

E5063A

Dis-assembly Procedure

Reverse Flow Dis-assembly Procedure Menu

Click the hyperlink below for any choice of dis-assembly procedure:

1. [LCD](#)
2. [SSD](#)
3. [CPU Module](#)
4. [Display Board](#)
5. [A1 Module](#)
6. [Analog Board](#)

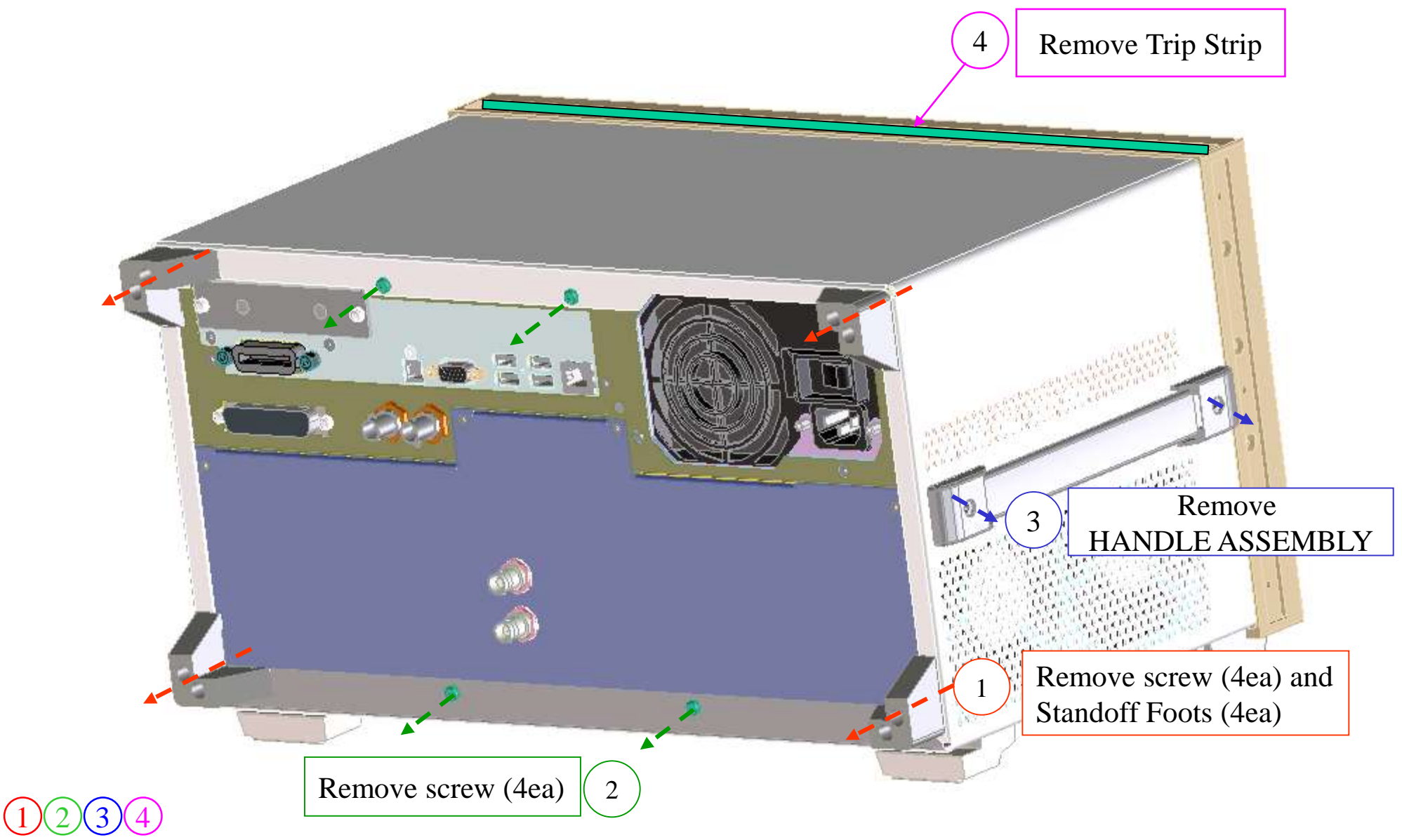
LCD

Dis-Assembly Procedure

Note:

1. Torque value shown in this document is only for reference and only used during assembly.





Remove Front sub-assy

1



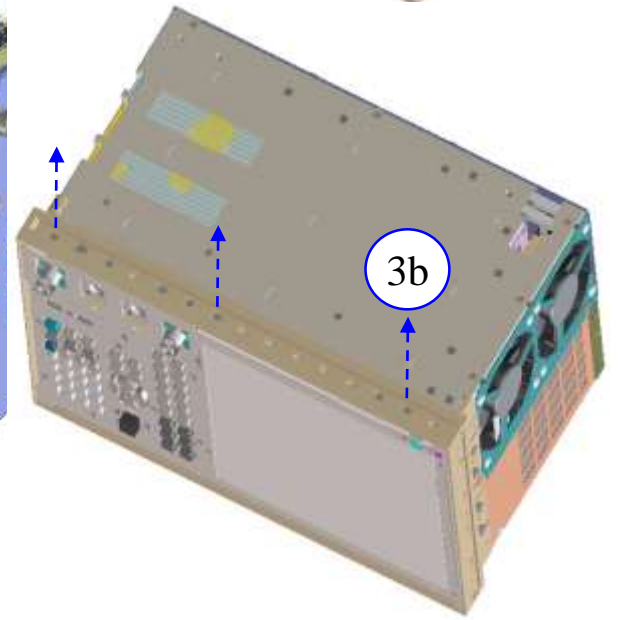
2

Disconnect flat cable of Front Panel Ass'y from CPU Module

1 2 3

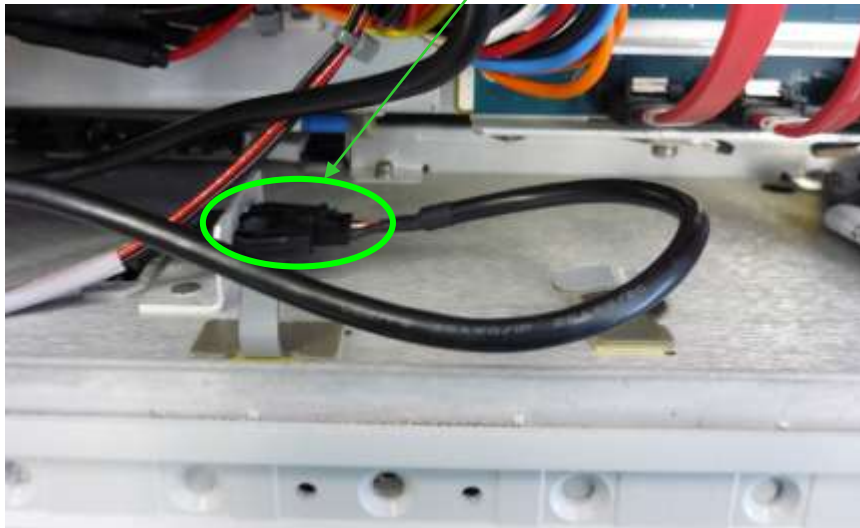
3a

Remove screw (7ea)

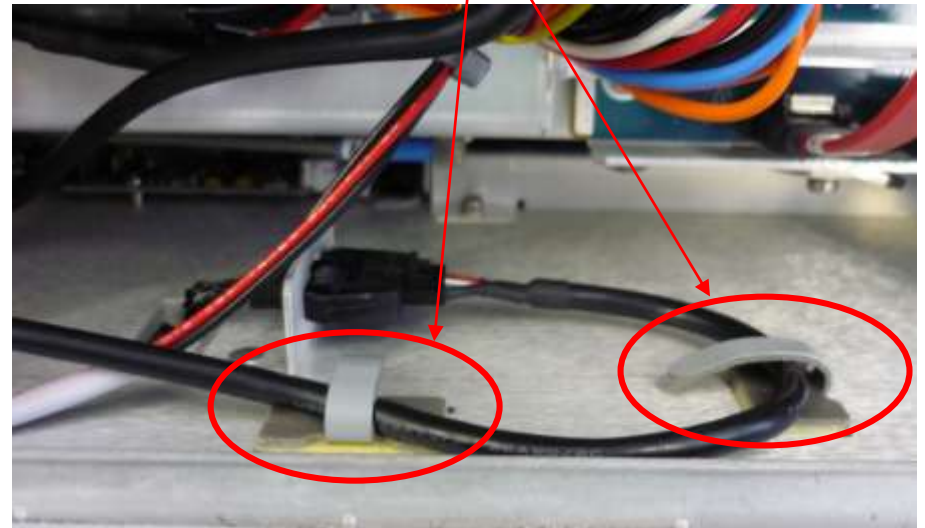


3b

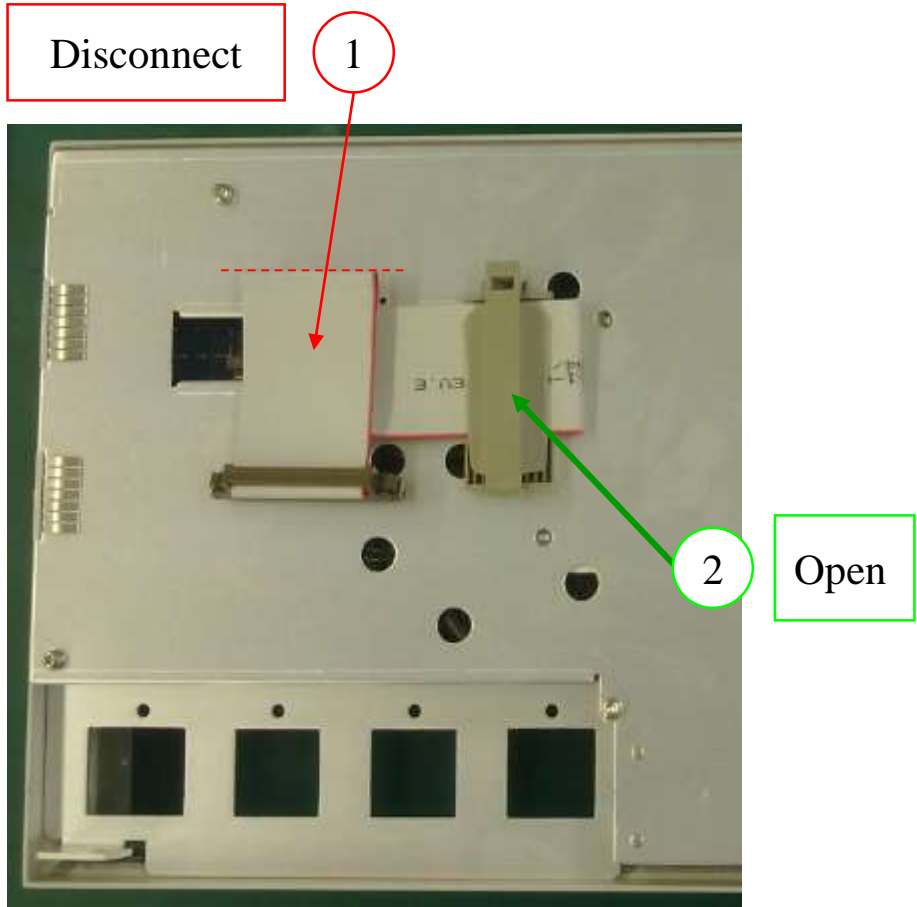
2 Disconnect



1 Open



① ②



① ②

Remove screw (6ea)

1

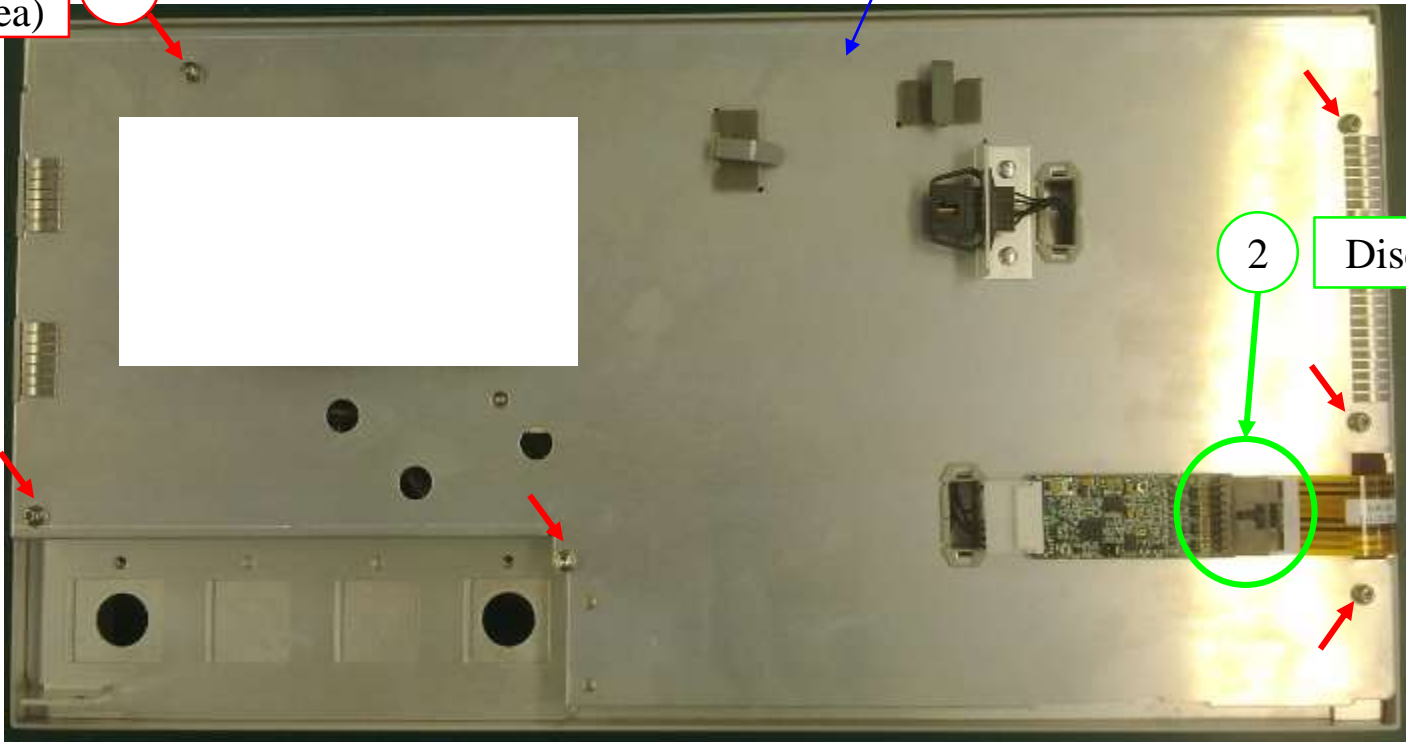
3

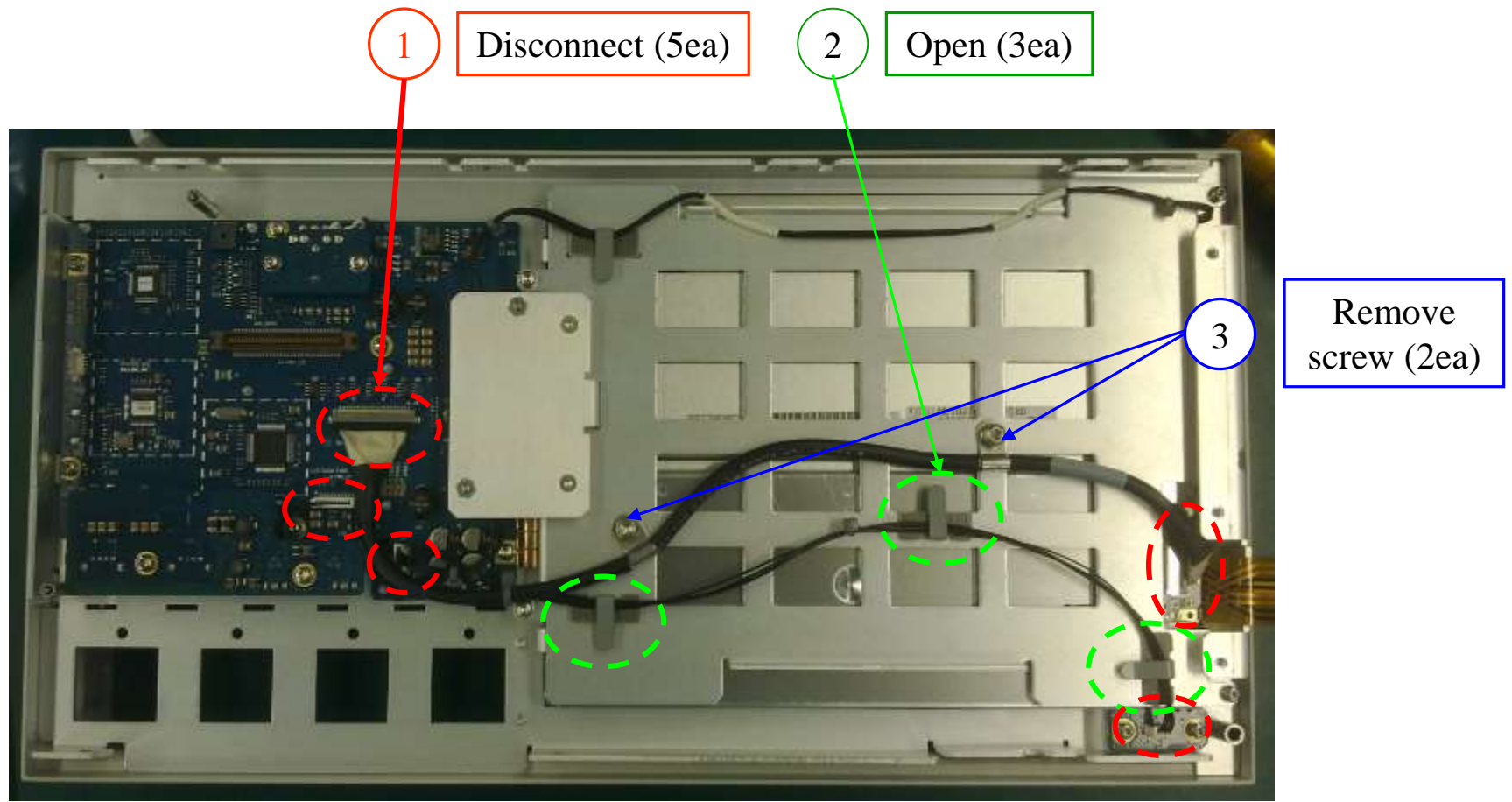
Remove

2

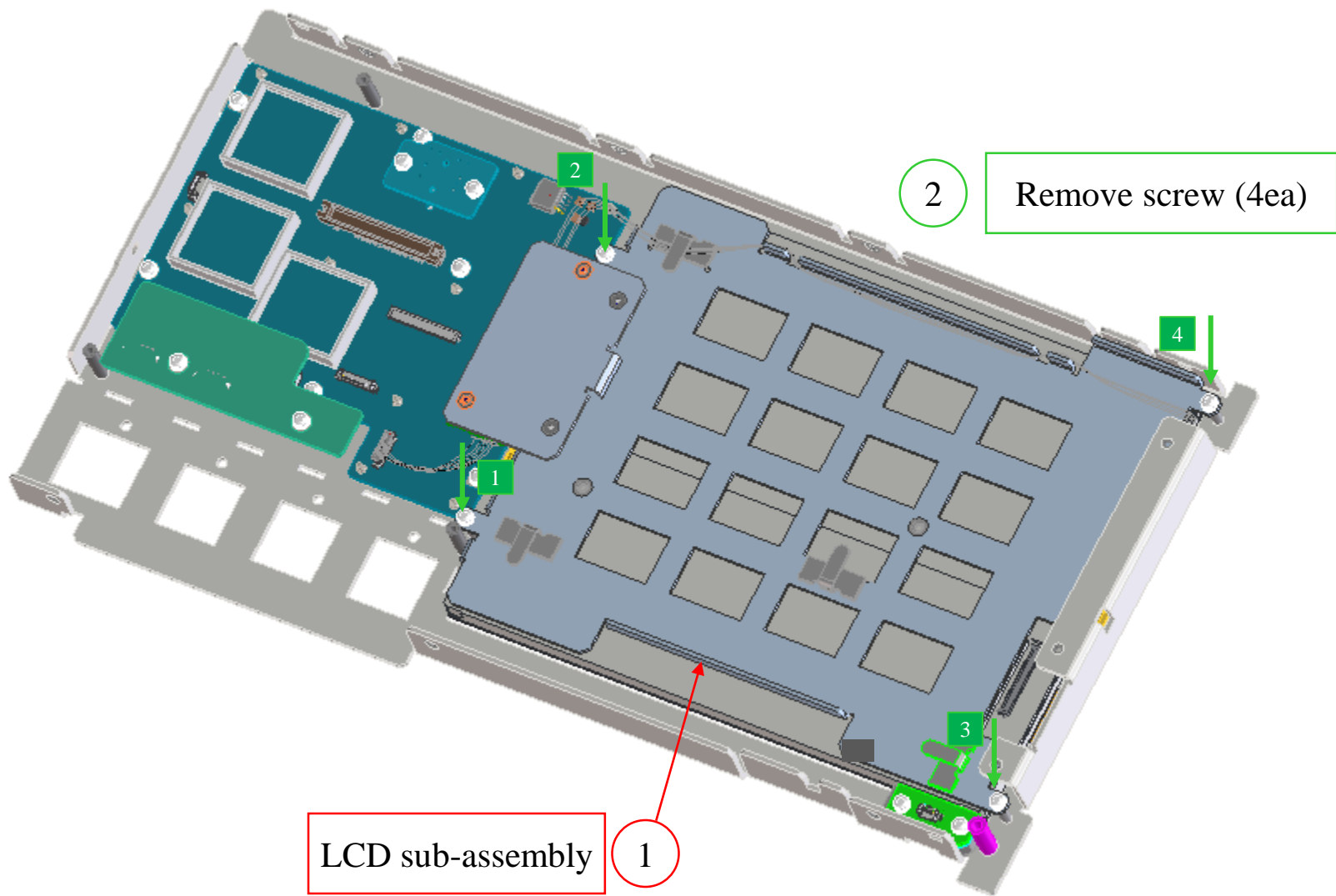
Disconnect

1 2 3





① ② ③



1 2

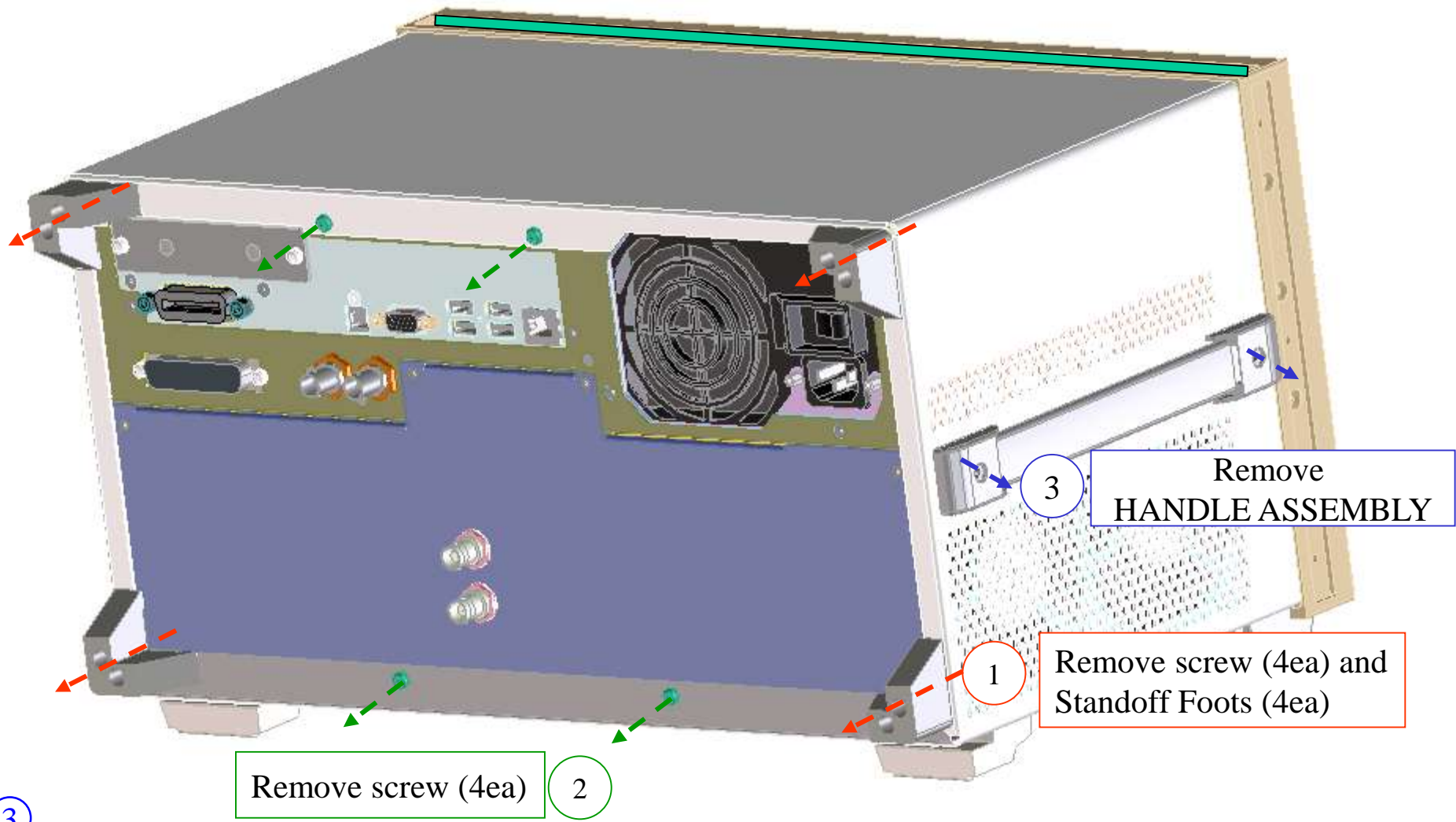
SSD

Dis-Assembly Procedure

Note:

1. Torque value shown in this document is only for reference and only used during assembly.



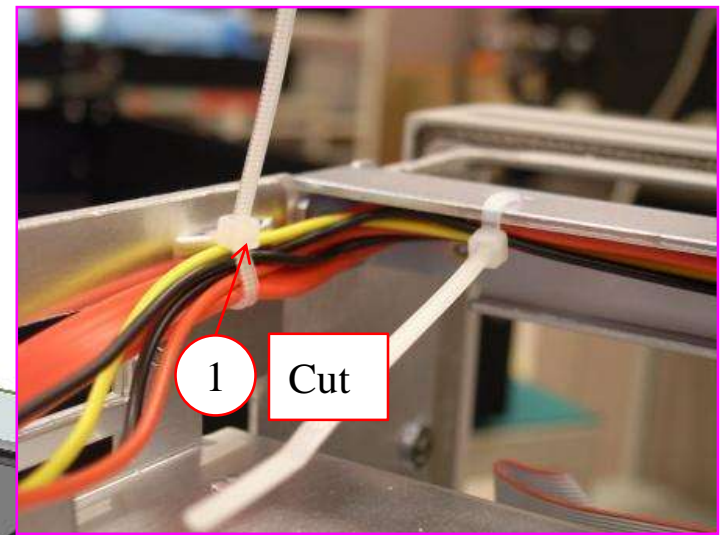
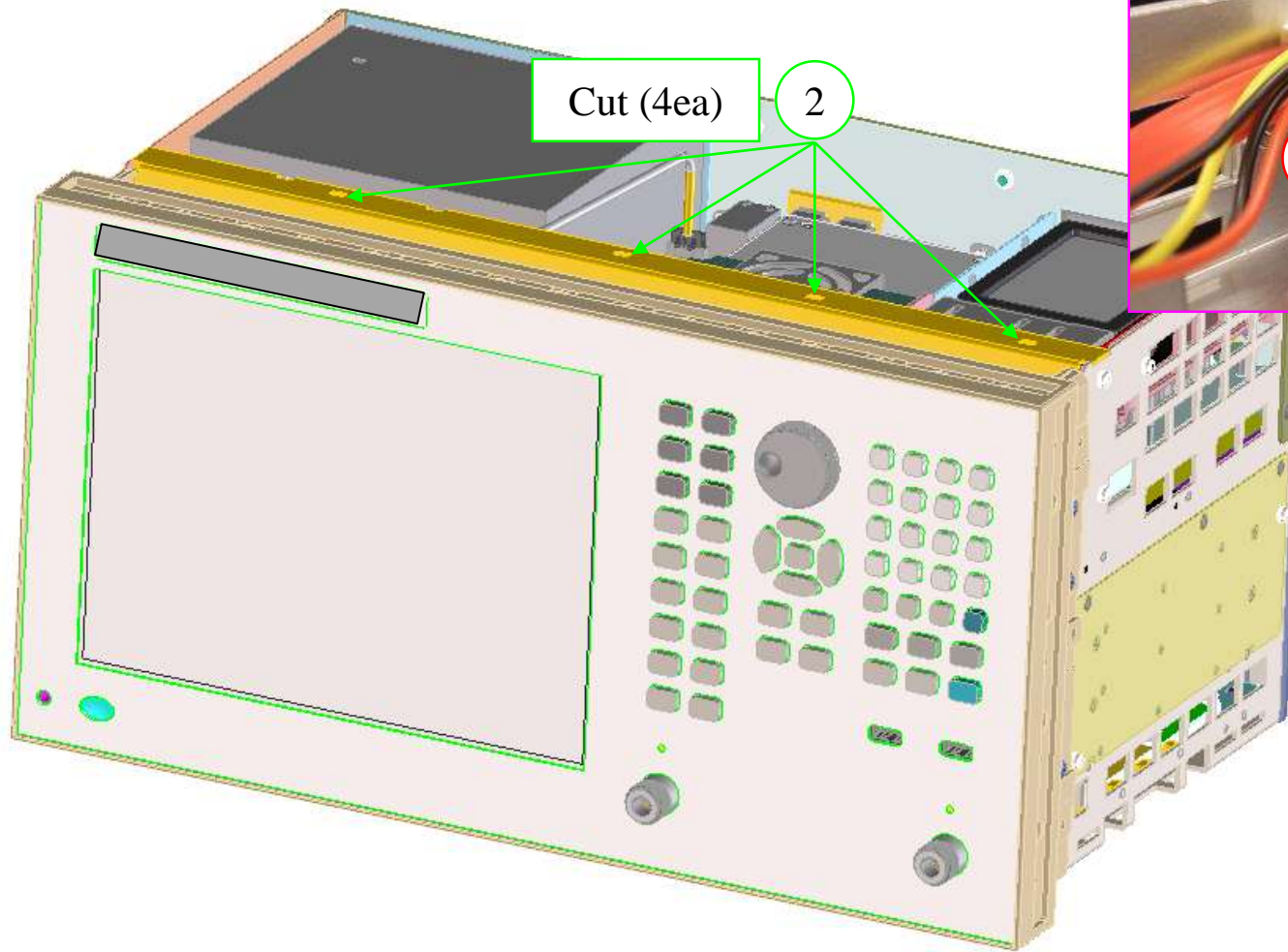


Remove
HANDLE ASSEMBLY

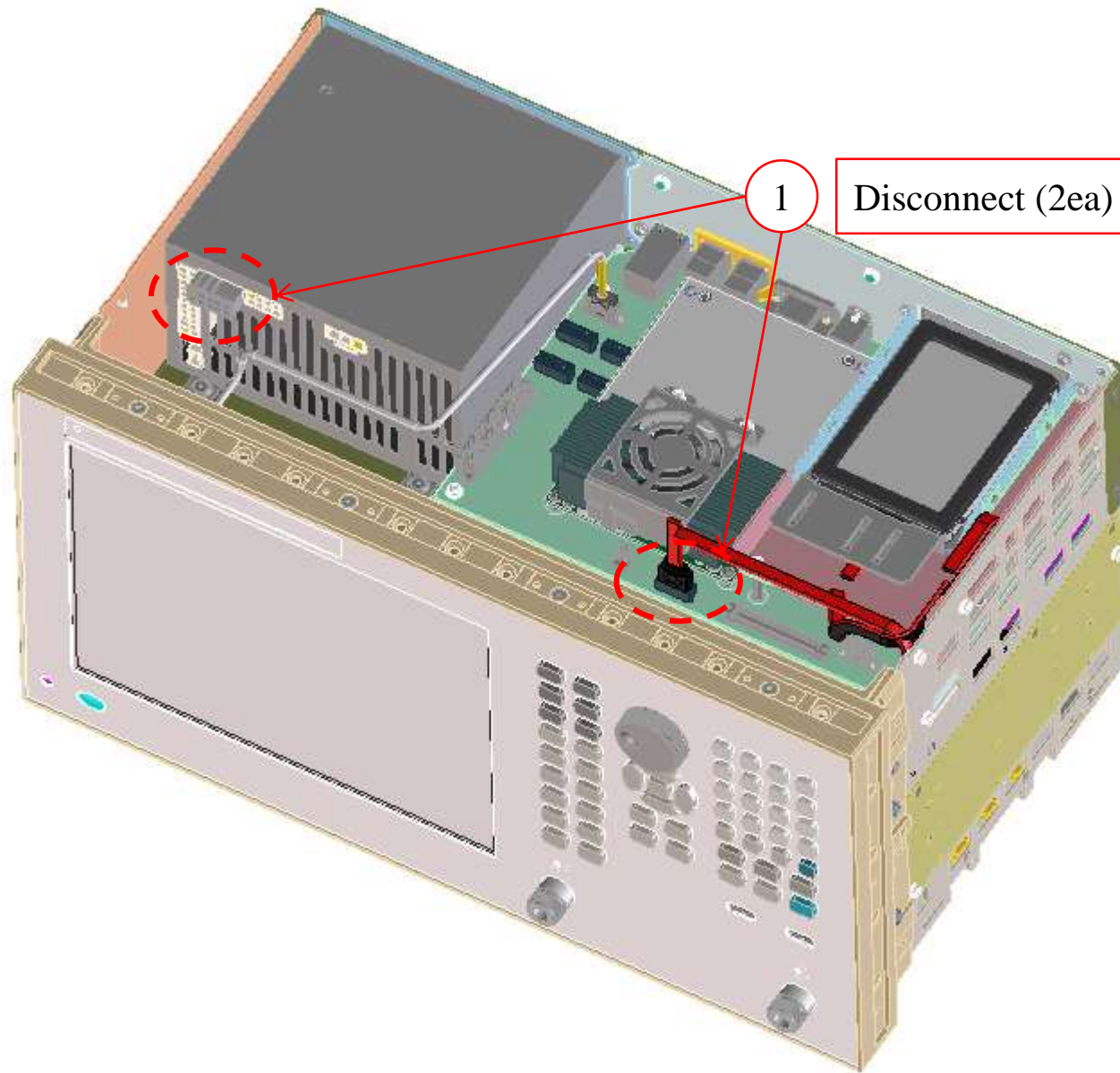
Remove screw (4ea) and
Standoff Feet (4ea)

Remove screw (4ea)

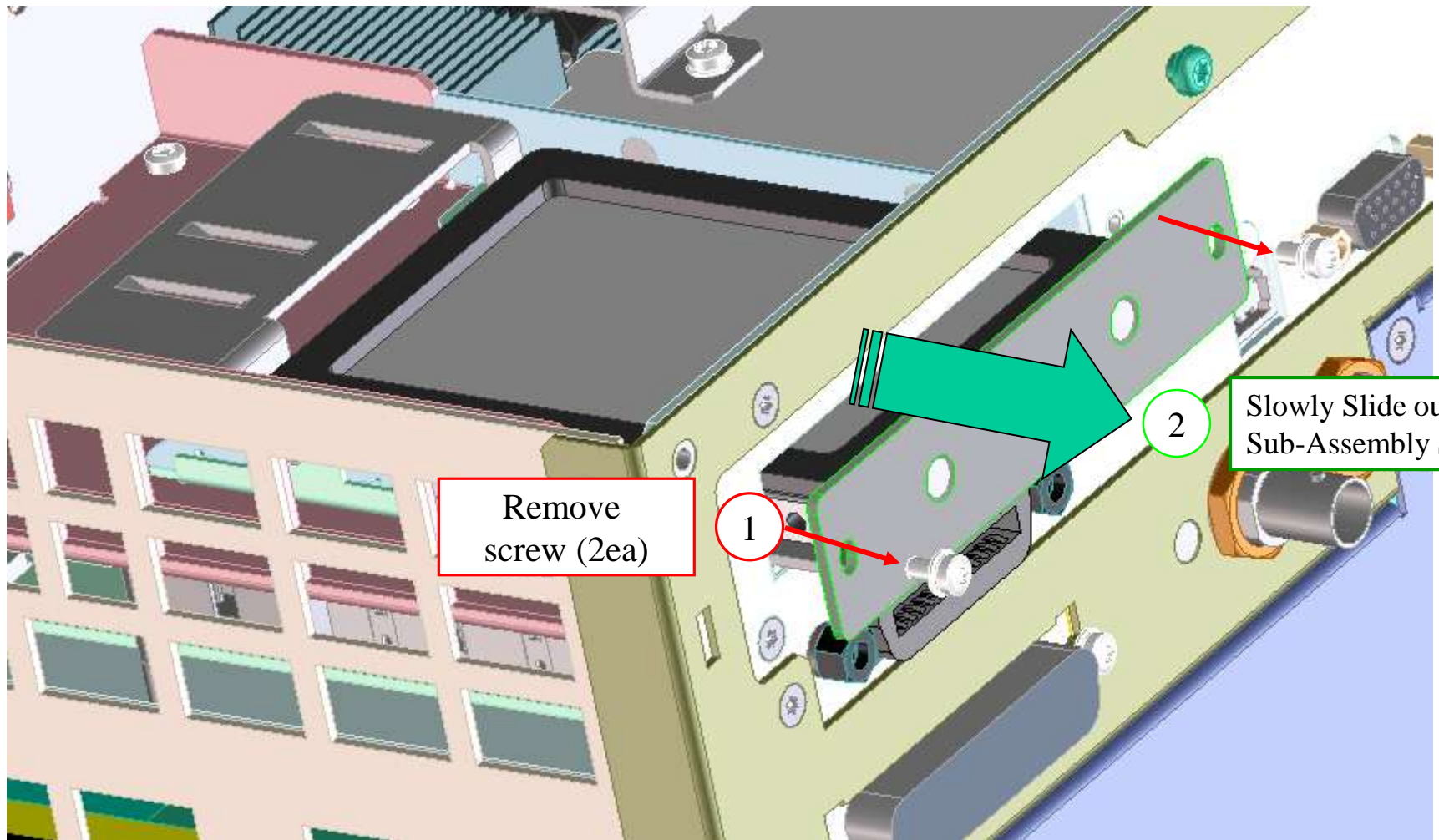
- 1
- 2
- 3



① ②



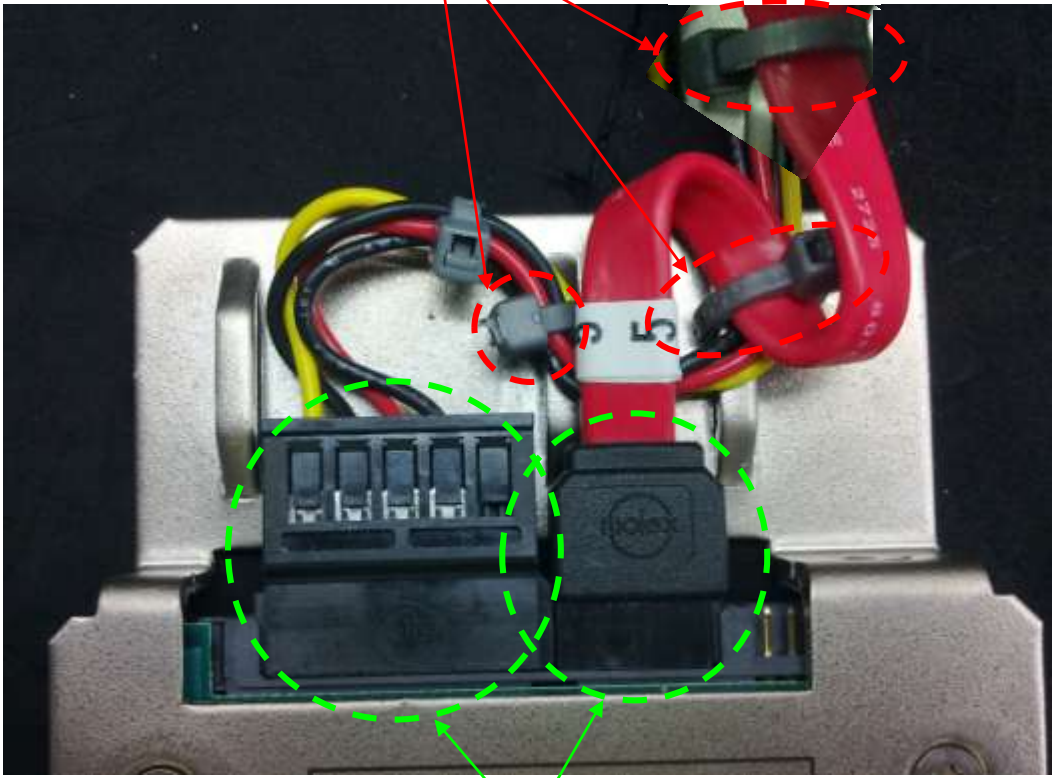
①



① ②

Cut (3ea)

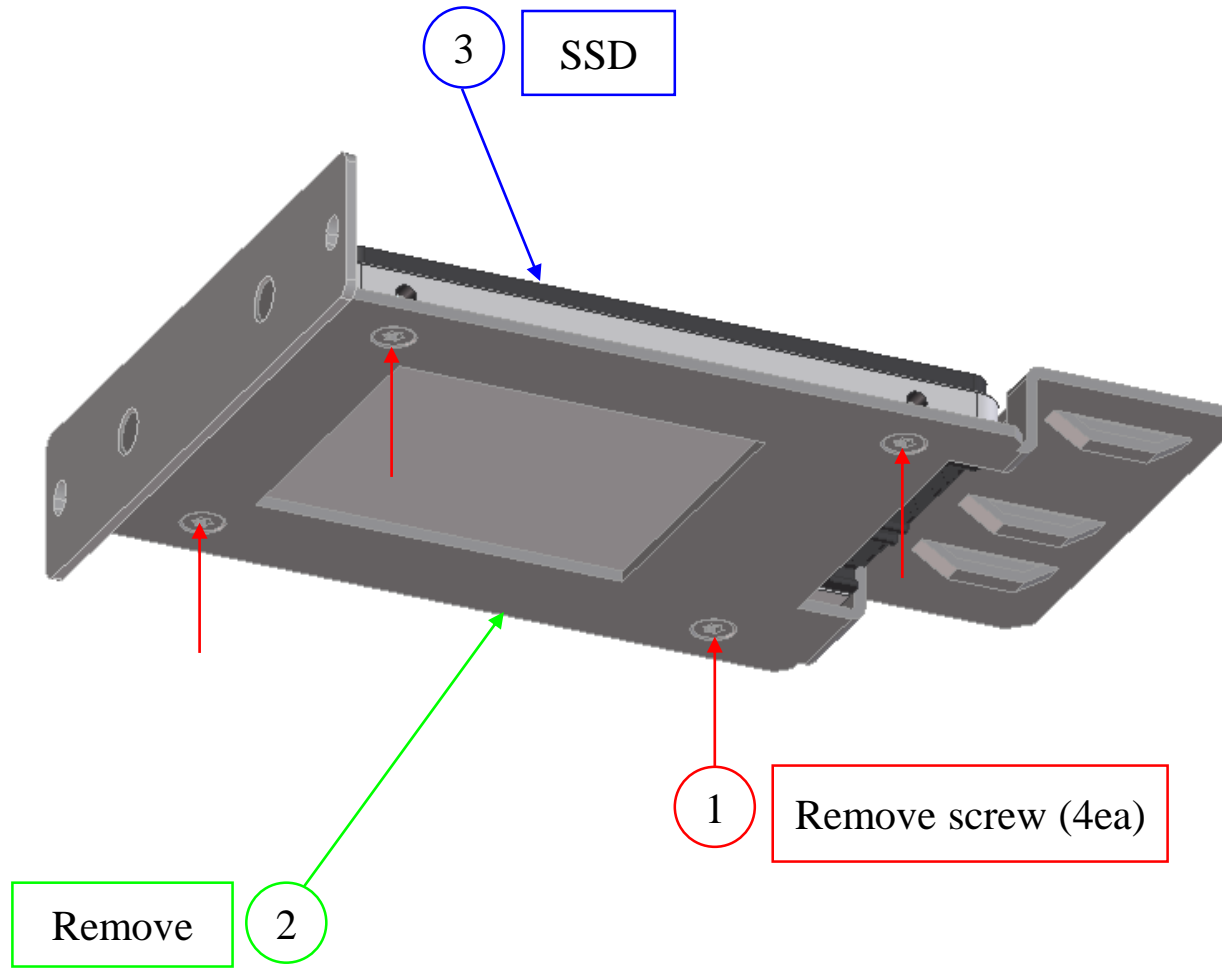
1



2

Disconnect

1 2



① ② ③

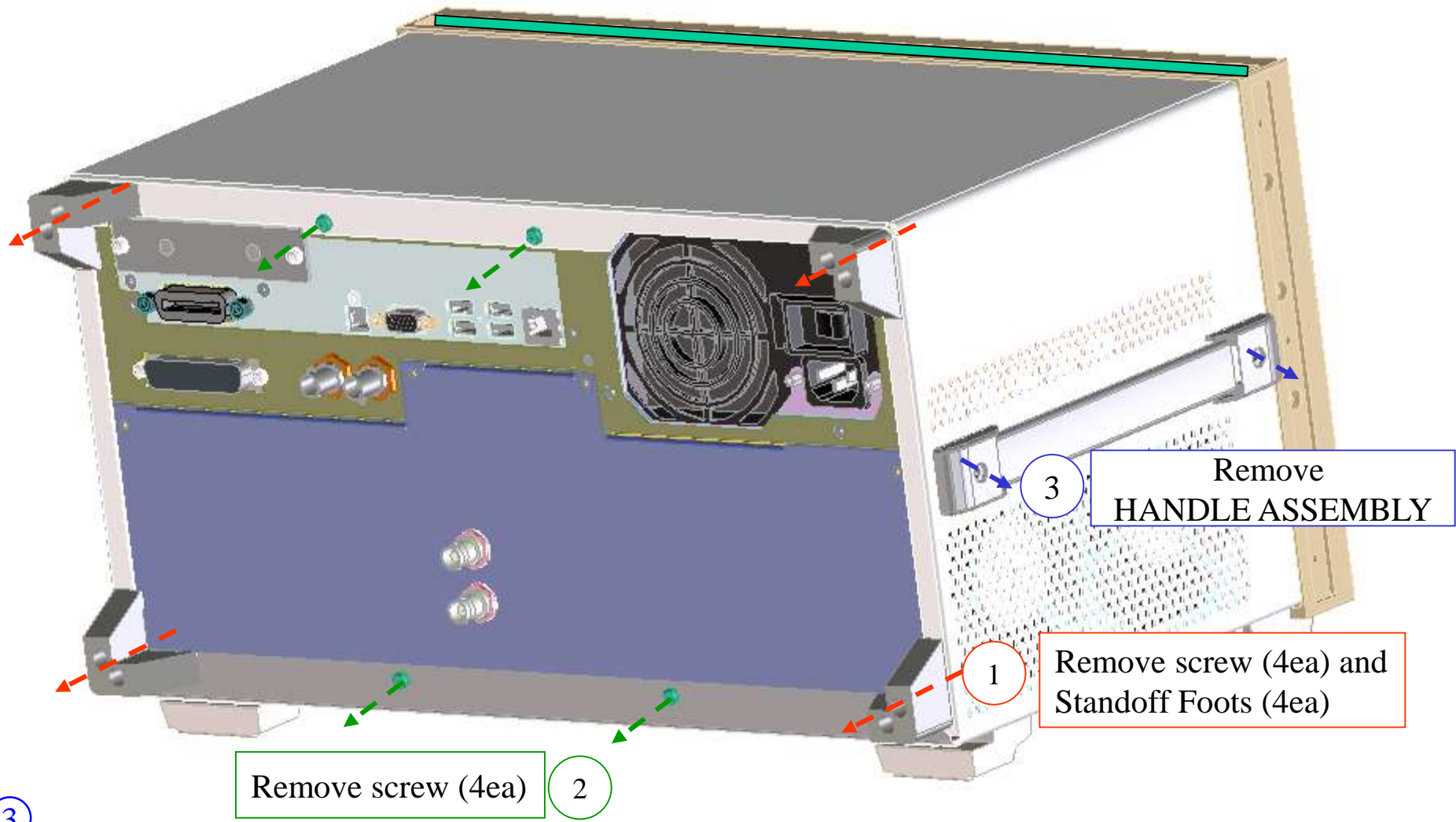
CPU Module

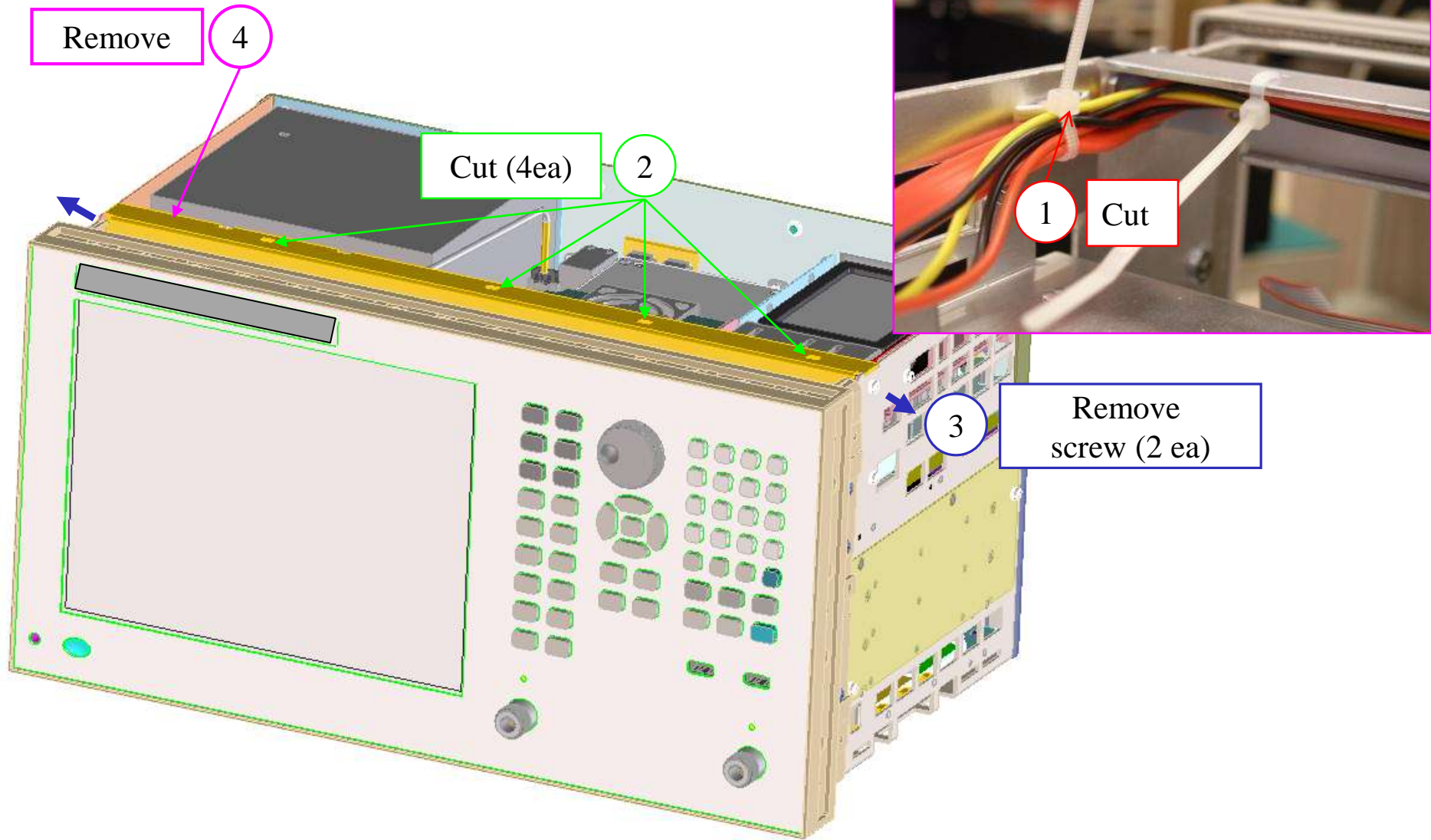
Dis-Assembly Procedure

Note:

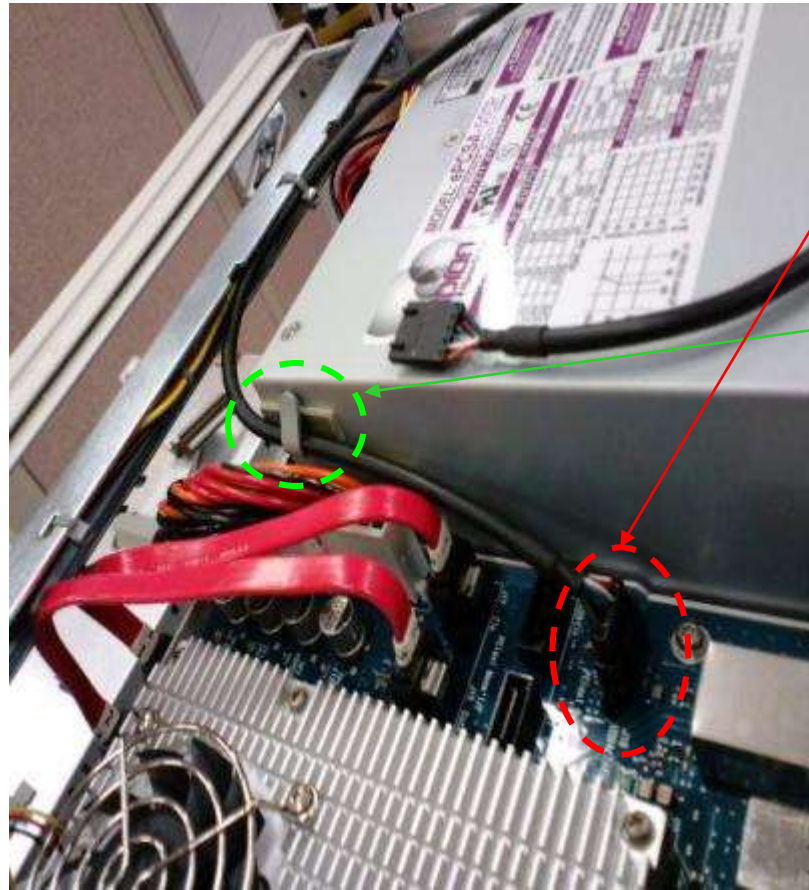
1. Torque value shown in this document is only for reference and only used during assembly.







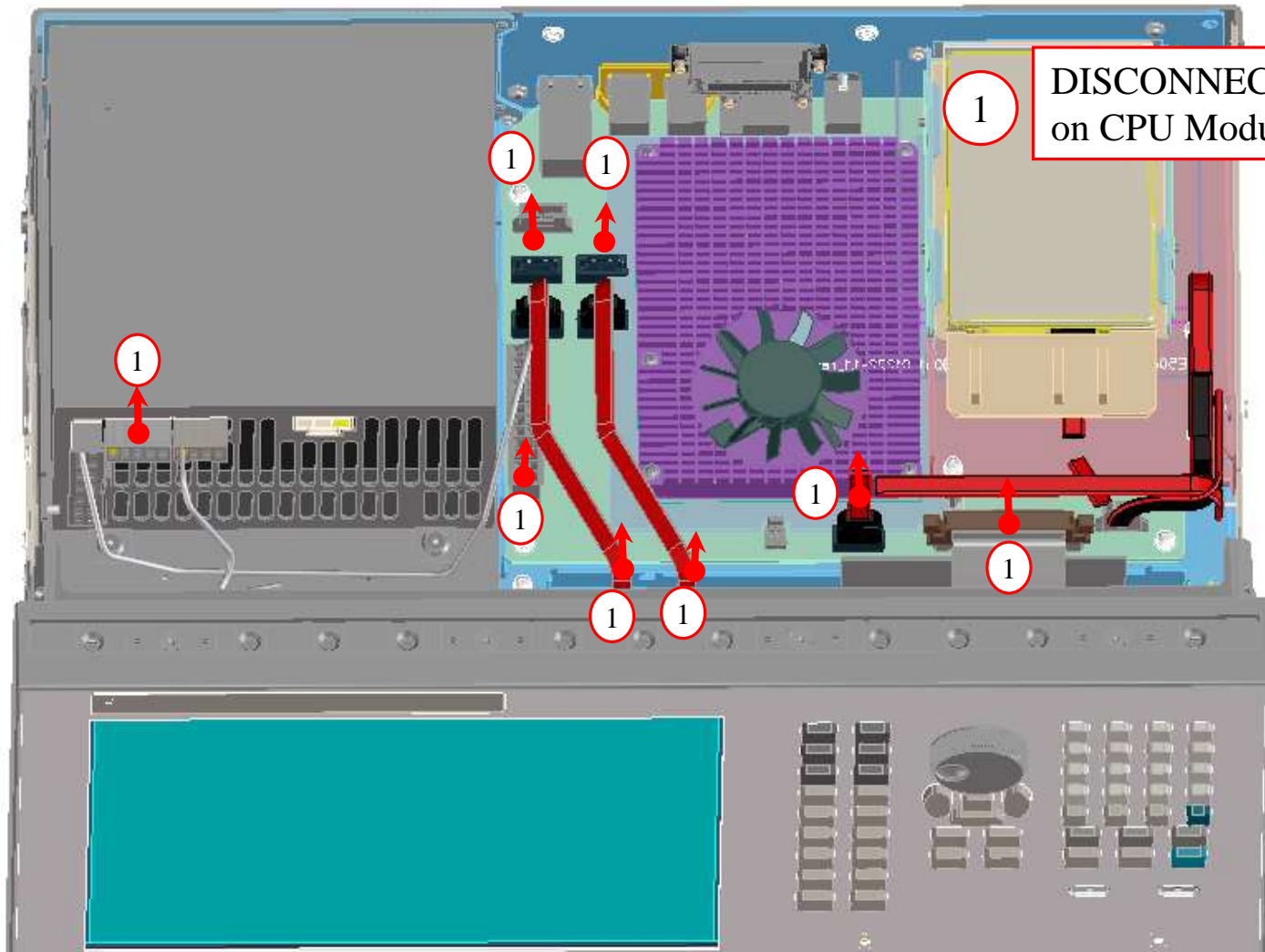
- 1
- 2
- 3
- 4



1 Disconnect

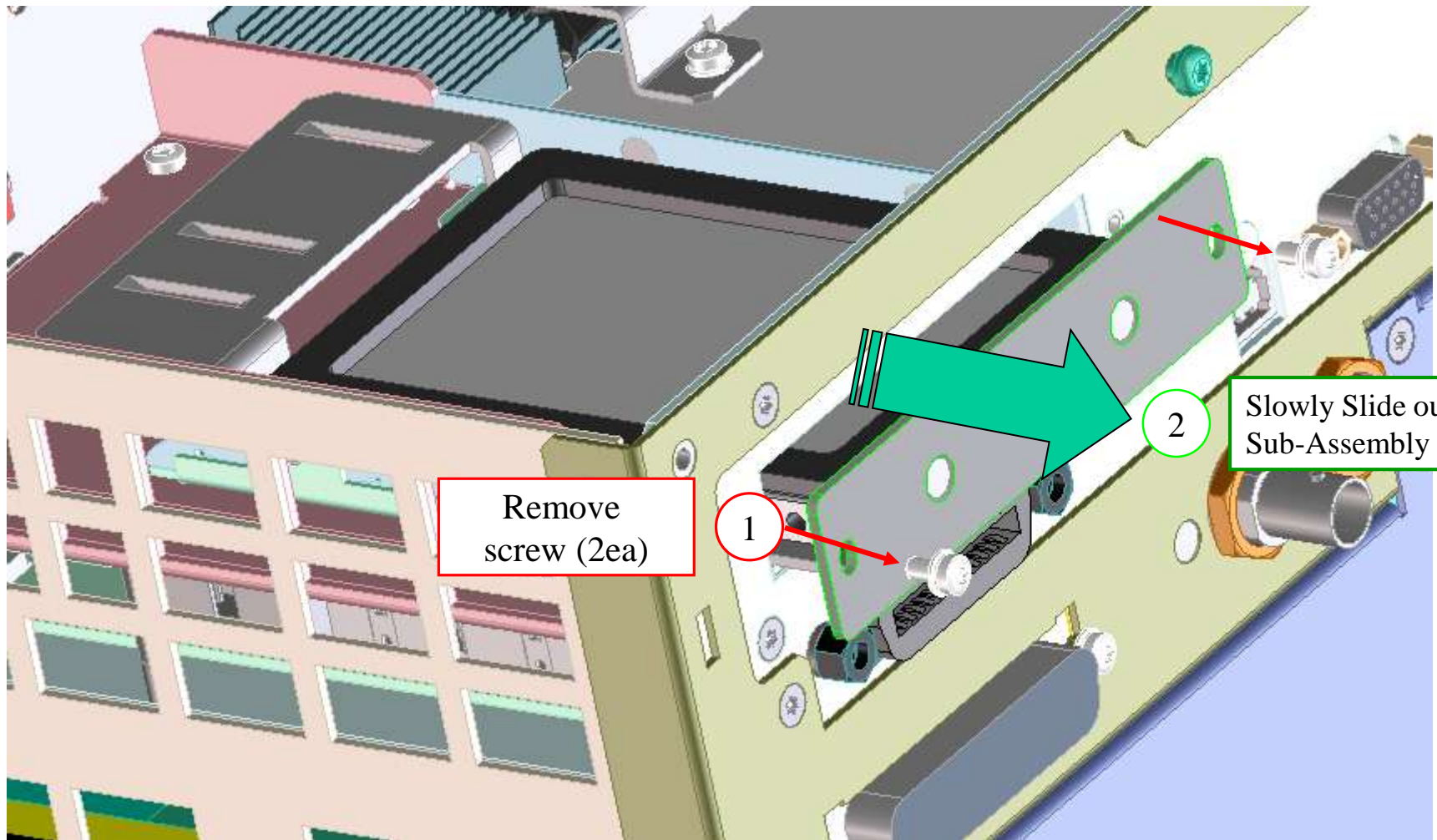
2 Open

1 2



1 DISCONNECT All cables on CPU Module

1



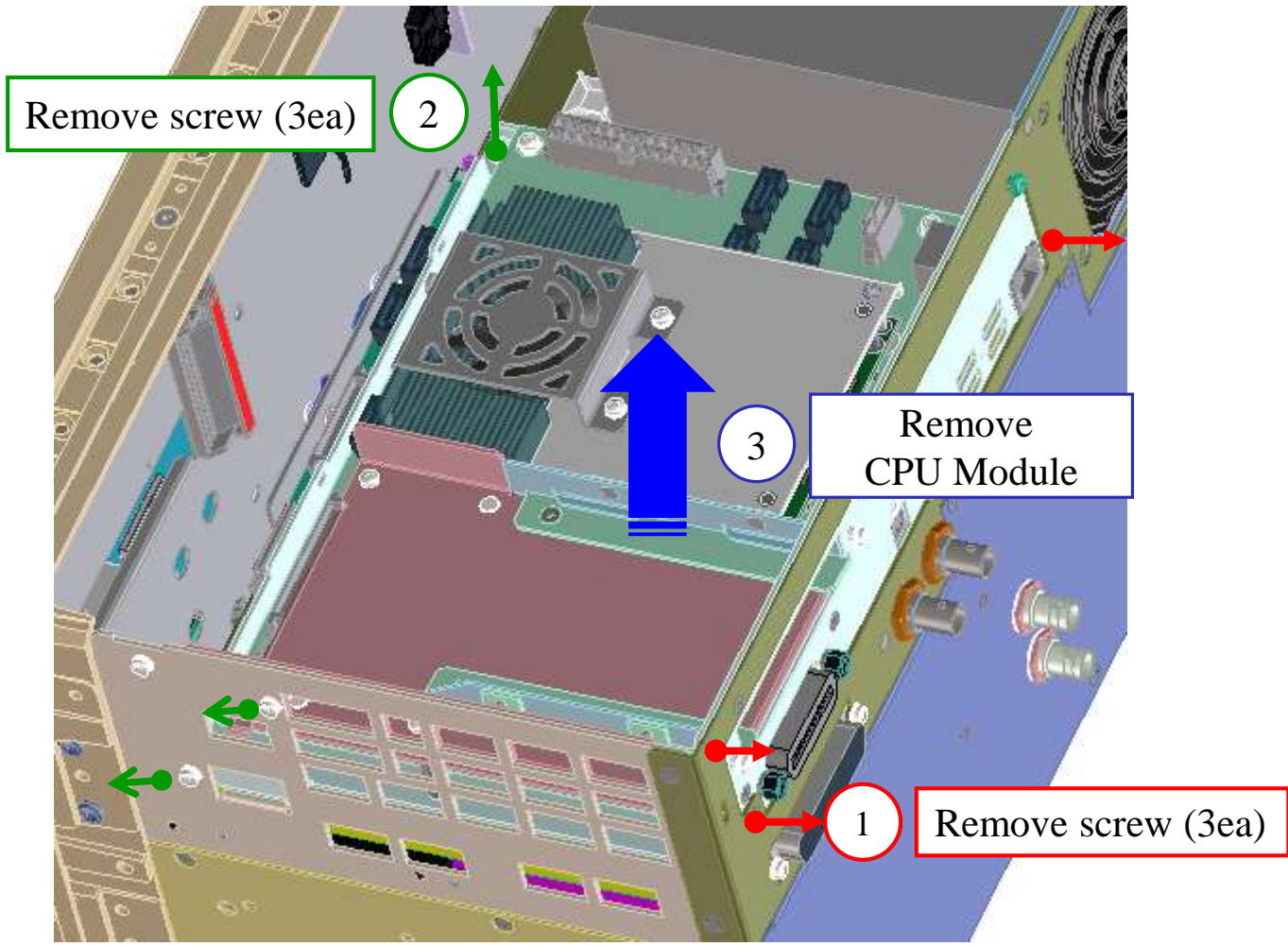
Remove screw (2ea)

1

2

Slowly Slide out the Sub-Assembly SSD

1 2



1 2 3

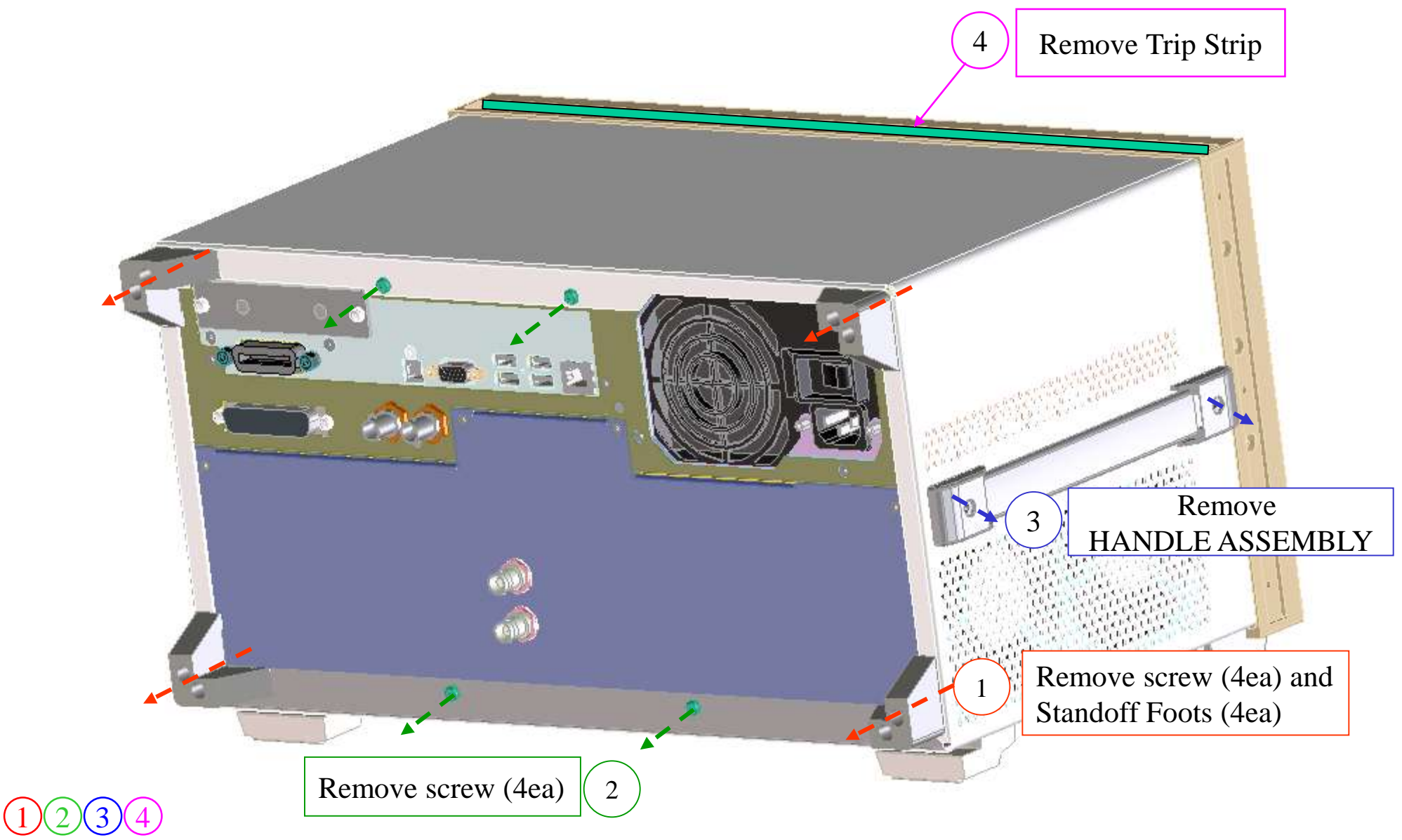
Display Board

Dis-Assembly Procedure

Note:

1. Torque value shown in this document is only for reference and only used during assembly.





4 Remove Trip Strip

3 Remove HANDLE ASSEMBLY

1 Remove screw (4ea) and Standoff Feet (4ea)

Remove screw (4ea) 2

- 1
- 2
- 3
- 4

Remove Front sub-assy

1



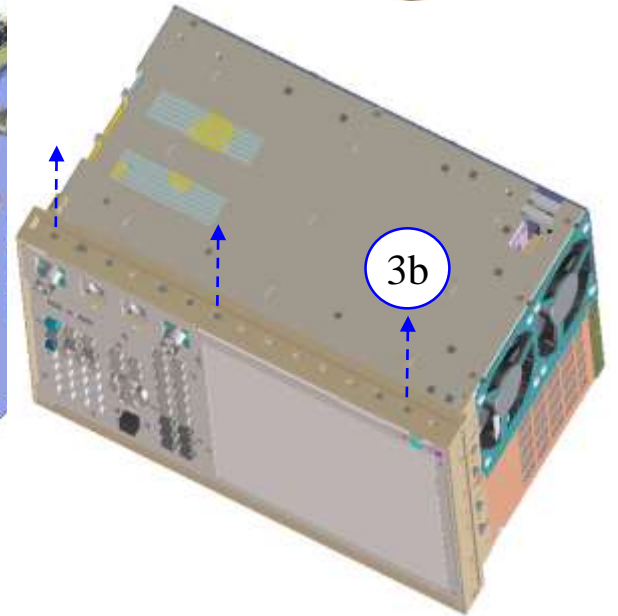
2

Disconnect flat cable of Front Panel Ass'y from CPU Module

1 2 3

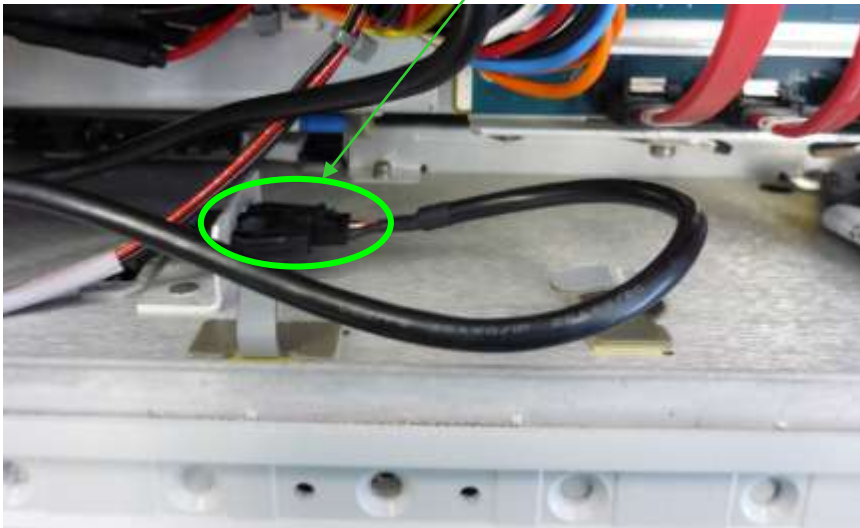
3a

Remove screw (7ea)

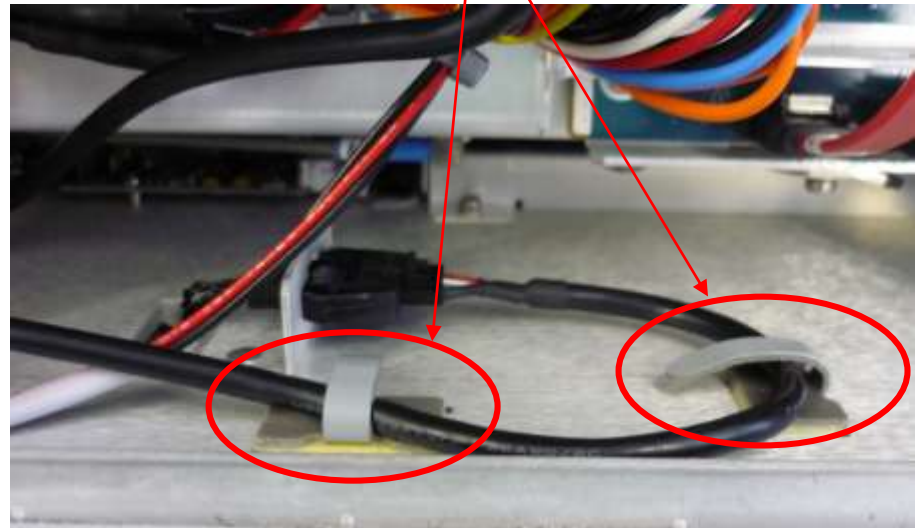


3b

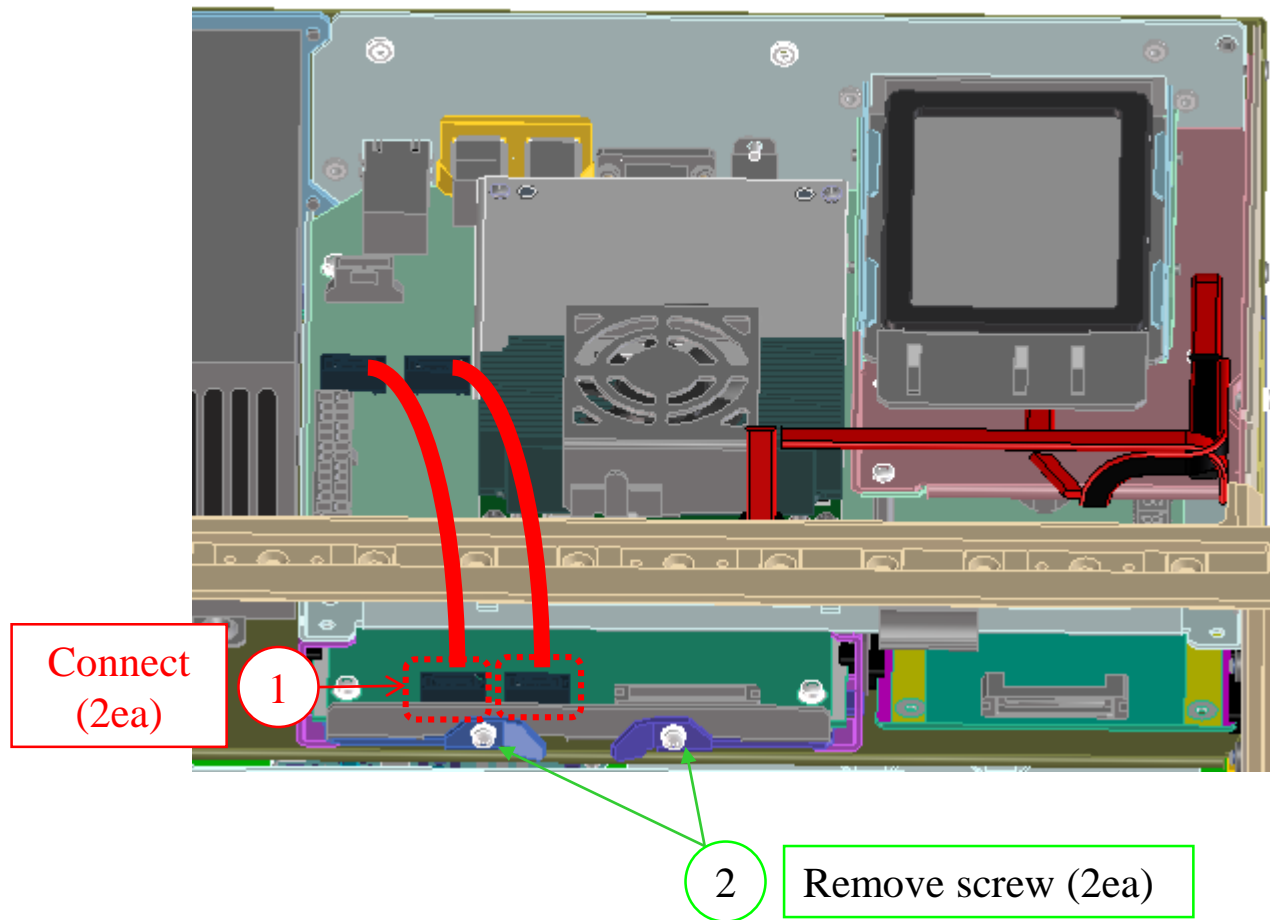
2 Disconnect



1 Open



① ②



① ②

Remove
Display Board

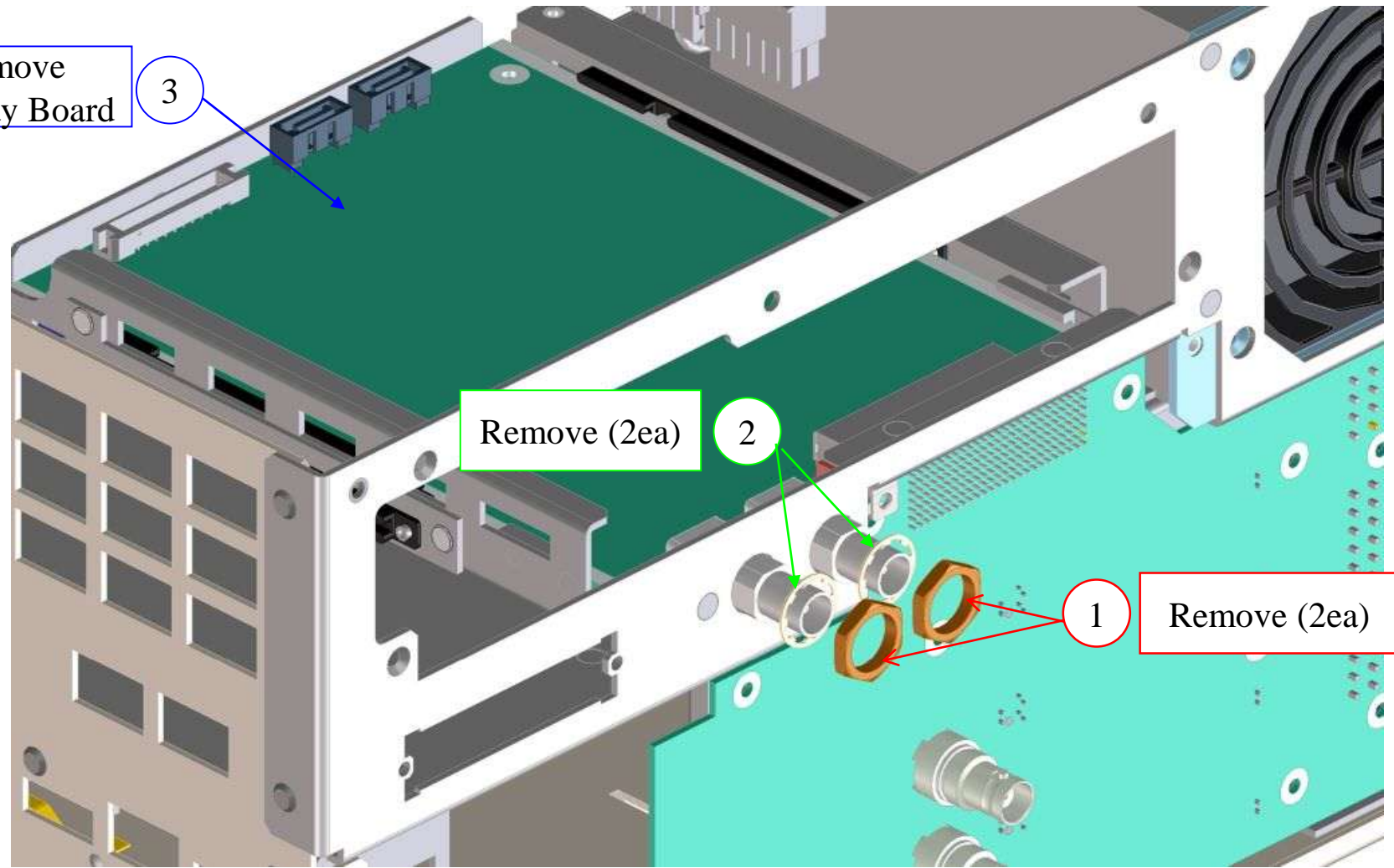
3

Remove (2ea)

2

1

Remove (2ea)



① ② ③

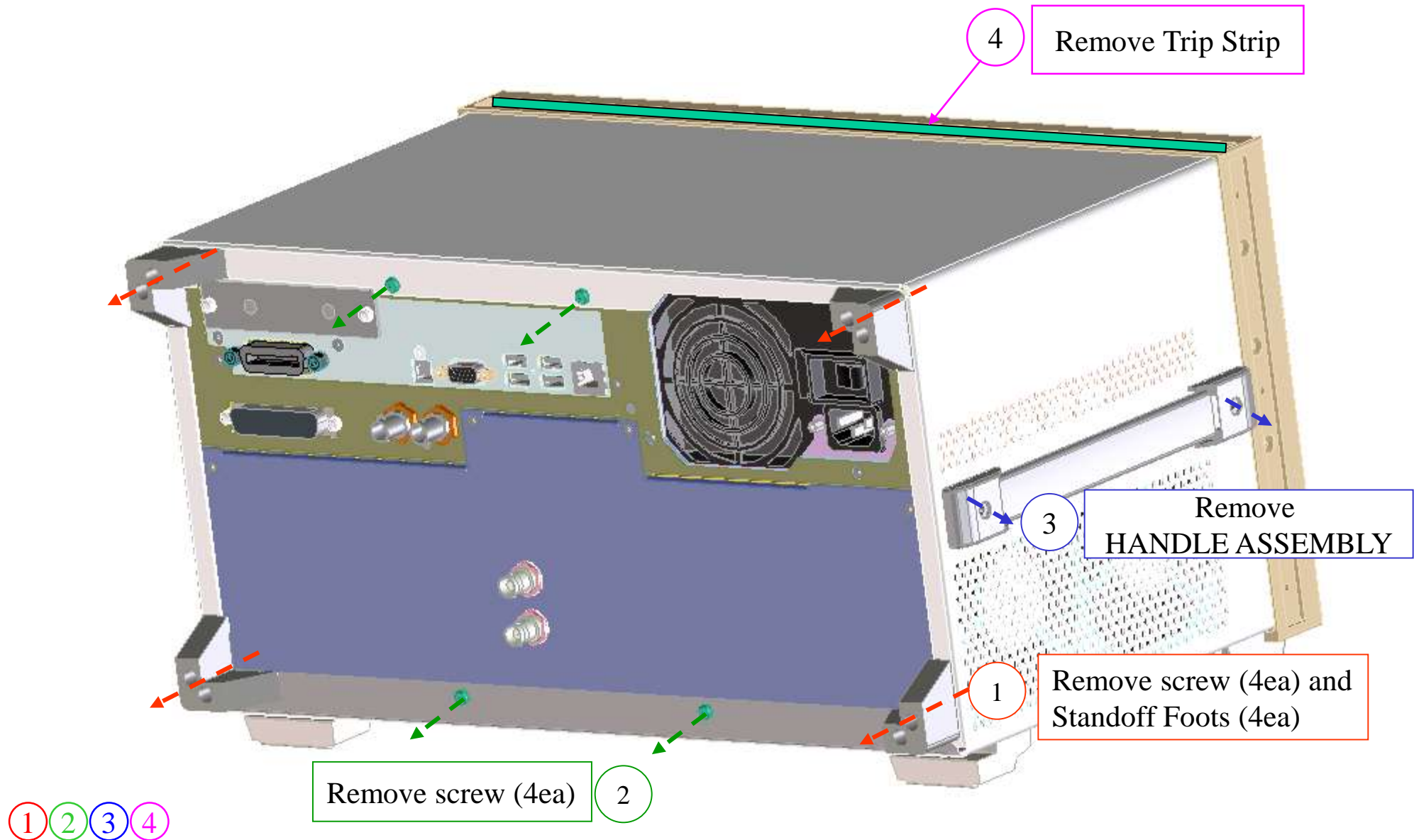
A1 Module

Dis-Assembly Procedure

Note:

1. Torque value shown in this document is only for reference and only used during assembly.





Remove Front sub-assy

1



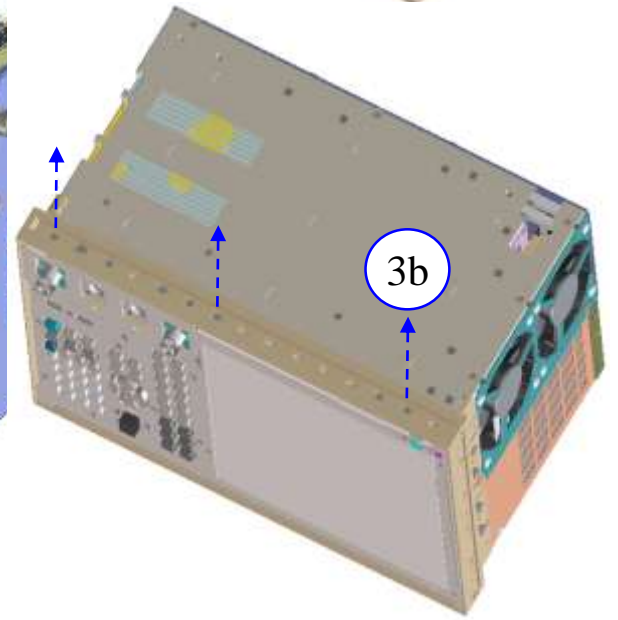
2

Disconnect flat cable of Front Panel Ass'y from CPU Module

1 2 3

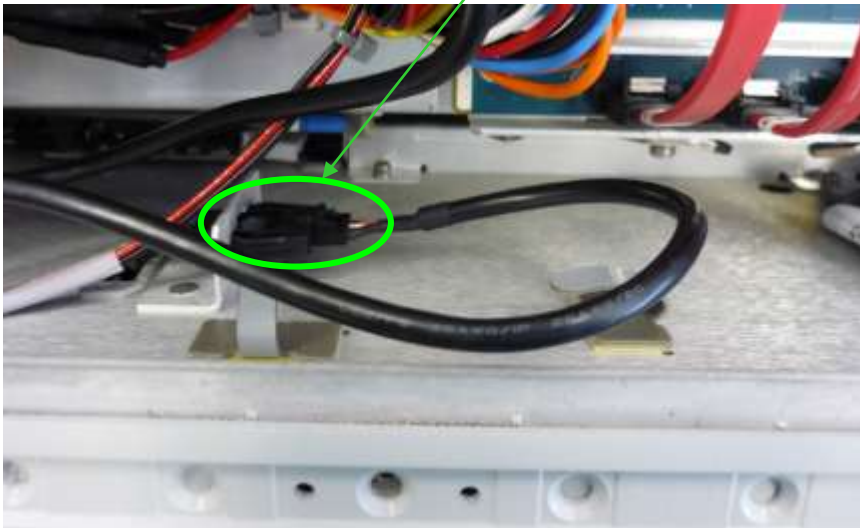
3a

Remove screw (7ea)

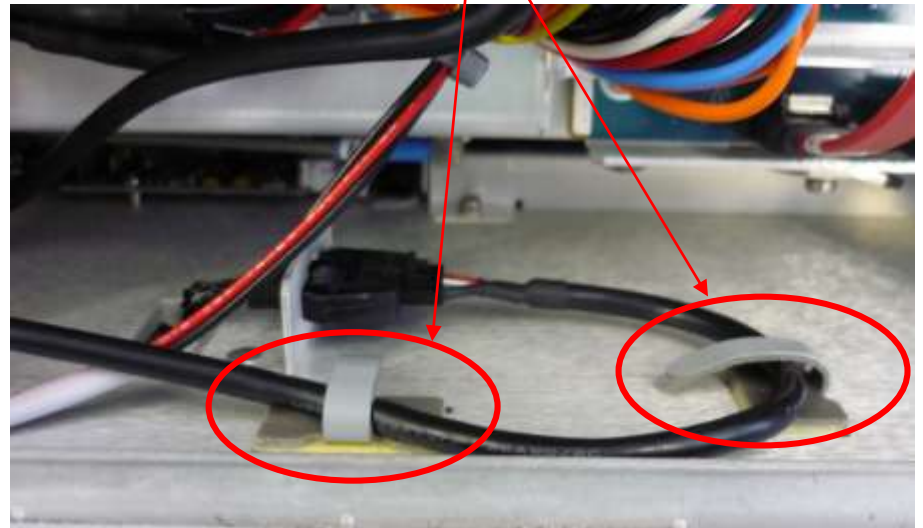


3b

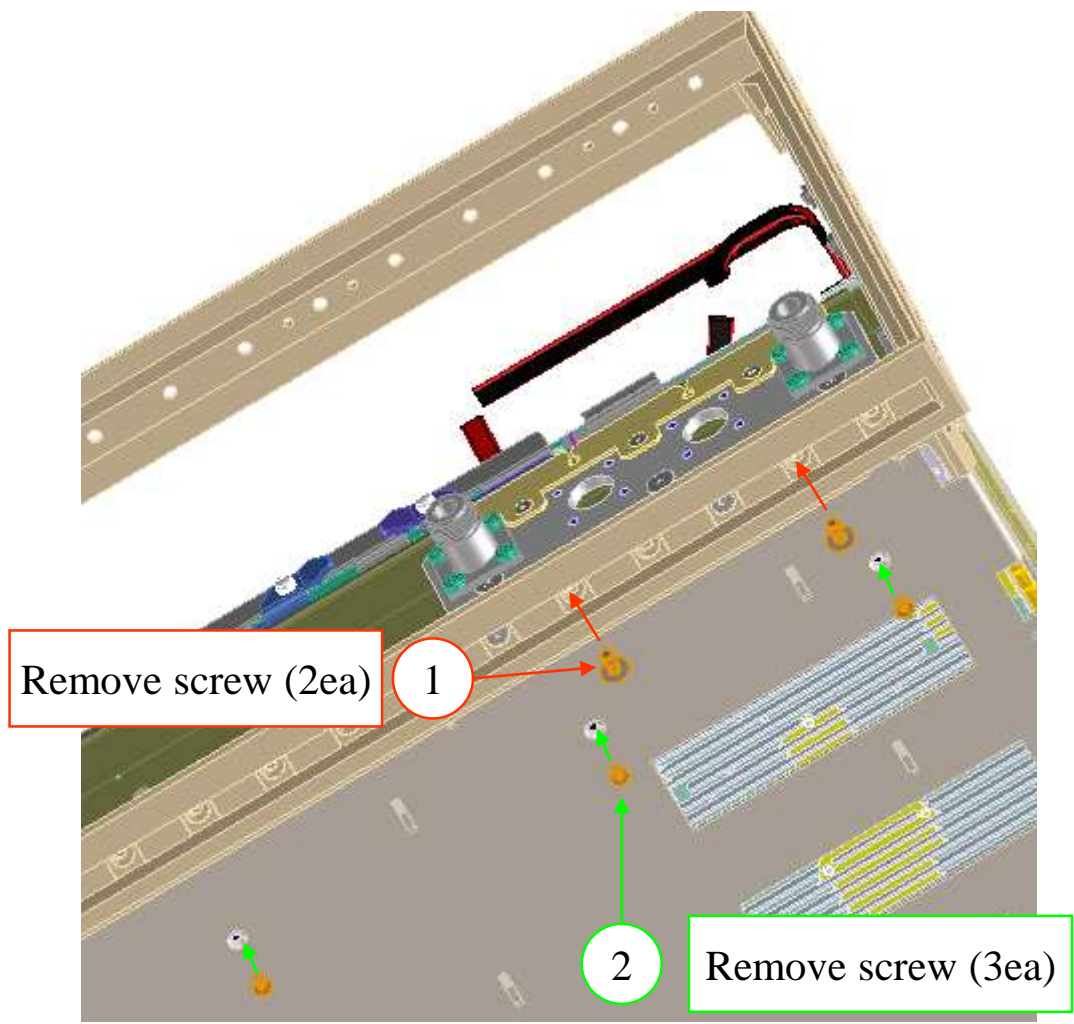
2 Disconnect



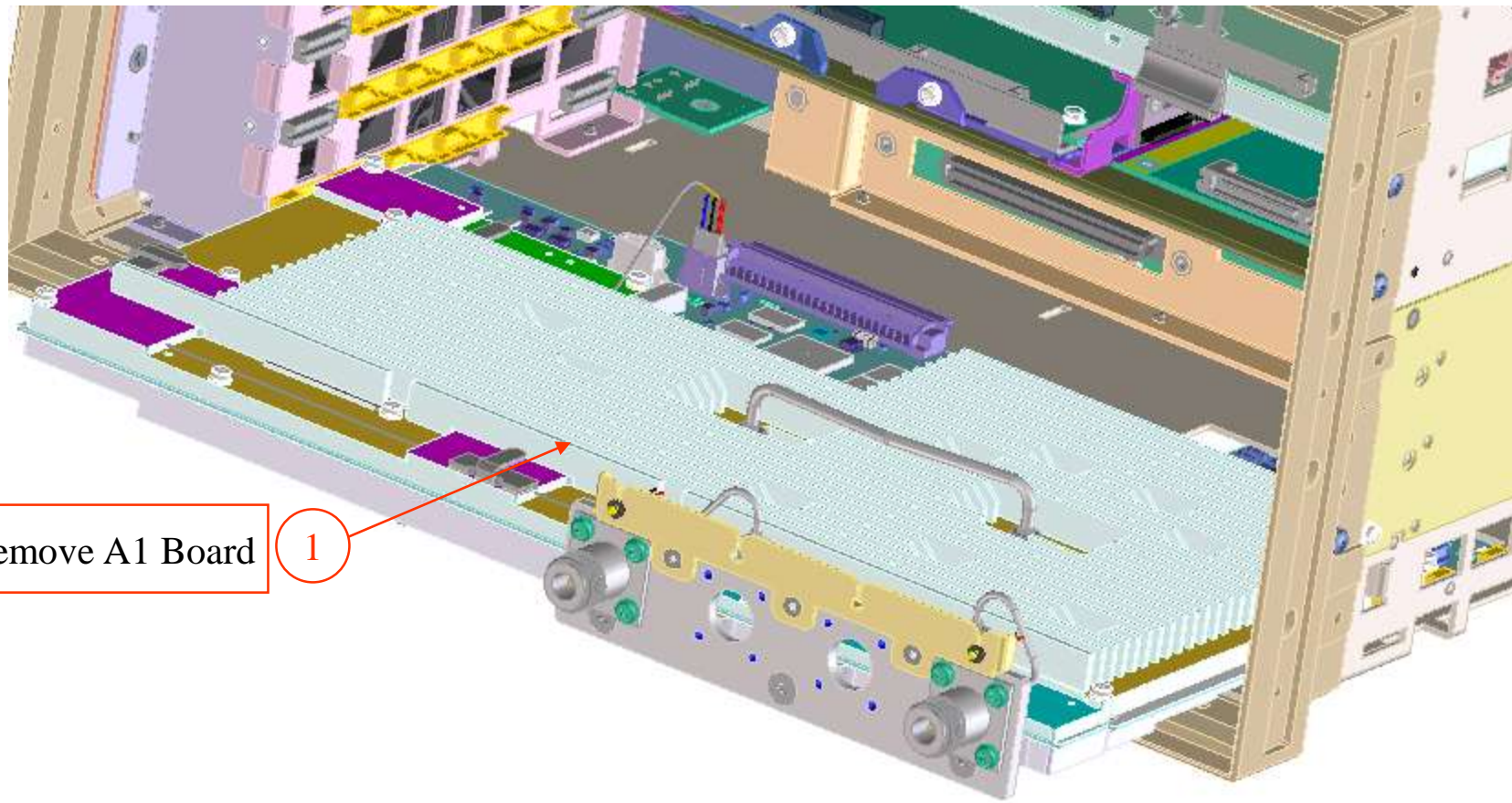
1 Open



① ②



1 2



Remove A1 Board

1

1

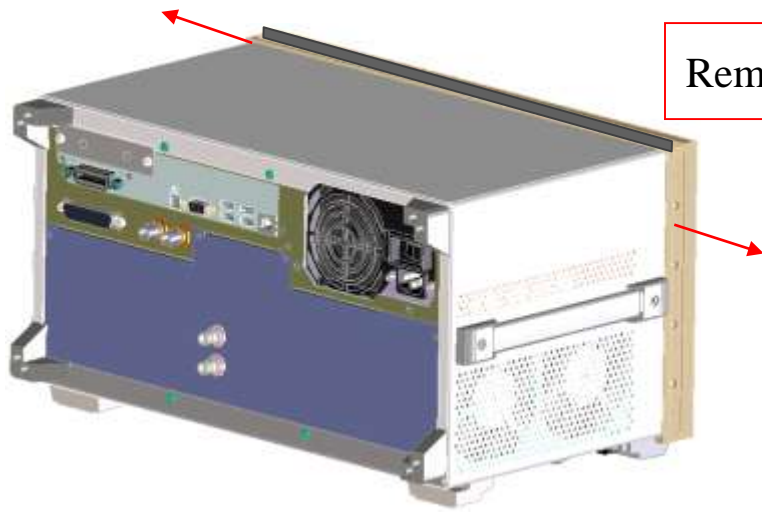
Analog Board

Dis-Assembly Procedure

Note:

1. Torque value shown in this document is only for reference and only used during assembly.





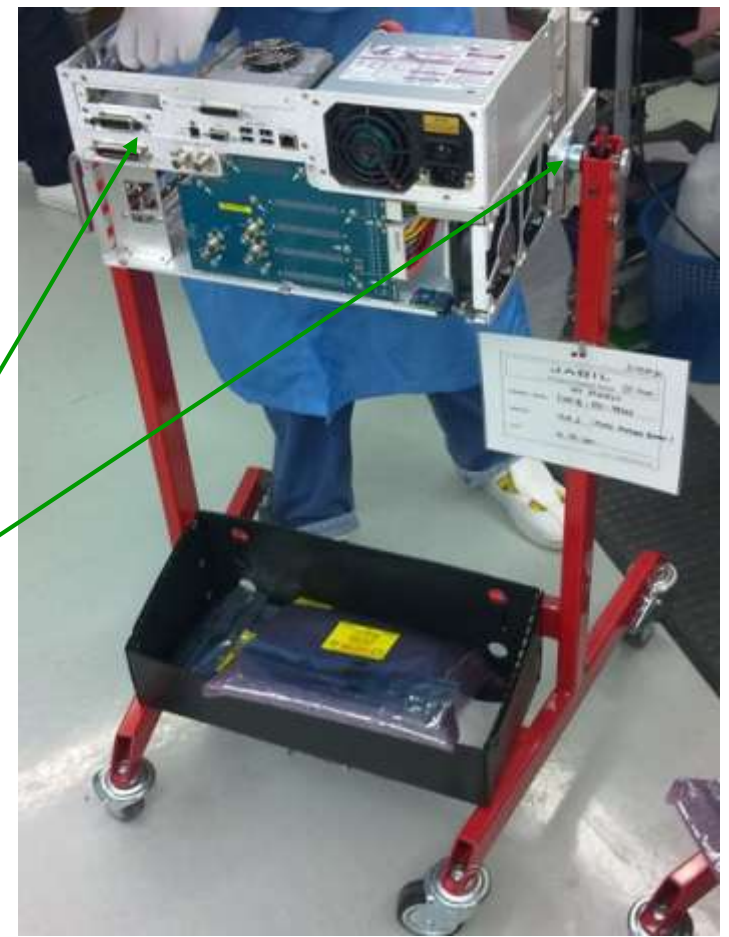
Remove Trim Side

1

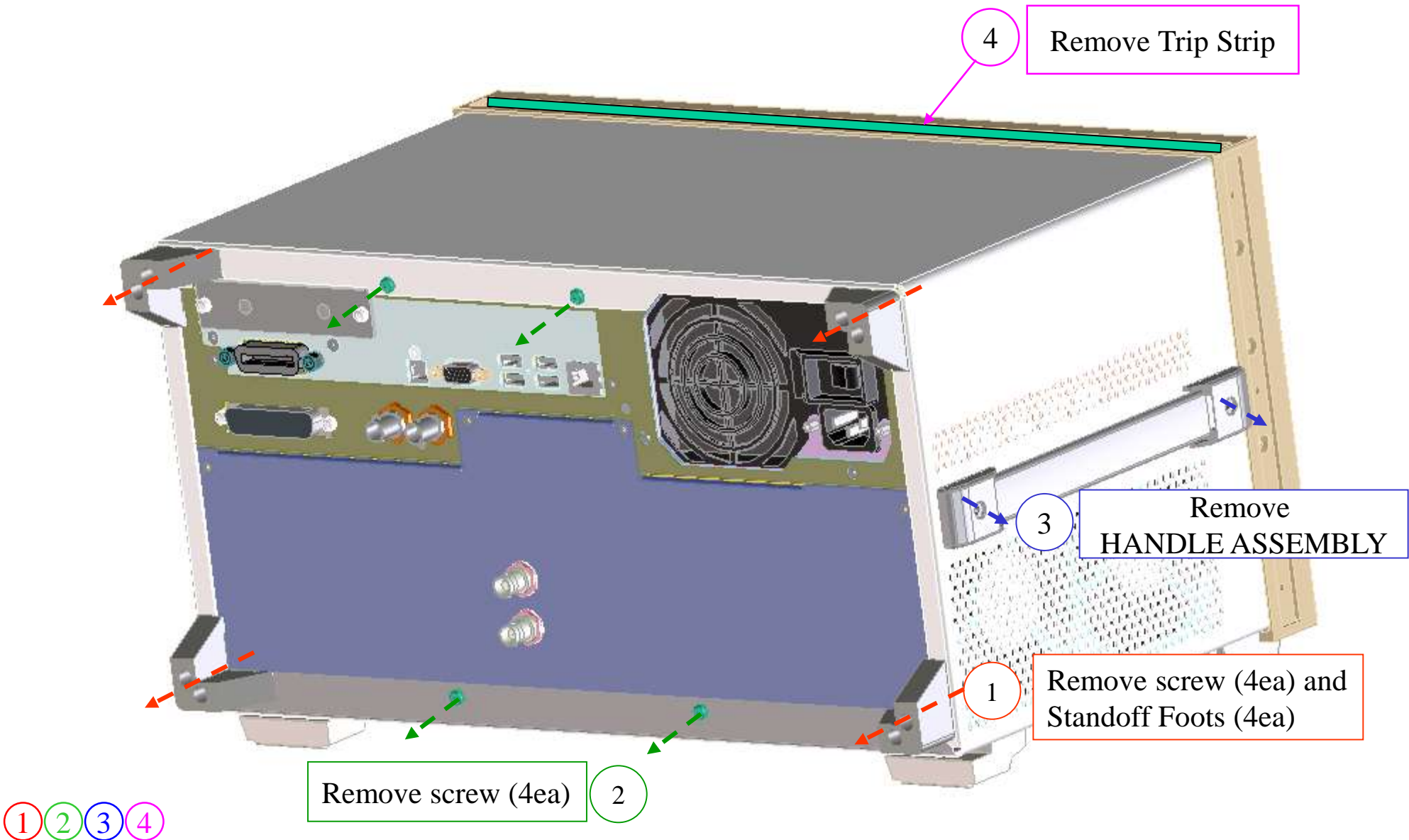
21 inlb

2

Attach T-384162, Cart arm



1 2



Remove Front sub-assy

1



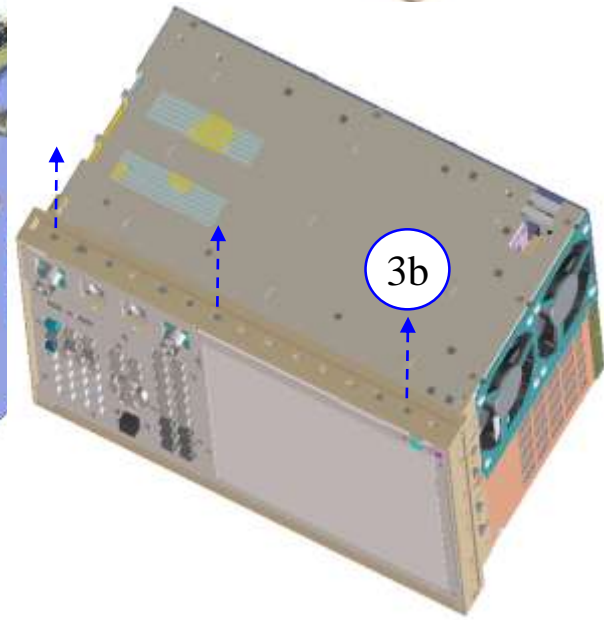
2

Disconnect flat cable of Front Panel Ass'y from CPU Module

1 2 3

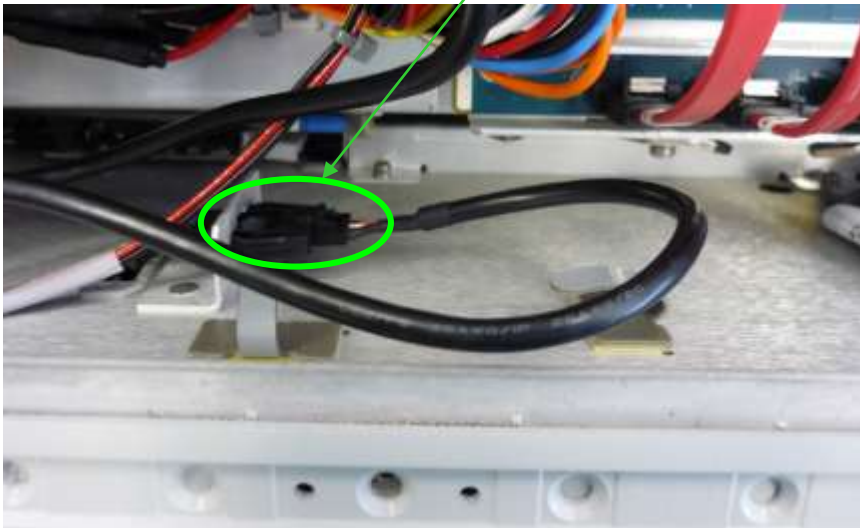
3a

Remove screw (7ea)

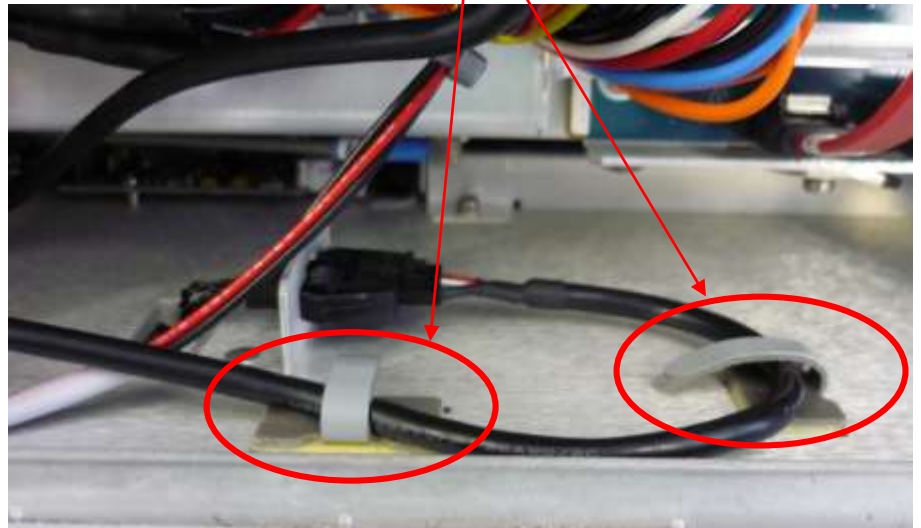


3b

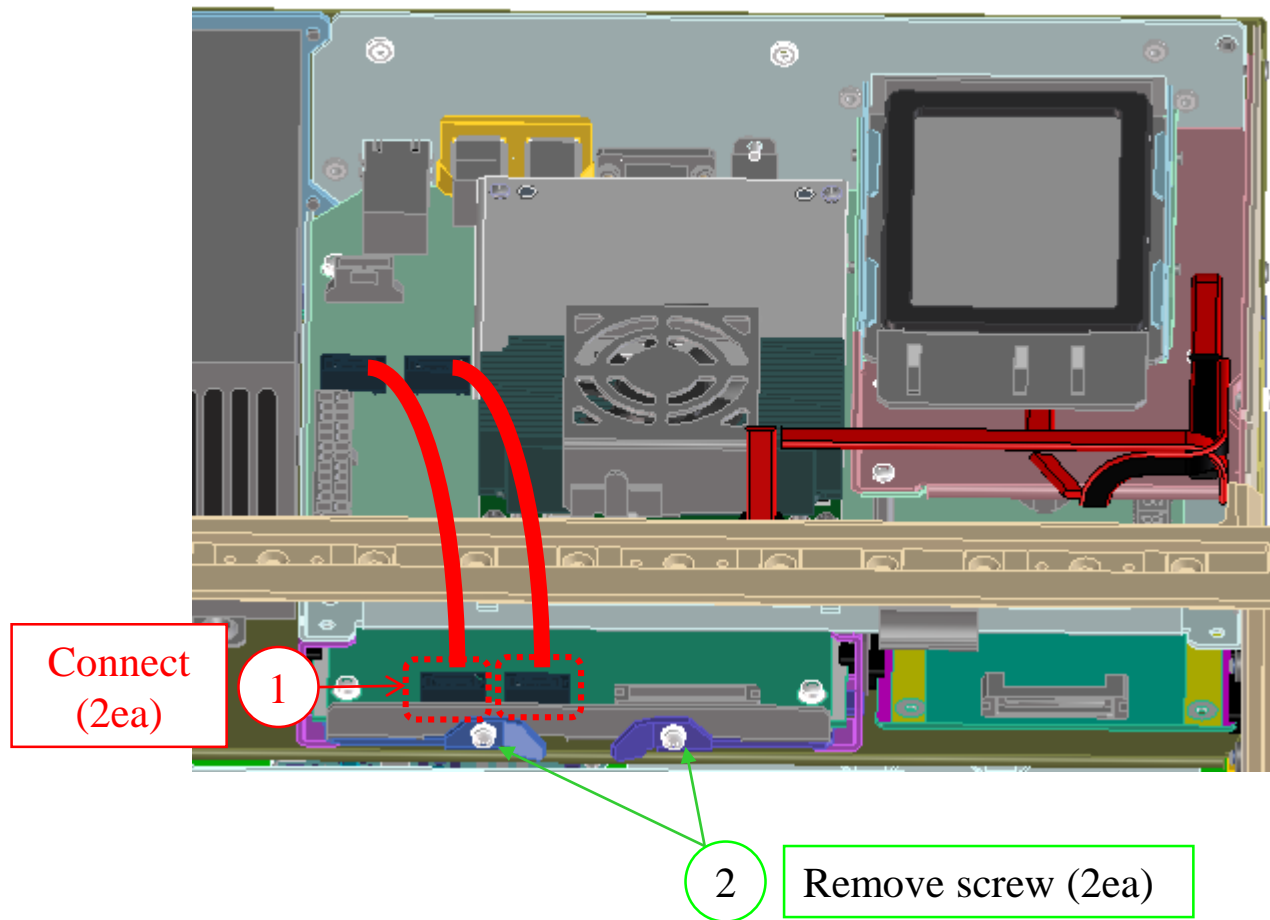
2 Disconnect



1 Open



① ②



① ②

Remove
Display Board

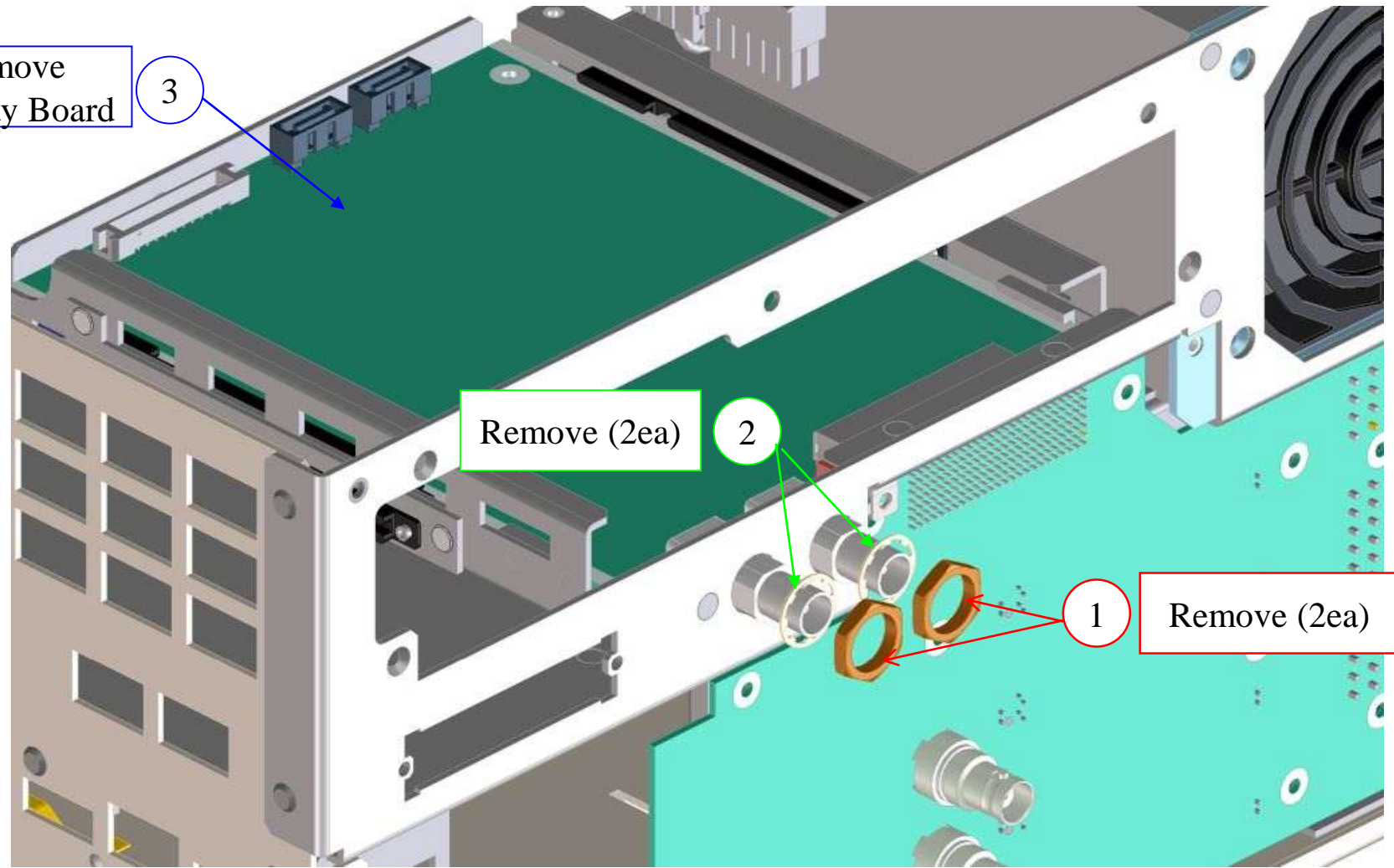
3

Remove (2ea)

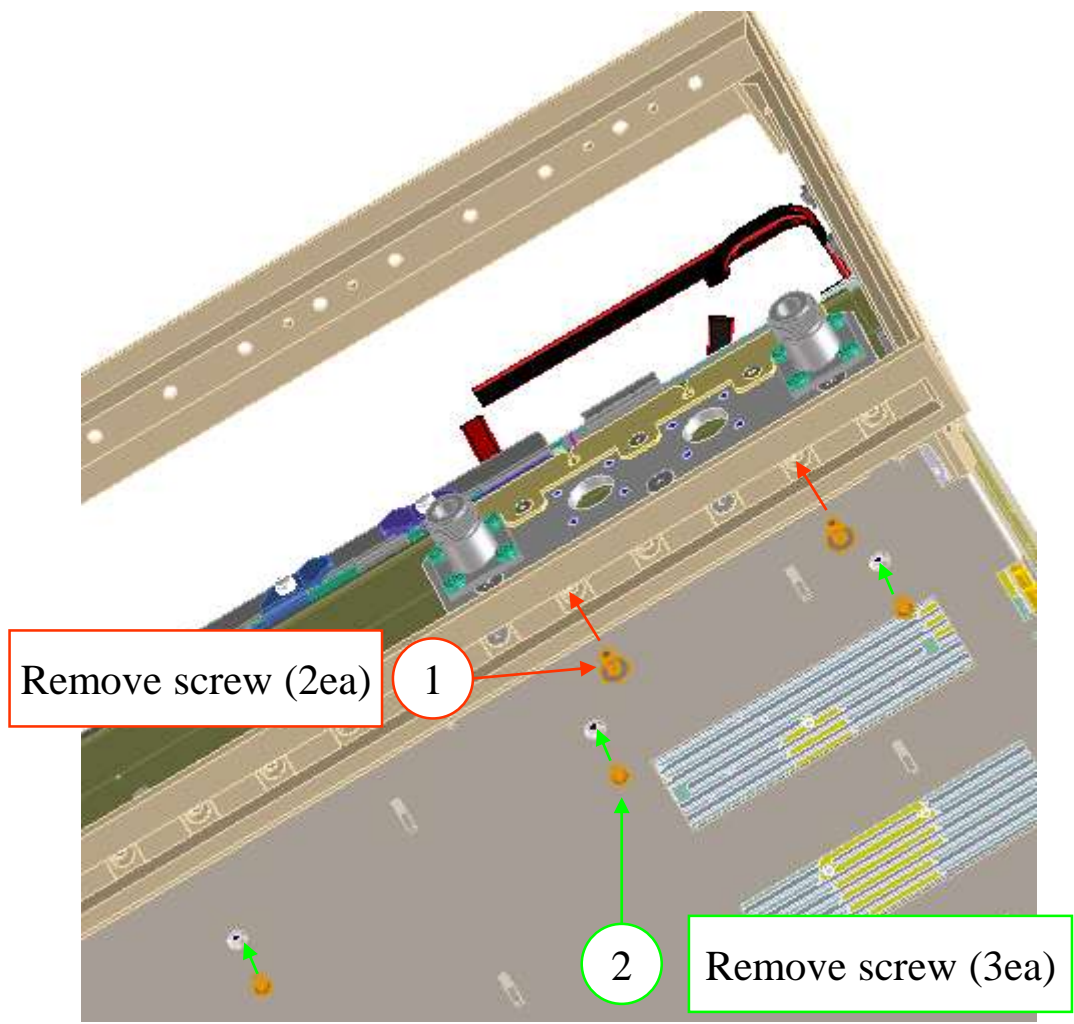
2

1

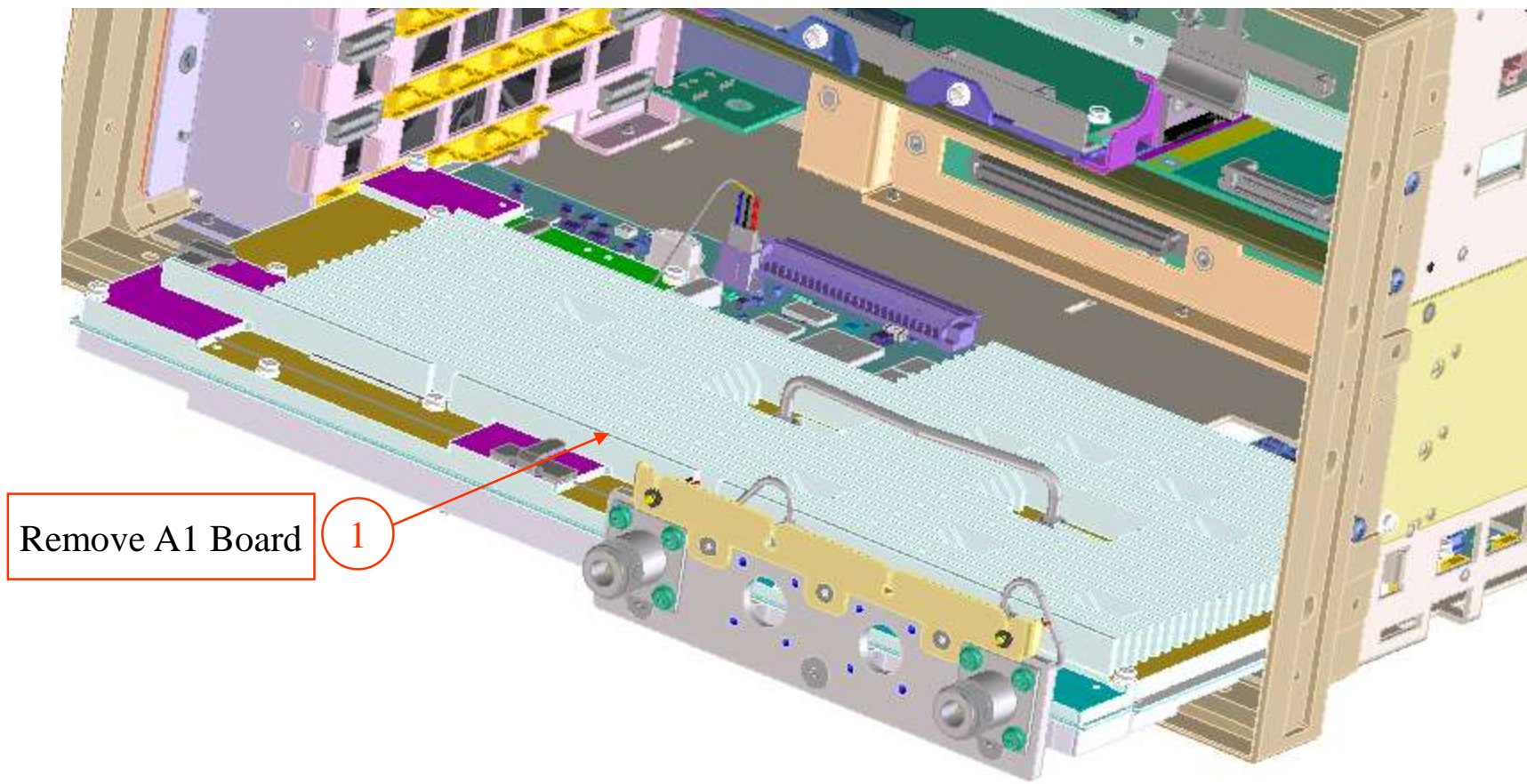
Remove (2ea)



① ② ③



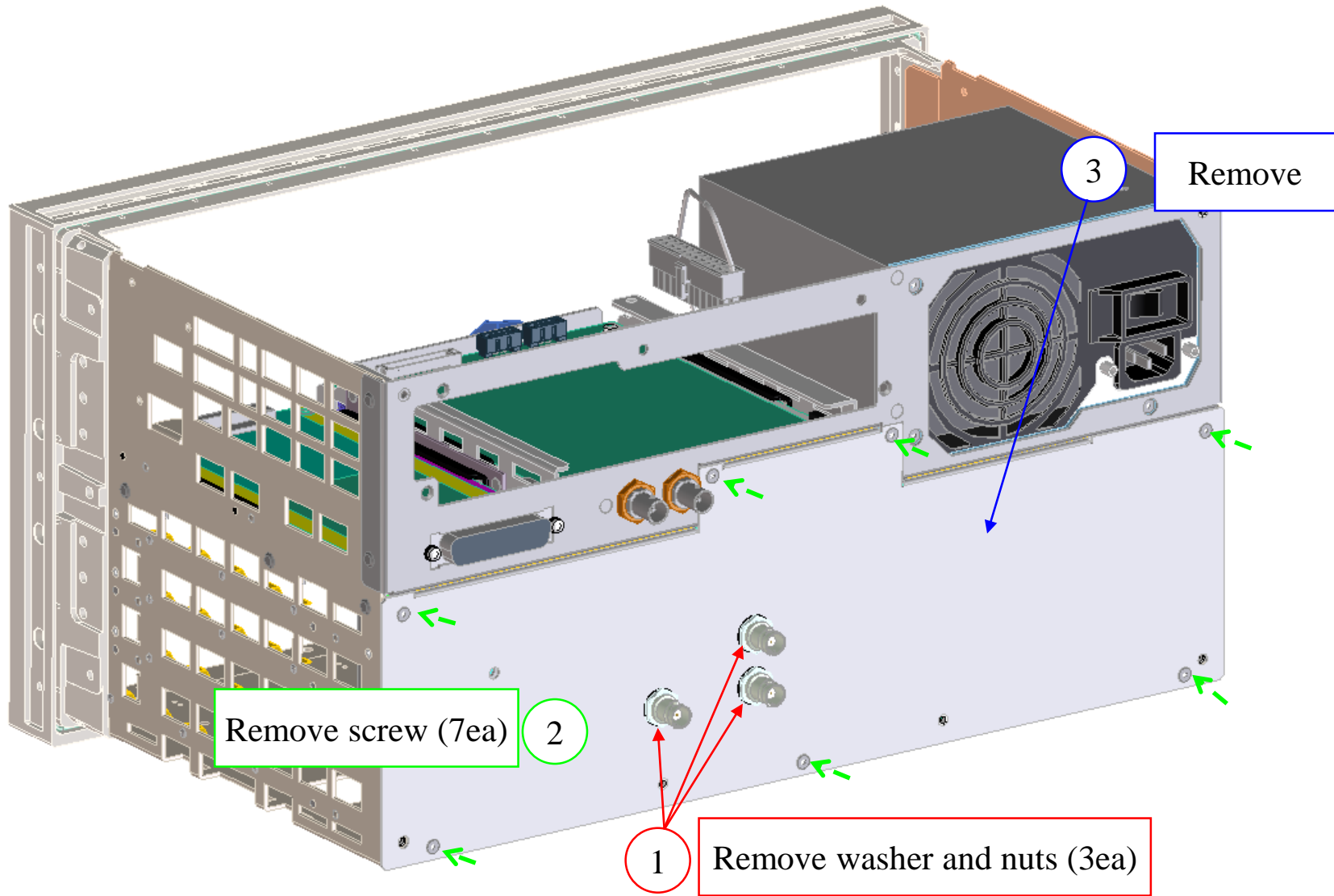
1 2

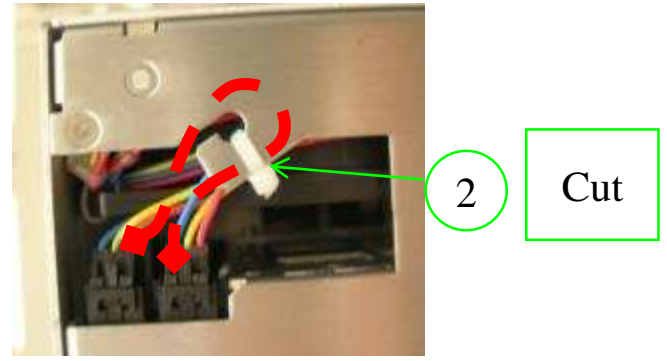
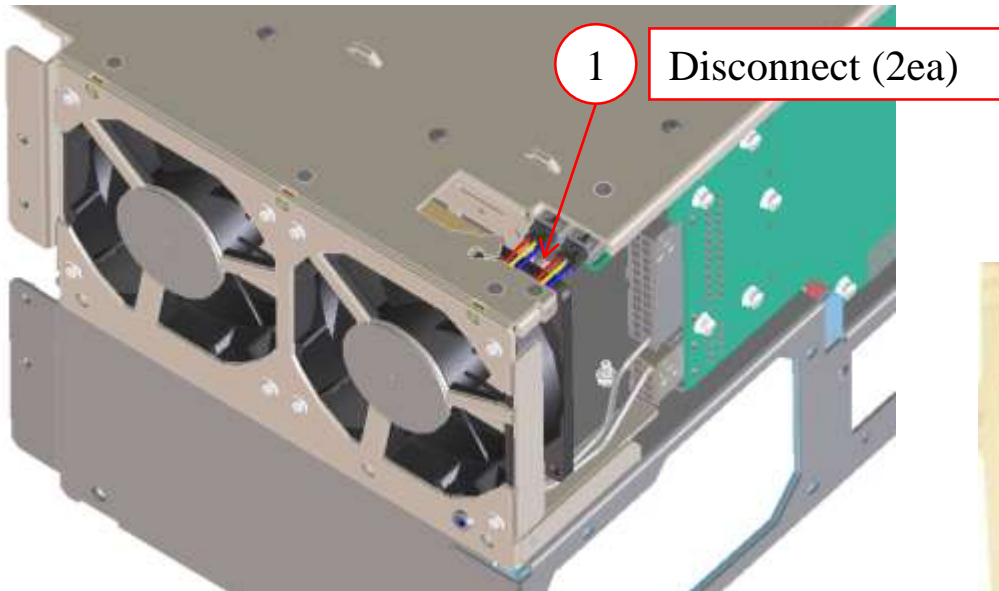


Remove A1 Board

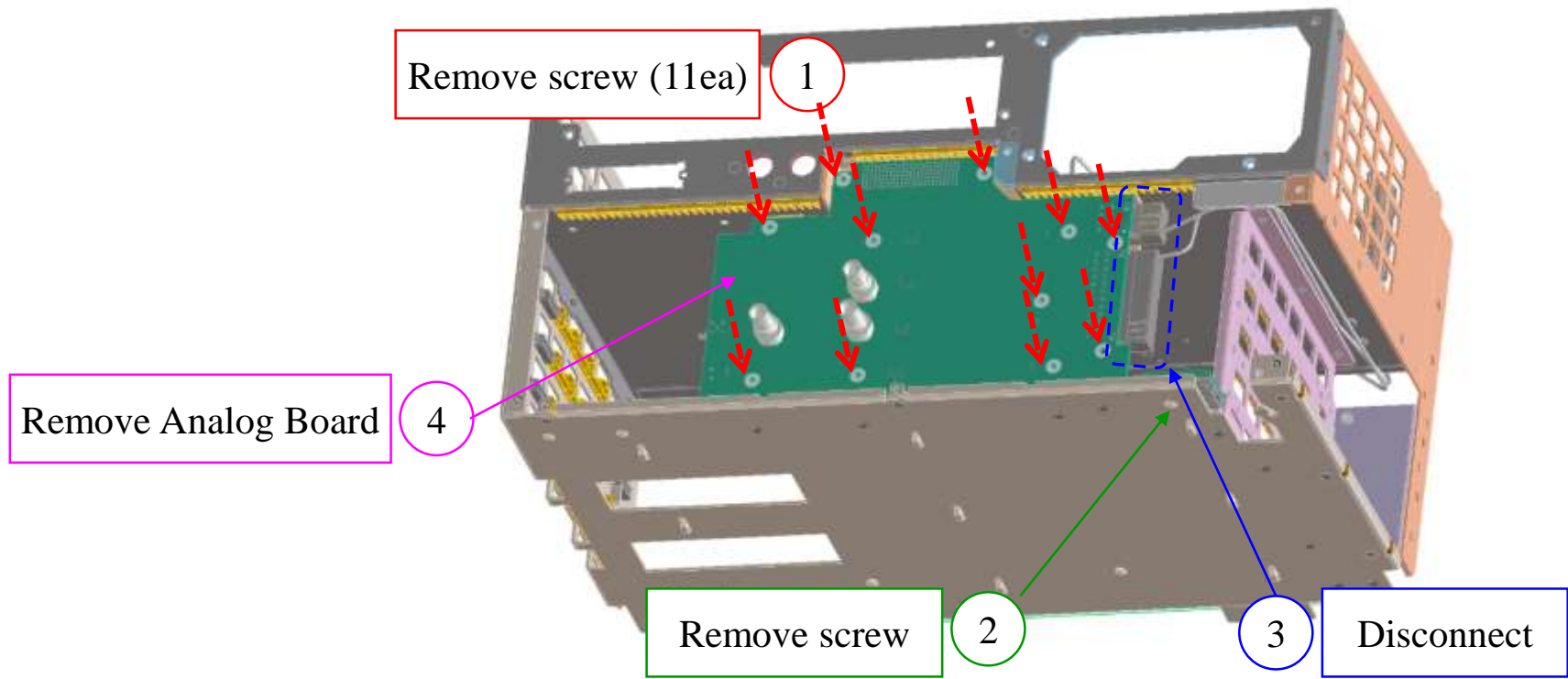
1

1





① ②



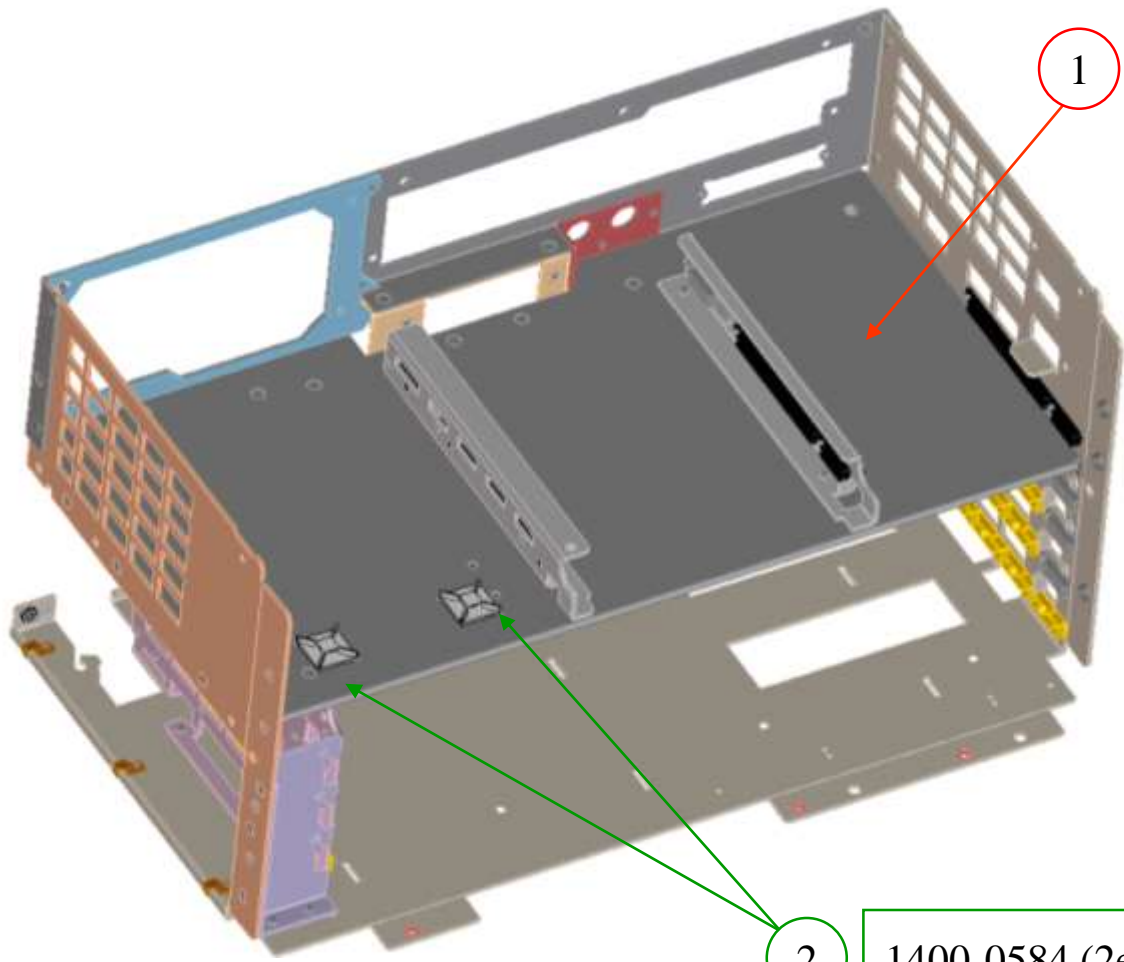
1 2 3 4

E5063A

Assembly Procedure

GENERAL INSTRUCTIONS:

1. Hand start (only a few turns) for all screws or nuts prior to torquing.
2. During screws/ nuts torquing, perform in X-tightening sequences.
3. All SMA cable connections require 9.5 lbin torque.



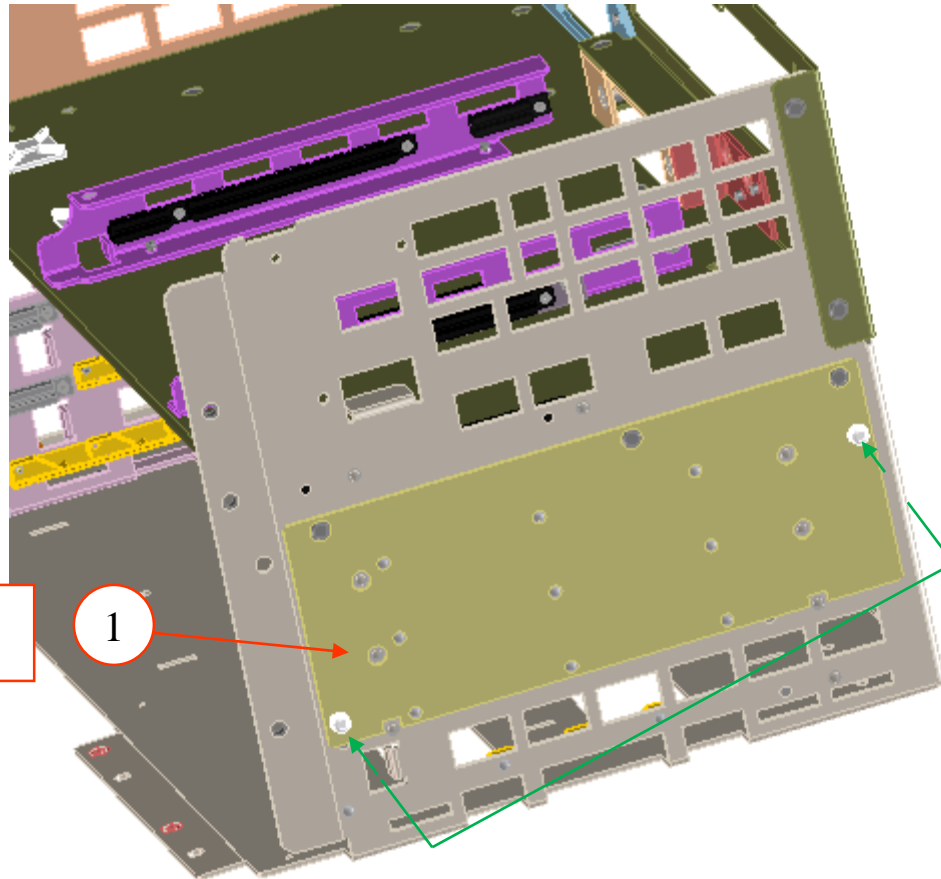
1

E5061-60006

2

1400-0584 (2ea)

1 2



E5063-00604

1

2

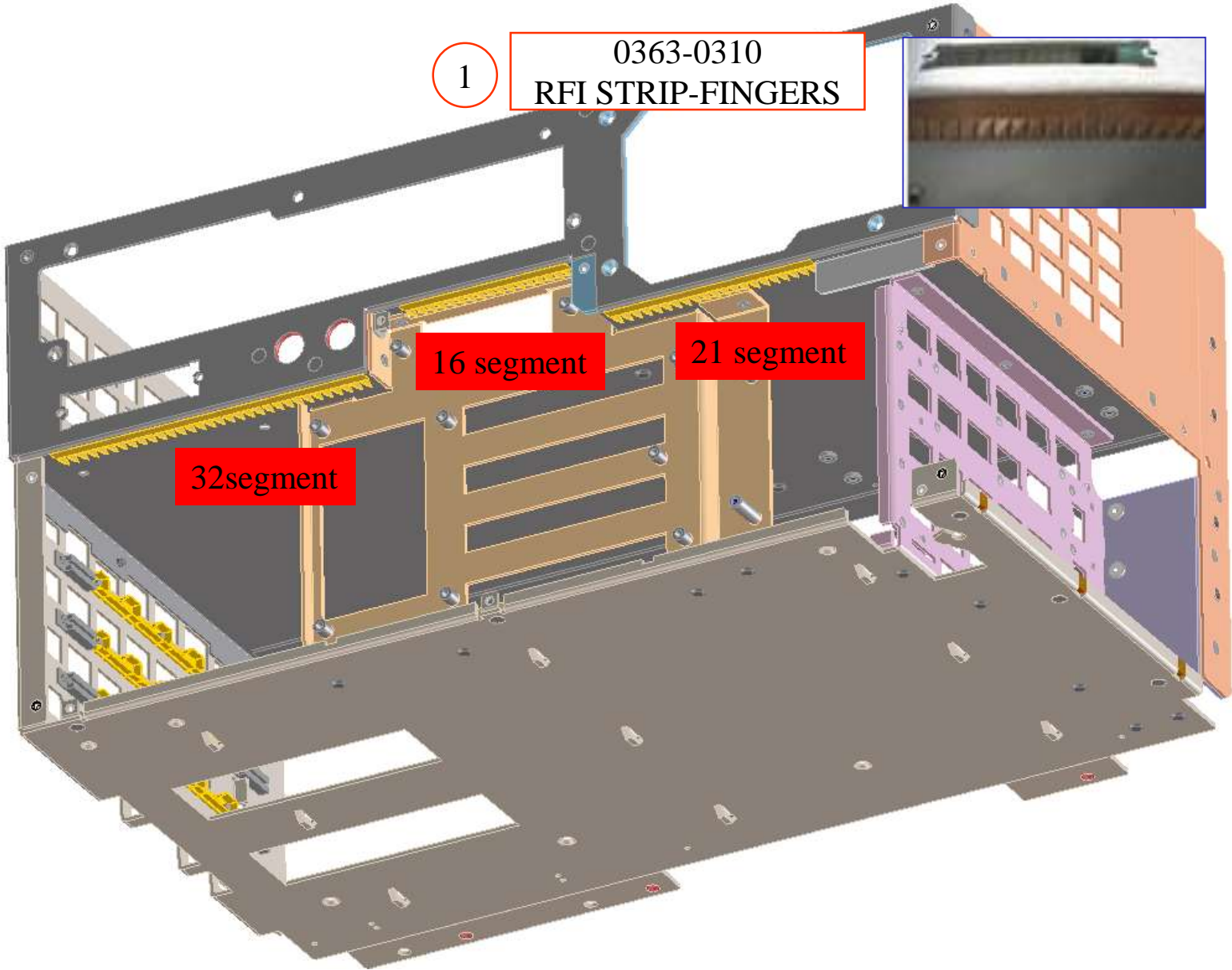
0515-0430 (2ea)
M3L6 PAN

9inlb

1 2

1

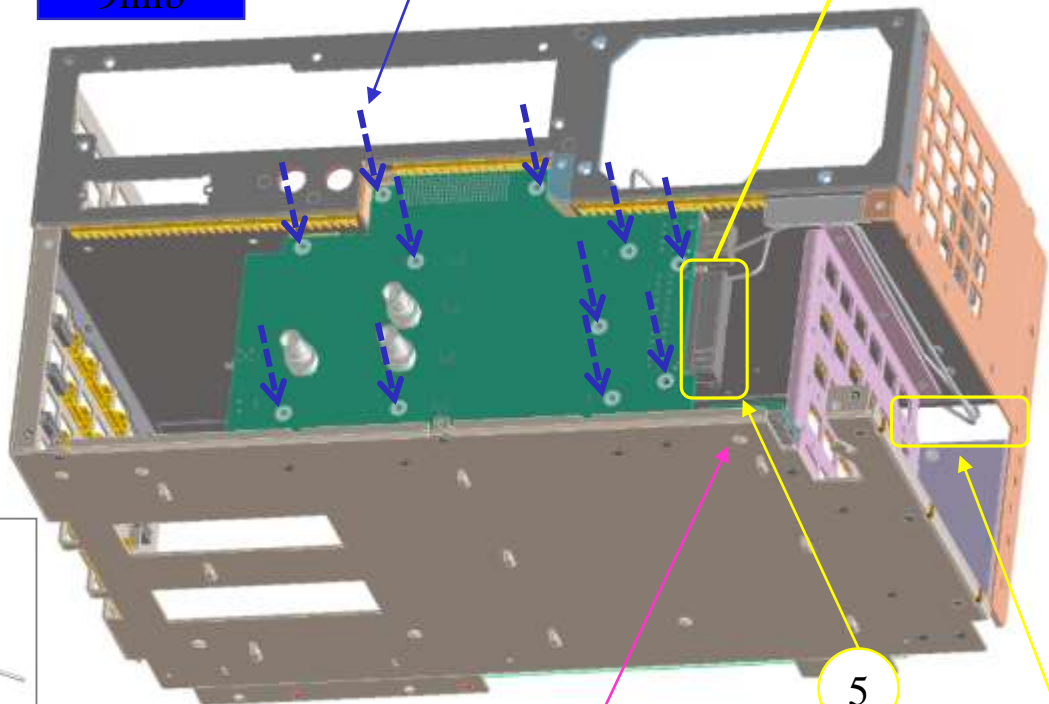
0363-0310
RFI STRIP-FINGERS



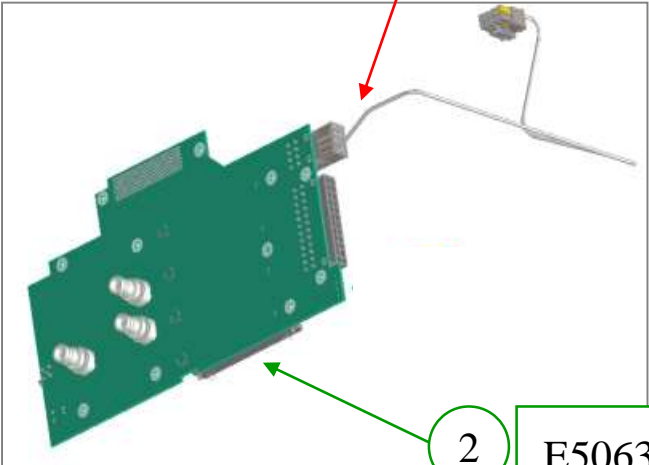
1



0515-0430 (11ea)
M3L6 PAN
9inlb



E5061-61612 1



0515-1946
M3L6 FLAT
9inlb

E5061-61611

“Analog M” cable needs to be slotted through the chassis open hole first before connecting to A10 Board.

E5063-66610

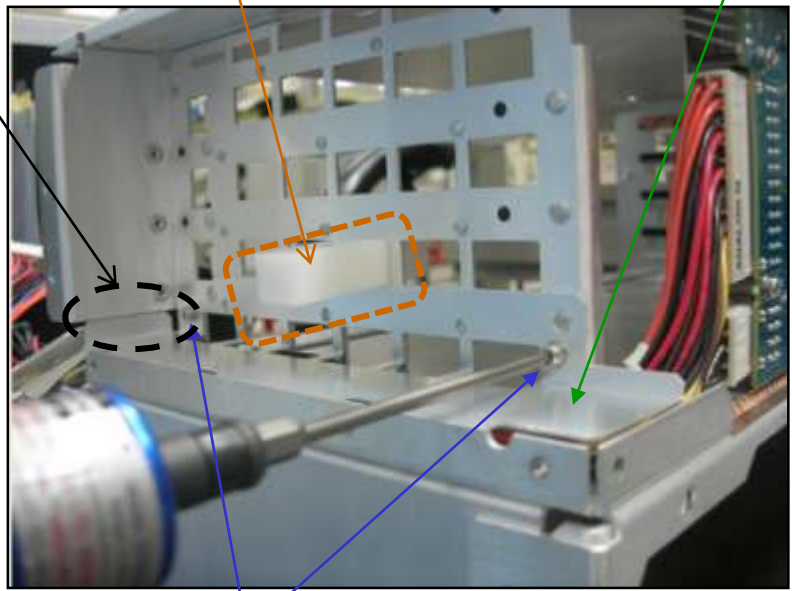
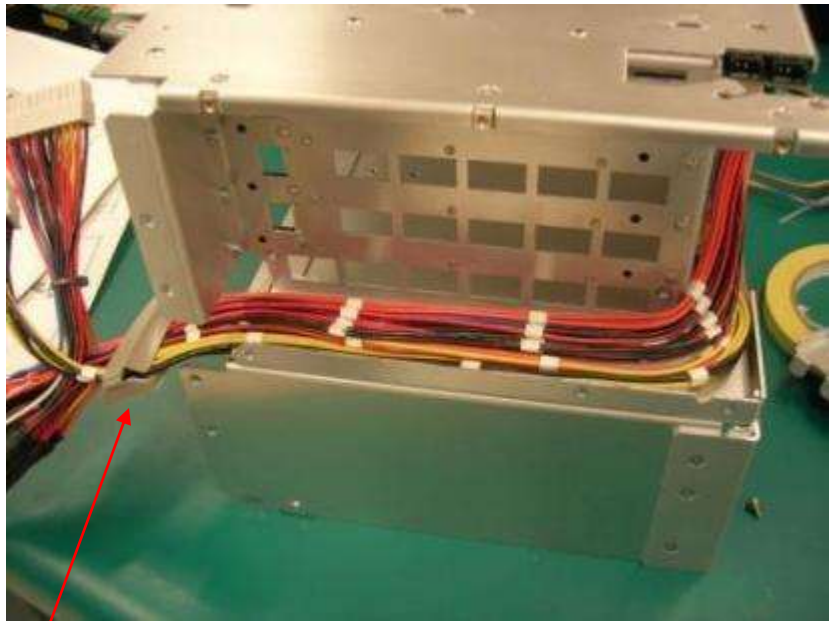
- 1
- 2
- 3
- 4
- 5

Use T-384186 to hold Angle

E5061-01207

2

Stopper



3

0515-0430 (2ea)
M3L6 PAN

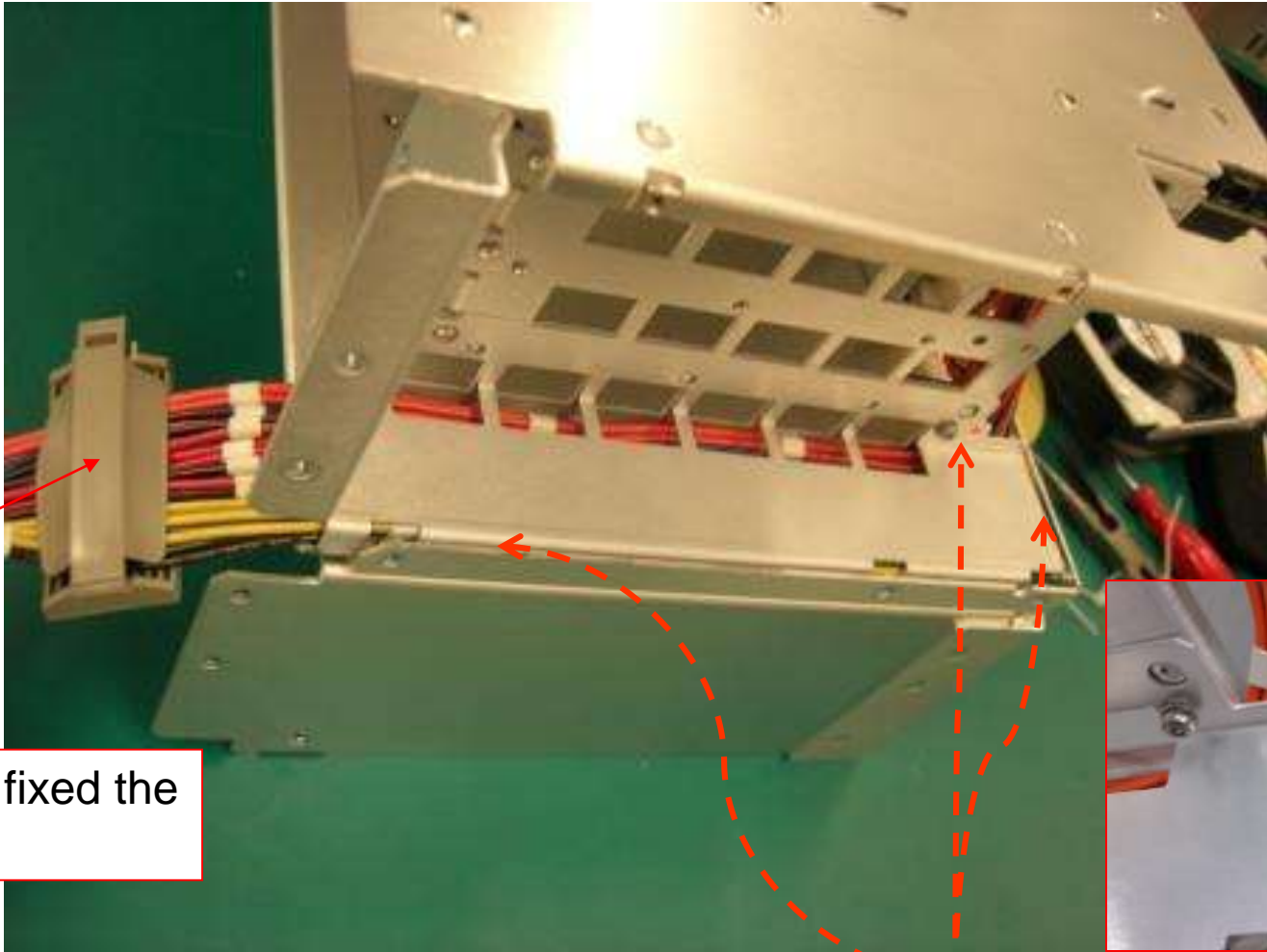
9inlb

Pull and push on the cables while tightening screw

1

Cables are divided with thin groups to be flat and temporary clamp with Jig (T-384163) to positioning its location.

1 2 3



1

T-384163

Remove jig after fixed the plate to chassis.

Attention: Ensure cable do not squeeze by plate

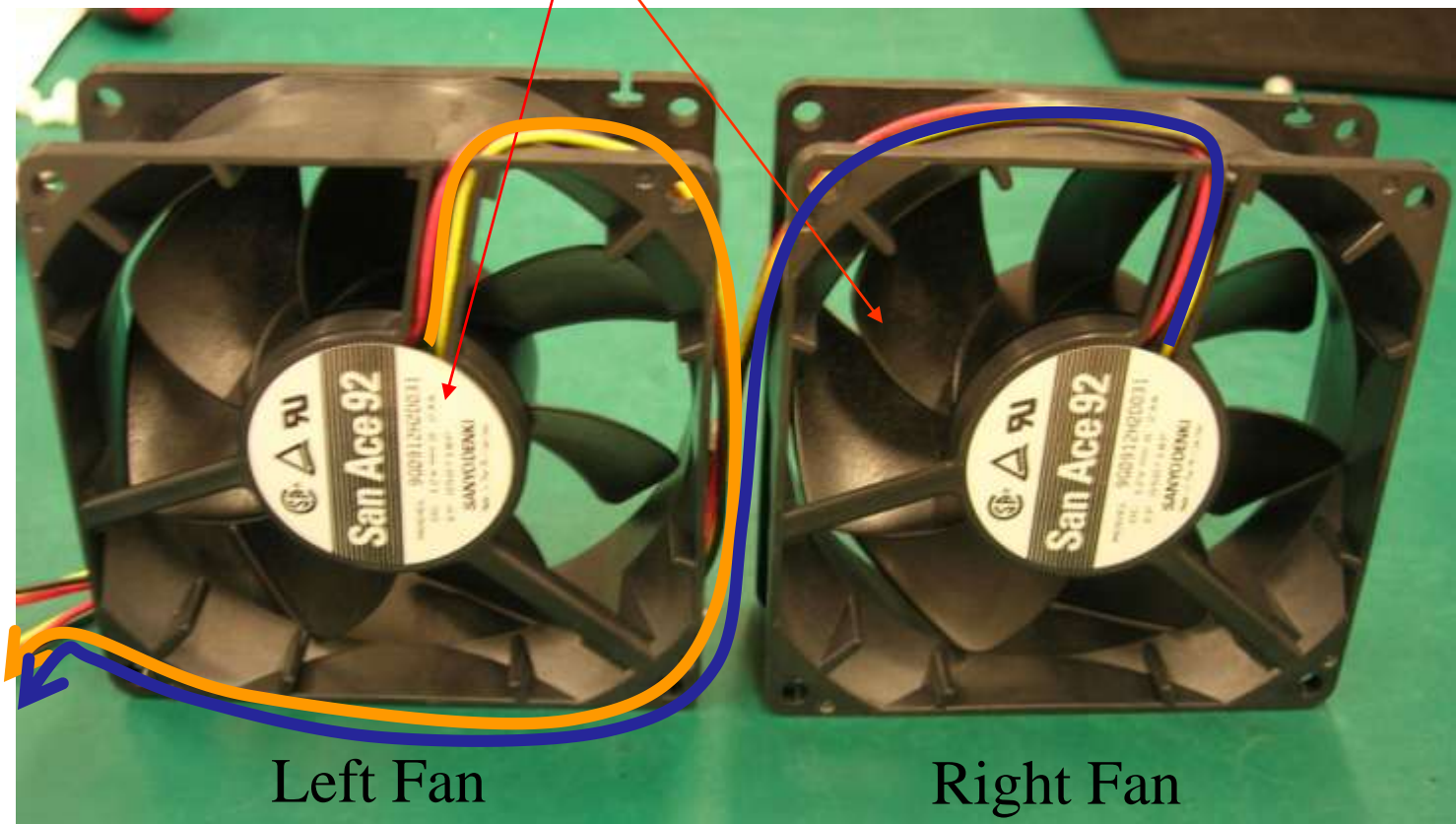
1

FAN SUB-ASSEMBLY

①

E5071-61628 (2ea)
FAN ASSY Middle Speed

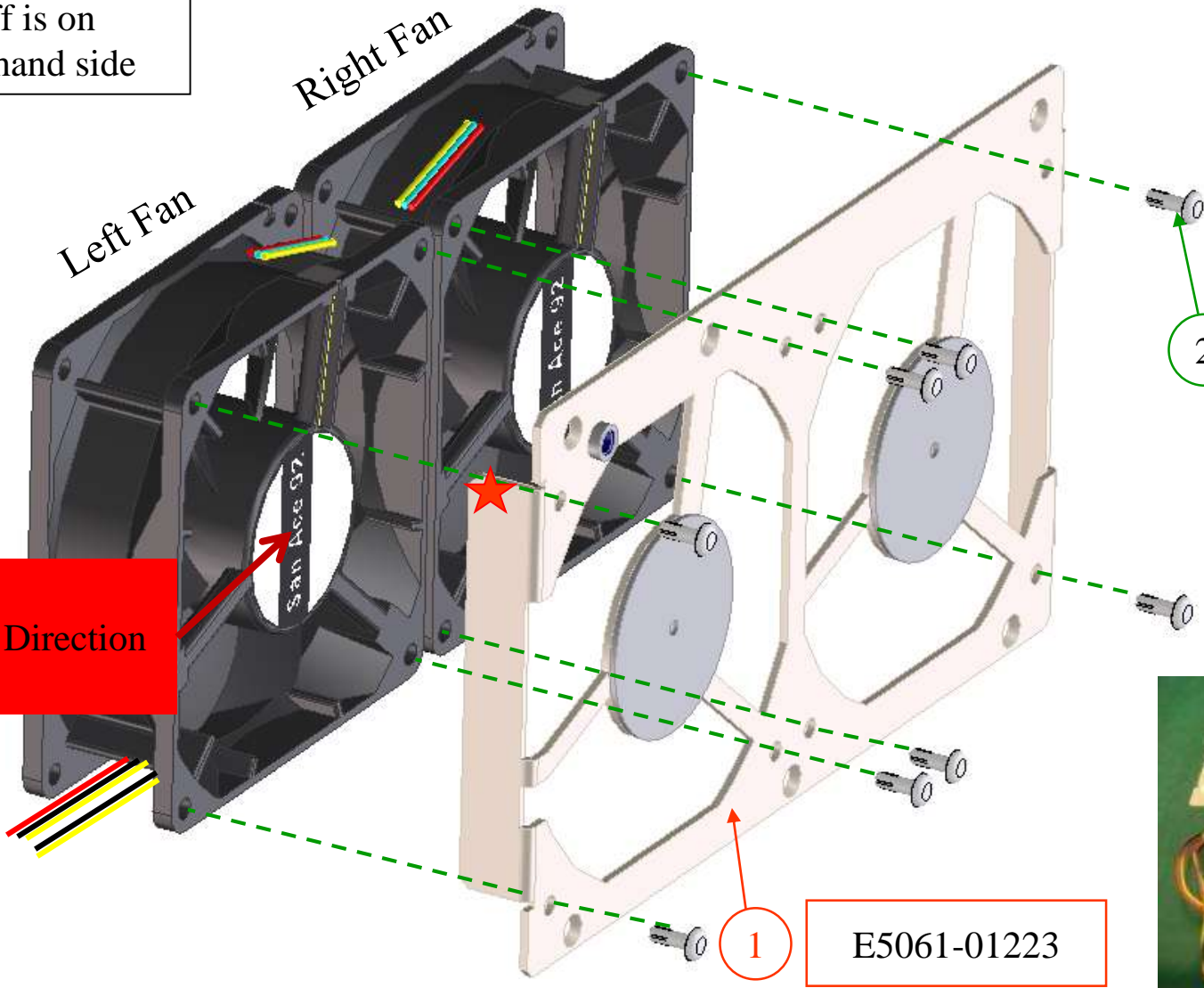
Route wire from fan as below



①

★ Standoff is on upper left hand side

Left Fan
Right Fan



Note:
Ensure Fan Direction
is correct

① ②

E5061-01223

0361-1881 8ea
Push Rivet
P4080-W



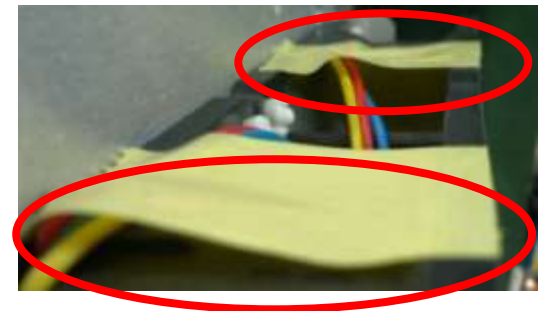
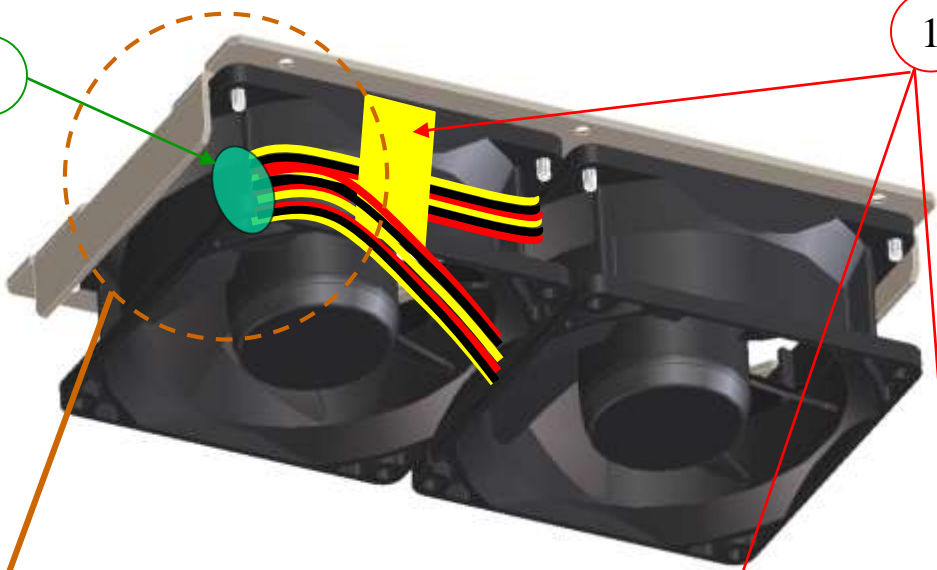
1400-0249
Cable Tie

2

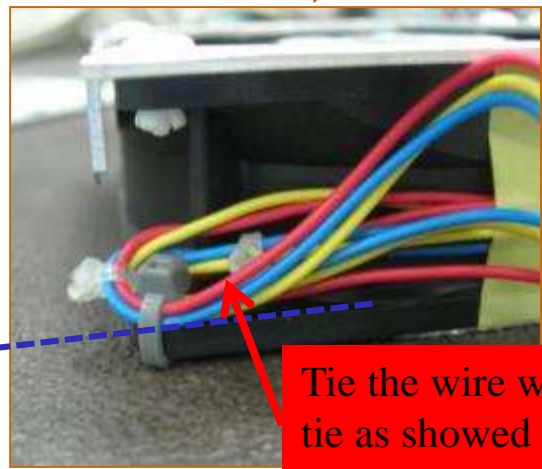
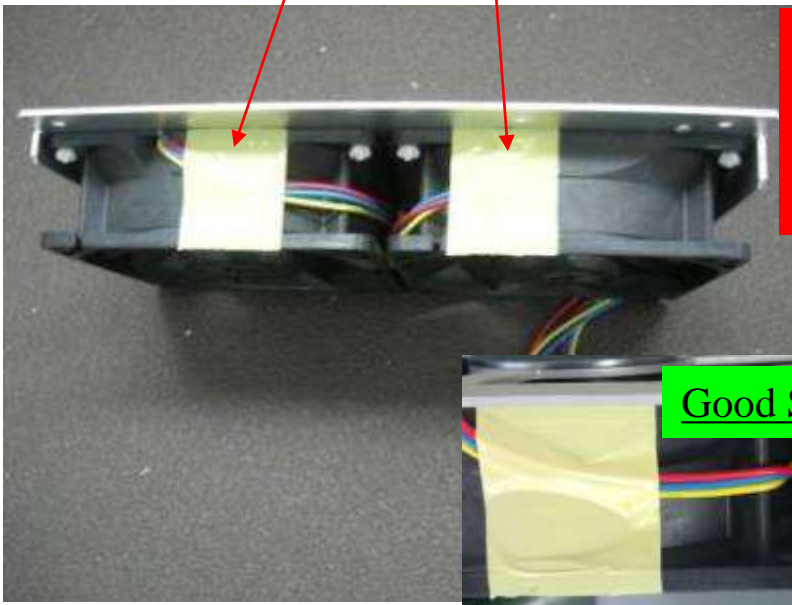
0460-0169 3ea
Tape

Pull both wires before
paste on tape

1



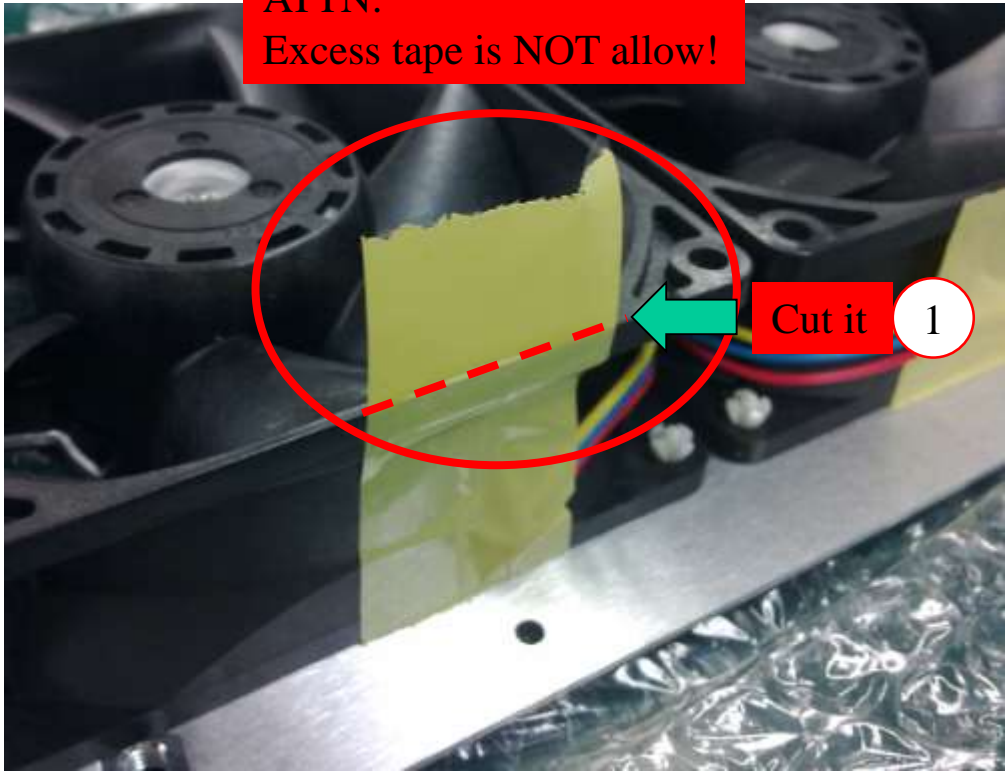
BAD Sample
Note: Make sure
no gap! Tape must
stick properly.



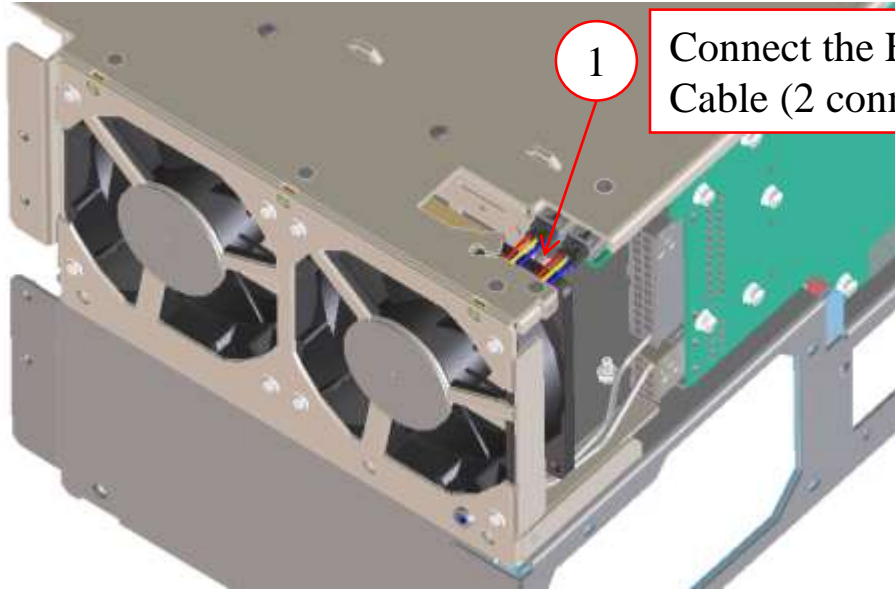
Tie the wire with cable
tie as showed in picture
and ensure wire is push
inward

1 2

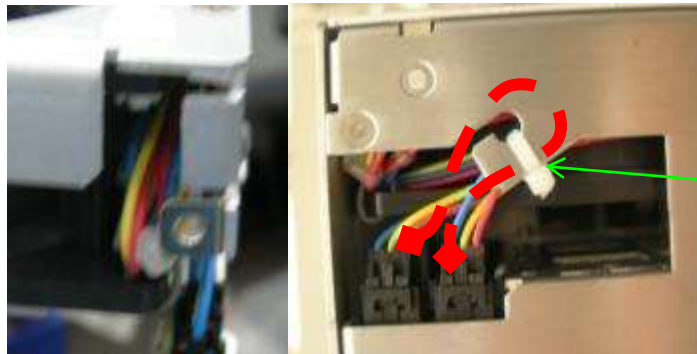
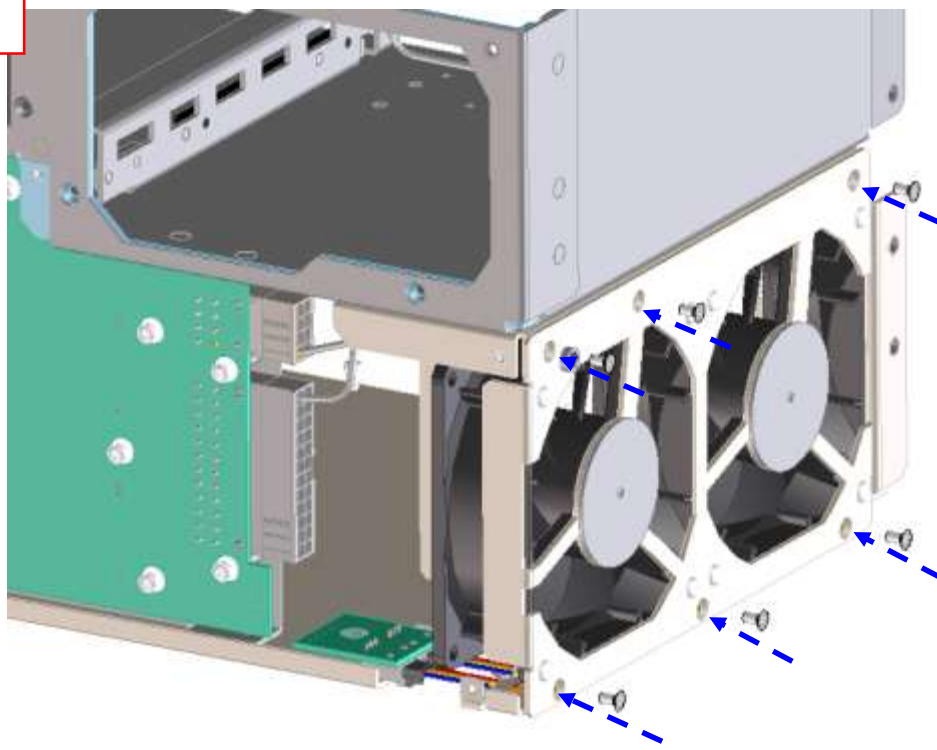
ATTN:
Excess tape is NOT allow!



①



1 Connect the Fan Cable (2 connector)



2 1400-0249 Cable Tie

Push these wires underneath of chassis

0515-1946 (6ea)
M3L6 Flat

9inlb

3

1 2 3

0950-4989
Power Supply

1

E5070-87103
Caution Label

2

3
Remove Hex screw
and washers (2ea)

Attention!
Avoid washer from
drop into power supply



1 2 3

REMOVE HEX SCREWS

b70

Rev. A

Fix gasket with 0515-0430 at this corner, remove it after assembled gasket
Note: Alignment of the gasket



1

E5061-07003

2

Reinsert Hex screws and washers (2ea)

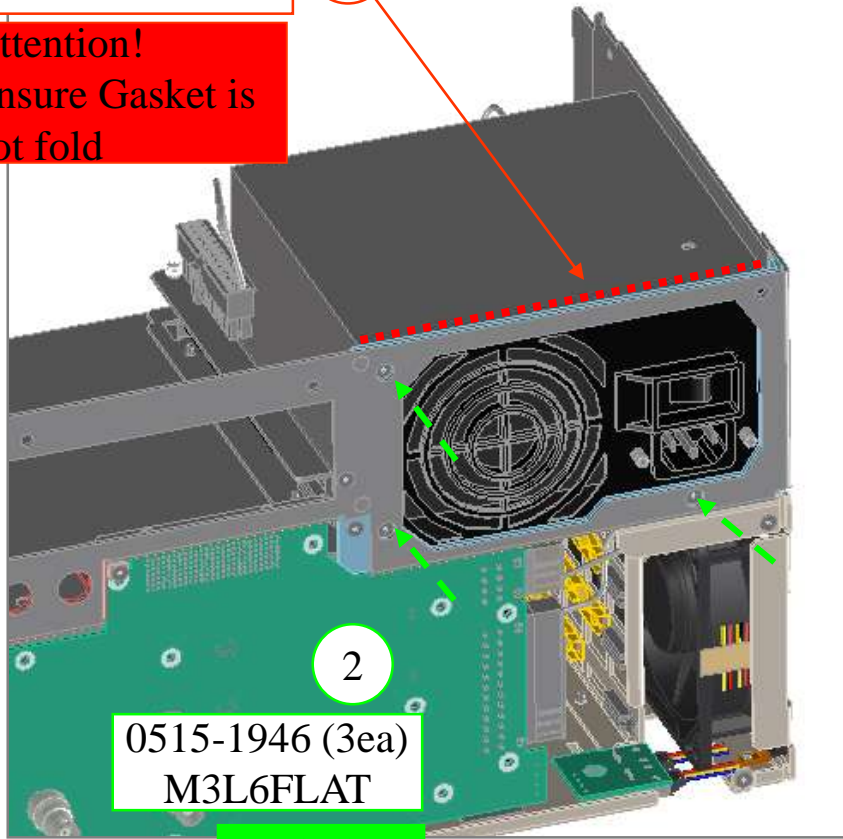
6inlb

1 2

Previous assembly

Attention!
Ensure Gasket is not fold

1



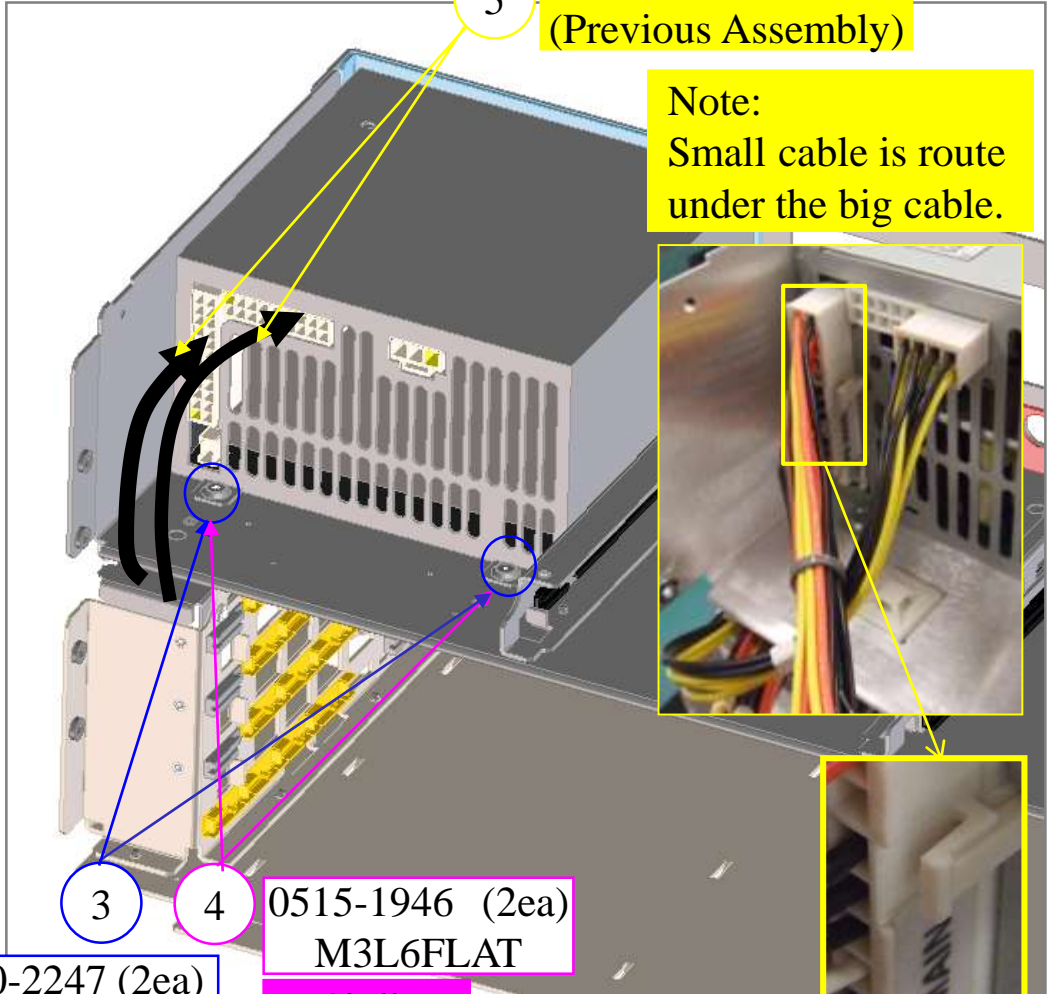
2

0515-1946 (3ea)
M3L6FLAT

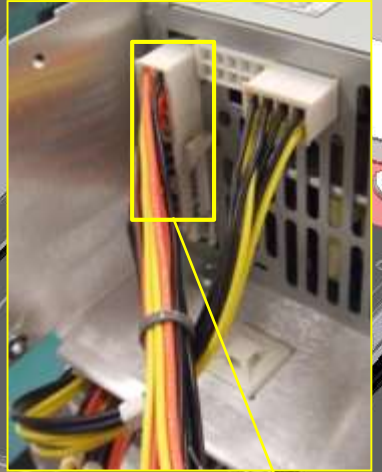
9inlb

Connect cable
(Previous Assembly)

5



Note:
Small cable is route under the big cable.



3

3050-2247 (2ea)
WASHER

4

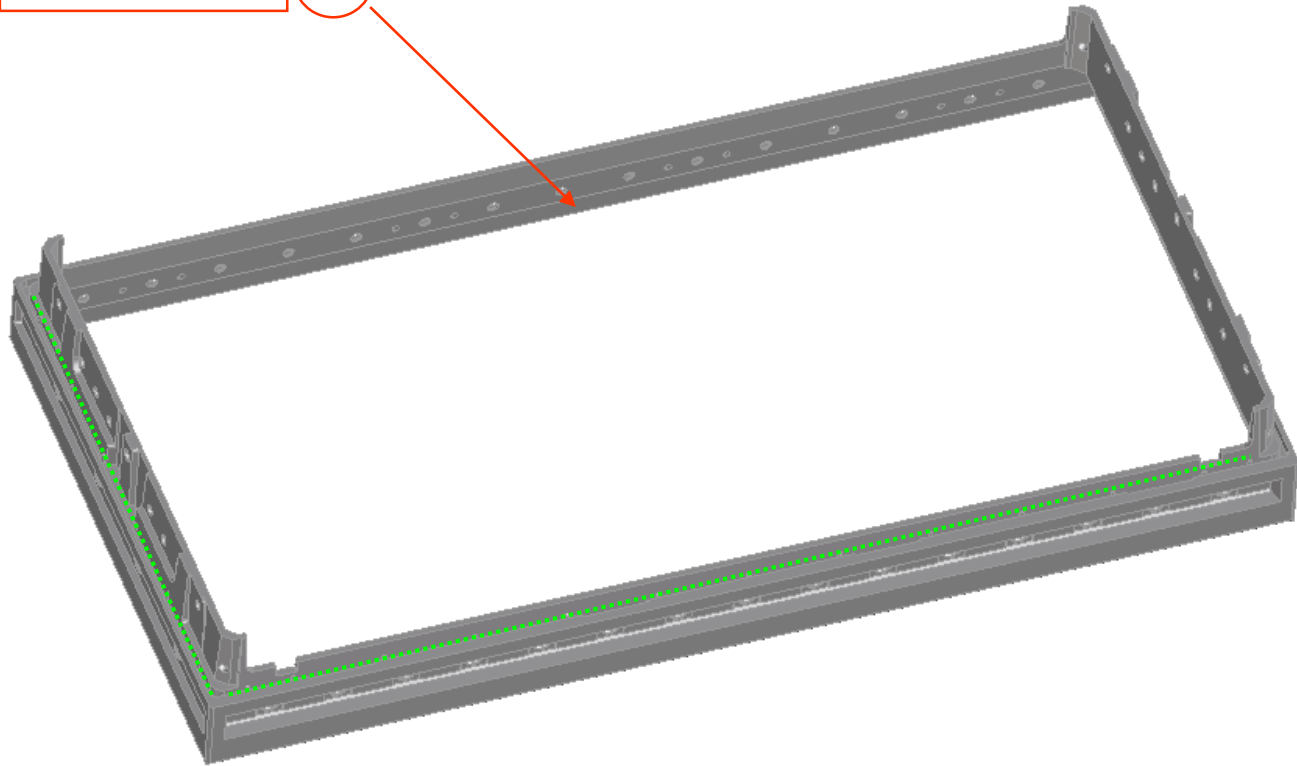
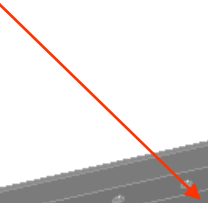
0515-1946 (2ea)
M3L6FLAT

9inlb

- 1 2 3 4 5

5022-1190

1



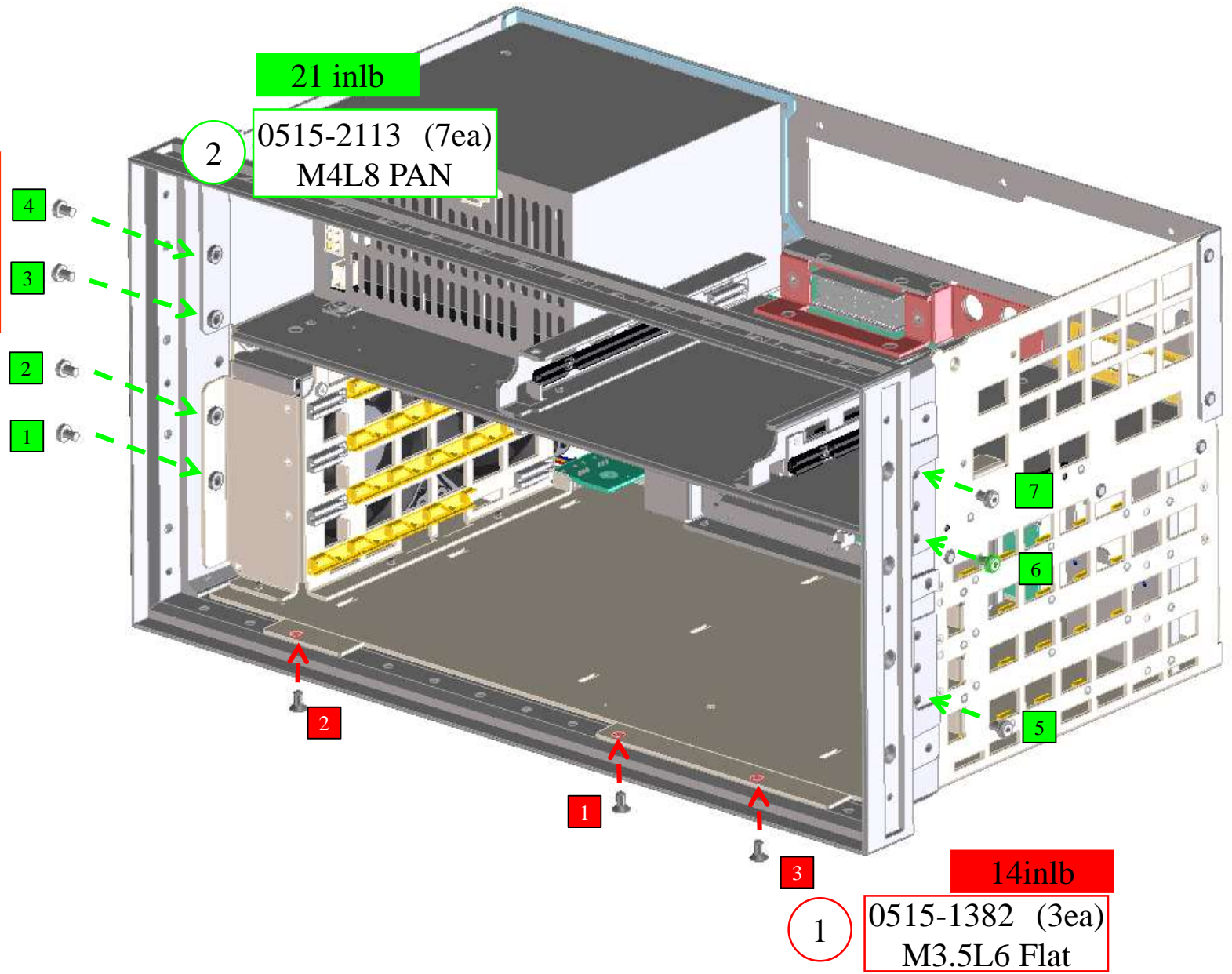
1 2

INSTALL GASKET AT FRONT FRAME

c20

Rev. A

Attention!
Follow the sequence
for screw tightening

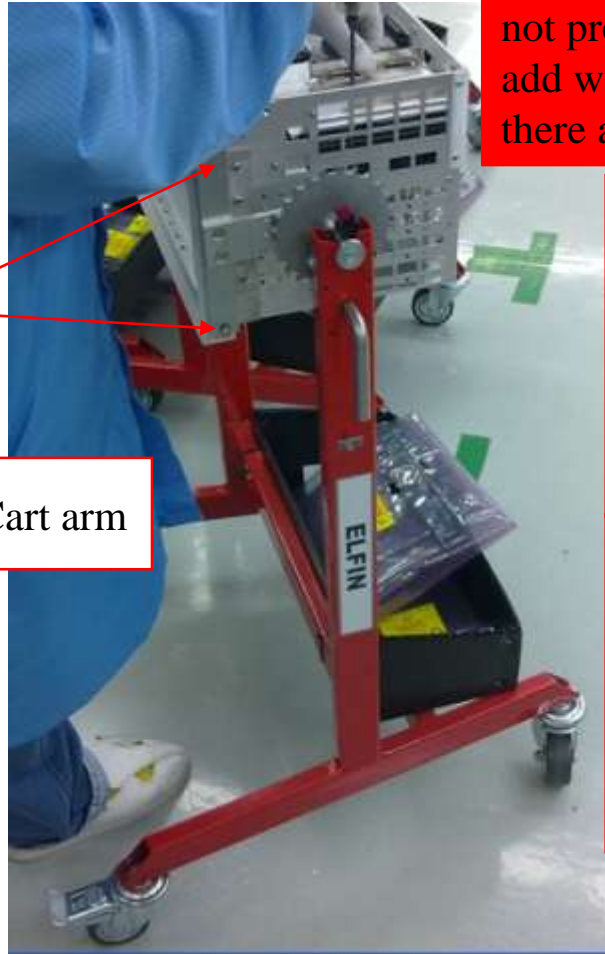
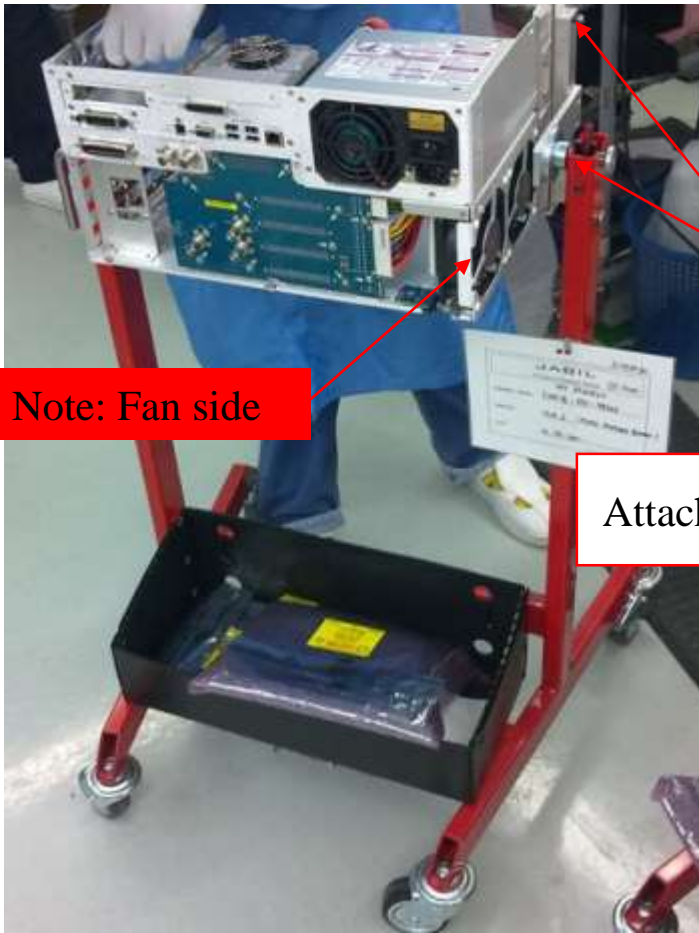


Left Arm

Right Arm

CHECK:

Make sure that the screws are not protruding out. If they are, add washers and re-tighten till there are no protrusions at all.

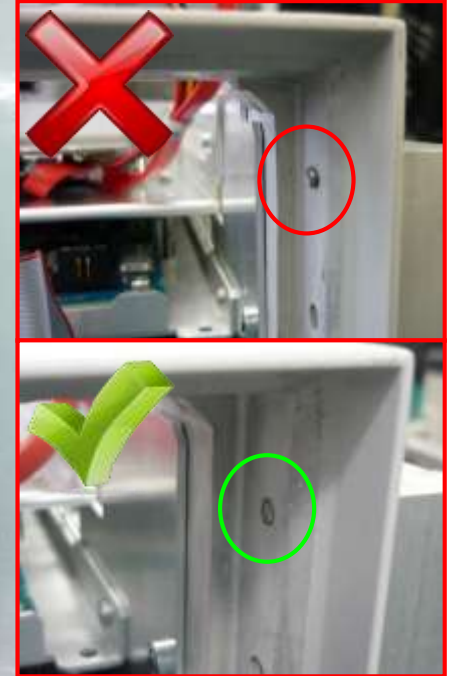


1

Note: Fan side

21 inlb

Attach T-384162, Cart arm



1

E5061-66651

1

ATTN:
Re-slot the A51 board for 3 times
before fasten with washers and Nut.

Re-slot x 3

2190-0054
Qty: 2

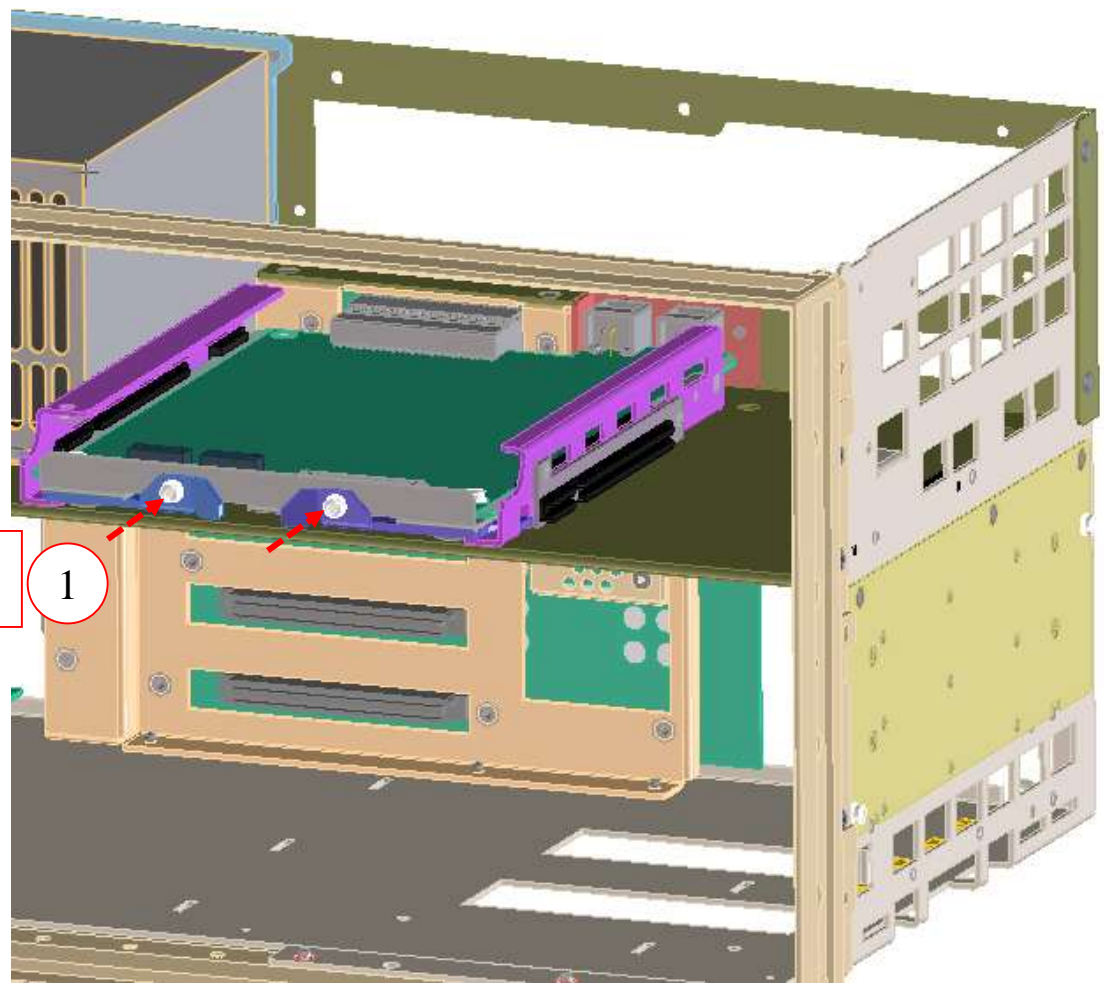
2

2950-0054
Qty: 2

3

Use T-384165 Protective Jig
5/8 Torque box
30.4 inlb

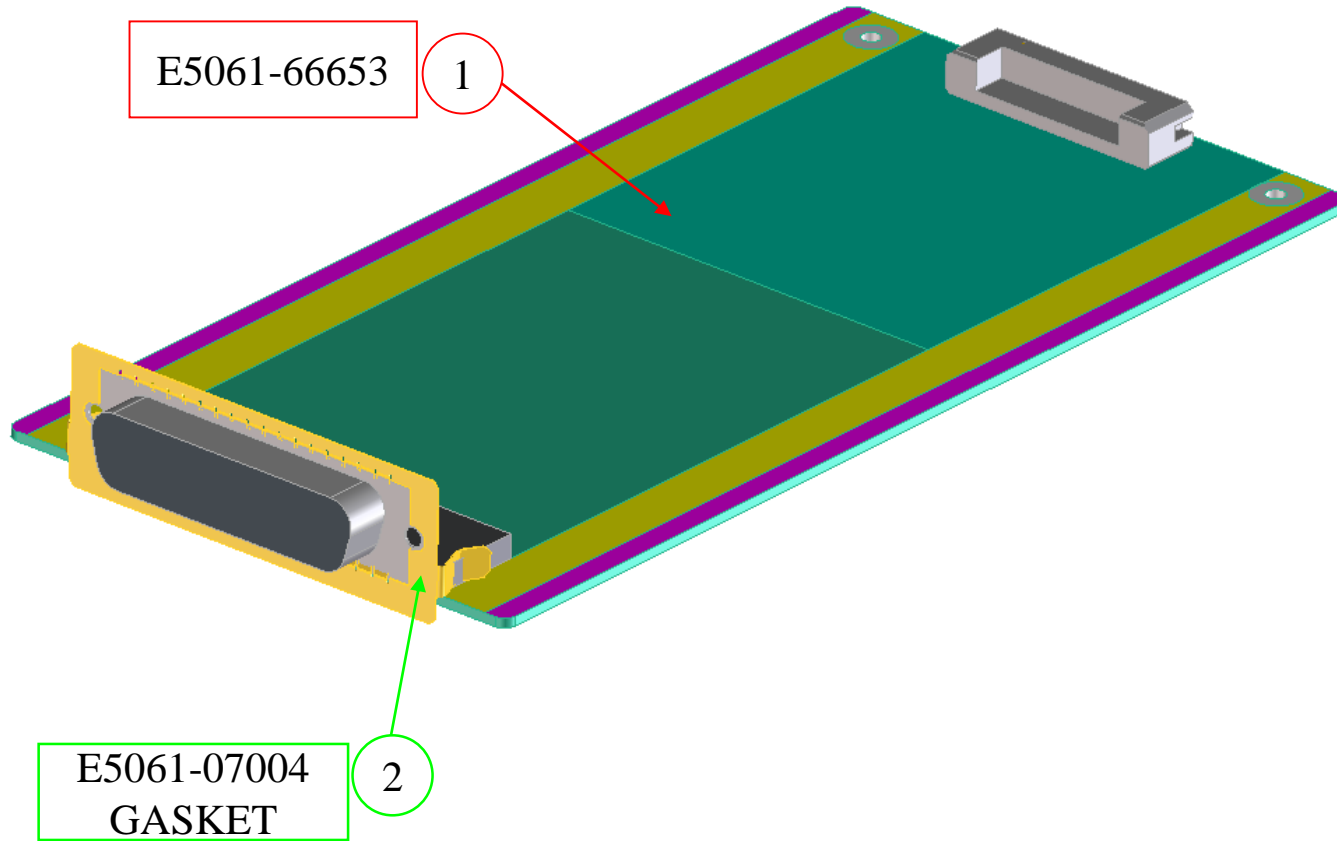
① ② ③



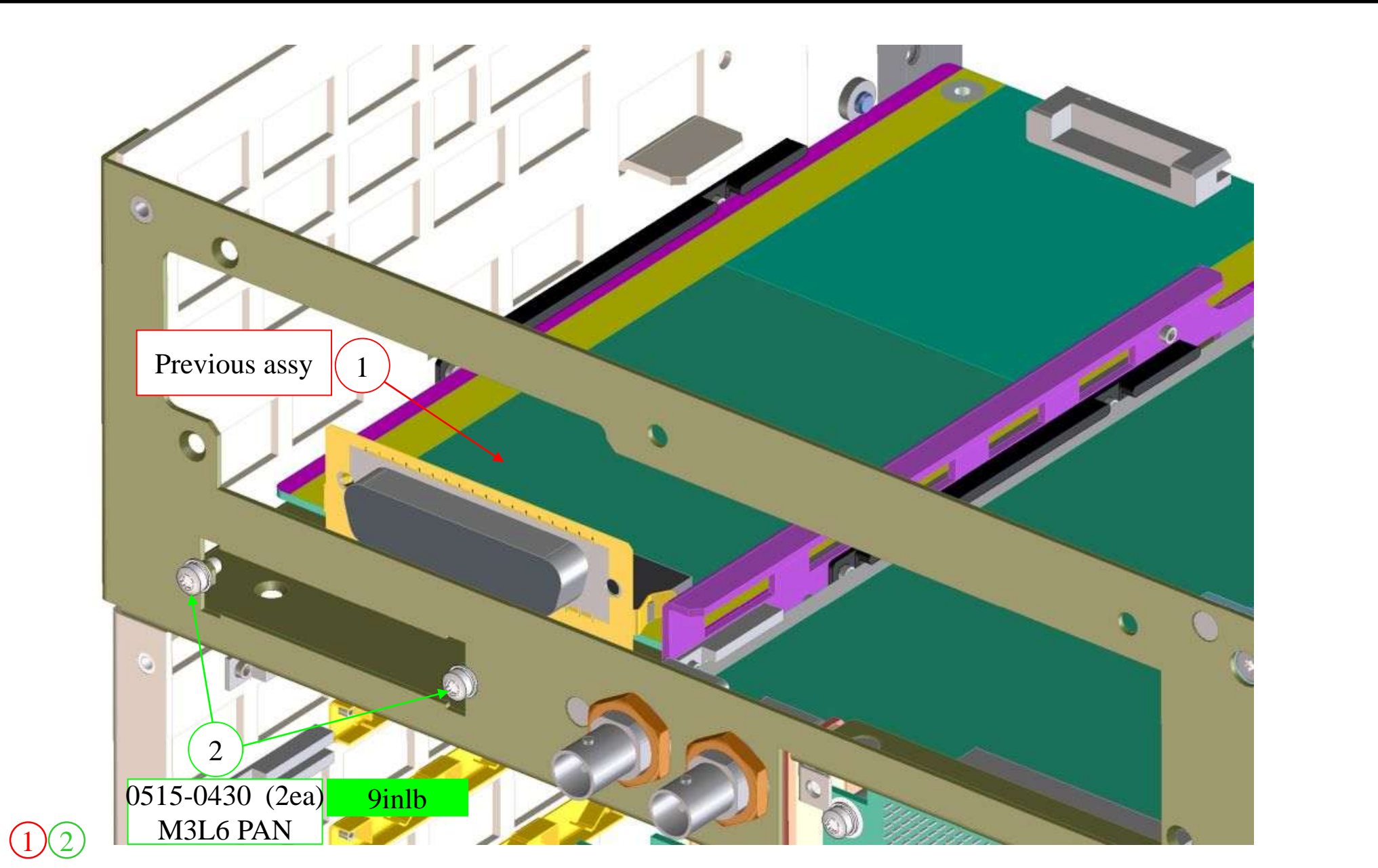
0515-0430 (2ea)
M3L6 PAN

1

1



① ②



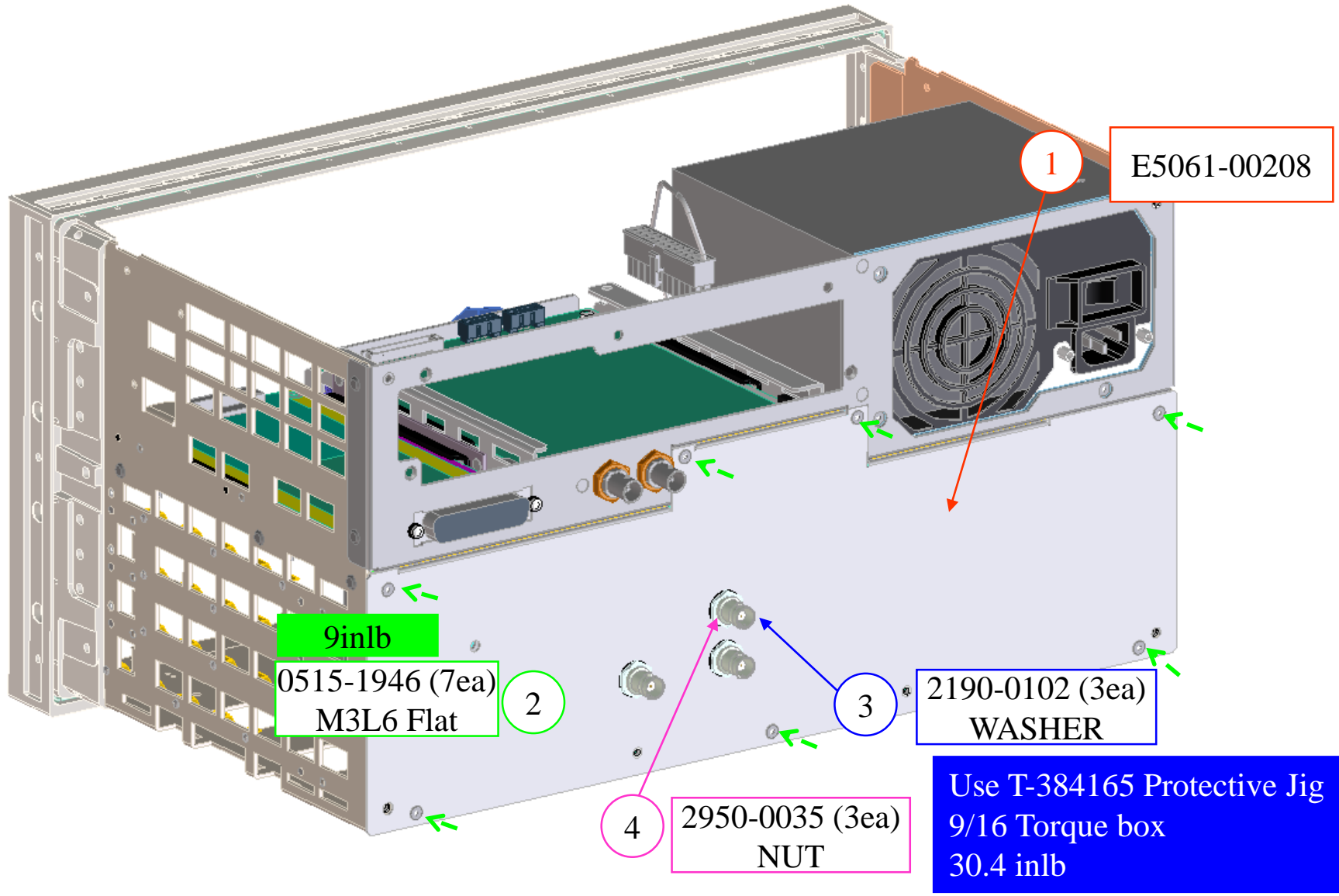
Previous assy

1

2

0515-0430 (2ea) 9inlb
M3L6 PAN

1 2

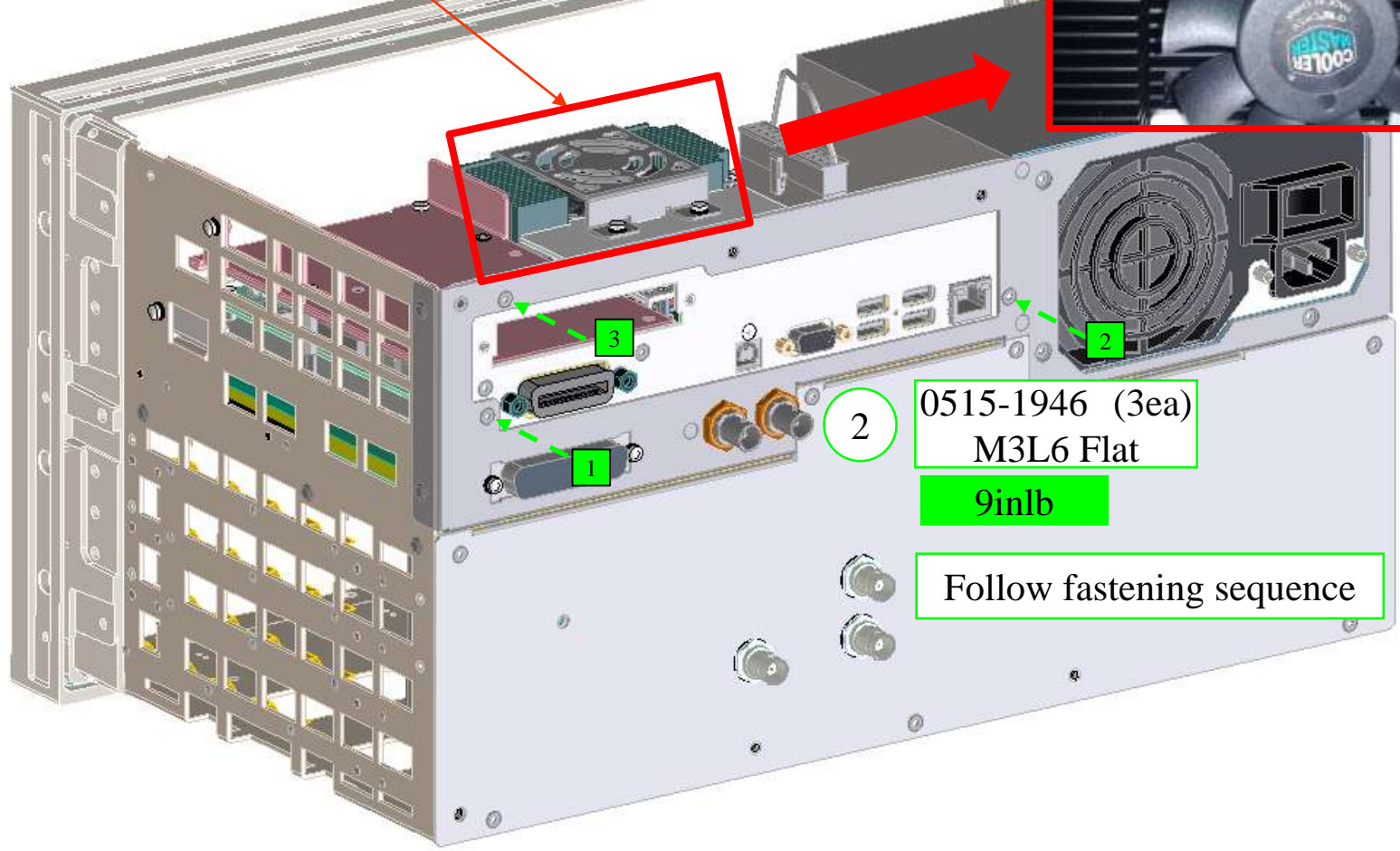


- 1
- 2
- 3
- 4

E5061-62180
Tested CPU Module

1

ATTN:
Confirm the FAN is
not block by cable



3

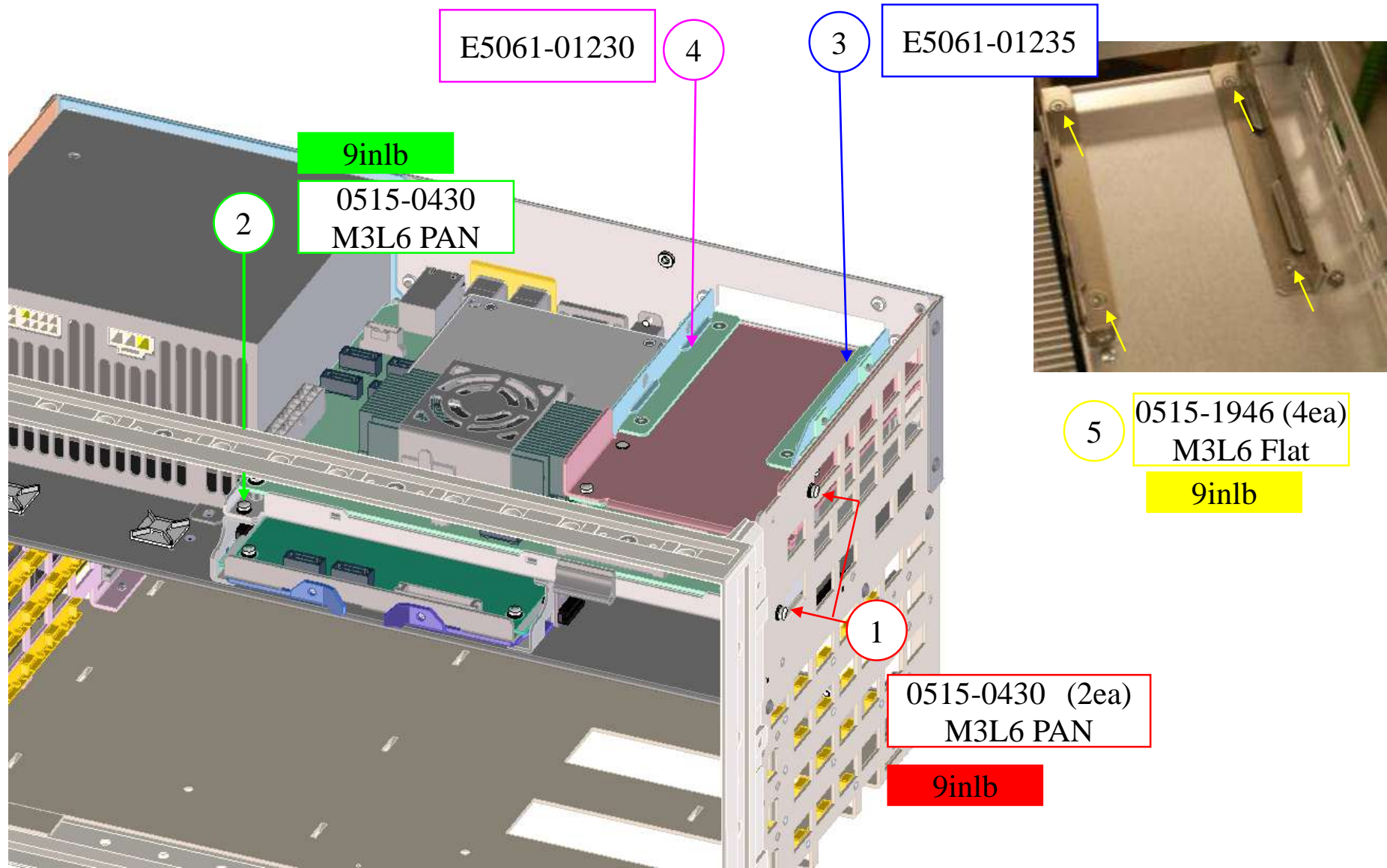
1

2

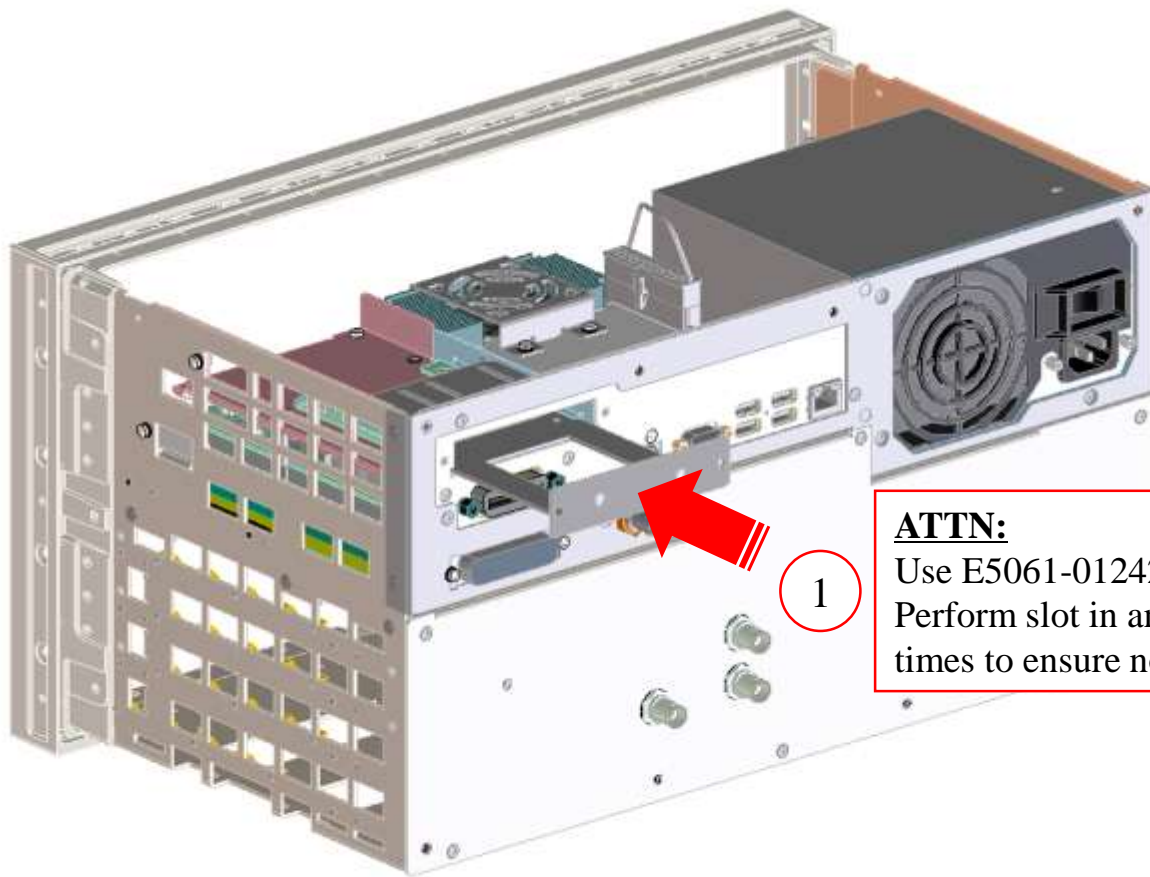
0515-1946 (3ea)
M3L6 Flat
9inlb

Follow fastening sequence

1 2



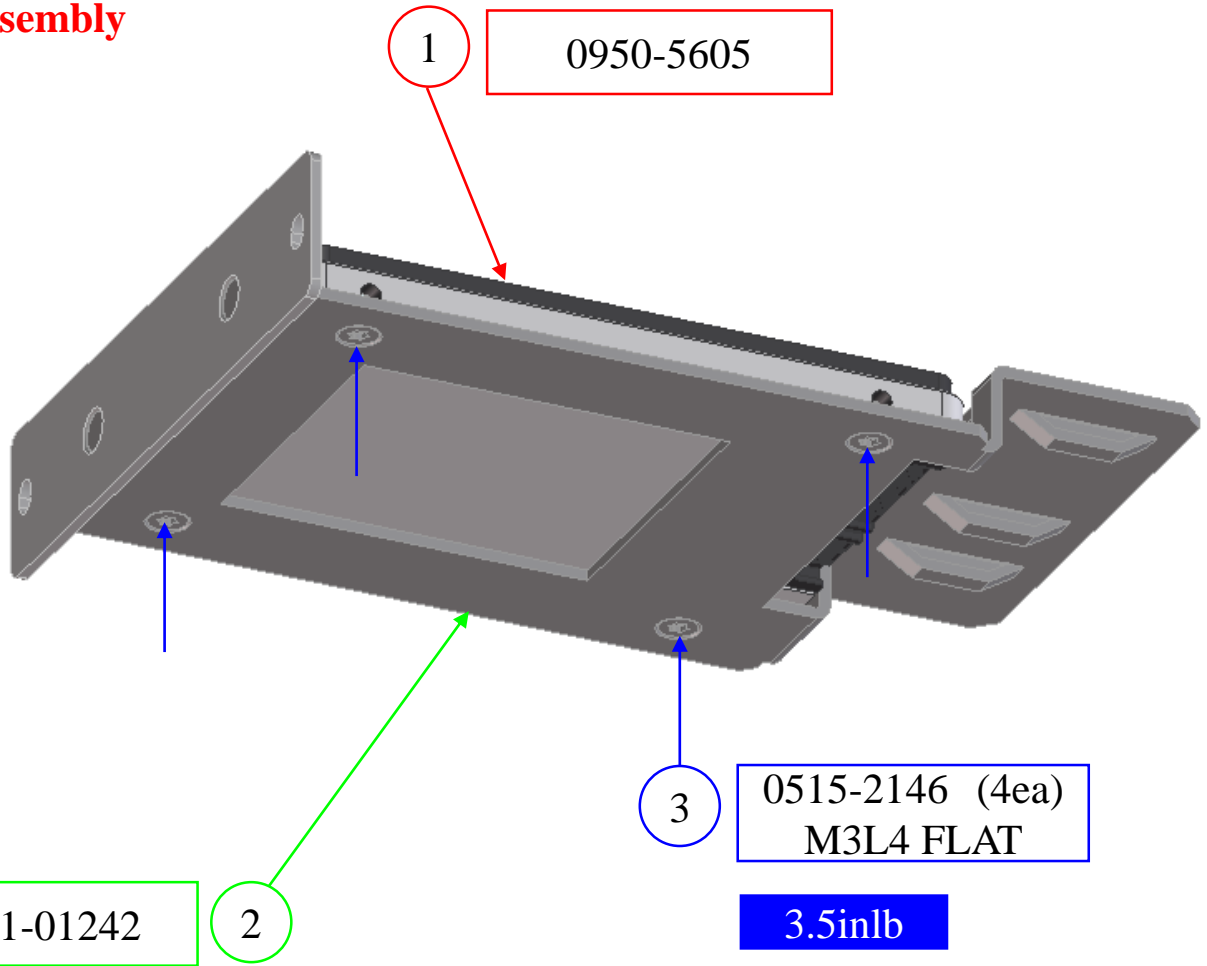
- ①
- ②
- ③
- ④
- ⑤



ATTN:
Use E5061-01242.
Perform slot in and out lightly for 3
times to ensure no stuck issue.

①

SSD Sub-Assembly



1 0950-5605

E5061-01242

2

3 0515-2146 (4ea)
M3L4 FLAT

3.5inlb

1 2 3

7124-0442
Qty 2
(Wording No = "5" at both ends)

1400-0249
Qty 2

1400-0249

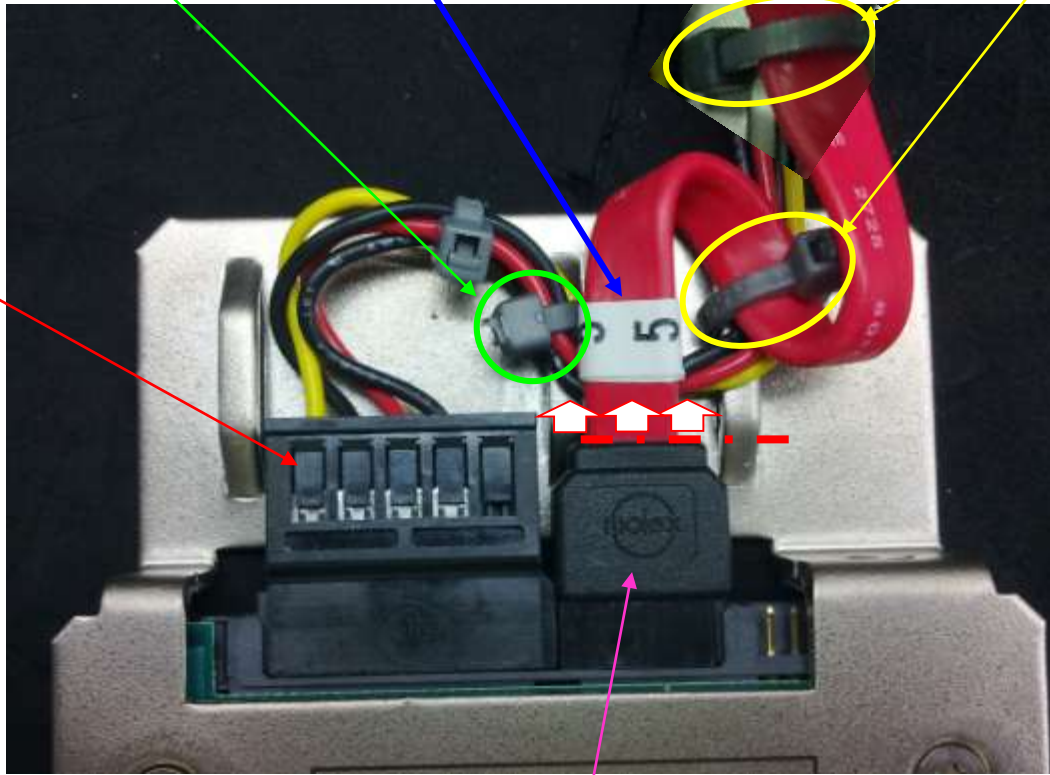
2

3

5

E5061-61614

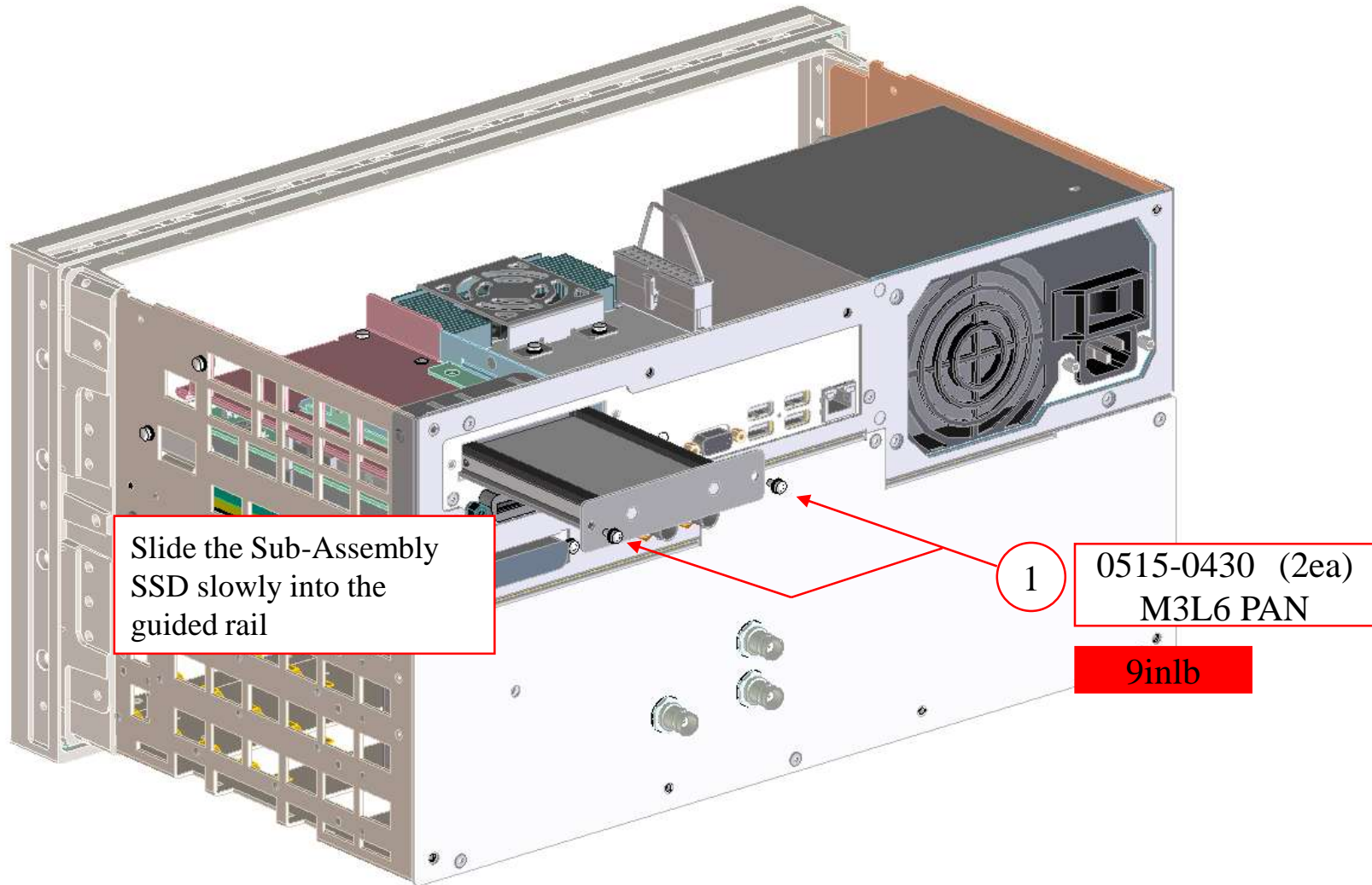
1



8121-1710

4

① ② ③ ④ ⑤

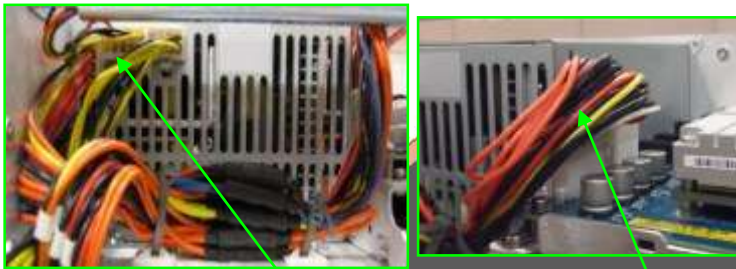
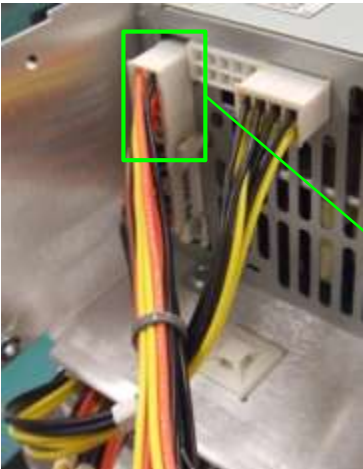


1

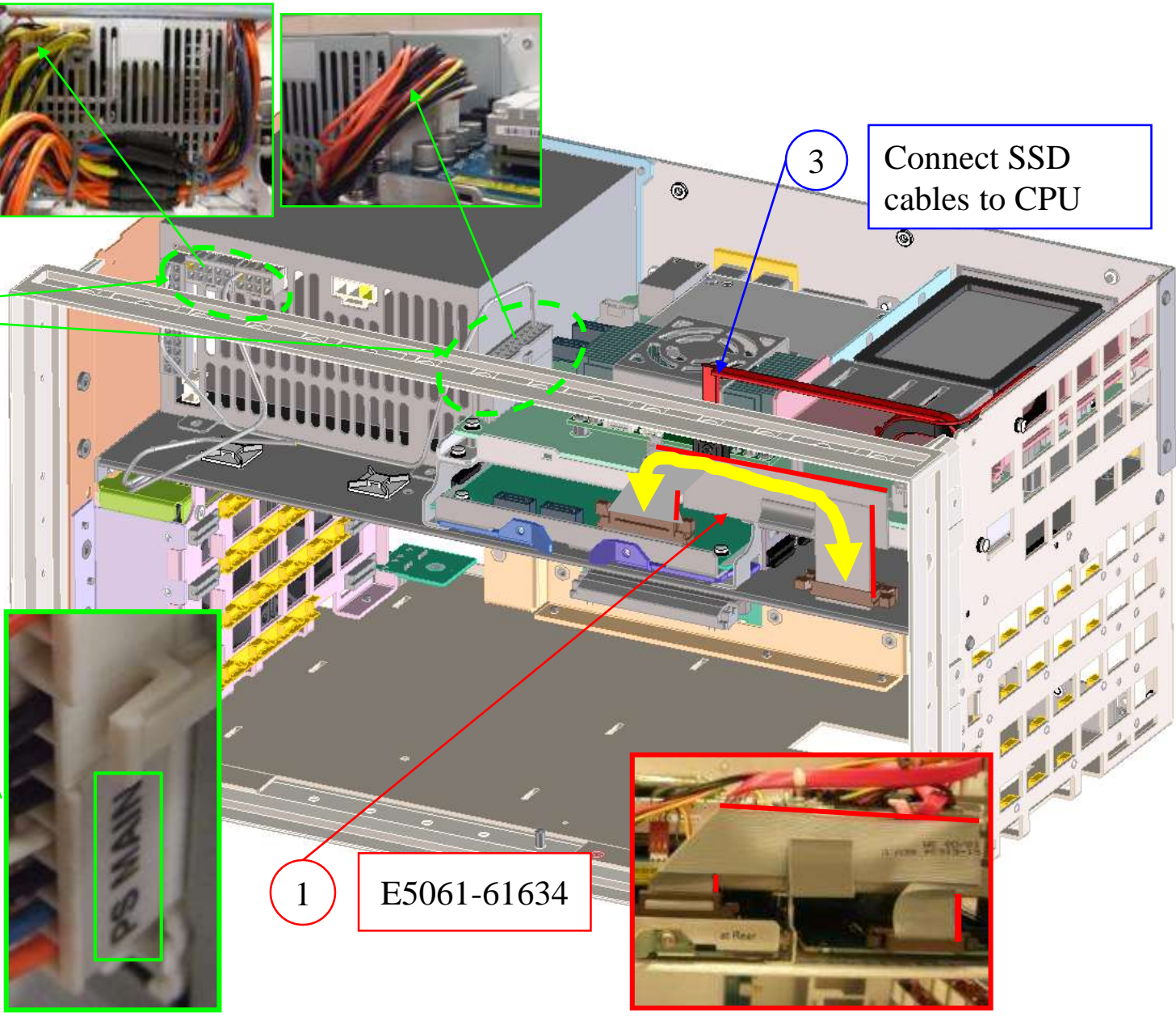
Connect cables to Power supply and CPU Module

2

Note:
Small cable is route under the big cable.



3 Connect SSD cables to CPU



1 E5061-61634



1 2 3

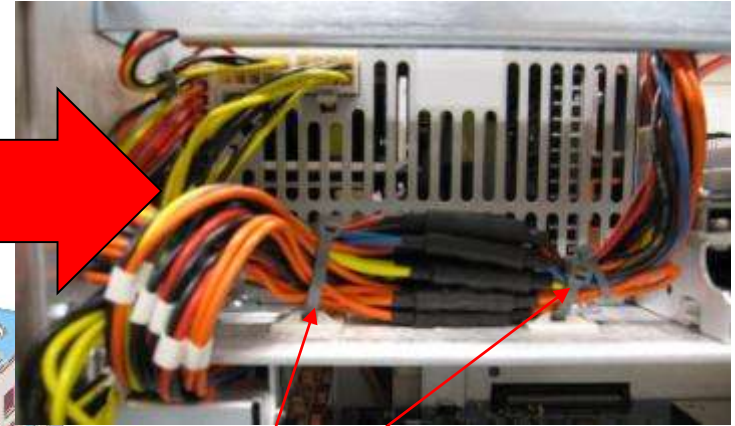
Fix POWER SUPPLY cables

1400-0493 (2ea)
CABLE TIE



1) Ensure yellow color isn't tied up together with the cable tie

2) Cables must be pushed toward PSU when tie up.



1400-0493
CABLE TIE

NOTE:
Make sure wires cable are lower than the top of PSU to avoid being hit by cover when cover up.



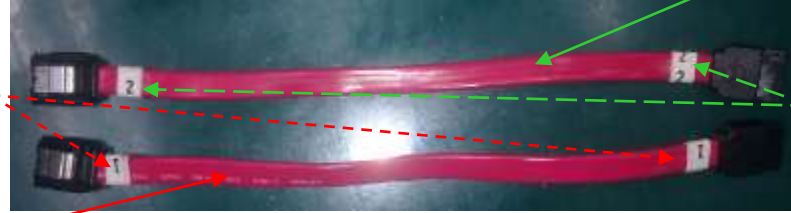
Paste "1" label on both end of the cable

7124-0438 (2ea)
Label + "1"- "1"

E5061-61613 ①
Cable

1a

1b



2b

2a

E5061-61613 ②
Cable

7124-0439 (2ea)
Label + "2"- "2"

Paste "2" label on both end of the cable

Connect
(x4)

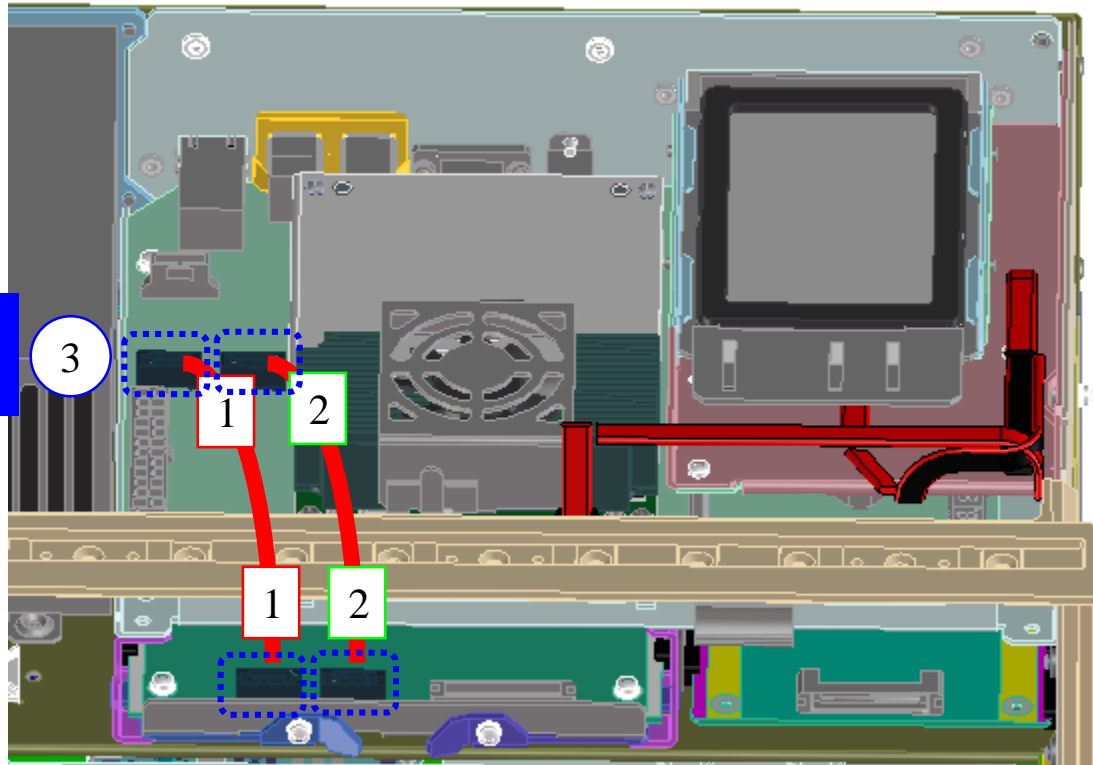
3

1

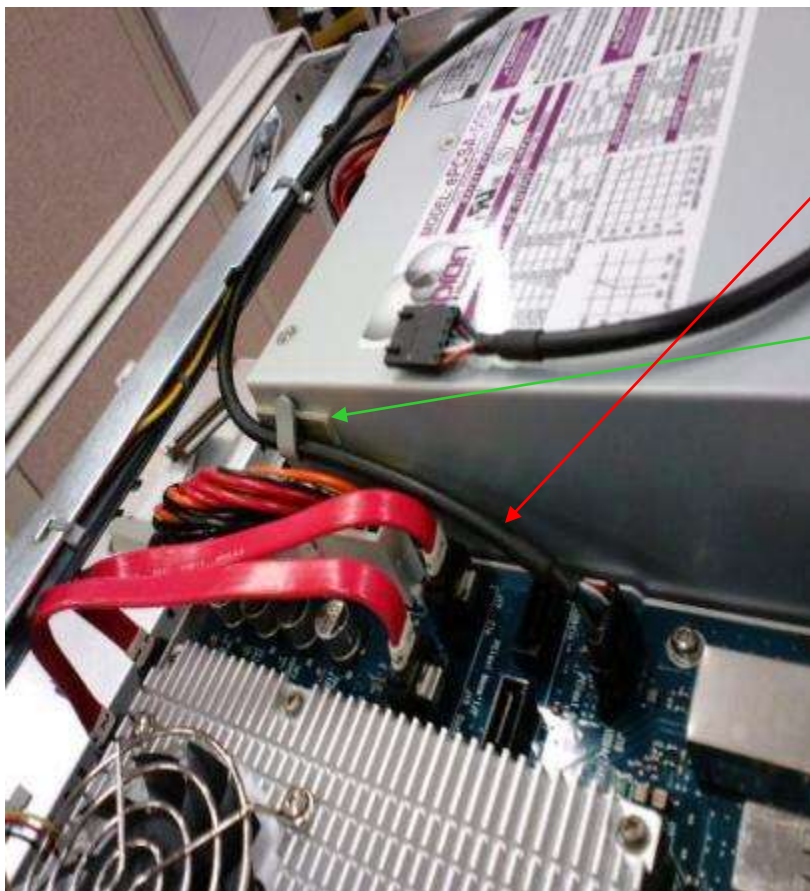
2

1

2



① ② ③



1

E5061-61652

2

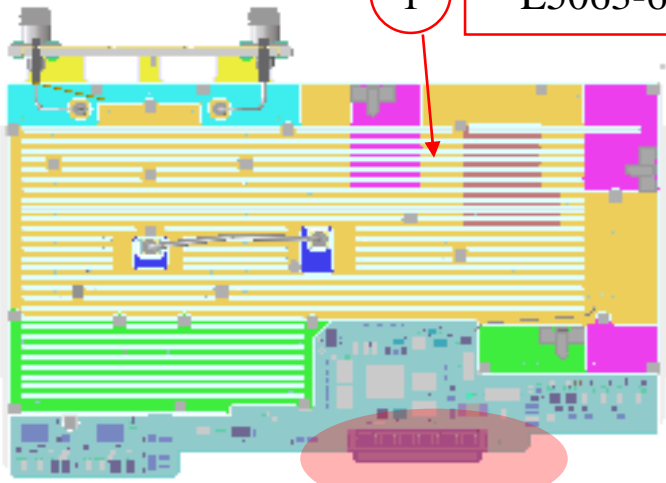
1400-1334

Steps:

- 1) Connect the cable to **J18** port on the CPU board
- 2) Paste a cable clamp on the sidewall of the PSU as the picture.
- 3) Clamp the cable properly and run through under the bar properly then tie the cable with other cables together with a cable tie 1400-0249. (refer to page f30)

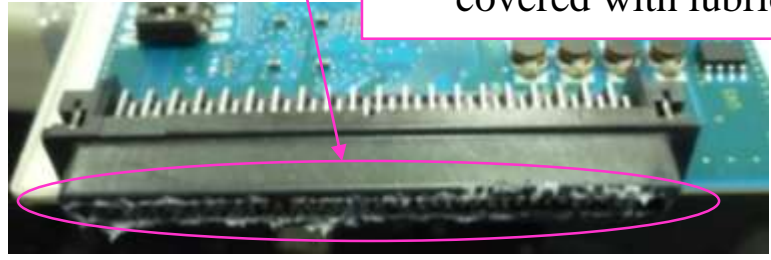
1 2

1 E5063-62001



1. Check pins for any damage
2. Make sure all gold pin were covered with lubricant

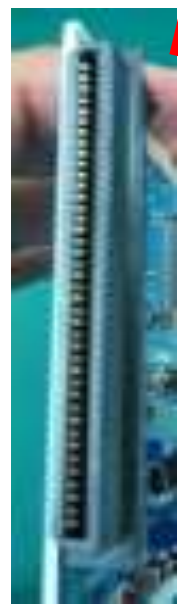
4



Apply Lubricant to connector of Analog module

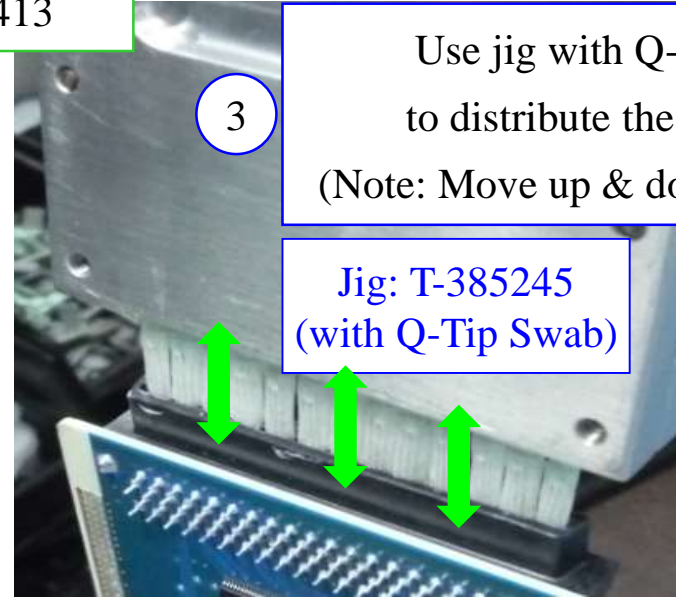


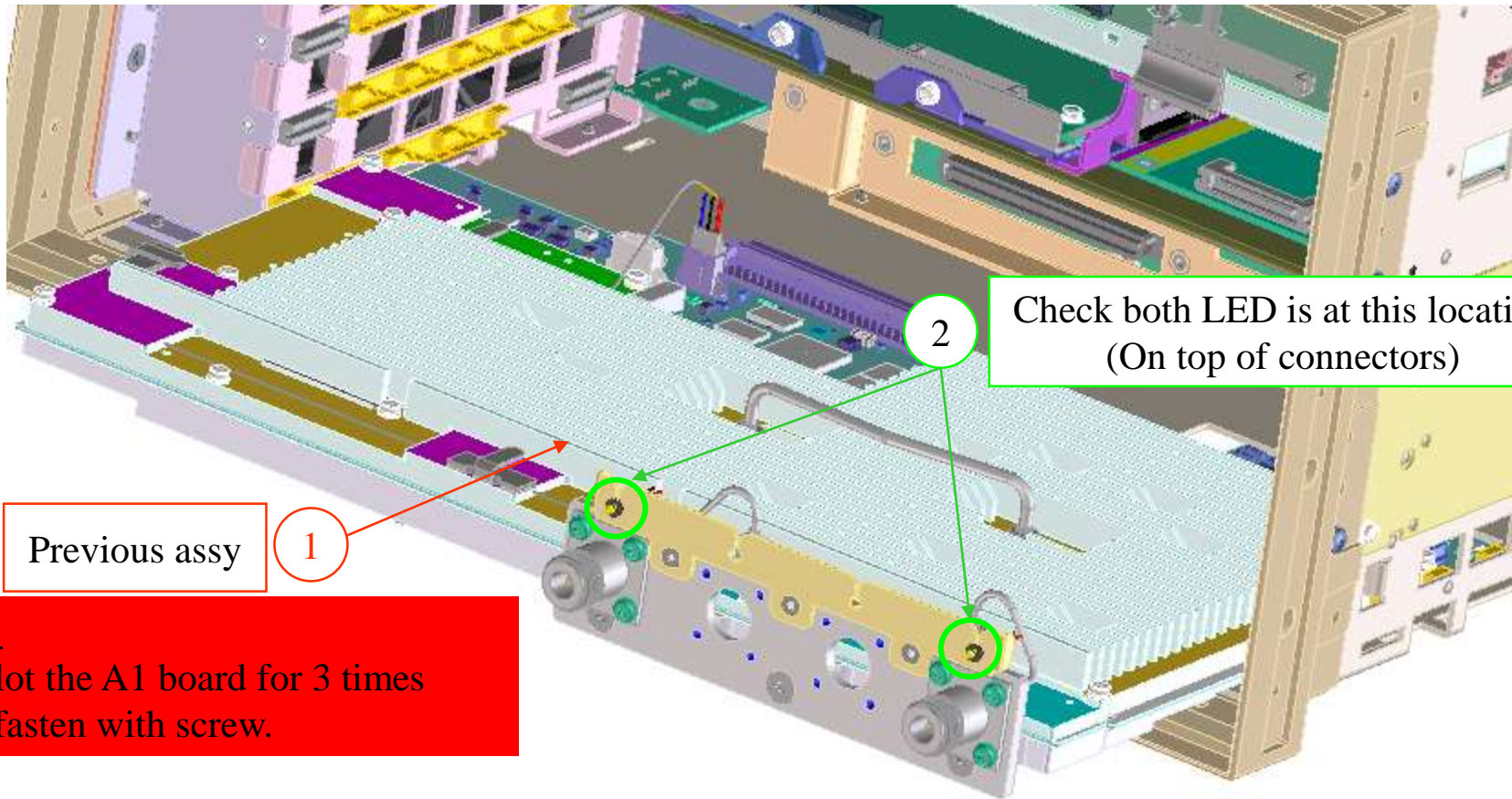
2 6040-1413



3 Use jig with Q-Tip Swab to distribute the Lubricant (Note: Move up & down for 3times)

Jig: T-385245 (with Q-Tip Swab)





Previous assy

1

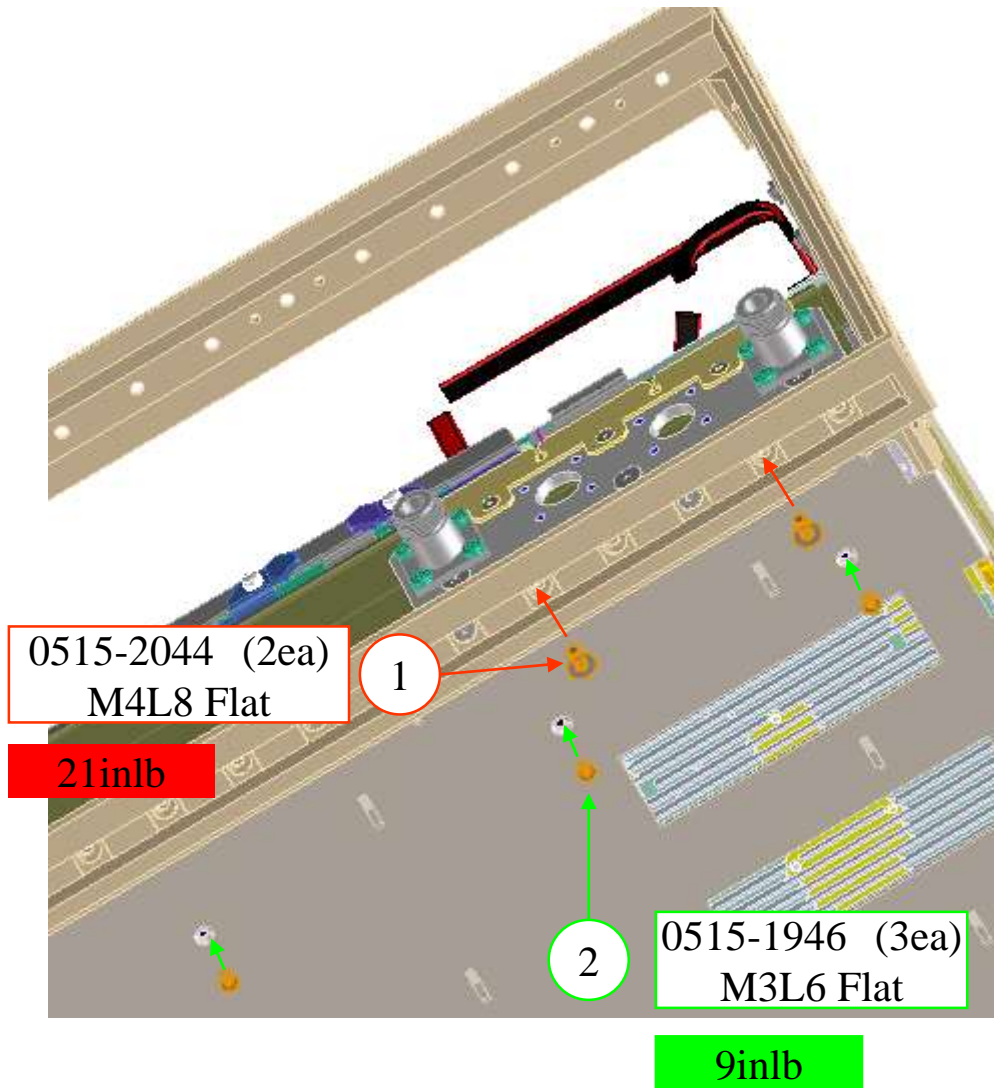
2

Check both LED is at this location
(On top of connectors)

ATTN:

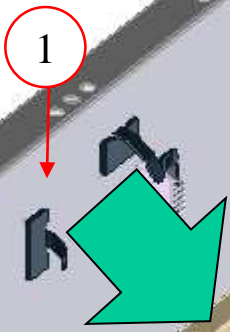
1. Re-slot the A1 board for 3 times
before fasten with screw.

1 2



1 2

Install Front sub-assy
E5063-64901

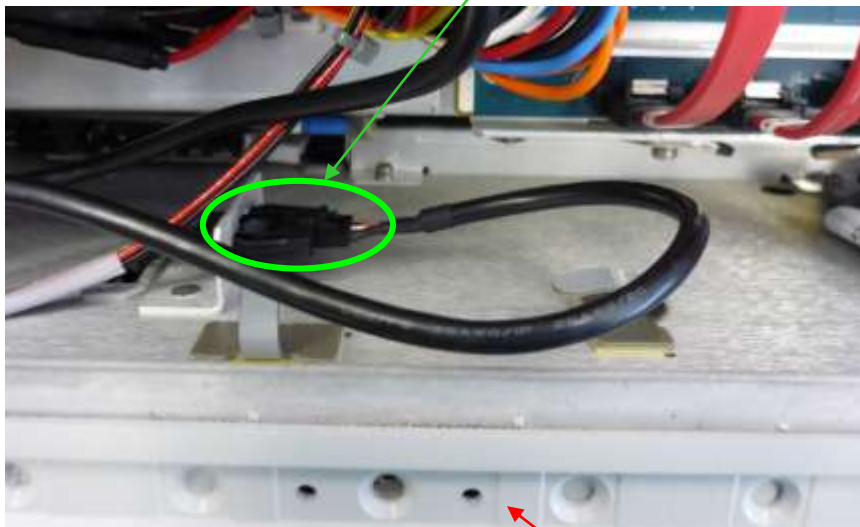


Connect flat cable from
Front Panel Ass'y to CPU
Module



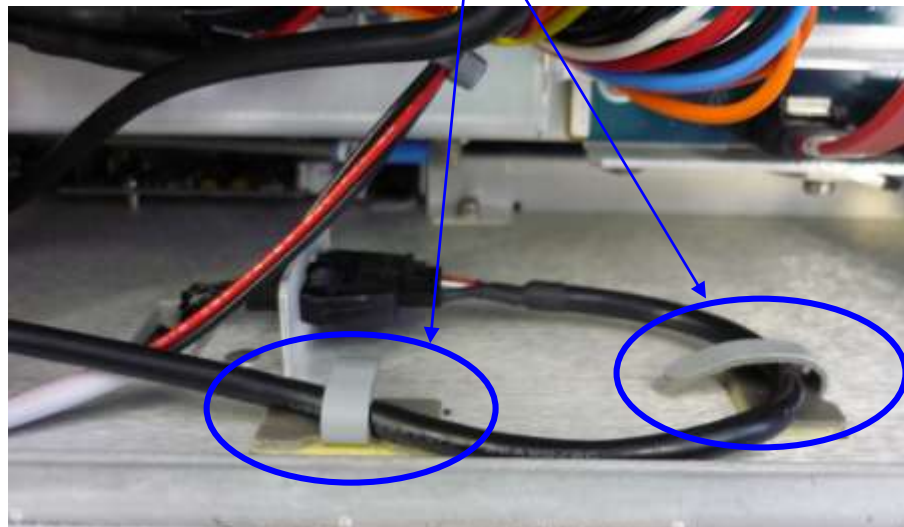
Connect page e10 assembly cable into front frame sub-assembly connector

2



Clamp the cable with cable clamps

3



Place Front frame Sub-assembly to Chassis

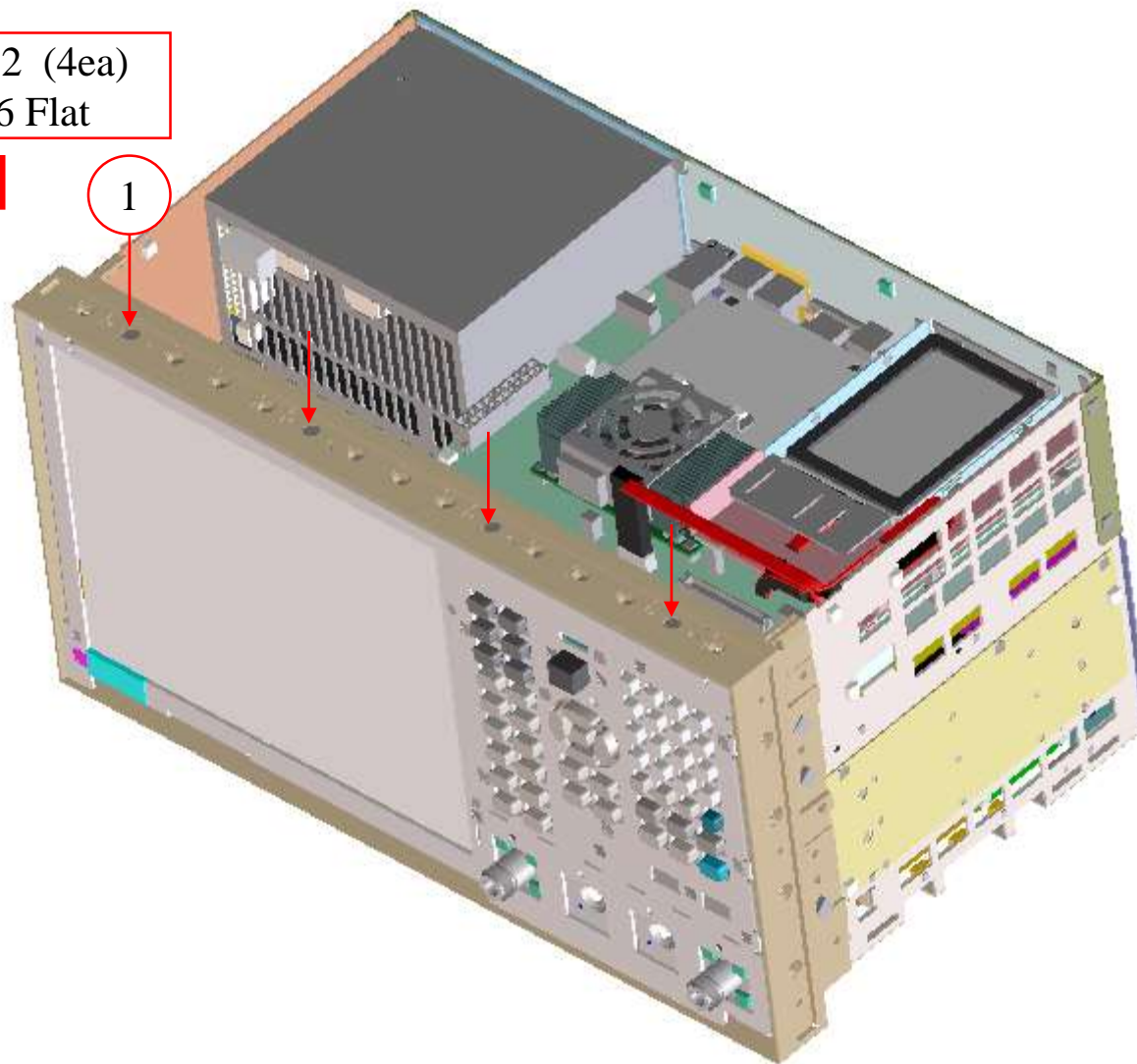
1

1 2 3

0515-1382 (4ea)
M3.5L6 Flat

14inlb

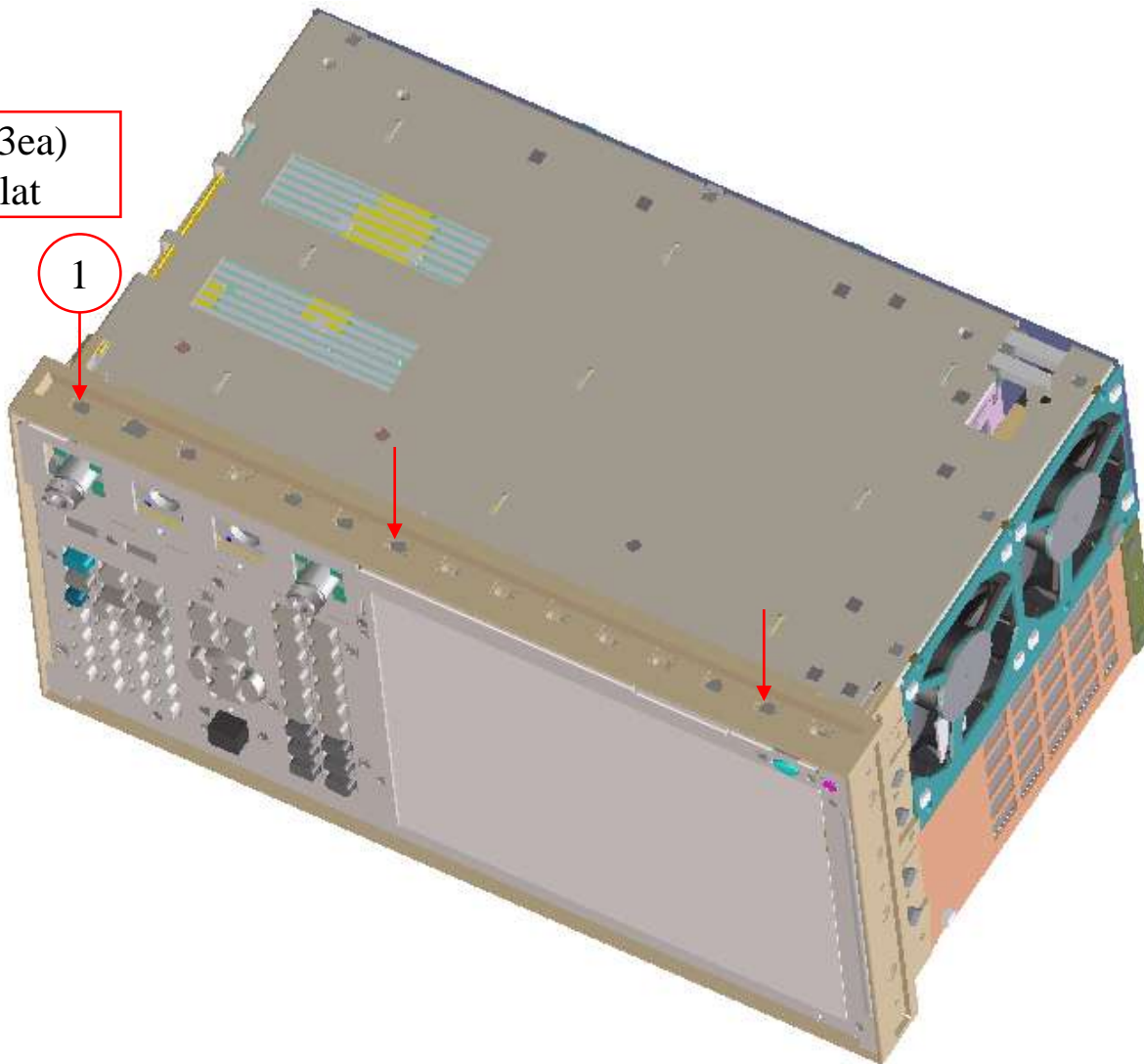
1



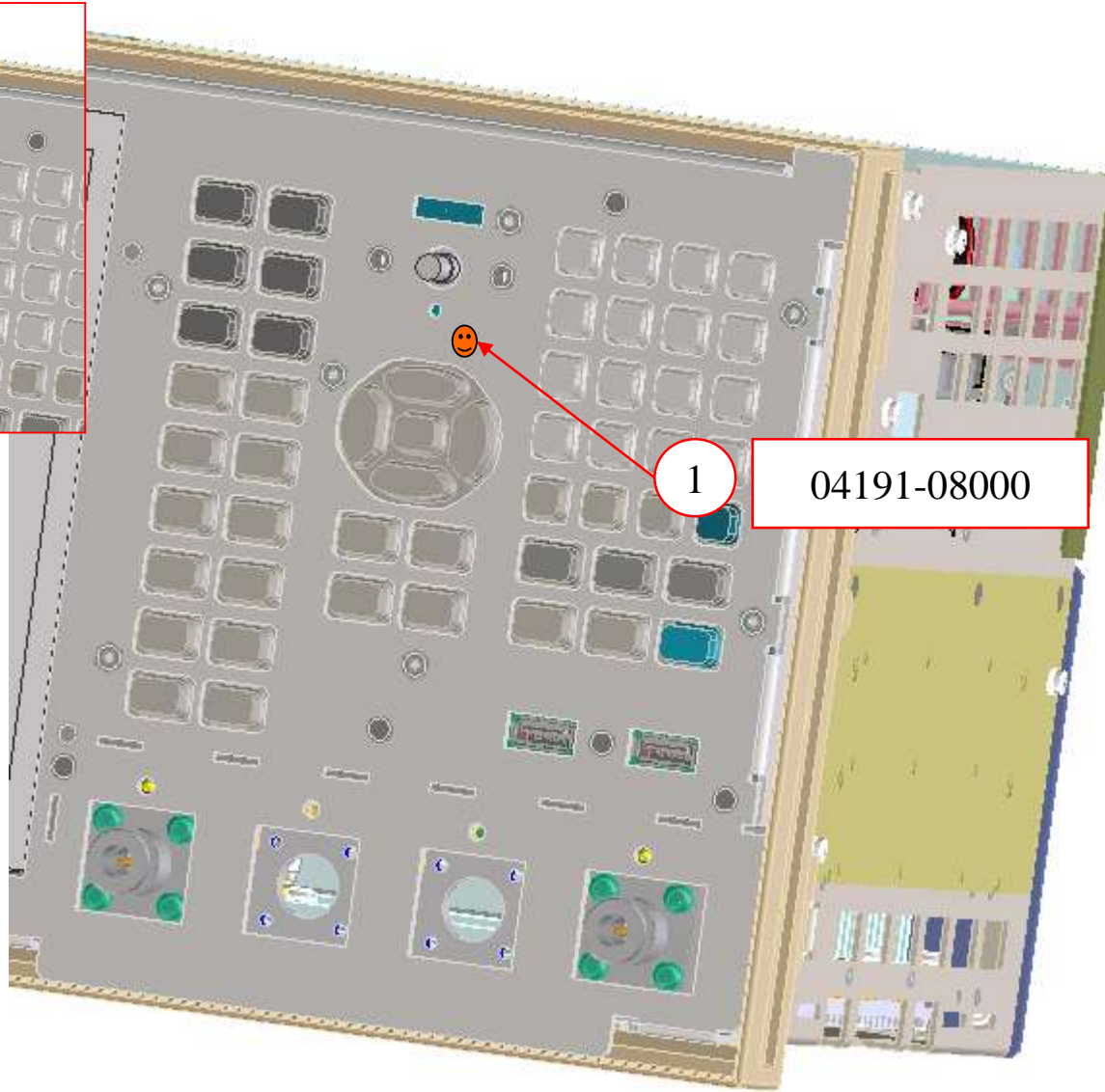
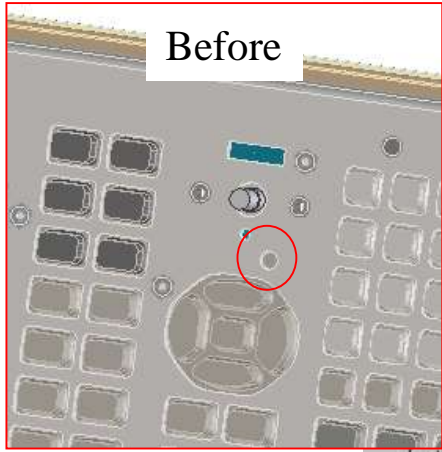
0515-1382 (3ea)
M3.5L6 Flat

14inlb

1



1



1 04191-08000

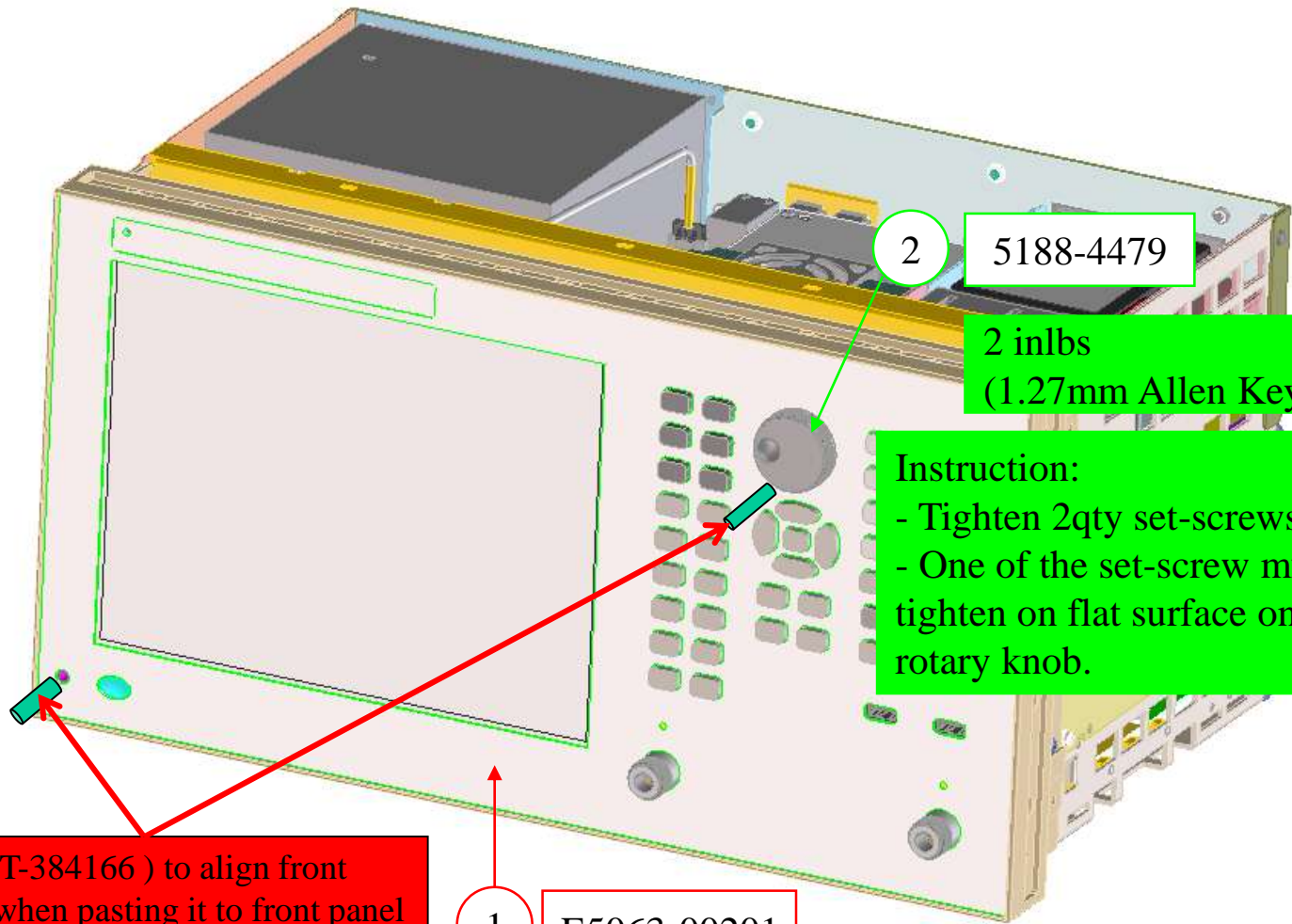
1

INSTALL GASKET

e80

Rev. A

CHECK:
Remember to remove the protective sheet before pasting the front overlay!



2

5188-4479

2 inlbs
(1.27mm Allen Key)

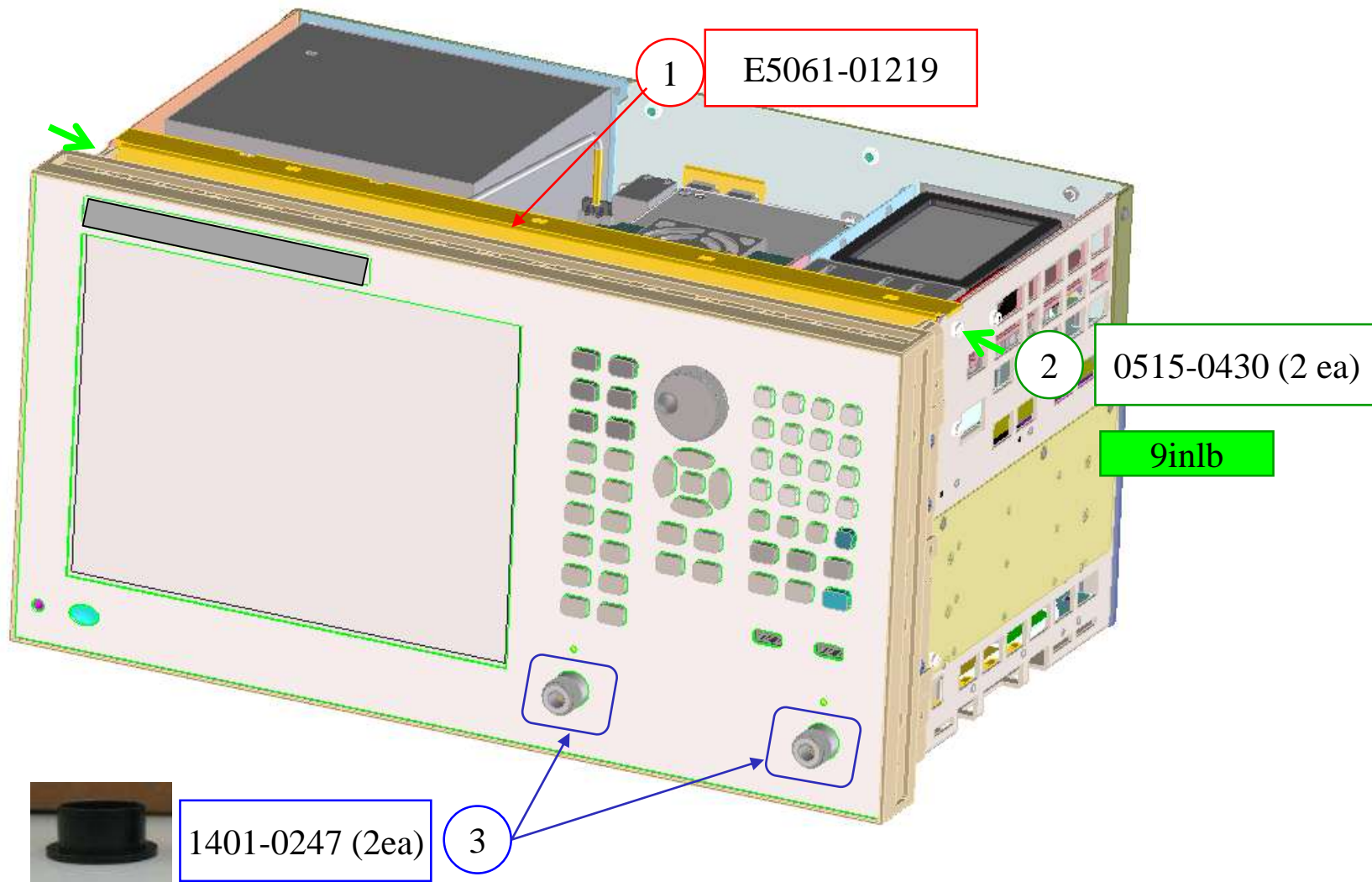
Instruction:
- Tighten 2qty set-screws
- One of the set-screw must tighten on flat surface on the rotary knob.

Use jig (T-384166) to align front overlay when pasting it to front panel

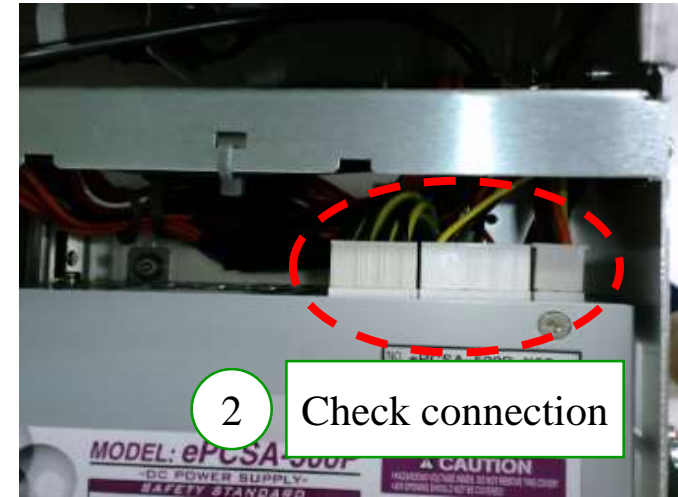
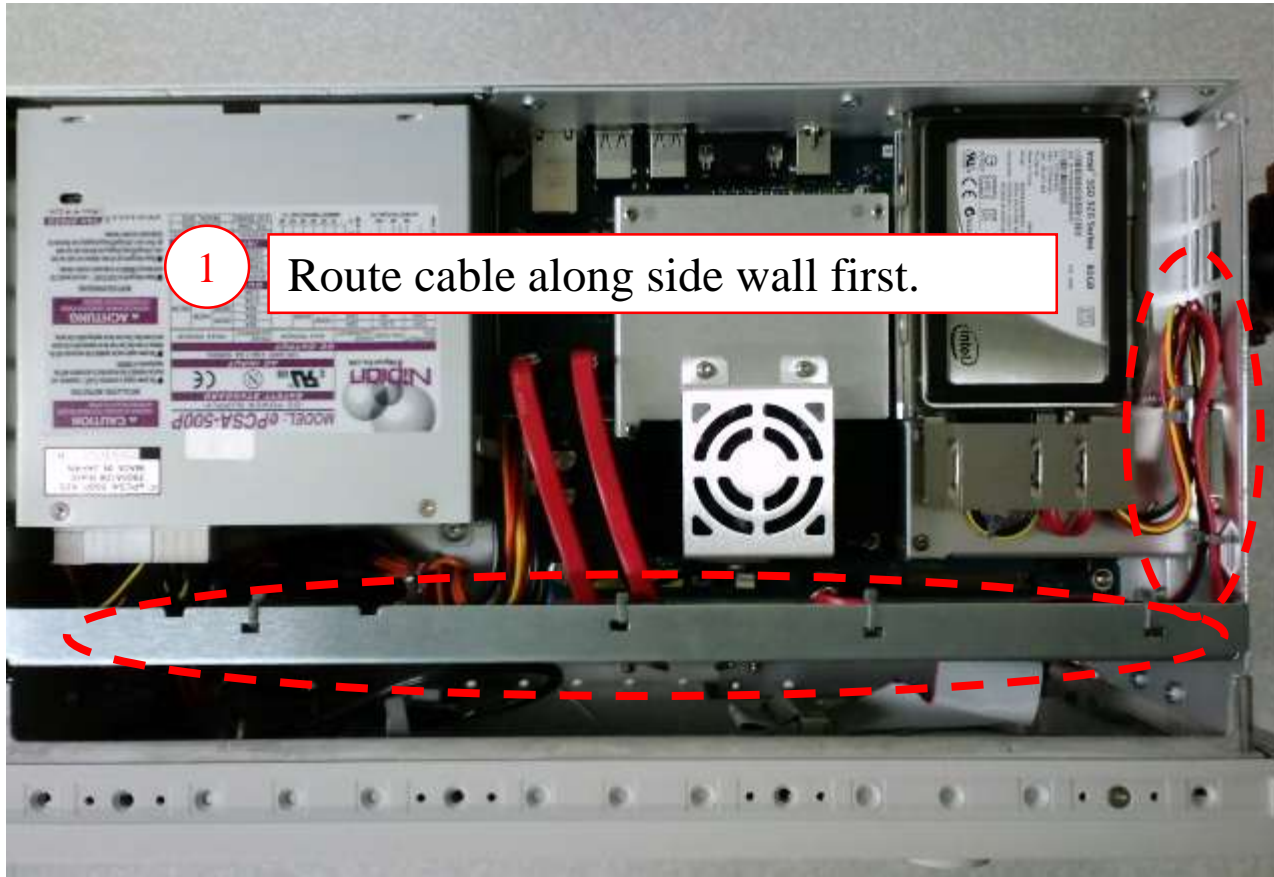
1

E5063-00201

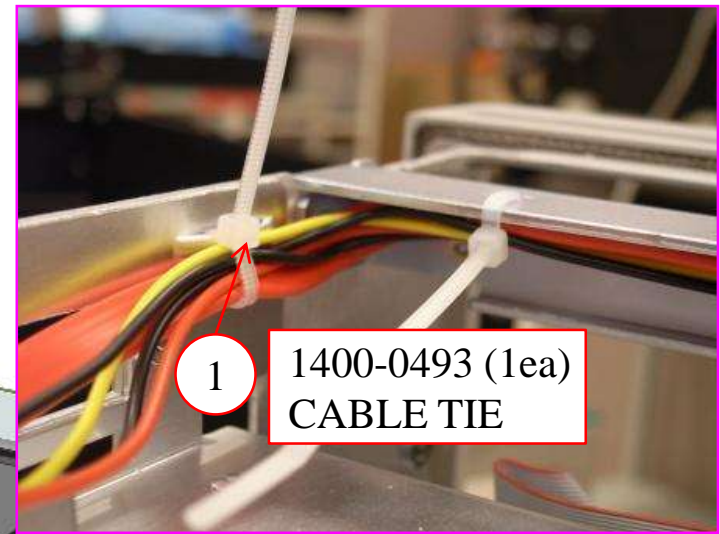
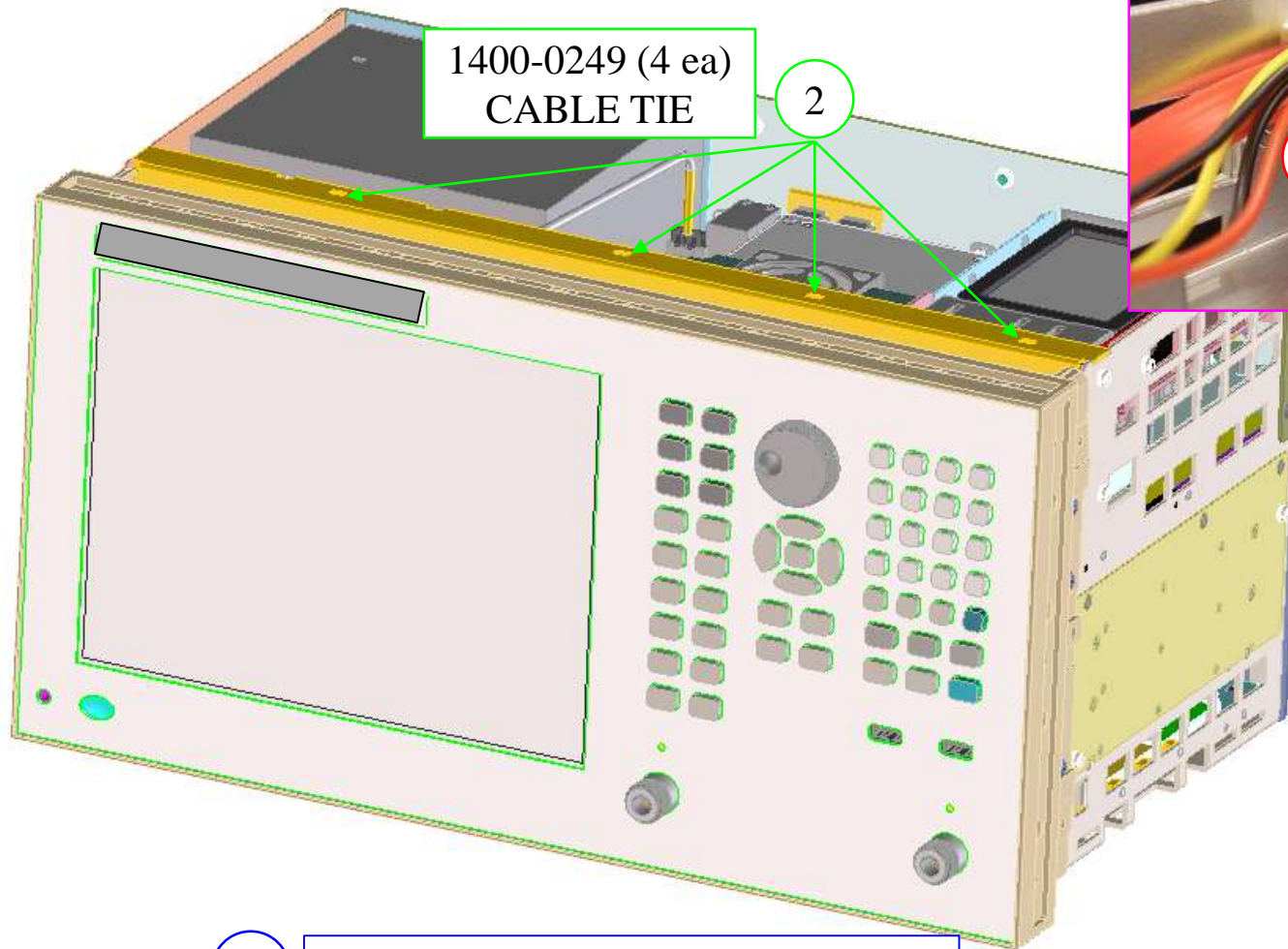
① ② ③



① ②



1 2

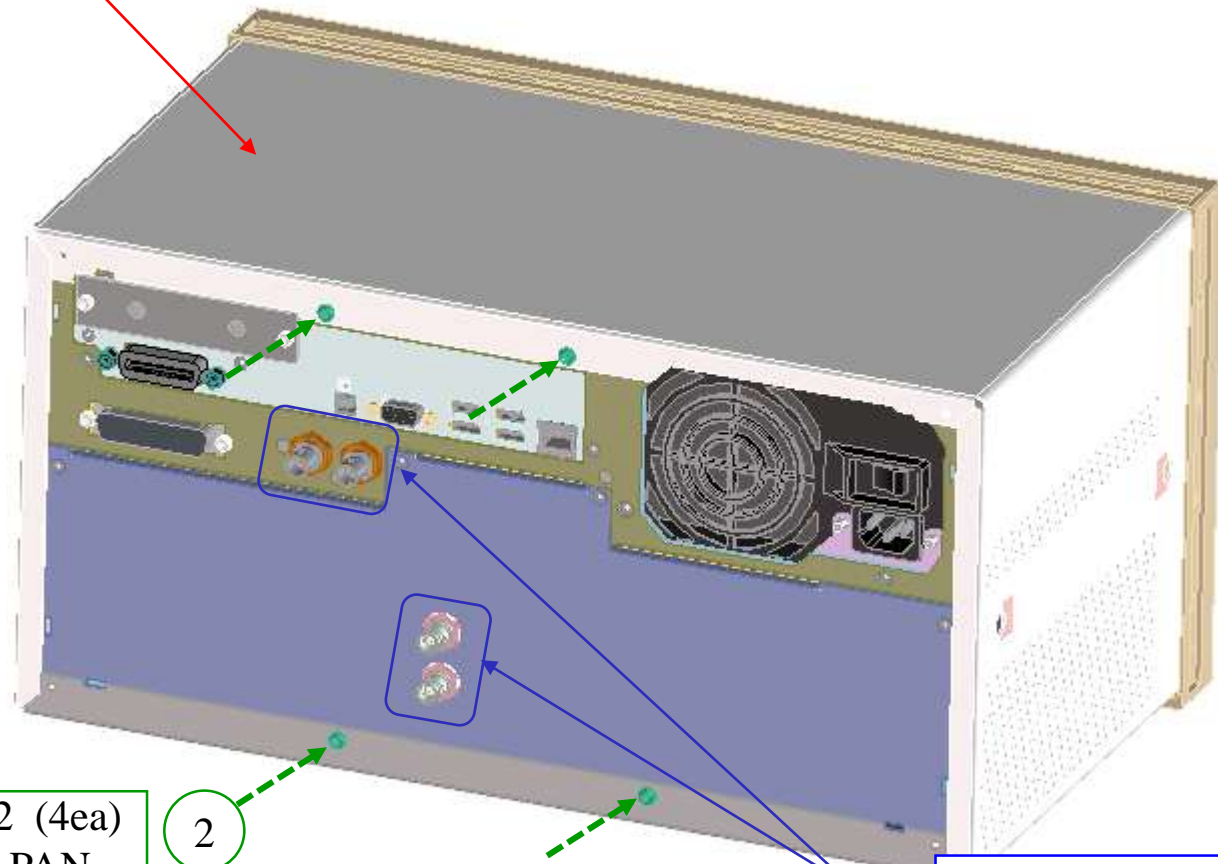


① ② ③

③ Use Air Gun to blow dust on the unit

E5061-60007

1



0515-1402 (4ea)
M3.5L8 PAN

2

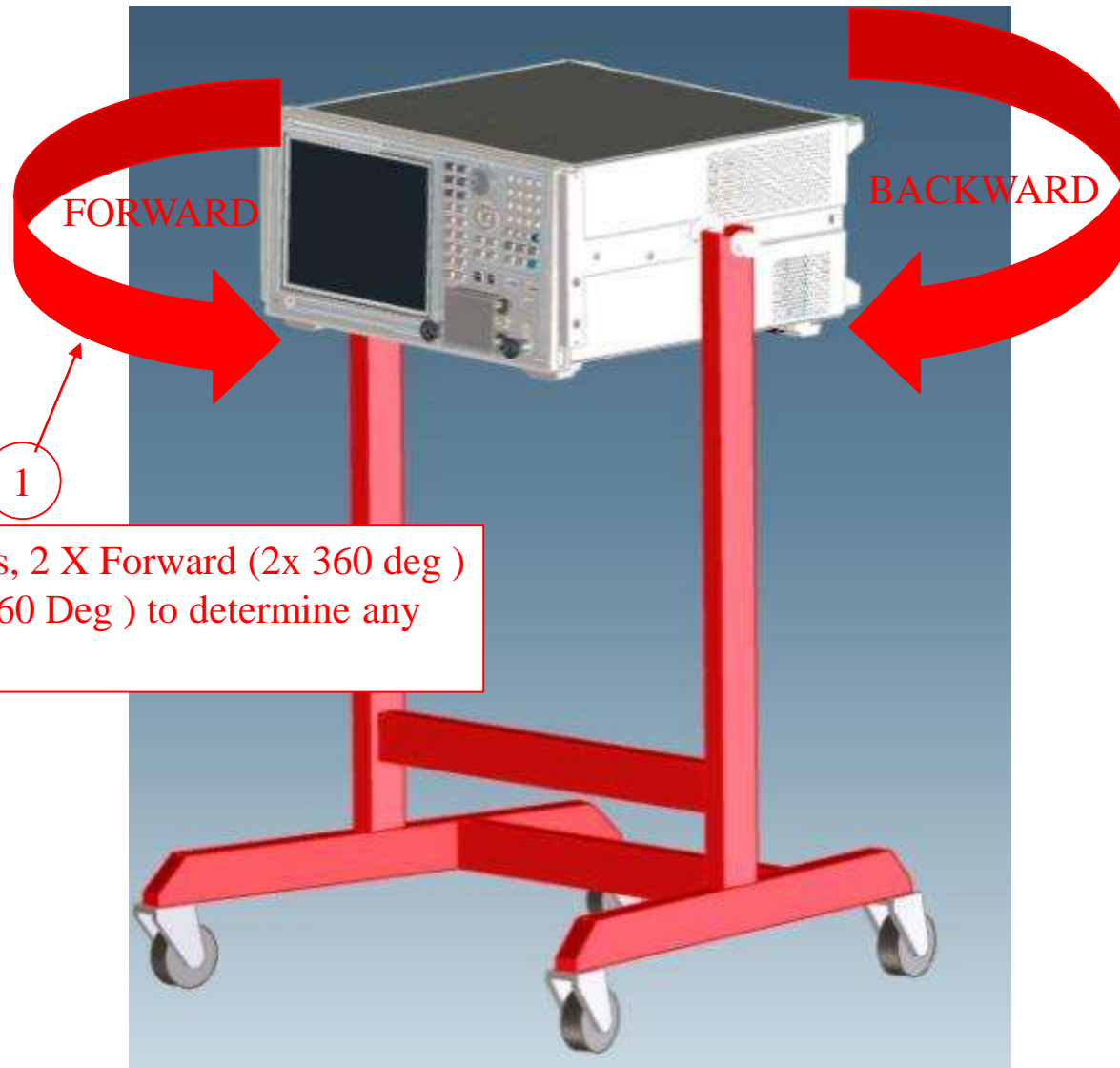
14inlb

3

1401-0448 (4ea)



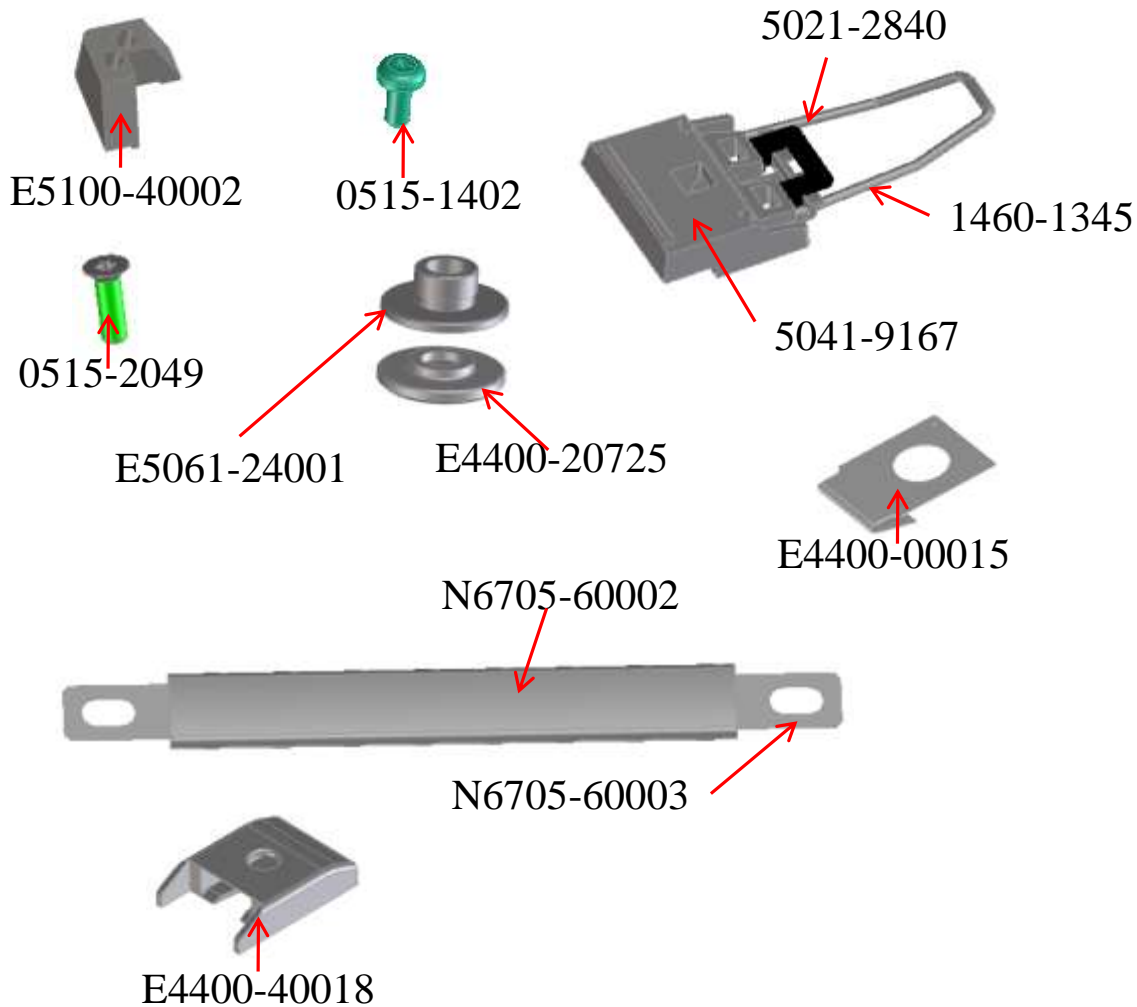
1 2 3



Turn the unit 4 Rounds, 2 X Forward (2x 360 deg)
& 2 X Backward (2x360 Deg) to determine any
loose parts inside unit.

①

NOTE: Parts required to be kitted to complete assembly after Final Test.

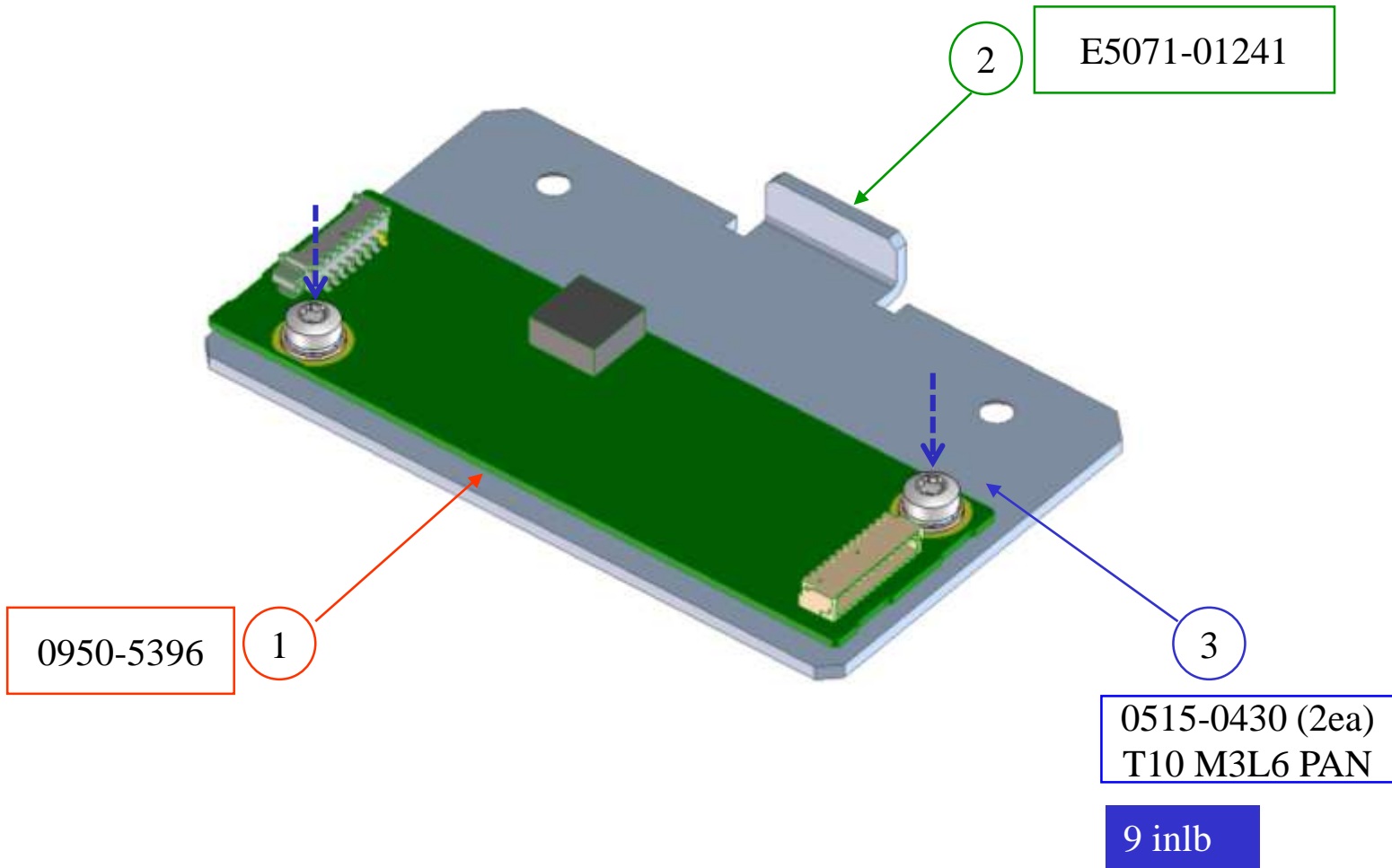


Part Number	Description	Quantity
1. E5100-40002	Rear Foot	4
2. 0515-1402	Screw	4
3. 1460-1345	Tilt Stand	2
4. 5021-2840	Key Lock	4
5. 5041-9167	Bottom Foot	4
6. 0515-2049	Screw	2
7. E4400-20725	Outer Retainer	2
8. N6705-60003	Inner Handler Strap	1
9. N6705-60002	Outer Handler Strap	1
10. E5061-24001	Inner Retainer	2
11. E4400-00015	Ground Spring	2
12. E4400-40018	End Cap	2
13. 5041-9173	Side Trim	2

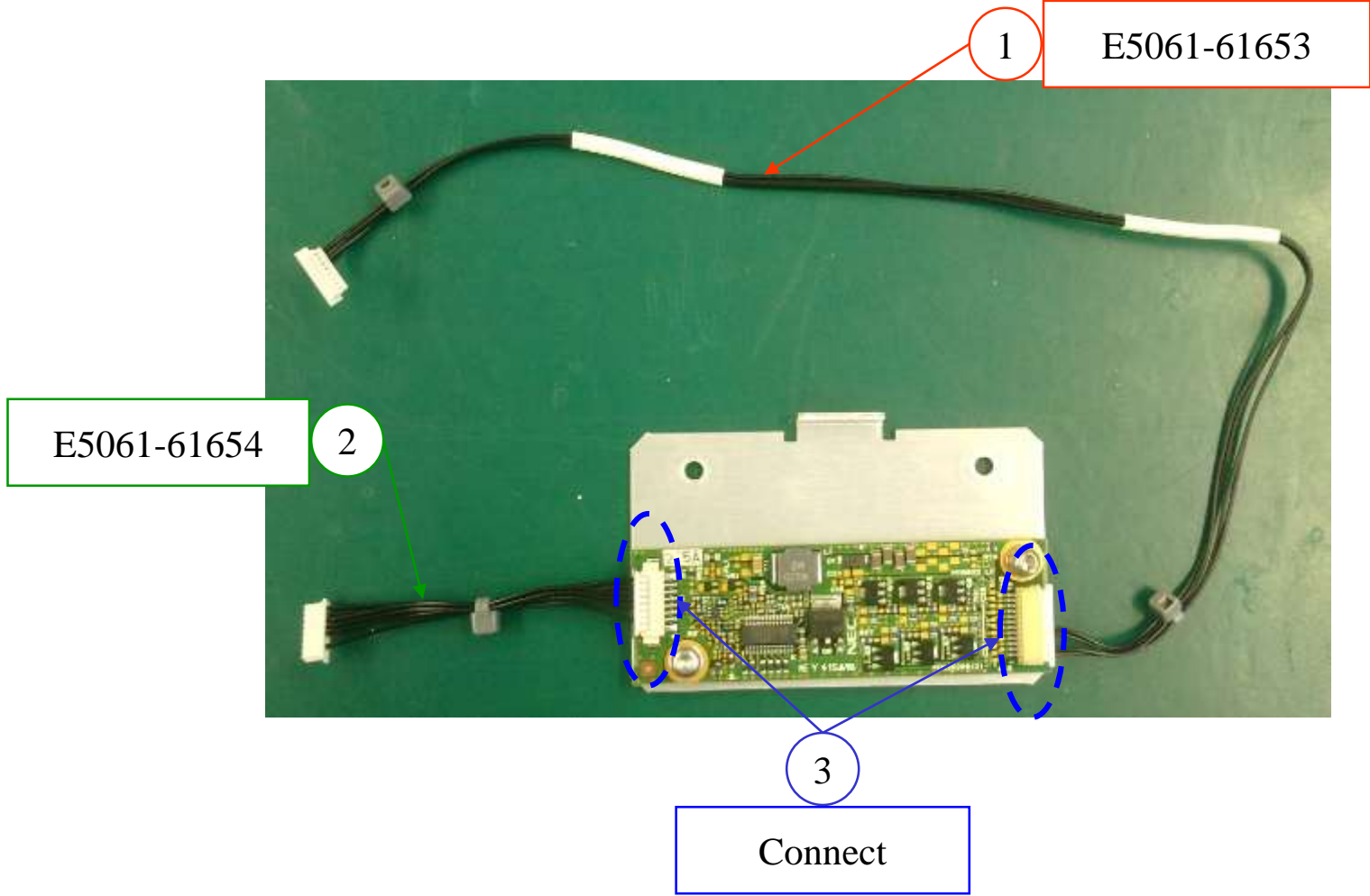
E5063A

Front Panel Assembly

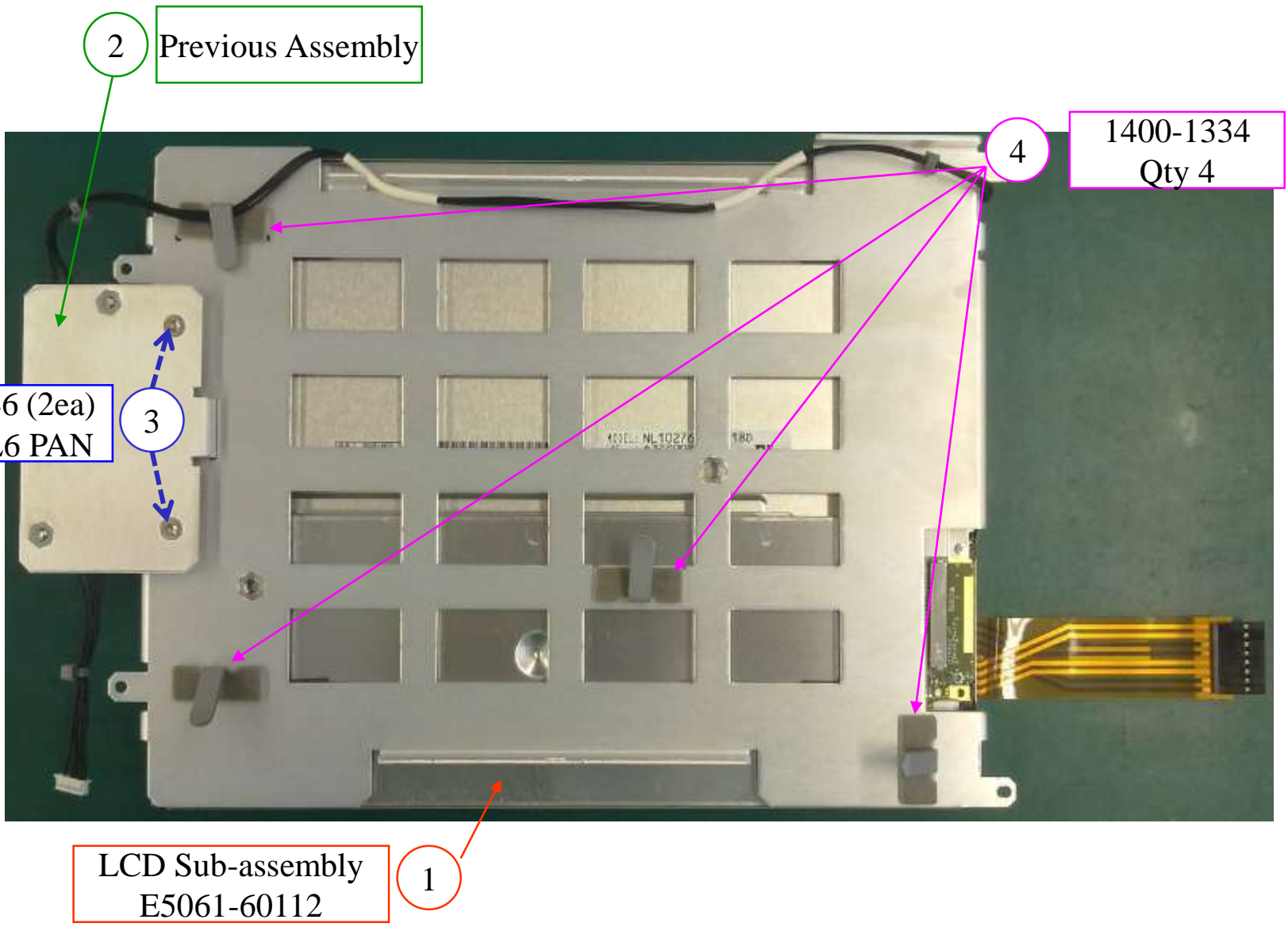
		Rev.
--	--	------



① ② ③



- ①
- ②
- ③



2 Previous Assembly

4 1400-1334 Qty 4

0515-1946 (2ea)
T10 M3L6 PAN
9 inlb

3

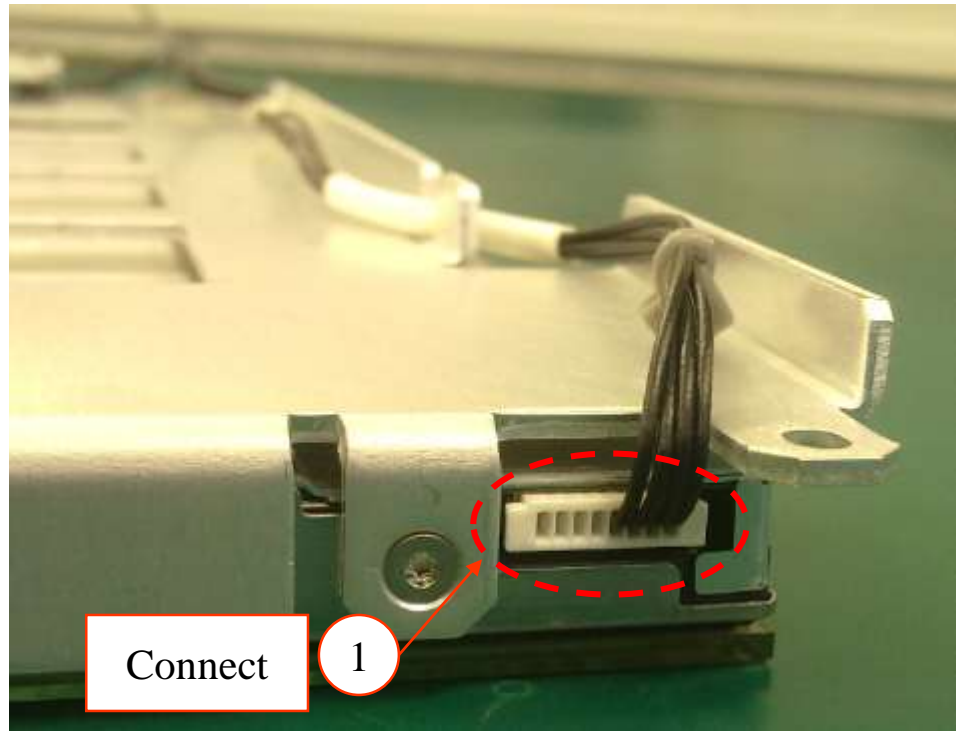
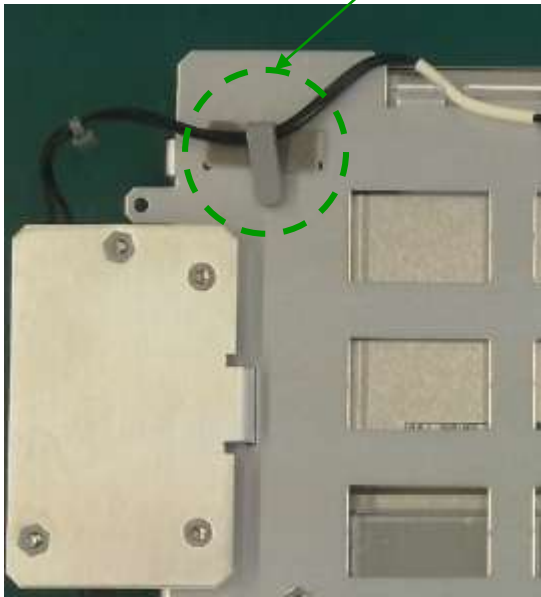
1 LCD Sub-assembly
E5061-60112

1 2 3 4

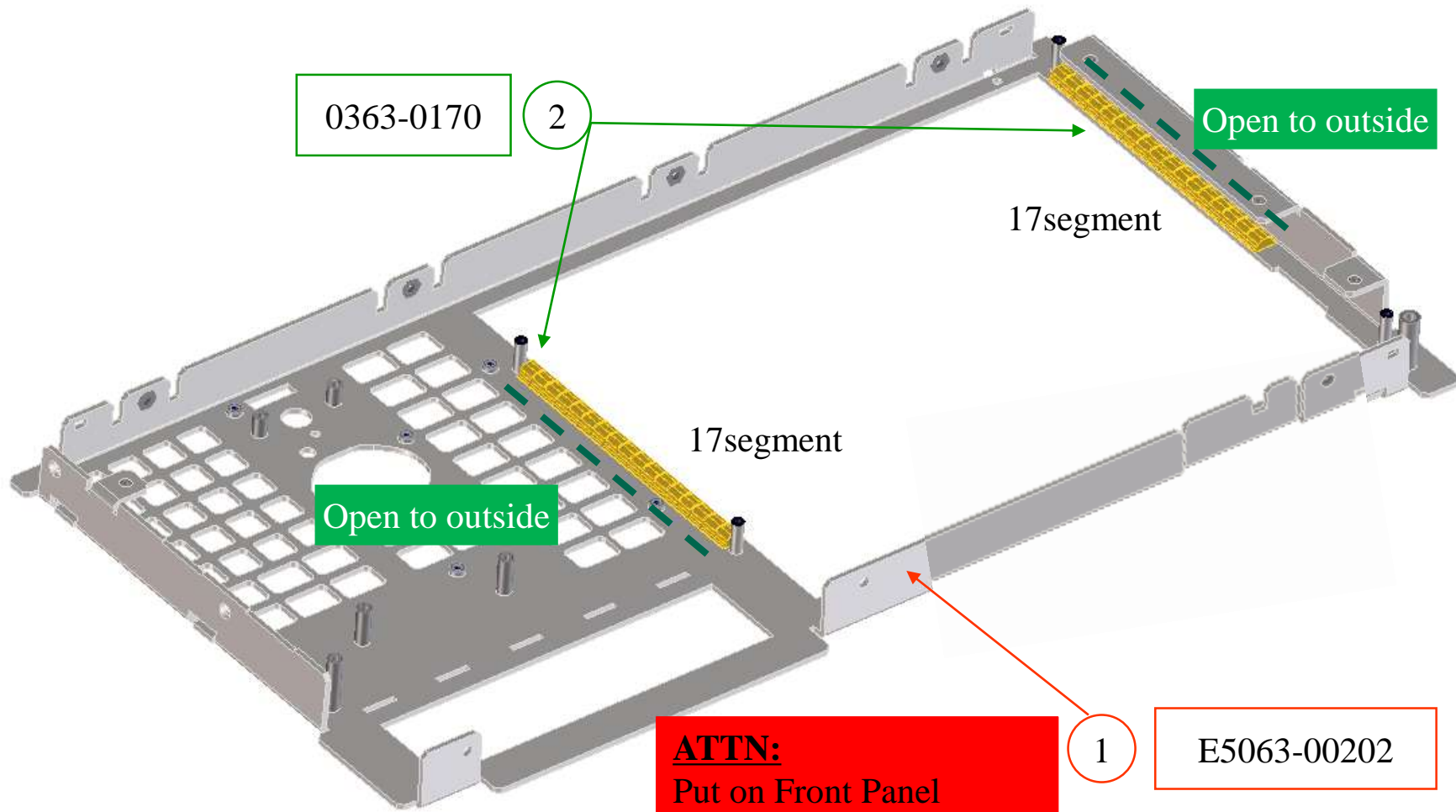
Note: Wire routing condition



2 Clamp



1 2



0363-0170

2

Open to outside

17segment

17segment

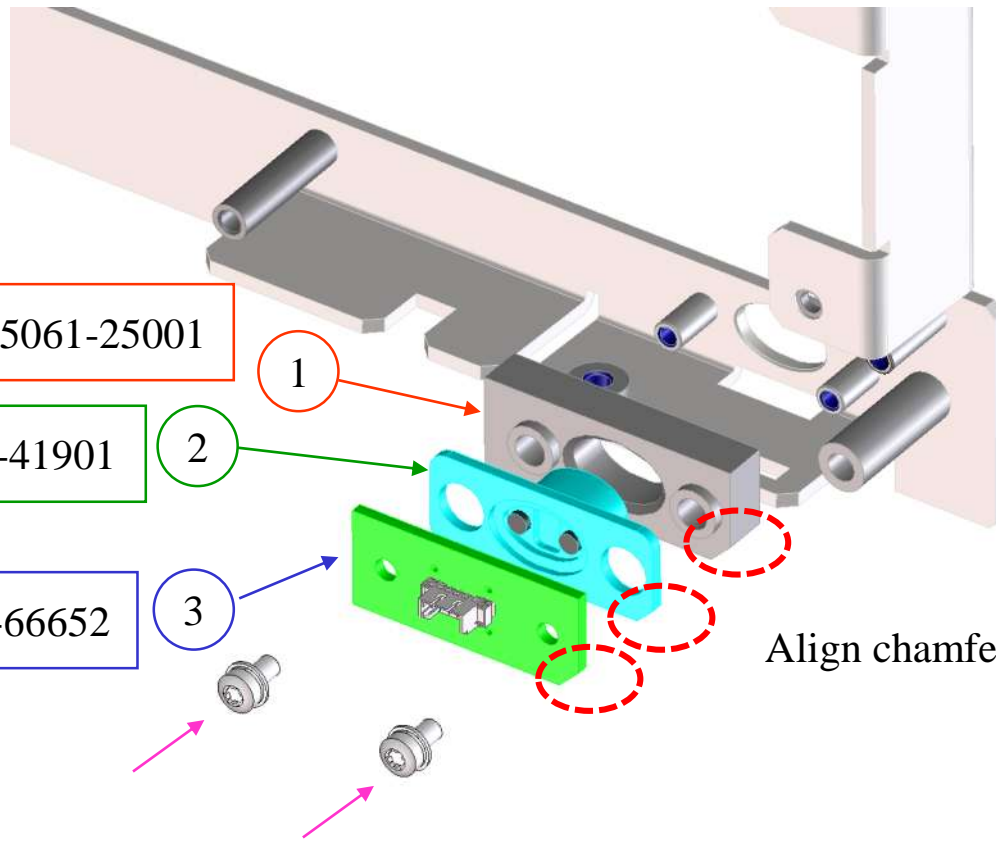
Open to outside

ATTN:
Put on Front Panel
Assembly Jig (T-384161)

1

E5063-00202

1 2



E5061-25001

1

01690-41901

2

E5063-66652

3

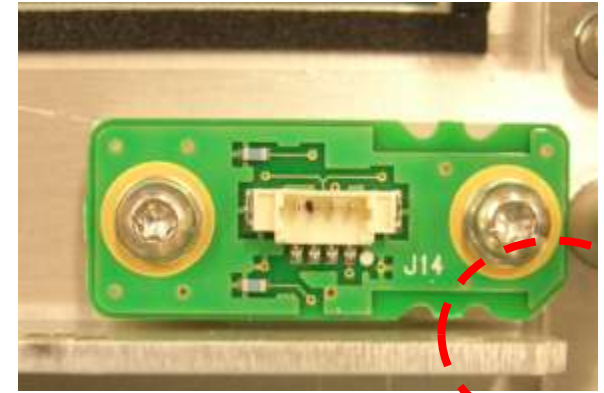


4

0515-0430 (2ea)
M3L6 PAN

9inlb

1 2 3 4



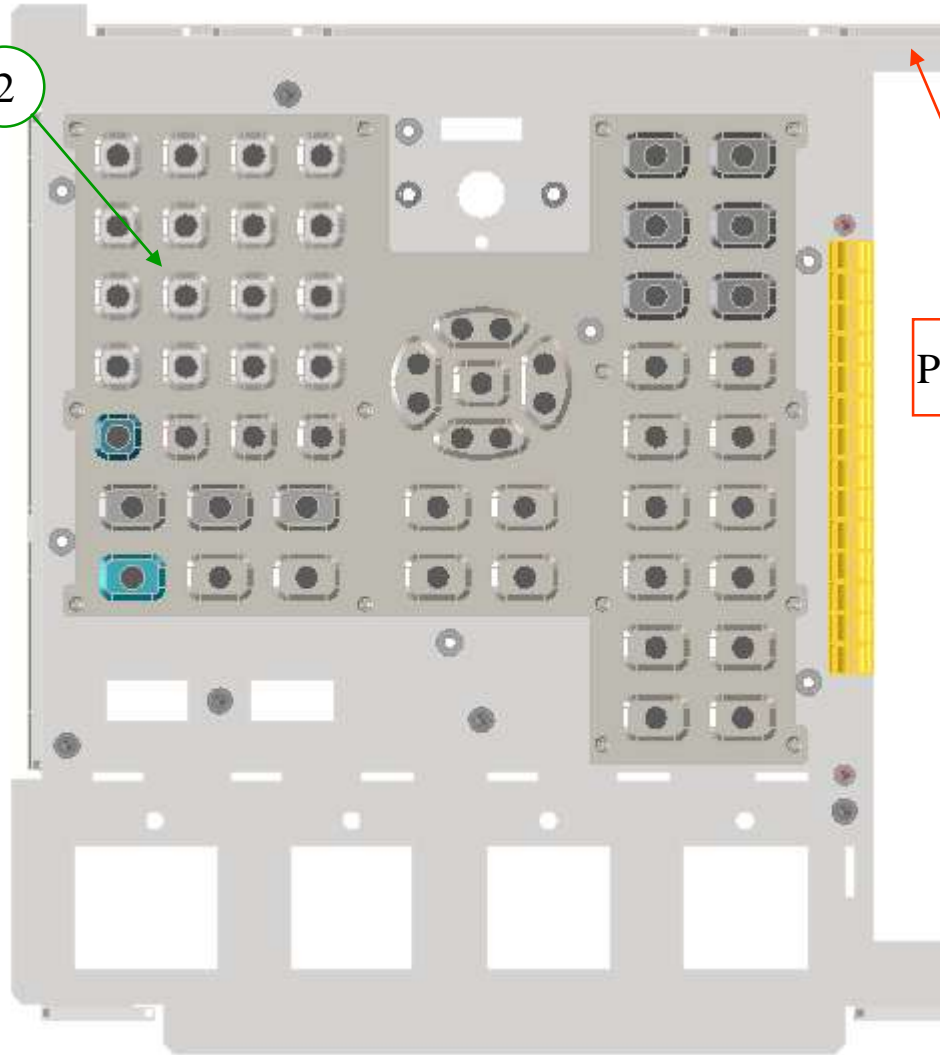
Align chamfered corners

Align chamfered corners

E5063-40001

2

Blow away dust
from the keypad
contact point

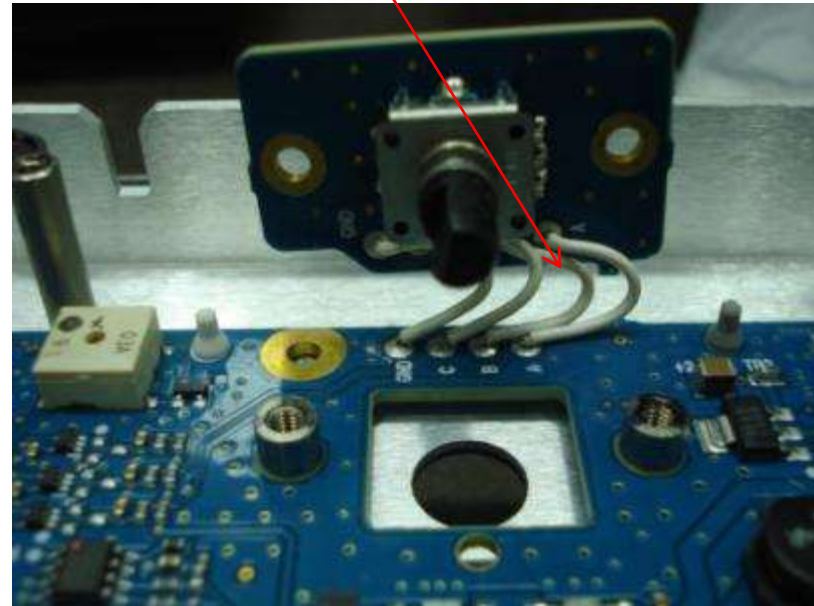
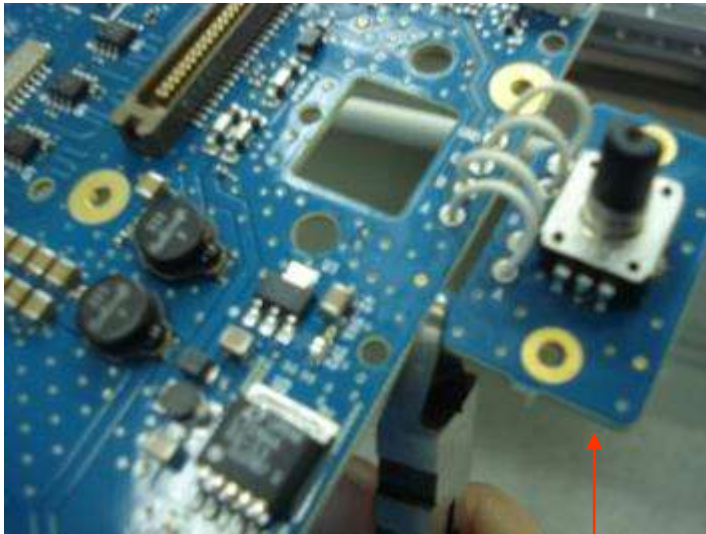


1

Previous Assembly

1 2

Carefully Bend the wire to the right side. Avoid cable being screwed on left side.

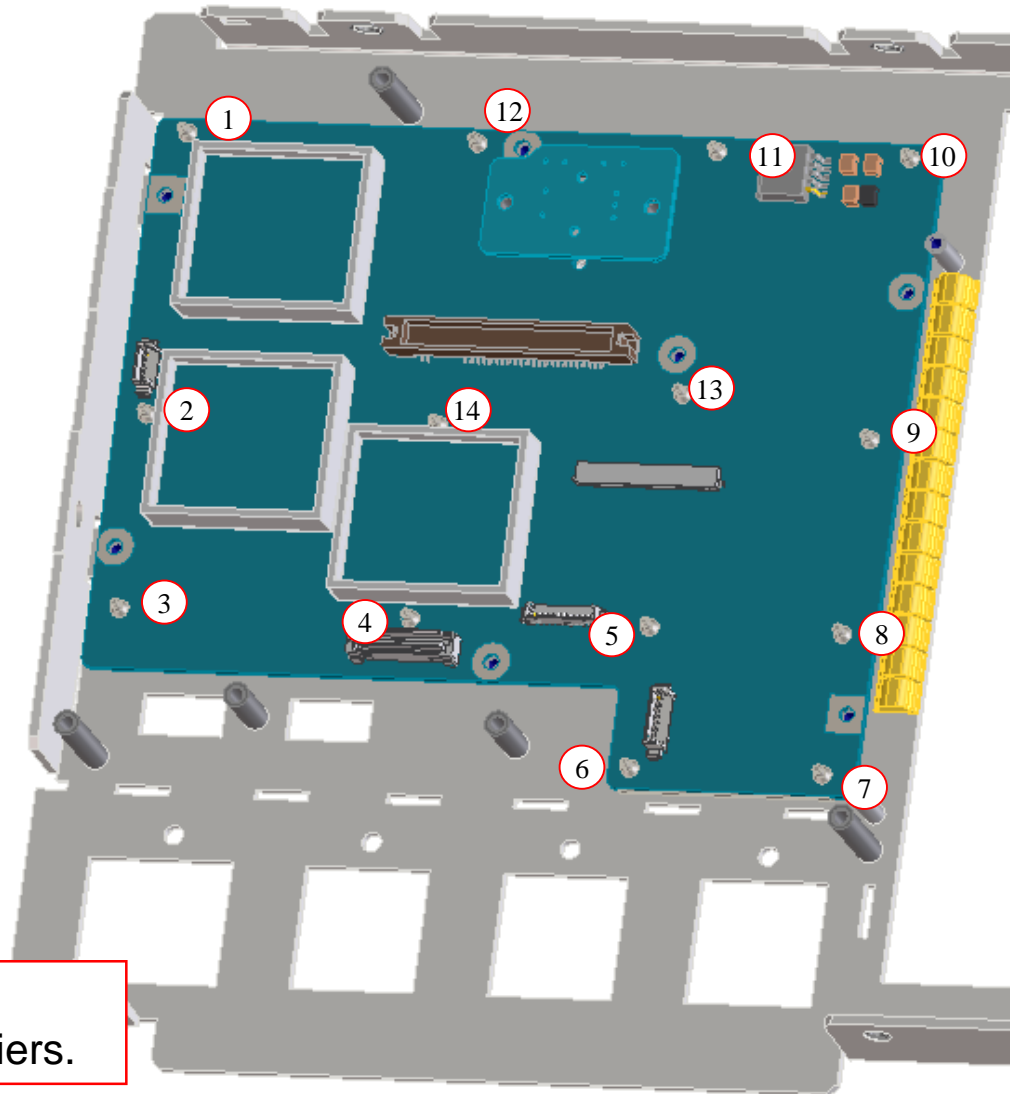


1

E5063-66652

Use Cutter to cut the joint

1



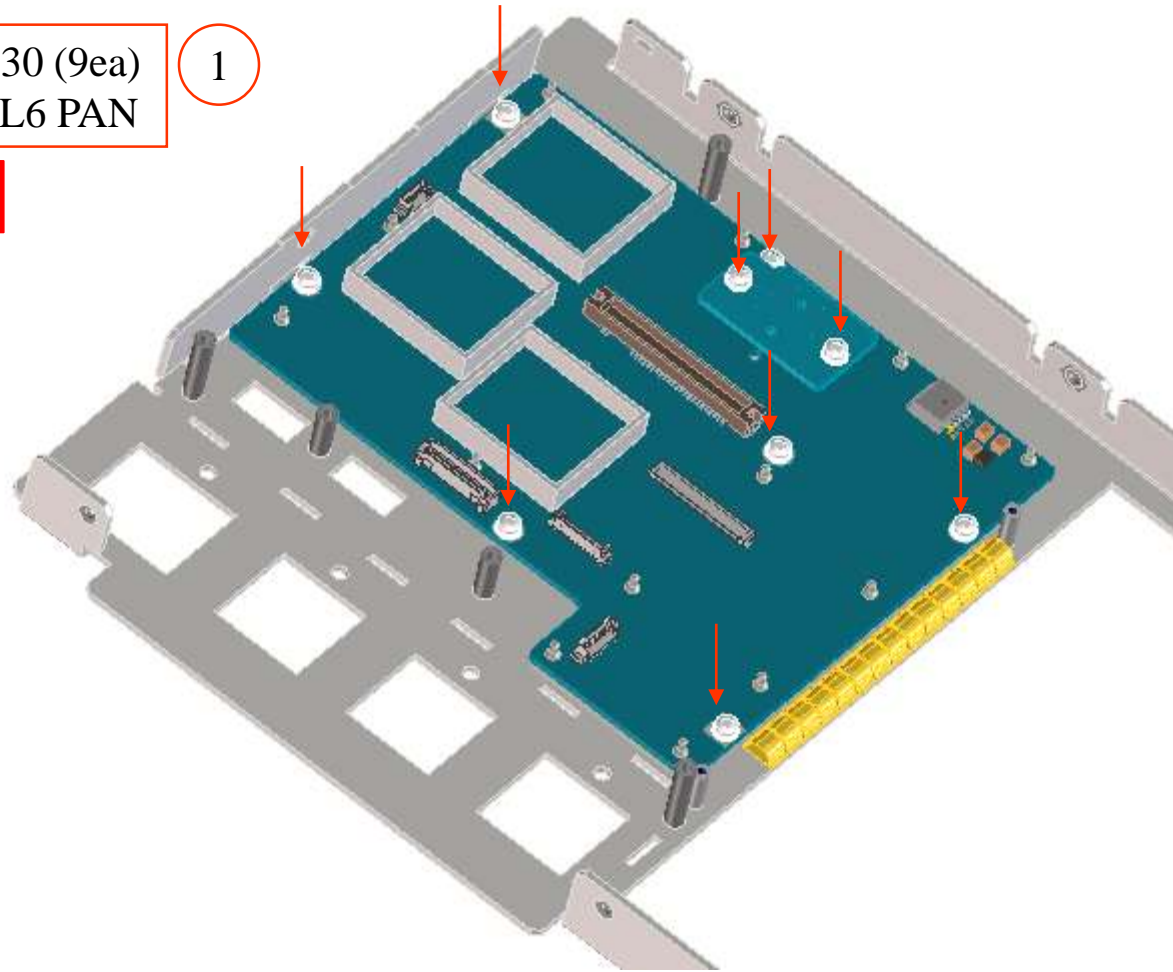
Pull 14 points of projection pin by pliers.

①

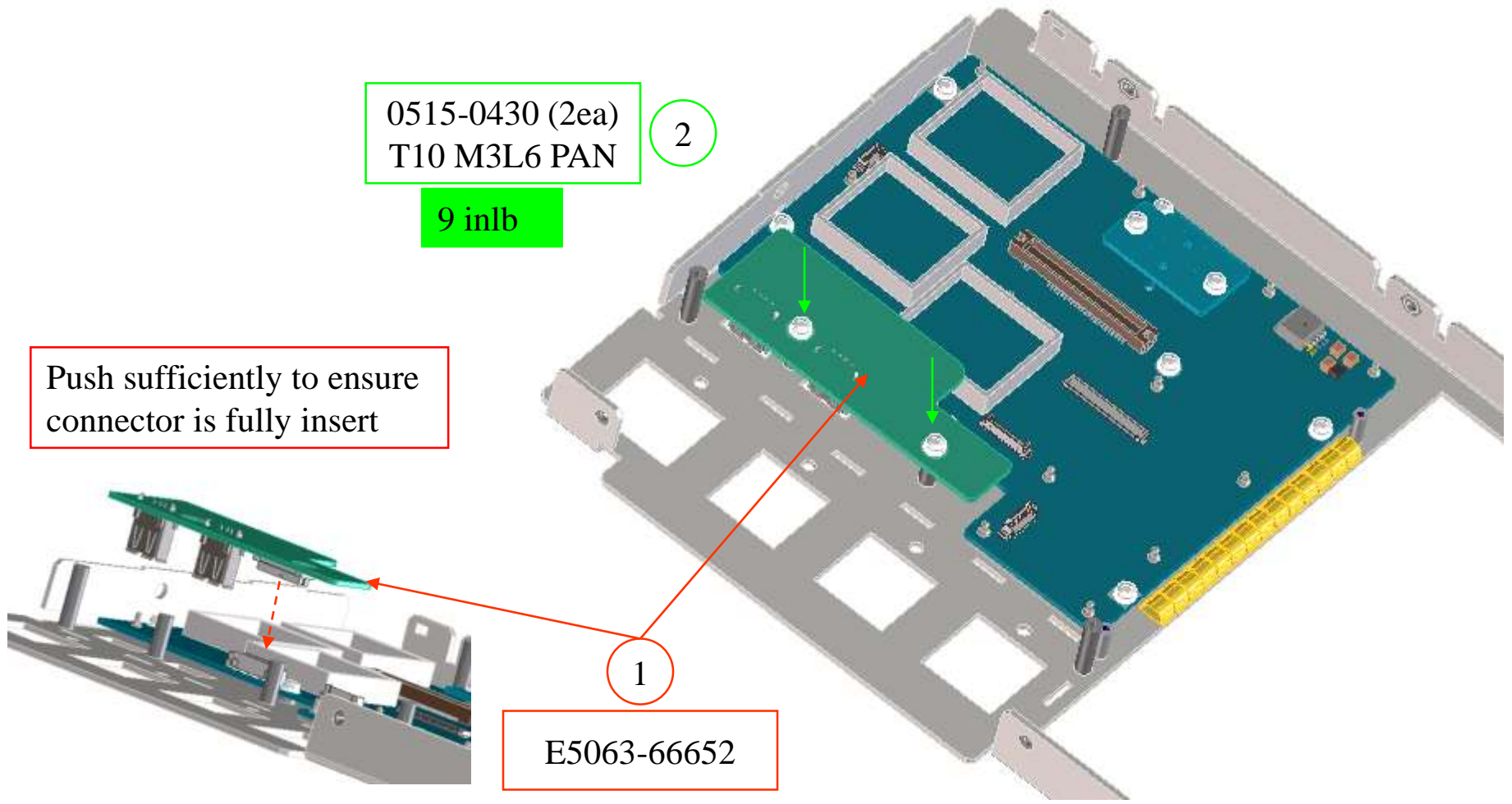
0515-0430 (9ea)
T10 M3L6 PAN

9 inlb

1



1



0515-0430 (2ea)
T10 M3L6 PAN

2

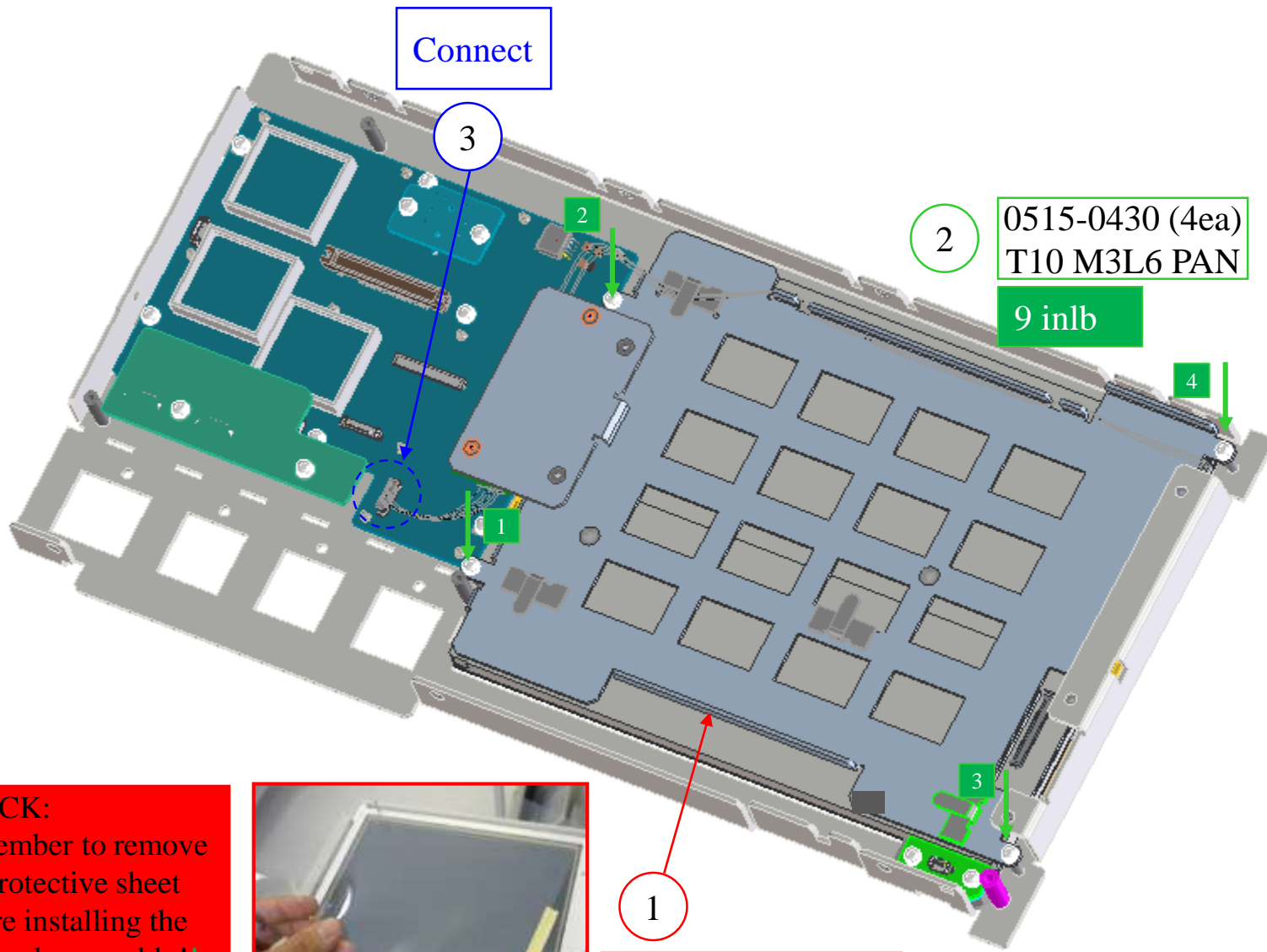
9 inlb

Push sufficiently to ensure
connector is fully insert

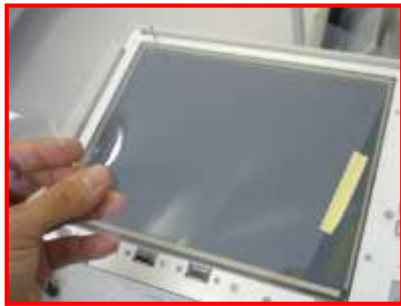
1

E5063-66652

1 2

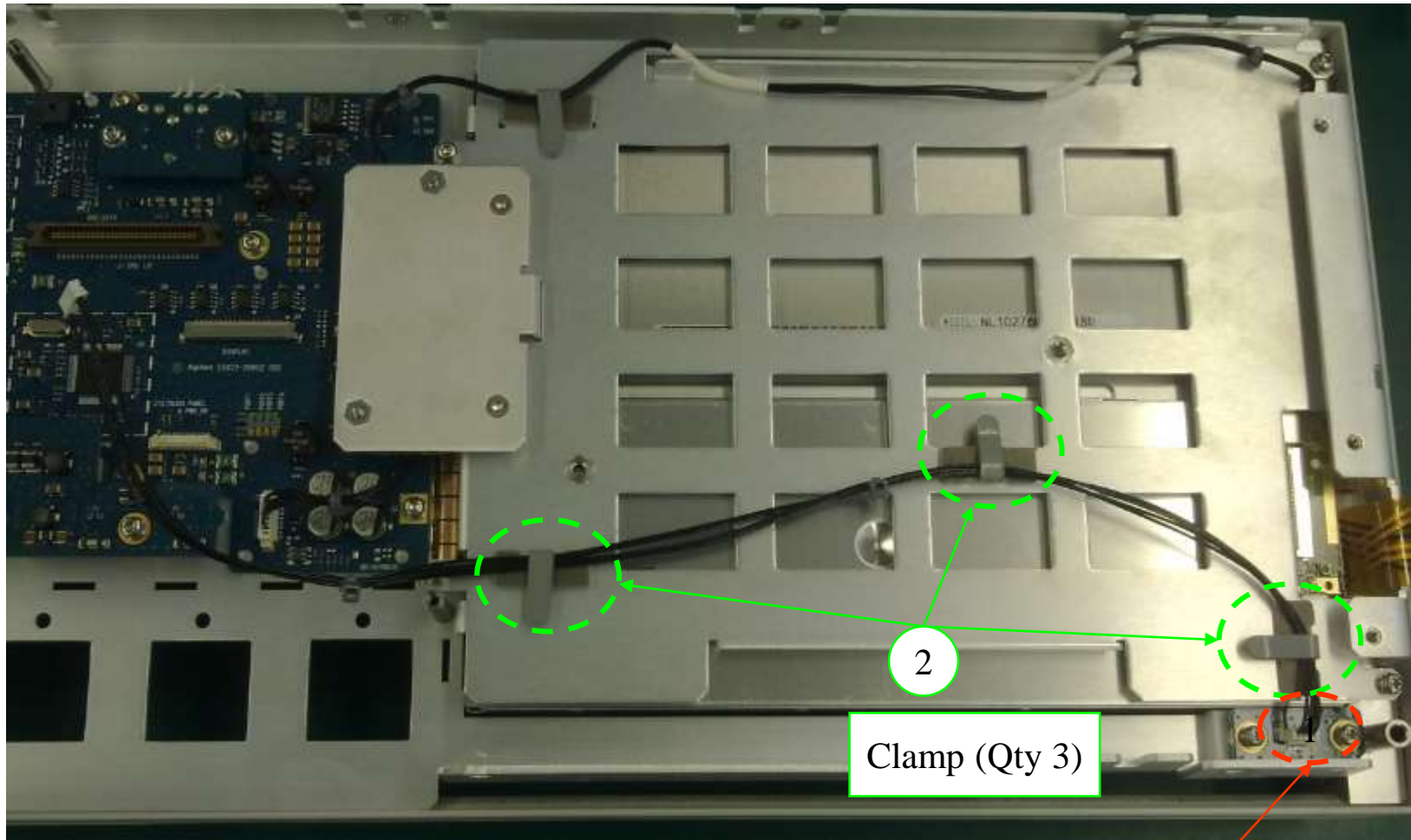


CHECK:
Remember to remove
the protective sheet
before installing the
LCD sub-assembly!!



1
LCD sub-assembly

1 2 3



① ②

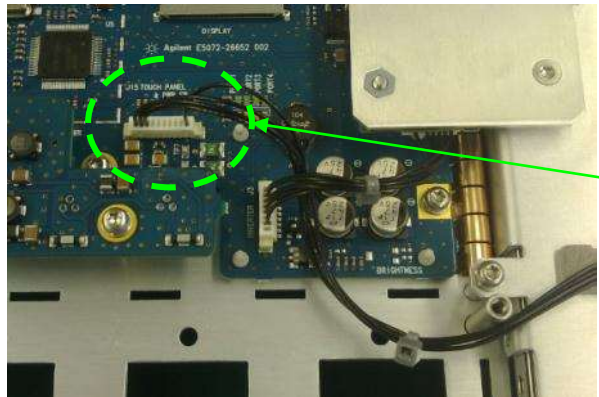
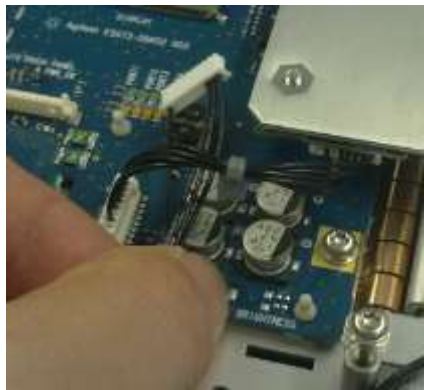
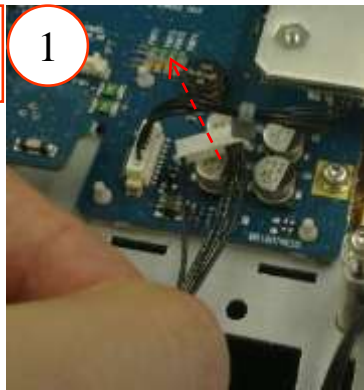
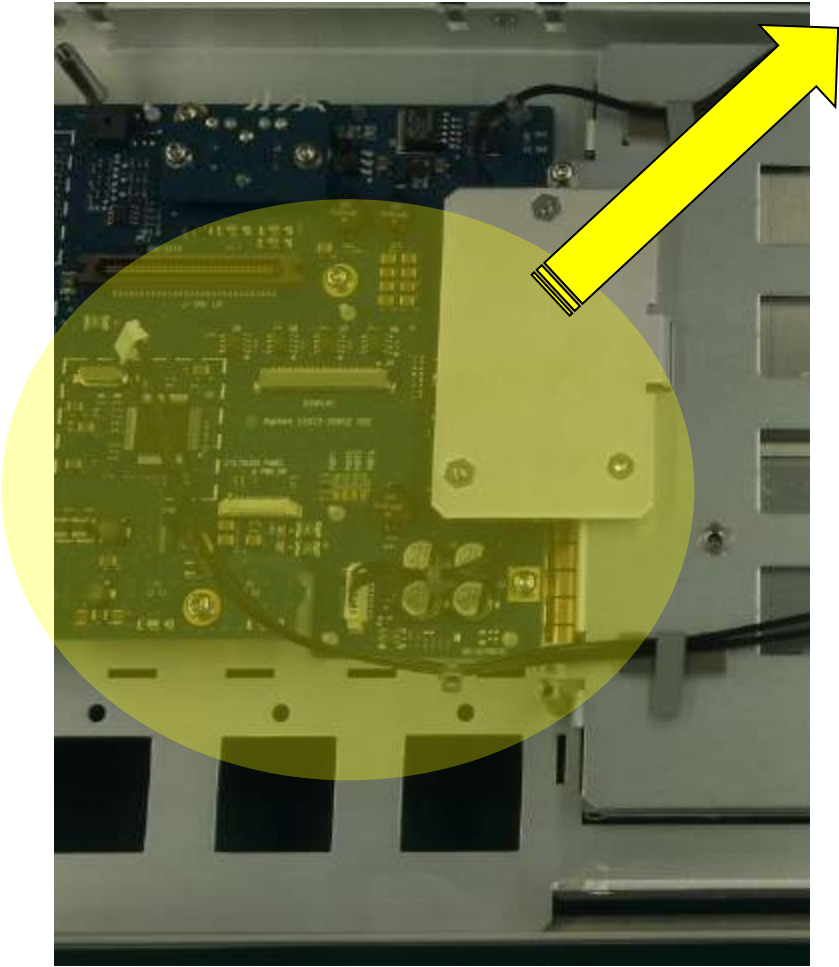
Connect E5061-61627

①

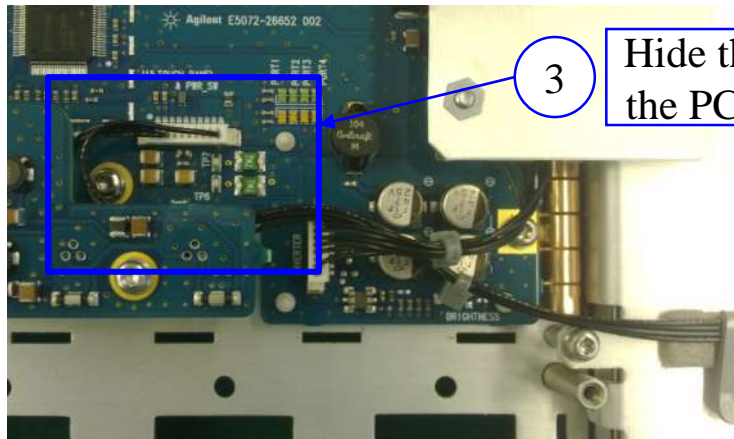
Clamp (Qty 3)

2

Route wire pass under E5061-61654

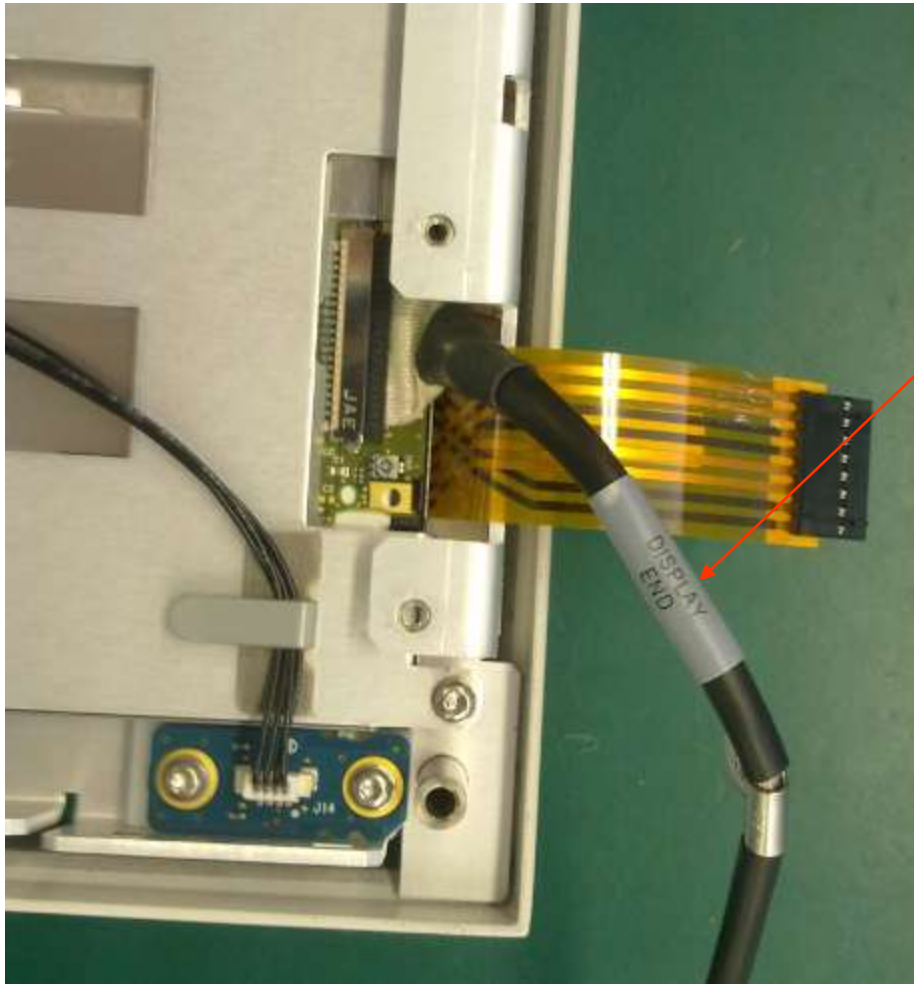


2 Connect



3 Hide the wire under the PCA board

1 2 3

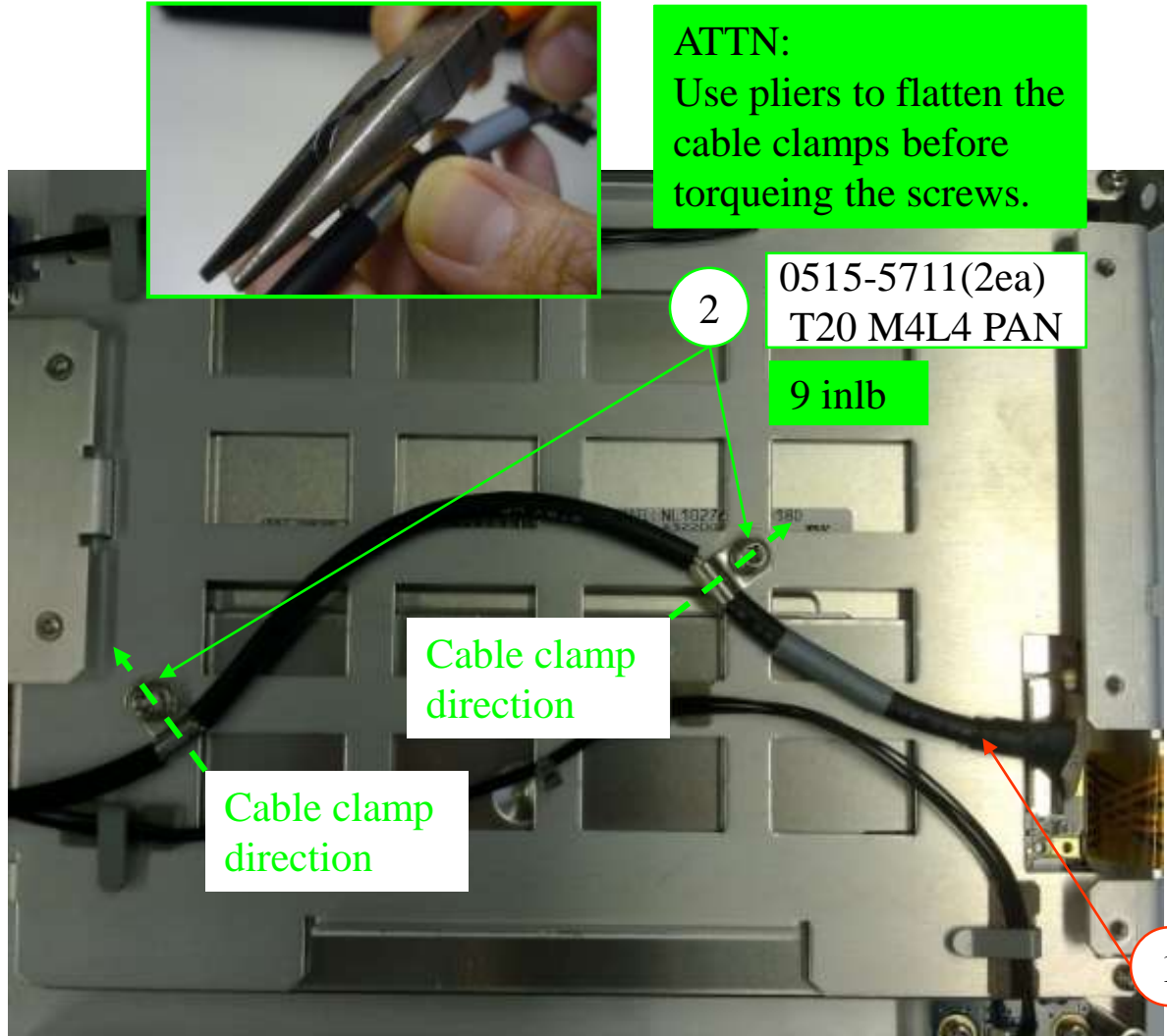


1

E5070-61699

Connect "Display End"
part of cable to the LCD
sub-assembly

1



ATTN:
Use pliers to flatten the
cable clamps before
torqueing the screws.

0515-5711(2ea)
T20 M4L4 PAN

9 inlb

2

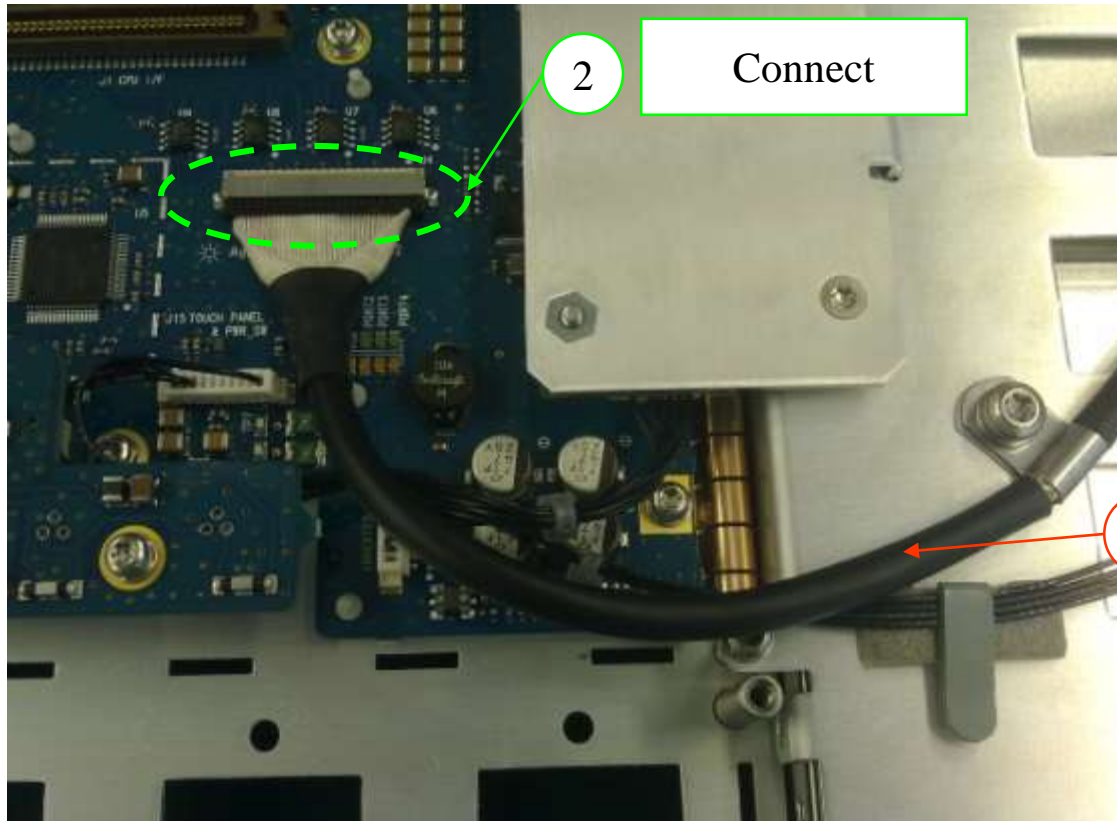
Cable clamp
direction

Cable clamp
direction

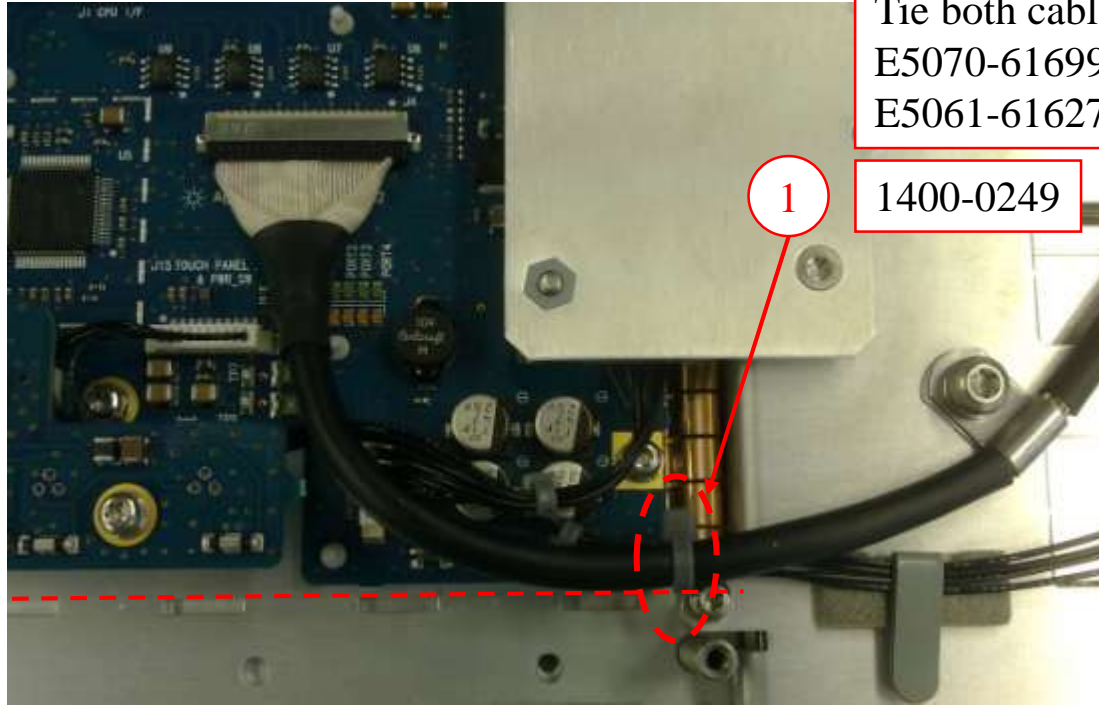
1

Previous assy

1 2



① ②



Tie both cables
E5070-61699 &
E5061-61627 together

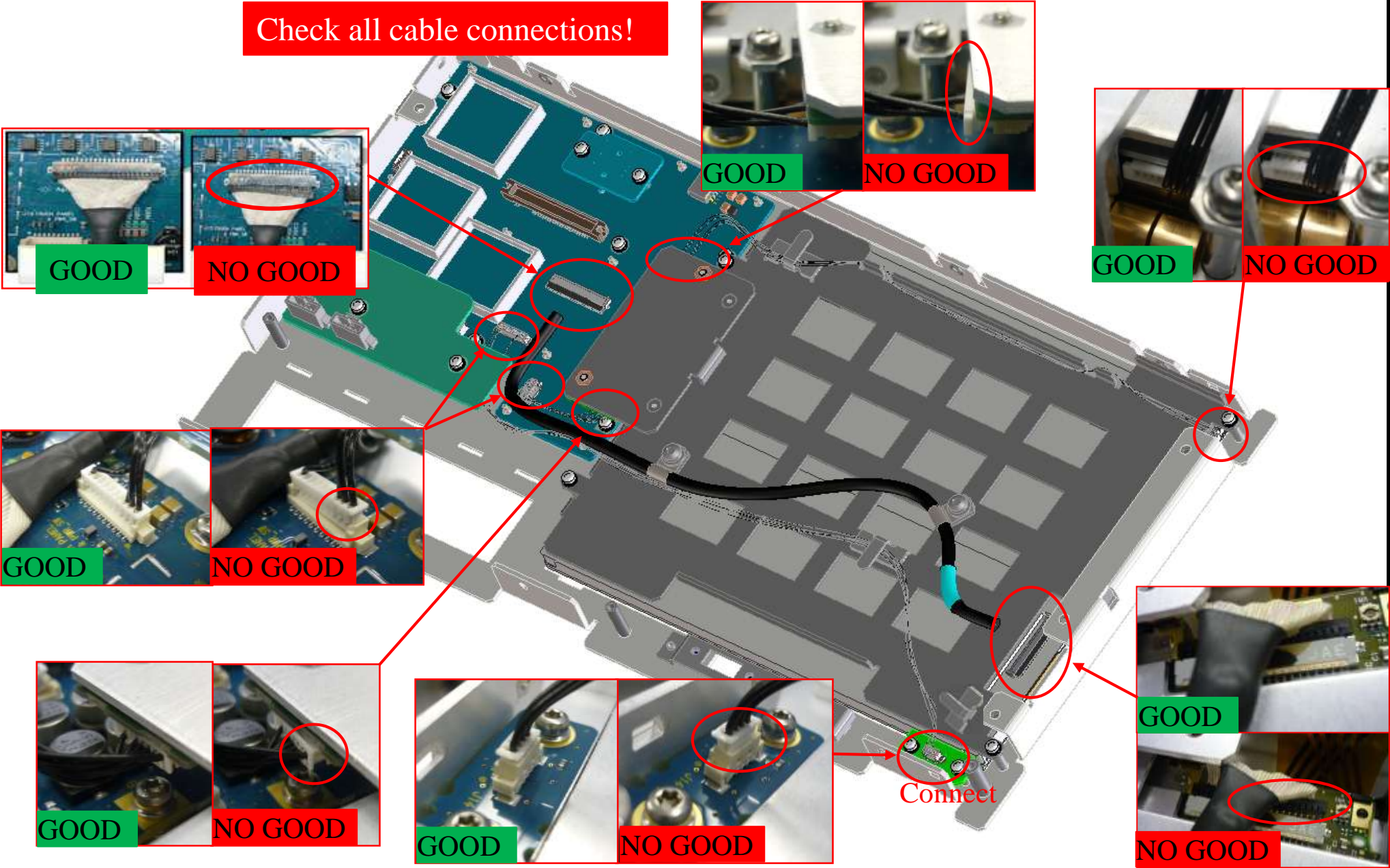
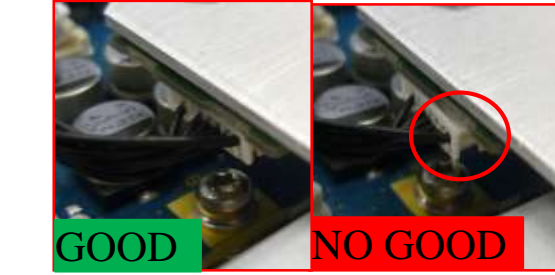
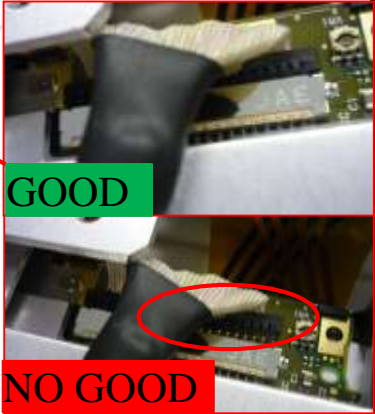
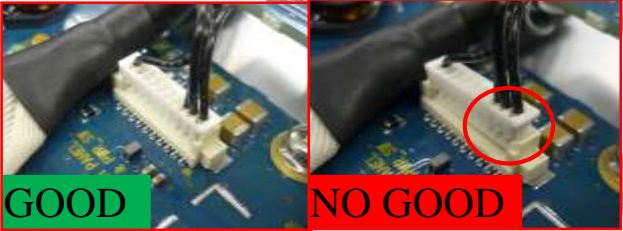
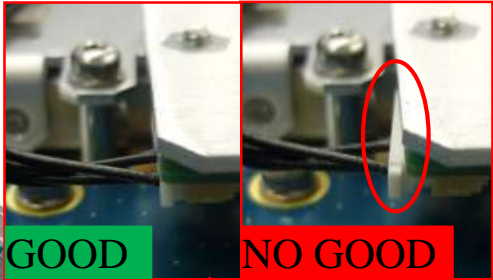
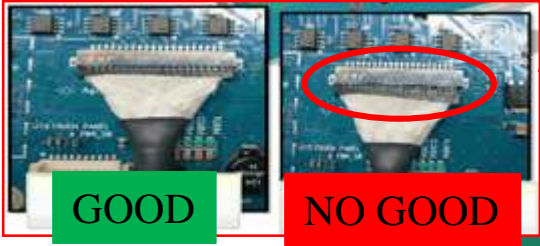
1400-0249

1

Make sure the cables
tied are above the line.

1

Check all cable connections!



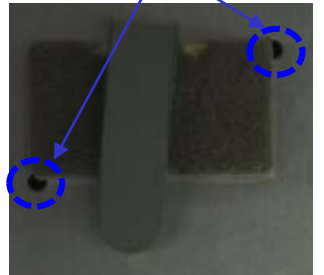
E5063-00603

1

1400-1391
Qty 2

3

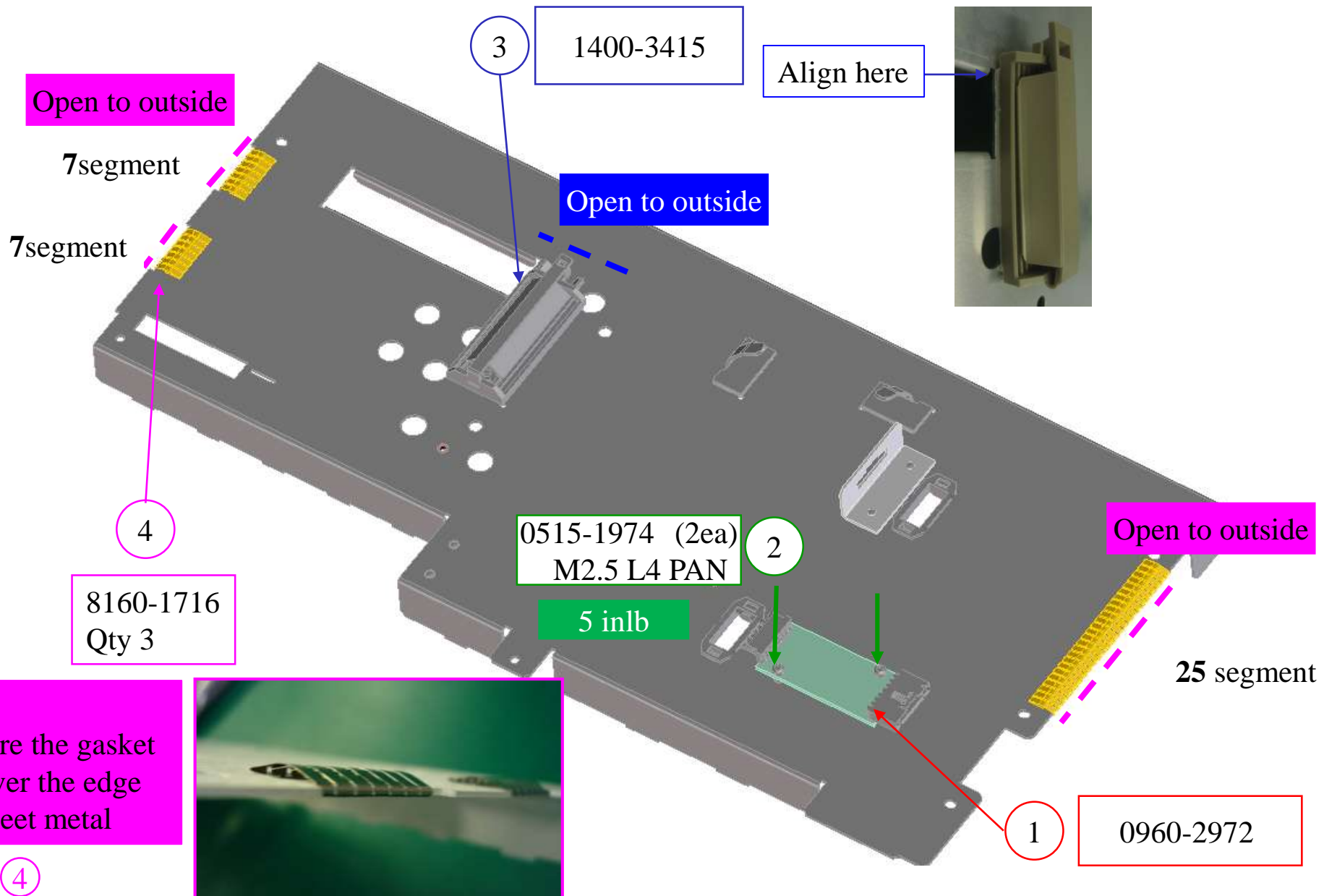
Guide points



1400-3156
Qty 2

2

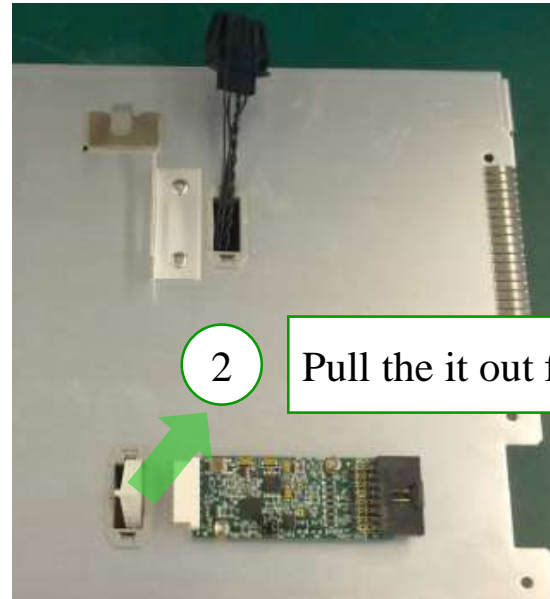
1 2 3



- ①
- ②
- ③
- ④



Insert it to the top hole

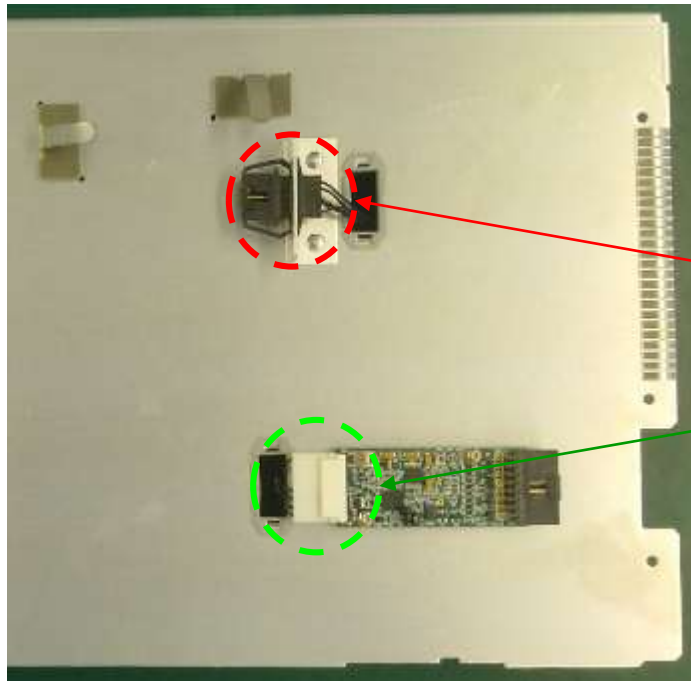


2 Pull the it out from the bottom hole

E5061-61651

1

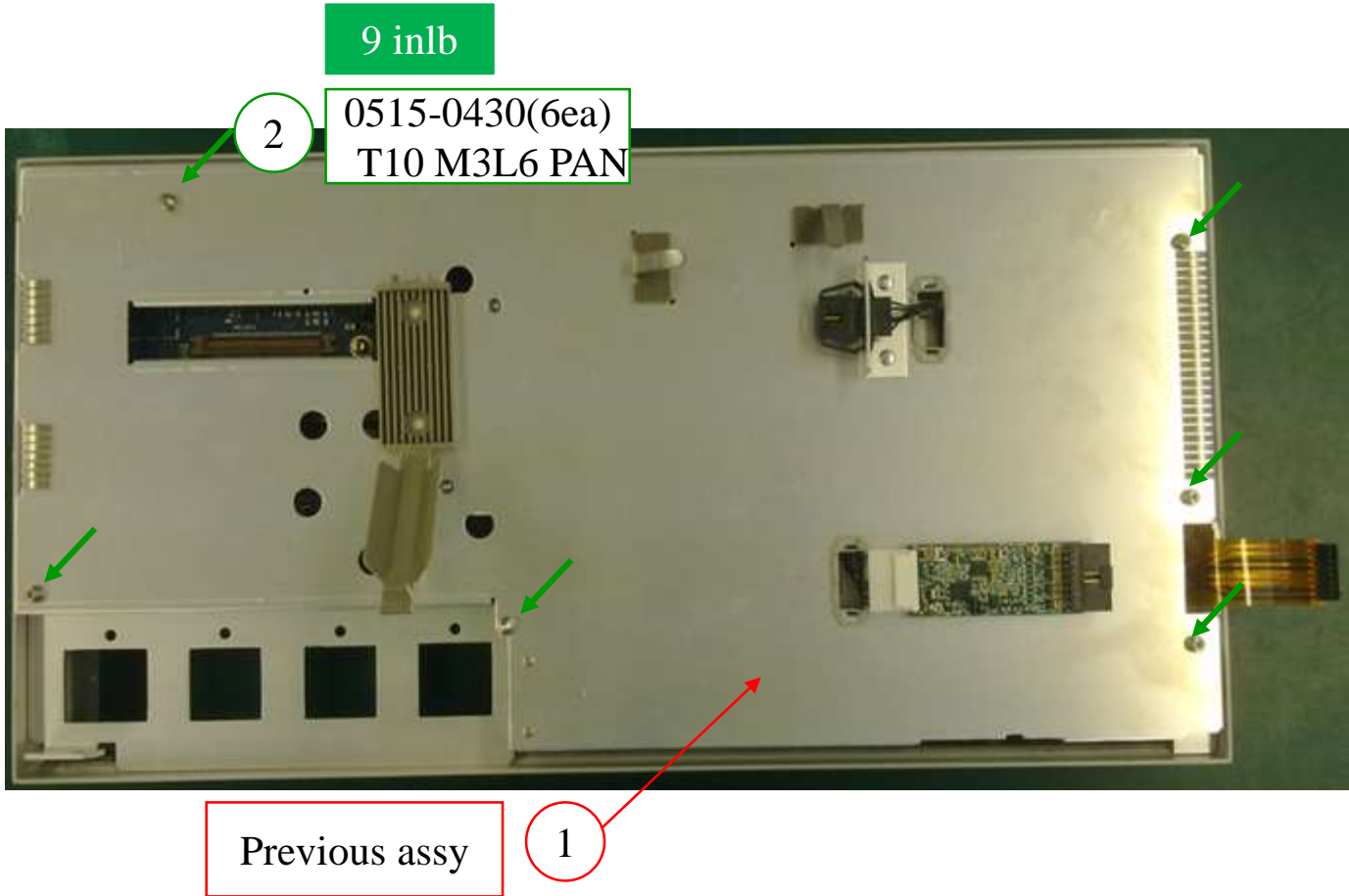
1 2



1 Connect

2 Connect

1 2

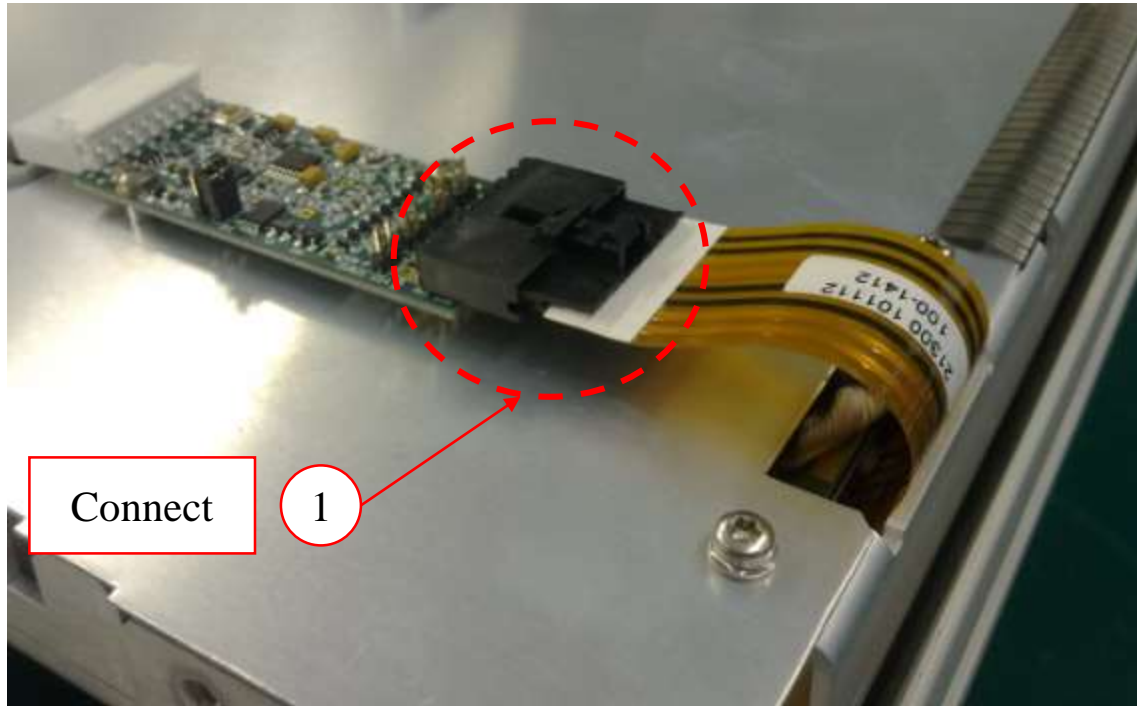


① ②

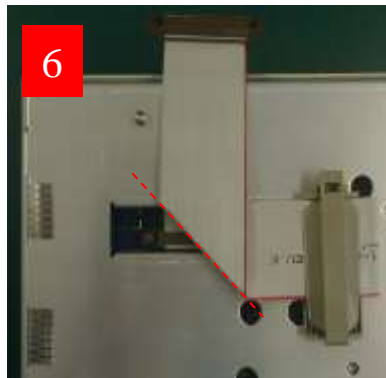
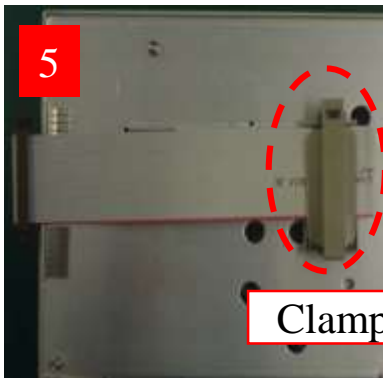
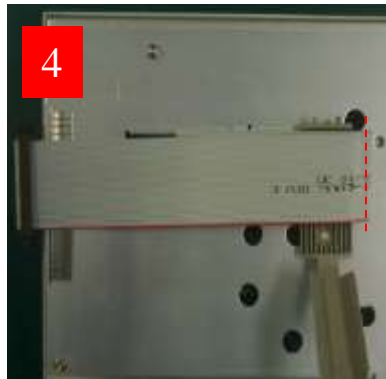
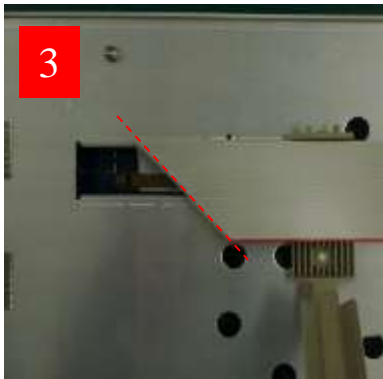
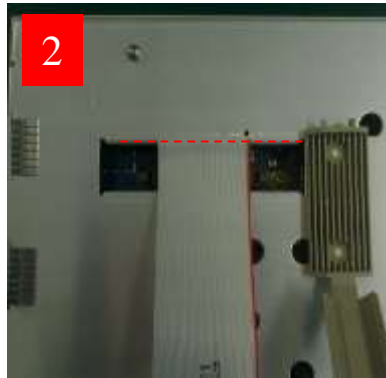
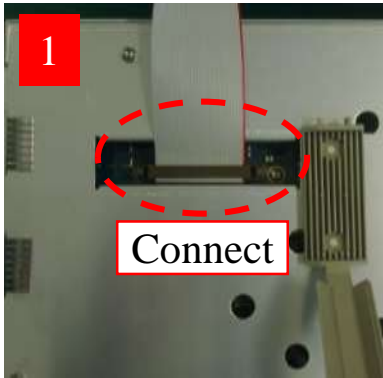
CLOSE COVER

d10

Rev. A

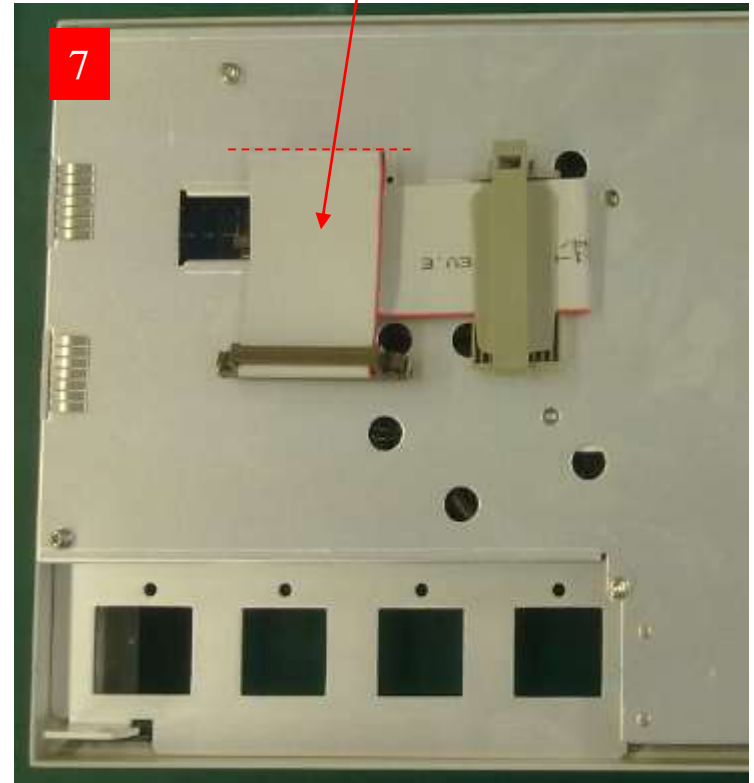


①



E5061-61631

1



①