Clarion

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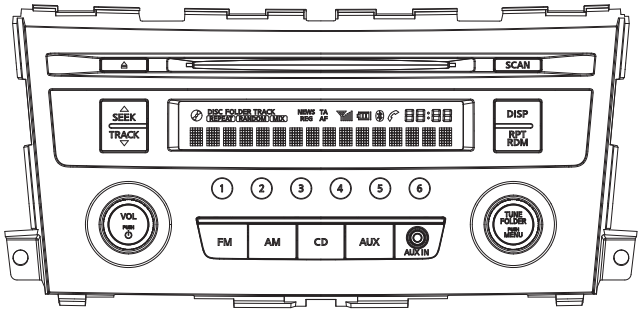
Service Manual



NISSAN MOTOR GENUINE
FM/AM RADIO TUNER
1CD PLAYER (FOR U.S.A.)

Model **PN-3378I-E**
(Genuine Part Number 28185 9HR0A)

Model	Genuine No.	Escutcheon	Manual No.
PN-3378I-A	28185 3TA0A	Black gloss	E7208-00
PN-3378I-B	28185 3TA0G	Black gloss	E7315-00
PN-3378I-C	28185 3TA0G	Black gloss	E7531-00
PN-3378I-D	28185 3TB0G	Black gloss	E7531-00
PN-3378I-E	28185 9HR0A	Black	E7752-00

LF

This product is a lead free model.
Lead free solder is used in PWB stamped LF mark.
Please keep the following conditions when you repair.

1. Use lead free solder.
   * Koki's lead free solder S3X-55M 0.6mm
     (CLARION Parts No.642-0231-01)
   * Koki's lead free solder S3X-55M 1.0mm
     (CLARION Parts No.642-0231-02)
2. Use a nitrogen solder system.
3. Do not use "General solder" and "Lead free solder" together.

REFERENCE SERVICE MANUAL

1CD Mechanism Module : 929-5150-81

Mechanism Module No.	Manual No.
929-5150-81	E7172-00

NOTES

* This product includes technology owned by Microsoft Corporation and cannot be used or distributed without a license from MSLGP.
* Specification and design are subject to change without notice for further improvement.
*

COMPONENTS

PN-3378I-E

1. MAIN UNIT ---------- 1

To engineers in charge of repair or inspection of our products.

Before repair or inspection, make sure to follow the instructions so that customers and Engineers in charge of repair or inspection can avoid suffering any risk or injury.

1. Use specified parts.
   The system uses parts with special safety features against fire and voltage. Use only parts with equivalent characteristics when replacing them.
   The use of unspecified parts shall be regarded as remodeling for which we shall not be liable. The onus of product liability (PL) shall not be our responsibility in cases where an accident or failure is as a result of unspecified parts being used.
2. Place the parts and wiring back in their original positions after replacement or re-wiring.
   For proper circuit construction, use of insulation tubes, bonding, gaps to PWB, etc, is involved. The wiring connection and routing to the PWB are specially planned using clamps to keep away from heated and high voltage parts. Ensure that they are placed back in their original positions after repair or inspection.
   If extended damage is caused due to negligence during repair, the legal responsibility shall be with the repairing company.
3. Check for safety after repair.
   Check that the screws, parts and wires are put back securely in their original position after repair. Ensure for safety reasons that there is no possibility of secondary problems around the repaired spots.
   If extended damage is caused due to negligence of repair, the legal responsibility shall be with the repairing company.
4. Cautions in removal and making wiring connection to the parts for the automobile
   Disconnect the battery terminal after turning the ignition key off. If wrong wiring connections are made with the battery connected, a short circuit and/or fire may occur. If extensive damage is caused due to negligence of repair, the legal responsibility shall be with the repairing company.
5. Cautions in soldering
   Please do not spread liquid flux in soldering.
   Please do not wash the soldering point after soldering.
6. Cautions in soldering of chip capacitors
   Please solder the chip capacitors after pre-heating for replacement because they are very weak to heat.
   Please do not heat the chip capacitors with a soldering iron directly.
7. Cautions in handling of chip parts
   Do not reuse removed chips even when no abnormality is observed in their appearance. Always replace them with new ones. (The chip parts include resistors, capacitors, diodes, transistors, etc).
   Please make an operation test after replacement.
8. Cautions in handling flexible PWB
   Before working with a soldering iron, make sure that the iron tip temperature is around 270°C. Take care not to apply the iron tip repeatedly (more than three times) to the same patterns. Also take care not to apply the tip with force.
9. Turn the unit OFF during disassembly and parts replacement. Recheck all work before you apply power to the unit.
10. Cautions in checking that the optical pickup lights up.
    The laser is focused on the disc reflection surface through the lens of the optical pickup. When checking that the laser optical diode lights up, keep your eyes more than 30 cms away from the lens. Prolonged viewing of the laser within 30 cms may damage your eyesight.
11. Cautions in handling the optical pickup
    The laser diode of the optical pickup can be damaged by electrostatic charge caused by your clothes and body. Make sure to avoid electrostatic charges on your clothes or body, or discharge static electricity before handling the optical pickup.

11-1. Laser diode
   The laser diode terminals are shorted for transportation in order to prevent electrostatic damage. After replacement, open the shorted circuit. When removing the pickup from the mechanism, short the terminals by soldering them to prevent this damage.

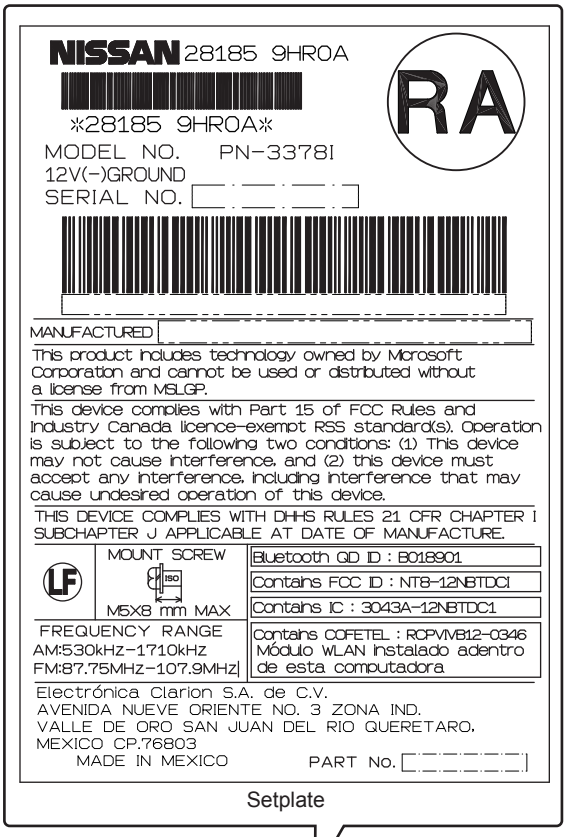
11-2. Actuator
   The actuator has a powerful magnetic circuit. If a magnetic material is put close to it, its characteristics will change. Ensure that no foreign substances enter through the ventilation slots in the cover.

11-3. Cleaning the lens
   Dust on the optical lens affects performance.
   To clean the lens, apply a small amount of isopropyl alcohol to lens paper and wipe the lens gently.

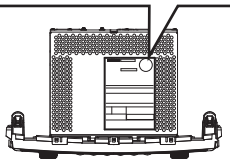
PRECAUTIONS

FCC CAUTION

Changes or modifications not expressly approved by the party responsible for compliance could void the user's authority to operate the equipment.



Setplate



Top view of unit

SPECIFICATIONS

FM Tuner

Frequency range: 87.75MHz to 107.9MHz
(AUTO 200KHz STEP,MANU 200KHz STEP)
Quieting sens.: Less than 15dBuV
(at 87.9 / 98.1 / 107.9MHz, S/N=30dB)
Stereo separation: More than 22 +/-5dB
(98.1MHz, ANT.IN 65dBuV, 1KHz)
More than 10 +/-5dB
(98.1MHz, ANT.IN 65dBuV, 7KHz)
SASC sens. 37 +/- 5dBuV
(at 98.1M Hz, MOD.7KHz, ANT.IN 65dBuV
-1dB POINT)
Auto stop sens.: DX 32 +/- 6dBuV
(at 87.9 / 98.1 / 107.9MHz)
S/N: More than 47dB
(at 87.9 / 98.1 / 107.9MHz,
ANT.IN 55dBuV, 0dB=1.0V)
Noise level -20dBuV IN: -10 +/- 3dB
(at 98.1MHz, ANT.IN 55dBuV → -20dBuV)

AM Tuner

Frequency range: 530KHz to 1710KHz
(AUTO 10KHz STEP,MANU 10KHz STEP)
Quieting sens.: Less than 37dBuV
(at 600 / 1000 / 1400KHz, S/N=20dB)
Auto stop sens.: DX 44 +/- 6dBuV
(at 600 / 1000 / 1400KHz)
S/N: More than 40dB
(at 600 / 1000 / 1400KHz,
ANT.IN 74dBuV, 0dB=1.0V)

CD Player

Distortion: Less than 0.2%
(1KHz 5TRACK 20KHz LPF)
S/N: More than 74dB
(1KHz 2TRACK → - ∞ 8TRACK
20KHz LPF, JIS-A)
Separation: More than 50dB
(1KHz 9TRACK/11TRACK 20KHz LPF)
* TEST DISC; TCD-782/SCD-5606

General

Backup current: Less than 1mA
(13.2V, 30 seconds after ACC OFF)
Clock accuracy: Within 0+/-1 sec. (DAY)
Weight: 1800g

Test conditions

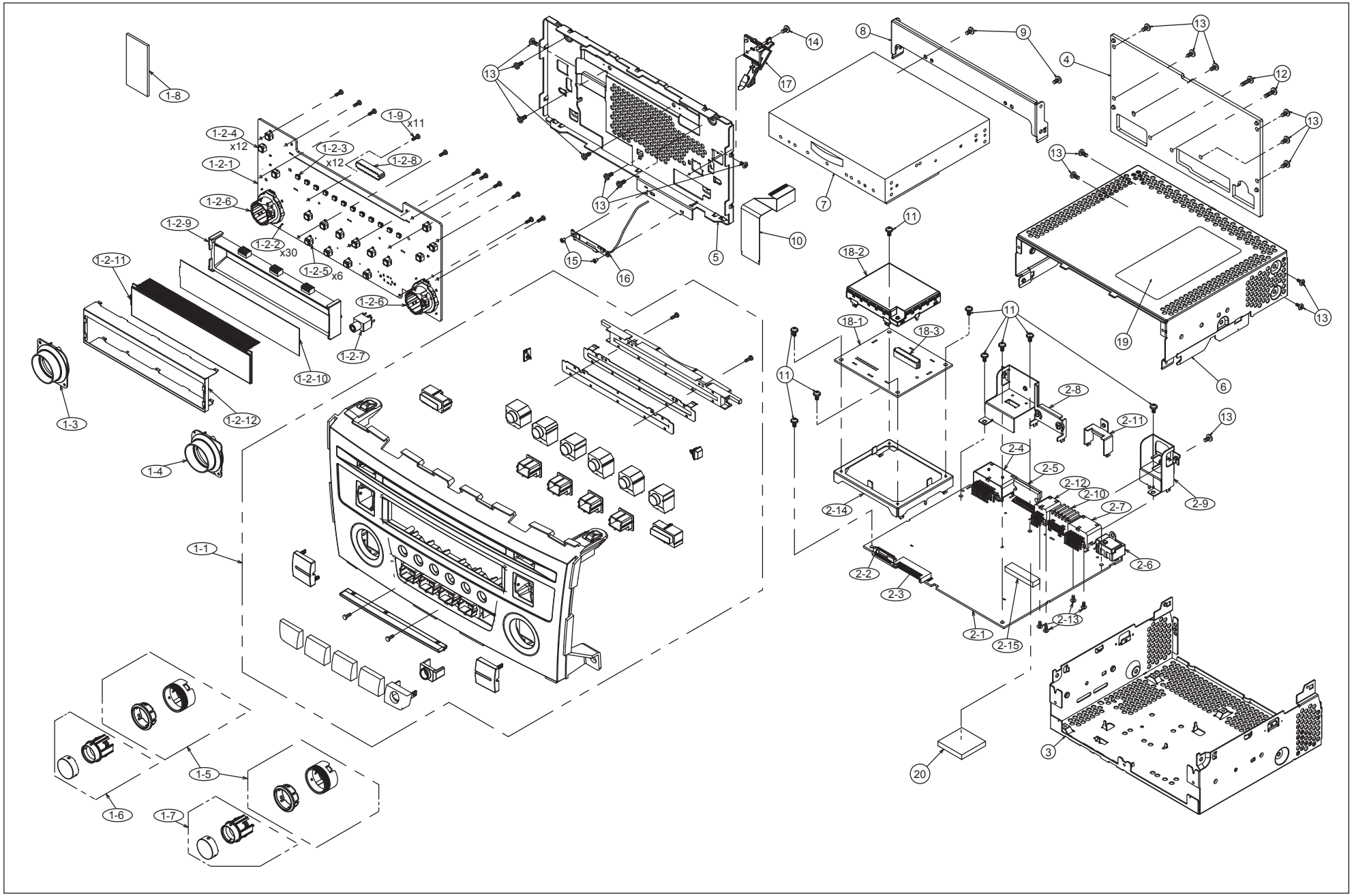
Power supply voltage: 13.2V DC, negative ground
Load resistance: 2 ohm
Tone, Bass/Treb position: CENTER
Balance position: CENTER
Fader position: CENTER
* For details, please refer to the design specifications.

EXPLODED VIEW / PARTS LIST

[Parts list]

NO.	PART NO.	DESCRIPTION	Q'TY
1	----------	*Unused number	-
1-1	940-8624-03	ESCUTCHEON-ASSY	1
1-2	----------	*Unused number	-
1-2-1	----------	SW PWB(379700-039)	1
1-2-2	001-7109-90	DIODE	30
1-2-3	001-7148-90	LED	12
1-2-4	013-6202-52	TACT SWITCH	12
1-2-5	013-6201-53	SWITCH	6
1-2-6	016-7006-00	ROTARY ENCODER	2
1-2-7	075-0395-01	JACK	1
1-2-8	074-3055-26	OUTLET SOCKET	1
1-2-9	335-9150-00	LCD HOLDER	1
1-2-10	335-9151-00	LCD REFLECTOR	1
1-2-11	379-1462-53	LCD	1
1-2-12	331-5137-00	LCD COVER	1
1-3	335-9147-00	ILLUMI RING(L)	1
1-4	335-9148-00	ILLUMI RING(R)	1
1-5	947-0835-00	KNOB-ASSY	2
1-6	947-0788-02	ASSY-PART(VOL)	1
1-7	947-0789-02	ASSY-PART(TUNE)	1
1-8	345-8090-00	CUSHION RUBBER	1
1-9	716-0778-52	SPECIAL SCREW	11
2	----------	*Unused number	-
2-1	----------	MAIN PWB(386901-039)	1
2-2	074-2260-88	OUTLET SOCKET	1
2-3	076-3011-76	PLUG	1
2-4	074-4009-20	OUTLET SOCKET	1
2-5	051-2067-00	IC	1
2-6	092-2210-01	ANT-RECEPT	1
2-7	074-1302-16	OUTLET SOCKET	1
2-8	331-5153-00	SOCKET HOLDER	1
2-9	331-4676-00	ANT-HOLDER	1
2-10	----------	*Not mounted(OUTLET SOCKET)	-
2-11	----------	*Not mounted(SOCKET HOLDER)	-
2-12	074-1302-08	OUTLET SOCKET	1
2-13	778-3006-00	TAP-SCREW	4
2-14	331-5269-00	BT-BRKT	1
2-15	076-3060-26	PLUG	1
3	311-1993-00	LOWER CASE	1
4	313-2070-20	HEAT SINK	1
5	309-1948-00	ES PLATE	1
6	310-1916-00	UPPER CASE	1
7	929-5150-81	CD-MECH-MODULE	1
8	331-5138-00	CD BRKT	1
9	714-2603-89	MACHINE SCREW	2
10	816-3064-05	FLAT WIRE	1
11	716-0878-50	SPECIAL SCREW	9
12	735-2614-1B	D-SEMS SCREW	2
13	714-2606-8B	MACHINE SCREW	17
14	716-3718-00	SPECIAL SCREW	1
15	716-1468-01	SPECIAL SCREW	2
16	060-8122-10	BLUETOOTH-ANT	1
17	335-9220-00	ANT-GUIDE	1
18	----------	*Unused number	-
18-1	----------	CONNECTOR-PWB(388800-039)	1
18-2	060-8141-01	BT MODULE	1
18-3	074-3055-26	OUTLET SOCKET	1
19	276-1158-03	SETPLATE	1
20	345-6653-00	RUBBER SHEET	1

[Exploded view]



ELECTRICAL PARTS LIST

MAIN PWB(B1) section

* Neither the part numbers of parts on which software is written, nor part numbers of parts for which replacement is prohibited in the production process are listed in the parts list.

REF NO.	PART NO.	DESCRIPTION
C101	168-2222-55	2200pF K
C122	166-1201-50	12pF CH
C128	045-2201-50	22pFJ CH
C129	046-1022-58	50V 1000pF
C130	046-1022-58	50V 1000pF
C131	045-3901-50	39pFJ CH
C132	045-1211-50	120pFJ CH
C133	045-4796-50	4.7pFJ CH
C134	045-1501-50	15pFJ CH
C135	045-2211-50	220pFJ CH
C136	046-3922-58	3900pF K B
C137	046-1022-58	50V 1000pF
C138	046-1032-78	0.01uF K B
C139	046-1032-78	0.01uF K B
C141	046-3322-58	3300pF K B
C142	046-2232-78	0.022uF K B
C143	046-1022-58	50V 1000pF
C144	046-2232-78	0.022uF K B
C145	046-2232-78	0.022uF K B
C146	046-2232-78	0.022uF K B
C147	046-2232-78	0.022uF K B
C148	043-0562-90	10V 0.22uF
C149	046-2232-78	0.022uF K B
C150	043-0563-90	16V 47uF
C161	043-0604-90	25V 10uF B
C162	046-1042-78	0.1uF K B
C202	046-2222-58	2200pF K B
C203	046-1042-78	0.1uF K B
C204	046-2222-58	2200pF K B
C206	165-3363-25	10V 33uF
C219	168-4722-55	4700pF K
C220	168-1022-55	1000pF K
C221	168-1022-55	1000pF K
C301	043-0570-90	16V 2.2uF K
C302	043-0570-90	16V 2.2uF K
C303	043-0570-90	16V 2.2uF K
C304	043-0570-90	16V 2.2uF K
C305	045-2201-50	22pFJ CH
C306	045-2201-50	22pFJ CH
C309	046-1042-78	0.1uF K B
C310	168-1052-78	16V 1uF K
C312	046-1042-78	0.1uF K B
C314	045-2201-50	22pFJ CH
C315	045-2201-50	22pFJ CH
C316	046-1042-78	0.1uF K B
C317	046-1042-78	0.1uF K B
C318	046-1042-78	0.1uF K B
C319	046-1042-78	0.1uF K B
C320	043-0570-90	16V 2.2uF K
C321	043-0570-90	16V 2.2uF K
C322	168-4752-98	4.7uF K
C323	168-4752-98	4.7uF K
C324	046-1042-78	0.1uF K B
C325	046-1042-78	0.1uF K B
C326	046-1042-78	0.1uF K B
C327	046-1042-78	0.1uF K B
C328	046-1042-78	0.1uF K B
C329	045-1007-50	10 +/-0.5pF CH
C330	045-1007-50	10 +/-0.5pF CH
C331	046-1042-78	0.1uF K B
C333	168-4752-98	4.7uF K
C335	046-1042-78	0.1uF K B
C336	046-1042-78	0.1uF K B
C337	046-1042-78	0.1uF K B
C338	042-4033-90	6.3V 220uF
C339	046-1042-78	0.1uF K B
C340	168-4752-98	4.7uF K
C341	045-2201-50	22pFJ CH
C342	046-1042-78	0.1uF K B
C345	046-1042-78	0.1uF K B
C347	168-1052-78	16V 1uF K
C348	046-1042-78	0.1uF K B
C349	046-1042-78	0.1uF K B
C350	046-1042-78	0.1uF K B
C351	046-1042-78	0.1uF K B
C352	043-0552-90	6.3V 47uF M
C353	043-0559-90	6.3V 22uF
C354	168-1052-78	16V 1uF K
C355	046-1042-78	0.1uF K B
C356	046-1042-78	0.1uF K B
C357	046-1042-78	0.1uF K B
C358	045-2201-50	22pFJ CH
C360	046-1042-78	0.1uF K B
C361	046-1042-78	0.1uF K B
C362	046-1042-78	0.1uF K B
C364	046-1042-78	0.1uF K B
C365	045-4711-50	470pFJ CH
C366	046-1022-58	50V 1000pF
C367	046-1042-78	0.1uF K B
C368	046-3322-58	3300pF K B
C369	046-3322-58	3300pF K B
C370	042-4033-90	6.3V 220uF
C371	046-3322-58	3300pF K B
C372	046-3322-58	3300pF K B
C373	046-1042-78	0.1uF K B
C375	046-3322-58	3300pF K B
C376	046-3322-58	3300pF K B
C377	046-1522-58	1500pF K B
C378	046-1522-58	1500pF K B
C379	046-1522-58	1500pF K B
C380	046-1522-58	1500pF K B
C381	043-0559-90	6.3V 22uF
C382	178-1052-78	25V 1uF
C383	178-1052-78	25V 1uF
C386	178-1052-78	25V 1uF
C387	178-1052-78	25V 1uF
C401	046-1042-78	0.1uF K B
C402	046-1042-78	0.1uF K B
C403	166-2201-50	22pF CH
C404	166-2201-50	22pF CH
C405	168-4722-55	4700pF K
C406	168-2242-58	0.22uF K
C407	168-4752-98	4.7uF K
C408	004-1580-14	45pF
C410	046-1042-78	0.1uF K B
C411	165-4763-15	6.3V 47uF
C412	045-2701-50	27pFJ CH
C413	046-1042-78	0.1uF K B
C414	046-1032-78	0.01uF K B
C415	046-1022-58	50V 1000pF
C416	046-1022-58	50V 1000pF
C417	046-1022-58	50V 1000pF
C418	042-2273-25	10V 220uF M
C419	042-2273-25	10V 220uF M
C420	045-1011-50	100pFJ CH
C517	168-1542-58	0.15uF K
C518	168-1542-58	0.15uF K
C519	168-1542-58	0.15uF K
C520	168-1542-58	0.15uF K
C521	168-1542-58	0.15uF K
C522	168-1542-58	0.15uF K
C523	168-1542-58	0.15uF K
C524	168-1542-58	0.15uF K
C525	168-1052-78	16V 1uF K
C526	042-1760-90	16V 10uF M
C527	178-2742-78	0.27uF
C528	168-1052-78	16V 1uF K
C530	043-0574-90	25V 1.0uF
C532	168-1832-55	0.018uF K
C533	043-5600-90	0.10uF
C534	042-1717-00	16V 3300uF
C535	168-6822-55	6800pF K
C536	168-6822-55	6800pF K
C537	168-6822-55	6800pF K
C538	168-6822-55	6800pF K
C539	168-6822-55	6800pF K
C540	168-6822-55	6800pF K
C541	168-6822-55	6800pF K
C542	168-6822-55	6800pF K
C543	168-1042-78	16V 0.1uF K
C544	168-2232-55	0.022uF K
C545	043-0604-90	25V 10uF B
C546	046-1022-58	50V 1000pF
C547	043-7503-90	4.7uF
C548	043-6400-90	16V 4.7uF K
C553	043-0603-90	16V 10uF
C554	043-0603-90	16V 10uF
C555	046-1042-78	0.1uF K B
C556	043-0552-90	6.3V 47uF M
C557	043-6400-90	16V 4.7uF K
C558	043-0570-90	16V 2.2uF K
C559	043-0570-90	16V 2.2uF K
C562	046-1022-58	50V 1000pF
C564	168-4752-98	4.7uF K
C565	043-0603-90	16V 10uF
C568	046-1022-58	50V 1000pF
C569	043-7503-90	4.7uF
C570	043-6400-90	16V 4.7uF K
C571	043-0604-90	25V 10uF B
C572	043-7701-90	2.2uF
C574	045-4701-50	47pF CH
C575	168-4742-78	0.47uF K
C576	168-1042-38	50V 0.1uF K
C577	046-1522-58	1500pF K B
C578	045-2201-50	22pFJ CH
C579	178-2242-38	0.22uF B
C580	042-4000-90	16V 470uF
C581	165-4763-35	16V 47uF
C601	ADZ0184	16V 330uF
C602	045-2201-50	22pFJ CH
C606	046-1042-78	0.1uF K B
C607	043-4306-90	1uF
C620	043-6400-90	16V 4.7uF K
C621	043-7503-90	4.7uF
C622	043-4306-90	1uF
C623	045-2201-50	22pFJ CH
C626	046-1022-58	50V 1000pF
D104	001-9013-90	BA891
D105	001-0580-90	1SS352
D106	001-9013-90	BA891
D401	001-2630-90	1SS420-TPL3,F
D501	001-2412-90	RR264M-400
D502	001-0580-90	1SS352
D503	001-2412-90	RR264M-400
D504	001-2412-90	RR264M-400
D505	001-2639-90	RSX201L-30
D506	001-2628-90	RB160M-40
IC101	----------	TEF7000 (Tuner) (Thermal pad) (402590-051)
IC301	051-3034-90	NJM4558V
IC302	----------	SAF7741HV/ N125(DSP) (Thermal pad) (674700-051)
IC303	051-7106-90	CD4052B-PWR
IC401	----------	S-24C16CI-T8T5U3 (E2P-ROM) (Software should be written on production) (942650-051)

REF NO.	PART NO.	DESCRIPTION
IC402	----------	R5F64177PFB
		(Micro computer)
		(Software should be
		written on
		production)
		(033320-052)
IC403	051-6647-80	TJA1051T,118
IC404	051-5481-90	S-1009N30I-
		M5T1U
IC502	051-2067-00	TB2946HQ
IC504	051-5443-08	BD4850G-TR
IC505	----------	BD00C0AWFP
		(Voltage regulator)
		(Thermal pad)
		(358290-051)
IC507	051-3034-90	NJM4558V
IC508	051-3579-90	S1112B15MCL6
		ATFG
IC509	051-3708-90	S-1112B33MC-
		L6STFG
IC511	----------	BD00C0AWFP
		(Voltage regulator)
		(Thermal pad)
		(358290-051)
IC513	----------	BD00D0AWHFP-
		TR
		(Voltage regulator)
		(Thermal pad)
		(370990-051)
IC514	----------	LT3481EDD
		#TRPBF
		(SW-REGULATOR)
		(thermal pad)
		(361280-051)
IC601	051-3716-91	NJM2865F05
		(TE1)
IC604	051-3034-90	NJM4558V
IC605	----------	BD00D0AWHFP
		-TR
		(Voltage regulator)
		(Thermal pad)
		(370990-051)
J201	074-2260-88	38P
J203	074-1302-16	16P
J204	074-1302-08	8P
J501	074-4009-20	20P
L110	010-3062-54	290nH
L111	010-3406-56	3.3uH J
L112	010-3062-56	0.5uH
L113	010-3062-53	0.215uH
L114	010-3439-51	1.8uH
L115	010-2290-52	330uH
L116	010-2290-52	330uH
L117	010-3104-54	600 ohm/100MHz
L301	010-3104-54	600 ohm/100MHz
L302	010-3104-54	600 ohm/100MHz
L303	010-3104-54	600 ohm/100MHz
L304	010-3104-54	600 ohm/100MHz
L305	010-3104-54	600 ohm/100MHz
L306	010-3104-54	600 ohm/100MHz
L307	010-3104-54	600 ohm/100MHz
L308	010-3104-54	600 ohm/100MHz
L309	010-3104-54	600 ohm/100MHz
L310	010-3104-54	600 ohm/100MHz
L311	010-3104-54	600 ohm/100MHz
L312	010-3104-54	600 ohm/100MHz
L313	010-3104-54	600 ohm/100MHz
L314	010-3104-54	600 ohm/100MHz
L315	010-3104-54	600 ohm/100MHz
L316	010-3104-54	600 ohm/100MHz
L317	010-3104-54	600 ohm/100MHz
L318	010-3104-54	600 ohm/100MHz
L319	010-3104-54	600 ohm/100MHz
L320	010-3105-70	240ohm/100MHz

REF NO.	PART NO.	DESCRIPTION
L321	010-3104-54	600 ohm/100MHz
L322	010-3104-54	600 ohm/100MHz
L323	010-3104-54	600 ohm/100MHz
L401	010-3406-54	2.2uH J
L501	010-8049-00	145uH
L507	010-3104-54	600 ohm/100MHz
L508	010-3414-93	4.7uH
P101	092-2210-01	ANT-RECEPT
P410	076-3011-76	26P
P602	076-3060-26	26P
Q107	190-2060-00	2SA2060
Q108	125-2046-95	DTC143ZUB
Q301	125-2046-95	DTC143ZUB
Q302	125-7021-90	RQ1A060ZPTR
Q505	191-1197-50	2SB1197K Q,R
Q506	192-4116-00	2SC4116
Q507	125-2046-91	DTC114EUBTL
Q509	125-2046-91	DTC114EUBTL
Q510	125-2032-93	RN1303
Q511	192-4081-00	2SC4081
Q512	191-1197-50	2SB1197K Q,R
Q513	125-2046-91	DTC114EUBTL
Q514	192-4116-51	2SC4116 G,L
Q515	191-1197-50	2SB1197K Q,R
Q516	125-2046-91	DTC114EUBTL
R102	119-0000-05	1/10W 0 ohm JW
R115	033-0000-05	1/16W 0 ohm
R124	033-1811-15	1/16W 180 ohm J
R125	033-3311-15	1/16W 330 ohm J
R126	033-4741-15	1/16W 470k ohm J
R127	033-1201-15	1/16W 12 ohm
R128	033-4741-15	1/16W 470k ohm J
R129	033-5601-15	1/16W 56 ohm J
R134	033-2231-15	1/16W 22k ohm J
R135	033-3921-15	1/16W 3.9k ohm J
R136	033-0000-05	1/16W 0 ohm
R137	033-0000-05	1/16W 0 ohm
R138	033-0000-05	1/16W 0 ohm
R139	033-0000-05	1/16W 0 ohm
R140	033-0000-05	1/16W 0 ohm
R143	033-0000-05	1/16W 0 ohm
R144	033-0000-05	1/16W 0 ohm
R146	116-1091-15	1/4W 1 ohm
R147	116-1221-15	1/4W 1.2k ohm
R151	033-1031-15	1/16W 10k ohm J
R152	033-0000-05	1/16W 0 ohm
R156	119-0000-05	1/10W 0 ohm JW
R157	033-1051-15	1/16W 1M ohm J
R158	033-1051-15	1/16W 1M ohm J
R203	033-1011-15	1/16W 100 ohm J
R220	116-6201-15	1/4W 62 ohm
R221	116-6201-15	1/4W 62 ohm
R225	119-0000-05	1/10W 0 ohm JW
R226	119-0000-05	1/10W 0 ohm JW
R301	119-1031-15	1/10W 10k ohm
R302	119-1031-15	1/10W 10k ohm
R303	032-0140-89	1/10W 47k ohm F
R304	032-0140-89	1/10W 47k ohm F
R305	032-0140-89	1/10W 47k ohm F
R306	032-0140-89	1/10W 47k ohm F
R307	033-1031-15	1/16W 10k ohm J
R308	032-0140-89	1/10W 47k ohm F
R309	032-0140-89	1/10W 47k ohm F
R310	032-0140-89	1/10W 47k ohm F
R311	032-0140-89	1/10W 47k ohm F
R313	033-1031-15	1/16W 10k ohm J
R318	033-1811-15	1/16W 180 ohm J
R319	033-1811-15	1/16W 180 ohm J
R320	033-1031-15	1/16W 10k ohm J
R321	033-1031-15	1/16W 10k ohm J
R322	033-1031-15	1/16W 10k ohm J
R323	033-1011-15	1/16W 100 ohm J
R324	033-1031-15	1/16W 10k ohm J
R325	032-0221-56	1/16W 22k ohm F

REF NO.	PART NO.	DESCRIPTION
R326	033-1031-15	1/16W 10k ohm J
R327	032-0221-56	1/16W 22k ohm F
R329	032-0221-56	1/16W 22k ohm F
R331	032-0221-56	1/16W 22k ohm F
R332	119-2201-15	1/10W 22 ohm
R334	033-1041-15	1/16W 100k ohm J
R335	033-1041-15	1/16W 100k ohm J
R338	033-4731-15	1/16W 47k ohm J
R344	033-1011-15	1/16W 100 ohm J
R348	033-1031-15	1/16W 10k ohm J
R349	033-1011-15	1/16W 100 ohm J
R350	033-1011-15	1/16W 100 ohm J
R352	033-1011-15	1/16W 100 ohm J
R354	033-1011-15	1/16W 100 ohm J
R355	033-1031-15	1/16W 10k ohm J
R356	119-0000-05	1/10W 0 ohm JW
R357	119-0000-05	1/10W 0 ohm JW
R358	033-1011-15	1/16W 100 ohm J
R359	119-2201-15	1/10W 22 ohm
R360	032-0150-54	1/16W 1k ohm F
R361	032-0150-54	1/16W 1k ohm F
R362	032-0150-54	1/16W 1k ohm F
R363	032-0150-54	1/16W 1k ohm F
R364	033-3331-15	1/16W 33k ohm J
R365	033-3331-15	1/16W 33k ohm J
R366	032-0150-51	1/16W 15k ohm F
R367	032-0150-51	1/16W 15k ohm F
R368	032-0150-51	1/16W 15k ohm F
R369	032-0150-51	1/16W 15k ohm F
R405	033-0000-05	1/16W 0 ohm
R411	033-1011-15	1/16W 100 ohm J
R412	033-1011-15	1/16W 100 ohm J
R413	119-4711-15	1/10W 470 ohm
R414	119-4711-15	1/10W 470 ohm
R415	119-4711-15	1/10W 470 ohm
R416	119-4711-15	1/10W 470 ohm
R418	033-1041-15	1/16W 100k ohm J
R419	033-3311-15	1/16W 330 ohm J
R420	033-3311-15	1/16W 330 ohm J
R421	033-1041-15	1/16W 100k ohm J
R422	033-2221-15	1/16W 2.2k ohm J
R423	033-2221-15	1/16W 2.2k ohm J
R424	119-1031-15	1/10W 10k ohm
R425	119-1031-15	1/10W 10k ohm
R426	119-1031-15	1/10W 10k ohm
R427	119-1031-15	1/10W 10k ohm
R428	033-1031-15	1/16W 10k ohm J
R429	033-1031-15	1/16W 10k ohm J
R430	033-1011-15	1/16W 100 ohm J
R431	033-1011-15	1/16W 100 ohm J
R432	116-6201-15	1/4W 62 ohm
R433	116-6201-15	1/4W 62 ohm
R434	033-0000-05	1/16W 0 ohm
R435	033-4731-15	1/16W 47k ohm J
R436	033-4731-15	1/16W 47k ohm J
R437	033-1031-15	1/16W 10k ohm J
R440	033-4731-15	1/16W 47k ohm J
R442	119-4791-15	1/10W 4.7 ohm
R445	033-0000-05	1/16W 0 ohm
R446	033-4721-15	1/16W 4.7k ohm J
R447	033-4731-15	1/16W 47k ohm J
R448	033-1031-15	1/16W 10k ohm J
R449	033-4731-15	1/16W 47k ohm J
R450	033-1021-15	1/16W 1k ohm J
R451	033-1011-15	1/16W 100 ohm J
R454	033-1011-15	1/16W 100 ohm J
R456	033-1021-15	1/16W 1k ohm J
R457	033-4721-15	1/16W 4.7k ohm J
R458	033-1011-15	1/16W 100 ohm J
R459	033-1011-15	1/16W 100 ohm J
R460	033-4731-15	1/16W 47k ohm J
R462	033-3331-15	1/16W 33k ohm J
R463	033-3331-15	1/16W 33k ohm J
R466	033-2231-15	1/16W 22k ohm J

REF NO.	PART NO.	DESCRIPTION
R467	033-4721-15	1/16W 4.7k ohm J
R468	033-4721-15	1/16W 4.7k ohm J
R475	033-4731-15	1/16W 47k ohm J
R479	033-3321-15	1/16W 3.3k ohm J
R480	033-3321-15	1/16W 3.3k ohm J
R481	033-2221-15	1/16W 2.2k ohm J
R488	033-1021-15	1/16W 1k ohm J
R489	033-1021-15	1/16W 1k ohm J
R490	033-1021-15	1/16W 1k ohm J
R491	033-1021-15	1/16W 1k ohm J
R492	033-0000-05	1/16W 0 ohm
R493	033-0000-05	1/16W 0 ohm
R495	033-3321-15	1/16W 3.3k ohm J
R496	033-3321-15	1/16W 3.3k ohm J
R497	033-1031-15	1/16W 10k ohm J
R521	033-1031-15	1/16W 10k ohm J
R522	033-3331-15	1/16W 33k ohm J
R527	033-1821-15	1/16W 1.8k ohm J
R528	033-1031-15	1/16W 10k ohm J
R529	119-5611-15	1/10W 560 ohm
R530	119-1031-15	1/10W 10k ohm
R531	032-0208-51	1/4W 15k ohm
R533	AQZ0457	1/16W 150k ohm 1%
R534	AQZ0461	1/16W 270k ohm 1%
R535	033-4731-15	1/16W 47k ohm J
R536	033-1031-15	1/16W 10k ohm J
R537	119-4731-15	1/10W 47k ohm
R538	119-2731-15	1/10W 27k ohm
R539	119-3321-15	1/10W 3.3k ohm
R540	119-0000-05	1/10W 0 ohm JW
R541	119-0000-05	1/10W 0 ohm JW
R542	119-0000-05	1/10W 0 ohm JW
R543	116-4721-15	1/4W 4.7k ohm
R544	119-2221-15	1/10W 2.2k ohm
R546	116-1531-15	1/4W 15k ohm
R547	116-4791-15	1/4W 4.7 ohm
R548	116-4791-15	1/4W 4.7 ohm
R550	032-0221-65	1/16W 68k ohm F
R551	032-0221-80	1/16W 6.2k ohm F

REF NO.	PART NO.	DESCRIPTION
R555	032-0221-51	1/16W 4.7k ohm F
R556	032-0221-51	1/16W 4.7k ohm F
R557	033-5611-15	1/16W 560 ohm J
R558	033-1031-15	1/16W 10k ohm J
R560	032-0221-76	1/16W 24k ohm F
R561	032-0221-61	1/16W 6.8k ohm F
R562	033-0000-05	1/16W 0 ohm
R563	033-0000-05	1/16W 0 ohm
R564	033-0000-05	1/16W 0 ohm
R565	033-0000-05	1/16W 0 ohm
R567	032-0221-65	1/16W 68k ohm F
R568	032-0221-61	1/16W 6.8k ohm F
R575	033-0000-05	1/16W 0 ohm
R576	032-0148-64	1/10W 390k ohm D
R577	032-0148-63	1/10W 130k ohm D
R578	033-1841-15	1/16W 180k ohm J
R579	033-3341-15	1/16W 330k ohm J
R581	033-1031-15	1/16W 10k ohm J
R582	032-0150-51	1/16W 15k ohm F
R583	033-5611-15	1/16W 560 ohm J
R584	033-1031-15	1/16W 10k ohm J
R585	119-0000-05	1/10W 0 ohm JW
R588	033-0000-05	1/16W 0 ohm
R589	033-0000-05	1/16W 0 ohm
R590	033-0000-05	1/16W 0 ohm
R591	033-0000-05	1/16W 0 ohm
R592	116-3991-15	1/4W 3.9 ohm
R593	116-3991-15	1/4W 3.9 ohm
R605	116-6891-15	1/4W 6.8 ohm
R615	033-2231-15	1/16W 22k ohm J
R616	033-1041-15	1/16W 100k ohm J
R618	033-2231-15	1/16W 22k ohm J
R621	032-0221-65	1/16W 68k ohm F
R622	032-0221-80	1/16W 6.2k ohm F
R623	033-1041-15	1/16W 100k ohm J
R624	033-2231-15	1/16W 22k ohm J
R625	119-0000-05	1/10W 0 ohm JW
R635	119-0000-05	1/10W 0 ohm JW
R636	033-1001-15	1/16W 10 ohm J
R637	033-1001-15	1/16W 10 ohm J
R638	033-1041-15	1/16W 100k ohm J

REF NO.	PART NO.	DESCRIPTION
RN401	050-0140-52	1/32W 100 ohm x4J
RN402	050-0140-52	1/32W 100 ohm x4J
RN405	050-0140-63	1/32W 47k ohm x4J
RN406	050-0140-63	1/32W 47k ohm x4J
RN407	050-0140-54	1/32W 1k ohm x4J
RN408	050-0140-54	1/32W 1k ohm x4J
RN409	050-0140-54	1/32W 1k ohm x4J
T101	010-4100-50	0.215uH
TH101	002-0229-00	PTH8L05BAIR8 M1B
VR213	001-9210-50	AVR-M1608C270 MTAAD
VR214	001-9210-50	AVR-M1608C270 MTAAD
VR215	001-9210-50	AVR-M1608C270 MTAAD
VR216	001-9210-50	AVR-M1608C270 MTAAD
VR217	001-9210-50	AVR-M1608C270 MTAAD
VR218	001-9210-50	AVR-M1608C270 MTAAD
VR502	001-9210-50	AVR-M1608C270 MTAAD
VR503	001-9210-50	AVR-M1608C270 MTAAD
VR504	001-9210-50	AVR-M1608C270 MTAAD
X301	061-3589-90	41.6MHz
X401	061-3567-90	8.000MHz AT-41CD2
ZD101	060-8107-50	SURGE PROTECTOR
ZD501	001-4312-34	02DZ6.2X TPH3-F
ZD503	001-4305-25	UDZSTE-17 9.1B
ZD507	001-4912-90	SM5S22A-HE3/2D
ZD508	001-4312-47	02DZ9.1Y TPH3-F
PWB	039-3869-01	PWB(WITHOUT COMPONENTS)

SW PWB(B2) section

REF NO.	PART NO.	DESCRIPTION
C601	043-0568-90	25V 2.2uF
C602	043-0568-90	25V 2.2uF
C603	043-0552-90	6.3V 47uF M
C604	045-4711-50	470pFJ CH
C605	043-0568-90	25V 2.2uF
C606	046-1022-58	50V 1000pF
C607	046-1022-58	50V 1000pF
C608	046-1022-58	50V 1000pF
C609	043-0552-90	6.3V 47uF M
C610	043-6400-90	16V 4.7uF K
D601	001-7109-90	SML-311DTT86 ORG
D602	001-7109-90	SML-311DTT86 ORG
D603	001-7109-90	SML-311DTT86 ORG
D604	001-7109-90	SML-311DTT86 ORG
D605	001-7109-90	SML-311DTT86 ORG
D606	001-7109-90	SML-311DTT86 ORG
D607	001-7109-90	SML-311DTT86 ORG
D608	001-7109-90	SML-311DTT86 ORG
D609	001-7109-90	SML-311DTT86 ORG
D610	001-7109-90	SML-311DTT86 ORG
D611	001-7109-90	SML-311DTT86 ORG
D612	001-7109-90	SML-311DTT86 ORG
D613	001-7109-90	SML-311DTT86 ORG
D614	001-7109-90	SML-311DTT86 ORG
D615	001-7109-90	SML-311DTT86 ORG
D616	001-7109-90	SML-311DTT86 ORG
D617	001-7109-90	SML-311DTT86 ORG
D618	001-7109-90	SML-311DTT86 ORG
D619	001-7109-90	SML-311DTT86 ORG
D620	001-7109-90	SML-311DTT86 ORG
D621	001-7109-90	SML-311DTT86 ORG
D622	001-7109-90	SML-311DTT86 ORG
D623	001-7109-90	SML-311DTT86 ORG

REF NO.	PART NO.	DESCRIPTION
D624	001-7109-90	SML-311DTT86 ORG
D625	001-7109-90	SML-311DTT86 ORG
D626	001-7109-90	SML-311DTT86 ORG
D627	001-7109-90	SML-311DTT86 ORG
D628	001-7109-90	SML-311DTT86 ORG
D629	001-7109-90	SML-311DTT86 ORG
D630	001-7109-90	SML-311DTT86 ORG
D631	001-7148-90	NSSB064-EE7-TKMLP4R2
D632	001-7148-90	NSSB064-EE7-TKMLP4R2
D633	001-7148-90	NSSB064-EE7-TKMLP4R2
D634	001-7148-90	NSSB064-EE7-TKMLP4R2
D635	001-7148-90	NSSB064-EE7-TKMLP4R2
D636	001-7148-90	NSSB064-EE7-TKMLP4R2
D637	001-7148-90	NSSB064-EE7-TKMLP4R2
D638	001-7148-90	NSSB064-EE7-TKMLP4R2
D639	001-7148-90	NSSB064-EE7-TKMLP4R2
D640	001-7148-90	NSSB064-EE7-TKMLP4R2
D641	001-7148-90	NSSB064-EE7-TKMLP4R2
D642	001-7148-90	NSSB064-EE7-TKMLP4R2
IC601	051-6105-00	LC75818PHT-8561-H
J601	075-0395-01	JACK
J602	074-3055-26	26P
LC601	379-1462-53	LCD
R601	033-0000-05	1/16W 0 ohm
R602	032-0225-64	1/16W 9.1k ohm +/-0.5%
R603	116-1521-15	1/4W 1.5k ohm
R604	116-1021-15	1/4W 1k ohm
R605	116-1521-15	1/4W 1.5k ohm
R606	116-1521-15	1/4W 1.5k ohm
R607	116-1021-15	1/4W 1k ohm
R608	116-1021-15	1/4W 1k ohm
R609	116-1021-15	1/4W 1k ohm
R610	116-3321-15	1/4W 3.3k ohm
R611	116-3321-15	1/4W 3.3k ohm
R612	116-3321-15	1/4W 3.3k ohm

REF NO.	PART NO.	DESCRIPTION
R613	116-3321-15	1/4W 3.3k ohm
R614	116-3321-15	1/4W 3.3k ohm
R615	116-3321-15	1/4W 3.3k ohm
R616	116-1521-15	1/4W 1.5k ohm
R617	116-1521-15	1/4W 1.5k ohm
R618	116-1521-15	1/4W 1.5k ohm
R619	116-1521-15	1/4W 1.5k ohm
R620	116-1821-15	1/4W 1.8k ohm
R621	116-1821-15	1/4W 1.8k ohm
R622	116-1511-15	1/4W 150 ohm
R623	116-1511-15	1/4W 150 ohm
R624	116-1511-15	1/4W 150 ohm
R625	116-1511-15	1/4W 150 ohm
R626	116-1511-15	1/4W 150 ohm
R627	116-1511-15	1/4W 150 ohm
R635	032-0150-55	1/16W 2.7k ohm F
R636	032-0150-55	1/16W 2.7k ohm F
R637	032-0150-55	1/16W 2.7k ohm F
R638	032-0150-55	1/16W 2.7k ohm F
R651	032-0140-72	1/10W 470 ohm F
SW601	013-6202-52	SKPMBJE010
SW602	013-6201-53	SKPMAPE010
SW603	013-6201-53	SKPMAPE010
SW604	016-7006-00	ROTARY SW
SW605	016-7006-00	ROTARY SW
SW606	013-6202-52	SKPMBJE010
SW607	013-6202-52	SKPMBJE010
SW608	013-6202-52	SKPMBJE010
SW609	013-6202-52	SKPMBJE010
SW610	013-6202-52	SKPMBJE010
SW611	013-6202-52	SKPMBJE010
SW612	013-6201-53	SKPMAPE010
SW613	013-6201-53	SKPMAPE010
SW614	013-6201-53	SKPMAPE010
SW615	013-6201-53	SKPMAPE010
SW616	013-6202-52	SKPMBJE010
SW617	013-6202-52	SKPMBJE010
SW618	013-6202-52	SKPMBJE010
SW619	013-6202-52	SKPMBJE010
SW620	013-6202-52	SKPMBJE010
VR601	001-9210-50	AVR-M1608C270 MTAAD
VR602	001-9210-50	AVR-M1608C270 MTAAD
VR603	001-9210-50	AVR-M1608C270 MTAAD
VR604	001-9210-50	AVR-M1608C270 MTAAD
ZD601	001-4312-32	02DZ5.6Y TPH3-F
ZD602	001-4312-32	02DZ5.6Y TPH3-F
ZD606	001-4312-32	02DZ5.6Y TPH3-F
ZD608	001-4312-32	02DZ5.6Y TPH3-F
ZD610	001-4312-32	02DZ5.6Y TPH3-F
ZD611	001-4312-32	02DZ5.6Y TPH3-F
PWB	039-3797-00	PWB(WITHOUT COMPONENTS)

CONNECTOR PWB(B3) section

REF NO.	PART NO.	DESCRIPTION
C101	168-4752-98	4.7uF K
C102	043-0603-90	16V 10uF
C103	046-1022-58	50V 1000pF
C104	043-6400-90	16V 4.7uF K
C105	043-0603-90	16V 10uF
C106	046-1022-58	50V 1000pF
IC101	060-8141-01	VPDASF-14F405-GA

REF NO.	PART NO.	DESCRIPTION
IC102	----------	BD00D0AWHFP-TR (Voltage regulator) (Thermal pad) (370990-051)
IC103	----------	BD00D0AWHFP-TR (Voltage regulator) (Thermal pad) (370990-051)

REF NO.	PART NO.	DESCRIPTION
R101	032-0221-76	1/16W 24k ohm F
R102	032-0221-61	1/16W 6.8k ohm F
R104	032-0221-65	1/16W 68k ohm F
R105	032-0221-62	1/16W 8.2k ohm F
PWB	039-3888-00	PWB(WITHOUT COMPONENTS)

FUNDAMENTAL SPECIFICATION

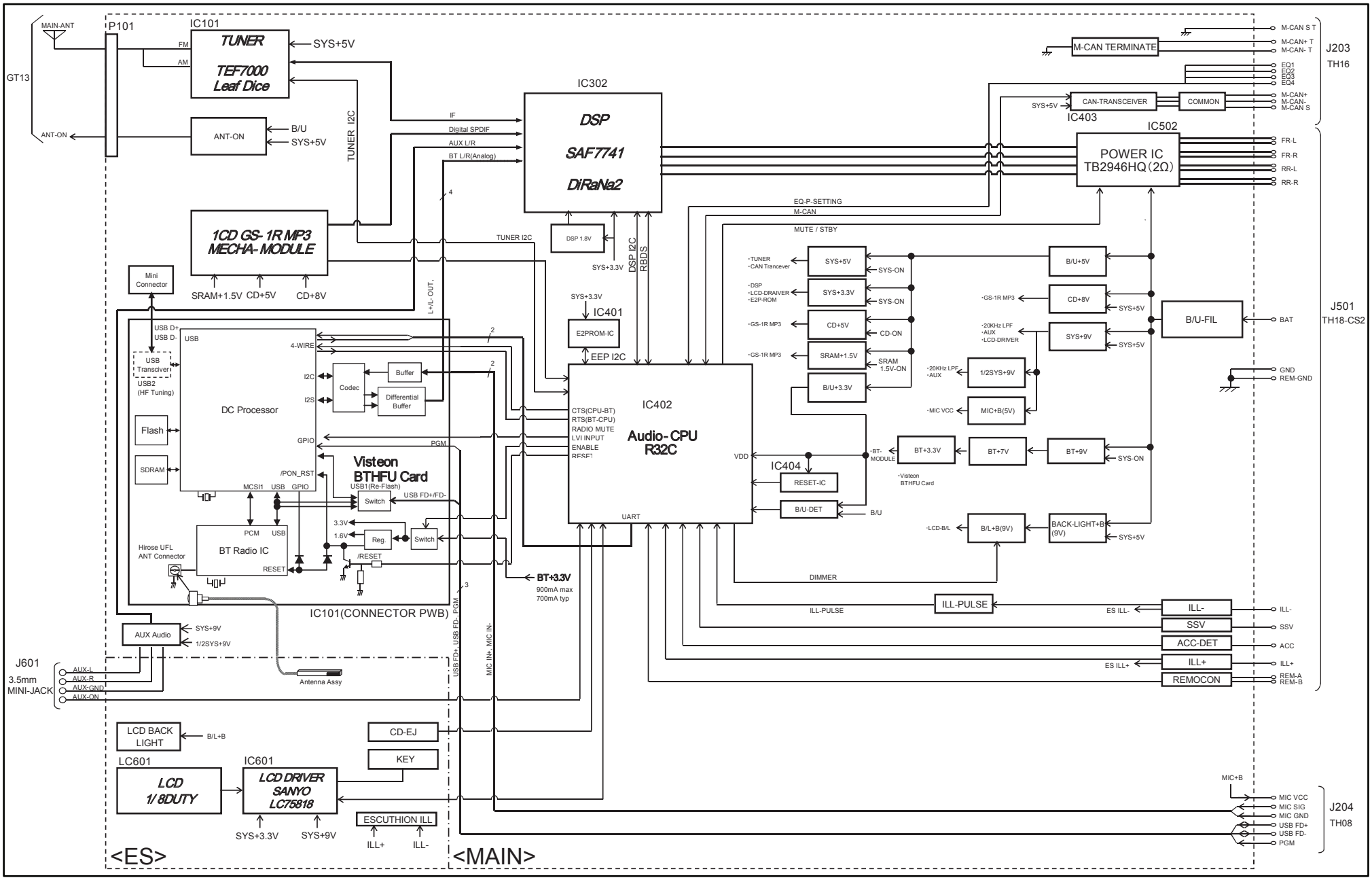
(Note: "X"=Available, "NA"= Not Available, "(X)"=Support design)

FUNCTION	DESTINATION	RADIO									CD	
		BAND	AUTO-TUNING	FM DIVERSITY	ANT-AMP CONNECT	FM-RBDS	FM RDS AF	FM-TA	FM RDS EON	FM RDS TMC	TYPE	FORMAT
APPLICATION	NAM	AM/FM1/FM2	SEEK/SCAN	NA	X	X PS, PTY	NA	NA	NA	NA	1CD MP3/WMA	CD-DA, CD-R, CD-RW

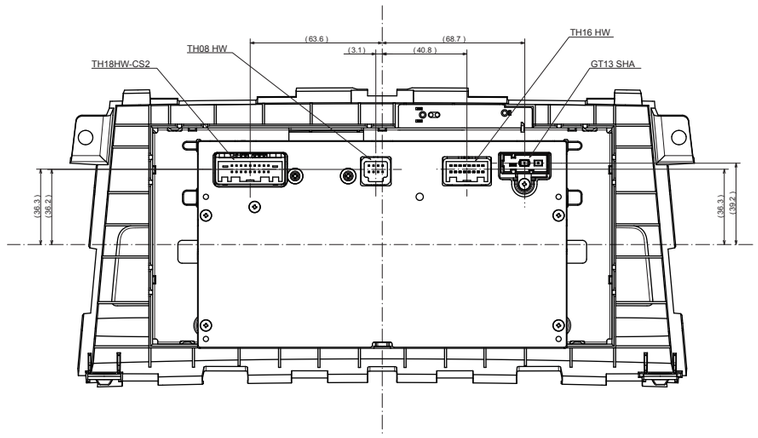
FUNCTION	CD	AUDIO INPUT					AUDIO CONTROL					EQ SEL
	SHOCK PROOF	CD-CHG CONTROL	iPod CONTROL	AUX CONNECT	BLUETOOTH-AUDIO CONNECT	NAVI-SIGNAL CONNECT	PRE OUTPUT	BASS /TREBLE	LOUDNESS (DYNAMIC)	FIX EQ	SOUND FOCUS	
APPLICATION	NA	NA	NA	X	X	NA	NA	X	X	X	NA	X

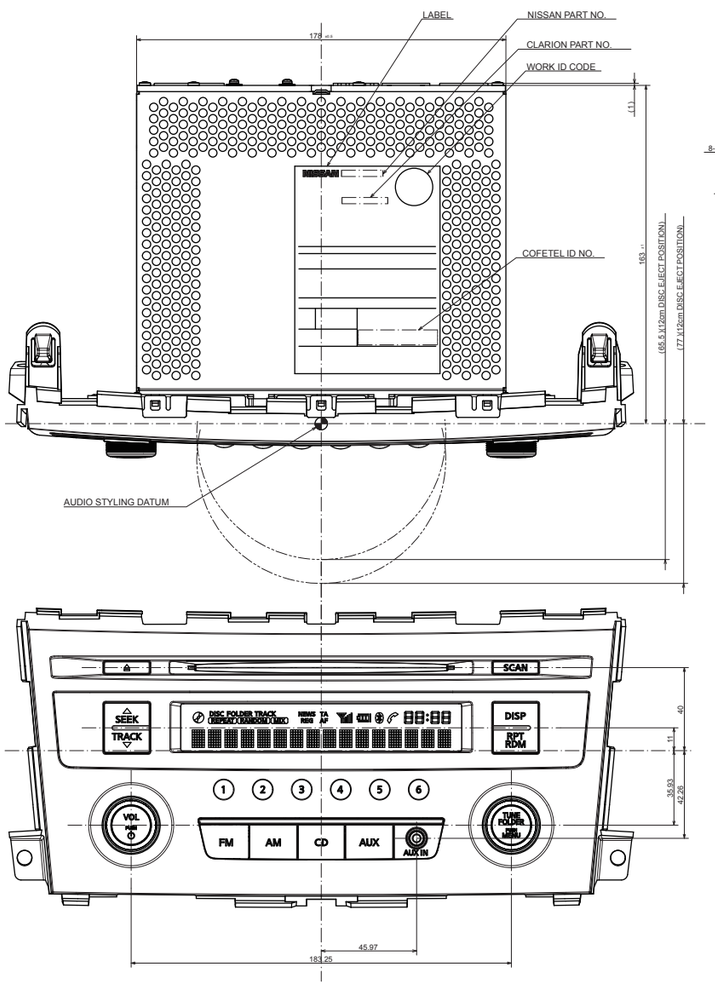
FUNCTION	AUDIO OUTPUT		SSV	STEERING REMOTE CONTROL	CONNECTED ANTENNA	ANTI THEFT	TEL MIC INPUT	BLUETOOTH INTERNAL PHONE SYSTEM	ILLUMI CONTROL	CLOCK	METER M-CAN COMMUNICATION	TEL M-CAN COMMUNICATION
	AUDIO OUTPUT	OUTPUT POWER										
APPLICATION	POWER OUTPUT	45W X 4ch/2ohm	X	X (M-CAN)	ACTIVE	NA	X	X	X	X	X (Including SRC)	NA

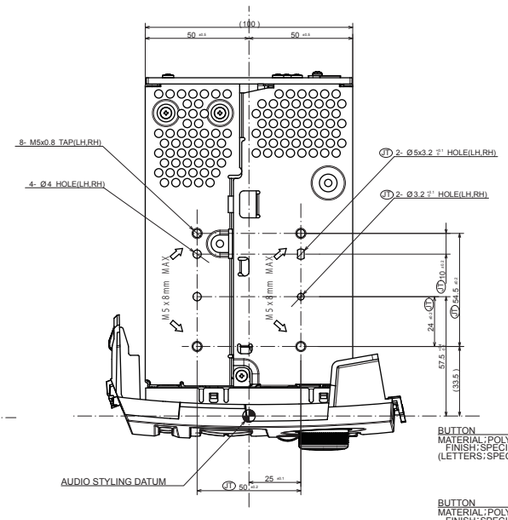
BLOCK DIAGRAM



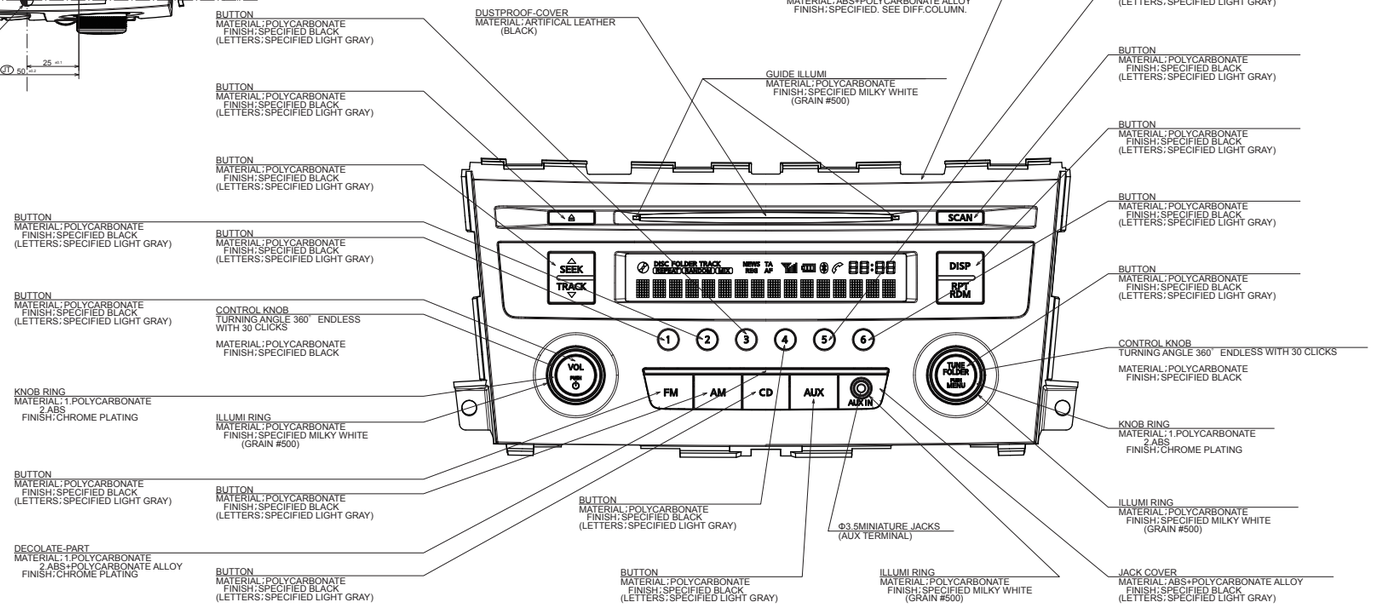
OUTSIDE VIEW







LOCATION	NO.	CONNECTION
TH18HW-CS2	01	N.C
	02	FR_SP_LH(+)
	03	FR_SP_LH(-)
	04	RR_SP_LH(+)
	05	RR_SP_LH(-)
	06	(STRG_SW_A)
	07	ACC
	08	ILL(-)
	09	ILL(+),LIGHT SW
	10	N.C
	11	FR_SP_RH(+)
	12	FR_SP_RH(-)
	13	RR_SP_RH(+)
	14	RR_SP_RH(-)
	15	(STRG_SW_GND)
	16	(STRG_SW_B)
	17	N.C
	18	SPEED SIGNAL
	19	BAT
	20	GND
TH16HW	01	EQ1
	02	EQ2
	03	EQ3
	04	EQ4
	05	N.C
	06	M-CAN SHIELD
	07	M-CAN +
	08	M-CAN -
	09	N.C
	10	N.C
	11	N.C
	12	N.C
	13	N.C
	14	M-CAN SHIELD2
	15	M-CAN TERMINATE +
	16	M-CAN TERMINATE -
GT13 SHA	AT1	NO PIN
	AT2	ANTENNA SIGNAL
	AT3	ANT+B
TH08HW	01	MIC SIGNAL
	02	MIC GND
	03	MIC VCC
	04	FD+
	05	GND
	06	GND
	07	PGM
	08	FD-



RA	○	×	○	○	180W	LCD	○	(○)	○	×	×	×	×	○	○	○	○	○	○	×	18	AM/FM	○	45Wx4ch (2 Ω)	○	REDDISH ORANGE	WHITE	BLACK (NOTE 5)	BLACK (NOTE 5)	NAM	28185 9HR0A	PN-3378I-E	3
A0	○	×	○	○	180W	LCD	○	(○)	○	×	×	×	×	○	○	○	○	○	○	×	18	AM/FM	○	45Wx4ch (2 Ω)	○	REDDISH ORANGE	WHITE	BLACK (NOTE 5)	BLACK GLOSS (NOTE 5)	NAM	28185 3TB0G	PN-3378I-D	2
A0	○	×	○	○	180W	LCD	○	(○)	○	×	×	×	×	○	○	○	○	○	○	×	18	AM/FM	○	45Wx4ch (2 Ω)	○	REDDISH ORANGE	WHITE	BLACK (NOTE 5)	BLACK GLOSS (NOTE 5)	NAM	28185 3TA0G	PN-3378I-C	1
WORK ID. CODE	ANT-ON SIGNAL	FM DIVERSITY	DIMMER	ILLUMI CONTROL	POWER OUTPUT	DISPLAY TYPE	SPEED DEPENDANT VOLUME CONTROL	REMOTE CONTROL	M-CAN	TEL ON TELEPHONE	LINE IN	SATELLITE CONTROL	CD A/C CONTROL	REPEAT TRACK CD	RANDOM	RBDS	BASS TREBLE BAL/FADER	LOUDNESS	AUTOMONO STEREO	LO/DX	PRESETS	BAND	2 STAGE EJECT	FR/RR-OUTPUT POWER	AUX INPUT	LETTERS ILLUMINATION COLOR	DISPLAY	BUTTON SURFACE COLOR	ESCUTCHEON	DESTINATION	NISSAN PART NO.	PART NO.	NO.

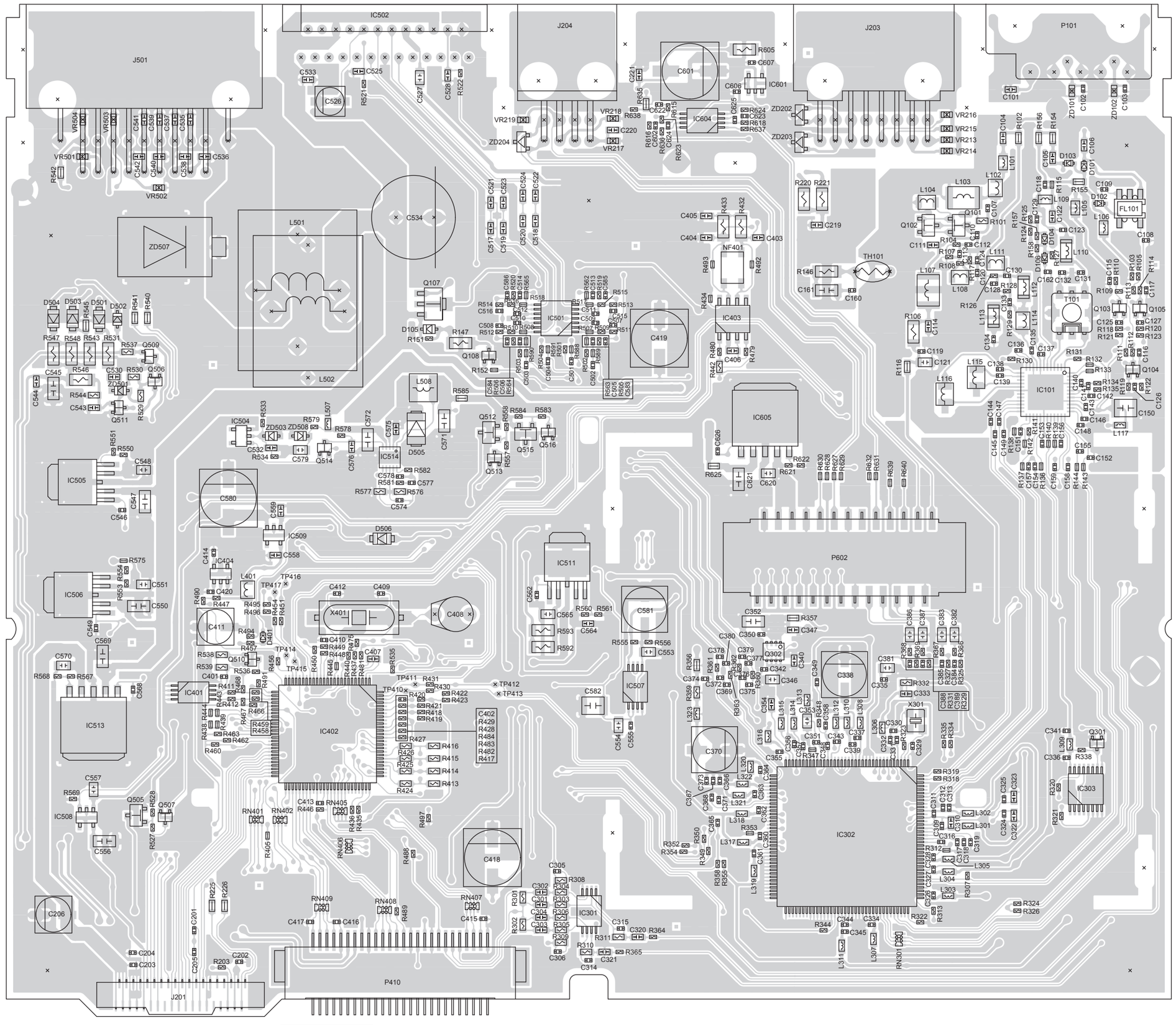
ACT WT(g) 1800g

PN-3378I-E

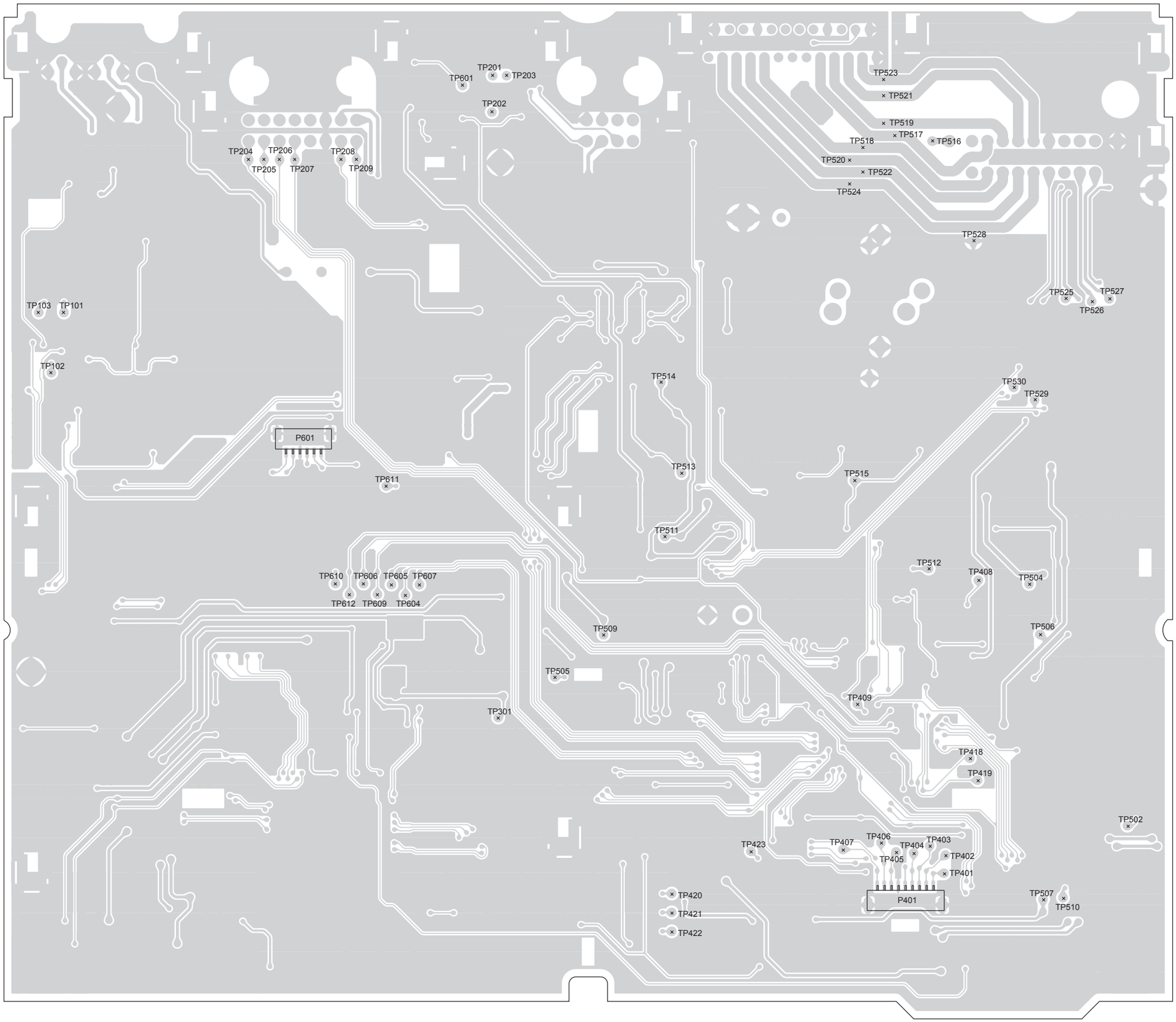
PRINTED WIRING BOARD

MAIN PWB(B1) section [Top view]

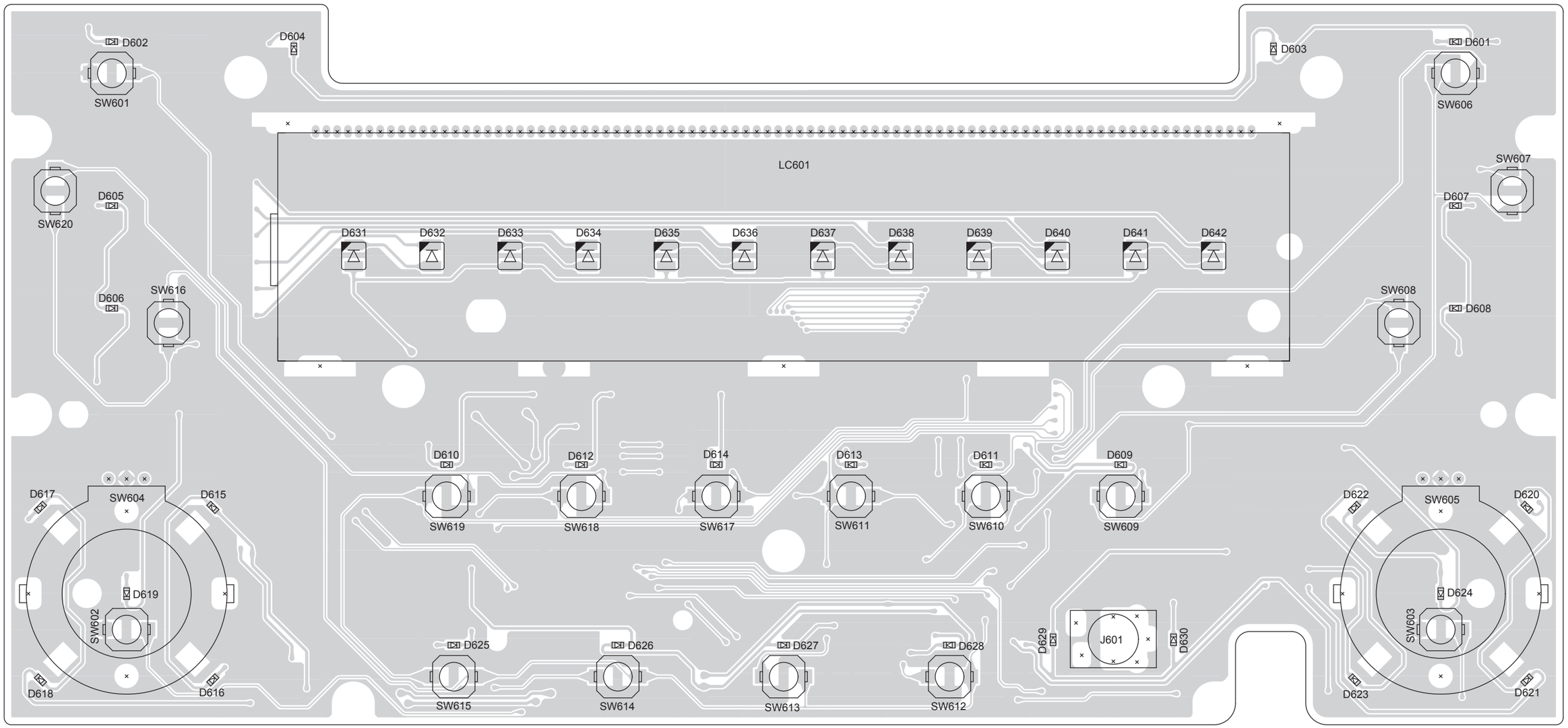
Some parts shown in this illustration may not actually be mounted.
Refer to the electrical part list regarding parts actually mounted to the PWB.



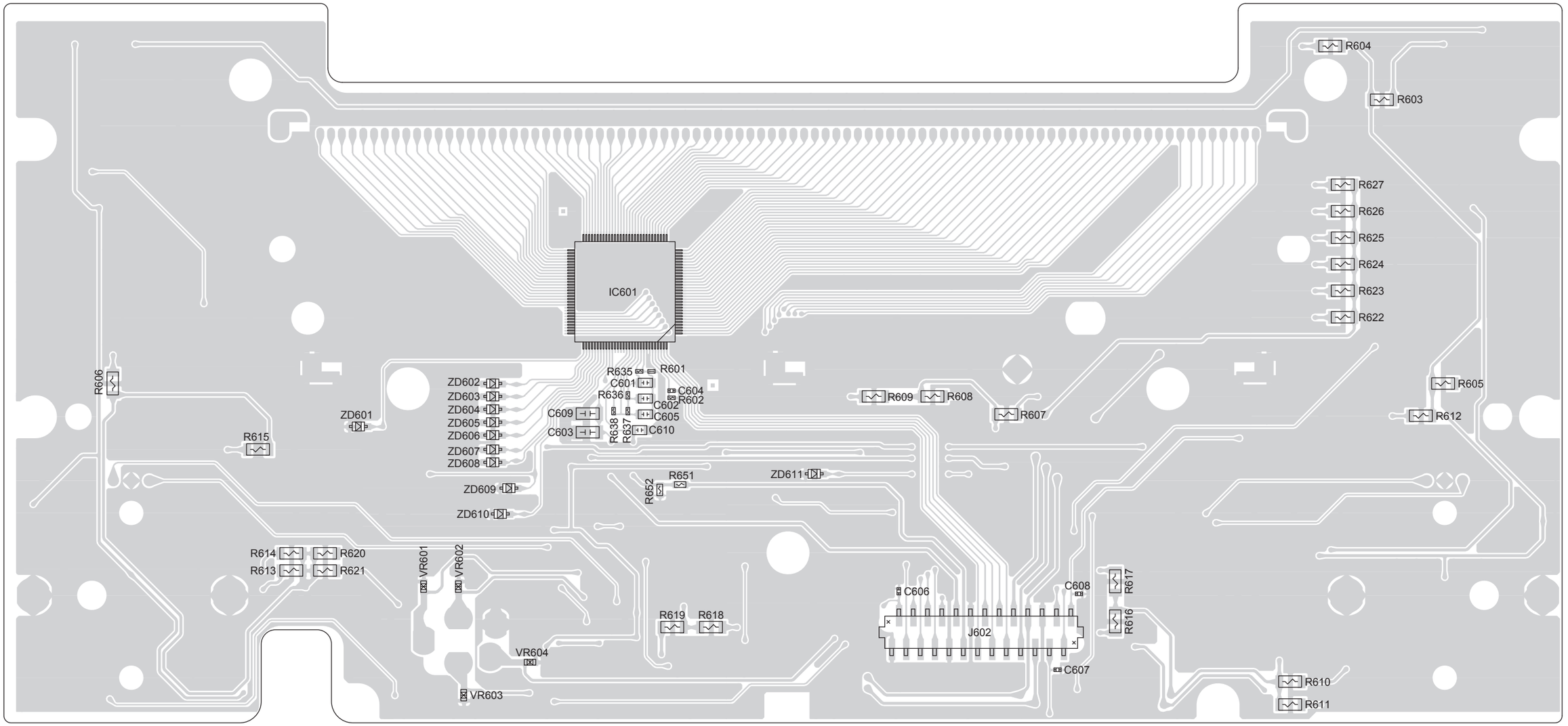
MAIN PWB(B1) section [Bottom view]



SW PWB(B2) section [Top view]

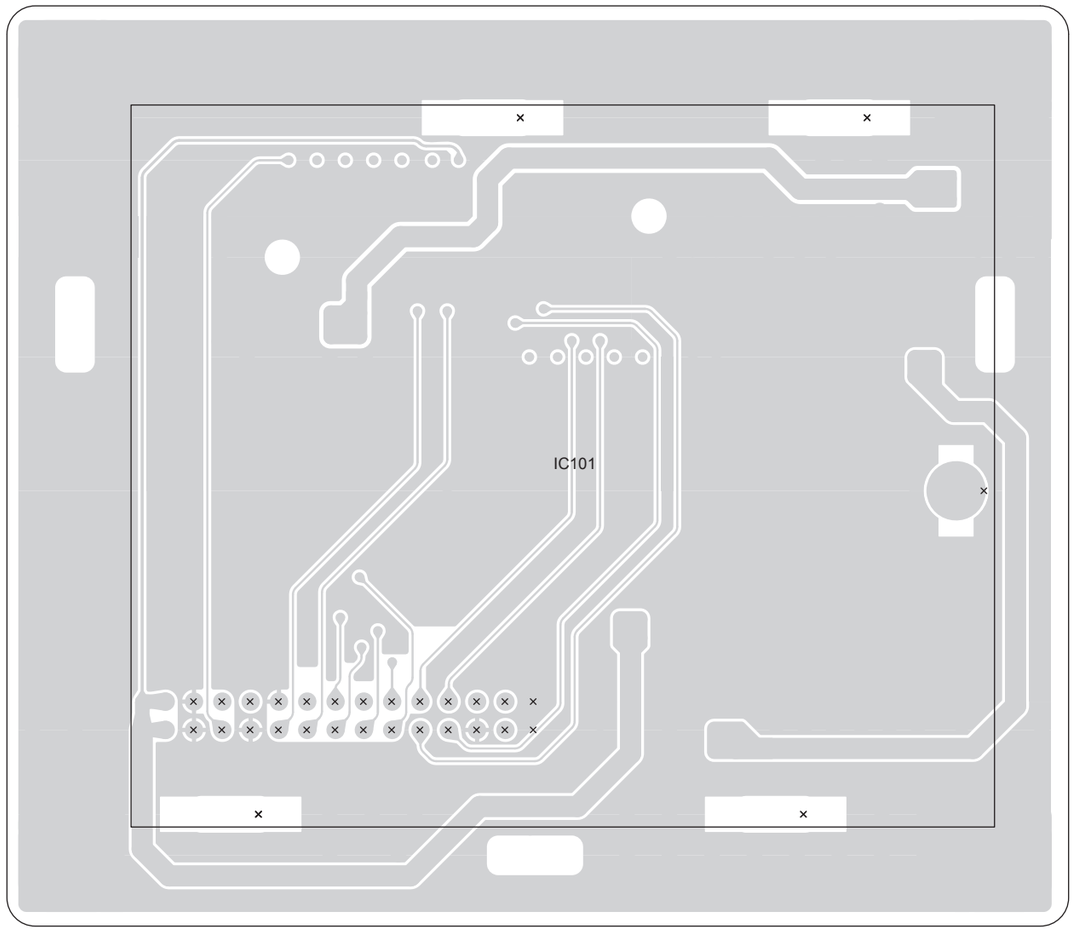


SW PWB(B2) section [Bottom view]

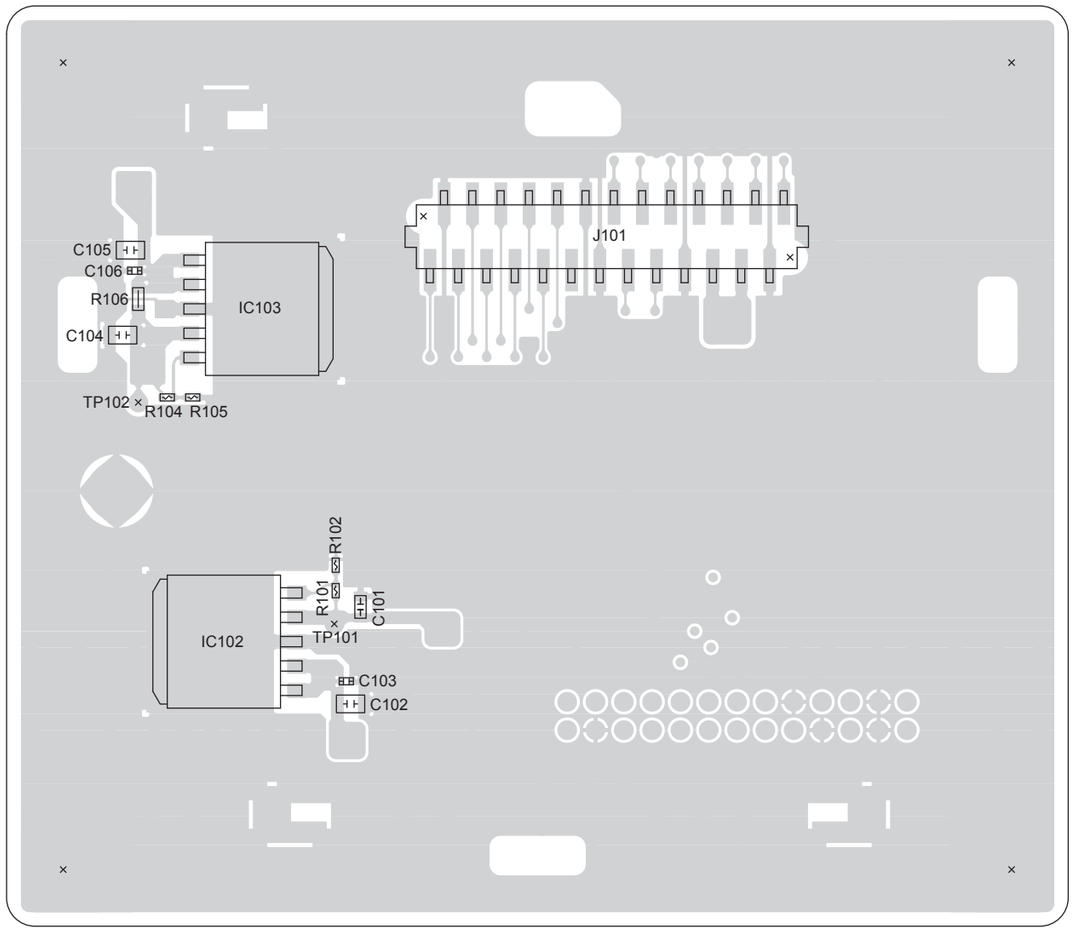


CONNECTOR PWB(B3) section

[Top view]



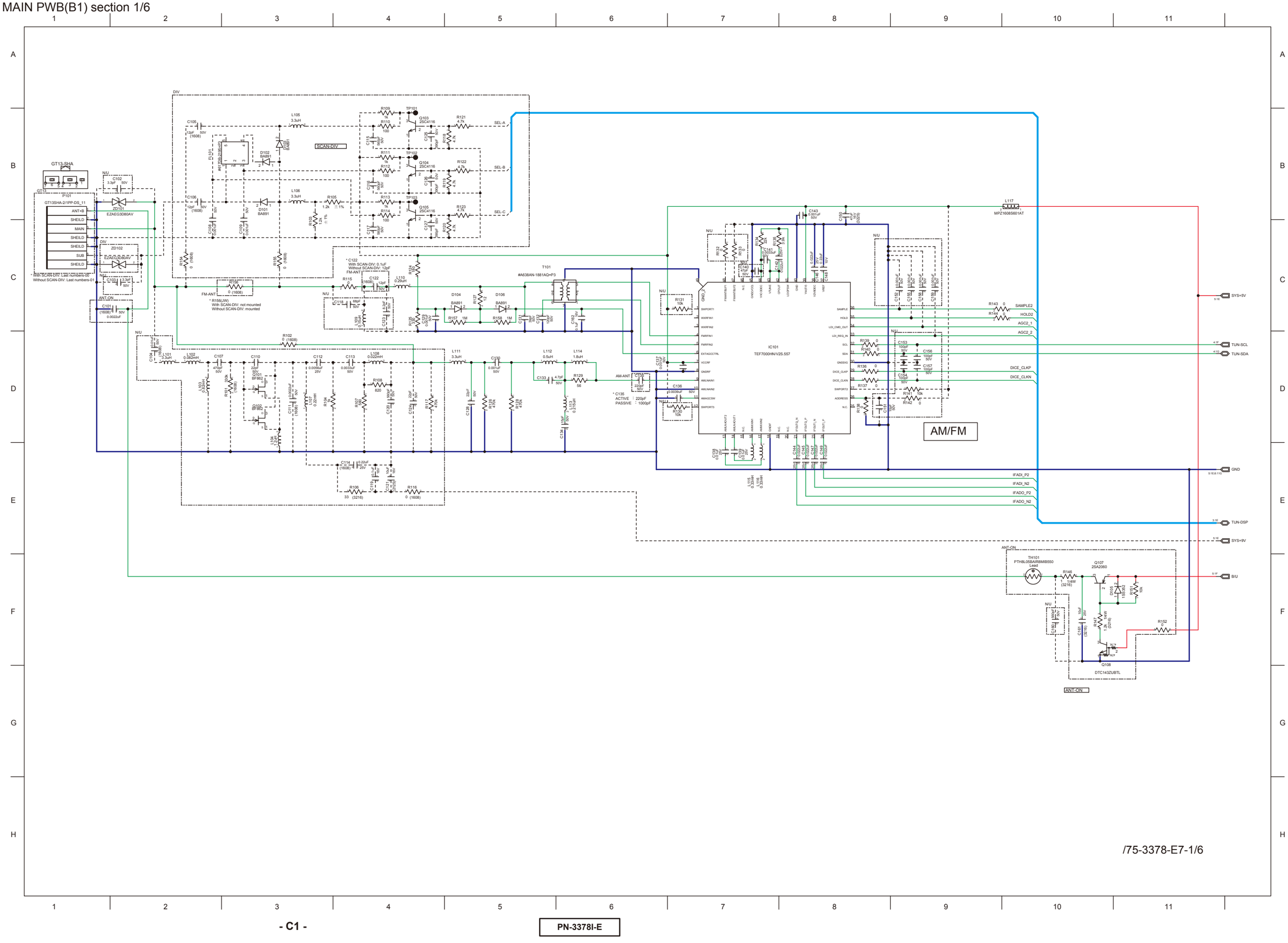
[Bottom view]



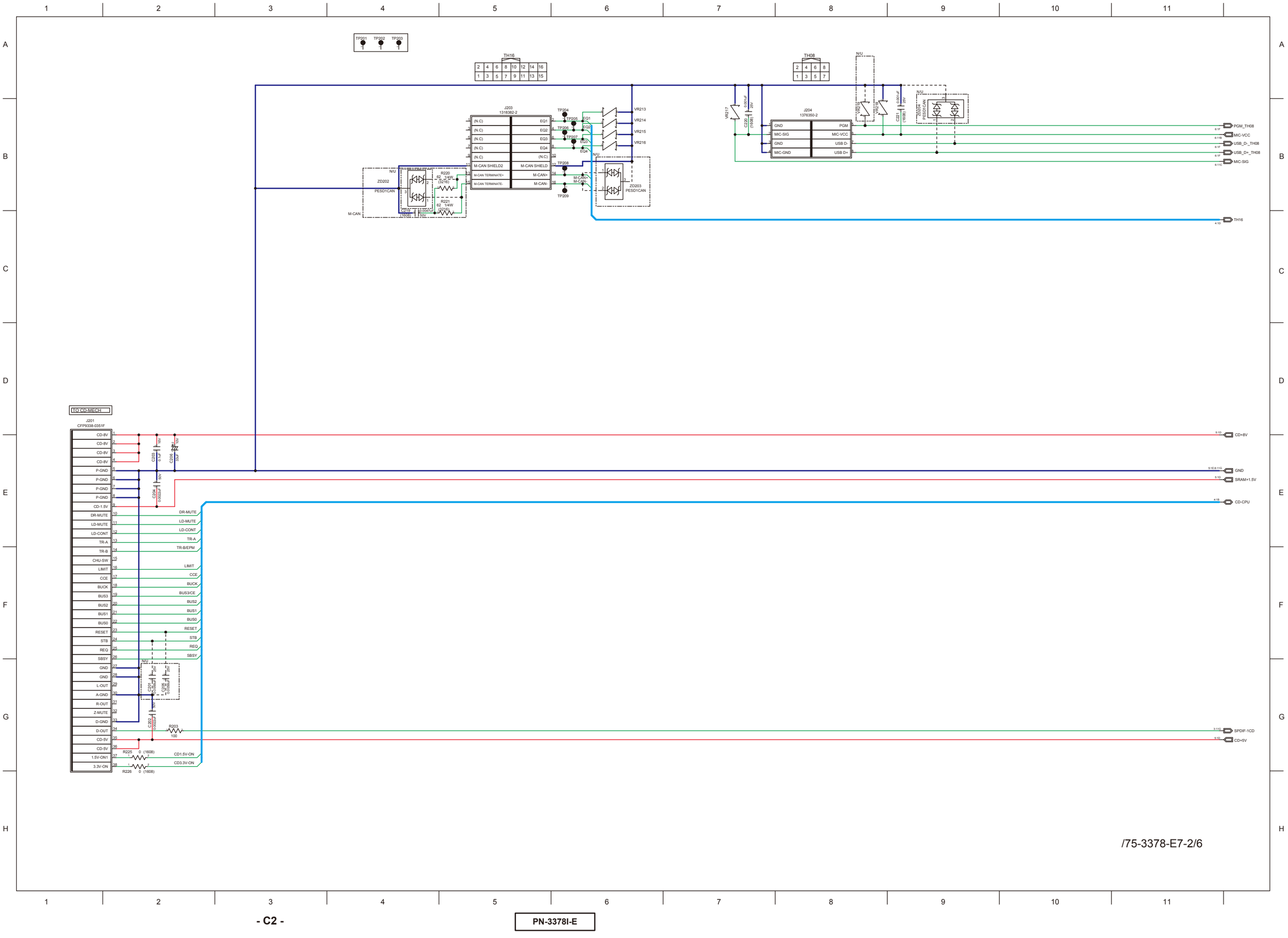
CIRCUIT DIAGRAM

MAIN PWB(B1) section 1/6

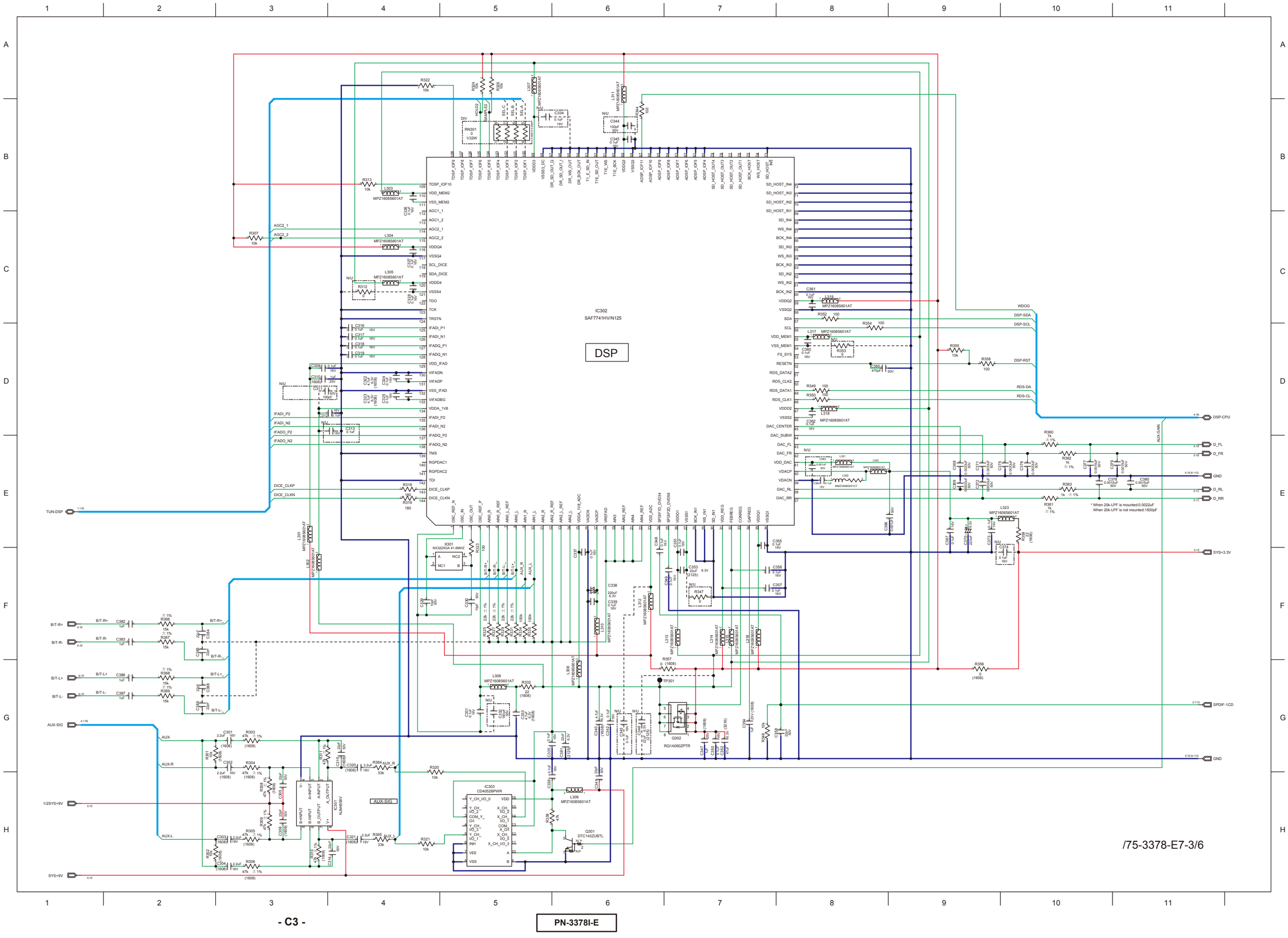
Some parts shown in this illustration may not actually be mounted.
Refer to the electrical part list regarding parts actually mounted to the PWB.



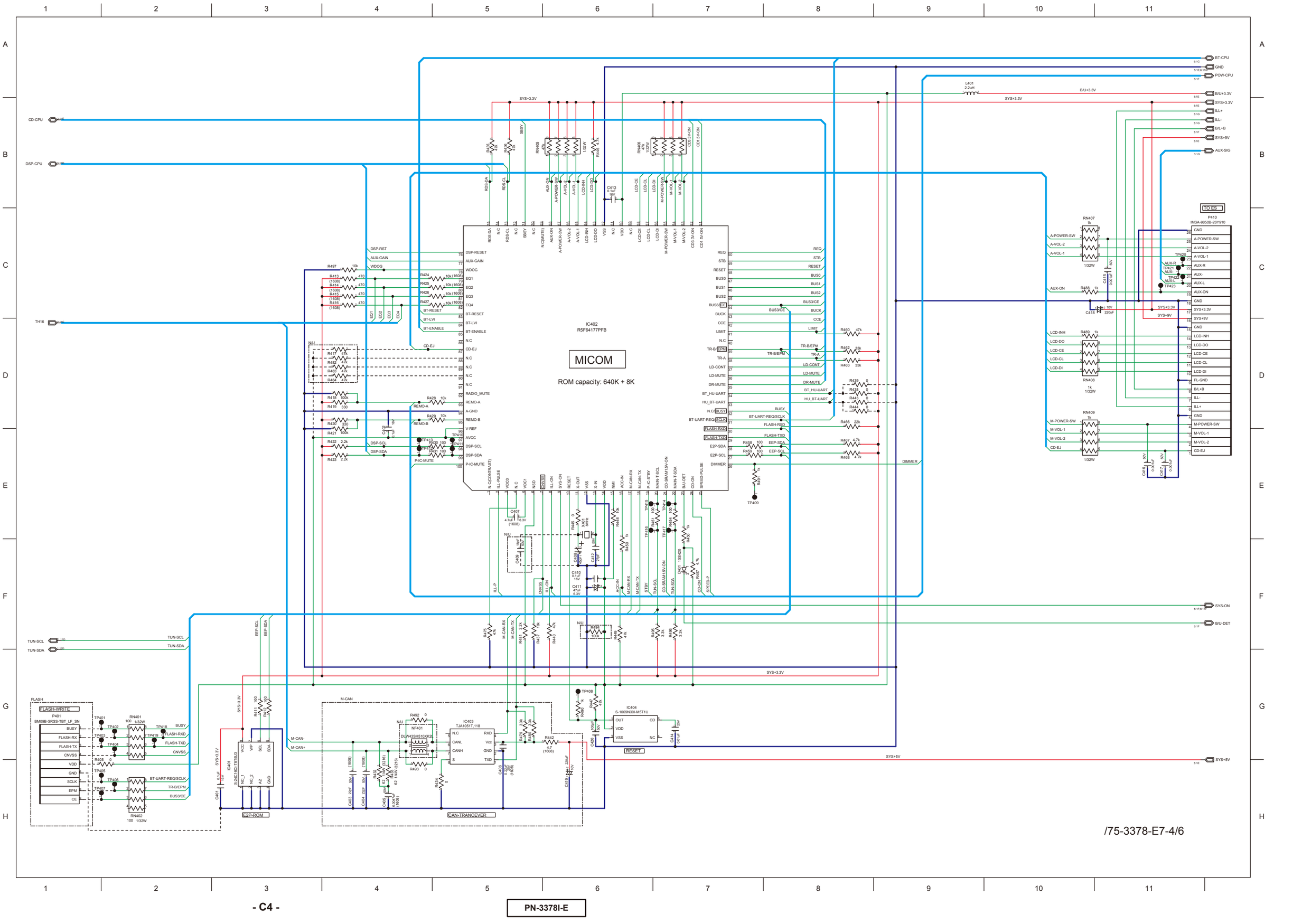
MAIN PWB(B1) section 2/6



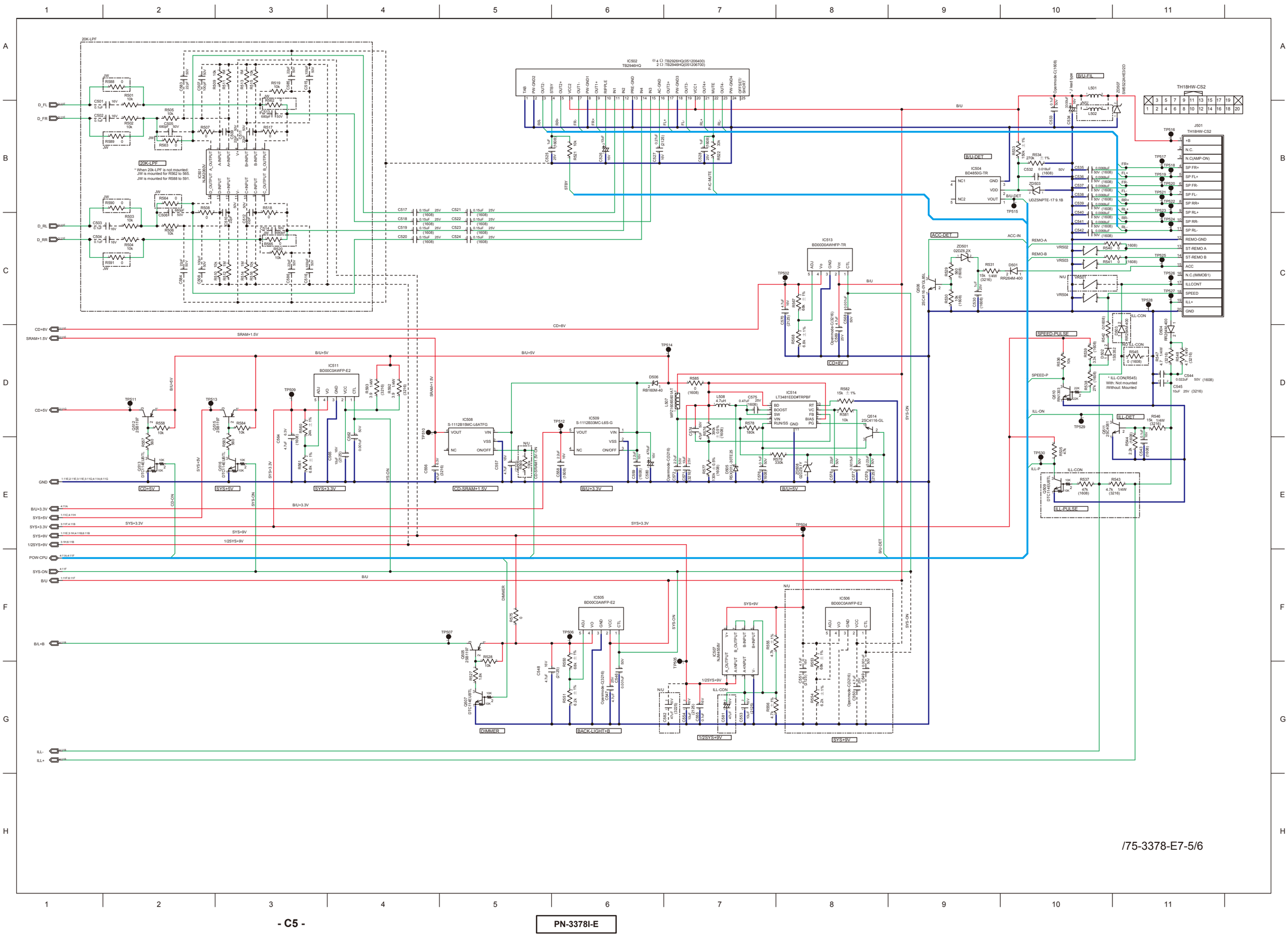
MAIN PWB(B1) section 3/6



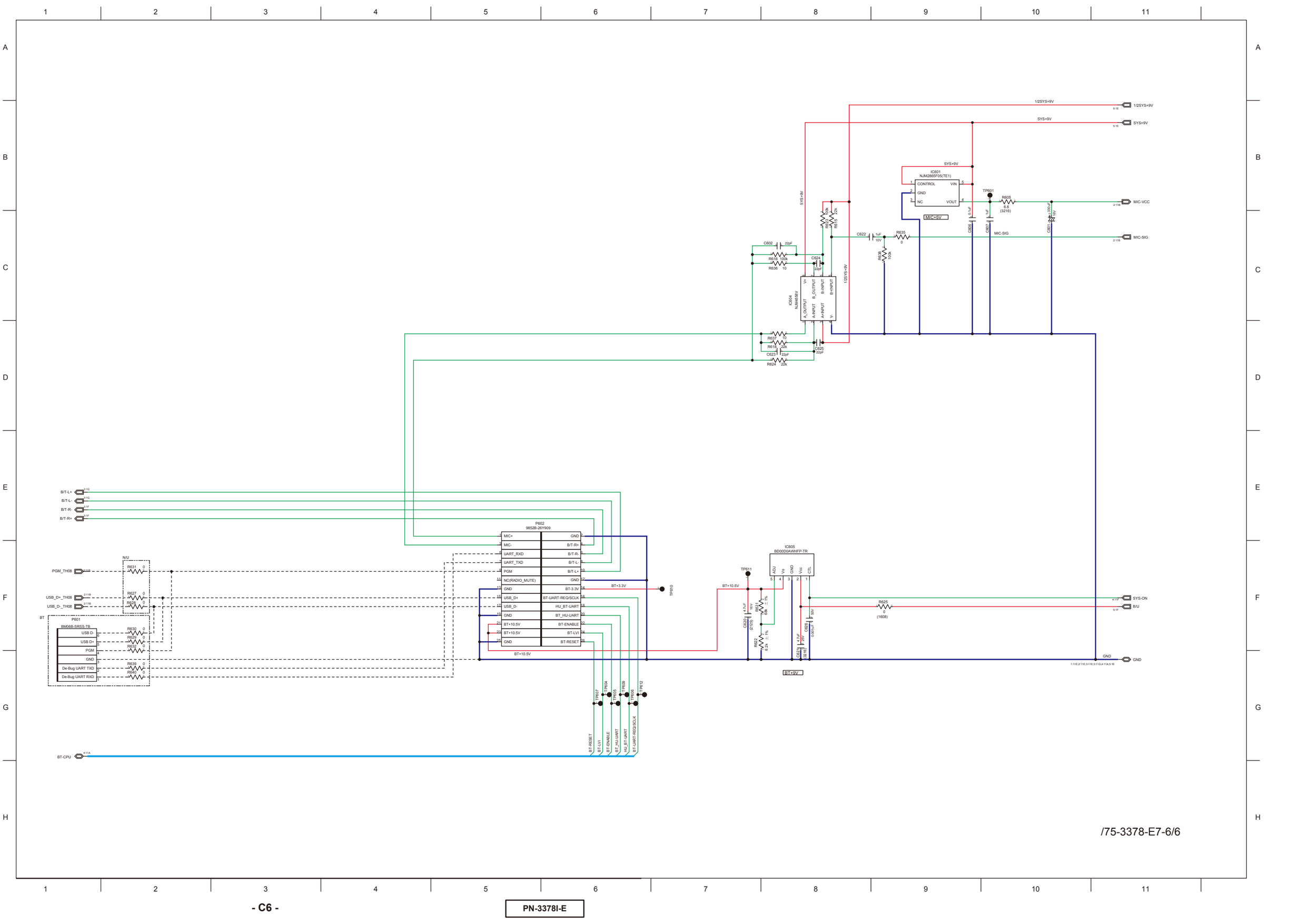
MAIN PWB(B1) section 4/6



MAIN PWB(B1) section 5/6

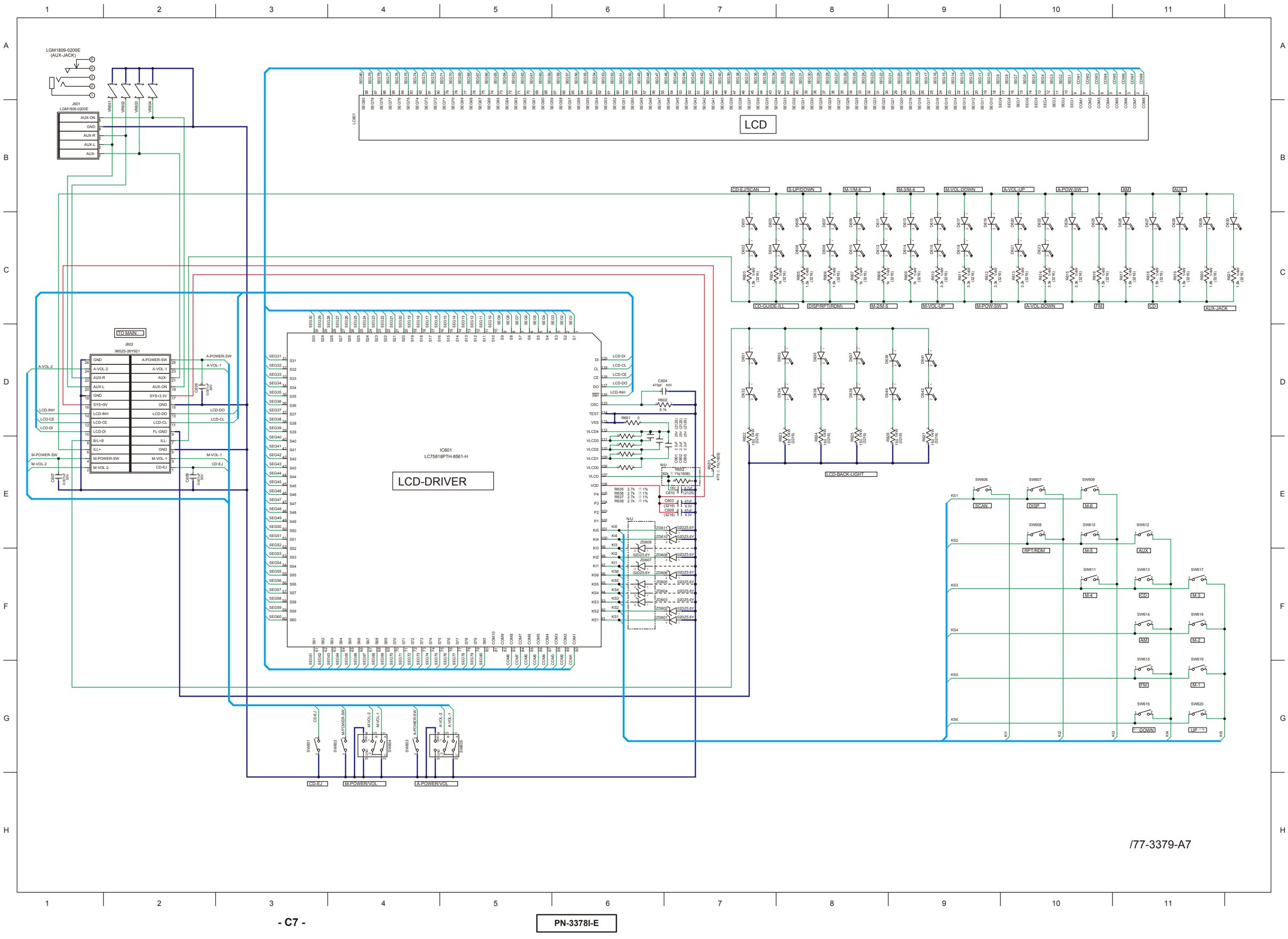


MAIN PWB(B1) section 6/6

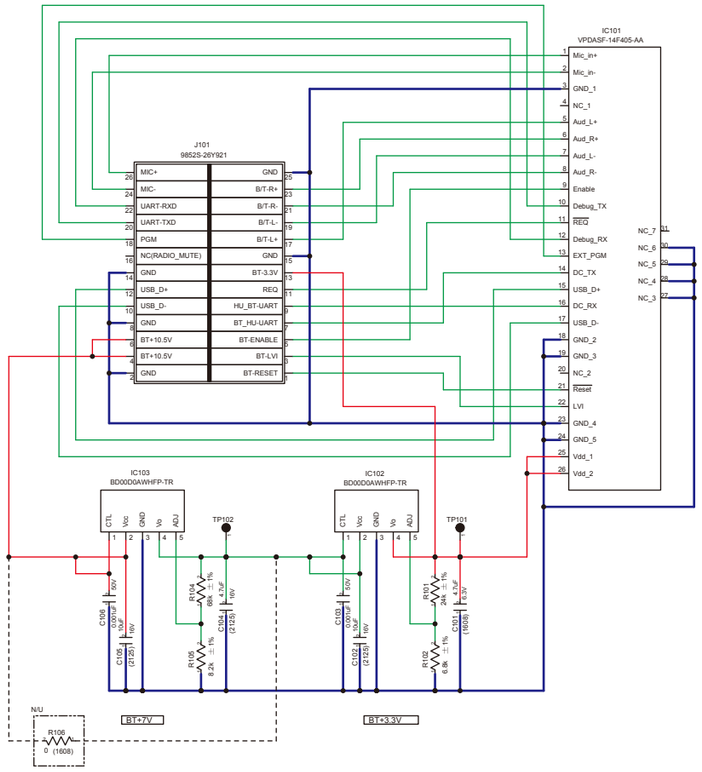


/75-3378-E7-6/6

SW PWB(B2) section 1/1



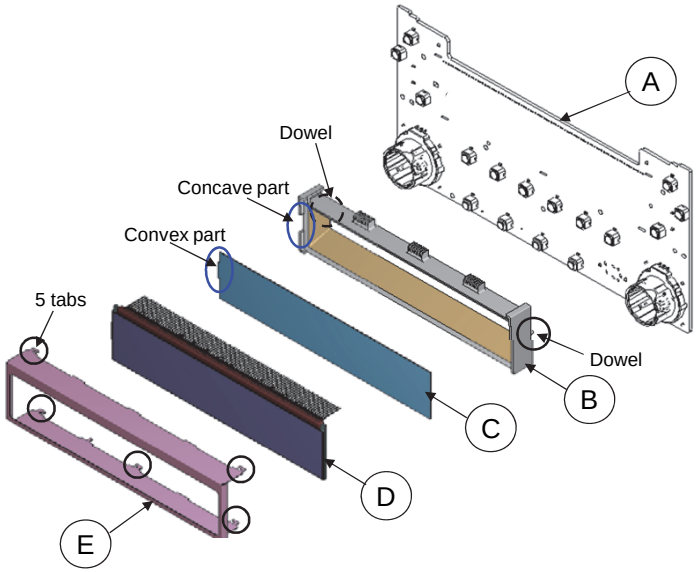
CONNECTOR PWB(B3) section 1/1



/79-3378-A7

ASSEMBLY INSTRUCTIONS / PN-3378I-E / SW PWB (1)

Process drawing



Note 1) Use the ionizer.
Note 2) Handle PWB from the edge to avoid touching the parts.

Procedure

Contents of process	No.	Parts Number	Qty	Control Points
・ Blow ionized air onto SW-A-PWB-ASSY (A) for dust removal, and then attach parts of jig ①.	A	-------	1	(3378B9-77)
・ Blow ionized air onto LCD-HOLDER (B) for dust removal, and then attach parts to SW-PWB.	B	335-9150-00	1	Fit dowels in two places.
・ Peel off the separator of LCD-REFLECTOR (C).	C	335-9151-00	1	Do not forget to peel off protective sheet. There is a mark to identify the protective sheet. (Front: 2 black lines, reverse side: light-blue)
・ Blow ionized air onto LCD-REFLECTOR (C) for dust removal, and then attach parts to LCD-HOLDER.	(C)	-------	(1)	Put the convex portion of LCD-REFLECTOR in the concave portion of LCD-HOLDER. LCD-REFLECTOR direction is specified.
・ Peel off protection sheet of both sides LCD (D).	D	379-1462-53	1	Do not forget to peel off protective sheet. There is a mark to identify the protective sheet. (Front: Yellow slash (thin), reverse side: Yellow slash (thick) Do not touch terminals. Supply the parts in the original package. (Terminal bending prevention.)
・ Blow ionized air onto LCD (D) for dust removal, and then attach parts to LCD-REFLECTOR.	(D)	-------	(1)	There should be no foreign material attached or mixed in. There should be no loose terminals.
・ Blow ionized air onto LCD-COVER (E) for dust removal, and then attach parts to SW-PWB.	E	331-5137-00	1	

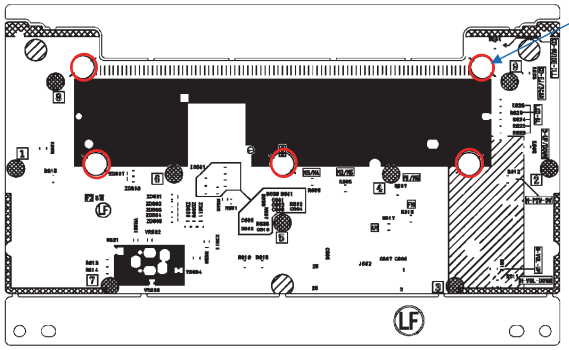
TOOLS		JIGS			
①	Ionizer	④		①	PWB support
②		⑤		②	
③		⑥		③	
④					
EQUIPMENT					
①	Ionized blower (gun type)				

Process name
PWB process (1)

77-3378-B7-01

ASSEMBLY INSTRUCTIONS / PN-3378I-E / SW PWB (2)

Process drawing



Note 1) Use the ionizer.
Note 2) Handle PWB from the edge to avoid touching parts.

Procedure

Contents of process	No.	Parts Number	Qty
・ Remove processed SW-A-PWB-ASSY from jig ①. Attach processed SW-A-PWB-ASSY to jig ②.			
・ Lock the cover of the tab twisting jig after checking that the LCD holder is not raised.			
・ Check that the button is illuminated. Push start button on. ⇒ automatic operation tab twisting starts. → LCD-COVER: 5 tabs			
・ After tab twisting, check that the OK-LED button is lit. Open the cover of jig.			
・ Remove processed SW-PWB from jig ①.			

Control Points

There should be no raised LCD-HOLDER.
START button should illuminate.

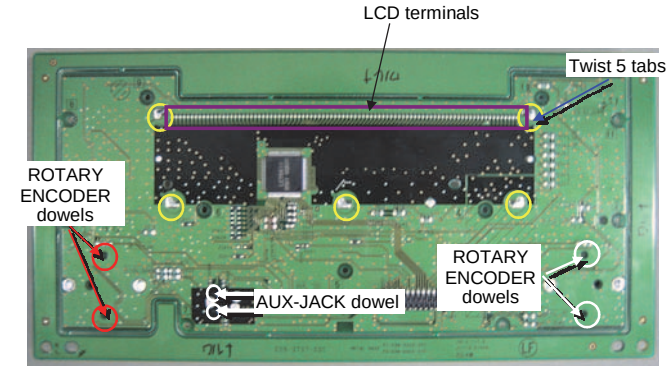
TOOLS		JIGS			
①	Ionizer	②	Tab twisting driver (right 30°)	①	PWB support
②			Tab twisting driver (left 30°)	②	Tab twisting jig (SW big)
③		③			Tab twisting jig
④					
⑤					
⑥					

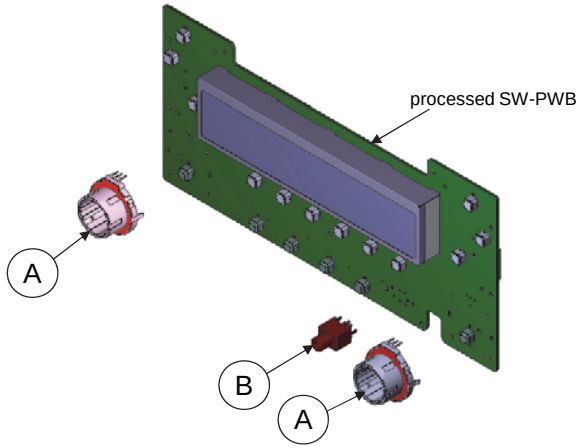
Process name
PWB process (2)

77-3378-B7-02

ASSEMBLY INSTRUCTIONS / PN-3378I-E / SW PWB (3)

Process drawing





Note 1) Use the ionizer.
Note 2) Handle PWB from the edge to avoid touching parts.

Procedure

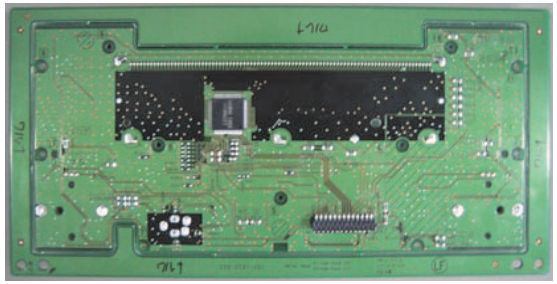
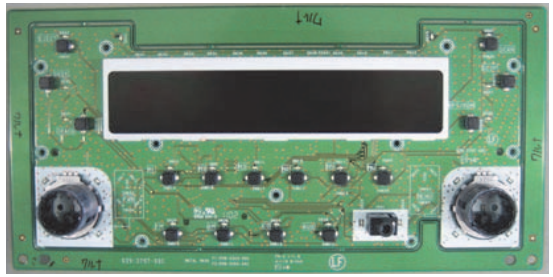
Contents of process	No.	Parts Number	Qty	Control Points
・ VISUAL CHECK. → Check the tab twisting in 5 places from the solder side. (Automatic tab twisting.) → Confirm 88 LCD terminals.				Twist tabs according to the silk print. There should be no loose or bent terminals.
・ Attach SW-PWB to jig ①. (Face the solder side downward.) Turn PWB locks (in 6 places) and hold down PWB.				
・ ROTARY ENCODER (A) *Insertion only	A	016-7006-00	2	LCD-REFLECTOR direction is specified. Fit dowels in 2 places. Supply the parts in the original package. (Terminal bending prevention.)
・ AUX-JACK *Insertion only	B	075-0395-01	1	LCD-REFLECTOR direction is specified. Fit dowels in 2 places. Supply the parts in the original package. (Terminal bending prevention.)

Sub material		TOOLS		JIGS	
①		①	Ionizer	①	Mask pallet (SW big)
②		②			
③		③		②	
④		④			
⑤		⑤		③	
⑥		⑥			

Process name
PWB process (3)

77-3378-B7-03

ASSEMBLY INSTRUCTIONS / PN-3378I-E / SW PWB (4)

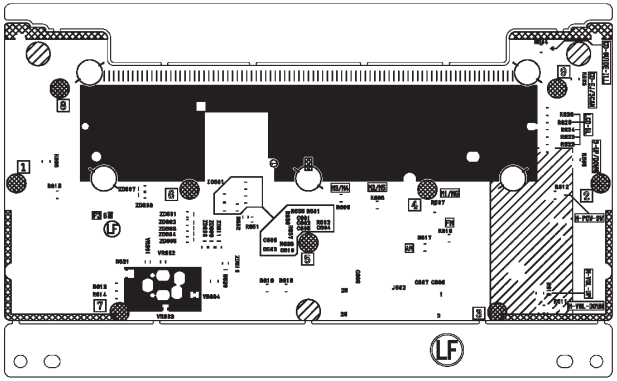
Process drawing	Procedure				Control Points
	Contents of process	No.	Parts Number	Qty	
 	★While MAIN-PWB is on jig ①. <Dip soldering> ・ Place jig ② and jig ③ on component side of processed SW-PWB, and put it in dipping pot. ・ Dip once without auto cutting process and without cleaning.				

Sub material		TOOLS		JIGS	
①	Solder (lead free type)	①	Ionizer	①	Mask pallet (SW big)
②	Post flux (non-washing type)	②		②	Dip parts holding jig (SW big)
③		③		③	Mask pallet cover (220)
EQUIPMENT		④			
①	Auto soldering machine	⑤			
		⑥			

Process name			77-3378-B7-04
PWB process (4)			

ASSEMBLY INSTRUCTIONS / PN-3378I-E / SW PWB (5)

Process drawing



Note 1) Use the ionizer.
Note 2) Handle PWB from the edge to avoid touching parts.

Procedure

Contents of process	No.	Parts Number	Qty
<Check and correction> ・ Remove jig ③ and jig ② from processed SW-PWB. Remove processed SW-PWB from jig ①. ・ Place SW-PWB on jig ④ and jig ⑤. (Face the soldering side upward) ・ Check and correction (soldering side) → Check soldering state.			

Control Points

Use jig ⑥.
There should be no soldering bridge,
miss-soldering, pin hole or solder projections.

Sub material	
①	Solder spool (lead free type)
②	
③	

TOOLS	
①	Soldering iron FM2026 (370 ± 30℃) N2 station FX-791 (2.5L / min) Nitrogen gas generator FX-780 Temperature regulator FX-951
②	Ionizer

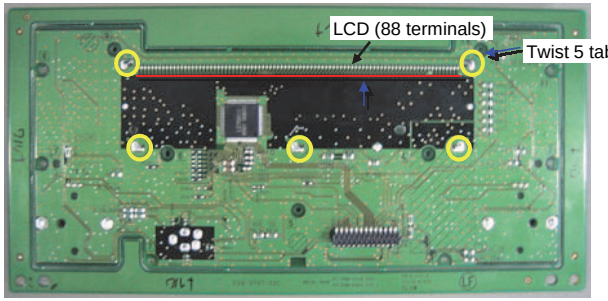
JIGS			
④	PWB support	①	Mask pallet (SW big)
⑤	Inclination rotation base	②	Dip parts holding jig (SW big)
⑥	For correction masking cover (SW big)	③	Mask pallet cover (220)

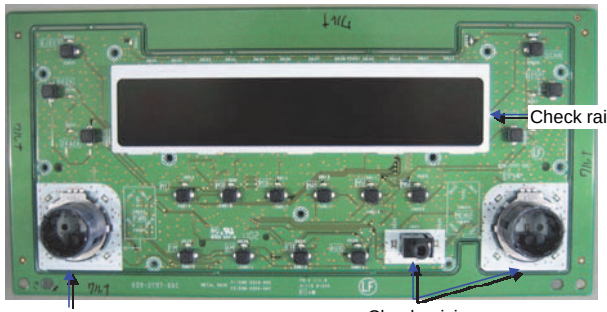
Process name
PWB process (5)

77-3378-B7-05

ASSEMBLY INSTRUCTIONS / PN-3378I-E / SW PWB (6)

Process drawing





Note1) Use the ionizer.
Note2) Handle PWB from the edge to avoid touching parts.

Procedure

Contents of process	No.	Parts Number	Qty	Control Points
・ Visual check 1) Check for loose leads. → LCD: 88 terminals 2) Check tab twisting. → LCD-COVER: 5 tabs				Make sure leads through the holes. Check tab untwisted.
・ After visual check, remove processed SW-PWB from jigs ① and ②. Attach SW-PWB to jigs ① and ② again. (Face the component side upward) ・ Check and correction (parts side) 1) Check for raising → LCD-HOLDER → ROTARY ENCODER → AUX-JACK				There should be no raised parts.
・ After visual check (component side), remove processed SW-PWB from jigs ① and ②. ・ Picture inspection.				
・ Apply protective sheet to front side of LCD.				Only apply to parts that are OK in the picture inspection.

TOOLS	
①	Soldering iron FM2026 (370 ± 30℃) N2 station FX-791 (2.5L / min) Nitrogen gas generator FX-780 Temperature regulator FX-951
②	Loupe (×10)
③	Tape cutter
④	Ionizer
⑤	

Sub material	
①	Solder spool (lead-free type)
②	Protection sheet
③	

JIGS			
④		①	PWB support
⑤		②	Inclination rotation base
⑥		③	

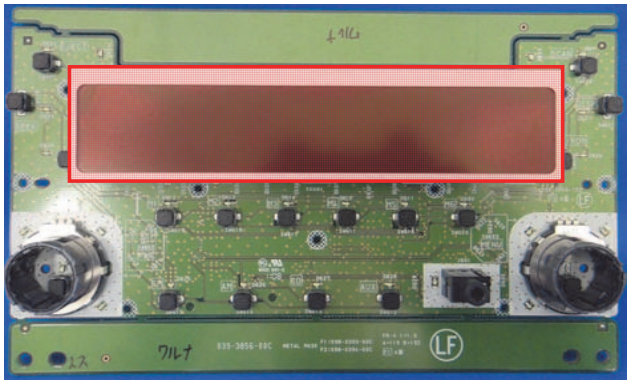
Process name
PWB process (6)

77-3378-B7-06

ASSEMBLY INSTRUCTIONS / PN-3378I-E / SW PWB (7)

Repair prohibited parts

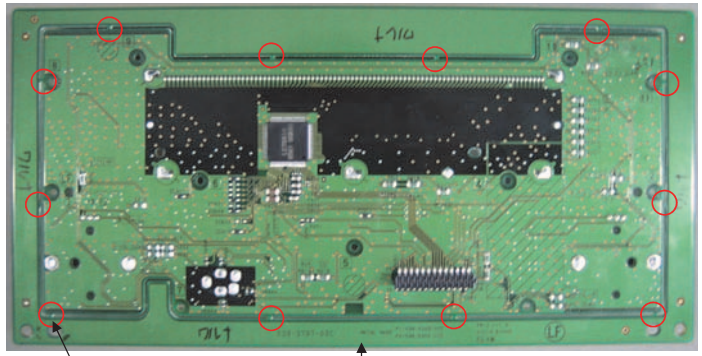
• LCD
⇒Lead type part and multi terminal through hole.
Concerning these parts, as the quality after repair cannot be ensured, repair is prohibited.



Working name	
Repair guide line (SW)	77-3378-B7-80

ASSEMBLY INSTRUCTIONS / PN-3378I-E / PANEL (1)

Process drawing



Note 1) Use the ionizer.
Note 2) Handle PWB from the edge to avoid touching parts.

Procedure

Contents of process	No.	Parts Number	Qty	Control Points
・ Cut SW-A-PWB (A). 1) Set SW-PWB on jig ①. 2) Push start button on equipment ① → ON → PWB cutting starts: AUTOMATIC 3) After completing the cut, remove SW-PWB from jig ①.	A	-------	1	(3378B7-77) Cut 12 portions.
・ Apply air-blow to SW-PWB.				Apply air-blow to both sides of SW-PWB.

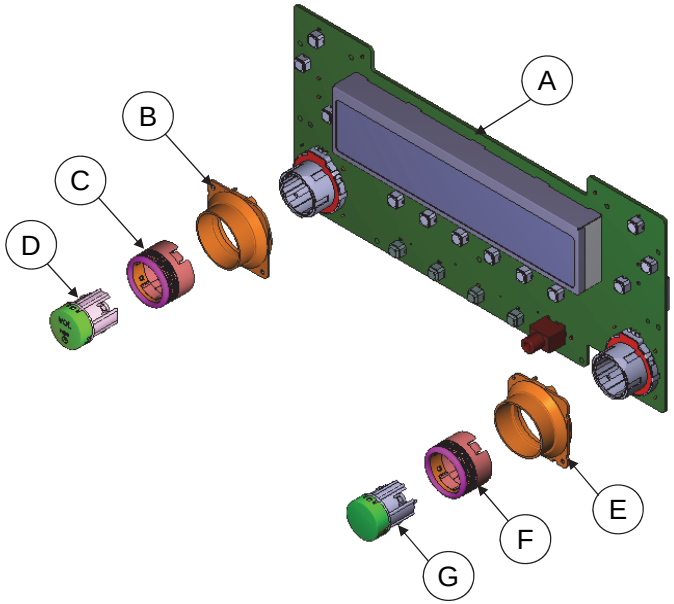
Sub material		TOOLS		JIGS	
①		①	Ionizer	①	PWB cutting support (SW big) Work range extension jig of Y-axis for RK Raising and extension table jig of Y-axis
②		②	Air-gun		
③		③			
④		EQUIOMENT			
⑤		①	Auto PWB cutting machine		
⑥					

Process name
ESCUTCHEON process (1)

45-3378-C0-01

ASSEMBLY INSTRUCTIONS / PN-3378I-E / PANEL (2)

Process drawing



Note 1) Use the ionizer.
Note 2) Handle PWB from the edge to avoid touching parts.

Procedure

Contents of process	No.	Parts Number	Qty	Control Points
・Peel off the protection sheet of SW-PWB (A) (LCD portion). Carry out the visual check of the inside of LCD, and then apply air-blow to both sides of SW-PWB. Set to jig ①. (Face soldering side downward.)	A	--------	(1)	Discard protective sheet. There should be no scratches, stains or dust. Apply air-blow to both sides of SW-PWB. Do not touch the parts of SW-PWB and LCD.
・Attach ILLUMI RING [L] (B), KNOB-ASSY (C) and BUTTON-ASSY [L] (D) on ROTARY ENCODER [LEFT SIDE] of SW-PWB.	(A) B C D	-------- 335-9147-00 947-0835-00 947-0788-02	(1) 1 1 1	 Attach according to silk print. “C”: Fit tabs in 3 places. “D”: Fit tabs in 4 places, and fit a dowel in 1place.
・Attach ILLUMI RING [R] (E), KNOB-ASSY (F) and BUTTON-ASSY [R] (G) on ROTARY ENCODER [RIGHT SIDE] of SW-PWB.	(A) E F G	-------- 335-9148-00 947-0835-00 947-0789-02	(1) 1 1 1	 Attach according to silk print. “F”: Fit tabs in 3 places. “G”: Fit tabs in 4 places, and fit a dowel in 1place.

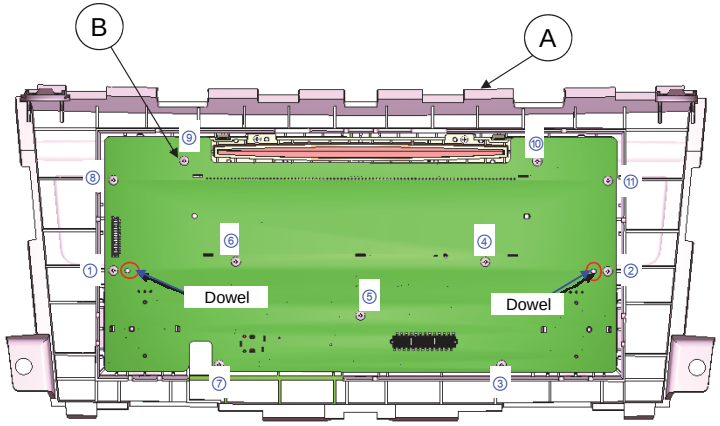
Sub material		TOOLS		JIGS	
①		①	Ionizer	①	Illumi ring attachment support (SW big)
②		②	Air-gun	②	
③		③		③	
④		④			
⑤		⑤			
⑥		⑥			

Process name
ESCUTCHEON process (2)

45-3378-C0-02

ASSEMBLY INSTRUCTIONS / PN-3378I-E / PANEL (3)

Process drawing



Note 1) Use the ionizer.
Note 2) Handle ES from the edge.

<Difference table>

Assy name	A: ES-ASSY
45-3378-B0	940-8624-01
45-3378-C0	940-8624-03

Procedure

Contents of process	No.	Parts Number	Qty	Control Points
・ Take ES-ASSY (A) from poly-bag. After visual check appearance, set ES-ASSY (A) on jig ①. (Face front side of ESCUTCHEON downward) (See difference table.)	A	See different table.	1	There should be no scratches, stains or paint failure.
・ Remove processed SW-PWB from jig ①. Attach processed SW-PWB (Face component side downward) according to the AUX-JACK and ILLUMI RING of ES-ASSY.				Fit dowels in 2 places.
・ Attach jig ② on soldering side of SW-PWB and fix with SPECIAL SCREW (B).	B	716-0778-52	11	Tighten in the order of ①→⑪. Jig ② tightening sequence is specified.
・ Remove jig ② from SW-PWB. Remove processed ES-ASSY from jig ①.				

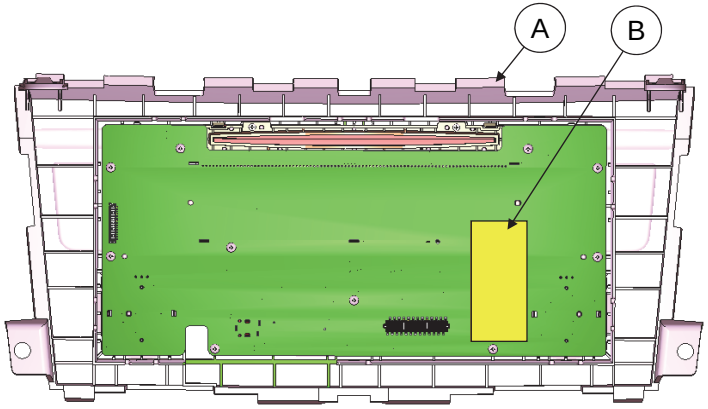
Sub material		TOOLS		JIGS	
①		①	Ionizer	①	ES support (ES big)
②		②	Electric screw driver (0.33 ± 0.02 N · m)	②	For tightening template (ES big)
③		③		③	
④		④			
⑤		⑤			
⑥					

Process name
ESCUTCHEON process (3)

45-3378-C0-03

ASSEMBLY INSTRUCTIONS / PN-3378I-E / PANEL (4)

Process drawing



Note 1) Use the ionizer.
Note 2) Handle ES from the edge.

Procedure

Contents of process	No.	Parts Number	Qty	Control Points
・ Attach processed ES-ASSY (A) to jig ①. (Face front of ES-ASSY downward.)	A	--------	(1)	
・ Check the quantity of screws. → SW-PWB fixing screws: 11 screws				There should be no missing or raised screws.
・ Peel off the separator of CUSHION RUBBER (B). Apply it to soldering side of SW-PWB of processed ES-ASSY (A).	B	345-8090-00	1	Push RUBBER PART and apply it firmly according to silk print. There should be no raised and no peeling parts.

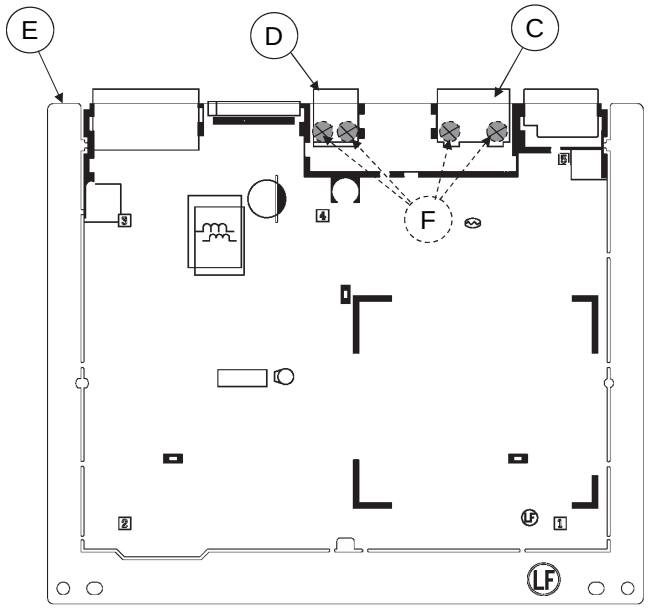
Sub material		TOOLS		JIGS	
①		①	Ionizer	①	ES support (ES big)
②		②		②	
③		③		③	
④		④			
⑤		EQUIOMENT			
⑥		①			

Process name
ESCUTCHEON process (4)

45-3378-C0-04

ASSEMBLY INSTRUCTIONS / PN-3378I-E / MAIN PWB (1)

Process drawing



Note 1) Use the ionizer.
Note 2) Handle PWB from the edge to avoid touching parts.

<Difference table>

ASSY NAME	E: MAIN-A-PWB
75-3378-C7	75-3378-C9
75-3378-E7	75-3378-E9
75-3378-F7	75-3378-F9

Procedure

Contents of process	No.	Parts Number	Qty	Control Points
<Pre-process>				
・ Cut leads				
1) THERMISTOR	A	002-0229-00	1	Use jigs ① and ②.
2) COIL	B	010-8049-00	1	Use jigs ① and ⑤.
<PRE-ATTACHMENT>				
・ Cut leads				
1) OUTLET SOCKET (TH16)	C	074-1302-16	1	Use jigs ① and ③. Supply the parts in the original package (terminal bending prevention).
1) OUTLET SOCKET (TH08)	D	074-1302-08	1	
・ Attach processed OUTLET SOCKETS (×2) on jig ④, and then attach MAIN-A-PWB-ASSY (E) on jig ④.	E	See difference table	1	
・ Check insertion condition of OUTLET SOCKET terminals (×2), and then secure OUTLET SOCKETS with TAP SCREWS (F).	F	778-3006-00	4	There should be no bent or loose terminals.
・ Remove processed MAIN-PWB from jig ④.				

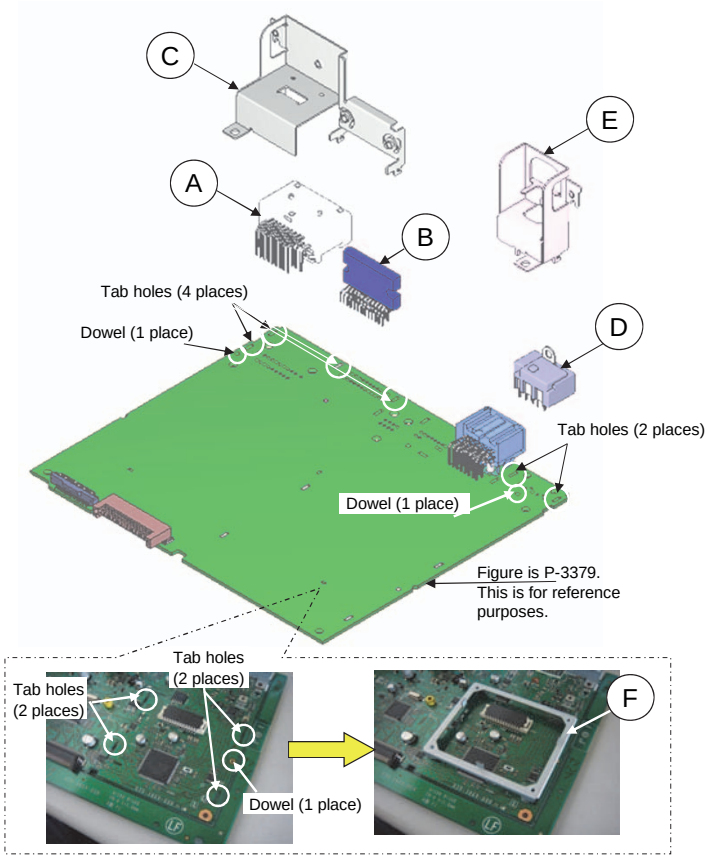
Sub material				Jigs	
①		④	TH-connector tightening jig	①	Leads cutting jig
②		⑤	Template	②	Leads cutting template
Tools		⑥		③	Leads cutting template
①	Electric screw driver (0.55 ± 0.05 N・m)				
②	Ionizer				
③					

Process name
PWB process (1)

75-3378-F7-01

ASSEMBLY INSTRUCTIONS / PN-3378I-E / MAIN PWB (2)

Process drawing



Note 1) Use the ionizer.
Note 2) Handle PWB from the edge to avoid touching parts.

Procedure

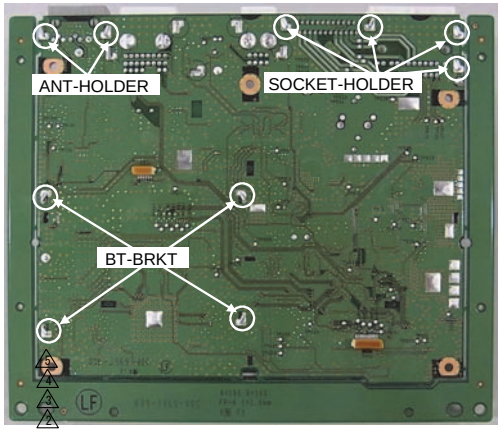
Contents of process	No.	Parts Number	Qty	Control Points
<PRE-ATTACHMENT> ・ Place MAIN-PWB on jig ①.				
・ Cut leads 1) OUTLET SOCKET [TH18] (A)	A	074-4009-20	1	Use jigs ② and ③. Supply the parts in the original package (terminal bending prevention). Cut leads while holding parts.
・ Insert the following parts. 1) Preprocessed OUTLET SOCKET [TH18] (A)	(A)	-------	(1)	
2) POWER-IC [TB2946HQ] (B)	B	051-2067-00	1	Supply the parts in the original package (terminal bending prevention).
3) SOCKET-HOLDER (C)	C	331-5153-00	1	Attach the socket-holder after inserting the outlet socket (TH18) and POWER-IC. Insert tabs in rectangular holes of MAIN-PWB in 4 places. Insert dowel in round hole of MAIN-PWB in 1 place. Fit dowels of OUTLET SOCKET (TH18) in 2 places.
4) ANT [GT13] (D)	D	092-2210-01	1	Fit dowels in 2 places.
5) ANT-HOLDER (E)	E	331-4676-00	1	Insert tabs in rectangular holes of MAIN-PWB in 2 places. Insert dowel in round hole of MAIN-PWB in 1 place.
6) BT-BRKT (F)	F	331-5269-00	1	Insert tabs in rectangular holes of MAIN-PWB in 4 places. Insert dowel in round hole of MAIN-PWB in 1 place.

Sub material		Jigs			
①		①	Tab twisting driver (left 30 degrees)	①	Tab twisting jig (MAIN-PWB)
②		②	Leads cutting jig		Tab twisting jig
③		③	Leads cutting template		Tab twisting driver (right 30 degrees)
Tools					
①	Ionizer				
②					

Process name
PWB process (2)

75-3378-F7-02

ASSEMBLY INSTRUCTIONS / PN-3378I-E / MAIN PWB (3)

Process drawing	Procedure				Control Points
	Contents of process	No.	Parts Number	Qty	
	<PRE-ATTACHMENT> ・ Lock cover of auto tab-twisting jig. ・ Check that the START button illuminates and then turr the START button on.→ automatic operation tab torsion. → SOCKET-HOLDER ※Twist 4 tabs → Processed ANT-HOLDER ※Twist 2 tabs → BT-BRKT ※Twist 4 tabs ・ After tab twisting is complete, check that the OK-LED buttor illuminates. Open the cover of jig. ・ Remove processed MAIN-PWB from jig ①.				

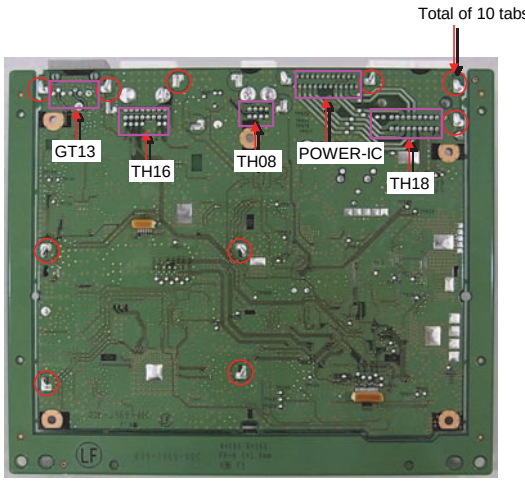
Note 1) Use the ionizer.
Note 2) Handle PWB from the edge to avoid touching parts.

Sub material		Jigs			
①		①	Tab twisting driver (left 30 degrees)	①	Tab twisting jig (MAIN-PWB)
②		②			Tab twisting jig
③		③			Tab twisting driver (right 30 degrees)
Tools					
①	Ionizer				
②					

Process name			
PWB process (3)			75-3378-F7-03

ASSEMBLY INSTRUCTIONS / PN-3378I-E / MAIN PWB (4)

Process drawing



Note 1) Use the ionizer.
Note 2) Handle PWB from the edge to avoid touching parts.

Procedure

Contents of process	No.	Parts Number	Qty
<PRE-ATTACHMENT> ・ VISUAL CHECK. → From the solder side, check the tabs in 10 places (automatic twisting tab). ・ When fixing POWER-IC with jig ①, position IC at upper end of tab of IC-HOLDER. ・ Check for loose leads. 1) OUTLET SOCKET (TH18) 20 terminals 2) OUTLET SOCKET (TH16) 16 terminals 3) OUTLET SOCKET (TH08) 8 terminals 4) ANT (GT13) 3 terminals 5) POWER-IC 25 terminals			

Control Points

Twist tabs according to the silk print.

Do not cover 2 screw holes. Fix IC securely.

There should be no loose or bent leads.

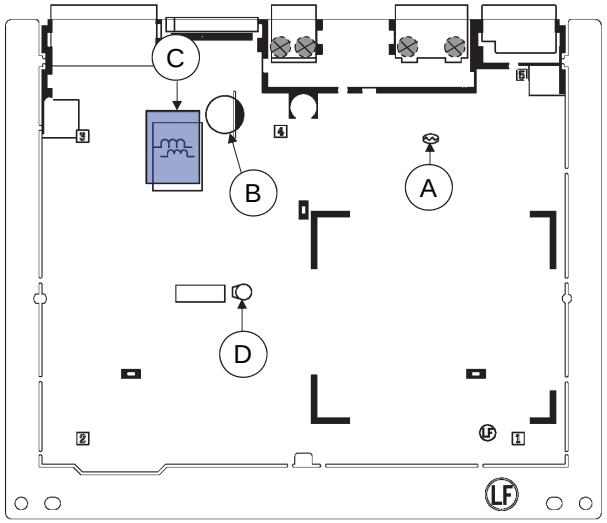
Sub material		Tools		Jigs	
①		①	Ionizer	①	POWER-IC fixing jig
②		②		②	
③		③		③	
④		④			
⑤		⑤			
⑥		⑥			

Process name
PWB process (4)

75-3378-F7-04

ASSEMBLY INSTRUCTIONS / PN-3378I-E / MAIN PWB (5)

Process drawing



Note 1) Use the ionizer.
Note 2) Handle PWB from the edge to avoid touching parts.

Procedure

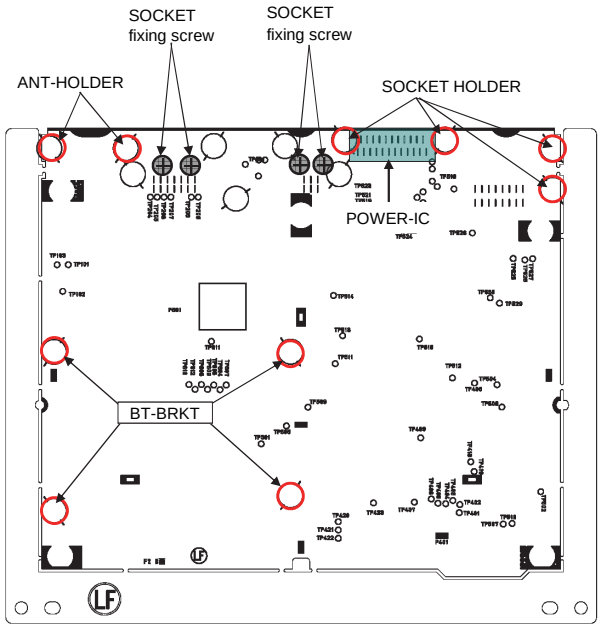
Contents of process	No.	Parts Number	Qty	Control Points
<PRE-ATTACHMENT>				
・ Place MAIN-PWB on jig ①. (The solder side faces downward.) Turn and hold down PWB locks in 6 places.				
・ Insert the following parts.				
1) Pre-processed THERMISTOR (A)	A	--------	(1)	
2) SPECIAL-C [16-3300] (B)	B	042-1717-00	1	Pay attention to polarity. (Insert according to silk print.)
3) Pre-processed COIL (C)	C	--------	(1)	Insert in L501.
4) TRIMMER (D)	D	004-1580-14	1	Pay attention to polarity. (Insert according to silk print.)
<Dip soldering>				
・ Place jig ② and jig ③ on component side of processed MAIN-PWB, and put it in dipping pot.				
・ Dip once, without auto cutting process and without cleaning.				

Sub material		Tools		Jigs	
①	Solder (lead free type)	①	Ionizer	①	Mask pallet (MAIN)
②	Post flux (non-washing type)	②		②	Dip parts holding jig (MAIN big)
③		③		③	Mask pallet cover (220)
④		④			
⑤		FACILITIES			
⑥		①	Auto soldering machine		

Process name
PWB process (5)

75-3378-F7-05

ASSEMBLY INSTRUCTIONS / PN-3378I-E / MAIN PWB (6)

Process drawing	Procedure	Control Points
	Contents of process	
	<ADDITIONAL PROCESS> ・ Remove jig ③ and jig ② from processed MAIN-PWB. Take processed MAIN-PWB from jig ①.	
	・ Place MAIN-PWB on jig ④ and jig ⑤. (Face the soldering side upward)	
	・ Check and correction (soldering side) → Check soldering state.	Use jig ⑥. There should be no soldering bridge, miss-solder, pin-hole and icicle.
	・Check leads cutting size → Slide jig ⑦ according to the solder side of MAIN-PWB and check that the leads and soldering protruding part of QFP back side are not touched.	Maximum lead length 2.6 mm Not ok UNITS shall be rejected and sent to repair process. (Do not cut leads during this process.)
	・ VISUAL CHECK. 1) Check for loose leads. → POWER-IC: 25 terminals	Use jig ⑧. There should be no loose leads.
	2) Tab untwisted. → SOCKET HOLDER: 4 portions → ANT-HOLDER: 2 portions → BT-BRKT: 4 portions	There should be no untwisted tabs.
	3) Check for missing screws. → OUTLET fixing screw: 4 screws	There should be no missing screws.
	・ After visual check, remove MAIN-PWB from jig ④ and jig ⑤.	

Note 1) Use the ionizer.
Note 2) Handle PWB from the edge to avoid touching parts.

Sub material	
①	Solder spool (lead-free type)
②	

Tools	
①	Ionizer
②	Soldering iron FM2026 (350 ± 30℃) N2 station FX-791 (2.5L / min) Nitrogen gas generator FX-780 Temperature regulator FX-951
③	Loupe (×10)

Jigs	
④	PWB support
⑤	Inclination rotation base
⑥	For correction masking cover (MAIN)
⑦	Leads cutting size check jig
⑧	Template for confirmation

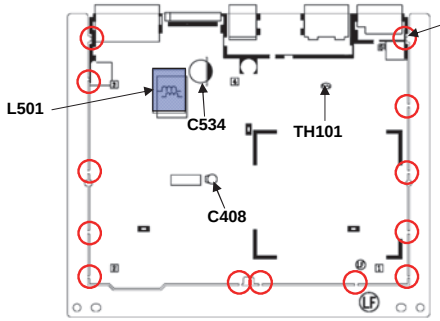
Jigs	
①	Mask pallet (MAIN)
②	Dip parts holding jig (MAIN big)
③	Mask pallet cover (220)

Process name
PWB process (6)

75-3378-F7-06

ASSEMBLY INSTRUCTIONS / PN-3378I-E / MAIN PWB (7)

Process drawing



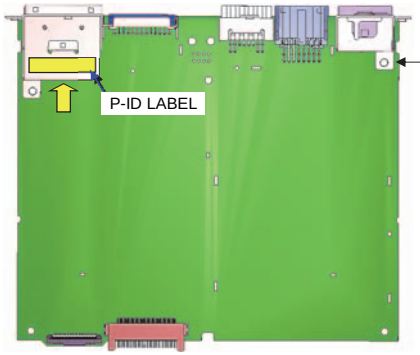


Figure is P-3379.
This is for reference purposes.

Note 1) Use the ionizer.
Note 2) Handle PWB from the edge to avoid touching parts.

<Difference table>

ASSY NAME	(MODEL NAME)	MODEL NO.	MODEL CODE
75-3378-C7	(PN-3378I-C)	PN3378IC	A1
75-3378-E7	(PN-3378I-C)	PN3378IC	A1
75-3378-F7	(PN-3378I-D)	PN3378ID	B5

Procedure

Contents of process

<ADDITIONAL PROCESS>

- Attach MAIN-PWB on jigs ① and ②. (Face the parts side upward.)

- Check and correction (parts side)
  1) Check polarity.
     → SPECIAL-C (C534)
     → TRIMMER (C408)

  2) Check missing parts
     → THERMISTOR (TH101)

  3) Check for raised parts.
     → COIL (L501)

- Peel off printed P-ID LABEL from sheet.
  Apply printed P-ID LABEL on the SOCKET-HOLDER.

- Remove MAIN-PWB from jig ① and jig ②.

- Cut MAIN-PWB.
  1) Set MAIN-PWB onto jig ③.

  2) Push the start button of equipment → ON
     → Start PWB cutting: AUTOMATIC

  3) After completing the cut, remove MAIN-PWB from jig ③.

- Apply air-blow to MAIN-PWB.

Control Points

Use jigs ① and ②.

Pay attention to the polarity.

There should be no missing parts.

There should be no floating.

MODEL NO. → See difference table.
MODEL CODE → See difference table.
Apply it so that it can be read
from the direction of the arrow mark.

Only parts that are OK according to the IBT inspection should be cut.

Cut 13 portions.

Apply air-blow to both sides of MAIN-PWB.

Tools	
①	Ionizer
②	Air-gun
③	

Jigs	
①	PWB support
②	Inclination rotation base
③	PCB cutting support (MAIN)

Sub material	
①	
②	
③	

FACILITIES	
①	AUTO PCB CUTTING MACHINE

Process name

PWB process (7)

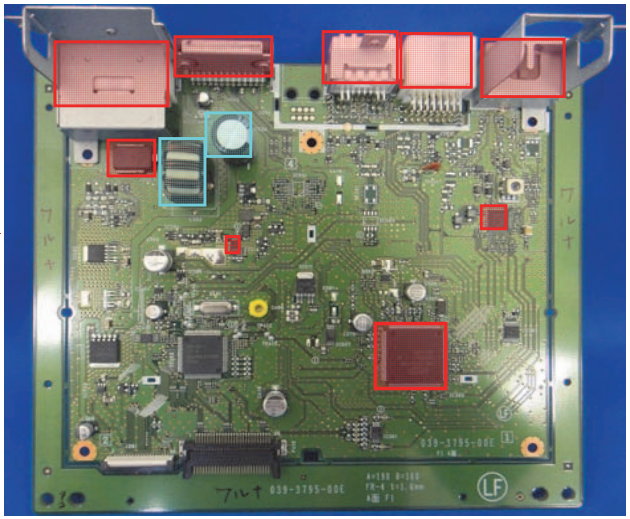
75-3378-F7-07

ASSEMBLY INSTRUCTIONS / PN-3378I-E / MAIN PWB (8)

Repair-prohibited parts

・ Outlet socket, ANT
・ Power-IC
⇒Lead type part and multi terminal through hole
・ QFP/SOP
⇒There is a thermal pad on the lower surface of the part.

Concerning these parts, as the quality after repair cannot be ensured, repair is prohibited.

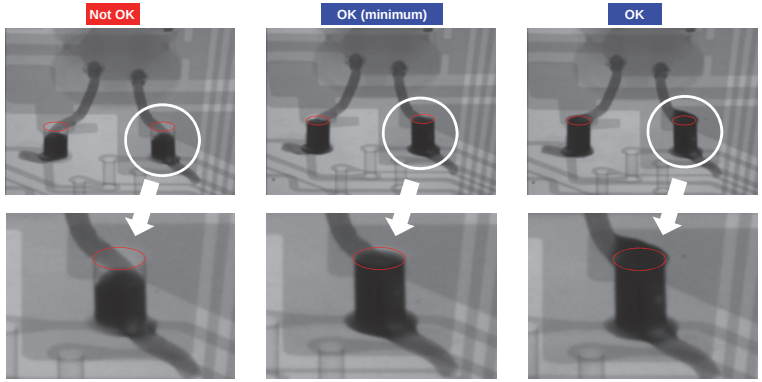


Conditional repairable parts

• Electrolytic capacitor
• Coil
⇒ After repair, the through hole soldering condition cannot be checked.

Concerning these parts, repair will be approved by carrying out verification by X-ray of the through-hole soldering condition after repair.
For soldering condition level judgment criteria, refer to the following.

■Through hole soldering condition level judgment criteria by X-ray



Working name	
Repair guidelines (main)	75-3378-F7-80

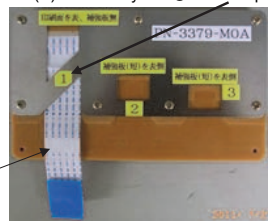
ASSEMBLY INSTRUCTIONS / PN-3378I-E / UNIT (1)

Process drawing & Procedure

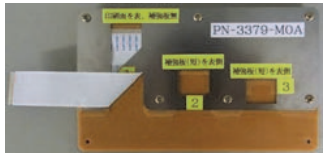
No.	Parts Number	Qty	
A	816-3064-05	1	Use jig ①. Insert flat wire all the way into the jig securely.

・ FLAT WIRE folding

1) With the reinforcement plate removed, securely insert the flat wire (A) all the way into① with the printed surface facing up.



2) Remove after folding along jig.

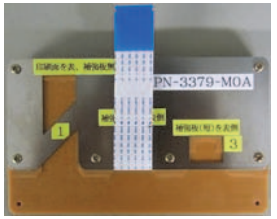


Insert flat wire all the way into the jig securely.

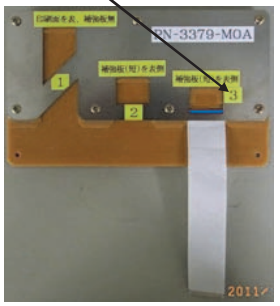
3) Insert the reinforcement plate (short) of flat wire in ② of jig.

Insert flat wire all the way into the jig securely.

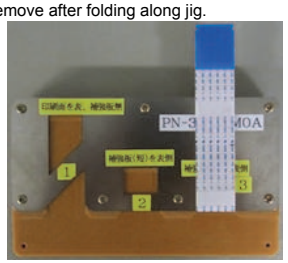
4) Remove after folding along jig.



5) Insert the reinforcement plate (short) of flat wire in ③ of jig.
Insert flat wire all the way into the jig securely.



6) Remove after folding along jig.



7) Bend FLAT WIRE in the direction specified by hand (3 points).

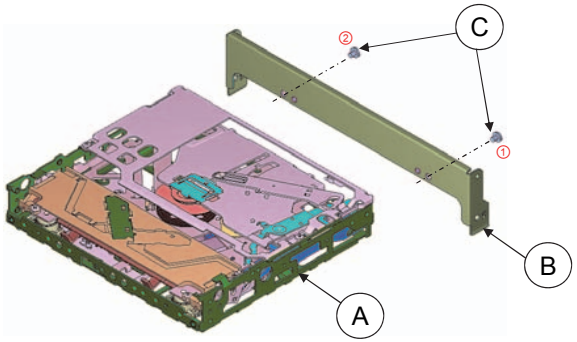
Sub material		TOOLS		JIGS	
①		①		①	FFC folding jig
②		②		②	
③		③		③	
④		④			
⑤		⑤			
⑥		⑥			

Process name
FLAT WIRE process

PN-3378I-E-01

ASSEMBLY INSTRUCTIONS / PN-3378I-E / UNIT (2)

Process drawing



Note 1) Use the ionizer.
Note 2) Handle CD-MECH from the edge to avoid touching parts.

Fig. 1

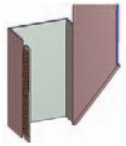
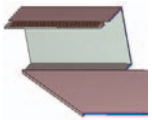
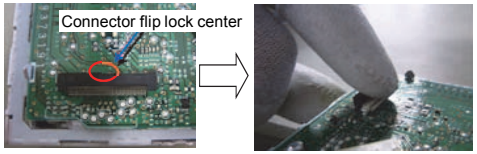


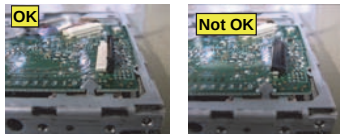
Fig. 2



Procedure

Contents of process	No.	Parts Number	Qty	Control Points
・ Take CD-MECH (A) from poly-bag.	A	929-5150-81	1	Flat cables (2 pieces) are held under the CD-MECH plate.
・ Place CD-MECH on jig ②. (The CD loading slot is facing downward, and MECH-PWB is facing toward you.) Visually check springs of rear and FFC of MECH-PWB.				The springs (2 pieces) of CD-MECH should not come out. The flat cables (in 2 places) should not come out.
・ Attach MECH-BRKT (B) on CD-MECH (A) and fix with MACHINE SCREW (C).	(A) B C	-------- 331-5138-00 714-2603-89	(1) 1 2	 Fit dowels in 2 places. Tighten in the order of ①→②.
・ Unlock connector flip lock of MECH-PWB side.				Open flip lock completely (90 degrees). After releasing connector clip, do not add any load (stress). Do not touch the parts.
・ Check the bending state of flat wire. 1) Place as shown in Fig. 1.				Use jig ①. Flat cable should fit in concave shape of the jig (riding is not OK).
2) Remove flat wire from jig ①.				
3) Place on jig ① as shown in Fig. 2.				Flat cable should fit in concave shape of the jig (riding is not OK).
4) Take flat wire out from jig ①.				



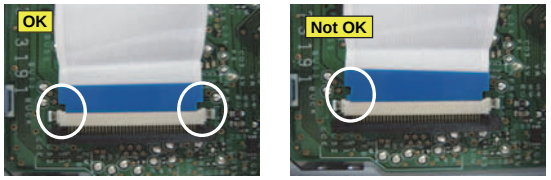
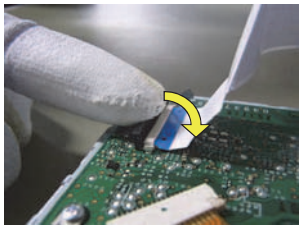
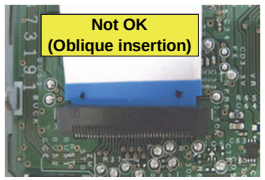
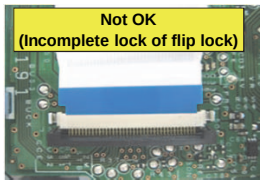


Sub material		TOOLS		JIGS	
①		①	Ionizer	①	FFC folding check jig
②		②	Electric screwdriver (0.4 ± 0.04 N·m)	②	GS-1 MECH processing jig
③		③		③	
④		④			
⑤		⑤			
⑥		⑥			

Process name
CD-MECH process(1)

PN-3378I-E-02

ASSEMBLY INSTRUCTIONS / PN-3378I-E / UNIT (3)

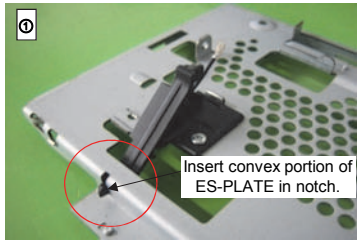
Process drawing	Procedure				Control Points
	Contents of process	No.	Parts Number	Qty	
	・ Moisten a dust-free cloth in alcohol and clean the terminal part of processed flat wire. ・ Insert processed FLAT WIRE [CD-MECH side] in the connector of CD-MECH at the same time with both hands.				There should be no foreign matter in terminal part. Insert it all the way in securely. Check that FFC cutout is aligned with connector edges. Oblique insertion is not OK.
	・ Push center of connector flip lock with finger, and then lock.				Push to lock until a click sound is heard. Fit connector flip lock with FFC concave portion.
  	・ Check inserted condition, and then remove processed CD-MECH. Note 1) Use the ionizer. Note 2) Handle CD-MECH from the edge to avoid touching parts.				There should be no oblique insertion, incomplete insertion, or incomplete connector lock.

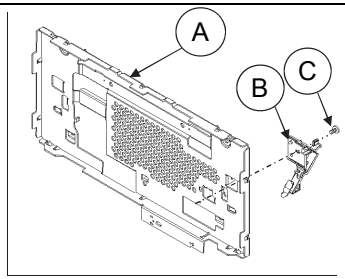
Sub material		TOOLS		JIGS	
①	Alcohol	①	Ionizer	①	
②		②	FFC cleaner	②	
③		③	Cloth	③	
④		④			
⑤		⑤			
⑥		⑥			

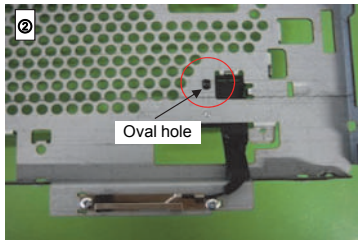
Process name			
CD-MECH process(2)			PN-3378I-E-03

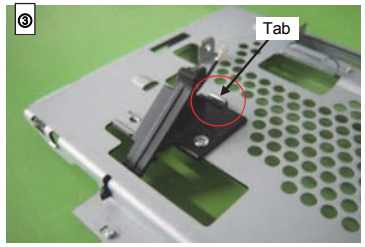
ASSEMBLY INSTRUCTIONS / PN-3378I-E / UNIT (4)

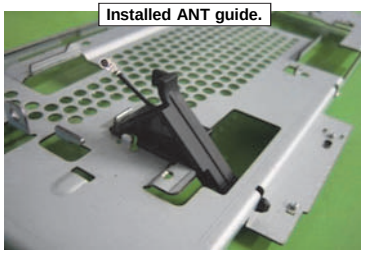
Process drawing











Note 1) Use the ionizer.
Note 2) Handle PWB from the edge to avoid touching parts.

Procedure

Contents of process	No.	Parts Number	Qty	Control Points
・ Attach ES attachment side of ES-PLATE (A) to jig ①. (Faces ES attachment side downward.)	A	309-1948-00	1	
・ ANT-GUIDE attachment.				
1) Put ANT-GUIDE (B) through the rectangular hole of ES-PLATE. Insert convex portion of ANT-GUIDE (B) in notch. →See left view ①.	B	335-9220-00	1	Fit tabs in 2 places and a dowel in 1 place.
2) Insert dowel of ANT-GUIDE (B) in oval hole of ES-PLATE. →See left view ②.				There should be no raised parts.
3) Snap-fit ANT-GUIDE clip. →See left view ③.				
・ Secure ANT-GUIDE with SPECIAL SCREW (C).	C	716-3718-00	1	
・ Take processed ES-PLATE from jig ①.				

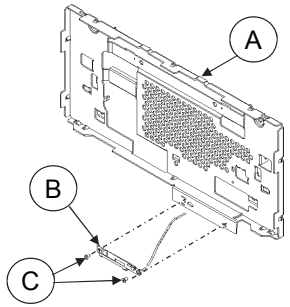
Sub material		TOOLS		JIGS	
①		①	Ionizer	①	BT-ANT/BT GUIDE attachment jig
②		②	Electric screwdriver (0.2 ± 0.04 N·m) *bit #1	②	
③		③		③	
④		④			
⑤		⑤			
⑥		⑥			

Process name
ES-PLATE process(1)

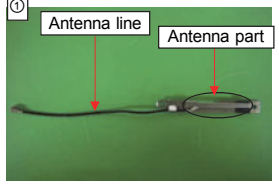
PN-3378I-E-04

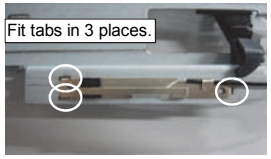
ASSEMBLY INSTRUCTIONS / PN-3378I-E / UNIT (5)

Process drawing

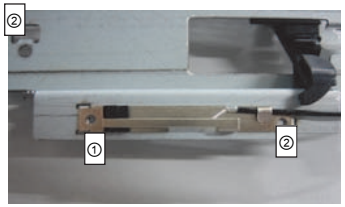


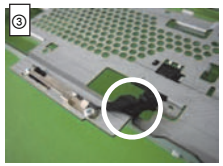
①





②





Note 1) Use the ionizer.
Note 2) Handle PWB from the edge to avoid touching parts.

Procedure

Contents of process	No.	Parts Number	Qty	Control Points
・ Attach ES attachment side of processed ES-PLATE (A) on jig ① again. (ES attachment side is top.)	A	--------	(1)	
・ Attach BT-ANT (B) to processed ES-PLATE (B). →See left view ①.	B	060-8122-10	1	Do not touch ANT portion of BT-ANT. Fit tabs in 3 places. Do not bend antenna line 90 degrees or more.
・ Close the template of jig ①. Secure BT-ANT with SPECIAL SCREW (C). →See left view ②.	C	716-1468-01	2	Tighten in the order of ①→②.
・ Open the template of jig ①. Remove processed ES-PLATE from jig ①.				
・ BT-ANT antenna line processing.				
1) Run BT-ANT through the ANT groove (R portion). →See left view ③.				
2) Push it into the clip inside jig ② while running BT-ANT through the groove of the ANT-GUIDE. →See left view ④.				
3) Run the BT-ANT through the tab of ANT-GUIDE. →See left view ⑤.				

Sub material	
①	
②	
③	

TOOLS	
①	Ionizer
②	Electric screwdriver (0.2 ± 0.04 N·m) *bit #0
③	
④	
⑤	

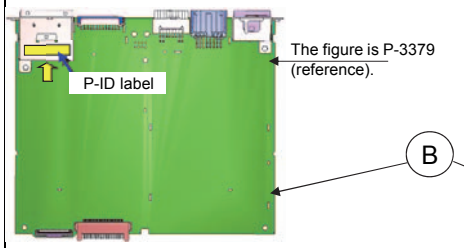
JIGS	
①	BT-ANT/BT GUIDE attachment jig
②	BT-ANT line processing jig
③	

Process name
ES-PLATE process(2)

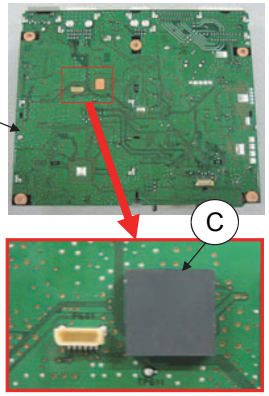
PN-3378I-E-05

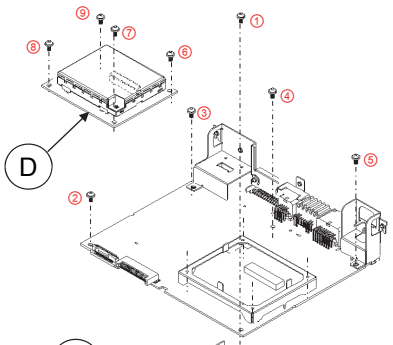
ASSEMBLY INSTRUCTIONS / PN-3378I-E / UNIT (6)

Process drawing



【Soldering side of MAIN-PWB.】





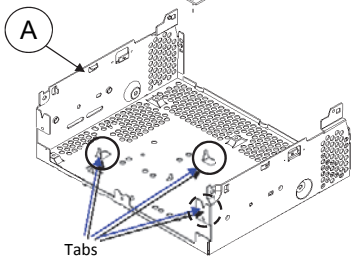


Fig. 1

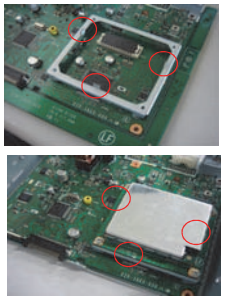
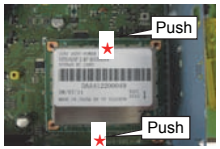


Fig. 2

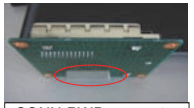


Note 1) Use the ionizer.
Note 2) Handle PWB from the edge to avoid touching parts.

Procedure

Contents of process	No.	Parts Number	Qty	Control Points
・Take out LOWER CASE (A), and set LOWER CASE on jig ①.	A	311-1993-00	1	
・Check P-ID LABEL of MAIN-PWB. → MODEL NO. + MODEL CODE (See difference table.)	B	See difference table.	1	
・Attach RUBBER PART (C) on soldering side of MAIN-PWB (B) (According to silk print).	(B) C	--------- 345-6653-00	(1) 1	Parts should not protrude from silk. RUBBER PART is number managed.
・Attach MAIN-PWB on LOWER CASE.	(A)	---------	(1)	Fit tabs of lower case to rectangular holes on MAIN-PWB in 3 places.
・Attach CONN-PWB-ASSY (D) to BT-BRKT of MAIN-PWB.	D (B)	See difference table. ---------	1 (1)	*See Fig. 1. Insert tabs of BT-BRKT to rectangular holes on CONN-PWB in 3 places.
・Push BT-MODULE connector and MAIN-PWB connector, to connect.				Push ★ portion of CONN-PWB. Do not push BT-MODULE. *See Fig. 2 & Fig. 3.
・Attach jig ② on component side of MAIN-PWB and fix with SPECIAL SCREW (E).	(B) E	--------- 716-0878-50	(1) 9	Tightening sequence is specified on jig.
・Take jig ② from MAIN-UNIT.				
・Take jig ① from MAIN-UNIT.				

Fig. 3


CONN-PWB connector


MAIN-PWB connector

<Difference table>

MODEL NAME	MODEL NO.	MODEL CODE	B: MAIN-PWB	D: CONN-PWB
PN-3378I-C	PN3378IC	A1	75-3378-E7	79-3378-B7
PN-3378I-D	PN3378ID	B5	75-3378-F7	79-3378-C7
PN-3378I-E	PN3378IE	C6	75-3378-F7	79-3378-C7

TOOLS	
①	Ionizer
②	Electric screwdriver (0.4 ± 0.08 N·m)
③	*Long bit 80 mm or more
Sub material	
①	
②	

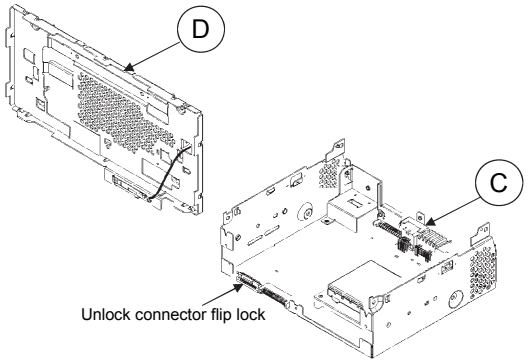
JIGS	
①	Set support
②	Tightening template (MAIN)
③	

Process name
MAIN-PWB attachment

PN-3378I-E-06

ASSEMBLY INSTRUCTIONS / PN-3378I-E / UNIT (7)

Process drawing



Note 1) Use the ionizer.
Note 2) Handle PWB from the edge of CD-MECH to avoid touching parts.

Fig. 1

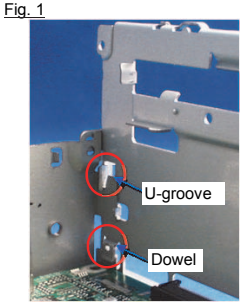
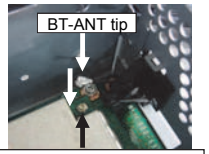


Fig. 2



Procedure

Contents of process	No.	Parts Number	Qty	Control Points
・ Unlock the lock of connector flip lock (MECH-PWB side) using tweezers.	C	------	(1)	Open clip completely (45 degrees). After releasing connector clip, do not add any load (stress).
・ Fit upper and lower tabs of processed ES-PLATE in U-CUT of LOWER-CASE (D), and then fix them at the same time.	D	------	(1)	Fit lower tabs (both sides) of ES-PLATE on LOWER-CASE, and then fit upper tabs in U-CUT portion at same time. *See Fig. 1.
・ Hold antenna leader in jig ②. Connect BT-ANT to connector of BT-MODULE side.				Do not push excessively when. *See Fig. 2.
・ Allow the slack portion of the antenna line to droop upwards.				

Allow slack without breaking ANT line at the base of the connector.

Do not allow upper part to protrude above the tab of the ANT guide.

The connector joint attachment direction is specified.

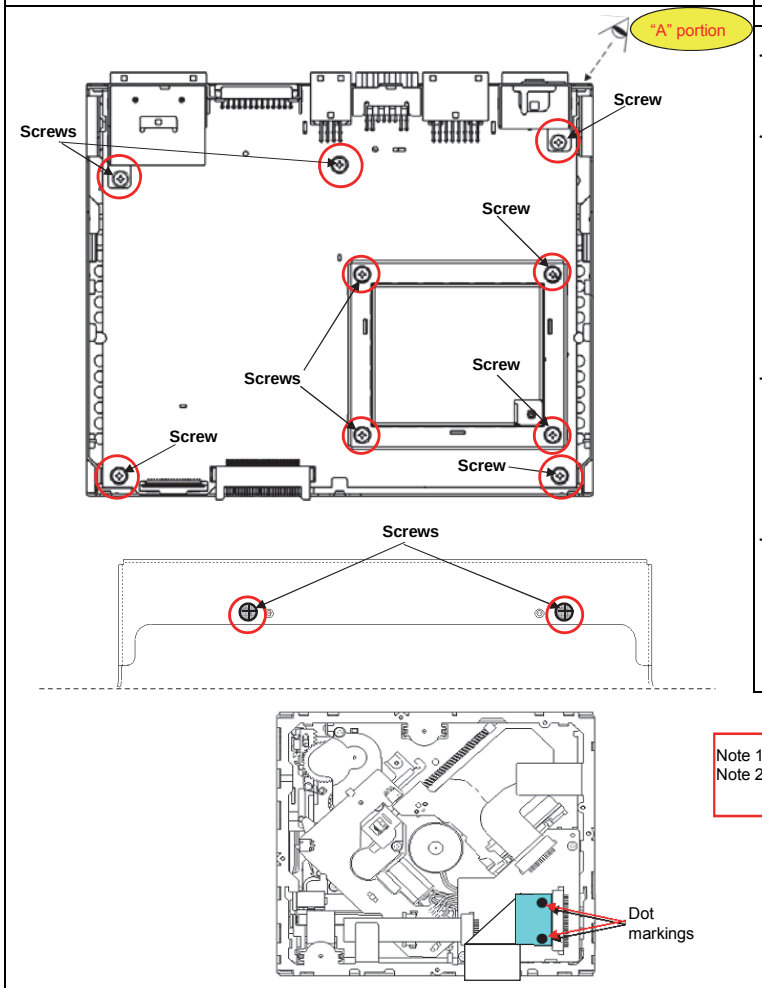
Sub material		TOOLS		JIGS	
①		①	Ionizer	①	Set support
②		②	Tweezers	②	BT-ANNTENA connection jig
③		③		③	
④		④			
⑤		⑤			
⑥		⑥			

Process name
ES-PLATE attachment

PN-3378I-E-07

ASSEMBLY INSTRUCTIONS / PN-3378I-E / UNIT (8)

Process drawing

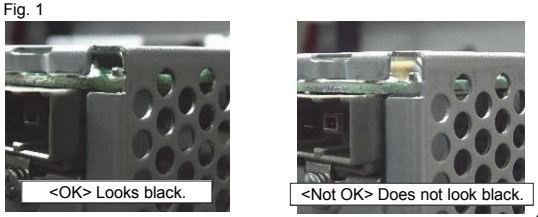


Procedure

Contents of process	No.	Parts Number	Qty	Control Points
· MAIN-UNIT is on jig ①.				
· Check the screw quantity. 1) MAIN-PWB fixing screws → 9 portions 2) CD-MECH BRKT fixing screws (rear side) → 2 portions				Check the screw quantity by pointing with a finger. (There should be no missing screws.) Tightening and checking process must be separated.
· Check insertion condition of processed CD-MECH and then mark the flat cable (two places of flat cable).				There should be no oblique insertion, incomplete insertion, or incomplete connector lock. Inserting and checking process must be separated.
· Look into the square hole of the lower case from the A part. Check for missing rubber parts. (Shining a light from the bottom of lower case improves visibility while checking.)				See Fig. 1. There should be no missing RUBBER PART.

Note 1) Use the ionizer.
Note 2) Handle PWB from the edge of CD-MECH to avoid touching parts.

Fig. 1



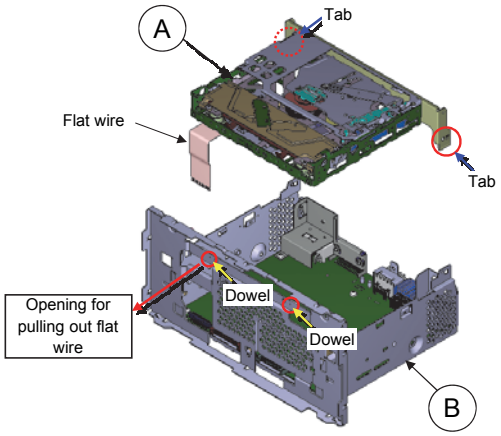
Sub material		TOOLS		JIGS	
①	Oily magic (black)	①	Ionizer	①	Set support
②		②		②	
③		③		③	
④		④			
⑤		⑤			
⑥		⑥			

Process name
VISUAL CHECK

PN-3378I-E-08

ASSEMBLY INSTRUCTIONS / PN-3378I-E / UNIT (9)

Process drawing



Note 1) Use the ionizer.
Note 2) Handle PWB from the edge to avoid touching parts.

Procedure

Contents of process	No.	Parts Number	Qty	Control Points
・ MAIN-UNIT is on jig ①.				
・ Take processed CD-MECH and then run the flat-wire through the hole of ES plate.	A B	-------- --------	(1) (1)	
・ Fit the CD Mechanism part while aligning the front surface with the positioning guide inside the main unit body ES plate.				Fit dowels in 2 places.
・ Attach BRKT portion of CD-MECH to LOWER CASE.				Fit dowels in 2 places.

Sub material		TOOLS		JIGS	
①		①	Ionizer	①	Set support
②		②		②	
③		③		③	
④		④			
⑤		⑤			
⑥		⑥			

Process name
CD-MECH attachment

PN-3378I-E-09

ASSEMBLY INSTRUCTIONS / PN-3378I-E / UNIT (10)

Process drawing

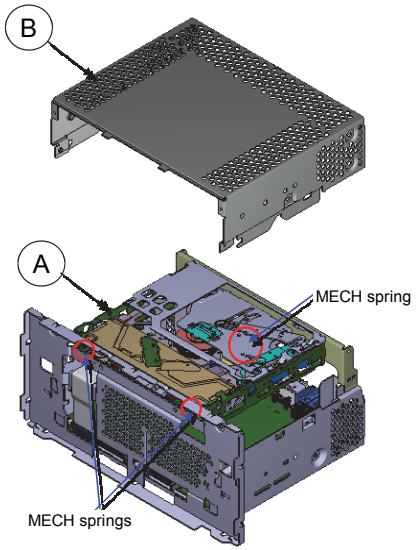


Fig. 1

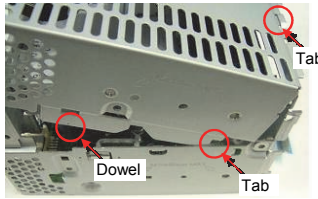
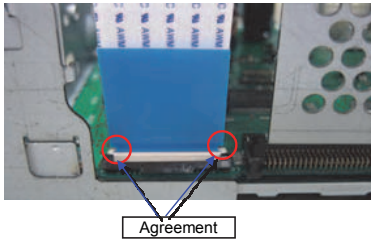


Fig. 2



Procedure

Contents of process	No.	Parts Number	Qty	Control Points
・ MAIN-UNIT is on jig ①.				
・ Visually check for the springs of CD-MECH. 1) Front side ×2 2) Upper side ×1	A	----------	(1)	
・ Insert the 2 UPPER-CASE (B) tabs into the 2 rectangular holes of ES-PLATE.	B	310-1916-00	1	
・ Fix the rear side of UPPER CASE on LOWER CASE.				Fit tabs in 4 places and dowels in 2 places. *See Fig. 1.
・ Check that the socket of MAIN-PWB is unlocked.				The flip lock should be open to the specified position (45 degrees). If not open, open it with a jig.
・ Hold both edges of reinforcement plate of flat-wire, and then insert them into the left and right of the connector of MAIN-PWB at the same time.				Do not touch the terminal portion. Insert part all the way securely. (The notch of FFC is aligned with the terminal of connector.) *See Fig. 2.
・ Take MAIN-UNIT from jig ①.				

Note 1) Use the ionizer.
Note 2) Handle SET from the edge to avoid touching parts.

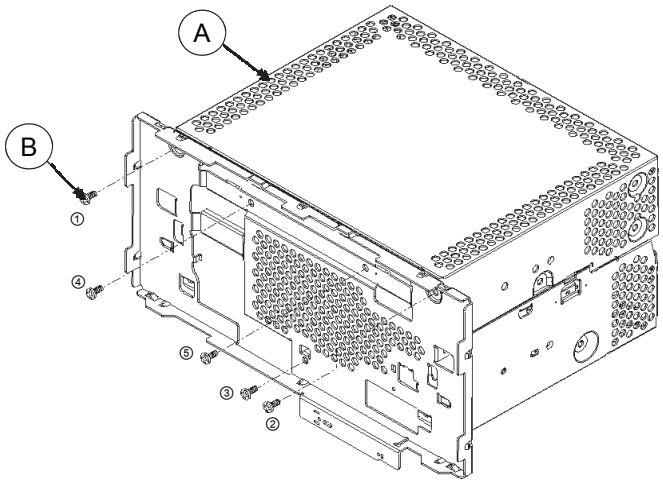
Sub material		TOOLS		JIGS	
①		①	Ionizer	①	Set support
②		②		②	
③		③		③	
④		④			
⑤		⑤			
⑥		⑥			

Process name
UPPER CASE attachment

PN-3378I-E-10

ASSEMBLY INSTRUCTIONS / PN-3378I-E / UNIT (11)

Process drawing



Note 1) Use the ionizer.
Note 2) Handle SET from the edge to avoid touching parts.

Procedure

Contents of process	No.	Parts Number	Qty	Control Points
・ Attach MAIN-UNIT (A) to jig ①. (Rear side of MAIN-UNIT is facing downward. LOWER CASE is facing toward you.) Attach jig ② on both sides of MAIN-UNIT.	A	----------	(1)	
・ Attach jig ③ on front side of MAIN-UNIT and fix with MACHINE SCREW (B).	B	714-2606-8B	5	Tighten in the order of ①→⑤. (Tightening sequence is specified for jig ③.)
・ Remove jig ③ and jig ② from MAIN-UNIT.				

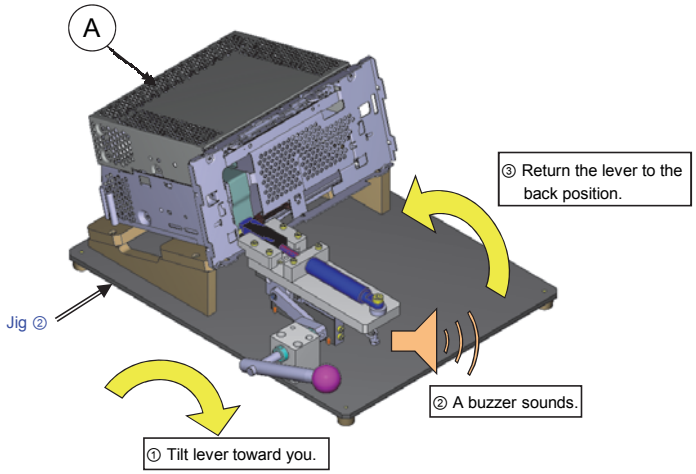
Sub material		TOOLS		JIGS	
①		①	Ionizer	①	Set rear support
②		②	Electric screwdriver (0.4 ± 0.08 N·m)	②	Bracket hole position jig
③		③		③	Screw drop prevention cover (FRONT)
④		④			
⑤		⑤			
⑥		⑥			

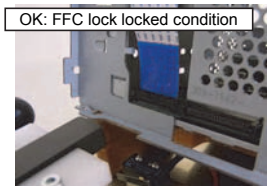
Process name
Screwing-1

PN-3378I-E-11

ASSEMBLY INSTRUCTIONS / PN-3378I-E / UNIT (12)

Process drawing





Note 1) Use the ionizer.
Note 2) Handle SET from the edge to avoid touching parts.

Procedure

Contents of process	No.	Parts Number	Qty	Control Points
・ Remove MAIN-UNIT (A) from jig ①. Set MAIN-UNIT (A) on jig ②.	A	---------	(1)	
・ Push lever of jig ② to the front until a buzzer sounds.				When starting operation, check the push tension. Tension = 50 +/- 10 N.
・ If a buzzer sounds, return the lever to the back position and remove MAIN-UNIT.				
・ Check the insertion condition.				There should be no incomplete lock.

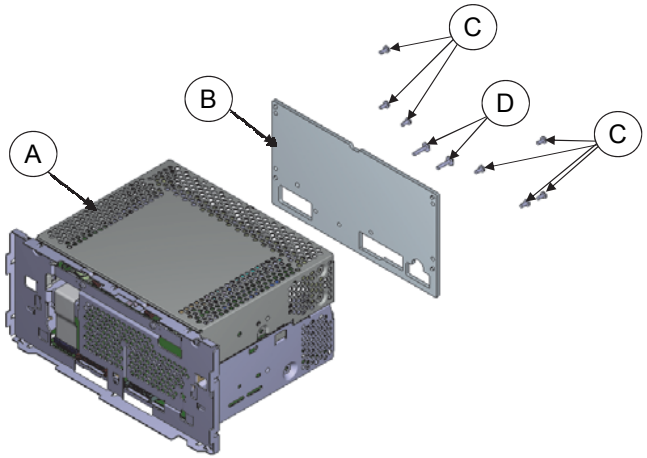
Sub material		TOOLS		JIGS	
①		①	Ionizer	①	Set rear support
②		②		②	FFC lock jig
③		③		③	
④		④			
⑤		⑤			
⑥		⑥			

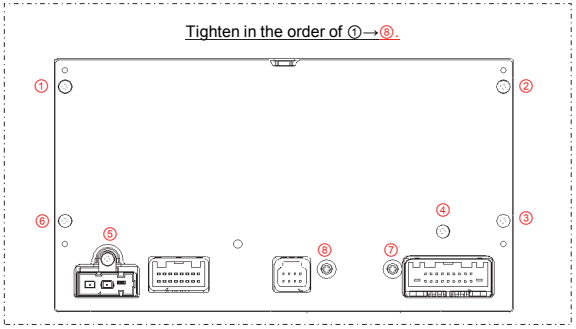
Process name
FFC lock

PN-3378I-E-12

ASSEMBLY INSTRUCTIONS / PN-3378I-E / UNIT (13)

Process drawing





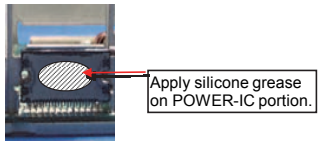
Note 1) Use the ionizer.
Note 2) Handle SET from the edge to avoid touching parts.

Procedure

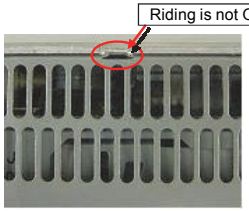
Contents of process	No.	Parts Number	Qty
・ Place jig ② on MAIN-UNIT. Place it on jig ①. (Face the front side of MAIN-UNIT downward. Face UPPER CASE toward you.)	A	---------	(1)
・ Attach jig ③ on POWER-IC portion of MAIN-UNIT rear side. Apply silicone grease to POWER-IC, and then remove jig ③.			
・ Install HEAT SINK (B) on rear side of MAIN-UNIT, and place jig ④ on them. Secure HEAT SINK with MACHINE SCREW (C) and DOUBLE-SEMS-SCREW (D).	B C D	313-2070-20 714-2606-8B 735-2614-1B	1 6 2
・ Take jig ④ out of MAIN-UNIT.			

Control Points

Use specified jig to apply an adequate amount.



Tighten in the order of ①→⑧.
(Tightening sequence for jig ④ is specified.)



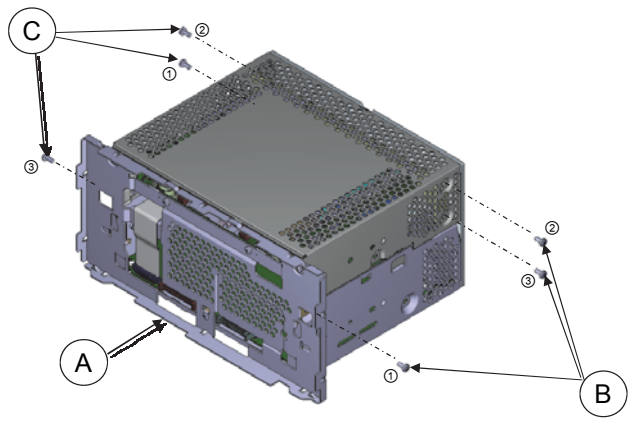
Sub material		JIGS			
①	Silicone grease	④	Screw drop prevention cover (rear)	①	Set rear support
②		⑤		②	Bracket hole position jig (1 CD)
TOOLS		⑥		③	Silicone applying jig
①	Ionizer				
②	Brush				
③	Electric screwdriver (0.4 ± 0.08 N·m)				

Process name
HEAT SINK attachment

PN-3378I-E-13

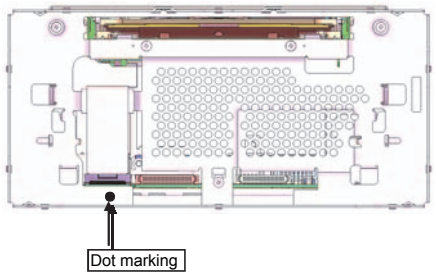
ASSEMBLY INSTRUCTIONS / PN-3378I-E / UNIT (14)

Process drawing



Note 1) Use the ionizer.
Note 2) Handle SET from the edge to avoid touching parts.

Fig. 1 Note) ES place figure is P-3379.



Procedure

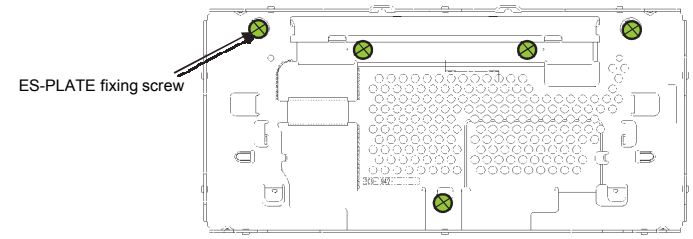
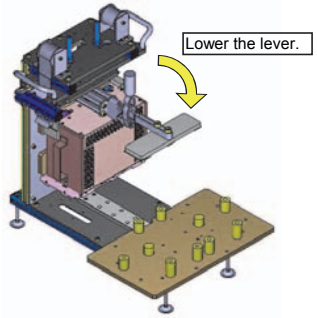
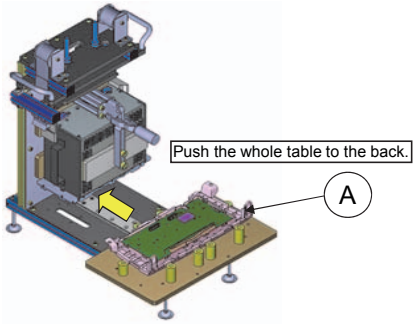
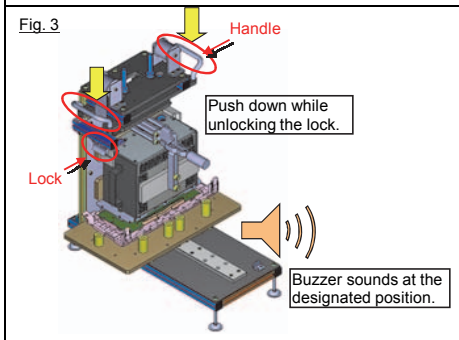
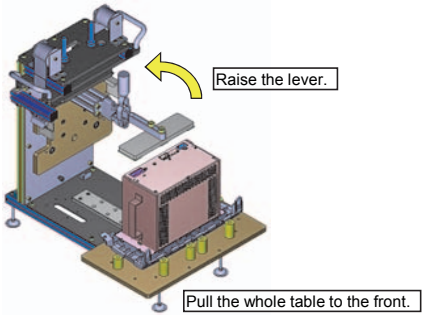
Contents of process	No.	Parts Number	Qty	Control Points
・ Place MAIN-UNIT (A) on jig ① and place jig ② on both sides of MAIN-UNIT. (Face rear side of MAIN-UNIT downward, and face LOWER CASE toward you.)	A	--------	(1)	
・ Turn over jig ②, and place jig ② on jig ① again. Secure left side of MAIN-UNIT with MACHINE SCREW (B).	B	714-2606-8B	3	Tighten in the order of ①→③.
・ Turn over jig ②, and attach jig ② on jig ① again. Secure right side of MAIN-UNIT with MACHINE SCREW (C).	C	714-2606-8B	3	Tighten in the order of ①→③.
・ Turn over with jig ② place on MAIN-UNIT. Place MAIN-UNIT on jig ① again. (Face rear side of MAIN-UNIT downward, and face LOWER CASE toward you) Take jig ② from MAIN-UNIT.				
・ Check insertion condition. When it is OK, apply magic marking.				There should be no oblique insertion, incomplete insertion, or incomplete connector lock. *See Fig. 1.

Sub material		TOOLS		Jigs	
①	Oily magic (black)	①	Ionizer	①	Set rear support
②		②	Electric screwdriver (0.4 ± 0.08 N·m)	②	Bracket hole position jig (1 CD)
③		③		③	
④		④			
⑤		⑤			
⑥					

Process name
Screwing-2

PN-3378I-E-14

ASSEMBLY INSTRUCTIONS / PN-3378I-E / UNIT (15)

Process drawing	Procedure	Control Points
 Note) The figure is for reference purposes.	・ Check the screw quantity. 1) ES-PLATE fixing screws: 5 screws	Check the screw quantity by pointing with a finger. (There should be no missing screws.)
Fig. 1  Fig. 2 	・ ES installation 1) Attach jig ① on MAIN-UNIT. Lower a lever toward you. And lock the MAIN-UNIT. → **See Fig. 1.** 2) Take ES-ASSY (A) from the POLY-BAG. Check the appearance. 3) Attach ES-ASSY (A) on slide table of jig. 4) Push the whole table to the back. → **See Fig. 2.** 5) Grab handles with both hands, unlock jig and push down. → **See Fig. 3.** 6) When buzzer sounds, release handle. 7) Pull table and MAIN-UNIT toward you. Take MAIN-UNIT from jig. → **See Fig. 4.**	There should be no missing CUSHION RUBBER. Push parts firmly to the end. Push the handle until the buzzer sounds.
Fig. 3  Fig. 4 	・ Check ES-ASSY attachment condition. 1) SHIELD PLATE riding. 2) Push 10 tab fitting portions of ES. ・ Take unit out from jig.	*There should be no SHIELD PLATE riding. *ES-ASSY is fit at 10 tabs.

No.	Parts No.	Unit
A	See difference table.	1

Note 1) Use the ionizer.
Note 2) Handle SET from the edge to avoid touching parts.

<Difference table>

MODEL NAME	A: ES-ASSY
PN-IC, PN-ID	45-3378-B0
PN-IE	45-3378-C0

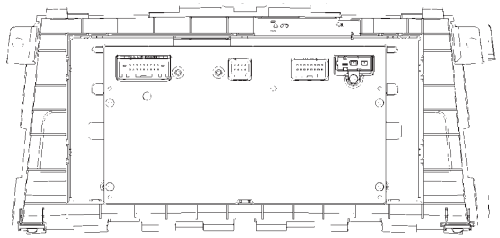
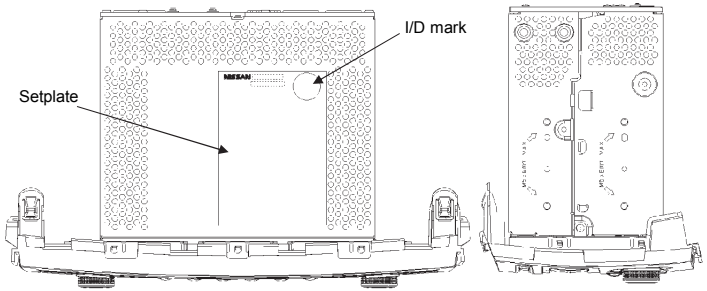
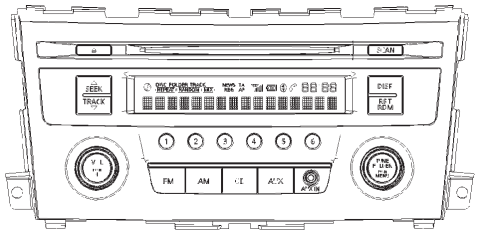
JIGS	
①	ES pressing jig
②	

TOOLS	
①	Ionizer

Process name
ES-ASSY attachment

PN-3378I-E-15

ASSEMBLY INSTRUCTIONS / PN-3378I-E / UNIT (16)

Process drawing	Procedure	Control Points
	・ Move pallet to the specified position.	
	・ Check the appearance. 1) There should be no scratches, stains, or paint failure.	
	2) Fit ES-ASSY with tabs in 10 places.	
	3) There should be no missing screws, oblique insertion, or incorrect parts. Left side: 3 screws Right side: 3 screws Rear side: 8 screws	Check by pointing with a finger. (There should be no missing parts.) Turn pallet.
	・ Check the position of holes for BRKT. → Fit jig ① on both sides.	On both sides, 4 pins of jig ① should fit smoothly.
	・ After the main unit (escutcheon) is turned to the front, lock the whole pallet.	
	・ Peel off setplate [setplate that has been printed] from sheet. Attach setplate on the specified top position of MAIN-UNIT.	Apply SETPLATE only to the units that pass the appearance check. To avoid S/NO. skipping and to control sequence number in the later process, apply serial numbers in ascending numerical order. I/D mark = See difference table.
	・ Remove the lock of pallet. Move the pallet to the next process.	

<Difference table>

MODEL NAME	I/D MARK
PN-3378I-C	A0
PN-3378I-D	BG
PN-3378I-E	RA

Note 1) Use the ionizer.
Note 2) Handle SET from the edge to avoid touching parts.

	TOOLS		JIGS	
	①	Ionizer	①	Bracket screw hole positioning jig (1 CD)
	②			
Sub material	③		②	
①	④			
②	⑤		③	
③	⑥			

Process name			
Finishing			PN-3378I-E-38