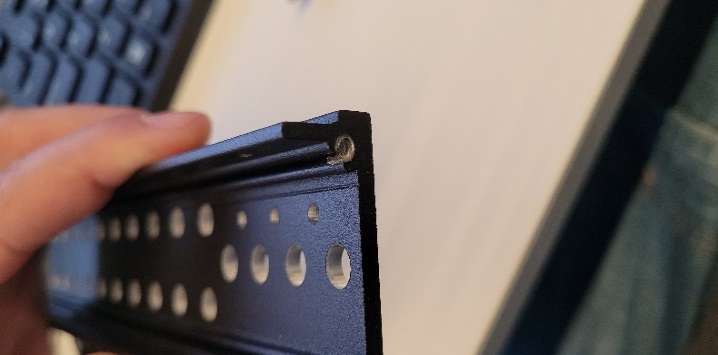
**AD-SYNCHRONA14 ASSEMBLY PROCEDURE**

**1st STEP:**

Use a threading tap (or a screw) to make the threads for the front and back panel.

**Clean the remaining metal debris.**

See pictures below.





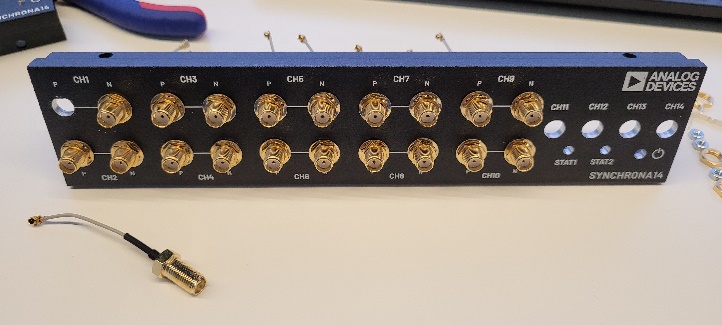
**2nd STEP:**

Place all the SMA-u.Fl (**CABLE 348 RF-050-F4-A-1** and**CAB.721**) cables into the front and back panel.

There should be 28pcs of **CABLE 348 RF-050-F4-A-1** and 2pcs of **CAB.721**.

!!! The two **CAB.721** cablesgo into the back panel into the ***PPS*** and ***REF IN*** slots !!!

Use a Torque Screwdriver or wrench to tighten the SMA nuts. **Set it at 1.1 - 1.2 Nm.**

See pictures below.



**3rd STEP:**

Crimp terminals **8550102** to the fan **MF25100V2-1000U-A99** wires.

Insert the terminals into connector **22013037**:

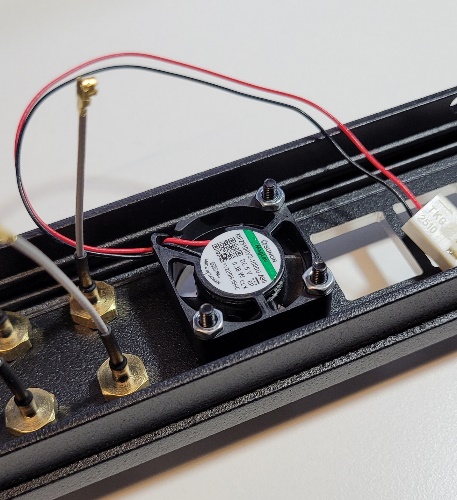
Pin 1 – NC

Pin 2 – red wire

Pin 3 – black wire

Mount the fan to the back panel with 3 **92000A109** (16mm) screws.

See pictures below.

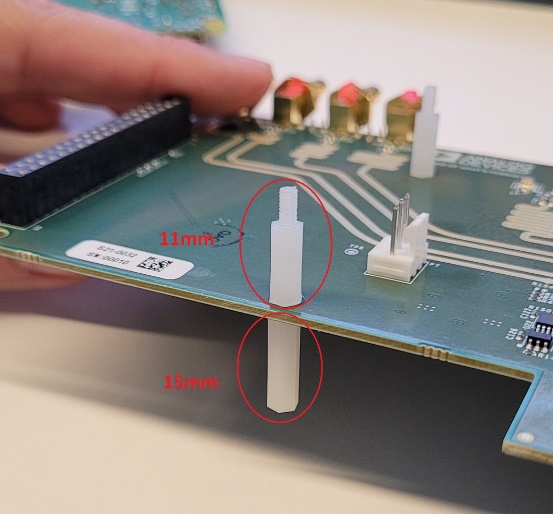
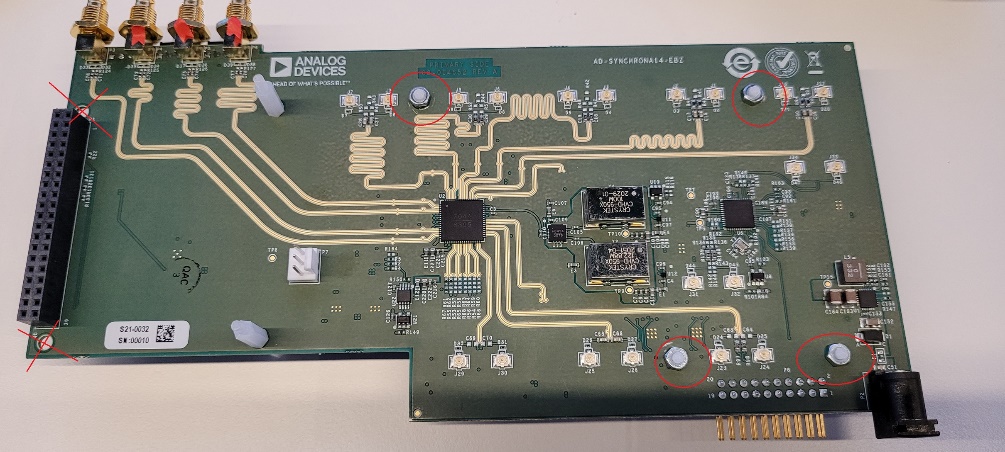
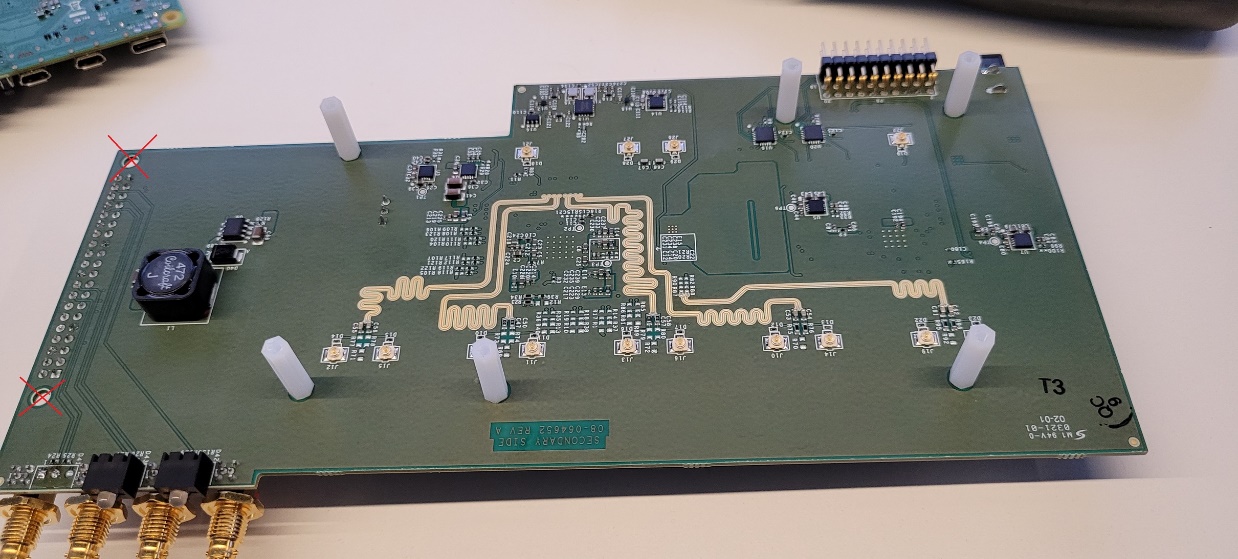


**4th STEP:**

Place 2, **971110155** 11mm spacers on top to hold the Raspberry Pi.

The 11mm spacers will be hold with **971150155** 15mm spacers from the bottom. (see picture).

Place 15mm spacers in the remaining mounting holes except for the ones near the Raspberry Pi connector.

See pictures below.

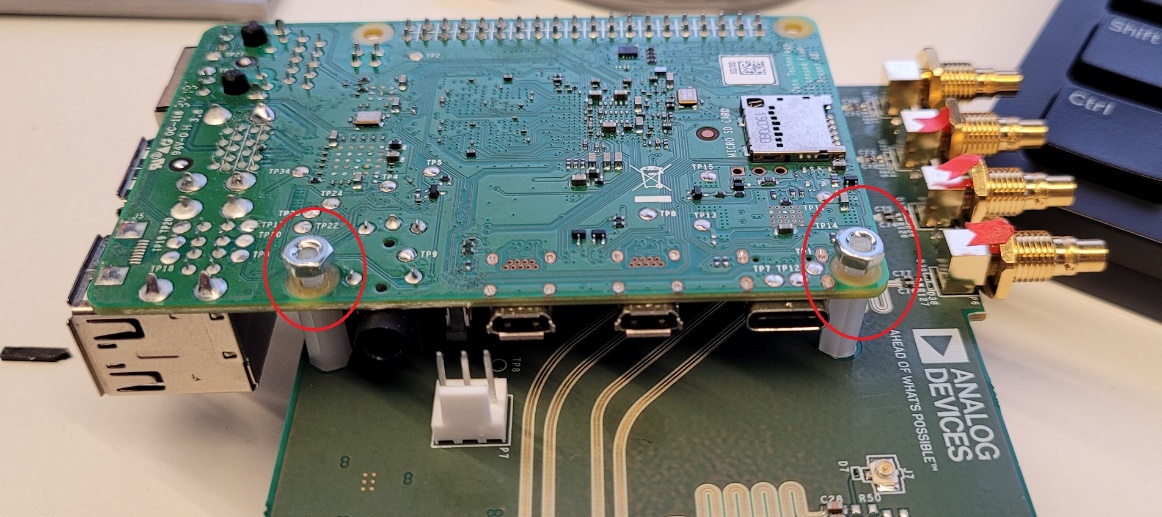
\*these are pictures of rev A board.

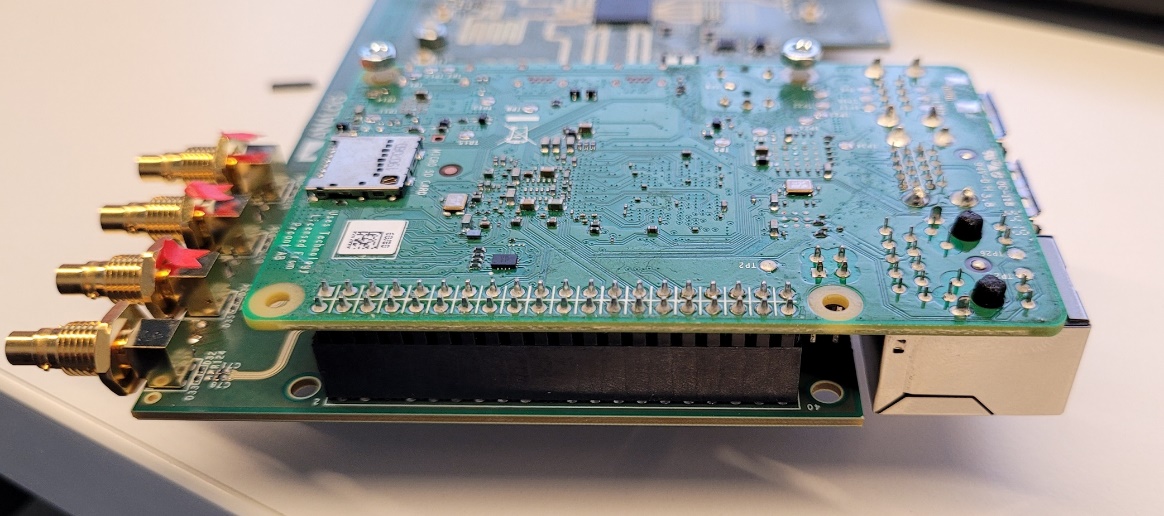
\*rev B should have a total of 7, 15mm spacers.

**5th STEP:**

Insert the Raspberry Pi. Place 2 nuts on the 11mm spacers.

Insert the SD card into the Raspberry Pi.

See pictures below.



**6th STEP:**

Insert the board into the front panel.

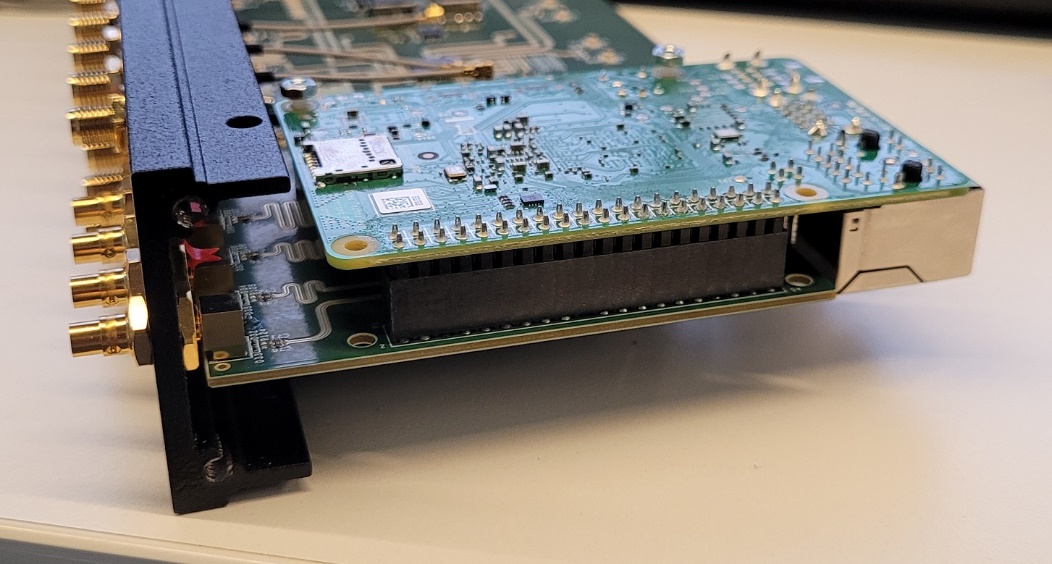
Fix it with the 4 nuts of the Twinax connectors.

**!!! Do not place the washers on these 4 connectors !!!**

Use a Torque Screwdriver or wrench to tighten the Twinax nuts. **Set it at 0.6 - 0.7 Nm.**

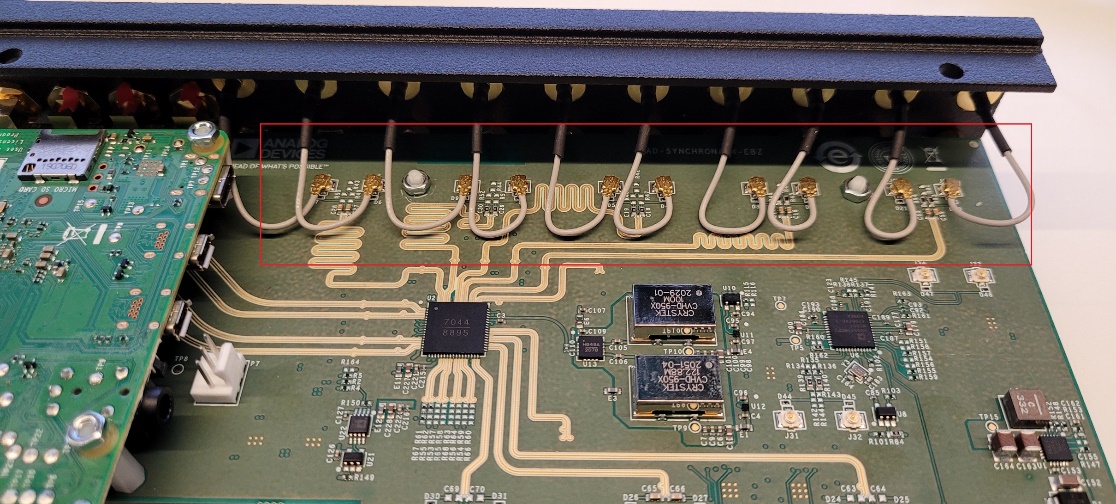
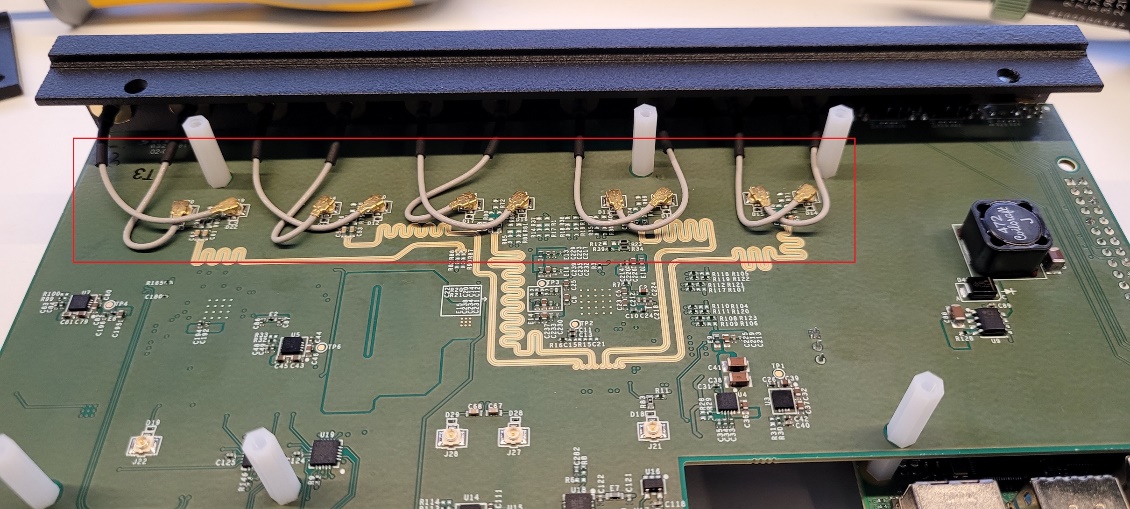
See pictures below





**7th STEP:**

Insert the u.Fl connectors. Match the designators from the front panel to the designators on the silkscreen.

See pictures below.

**8th STEP:**

Mount the side panels. Place the side panel with the cuts on the Raspberry Pi side.

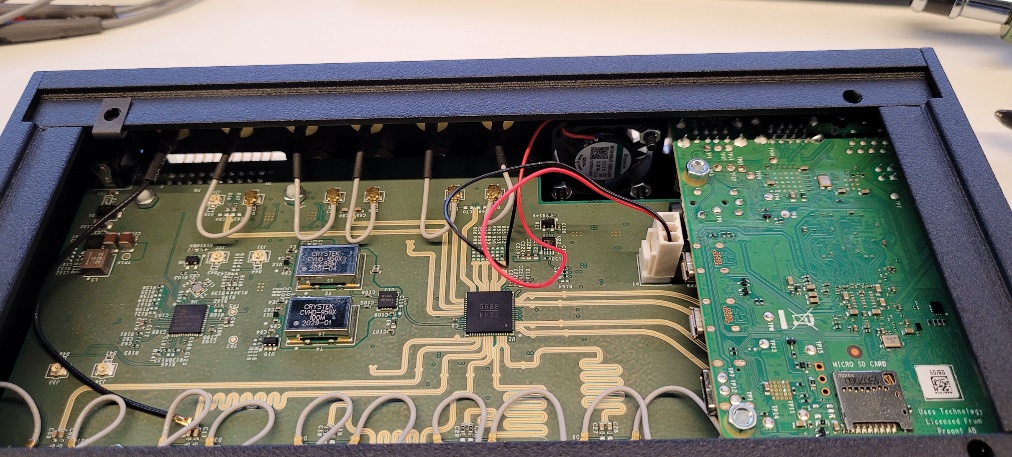
See pictures below.

**9th STEP:**

Mount the back panel.

Insert the fan connector.

Insert the u.Fl connectors. Match the designators from the back panel to the designators on the silkscreen.

See pictures below.



**10th STEP:**

Place the Heatsink (**S1510-10W-T411-10**), on U2.

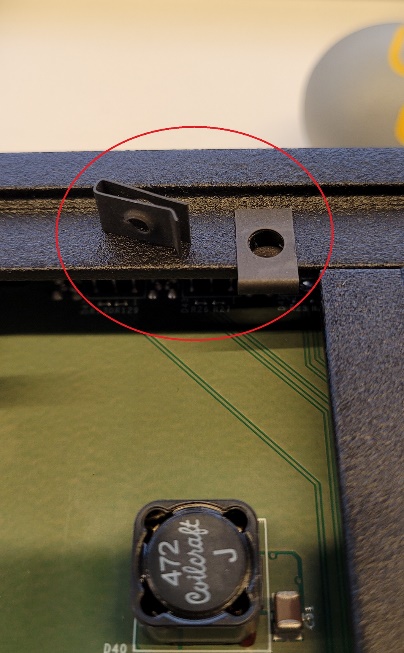
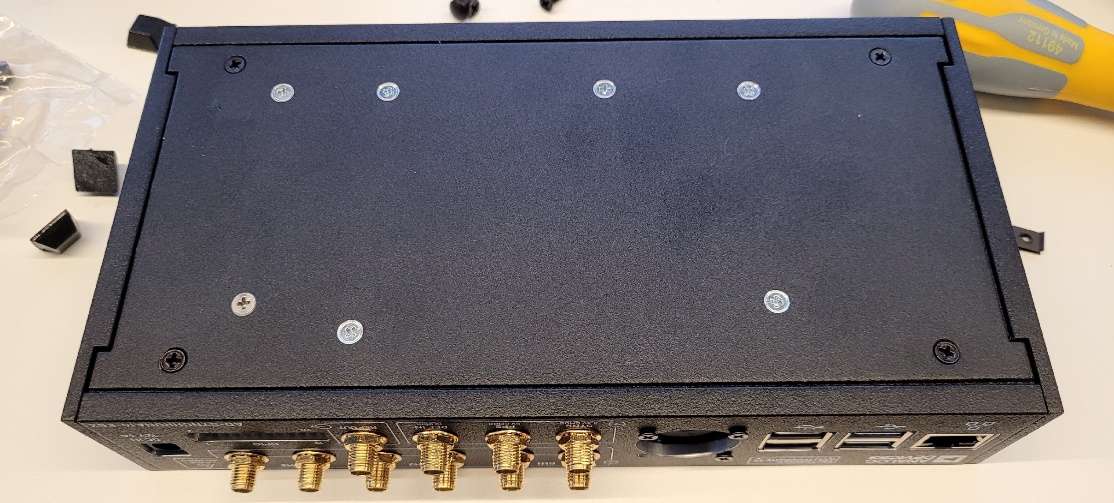
**11th STEP:**

Place the clip nuts on mounting holes of the bottom panel.

Place the bottom panel and insert the 6mm screws **91801A135** that go into the spacers.

Fix the bottom panel with the screws that came with the Hammond enclosure.

See pictures below.



**12th STEP:**

Place the clip nuts on mounting holes of the top panel.

Fix the top panel with the screws that came with the Hammond enclosure.

