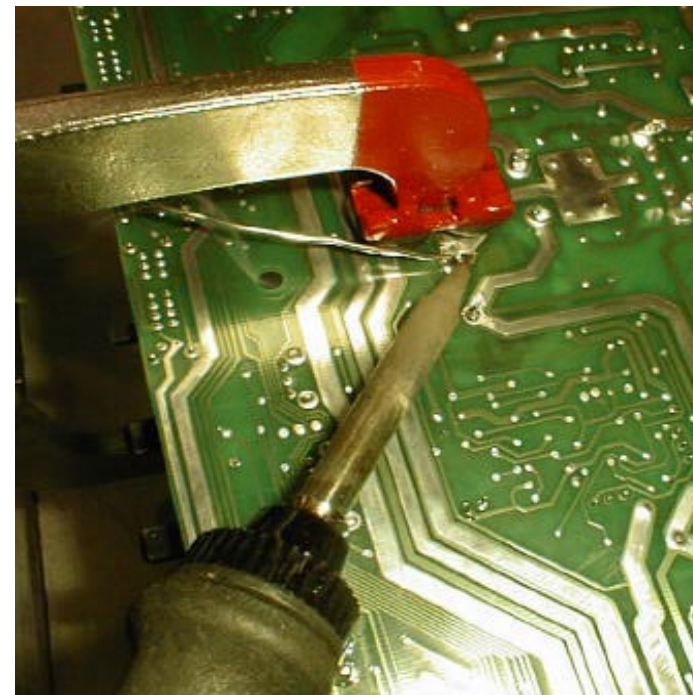
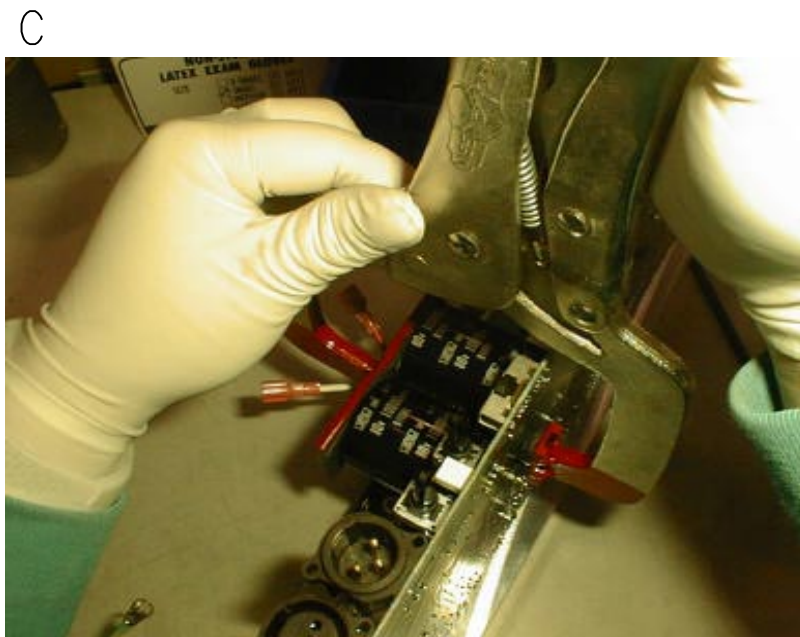
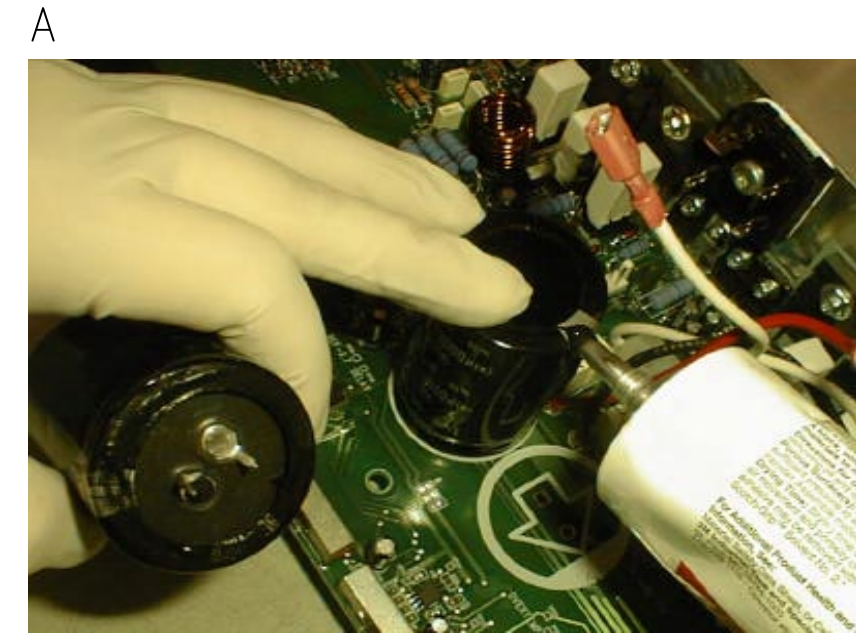
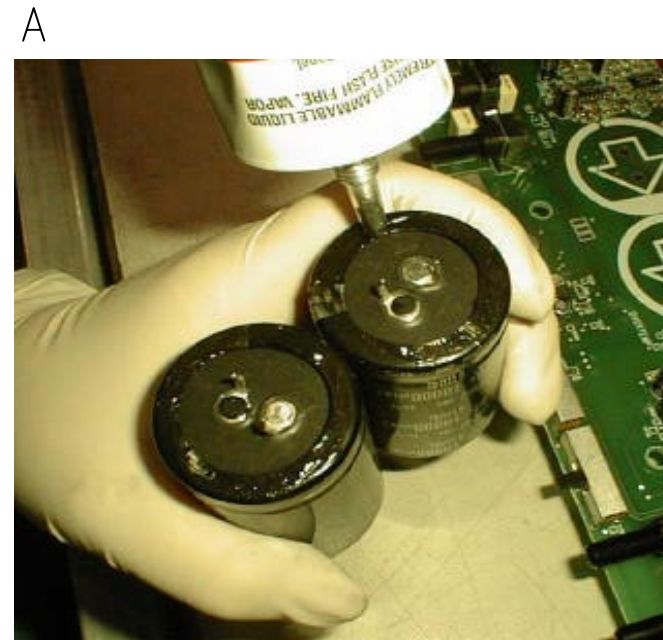
STEP	DESCRIPTION
A	INSTALL REMAINING TRANSISTOR HARDWARE, ITEM ① CAMCAR SCREW (3X) AND ITEM ⑥ FLAT WASHER (3X) THROUGH SMALLER CENTER DEVICES. NOTE: WHEN TIGHTENING SMALLER DEVICES TAKE CARE TO SLOW THE DRIVER DOWN WHILE TIGHTENING. BE CAREFUL TO AVOID BENDING THE COMPONENT LEADS.
B	INSTALL ITEM ② THERMAL SENSOR CLAMP USING ITEM ① CAMCAR SCREW.
C	APPLY A THIN EVEN FILM OF ITEM ③ THERMAL JOINT COMPOUND TO ITEM ④, BACK SIDE OF RECTIFIER.
D	SECURE ITEM ④ RECTIFIER TO HEATSINK USING ITEM ⑤ TORX SCREW (1X).
E	CONNECT 4 WIRES FROM PCB TO RECTIFIER. BE SURE RECTIFIER IS POSITIONED CORRECTLY AND WIRES ARE CONNECTED AS SHOWN.



ITEM	PART NUMBER	PART DESCRIPTION	QTY	TORQUE IN. LBS.
1	700-087-00	1/4" CAMCAR SCREW	4	6
2	550-396-00	BRKT TO-92	1	
3	730-001-00	THERMAL JOINT COMPOUND	A/R	
4	301-022-00	DIO POWER BRDG	1	
5	700-117-00	#10-32 3/4" TF	1	16
6	710-036-00	#4 FLAT WASHER	3	

B-4 M800 HEATSINK SUB-ASSEMBLY

STEP	DESCRIPTION
A	APPLY ITEM ① ADHESIVE TO UNDERSIDE OF ITEM ② LARGE CAPS (2x) AND BETWEEN CAPS.
B	INSTALL ITEM ② LARGE FILTER CAPS (2X) ONTO PCB. NOTE: BE SURE CAPS ARE INSTALLED IN THE PROPER DIRECTION.
C	CLAMP CAPACITORS TO PCB USING CAPACITOR CLAMPING TOOL.
D	SOLDER CAPS INTO PLACE. TRIM LEADS AS NECESSARY. NOTE: IT IS VERY IMPORTANT THAT THE PROPER FUSE IS INSTALLED. CHECK THE FUSE P/N. ALSO LOOK AT THE INFORMATION MARKED ON THE FUSE AND VERIFY IT IS A "10 AMP" FUSE.
E	INSTALL ITEM ③ FUSE (1X) IN FUSE HOLDER AFTER VERIFYING IT IS THE CORRECT FUSE. NOTE: BE SURE THE FUSE CLIPS ARE NOT BENT AND THAT THE FUSE IS BEING HELD FIRMLY BY THE FUSE CLIPS.



ITEM	PART NUMBER	PART DESCRIPTION	QTY
1	730-003-00	3M ADHESIVE	A/R
2	220-033-00	LARGE FILTER CAPS, 10,000uF	2
3	510-028-00	FUSE SB 10 AMP	1