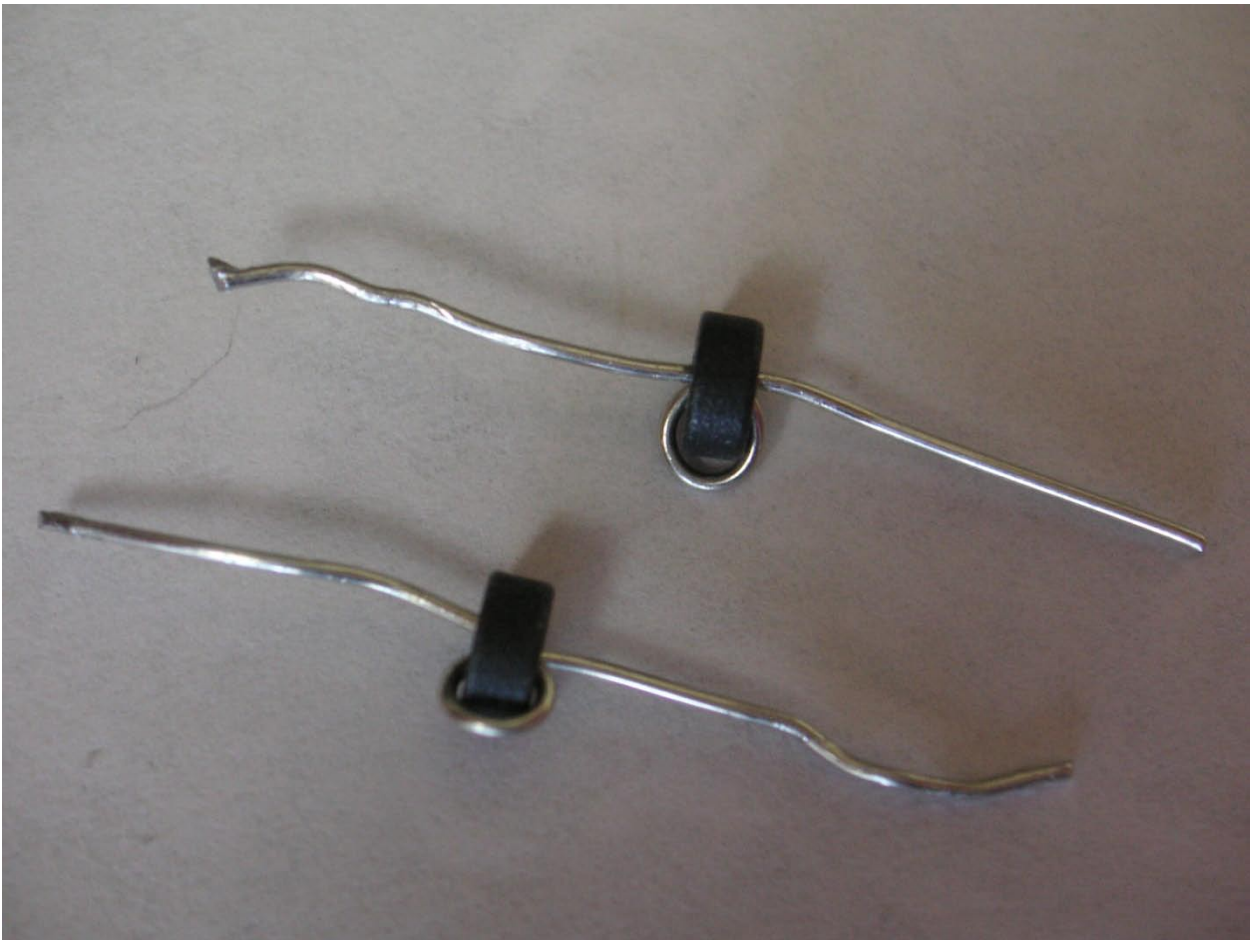


1. Use the bare Printed Circuit Board (PCB) as a template to mark and center punch the aluminum enclosure in four places corresponding to the mounting holes at the four corners of the PCB. Then use a 1/8" drill to drill the 4 mounting holes in the bottom of the enclosure.
2. Sort the resistors using an ohm-meter. An auto-ranging DMM will make this an easy task.



3. Insert and solder the 10 Ω Resistors on the PCB at R5,R6 and R7 (near IC1).
4. Insert and solder the 100 Ω Resistor on the PCB at R18 (near the output transformer).
5. Insert and solder the 150 Ω Resistor on the PCB at R13 (near IC3).
6. Insert and solder the 402 Ω Resistors on the PCB at R8 and R16 (near IC2,IC5).
7. Insert and solder the 2.2k Ω Resistor on the PCB at R14 (between IC3 and IC4).
8. Insert and solder the 2.87k Ω Resistors on the PCB at R9 and R17 (near IC2,IC5).
9. Insert and solder the 4.99k Ω Resistor on the PCB at R15 (near IC4).
10. Insert and solder the 10k Ω Resistors on the PCB at R3 and R4 (near IC1).
11. Insert and solder the 35.7k Ω Resistor on the PCB at R21 and R22 (near the center of the PCB).
12. Insert and solder the 127k Ω Resistor on the PCB at R10 (near IC3).
13. Insert and solder the 200k Ω Resistor on the PCB at R11 (near IC3).
14. Insert and solder 100pf Capacitors on the PCB at C1,C2 and C3 (near the input connector).
15. Insert and solder 100pf Capacitors on the PCB at C9 and C17 (near IC2,IC4)

16. Assemble 2 ferrite beads by wrapping one turn of wire through the beads. Install the beads on the PCB at R1 and R2 (near the input) taking care not to create a short where the wire passes through the beads.



17. Slide a ferrite bead on each diode and install the diodes onto the PCB at D1 and D2 (near the power connector). Take care to align the banded end of each diode (cathode) with the silk screen image on the PCB.
18. Install the 5 IC sockets on the PCB at IC1-IC5. Take care to align the notched end of each socket with the notched end on the silk screened image on the PCB.
19. Install the 0.1uf film capacitor (red Panasonic capacitor) on the PCB at C14 (near the center of PCB)
20. Install the 5 short wire loops at the test points TP01-TP03, TPCOM.
21. Install the remaining 0.1uf capacitors at C2,C4,C5,C8,C10,C11,C13,C16,C18,C19,C20,C24
22. Install the 10nf capacitors at C12,C15 (near IC3)
23. Install the 150uf electrolytic capacitors at C22 and C23 (near center of PCB) Take care to match the polarity of the capacitor to the silk screen image.
24. Install the 15uf electrolytic capacitors at C6 and C7 (near IC1) Take care to match the polarity. Note: for PCB V0.9.2 the polarity of C7 is printed wrong on the PCB. Make sure that the + lead of C7 is connected to the ground plane of the PCB. The – lead of the capacitor is connected to the V- supply.

25. Install the LED's at V+ and V- (near center of PCB). Take care to align the flat on the rim of the LED to the image on the PCB.
26. Install the 200k trim pot (marked W204) at R23 (near IC3).
27. Install the 20K trim pot (marked W203) at R12 (near IC4).
28. Assemble the CMF Ferrite Ring by twisting two #24 wires together and winding them 5-8 times through the Ring. Install to the PCB at L2 (near input).



29. Install the small Audio Transformer at TR1 (lower right corner of PCB). Note: the side of the transformer marked with a "P" is used as the secondary and should be connected to TP01, TP02 and the output connector.
30. Install the 3 pole terminal blocks at the Input, Output and Power connectors.

