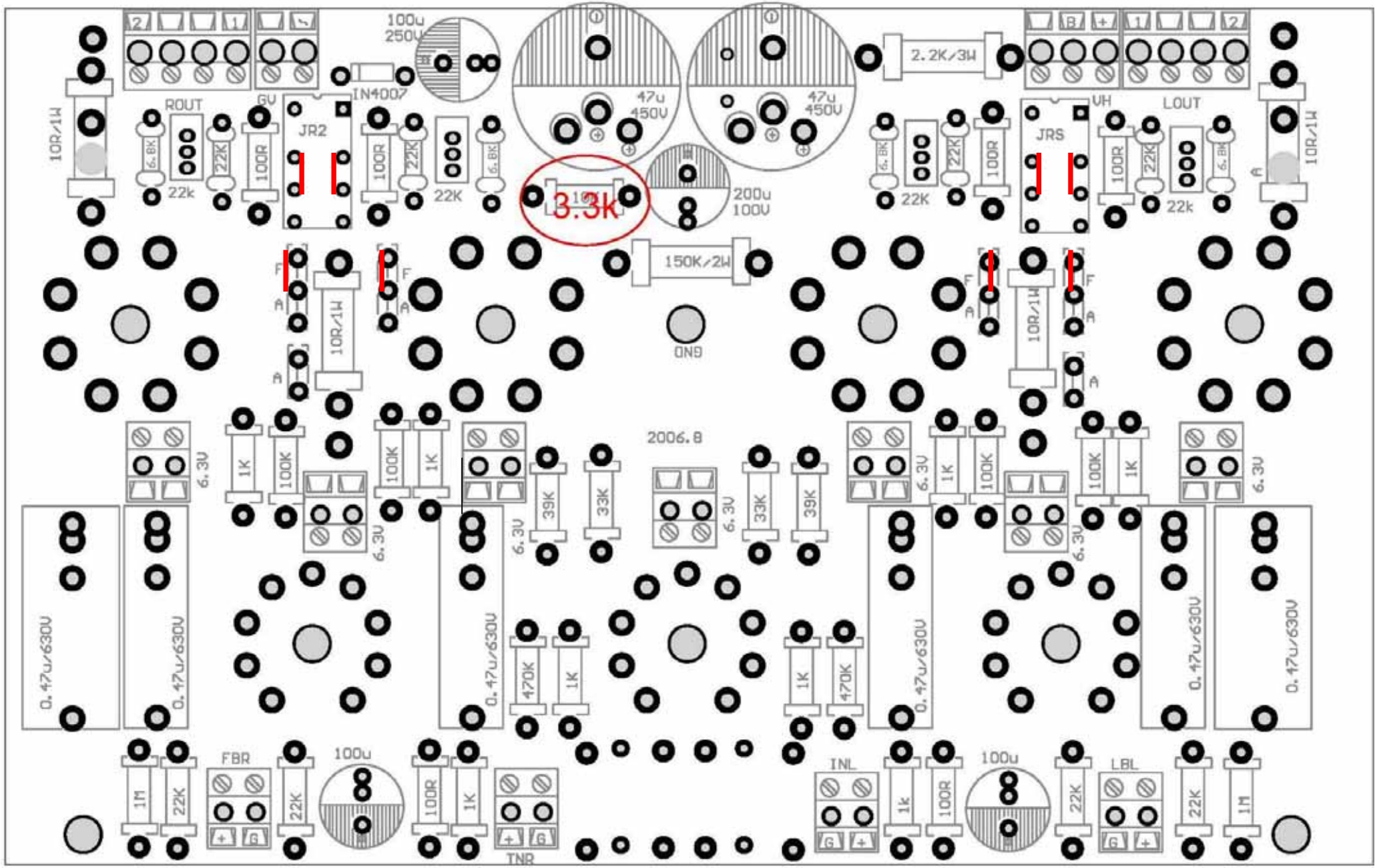
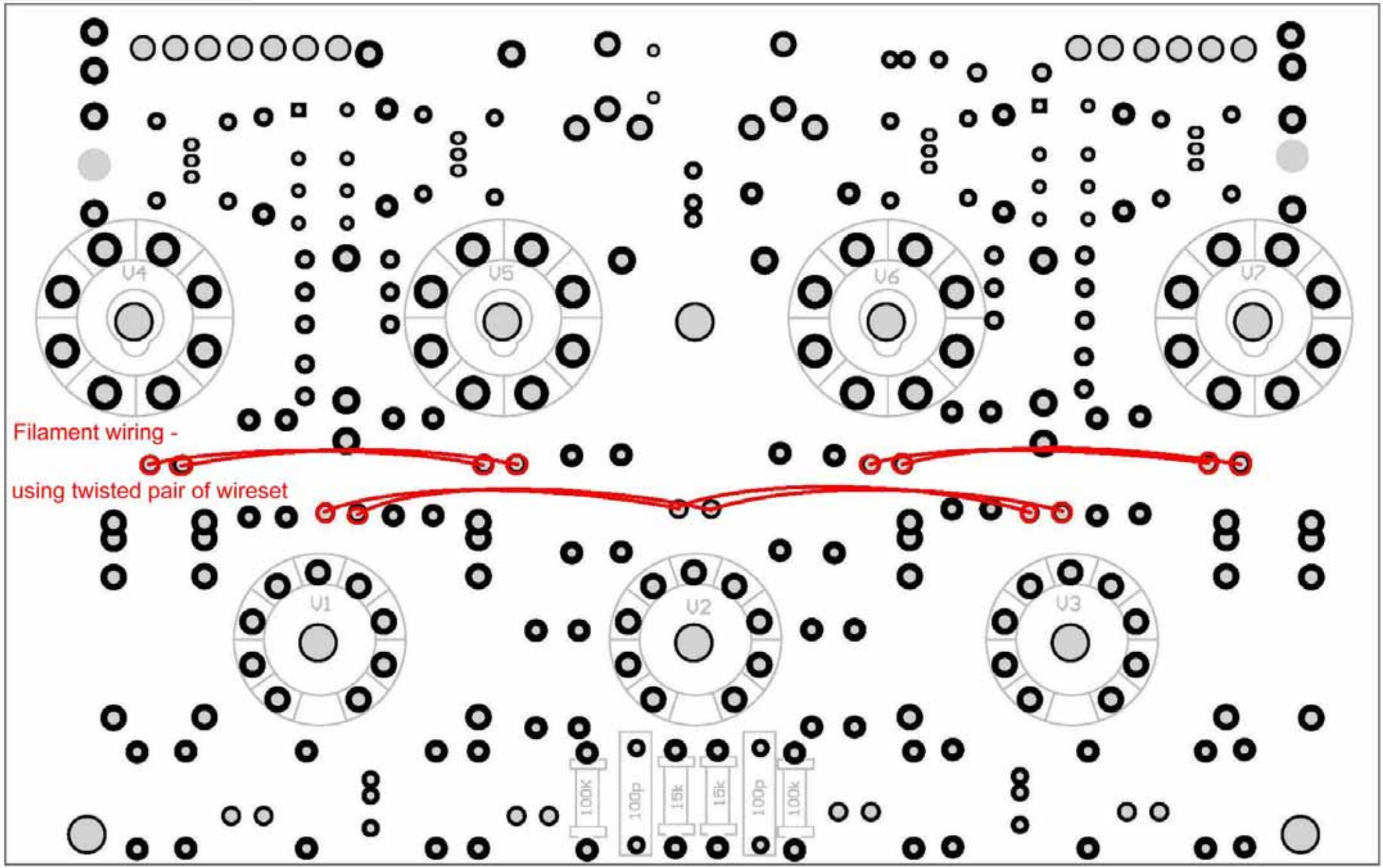
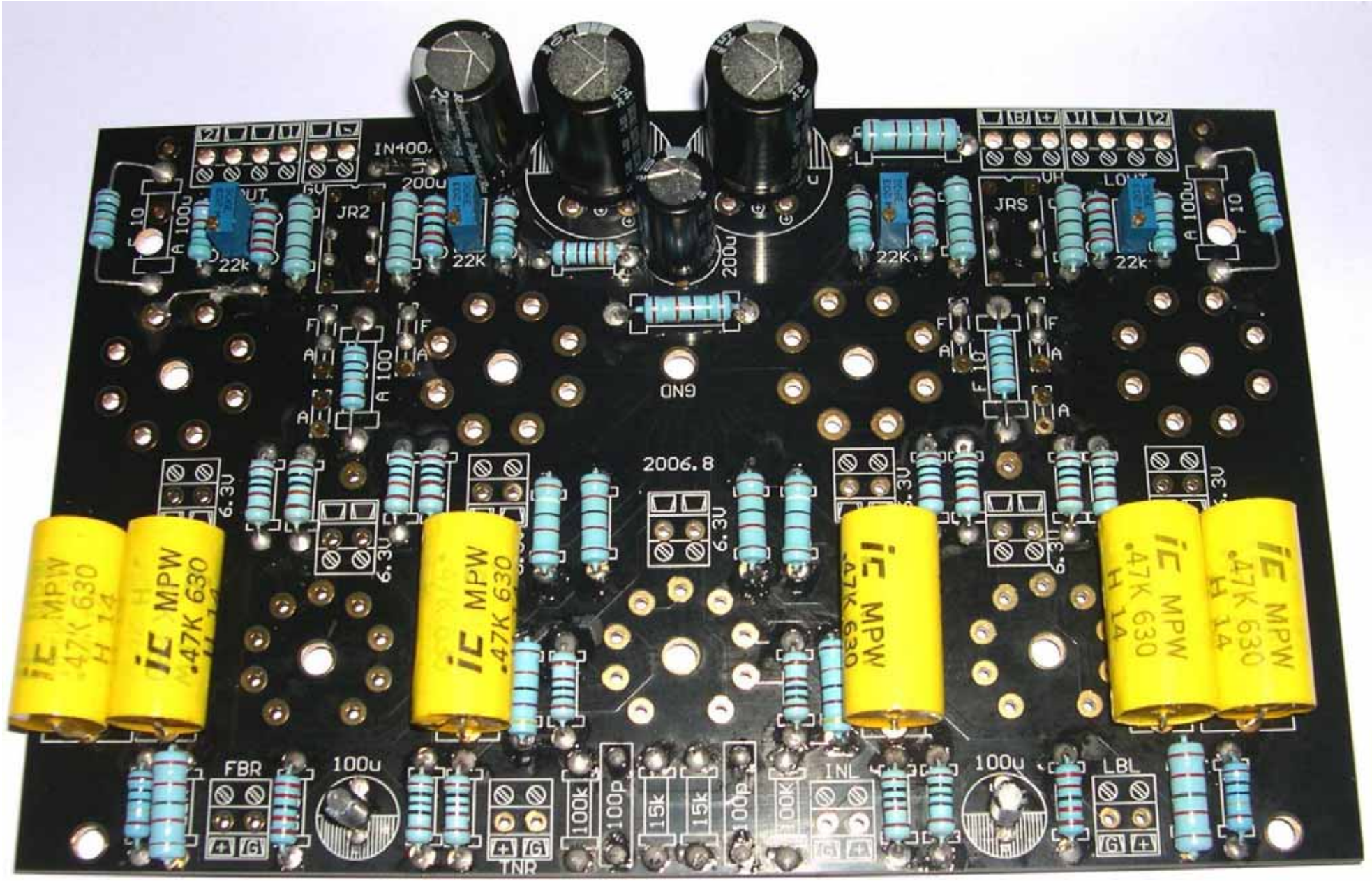
Step 1. Bottom side parts stuffing: change 10Kohm into 3.3K ohms; put 8 jumpers, see red color lines;



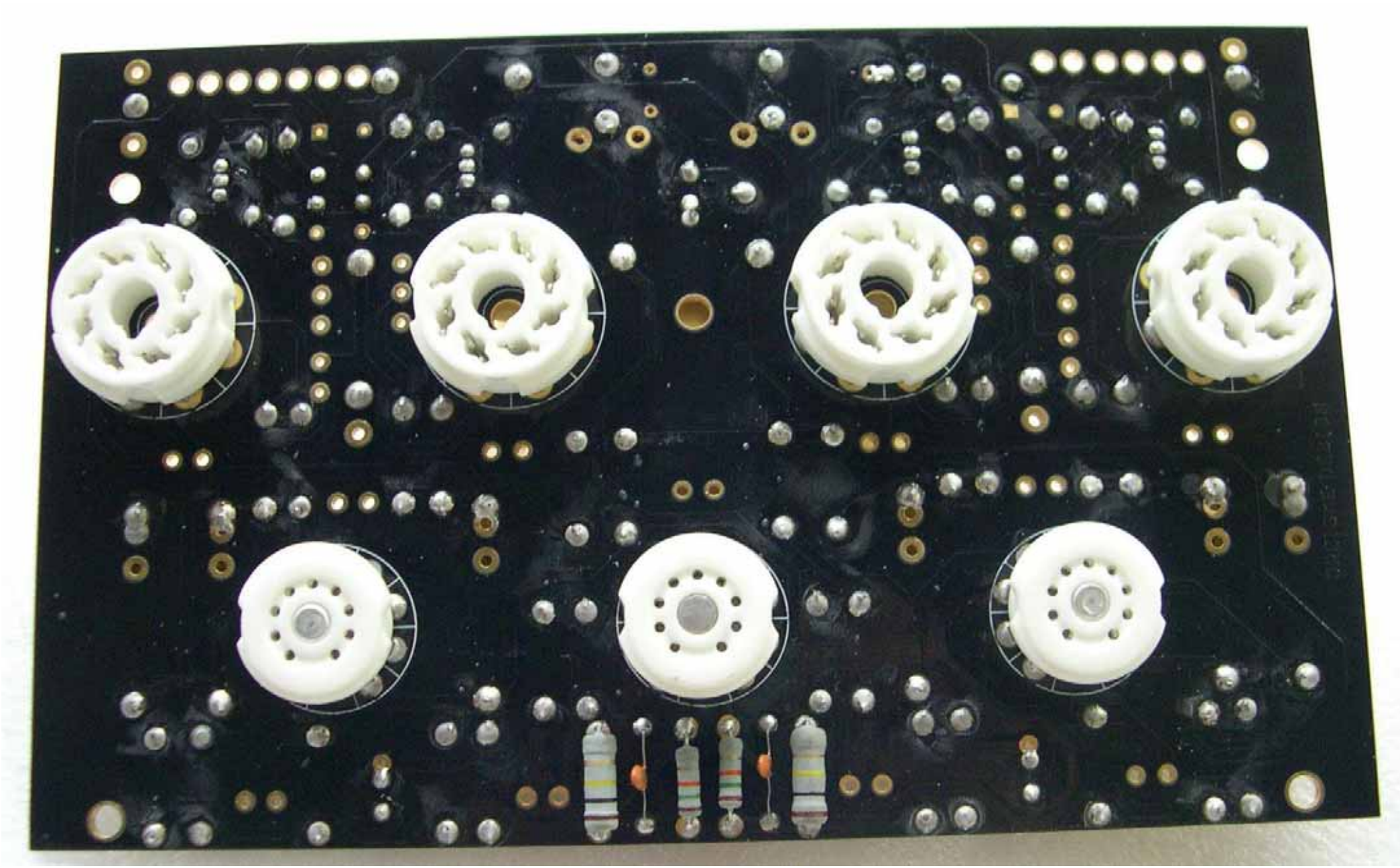
Step 2. Top side parts stuffing



Step3. Finished PCBA – bottom side



Step 4. Finished PCBA – top side



Step 5. Chassis level assembly

a. fasten both Rubycon cap with clamps

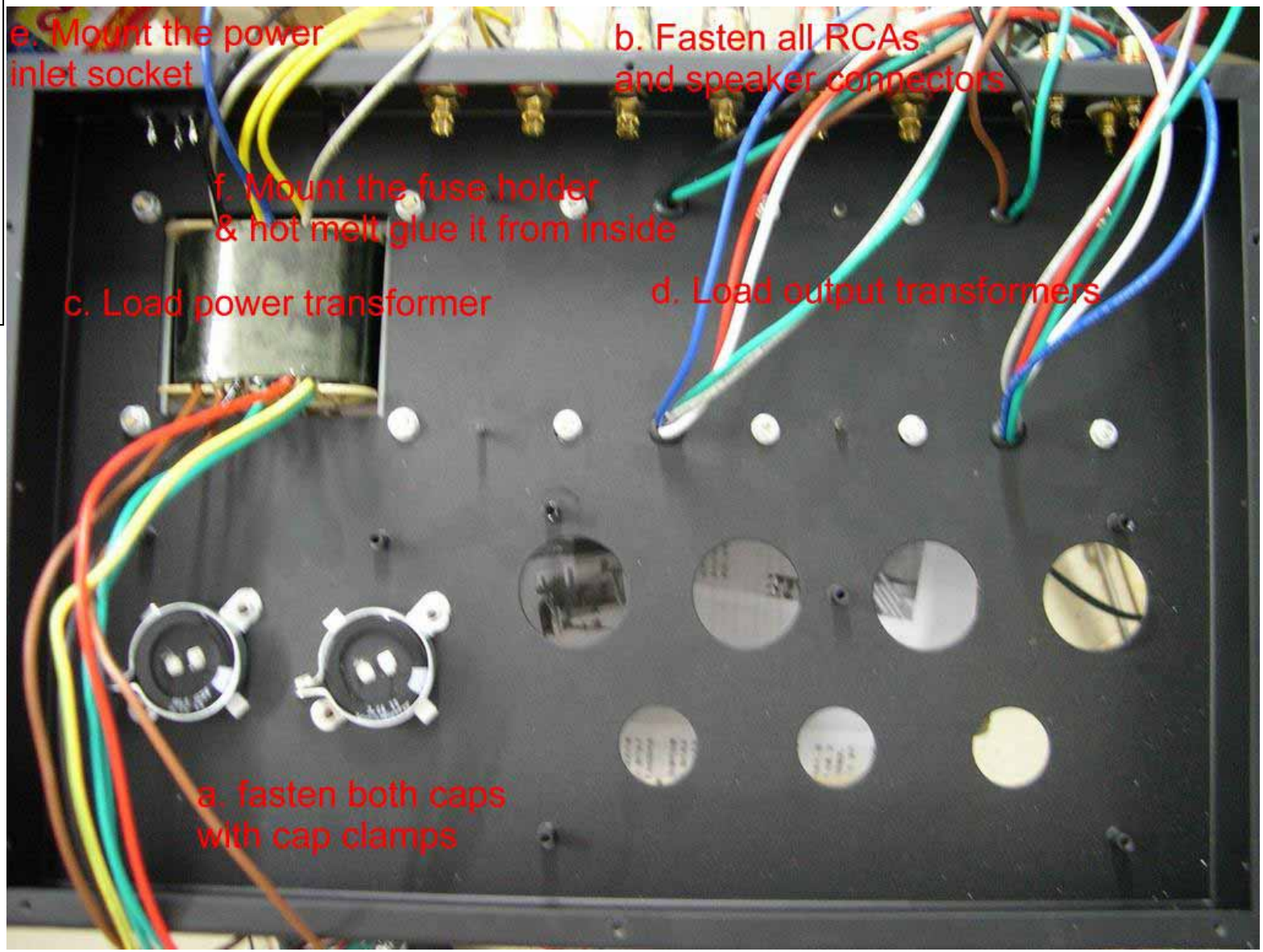
b.fasten all RCA and speaker connectors

c.load the power transformer

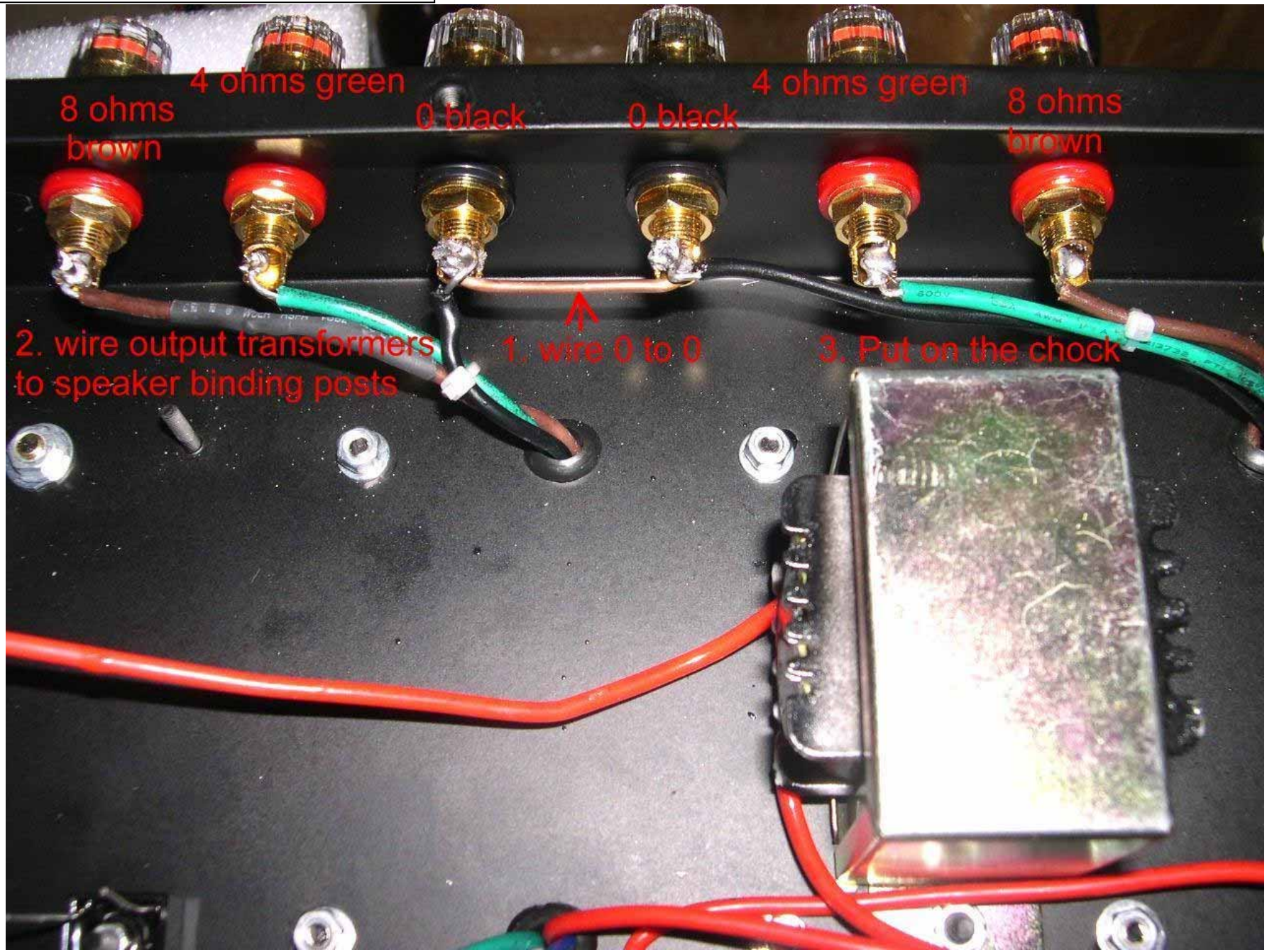
d. load both output transformers

e. mount the power inlet socket

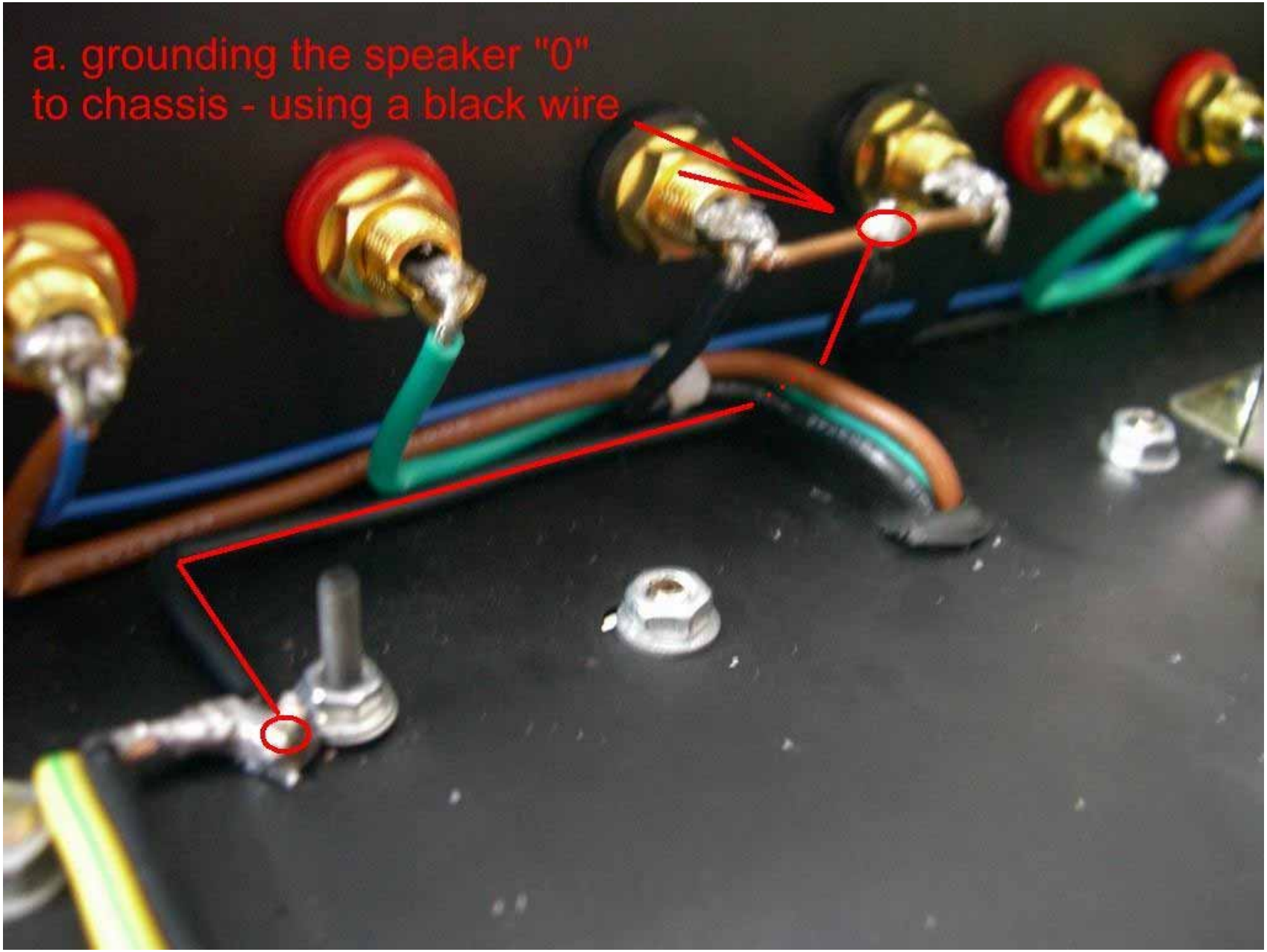
f. mount the fuse holder and hot melt glue it from the inside of the chassis



Step 6. Speaker binding posts wiring and chock loading;

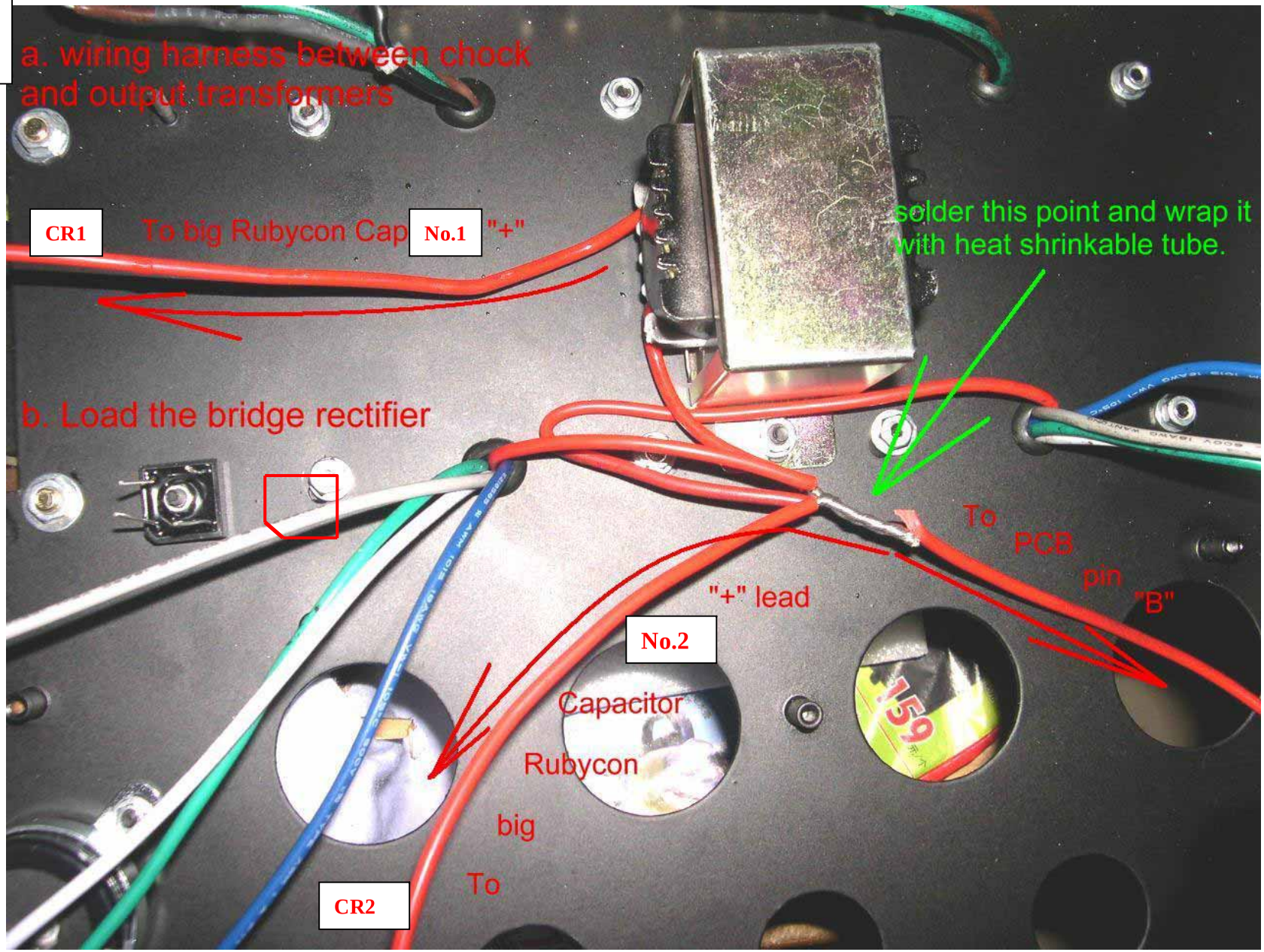


Step7. Ground the speaker binding post “0” to chassis, using a black wire.

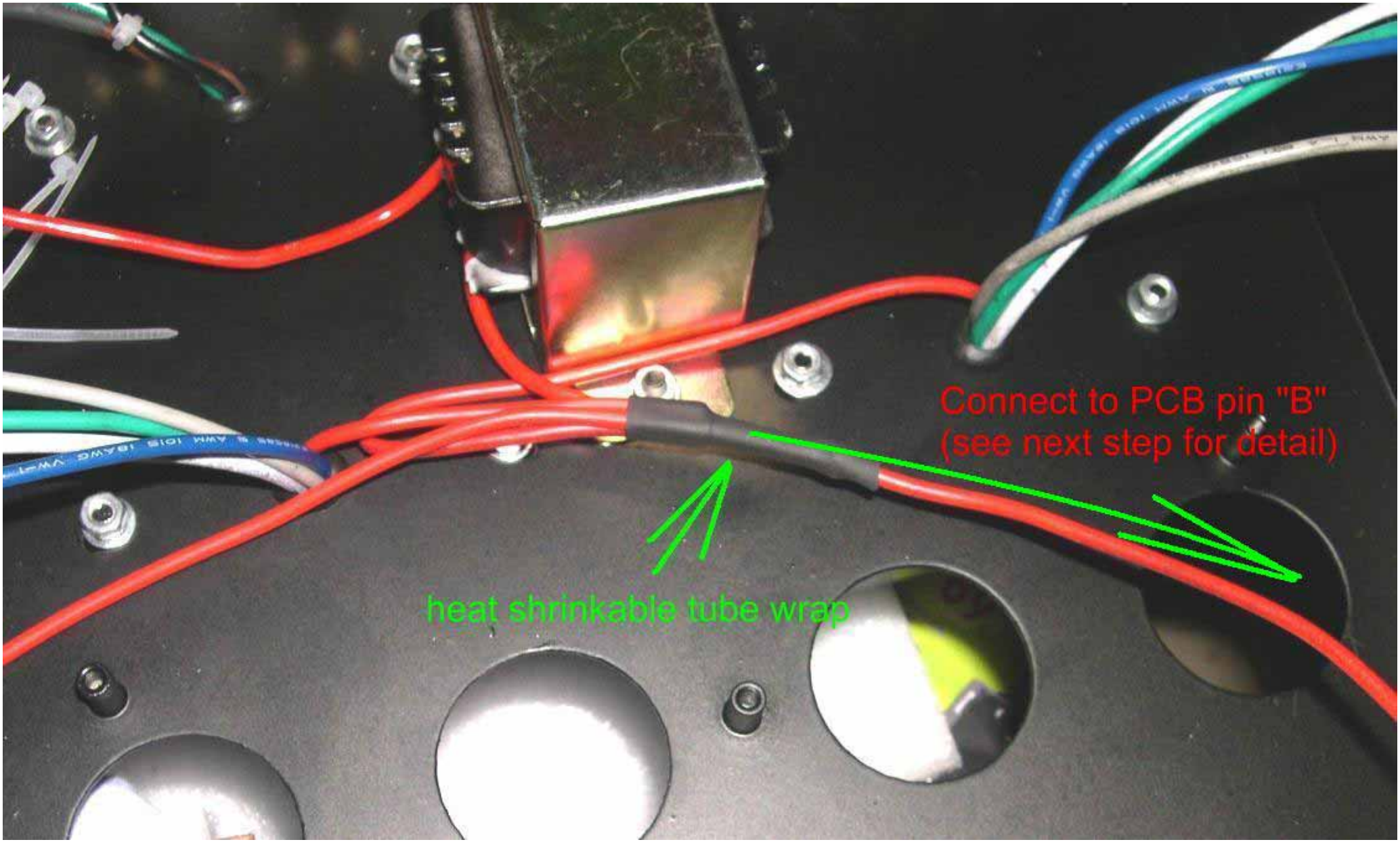


Step8. Put a grounding wire among all RCA connectors.

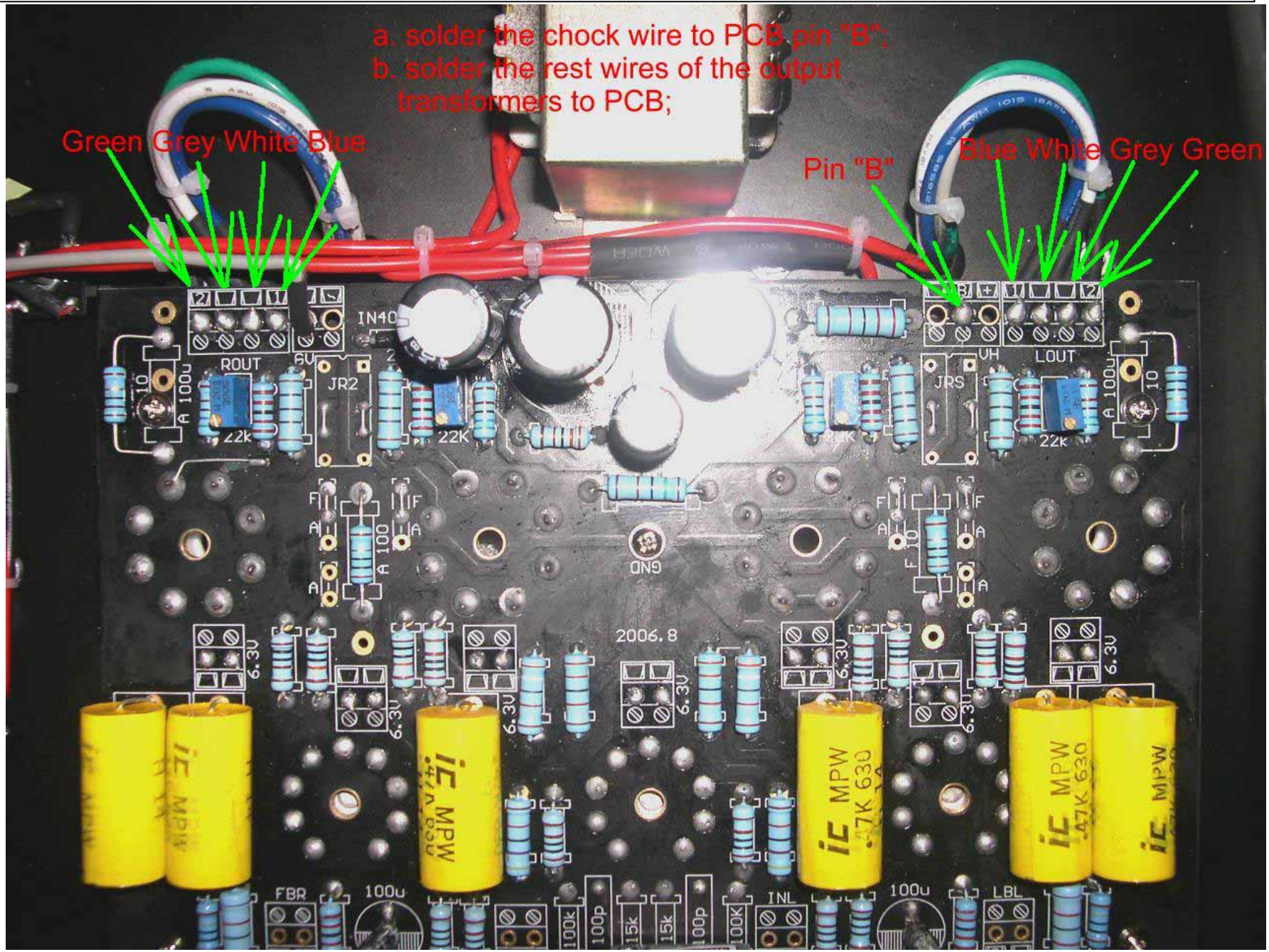
Step9. Chock wiring to Rubycon capacitor and to PCB;
Rectifier bridge loading – make sure assembly direction is correct as shown.;



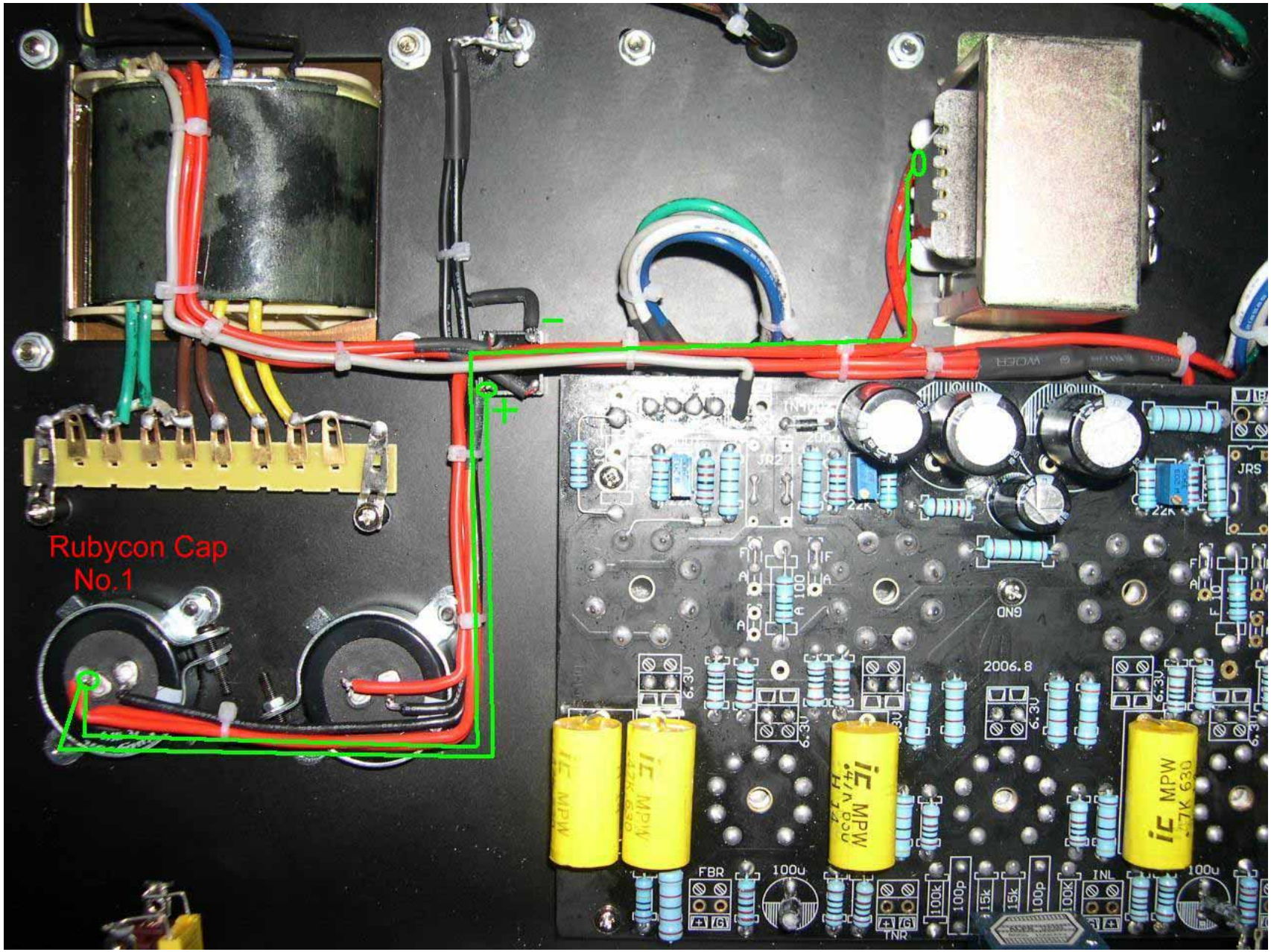
Wires conjunction heat shrinkable tube wrap.



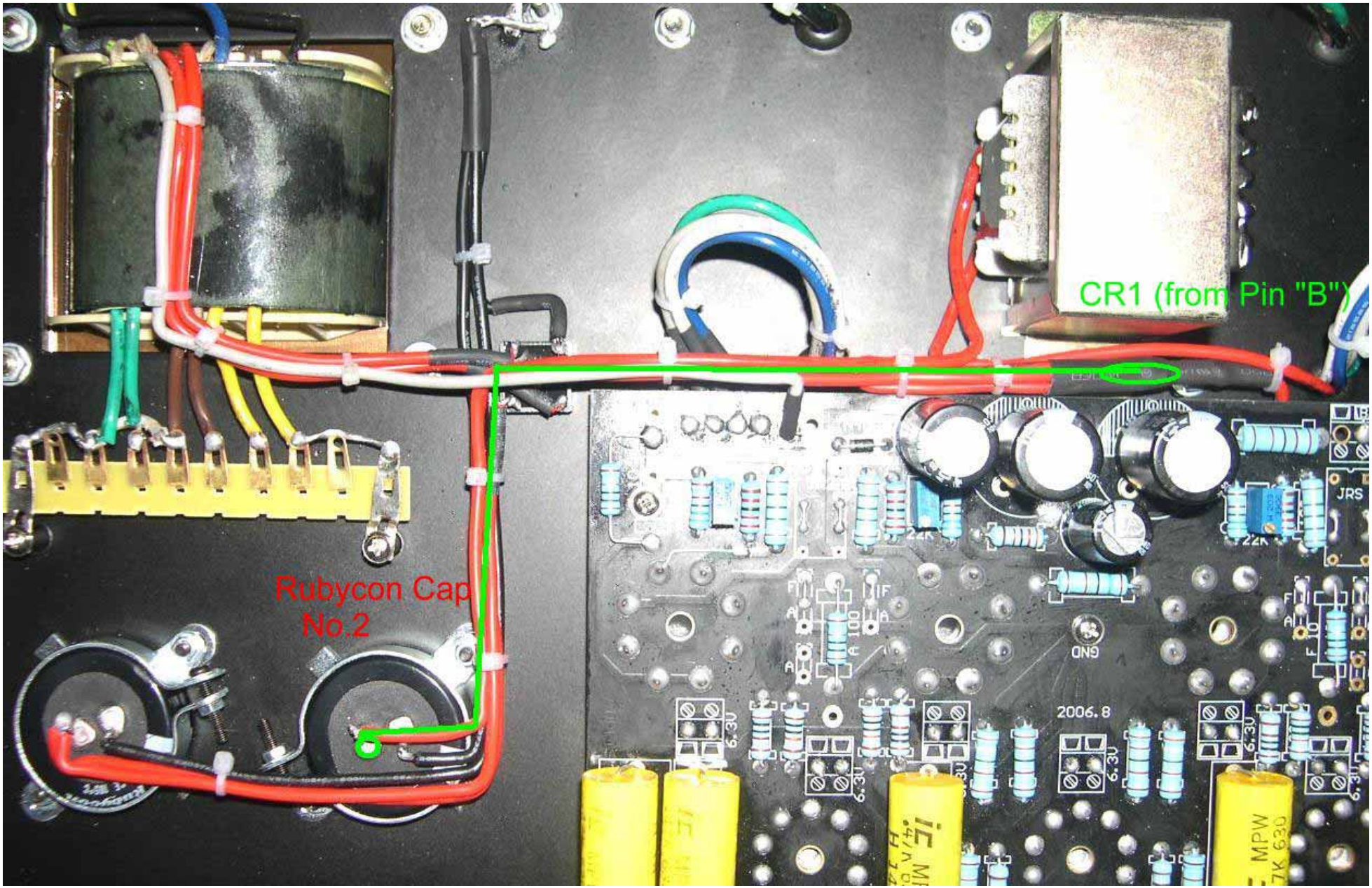
Step 10. Chock and Output transformer connection: a. Solder the tube wrapped chock wire to PCB pin “B”; b. Solder the rest wires of the output transformer to PCB;



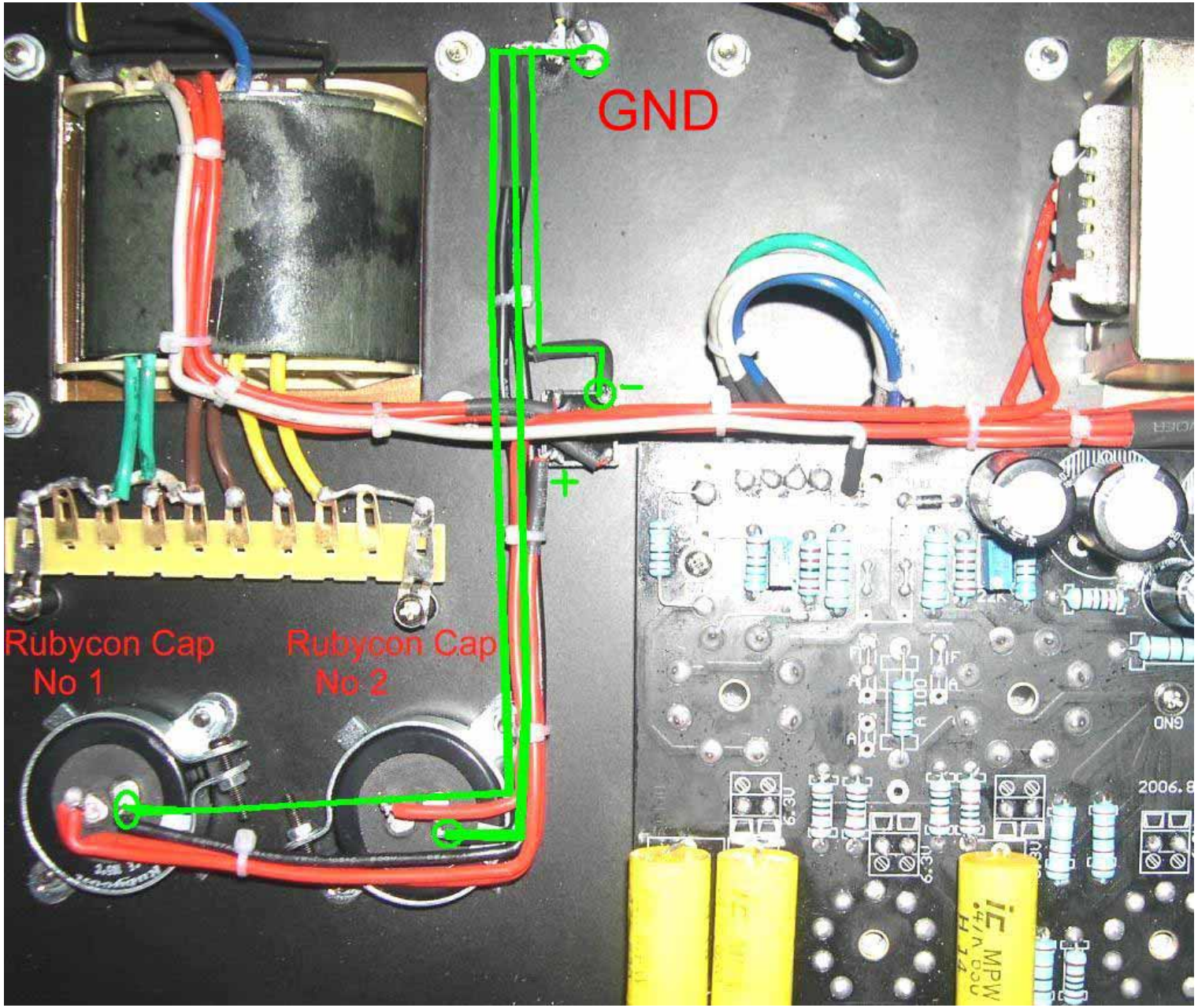
Step 11. Connection between chock and Rubycon capacitor: using two red wires (See step 9 for **CR1**), connect CR1 to the “+” of No 1 Rubycon capacitor; connect “+” of the bridge to the “+” of No 1 Rubycon capacitor. See below green color route



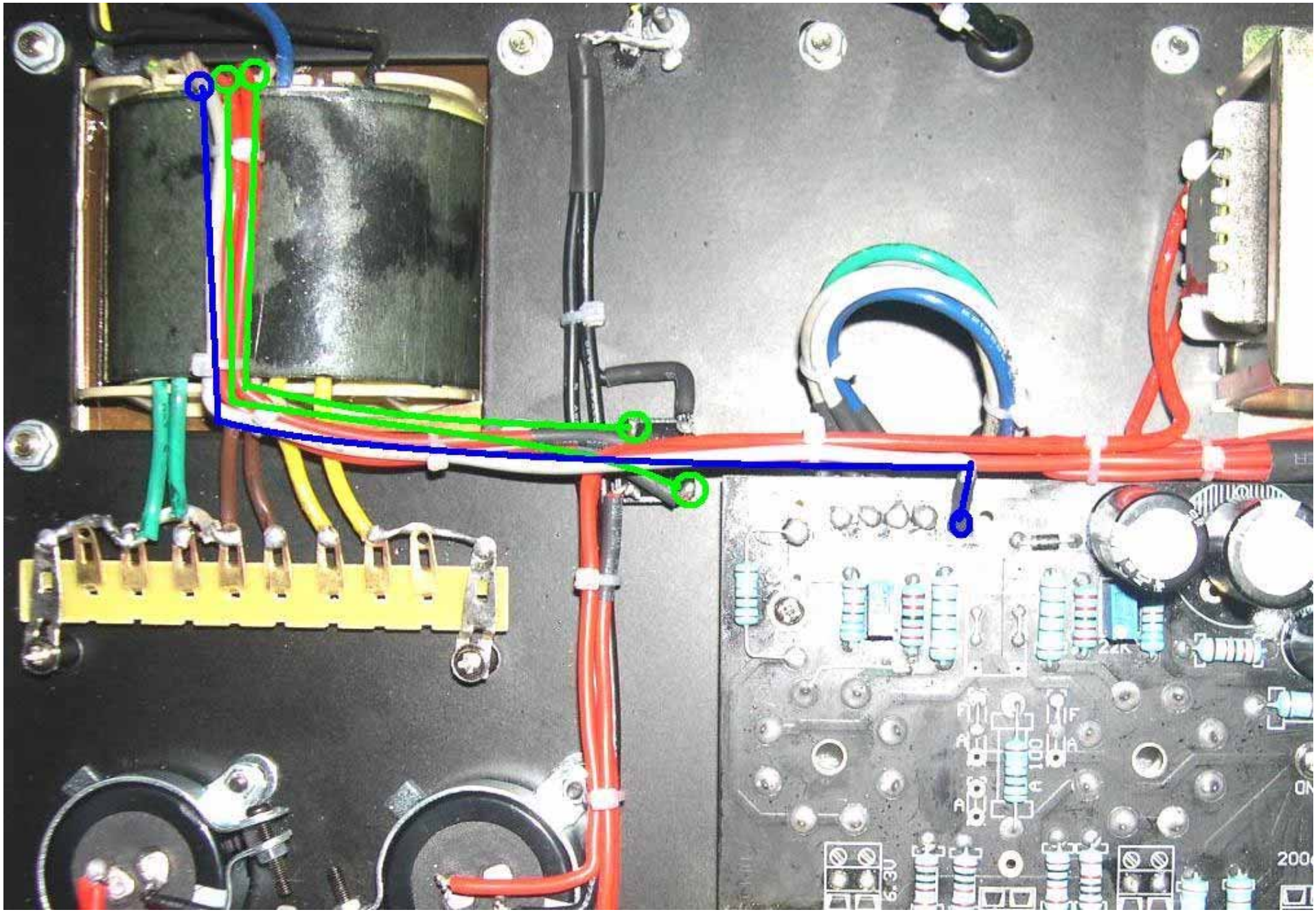
Step 12. Connection between Pin “B” and Rubycon capacitor: using one red wire (See step 9 for **CR2**), connect CR2 to the “+” of No 2 Rubycon capacitor; See below green route.



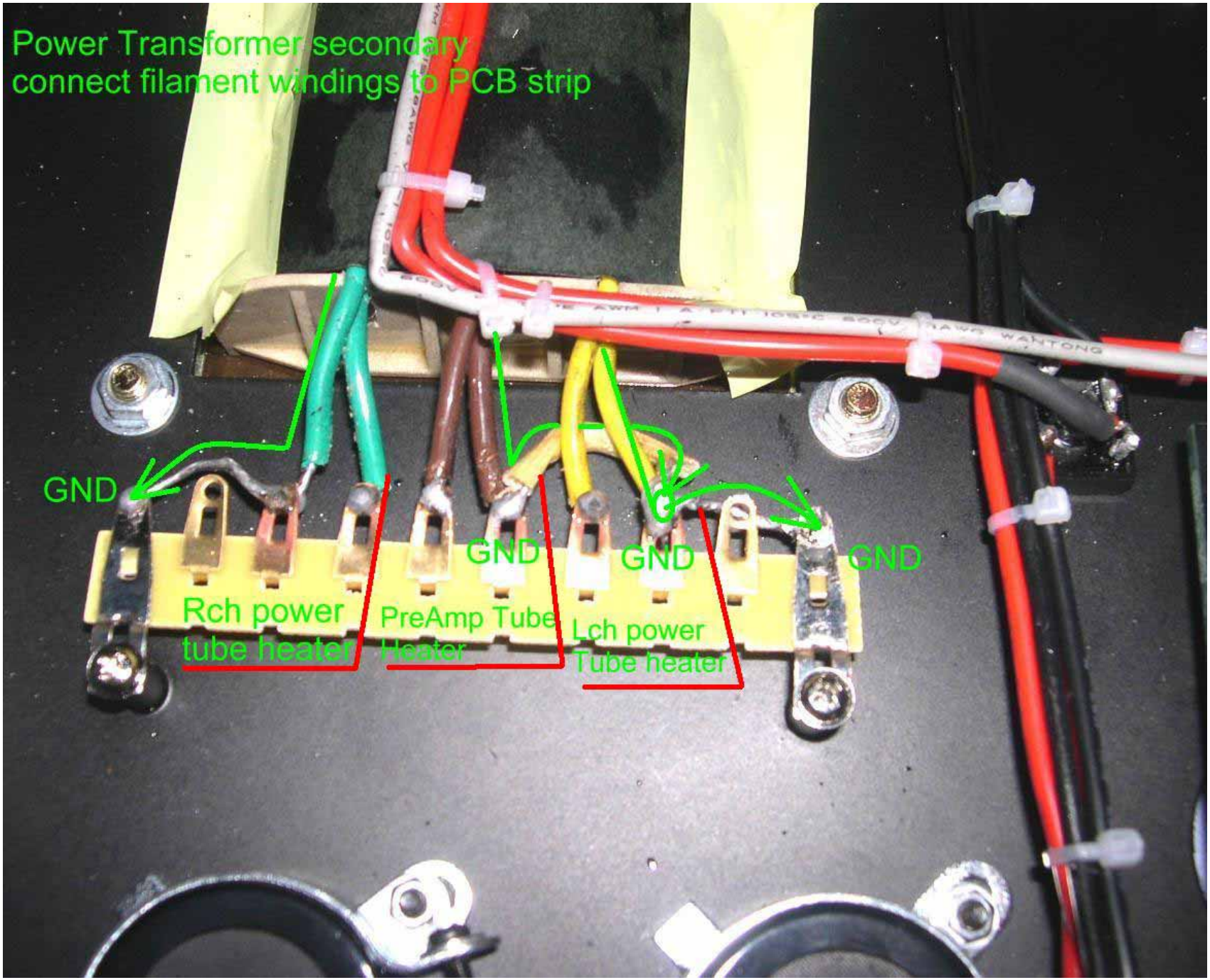
Step13. Grounding wires: using 3 black color wires. Connect the “-“ of Rubycon Cap No 1, the “-“ of Rubycon Cap No 2 and the “-“ of Bridge to the chassis ground. See below Green route



Step14. Power transformer to Bridge connection: connect two red secondary windings to the other two leads of Bridge; Connect gray wire to the PCB as shown in blue route below;

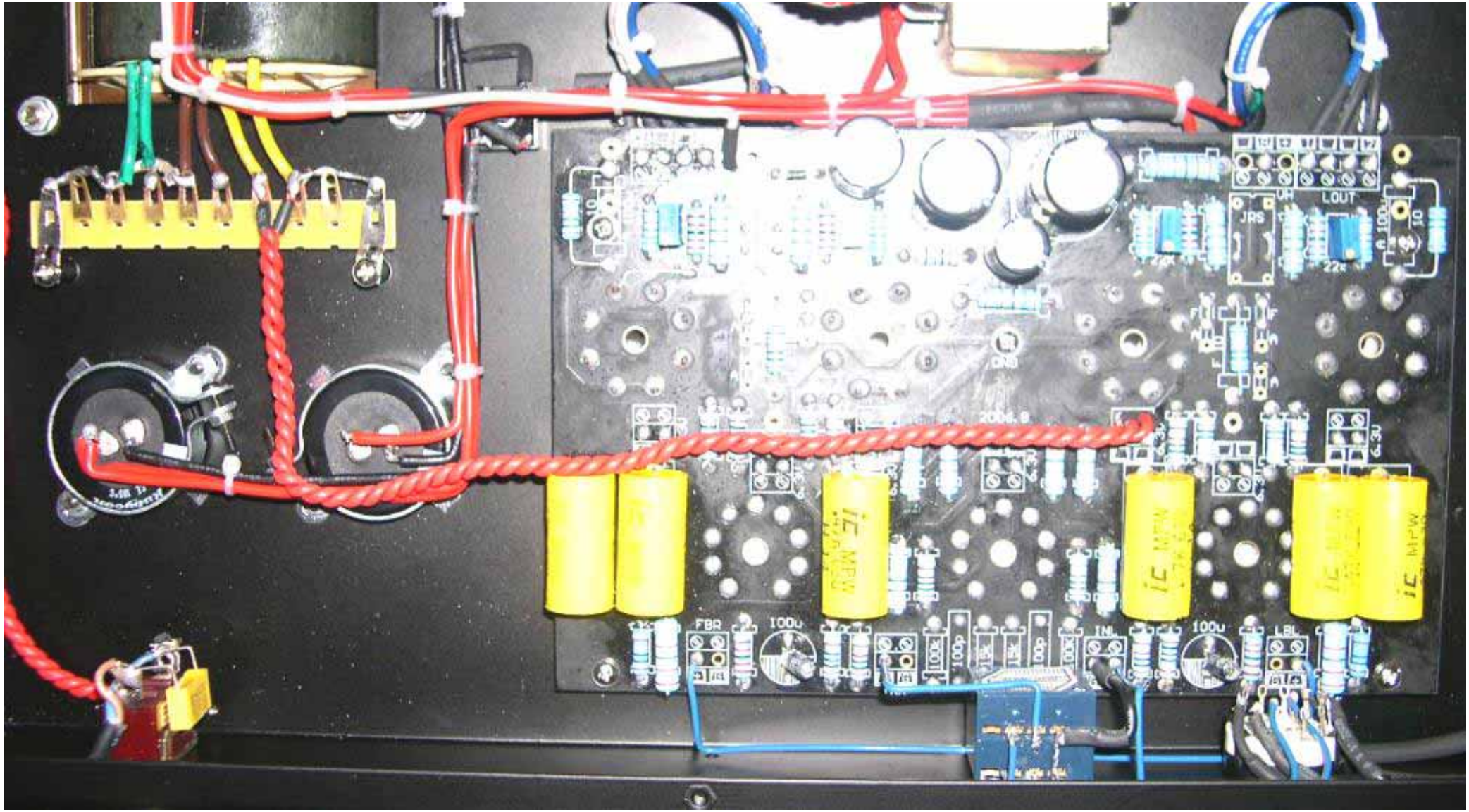


Step 15. Connects power transformer secondary heater windings to PCB strip, see below illustrations.

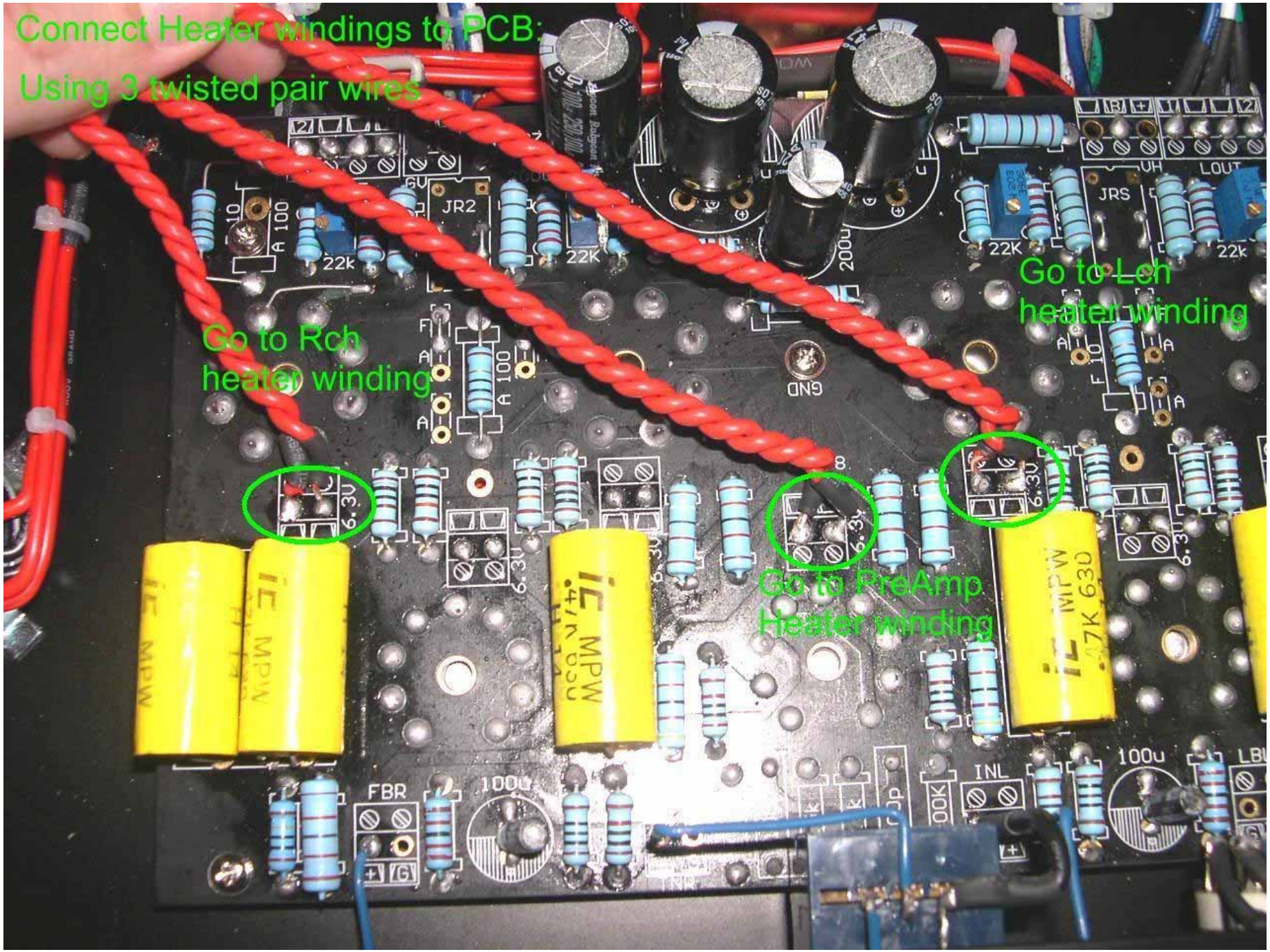


Step 16. Connect heater windings from PCB strip to PCB, see below 3 illustrations:

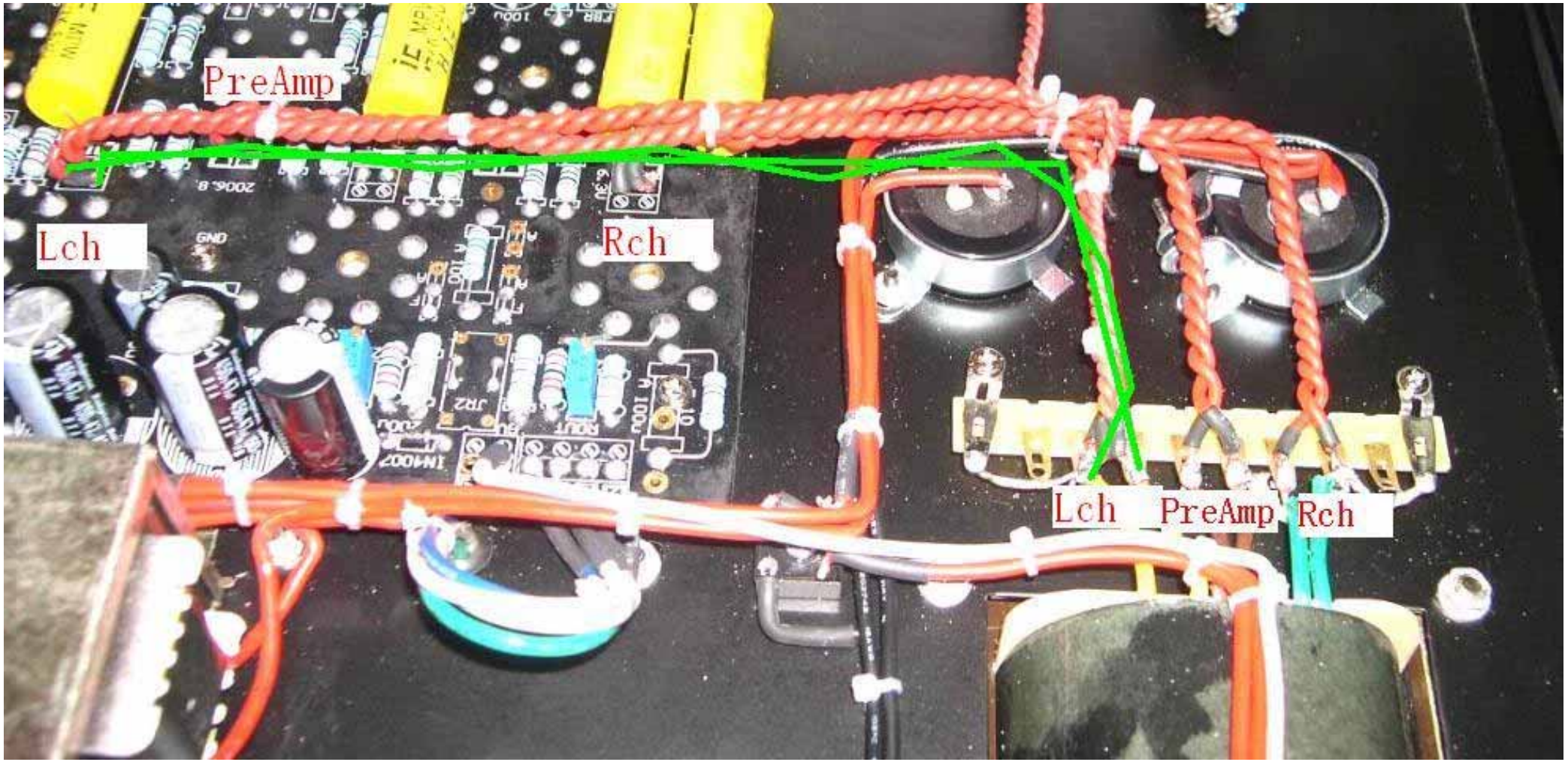
A.



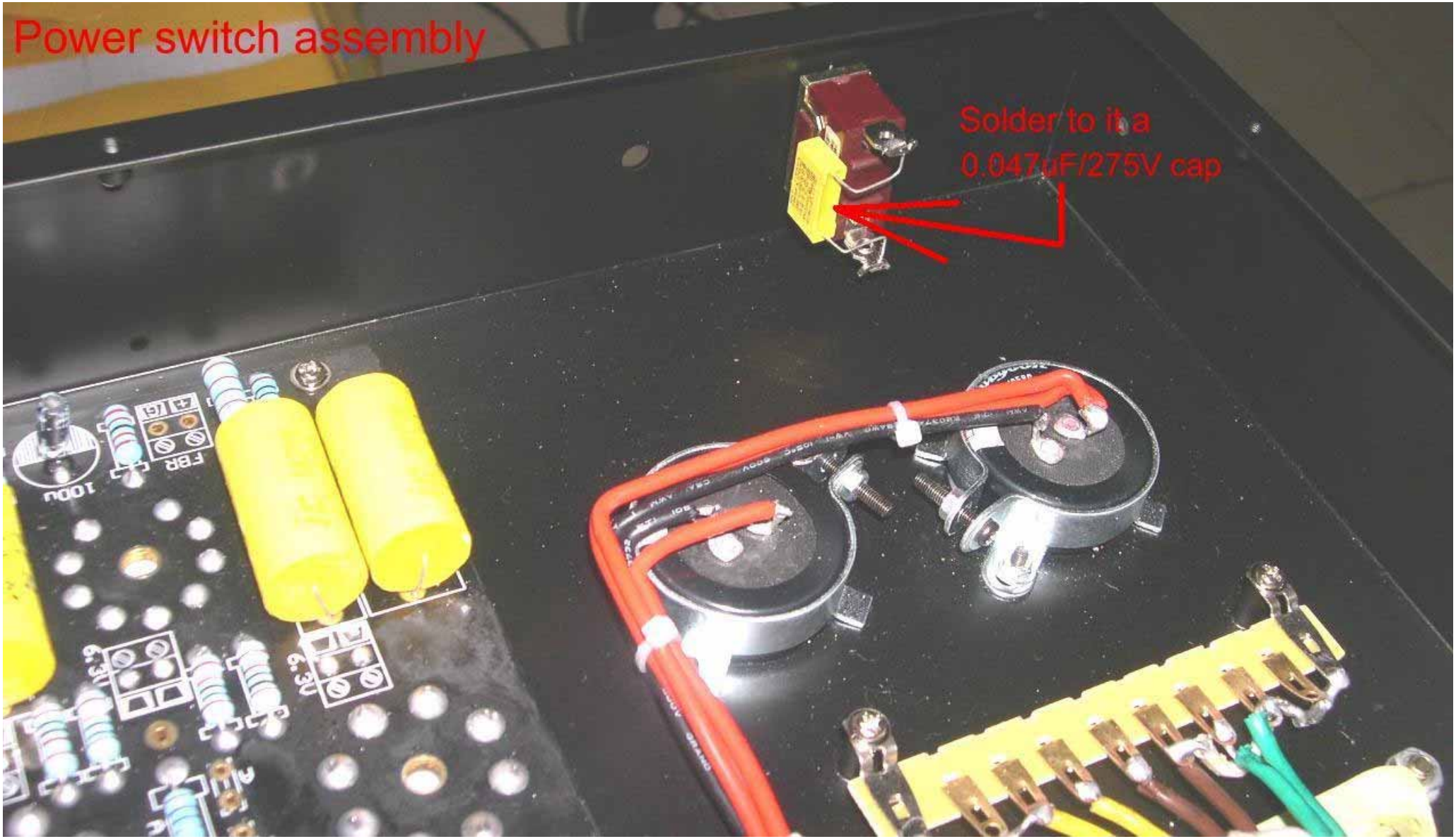
B.


Connect Heater windings to PCB:
Using 3 twisted pair wires
Go to Rch heater winding
Go to Lch heater winding
Go to PreAmp Heater winding
JR2
JRS
22k
22K
200u
100u
GND
FBR
INL
6.3V

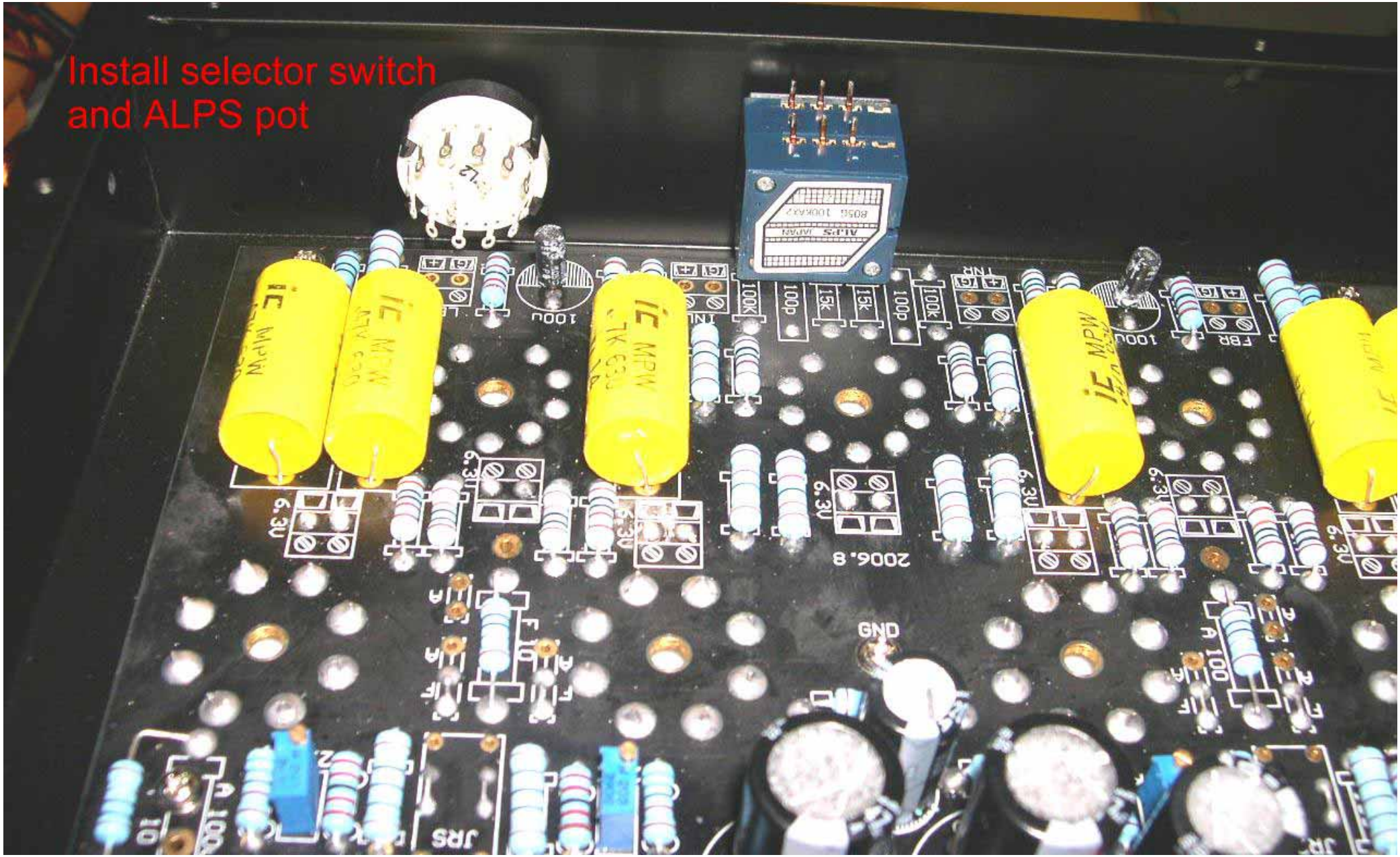
C.



Step 17. Install power switch



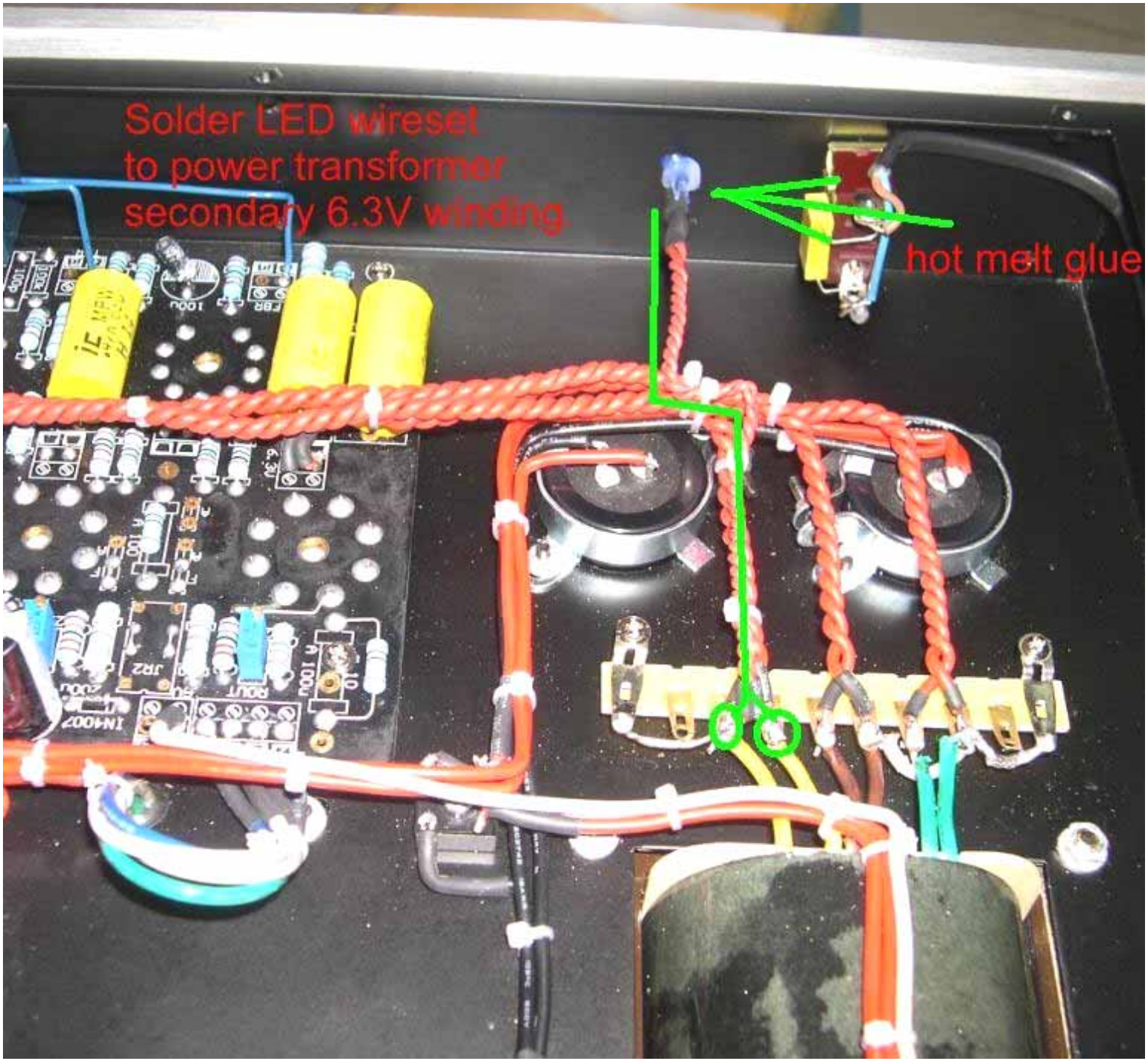
Step 18. Install selector switch(be sure you set the selector switch for 2 switching positions – for CD and AUX) and ALPS potentiometer



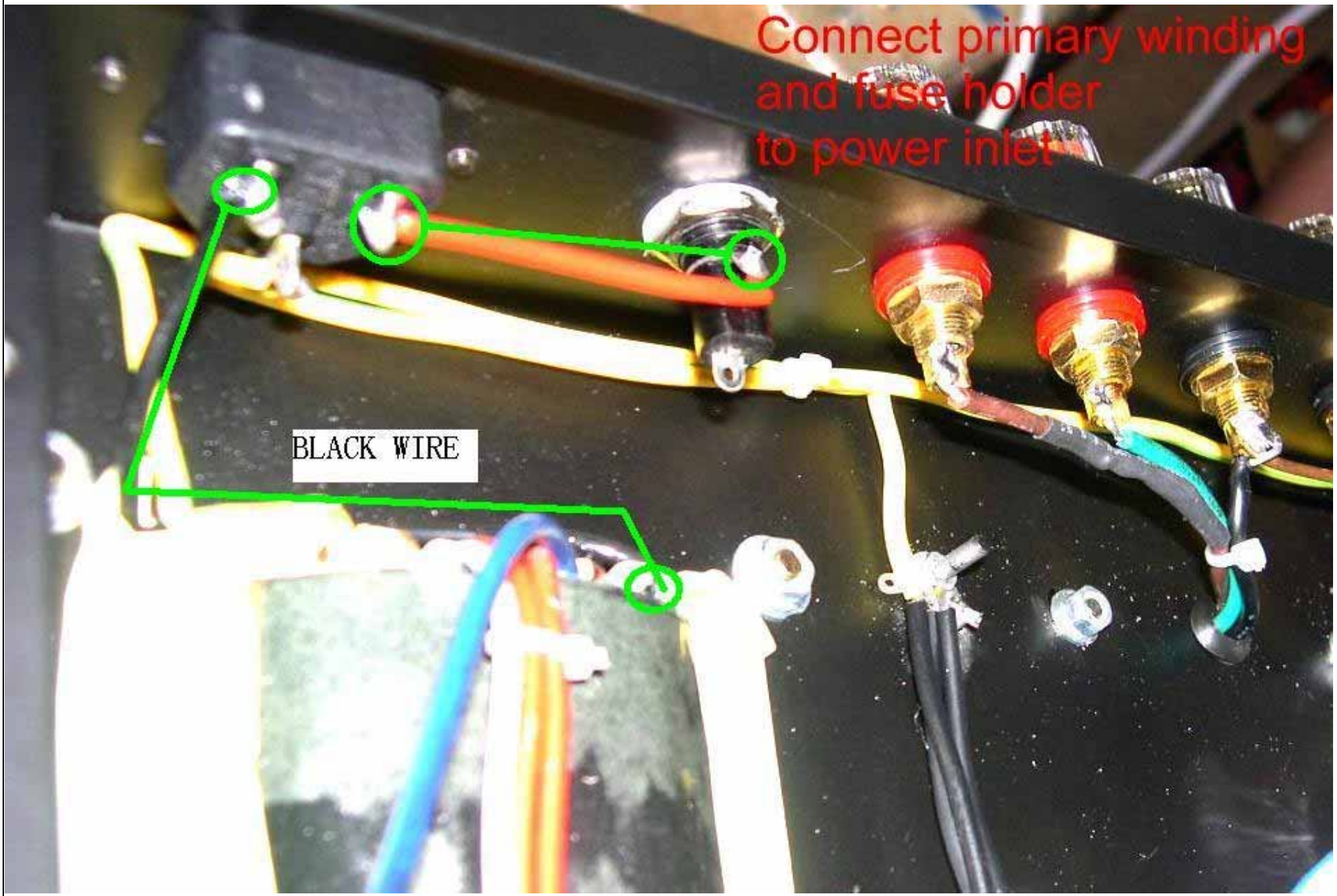
Step 19. Put on the Aluminum face plate, screw it to the front of the metal housing.

Step 20. LED wire harness and connection, see below two images.

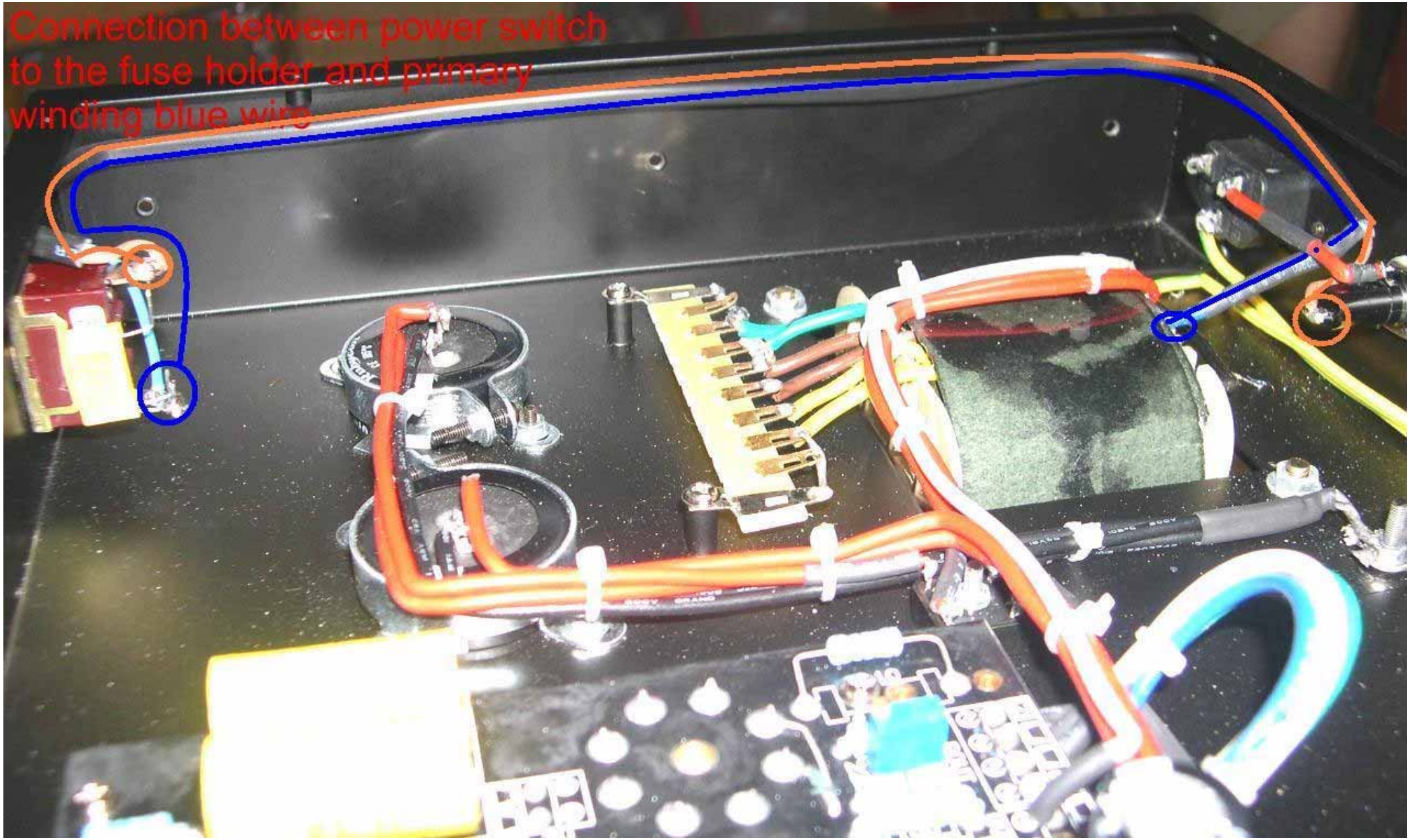
After you heat shrink the plastic tube, please check the LED with a battery to see if it lights up correctly before you use it for next step assembly.


Solder LED wireset
to power transformer
secondary 6.3V winding.
hot melt glue

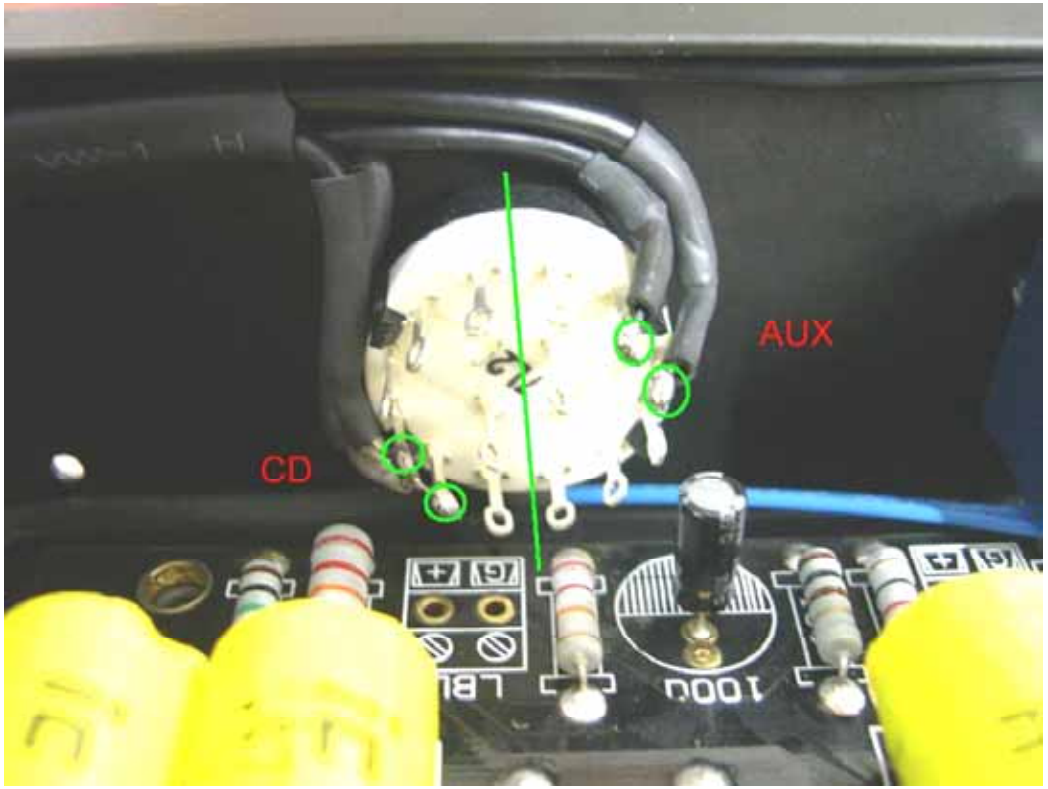
Step 21. Connect primary winding black wire to the power inlet socket and connect the fuse holder to power inlet socket. See below:



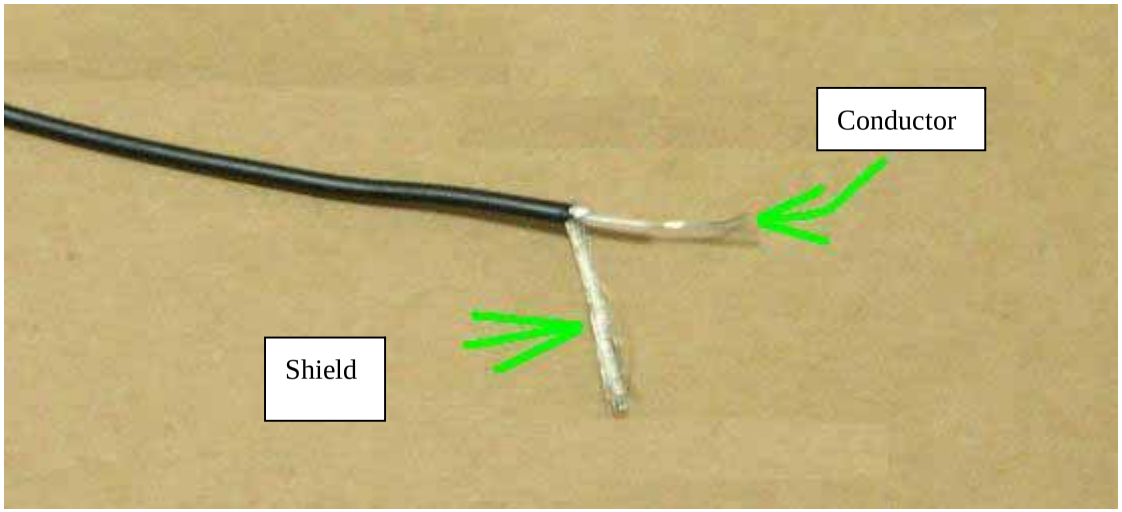
Step 22. Connections between Power Switch and fuse holder & primary winding blue wire; See below:



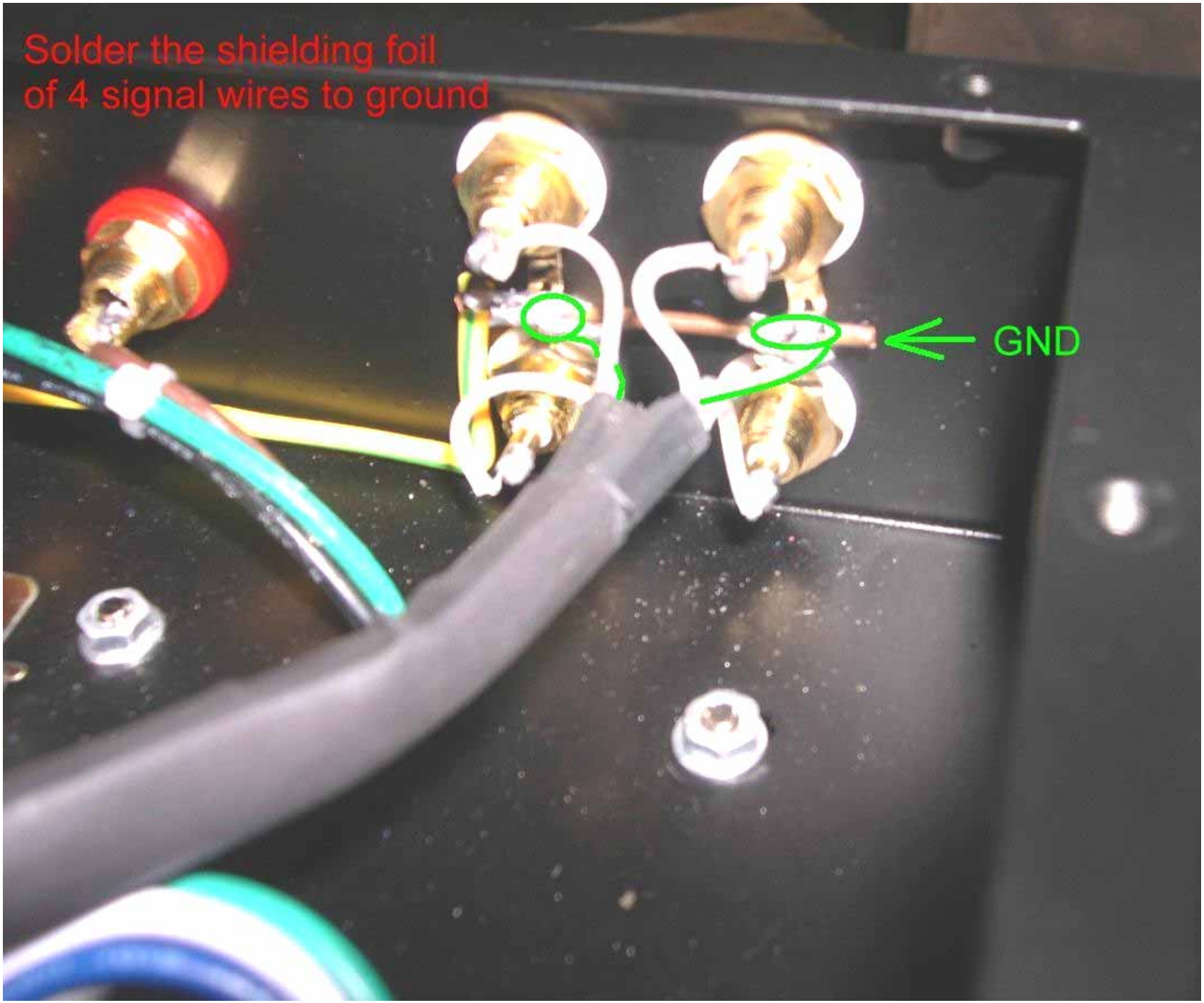
Step 23. Connections between RCA and Selector switch, see below: using 4pcs shielding wires;



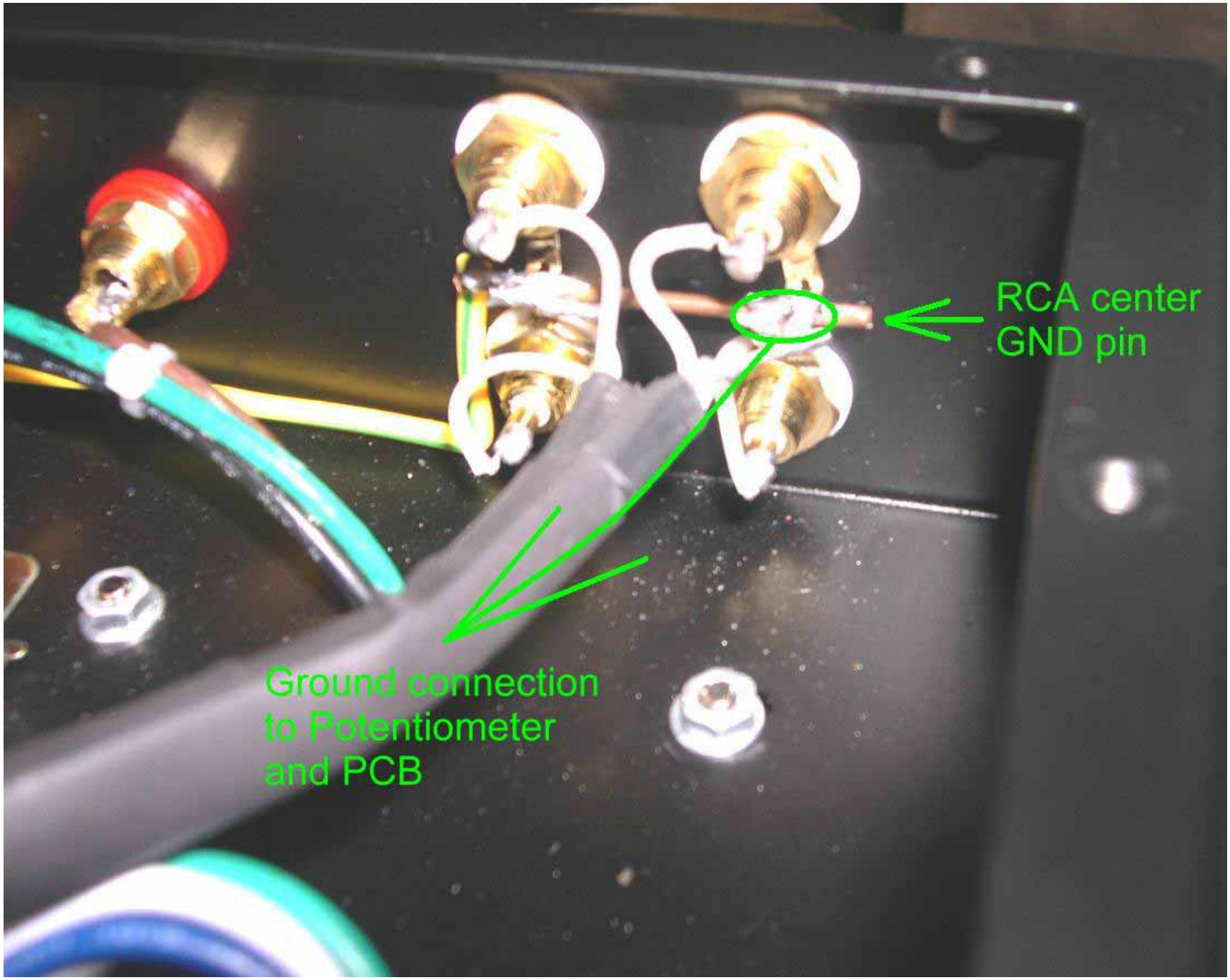
Example of shielding signal wire: conductor should be soldered to RCA connector; while Shield should be soldered to RCA GND pin;

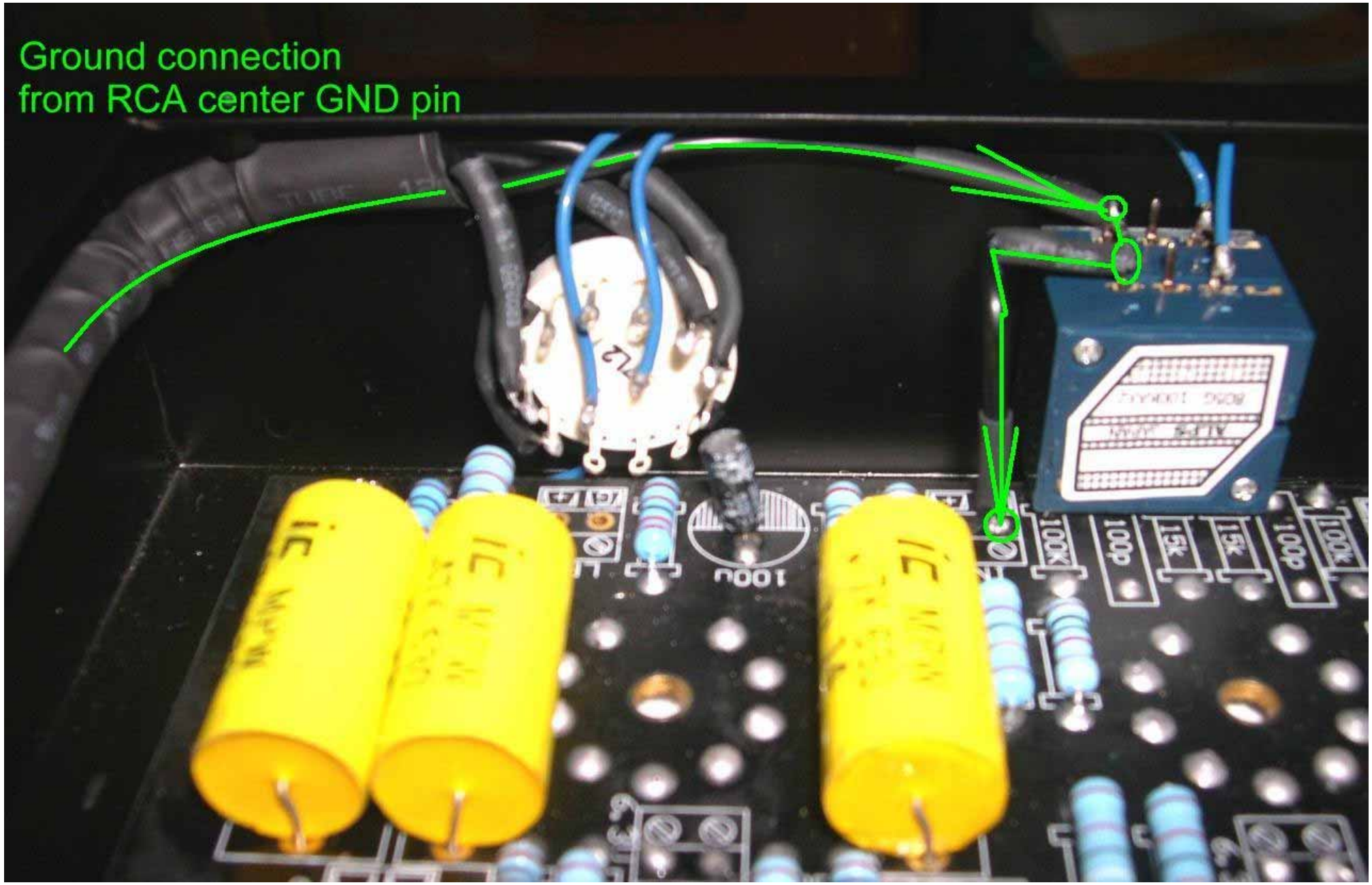


Solder all shielding foil of the 4 signal wires to ground, see below

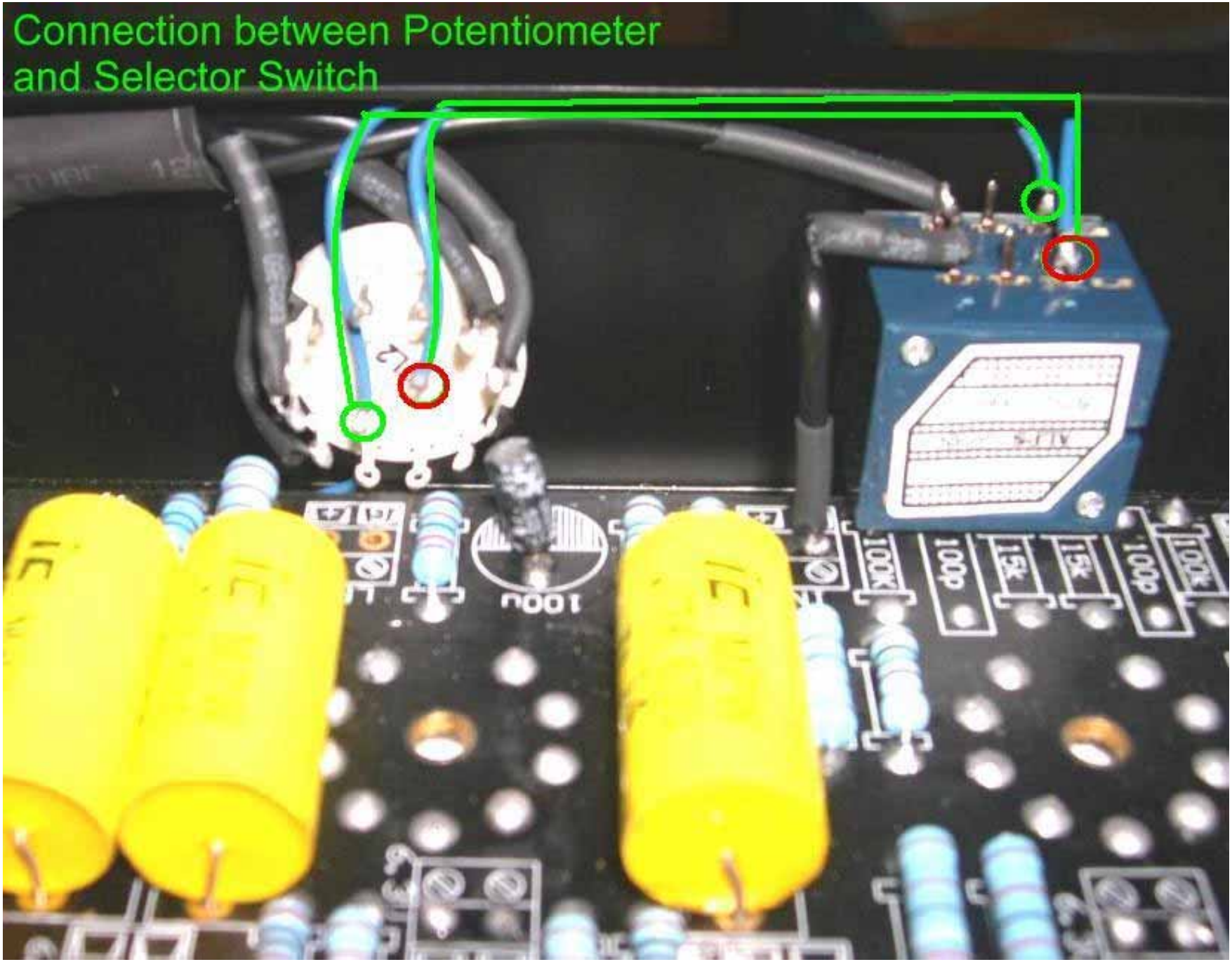


Step 24. Ground connection between the RCA center GND pin to ALPS potentiometer and PCB: using one stranded wire; See below two images:

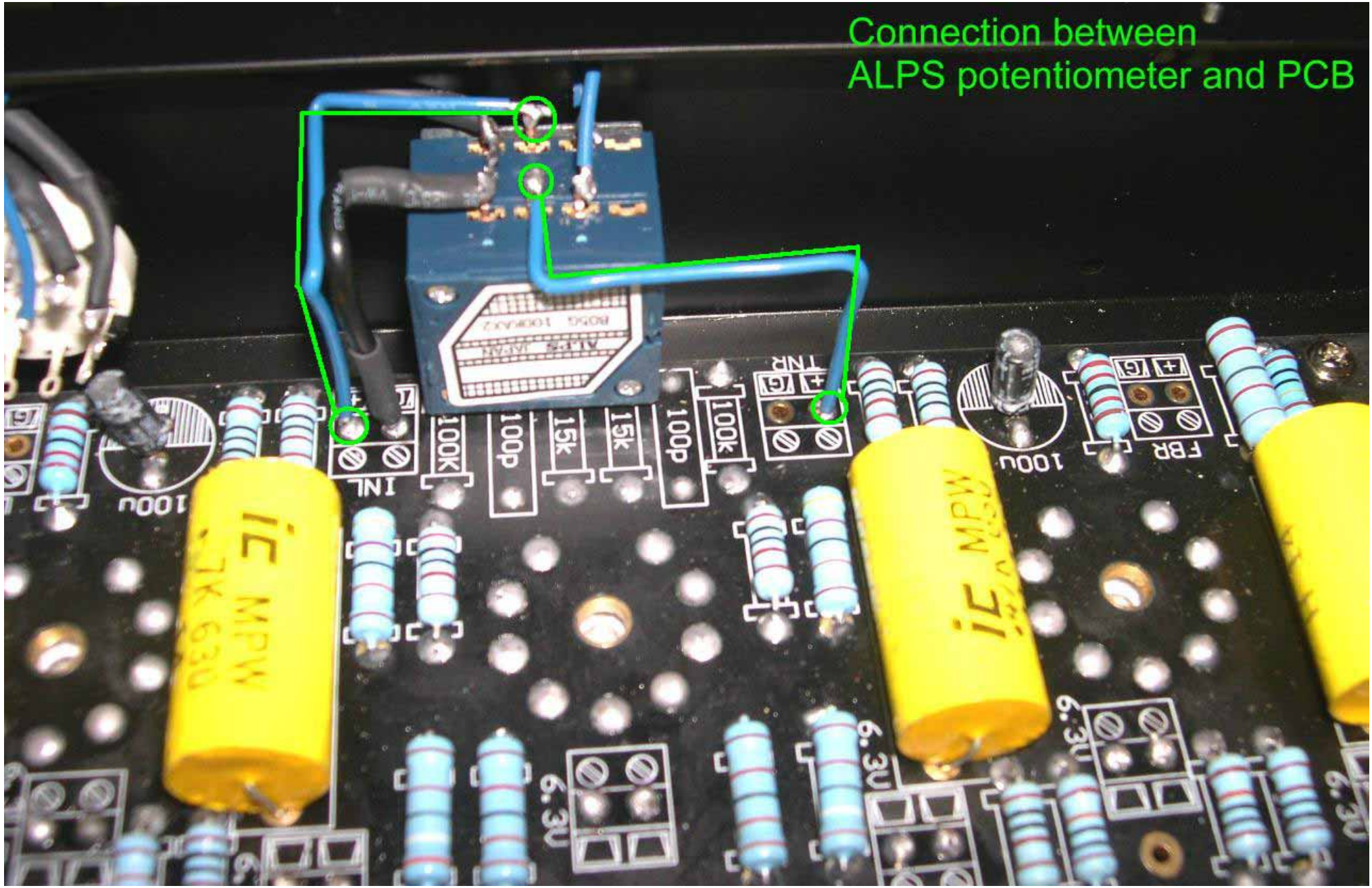



Ground connection
from RCA center GND pin

Step 25. Connection between Potentiometer and Selector Switch, see below picture:

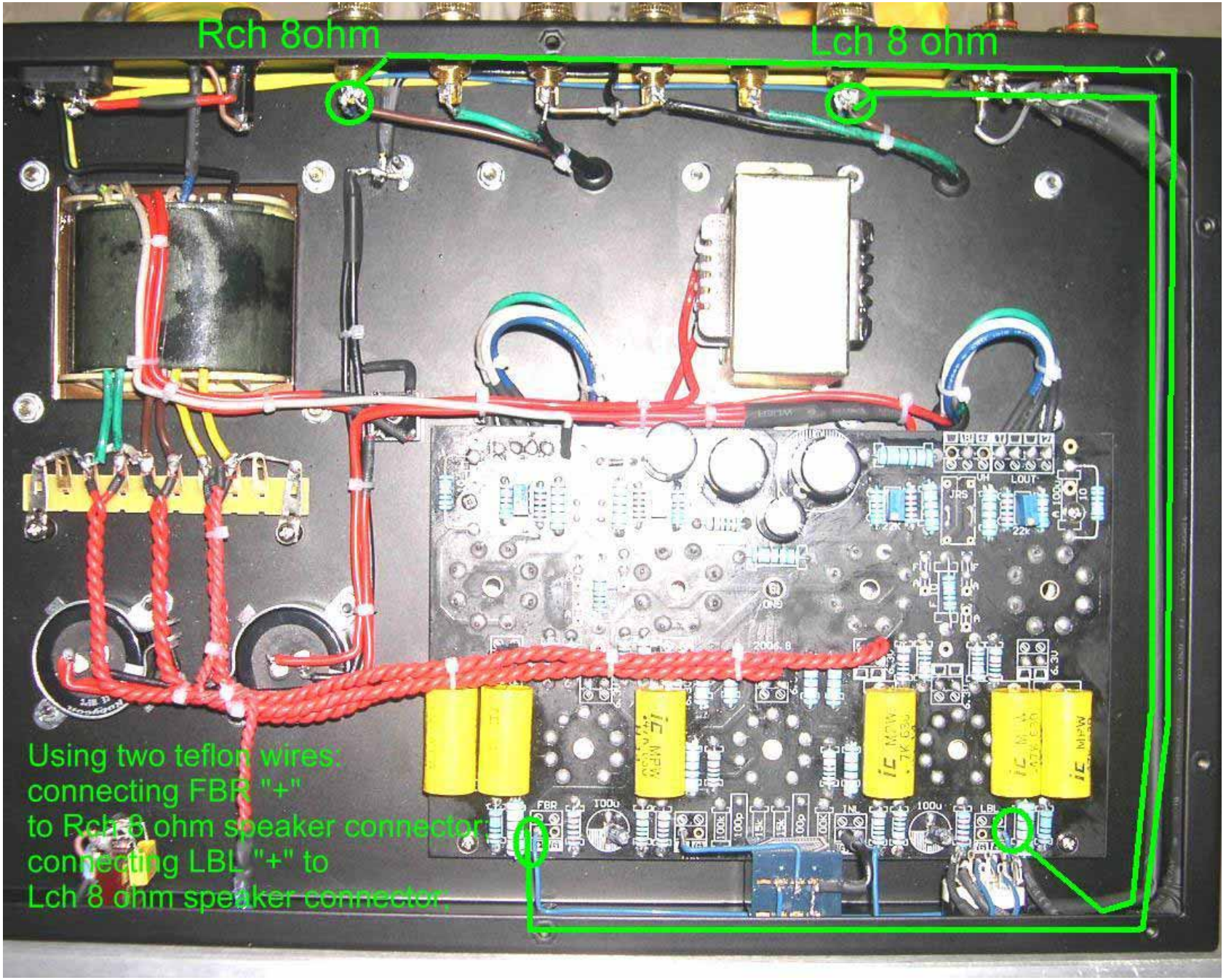


Step 26. Connection between Potentiometer to PCB, see below picture (using Teflon wires)

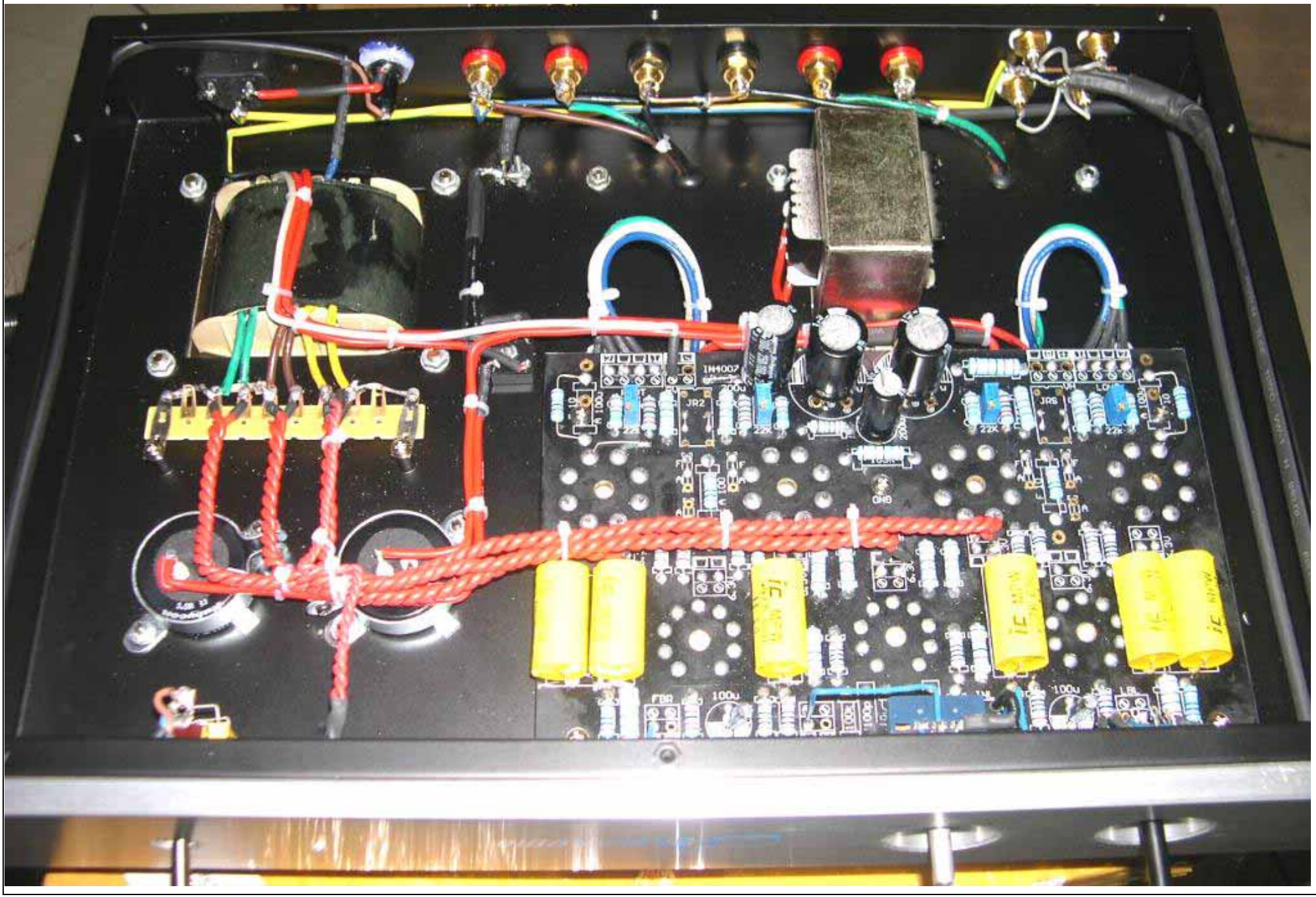


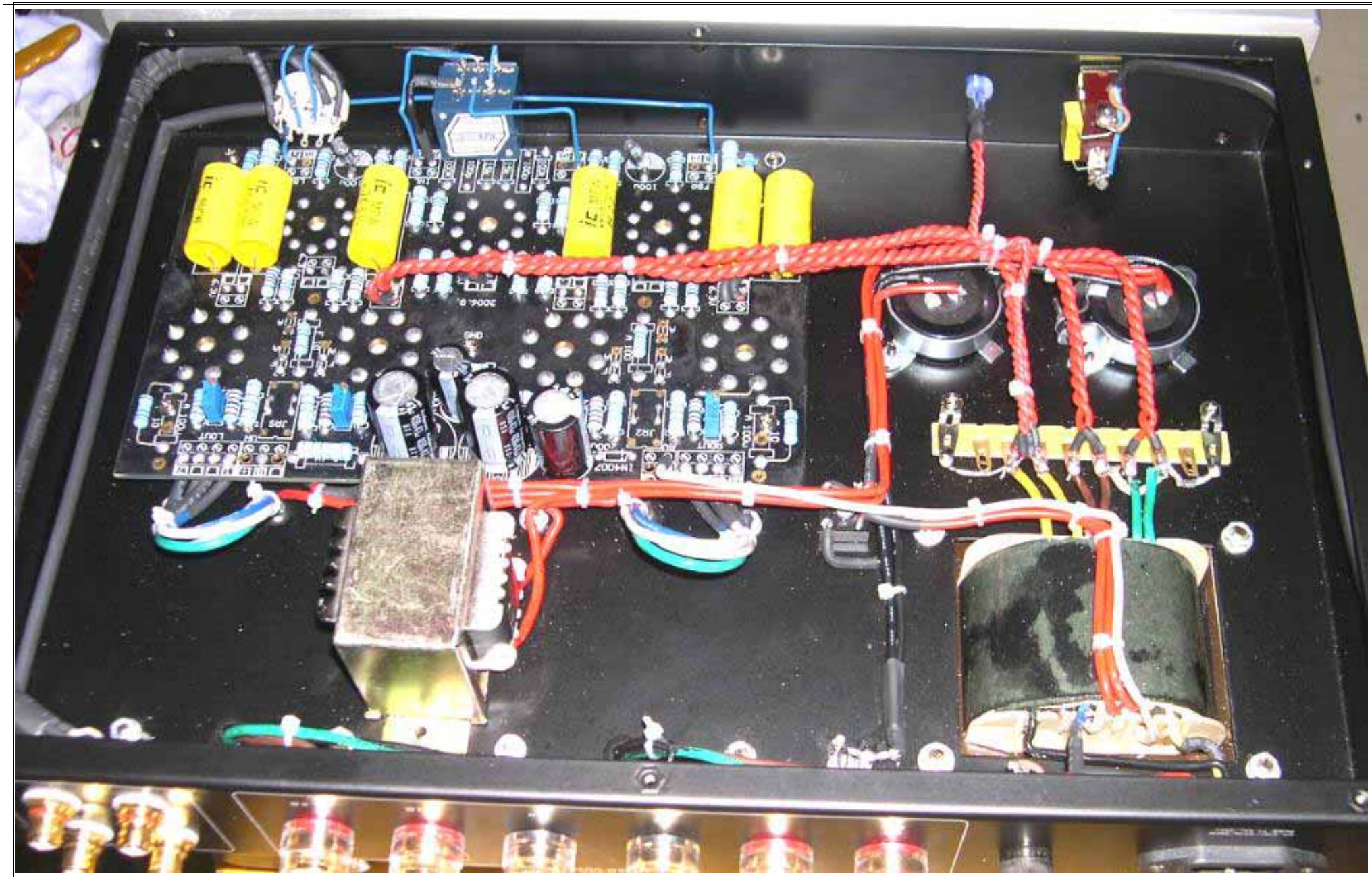
Step 27. Connection between PCB to 8 ohm speaker binding posts:

Using two teflon wires: a. connecting FBR "+" to Rch 8 ohm speaker connector; b. connecting LBL "+" to Lch 8 ohm speaker connector;



Final views of the inside:





Step 28. Put on the aluminum knobs;

Step 29. Cover the amp with a bottom plate.