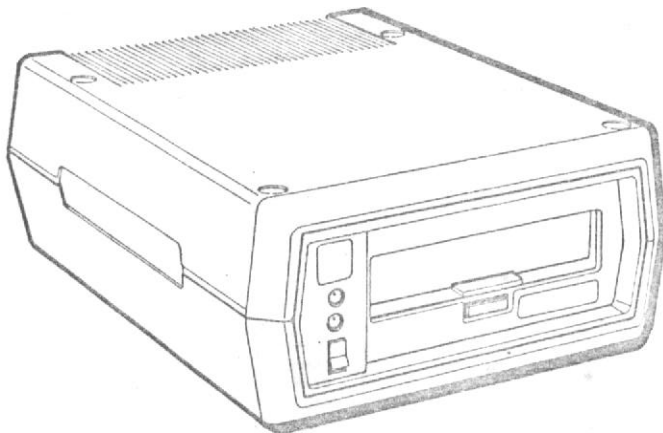


DISASSEMBLY / REASSEMBLY



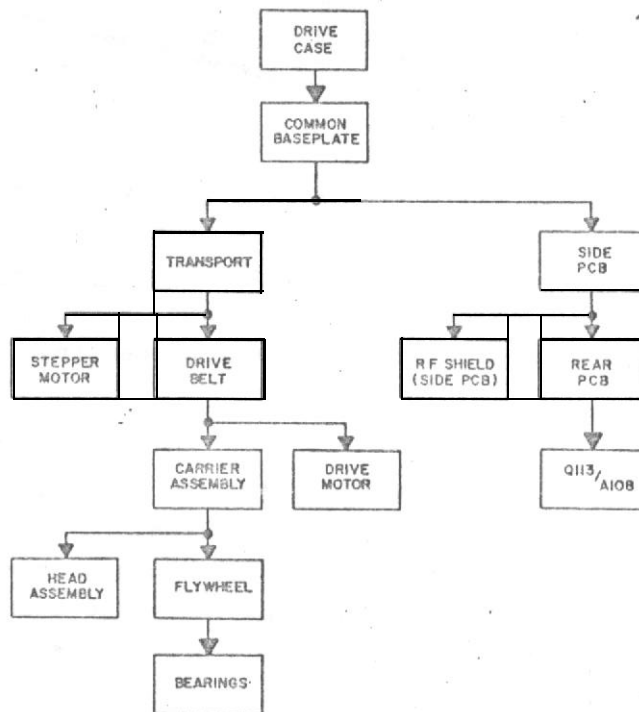
DISASSEMBLY AND REASSEMBLY

The level of Disk Drive disassembly will vary with the specific problem encountered. Some procedures list steps which are themselves procedures: ie. "Disassemble the Drive case." When you encounter an underlined step, turn to that procedure first and follow it before proceeding.

SPECIAL NOTES

1. Refer to the Disk Drive and 400/800 Operators Manuals for proper Drive setup and operation.
2. Disk Drive circuitry includes static sensitive MOS devices. All Drive repairs should be performed at static protected work surfaces. Anyone handling Drive PCBs should wear a grounding strap.
3. To prevent thread damage, use only the specified screws.
4. Overtightening screws will strip the threads on plastic and aluminum parts. Do not exceed 6 inch pounds torque for plastic parts, or 10 inch pounds torque for aluminum parts.
5. Internal wiring connections are made with wiring harnesses terminated by nonpolarized pins and jacks. Be sure all pins and jacks are correctly installed before trying to operate the Disk Drive.
6. When reassembling the Drive, ensure that all wiring harnesses are routed in such a way as to prevent them from being pinched between reassembled parts.

DISASSEMBLY FLOW CHART

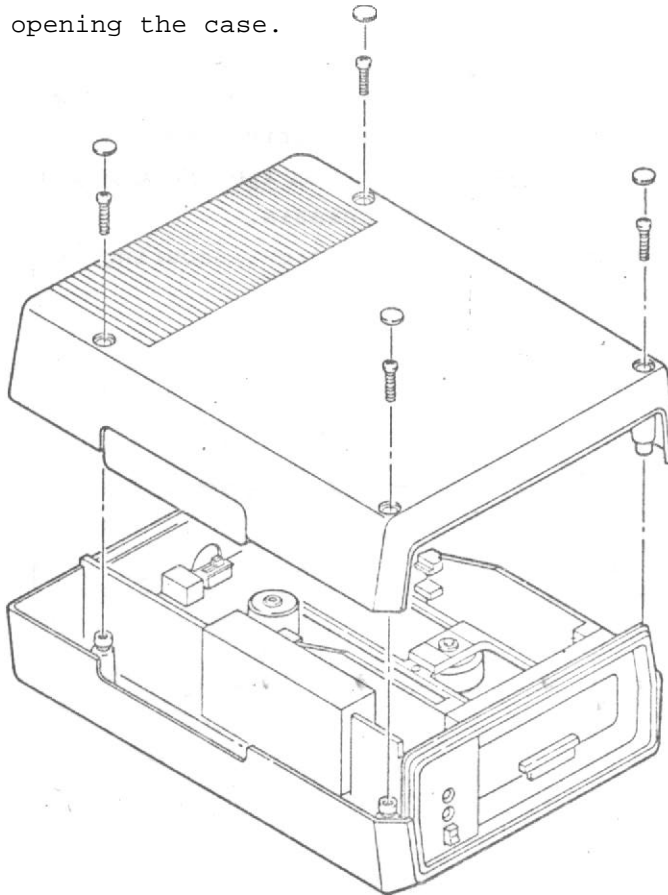


Identify the level of disassembly required and complete the sequence of steps indicated above.

DISASSEMBLY

DISASSEMBLING THE DISK DRIVE CASE

WARNING: Unplug the Drive's AC transformer from AC power BEFORE opening the case.



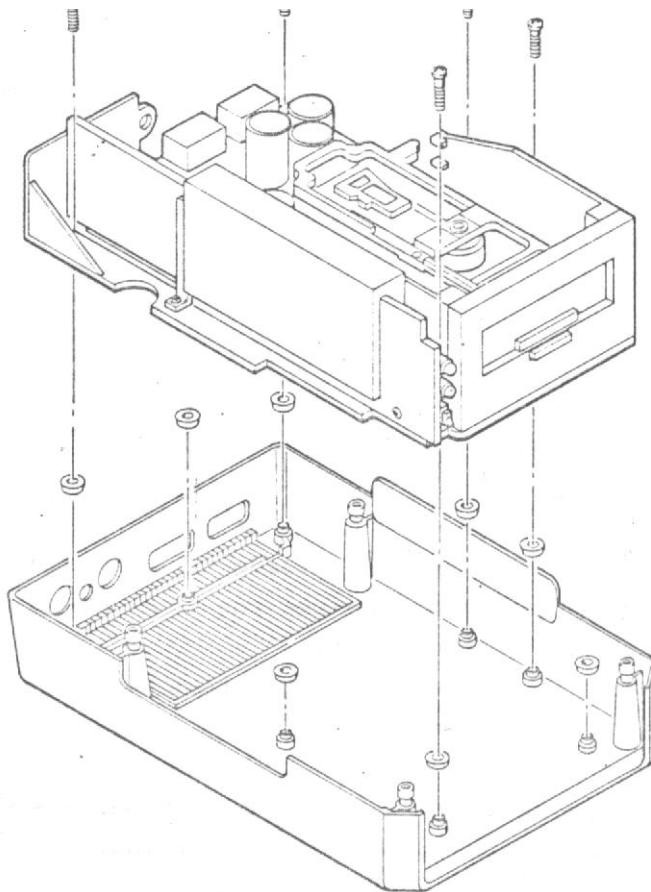
1. With the Disk Drive rightside up on a suitable work surface, locate and remove the four adhesive screw hole covers on the tophousing.
2. Locate and remove the four screws securing the tophousing to the base.
3. Lift the tophousing from the base, and set it aside.

CAUTION: The record/playback and erase head sub-assembly is extremely sensitive to magnetic fields. DO NOT use magnetized tools or articles when working inside the Drive case or near the Drive transport.

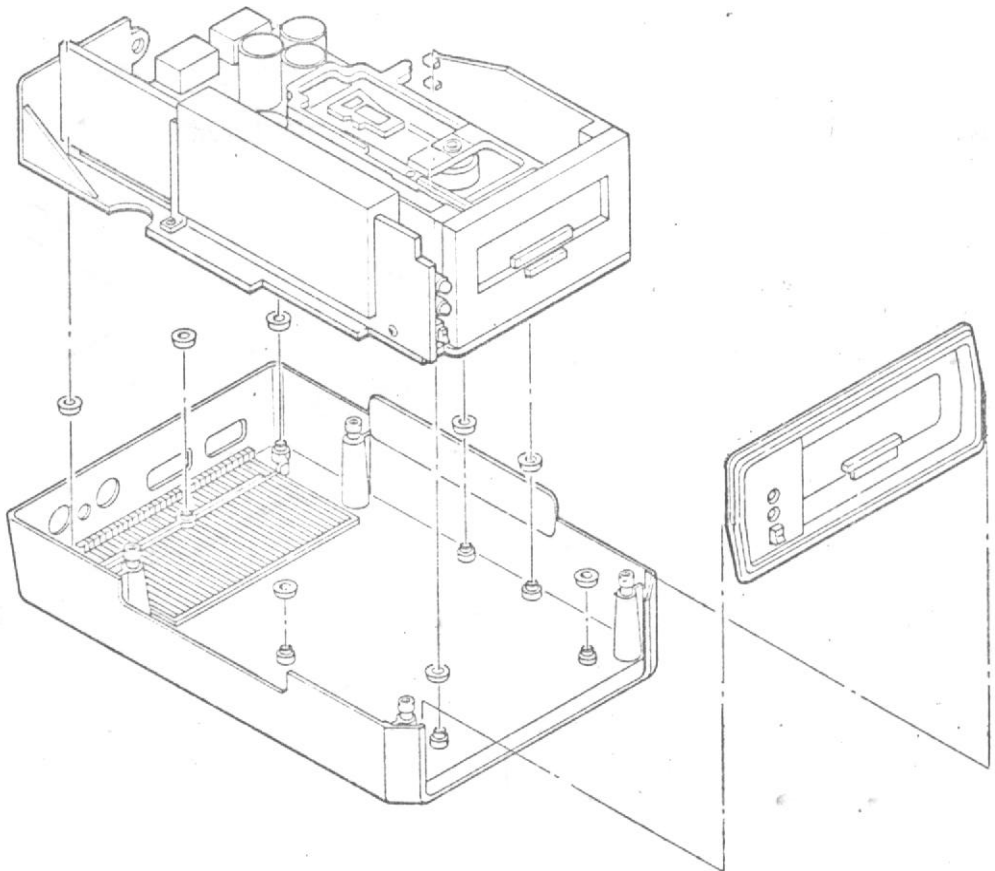
REMOVING THE COMMON BASEPLATE

NOTE: Removal of either the side PCB, rear PCB or Drive transport requires removal of their common baseplate from the Disk Drive base.

1. Disassemble the Disk Drive case.
2. Disconnect the AC transformer power cord from the PWR jack at the rear of the Drive chassis.
3. Disconnect any I/O cables from the I/O CONNECTORS at the rear of the Drive chassis.
4. Locate and remove the five screws securing the common baseplate to the base.



5. Carefully lift the baseplate from the base. Note that each of the bosses in the base is topped with a rubber washer.

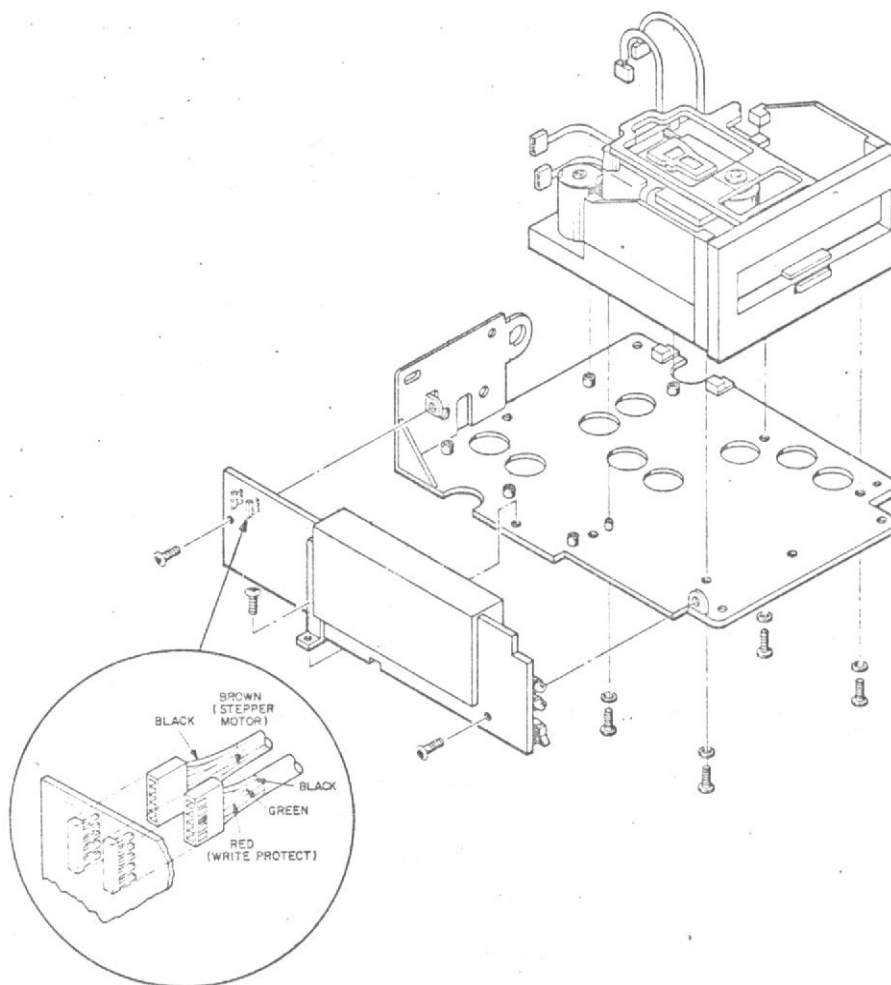


NOTE: As you lift the baseplate from the base, the front coverplate will lift out at the same time. Remove the coverplate from the baseplate and set it aside.

6. Place the baseplate on a suitable static protected work surface.

REMOVING THE SIDE PCB

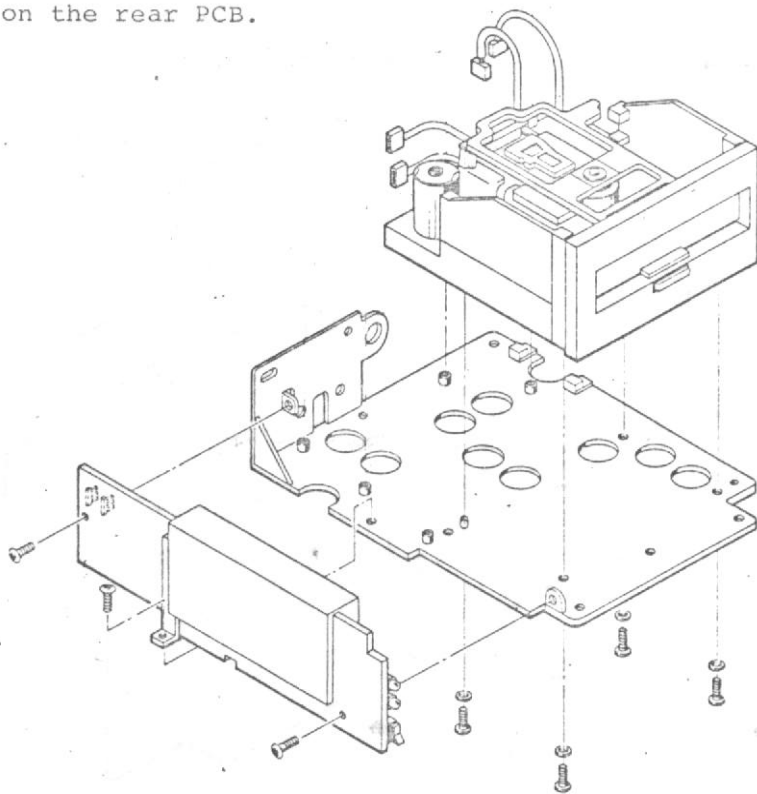
1. Disassemble the Disk Drive case.
2. Remove the common baseplate from the Drive base.



3. Locate and disconnect the write protect wiring harness (nonpolarized - black, green, (blank), red, black) from the side PCB.
4. Locate and disconnect the stepper motor wiring harness (nonpolarized - black, white, red, green, brown) from the side PCB.

MOTE: See Appendix for alternate wiring harness arrangement.

5. Locate and remove the three screws securing the side PCB and its center ground bracket to the common baseplate.
6. Grasp the side PCB at both its front edge and its upper rear corner. Lift the PCB straight up to disengage its rear jack from the row of pins on the rear PCB.



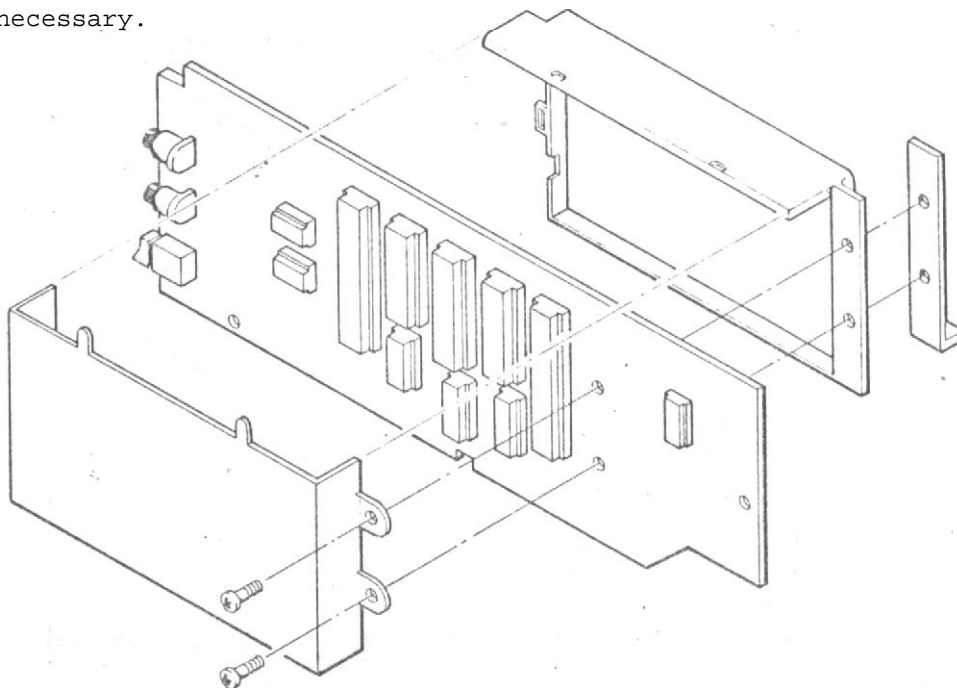
NOTE : You may have to rock the PCB slightly to overcome the jack-to-pin tension between the two PCBs.

7. Place the side PCB on a static protected work surface.

REMOVING THE RF SHIELD (SIDE PCB)

1. Disassemble the Disk Drive case.
2. Remove the common baseplate from the Drive base.
3. Remove the side PCB from the common baseplate.
4. Locate and carefully straighten the three tabs' securing the RF shield case halves together on the side PCB.

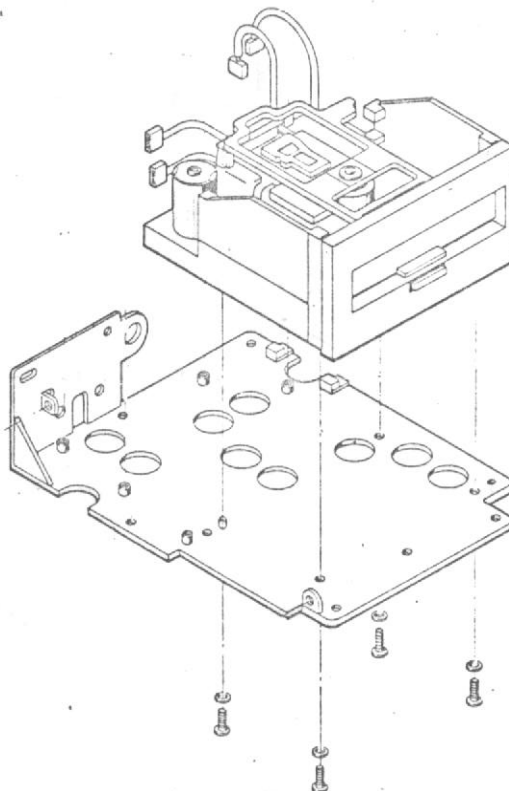
CAUTION: Excessive bending of the metal tabs will break them. DO NOT bend the tabs anymore than necessary.



5. Locate and remove the two screws securing the case half; to the ground bracket and PCB.
6. Carefully disengage the case halves from each other and the PCB. Set the case halves aside.

REMOVING THE DRIVE TRANSPORT

1. Disassemble the Disk Drive case.
2. Remove the common baseplate from the Drive base.
3. Remove the side PCB.
4. Grasp the transport securely, tip the assembly upside down, and place it on a suitable work surface.
5. Locate and remove the four screws that secure the transport to the baseplate.' The screws are accessible only from the underside of the baseplate.

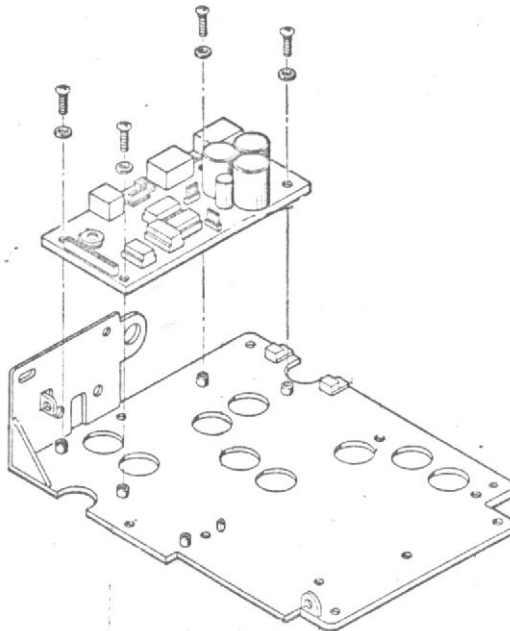


CAUTION: The transport provides critical mechanical alignments necessary for proper Disk Drive operation. Be very careful not to jar or damage the transport or any of its associated sub-assemblies and components.'

6. Place the transport and baseplate on a suitable work surface.

REMOVING THE REAR PCB

1. Disassemble the Disk Drive case.
2. Remove the common baseplate from the Drive base.
3. Remove the side PCB from the common baseplate.
4. Locate and remove the four screws securing the rear PCB to the common baseplate.'
5. Grasp the rear PCB on both side edges. Carefully lift the board straight up far enough to disengage the board's two right side jacks from the six device pins.

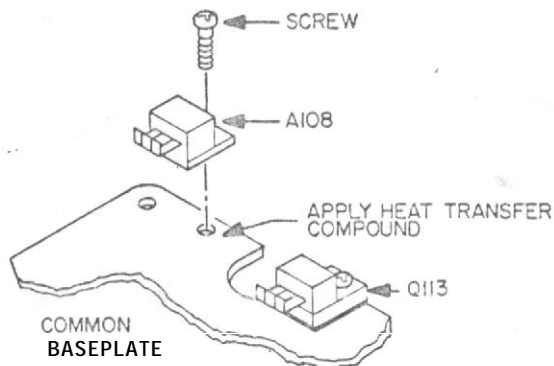


NOTE: You may have to rock the PCB slightly to overcome the jack-to-pin tension between the PCB and the pins attached to the common baseplate.

6. Lift the rear PCB away from the baseplate and place it on a suitable work surface.

REMOVING Q113 (TRANSISTOR)/A108 (VOLTAGE REGULATOR)

1. Disassemble the Disk Drive case.
2. Remove the common baseplate from the Drive base.
3. Remove the side PCB from the common baseplate.
4. Remove the rear P C S from the common baseplate.
5. Locate and remove the single screw securing the device (either transistor Q113 or voltage regulator A108) to the common baseplate.

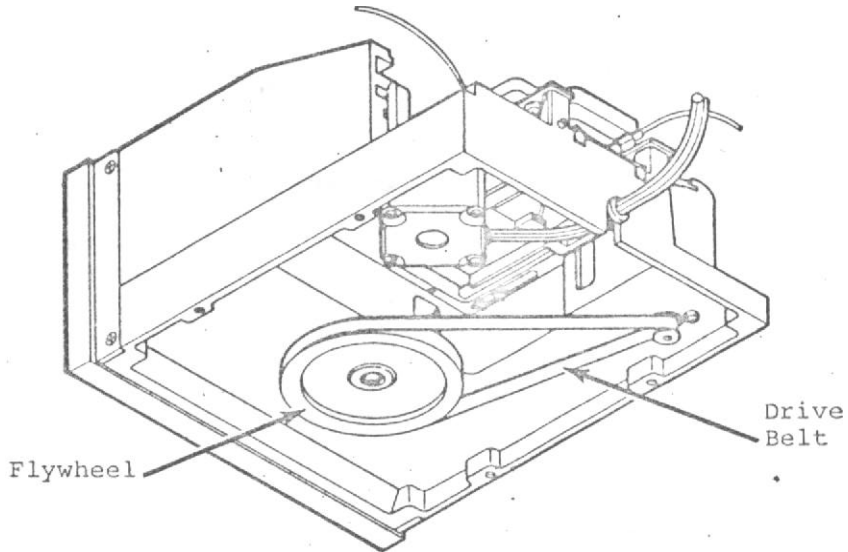


NOTE: If you are removing Q113 you should find an insulating plate between the back of the device and the common baseplate. Also, both Q113 and A108 use the common baseplate as a heatsink. Each device and Q113's insulating plate should be coated with heat transfer compound.

6. Lift the device (Q113 or A108) from the baseplate and set aside.

REMOVING THE TRANSPORT DRIVE BELT

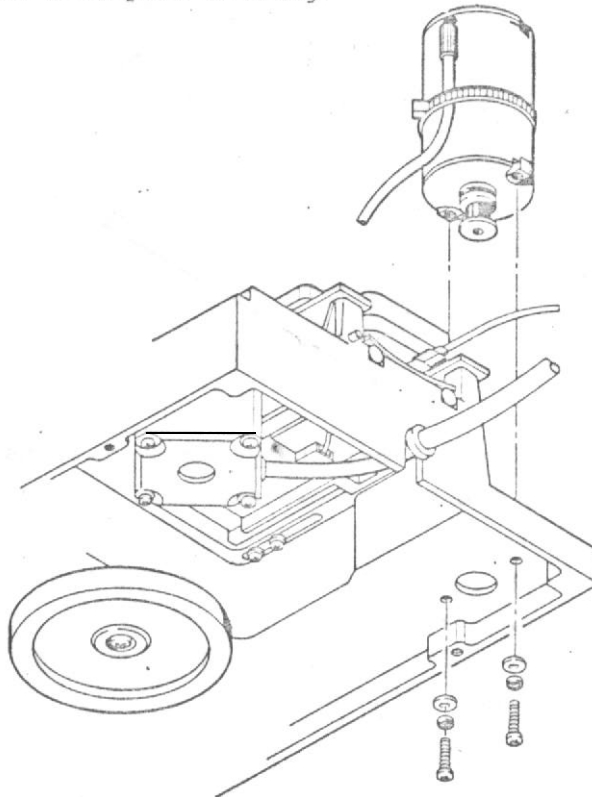
1. Disassemble the Disk Drive case.
2. Remove the common baseplate from the Drive base.
3. Remove the Drive transport from the common baseplate.
4. Carefully lay the transport on its side.
5. Locate and remove the drive belt.



NOTE: To remove the drive belt without stretching or damaging it, rotate the large flywheel (marked for strobe) while easing the belt off the outside edge of the flywheel.

REMOVING THE TRANSPORT DRIVE MOTOR

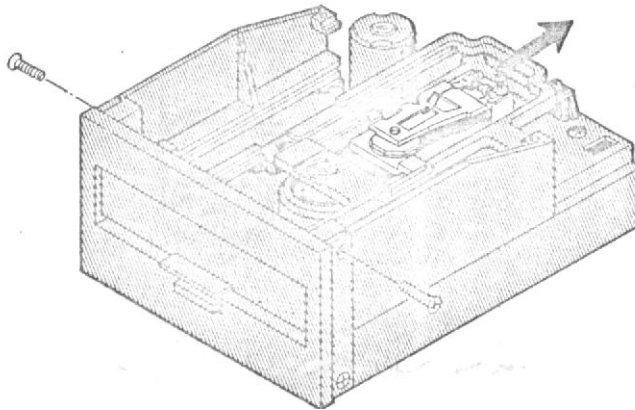
1. Disassemble the Disk Drive case.
2. Remove the common baseplate from the Drive base.
3. Remove the Drive transport from the common baseplate.
4. Remove the drive belt from the transport.
5. Locate and disconnect the single black ground lead coming from the drive motor wiring harness and going to the transport casting.



6. While supporting the drive motor with one hand, locate and remove the two screws securing the drive motor to the transport casting.
7. Separate the drive motor from the casting.

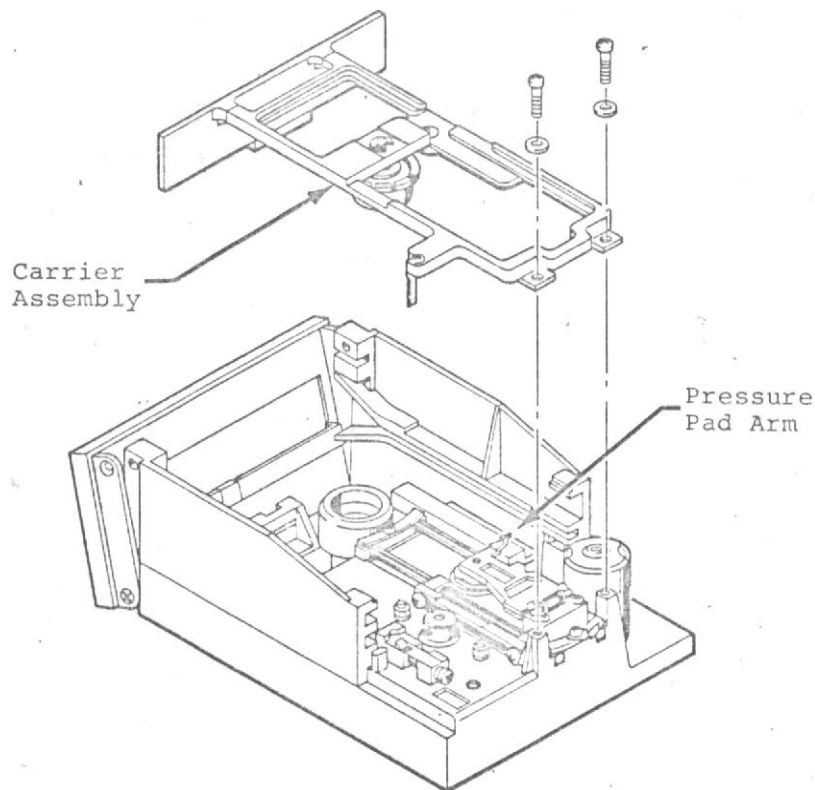
REMOVING THE CARRIER ASSEMBLY

1. Disassemble the Disk Drive case.
2. Remove the common baseplate from the Drive base.
3. Remove the Drive transport from the common baseplate.
4. Locate the head assembly and slide the assembly all the way to the rear of its travel.



5. Locate and loosen approximately two full turns, but do not remove, the two screws securing the carrier assembly to the rear of the transport casting.
6. Locate the four screws securing the front panel bezel to the side guide assemblies and the transport casting.
7. Loosen (do not remove) the two bottom screws approximately four full turns.
8. Remove the two top screws.

9. Push the door release button at the front of the transport to disengage the carrier assembly from the door latch. Lift the assembly far enough to clear the latch mechanism and release the button. Lower the door to a resting position.

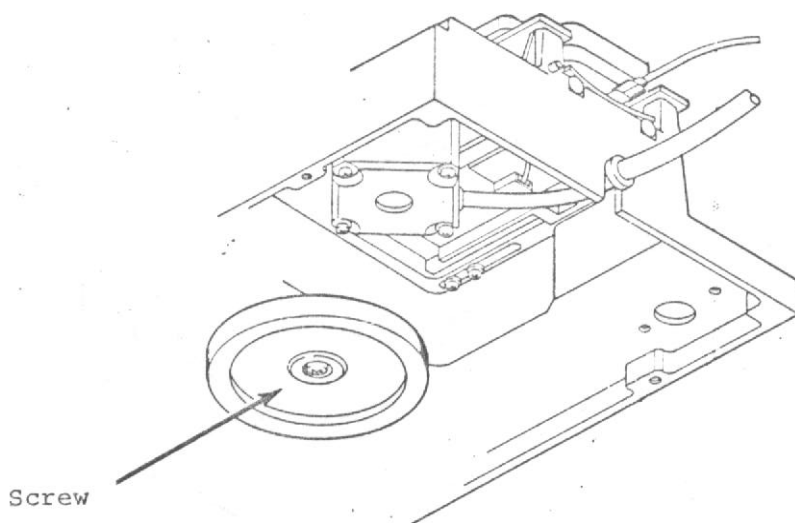


10. Now completely remove the two screws at the rear of the transport casting.
11. Pull the top of the front panel bezel forward.
12. Carefully, lift the carrier assembly out of the transport.

CAUTION : You will have to tilt the carrier assembly slightly to clear the head assembly's pressure pad arm. DO NOT lift the pressure pad arm higher than it would be lifted by the door arm during normal Drive operation. Lifting the pad arm too far will distort its pressure spring, changing the pressure pad's loading effect on the head.

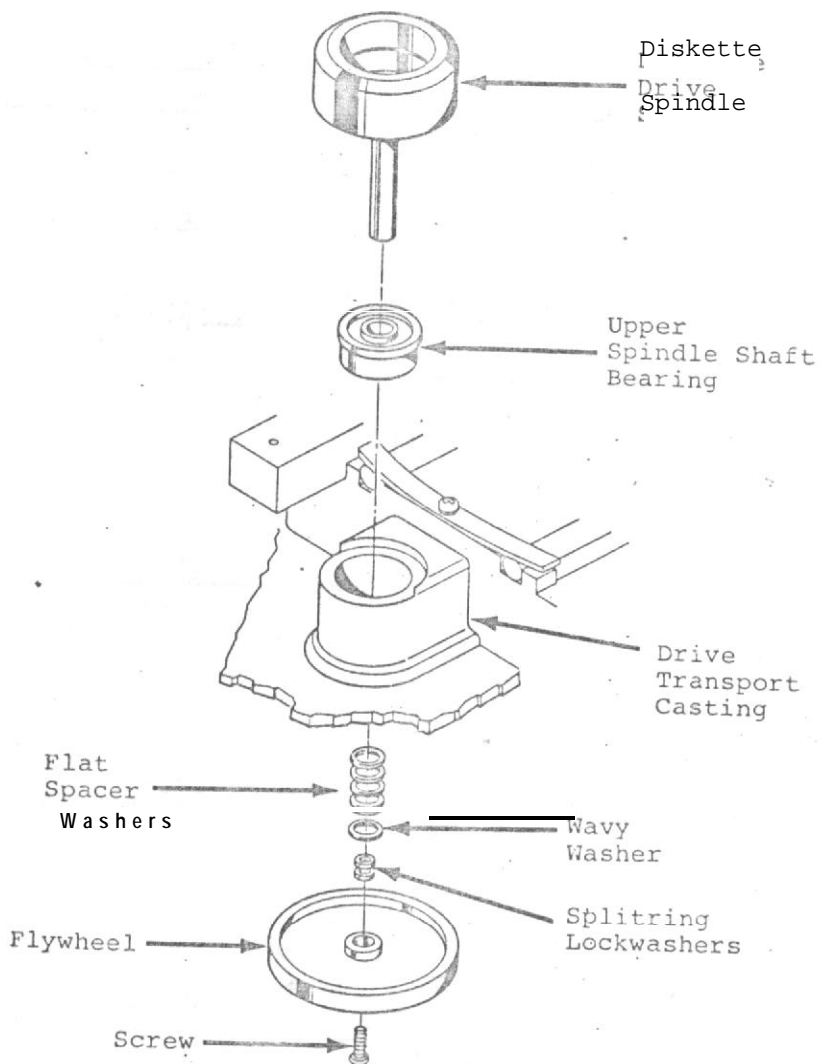
REMOVING THE TRANSPORT FLYWHEEL/DRIVE SPINDLE

1. Disassemble the Disk Drive case.
2. Remove the common baseplate from the Drive base.
3. Remove the Drive transport from the common baseplate.
4. Remove the drive belt from the transport.
5. Remove the carrier assembly from the transport.
6. Carefully lay the transport on its side.



7. Locate the single screw in the center of the flywheel. Holding the flywheel with one hand, remove the screw.

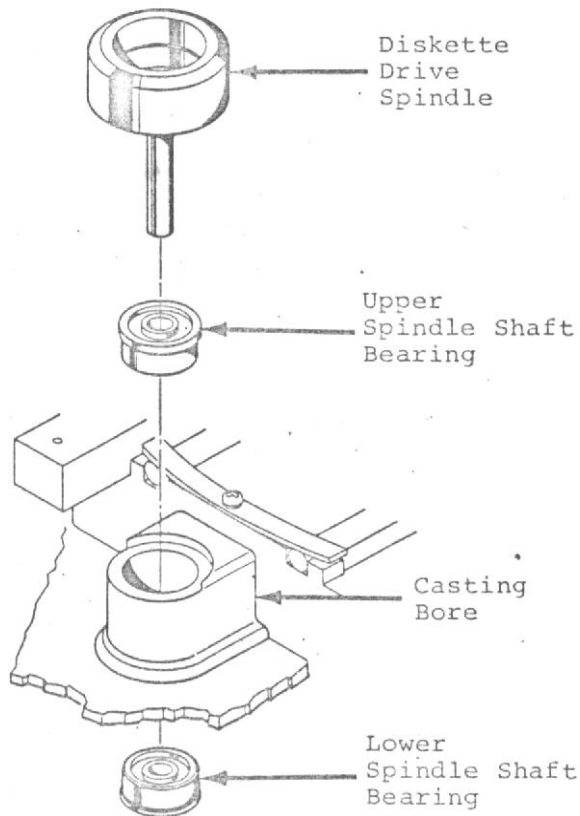
NOTE : See the following illustration of the flywheel/casting/spindle relationship. The specific number and placement of the washers is very important and helps to determine diskette speed during operation. DO NOT lose any of the washers you remove during this step.



8. Being very Careful not to lose any washers, hold the drive spindle with one hand and carefully pull the flywheel away from the casting with the other hand.
9. Pull the spindle from the casting.

REMOVING THE TRANSPORT SPINDLE SHAFT BEARINGS

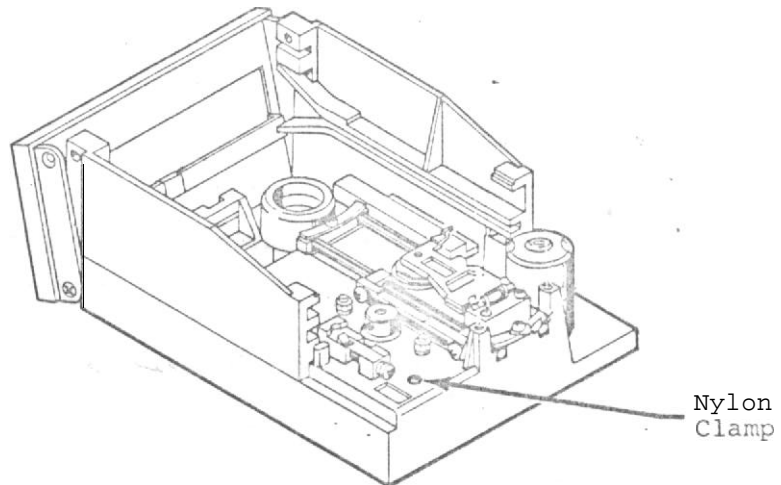
1. Disassemble the Disk Drive case.
2. Remove the common baseplate from the Drive base.
3. Remove the Drive transport from the common baseplate.
4. Remove the drive belt from the transport.
5. Remove the carrier assembly from the transport.
6. Remove the flywheel and drive spindle from the transport.



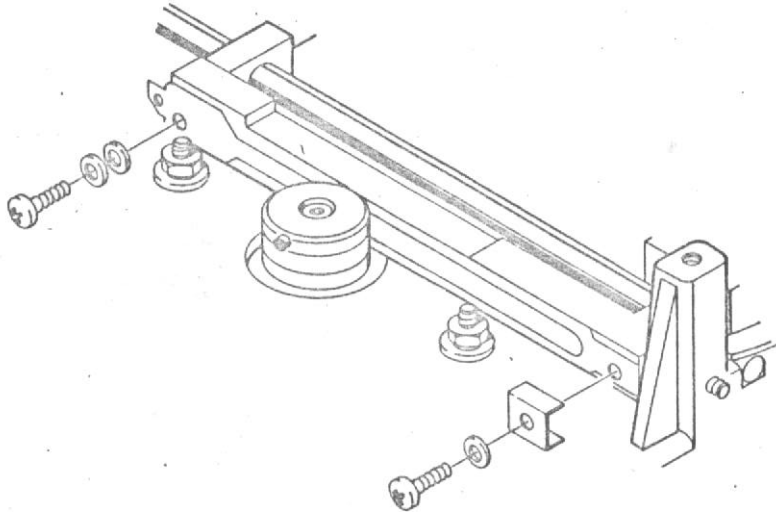
7. The top spindle shaft bearing may have lifted from the casting when you removed the drive spindle. If it did not, very carefully pry the bearing out of the casting.
8. Very carefully push the bottom bearing out of the casting (push from the top side of the casting, being very careful not to damage the casting bore).

REMOVING THE HEAD ASSEMBLY

1. Disassemble the Disk Drive case.
2. Remove the common baseplate from the Drive base.
3. Remove the Drive transport from the common baseplate.
4. Remove the carrier assembly from the transport.



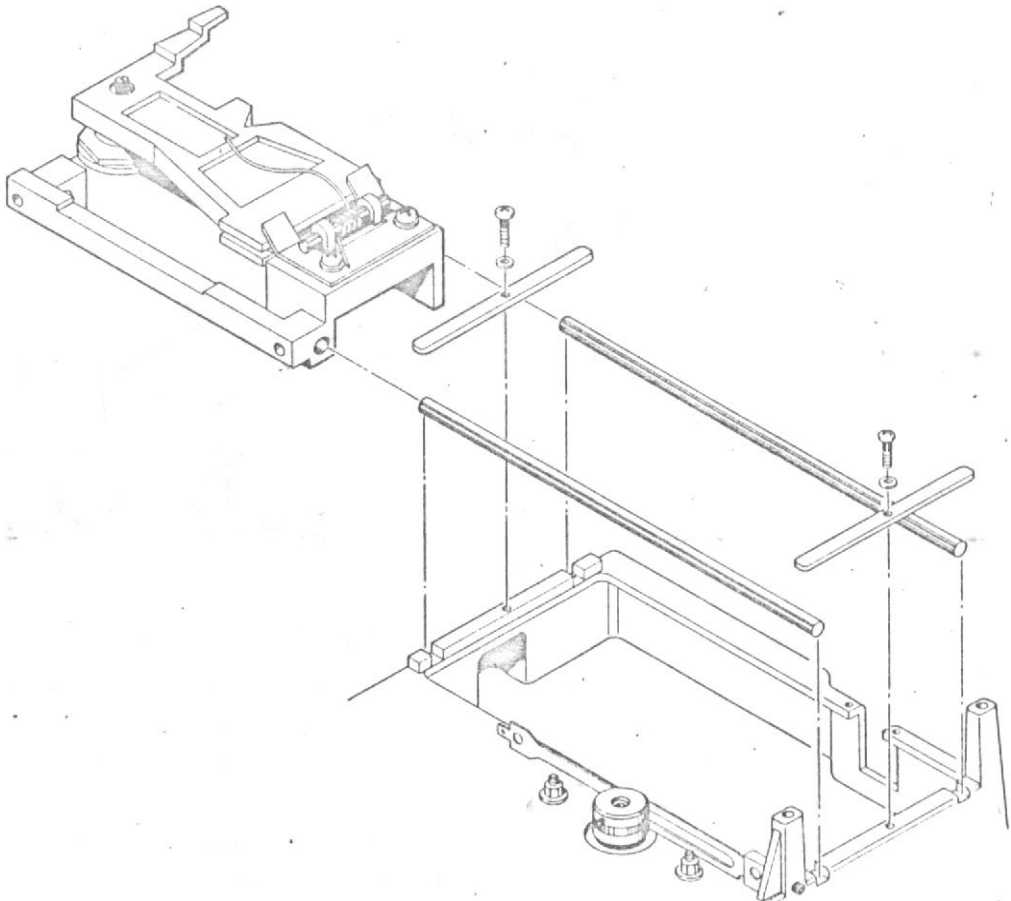
5. Locate the nylon clamp securing the record/playback and erase head I/O wiring harness to the right rear corner of the casting. Release the clamp from the casting.
6. Push the head assembly as far to the rear of the Drive as it will slide.
7. Locate and remove the ground lead (black wire from the drive motor wiring harness) faston from the rear of the casting.



8. Locate the two screws securing the stepper motor positioning band to the right side of the head assembly.
 - a. Remove the rear screw, being very careful not to crimp or damage the band, and noting the screw and washer arrangement.
 - b. Slide the head assembly carriage forward enough to allow you to remove the front band screw. Remove the front screw, again noting the screw and washer arrangement.

NOTE: The stepper motor positioning band is very delicate and very important to the operation of the Drive. DO NOT kink or damage the band in any way.

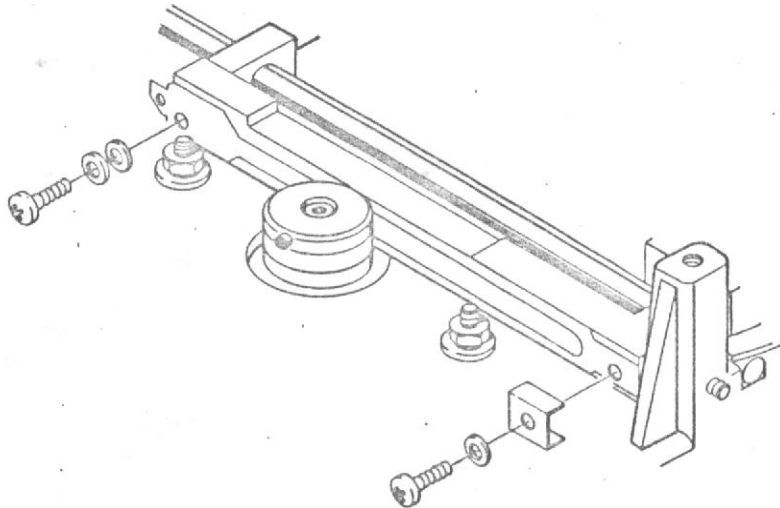
3. Locate the two screws securing the carriage guiderod clamps to the drive casting.
10. Remove the two screws and lift the guiderod clamps away from the assembly.
11. Carefully pry the two guiderods up out of their locating notches in the drive casting.



12. Gently lift the head assembly carriage and guiderods away from the casting. You will have to feed the head I/O cable through the casting at the same time.
- CAUTION: The head is subject to external magnetic fields. DO NOT use magnetized tools or allow the head to get near any equipment producing strong magnetic fields.
13. Slide the guiderods Out of the carriage.

REMOVING THE STEPPER MOTOR

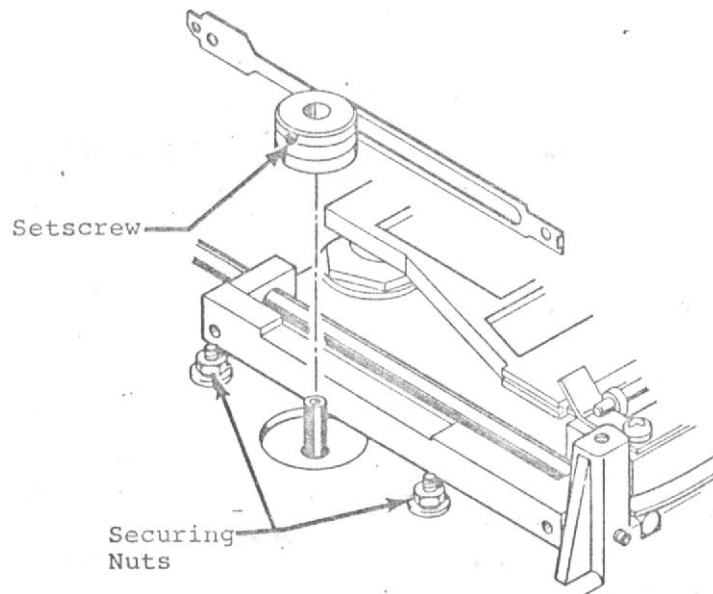
1. Disassemble the Disk Drive case.
2. Remove the common baseplate from the Drive case.
3. Remove the Drive transport from the common baseplate.



4. Locate the two screws securing the stepper rotor positioning band to the right side of the head assembly.
 - a. Remove the rear screw, being very careful not to crimp or damage the band, and noting the screw and washer arrangement.
 - b. Slide the head assembly carriage forward enough to allow you to remove the front band screw. Remove the front screw, again noting the screw and washer arrangement.

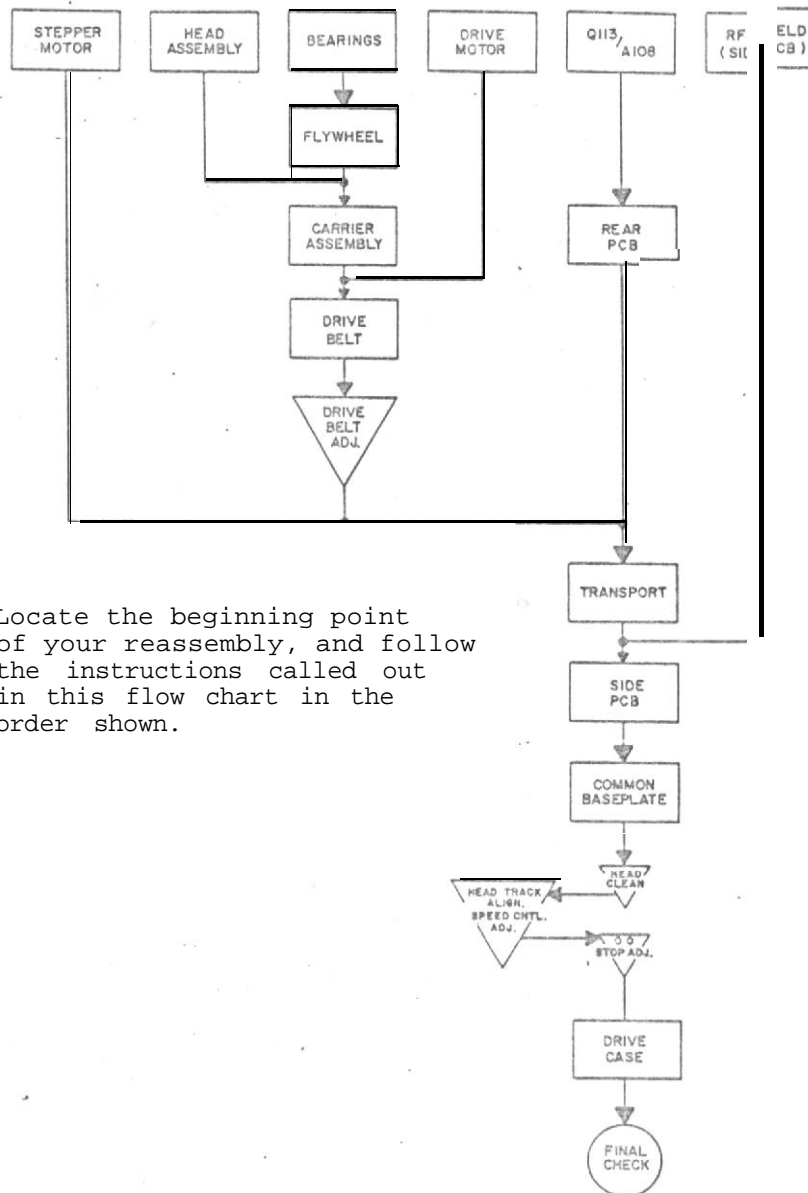
NOTE : The stepper motor positioning band is very delicate and very important to the operation of the Drive. DO NOT kink or damage the band in any way.

5. Locate the allen-head setscrew securing the head positioning strap pulley to the stepper motor drive shaft (topside of casting).
6. Back the setscrew out about 1 turn (counterclockwise).



7. Remove the band/pulley from the stepper motor shaft and set it aside.
8. Locate the two nuts securing the stepper motor to the casting.
9. Lay the casting on its left side.
10. While supporting the stepper motor with your right hand, remove the two securing nuts.
11. Carefully separate the motor from the chassis, while pulling the motor wiring harness out of its chassis slot.

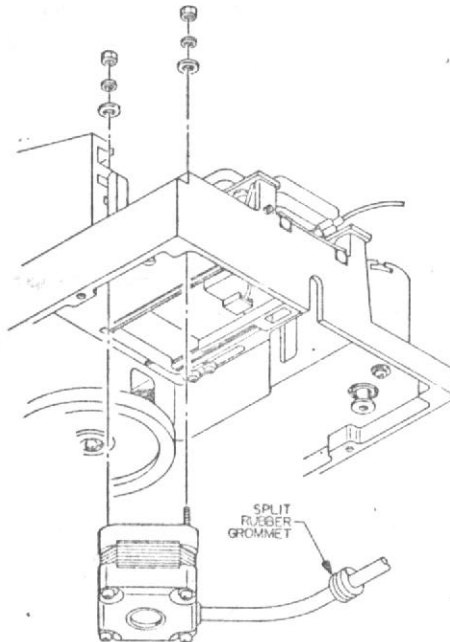
REASSEMBLY



Locate the beginning point of your reassembly, and follow the instructions called out in this flow chart in the order shown.

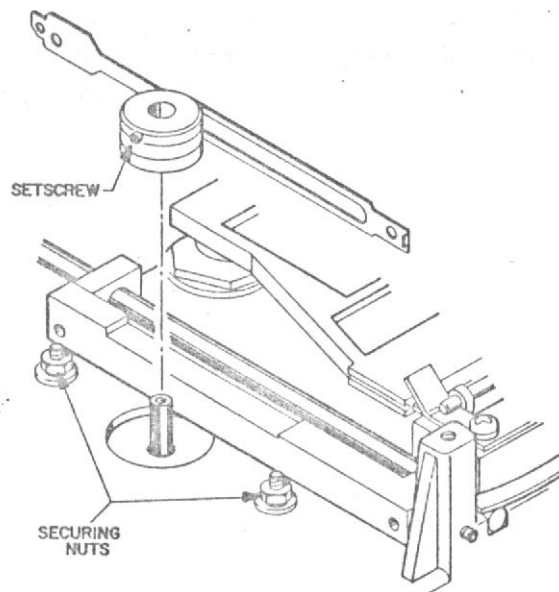
INSTALLING THE STEPPER MOTOR

1. Install a split rubber grommet on the stepper motor wiring harness.
2. Lay the transport on its left side.
3. Position the stepper motor to the underside of the transport casting. The motor's wiring harness should lie toward the rear center of the casting.



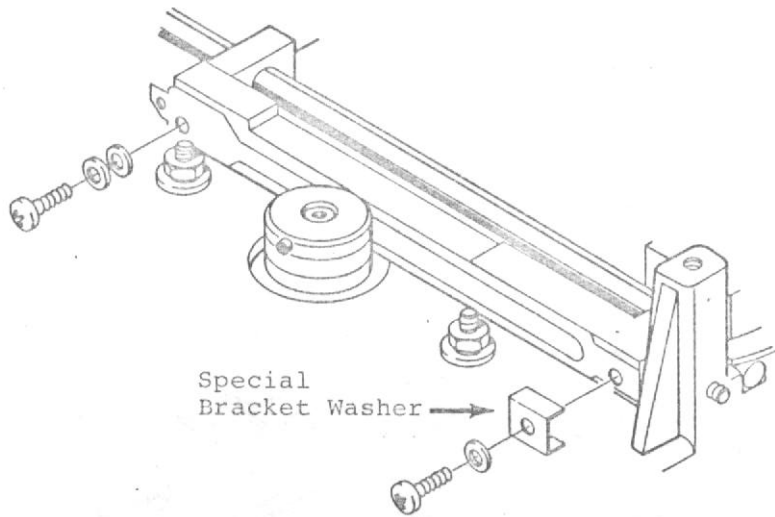
CAUTION: The head is subject to magnetization from external fields. DO NOT use magnetized tools or allow the head to get near any equipment producing strong magnetic fields.

4. Install a flatwasher, a splitting lockwasher, and a 1/4" hexnut onto each of the two stepper motor stud bolts projecting through the top of the casting. Lightly tighten the nuts.



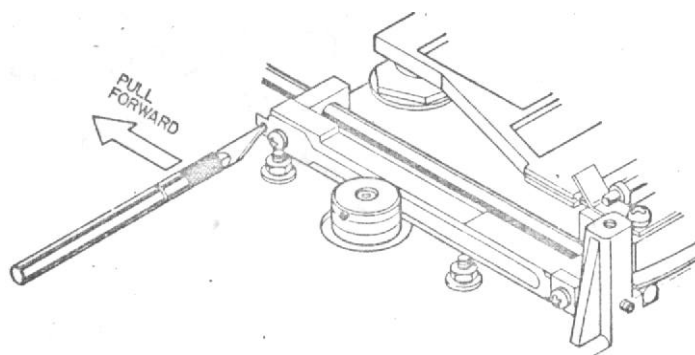
5. Carefully install the head positioning band pulley onto the stepper motor drive shaft (projecting through the top of the casting). If the pulley does not easily slip onto the motor shaft, back the pulley's allen-head setscrew a little farther out of the pulley. DO NOT tighten the setscrew at this time.

NOTE: The stepper motor positioning band is delicate and very important to the operation of the Drive. DO NOT kink or damage the band in any way.



6. Carefully position the head assembly, so that you can connect the positioning band to the assembly's right rear corner.
7. Install, but do not tighten, the rear screw, splitting lockwasher, and special bracket washer to hold the rear section of the positioning band to the head assembly.
8. Carefully pull the front section of the positioning band forward until its screw hole is located over the matching screw hole on the front corner of the head assembly.
9. Install, but do not tighten, the screw, splitting lockwasher, and flatwasher to secure the band to the head assembly.
10. Gently slide the head assembly back and forth on its guiderods. This will center the band pulley on the stepper motor shaft.
11. Tighten the rear band retaining screw.

CAUTION: DO NOT exceed 6 inch lbs. torque when tightening screws into plastic parts.



12. Use a pointed tool (ie. X-acto knife point, etc.) to hook the small hole on the front end of the positioning band. Pull forward slightly on the band while tightening the front band retaining screw.
13. Slide the wiring harness' grommet up into the slot at the rear of the transport casting.
14. Attach the transport to the common baseplate.
15. Attach the common baseplate to the Drive base.

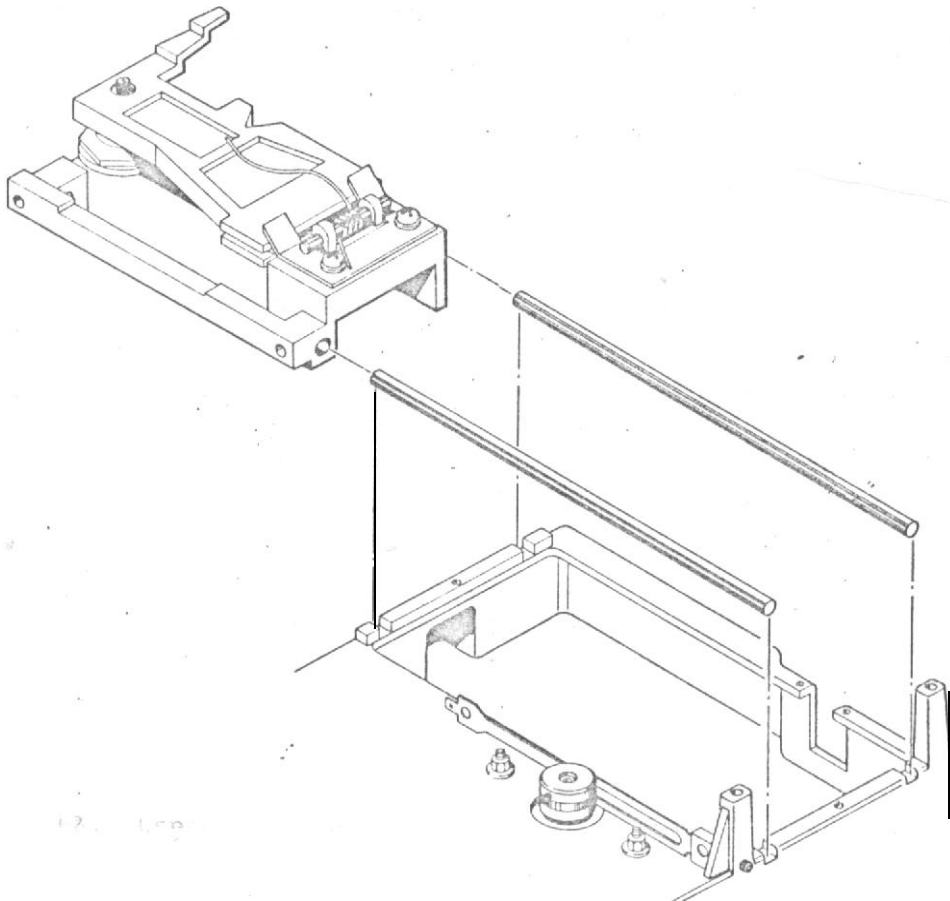
INSTALLING THE HEAD ASSEMBLY

CAUTIONS: The head is subject to magnetization from external fields. DO NOT use magnetized tools or allow the head to get near any equipment producing strong magnetic fields.

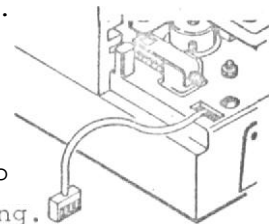
The head is also damaged by dirt and oils. DO NOT touch either the head or the pressure pad with your fingers.

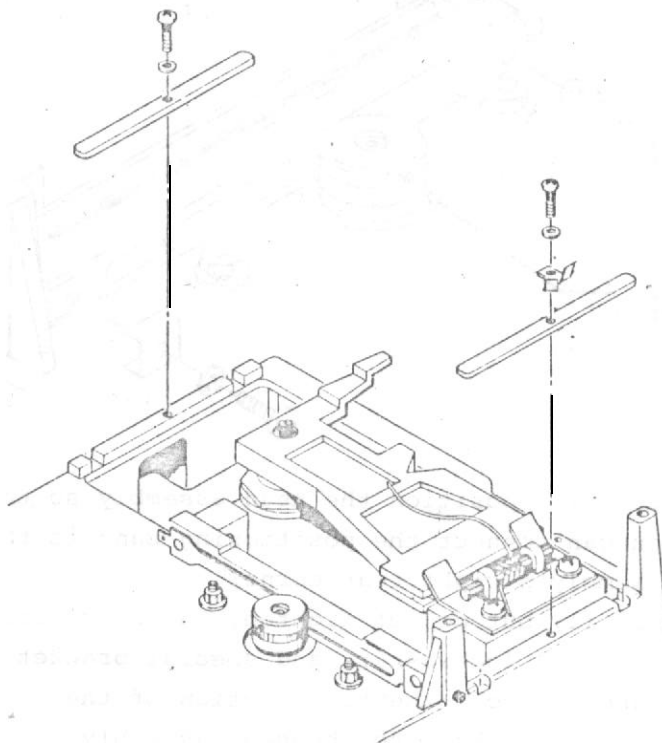
DO NOT lift the pressure pad arm farther from the head carriage than the arm would be lifted during normal Disk Drive operations. Lifting the arm too far will distort its pressure spring, changing the arm's loading effect on the head during operation.

The stepper motor positioning band is delicate and very important to the operation of the Drive. DO NOT kink or damage the band in any way.

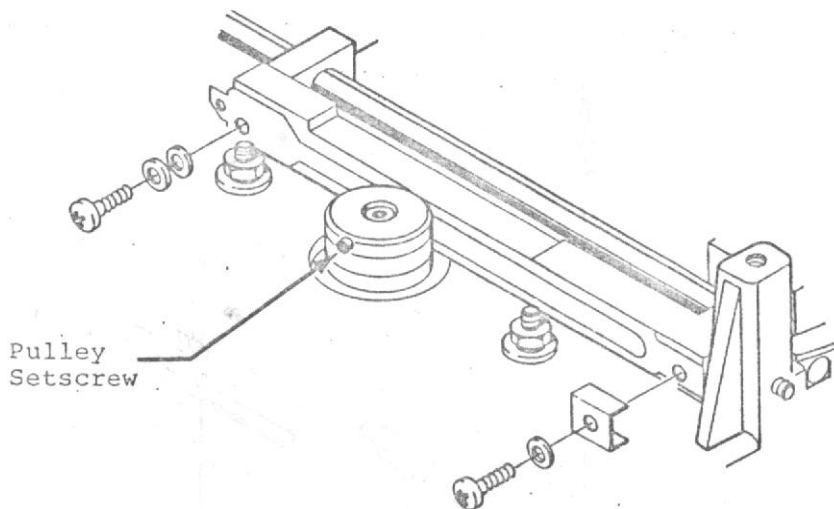


1. Slide the two guiderods into the sides of the head assembly carriage.
2. Carefully lower the carriage/guiderods assembly into position in the transport casting. Ensure that the head wiring harness lies down in the underside of the transport.
3. Wrap a small piece of masking tape around the head assembly's wiring harness, about 3" from the head. Install the nylon cable clamp over the tape and snap the clamp into the hole provided at the back of the casting.
4. Feed the wiring harness up through the rectangular hole at the right rear corner of the transport casting.



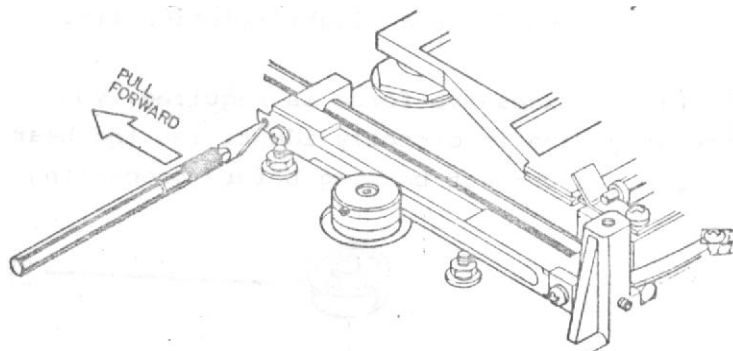


5. Center (front-to-back) the two head assembly guiderods in their transport casting slots.
6. Position the two guiderod clamps onto the casting, over the ends of the guiderods.
7. Install, but do not tighten, the front clamp screw including a splitring lockwasher.
8. Install, but do not tighten, the rear clamp screw including two male faston terminals and a splitring lockwasher.
9. Tighten the two clamp screws to 10 inch lbs. torque.



10. Carefully position the head assembly so that you can connect the positioning band to the assembly's right rear corner.
11. Install, but do not tighten, the rear screw, splitting lockwasher, and special bracket washer to hold the rear section of the positioning band to the head assembly.
12. Carefully pull the front section of the positioning band forward until its screw hole is located over the matching screw hole on the front corner of the head assembly.
13. Install, but do not tighten, the screw, splitting lockwasher, and flatwasher to secure the band to the head assembly.
14. Locate the allen-head setscrew securing the positioning band pulley to the stepper motor driveshaft. Back the setscrew out (counterclockwise) about 1/4 turn.
15. Gently slide the head assembly back and forth on its guiderods. This will center the band pulley on the stepper motor shaft.
16. Tighten the rear band retaining screw.

CAUTION: DO NOT exceed 6 inch lbs. torque when tightening screws into plastic parts.

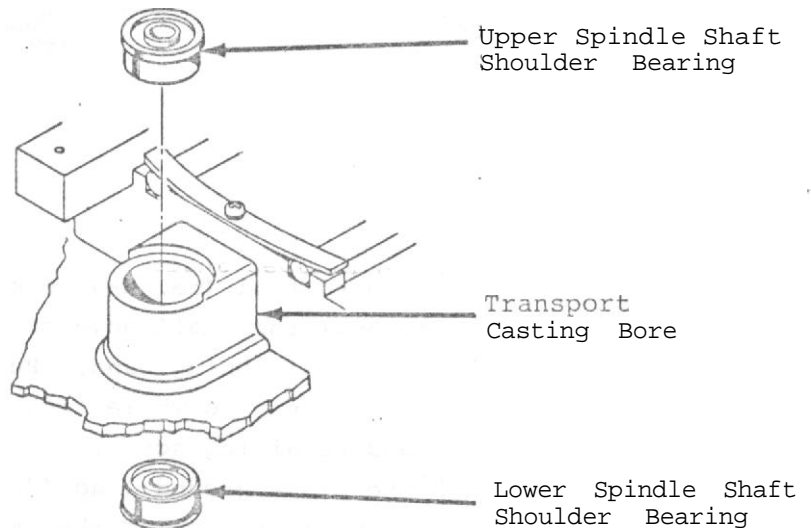


17. Use a pointed tool (ie. X-acto knife point, etc.) to hook the small hole on the front end of the positioning band. Pull forward slightly on the band while tightening the front band retaining screw.
18. Attach the black ground lead (drive motor wiring harness) to one of the faston lugs at the rear of the transport.
19. Attach the carrier assembly to the transport.

INSTALLING THE TRANSPORT SPINDLE SHAFT BEARINGS

1. Gently insert either the top or bottom(or both) shoulder bearings into the casting bore.
There should be a slight friction fit.

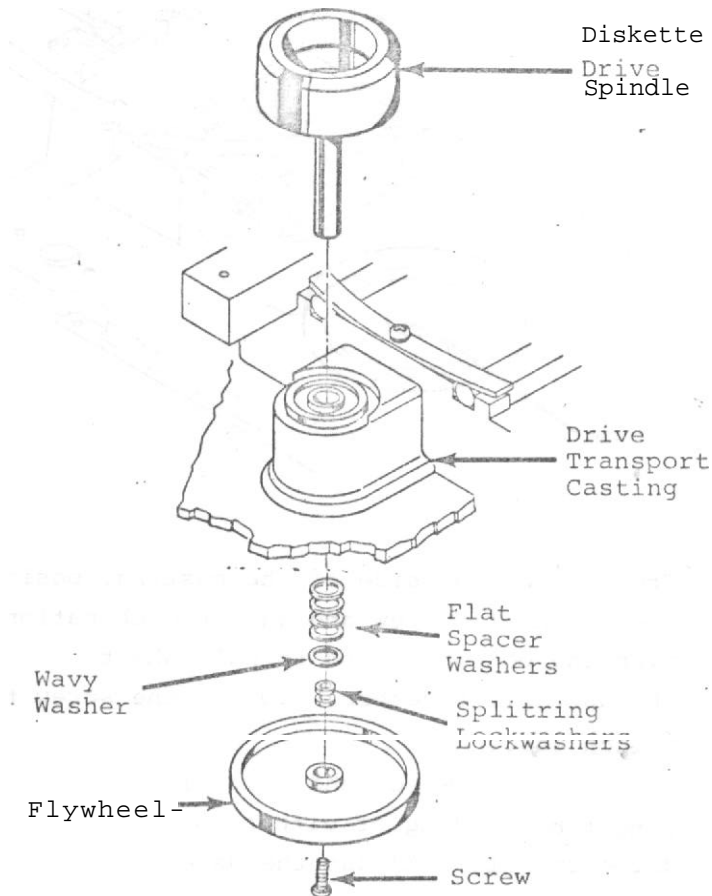
NOTE: If excessive force is required, you probably have incorrectly identified the bearing.
Obtain the correct bearing before proceeding.



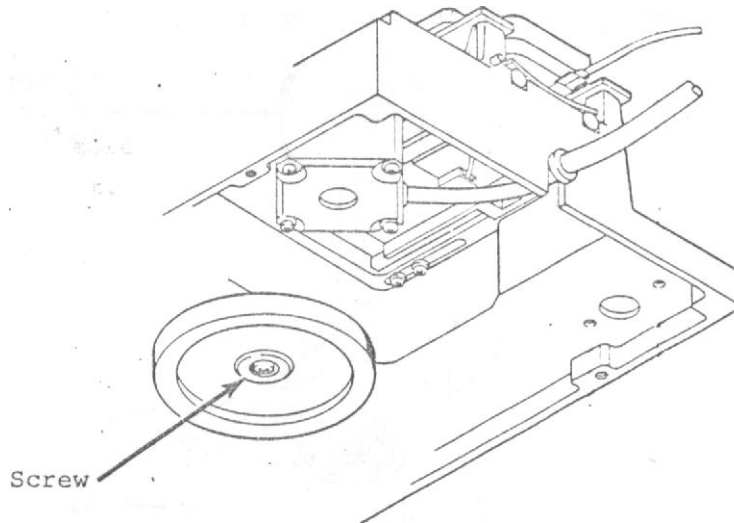
2. Ensure that the shoulder of the bearing is firmly seated flat against the casting.
3. Attach the flywheel and drive spindle to the transport.

INSTALLING THE TRANSPORT FLYWHEEL/DRIVE SPINDLE

1. Lay the transport casting on its side.



2. From the top side of the casting, insert the diskette drive spindle into the shoulder bearings.
3. Assemble the necessary combination of washers along with the flywheel and screw. See the illustration for the flywheel/casting/spindle relationship. The specific number and placement of the washers is very important and helps to determine diskette speed during operation.



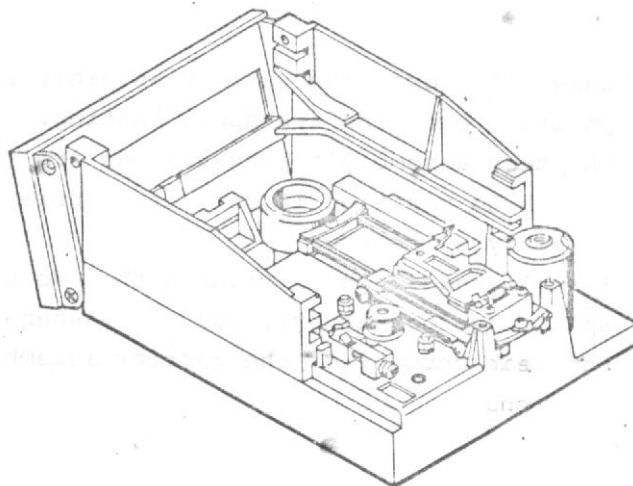
4. From the bottom side of the casting, position the flywheel, screw and washer combination over the bottom of the spindle shaft. screw the assembly together. Torque the screw to 6 inch lbs..
5. Rotate the flywheel and check for wobble, runout or binding of either the flywheel or drive spindle. Adjust the assembly as necessary.
6. Attach the carrier assembly to the transport.

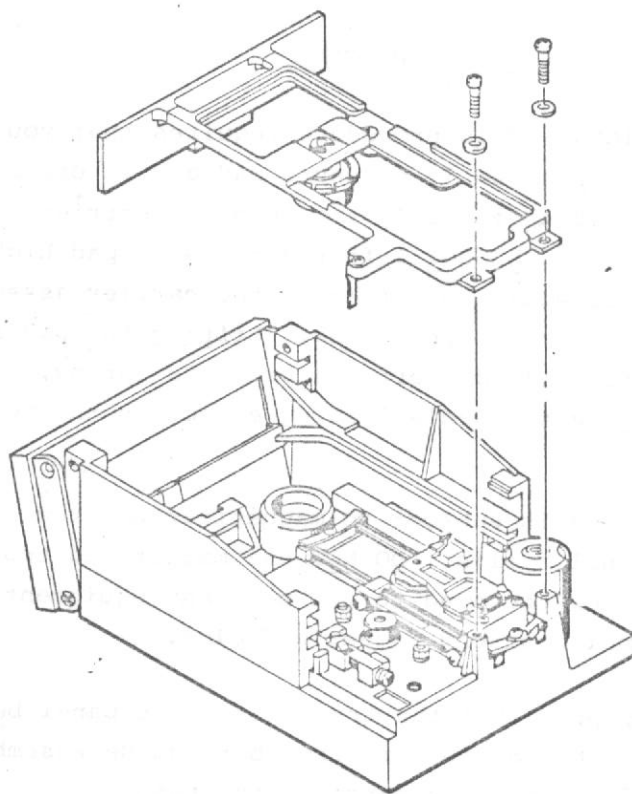
INSTALLING THE CARRIER ASSEMBLY

CAUTIONS: This procedure requires that you lift the head assembly pressure pad arm in order to position its lift arm onto the carrier assembly. DO NOT lift the pressure pad higher than it would be lifted by the carrier assembly during normal operations. Lifting the pad arm too far will distort its pressure spring, changing the pad's loading effect on the head.

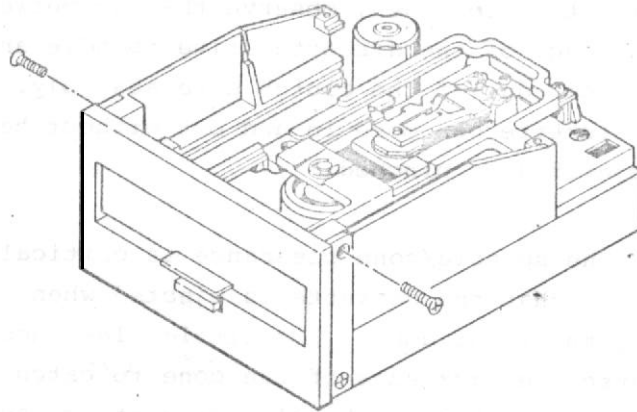
The head is subject to magnetization from external fields. DO NOT use magnetized tools or allow the head to get near any equipment producing strong magnetic fields.

1. Ensure that the transport front panel bezel is tilted forward from both guide assemblies for extra clearance at the top.

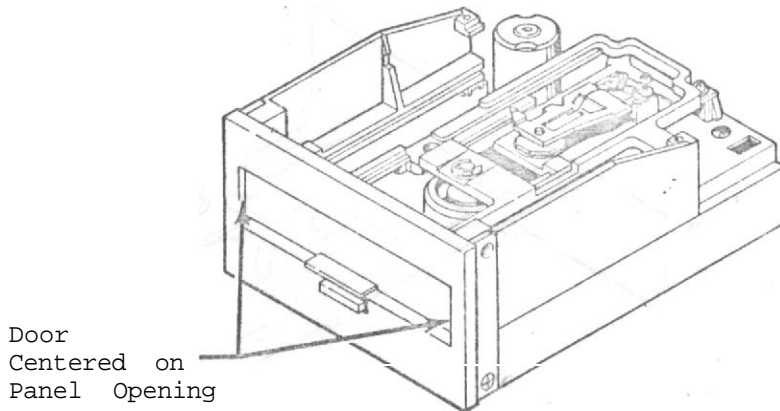




2. Carefully lower the carrier assembly into position over the transport casting. Lift the head assembly's pressure pad arm just enough to position it onto its carrier assembly slide area.
3. Install and slightly tighten the two screws, splitting lockwashers, and flatwashers at the rear corners of the carrier assembly.



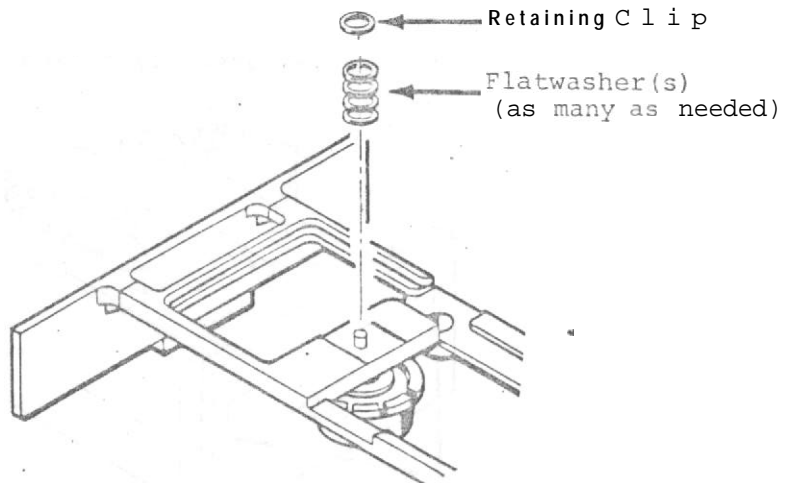
4. Push the bezel back to its normal position and install the two top screws.
5. Tighten the four screws securing the bezel to the transport.
6. Latch the carrier assembly closed (down) at the bezel.



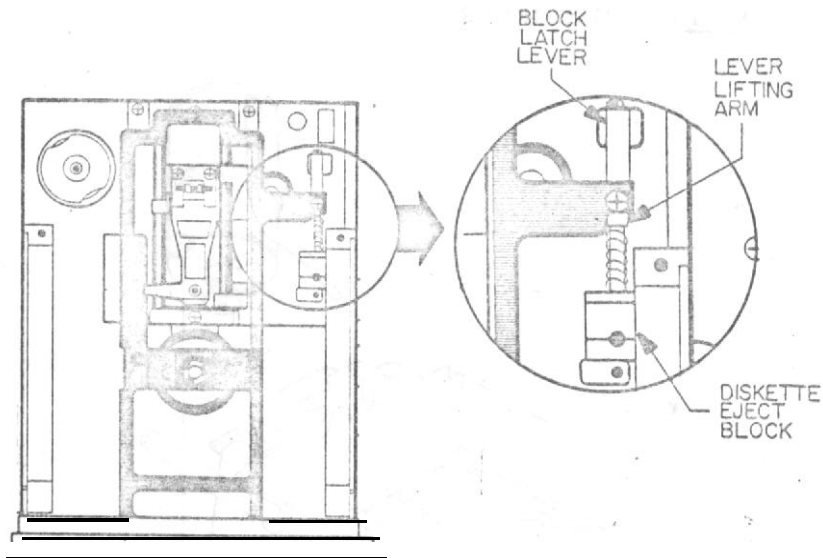
7. Horizontally center the door in the door opening of the bezel.
8. Tighten (10 inch lbs.) the two screws securing the rear corners of the carrier assembly to the rear of the transport casting.
3. Press the front door release button. Ensure that the door opens and the carrier assembly lifts the head assembly pressure pad arm.

10. With the door open, observe the gap between the top edge of the diskette drive spindle and the bottom edge of the clutch cone assembly. Be sure a diskette can move in and out without being scratched or pinched.

NOTE : The spindle/cone clearance is critical to ensure that the diskette is ejected when opening the front door. Too little clearance may cause the back edge of the cone to catch the edge of the diskette hub hole, preventing the diskette from being ejected. Test the ejection process using a standard diskette.

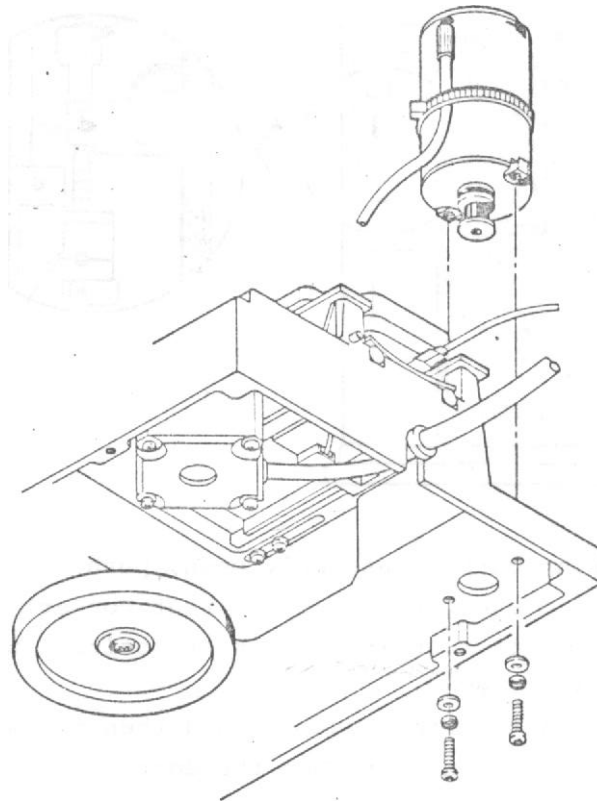


11. To adjust the clearance, compress the clutch cone into the doorarm, forcing the clutch cone shaft up out of the top of the carrier assembly.
12. Locate and remove the retaining clip from the shaft.
13. Place another flatwasher over the shaft and replace the retaining clip.
14. Release the clutch cone and return to step 10.



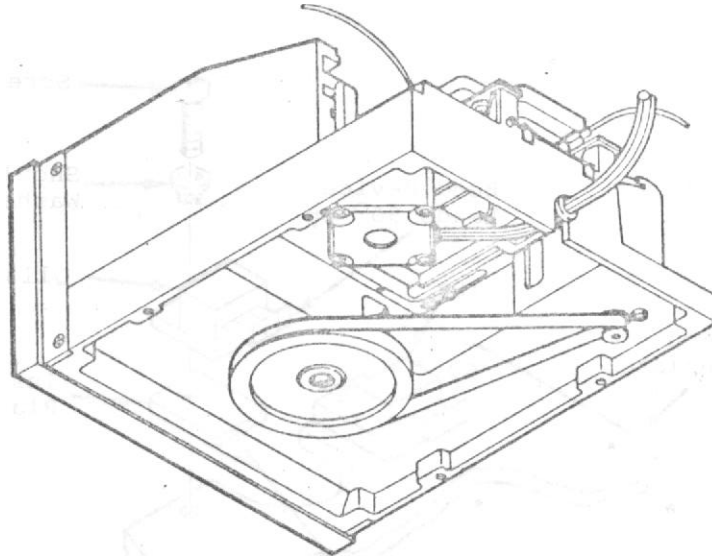
15. With the carrier assembly open, push the diskette eject block (right rear corner) until it latches into its rear position under the latch lever.
16. Close the carrier assembly and then press the release button to reopen the door.'
17. Check to see that the diskette eject block freely returned to its forward position when the carrier assembly opened.
18. If the block did not return, bend either the latching lever or the lever lifting arm to adjust the mechanism.
19. Repeat, steps 15 thru 18 until the diskette eject mechanism works as indicated.
20. If necessary, install the drive belt.
21. Attach the transport to the common baseplate.

INSTALLING THE "RIVE MOTOR



1. Lay the Drive transport on its side.
2. Position the drive motor onto the top side of the casting. The motor's wiring harness should exit the motor toward the center rear of the transport.
3. While supporting the motor with one hand, install the two screws, split ring lockwashers, and flat washers to secure the motor to the transport.
4. Torque the two screws to 10 inch lbs.
5. Attach the drive belt to the transport.

INSTALLING THE TRANSPORT DRIVE BELT

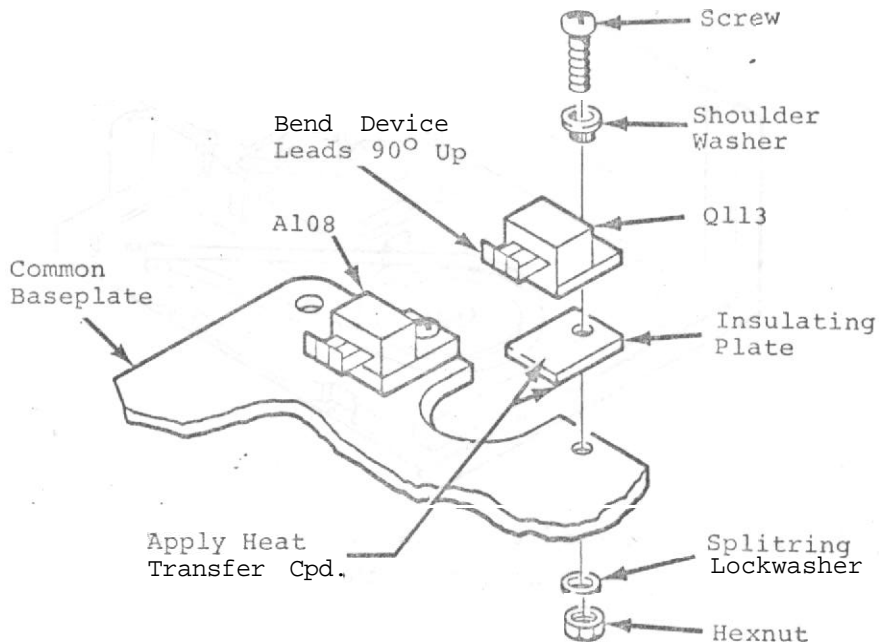


1. Lay the transport on its s i d e .
2. Loop the drive belt over the drive motor drive hub. Carefully ease the belt onto the flywheel while rotating the flywheel.

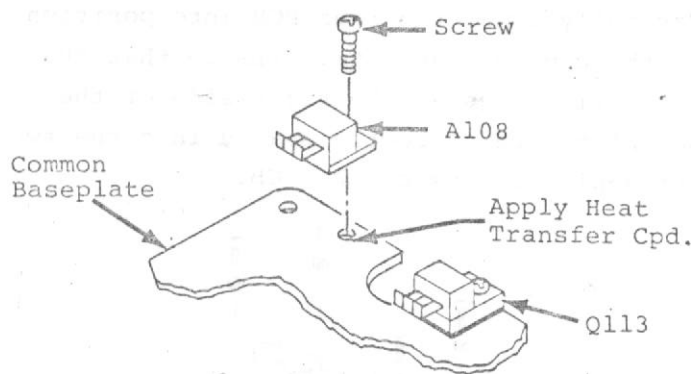
NOTE: DO NOT stretch or damage the drive belt. It is primarily responsible for diskette speed and any variations in diskette speed caused by a stretched or damaged drive belt can cause errors during read and write operations.

3. Refer to the adjustments section of this manual and complete the drive belt adjustment.
4. Attach the transport to the common baseplate.

INSTALLING Q113 (TRANSISTOR)/A108 (VOLTAGE REGULATOR)



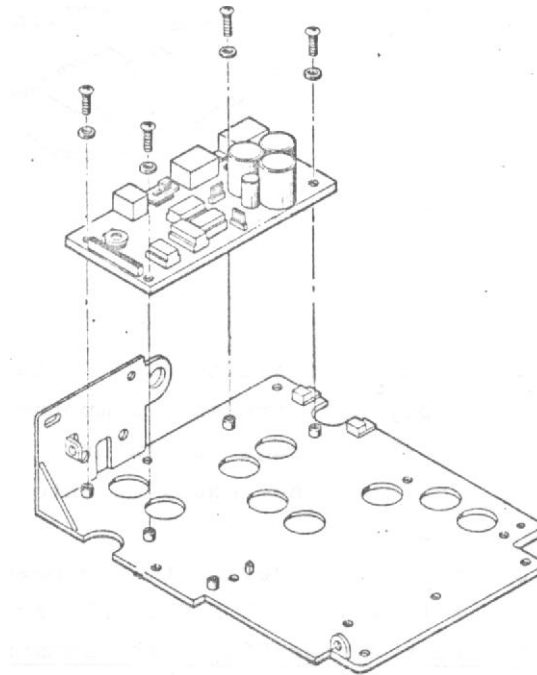
1. Bend the leads of the device you are about to install as shown above.
2. If you are installing Q113(transistor):
 - a. Apply heat transfer compound to both sides of the mica insulating plate.
 - b. Place the insulating plate into location on the common baseplate.
 - c. Place the transistor into position on top of the insulating plate.
 - d. Secure the transistor/insulating plate combination to the common baseplate with a #4-40 x 3/8" PHIL HD. screw, a shoulder washer, #4 splitring lockwasher, and a #4 ST2 hexnut.



3. If you are installing A108(voltage regulator):
 - a. Apply heat transfer compound to the back of the voltage regulator.
 - b. Position the regulator onto the common baseplate.
 - c. Secure the device to the baseplate with a #4 x 1/4 THD F PHIL HD. screw.
4. Attach the rear PCB to the common baseplate.

INSTALLING THE REAR PCB

1. Carefully lower the rear PCB into position on the common baseplate. Ensure that the six device legs at the right side of the baseplate are correctly seated into the two three-pin sockets on the PCB.

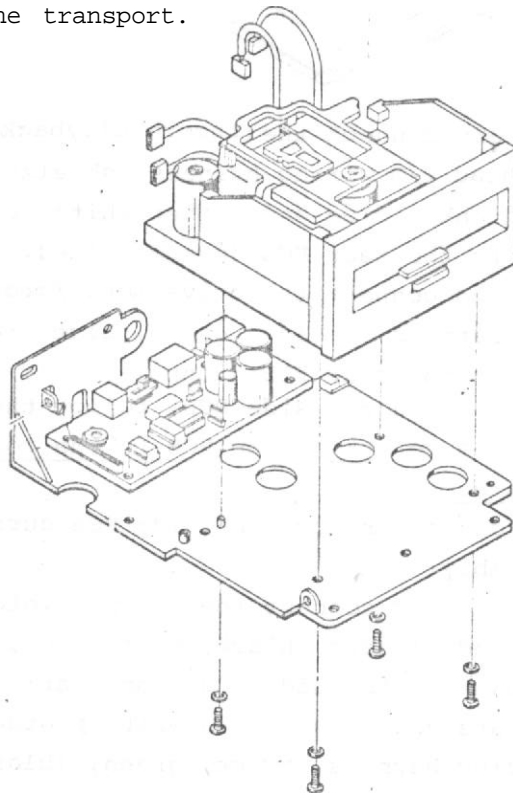


2. Install and tighten the four screws (#6-32 x 1/4" PHIL HD.) and lockwashers (#6 splitring) to secure the PCB to the baseplate.
3. Connect the transport to the common baseplate.

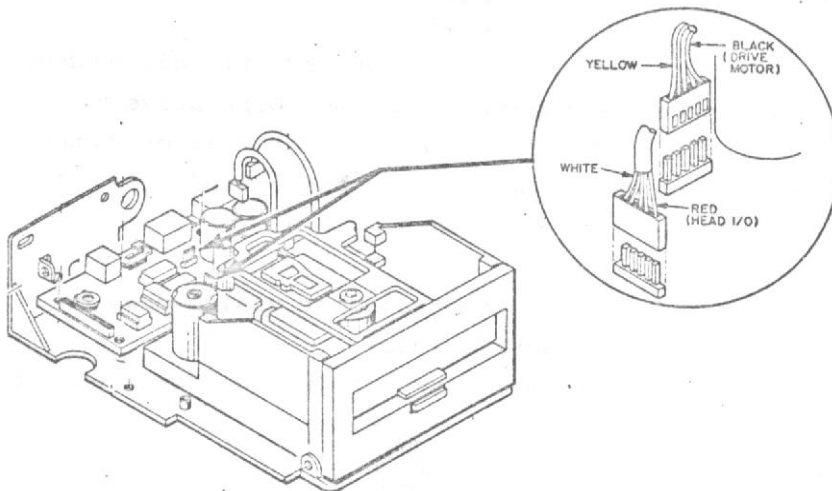
INSTALLING THE DRIVE TRANSPORT

CAUTION: The transport provides critical mechanical alignments necessary for proper Disk Drive operation. Be very careful not to jar or damage the transport or any of its associated sub-assemblies and components.

1. Carefully set the transport upside down on a suitable work surface.
2. Gently set the transport (upside down) on top of the transport.



3. Install and tighten the four screws (#6-32 x 1/4" PHIL HD.) and lockwashers (#6 splitting) to secure the transport to the baseplate.
4. Set the assembly rightside up on the work surface.

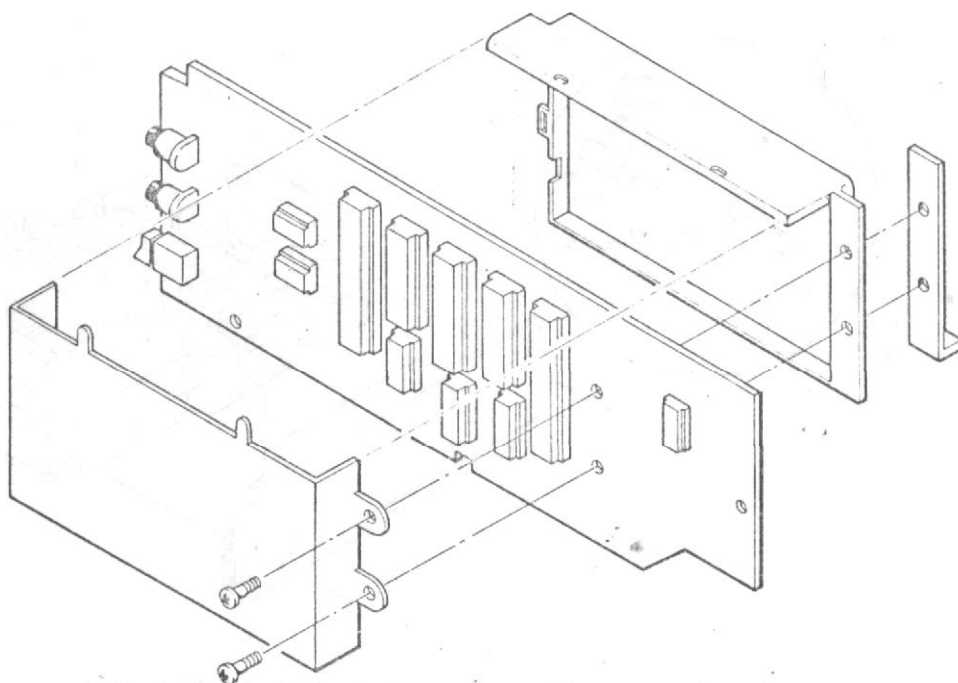


5. Locate and connect the record/playback and erase head I/O wiring harness (shielded-red, (blank), blue and either white, black or black, white) to the r&r PCB (nonpolarized, X4).
6. Locate and connect the drive motor/ground wiring harness (yellow, green, blue, red, black) to the rear PCB (nonpolarized, #3).*
7. If you removed the side PCB, follow the procedures to attach the PCB to the common baseplate.
8. If you did not remove the side PCB during disassembly:
 - a. Locate and connect the stepper motor wiring harness (black, white, red, green, brown) to the side PCB (nonpolarized, #2).
 - b. Locate and connect the write protect wiring harness (black, green, (blank), red, black) to the side PCB (nonpolarized, #1).
9. Go on to step 10.
10. Attach the common baseplate to the Drive base.

"NOTE: See Appendix for alternate wiring harness arrangement.

INSTALLING THE RF SHIELD (SIDE PCB)

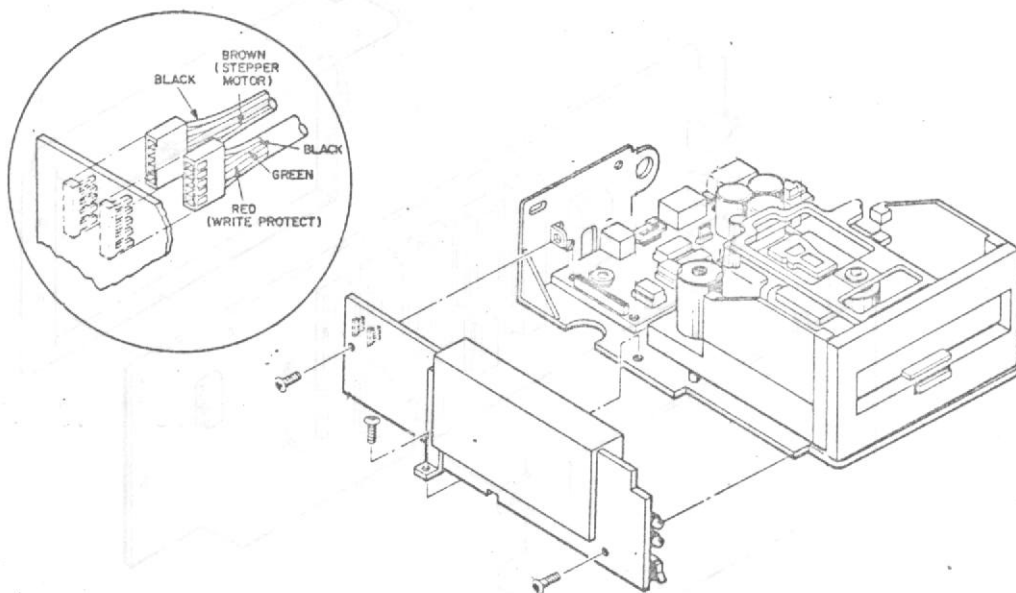
CAUTION: Excessive handling of the locating tabs on the shield case will break them. DO NOT bend the tabs anymore than absolutely necessary.



1. Carefully position the case halves onto the side PCB.
2. Position the ground bracket onto the side PCB.
3. Install and tighten the two screws (#6-32 x 5/16" TRD F, PHIL HD.) to secure the ground bracket to the PCB and case halves.
4. Locate and bend the three tabs securing the RF shield case halves together.
5. Connect the side PCB to the common baseplate.

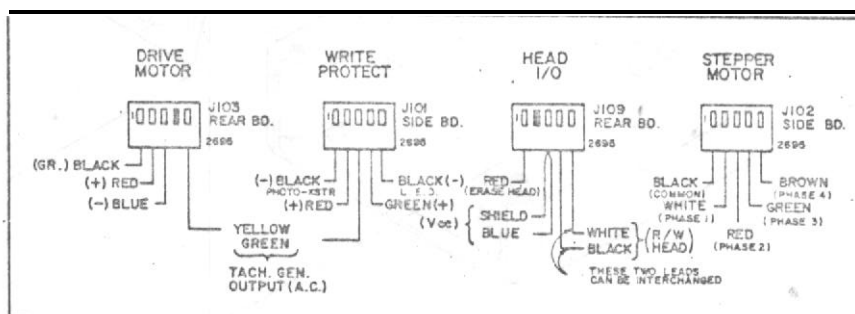
INSTALLING THE SIDE PCB

1. Position the side PCB on the common baseplate (with rear PCB installed).



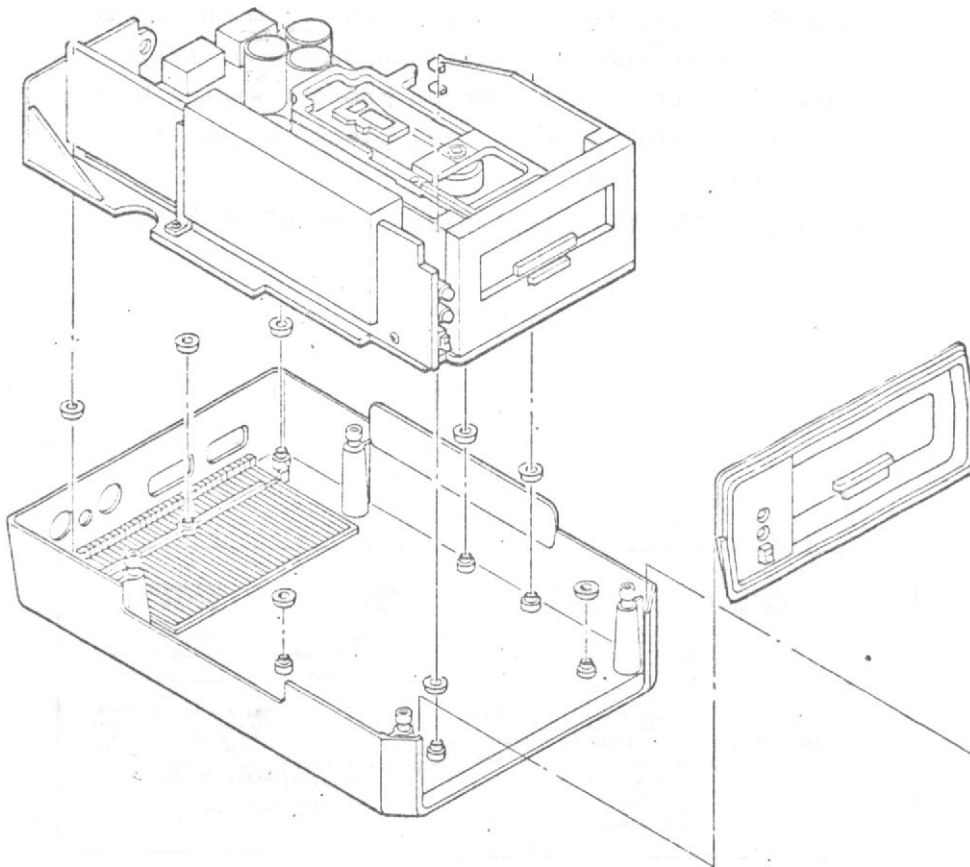
2. Gently seat the multipin socket at the rear lower edge of the side PCB down onto the pins protruding from the rear PCB.
3. Install and tighten the three screws (#6-32 x 5/16" THD F, PHIL HD.) that secure the side PCB and its ground bracket to the common baseplate.

4. Locate and connect the stepper motor wiring harness (black, white, red, green, brown) from the Drive transport to the side PCB (nonpolarized, #2).
5. Locate and connect the write protect wiring harness (black, green, (blank), red, black) to the side PCB (nonpolarized, #1).
6. Attach the common baseplate to the Drive base.

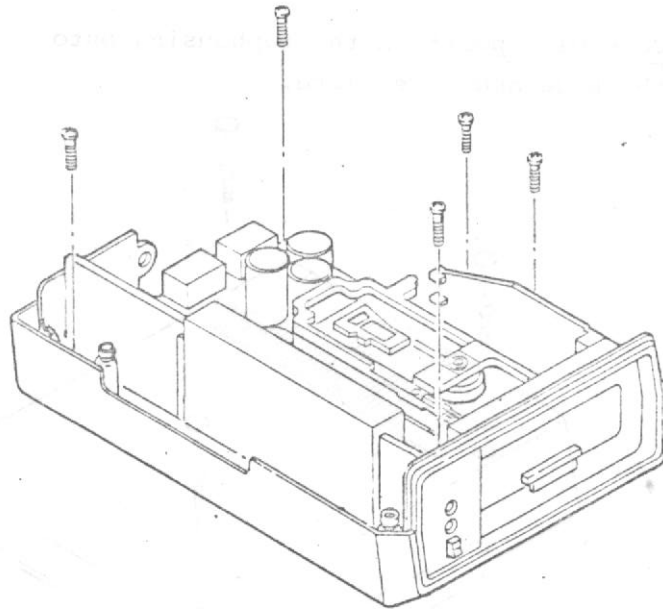


NOTE: You may also have this wiring harness arrangement.

INSTALLING THE COMMON BASEPLATE



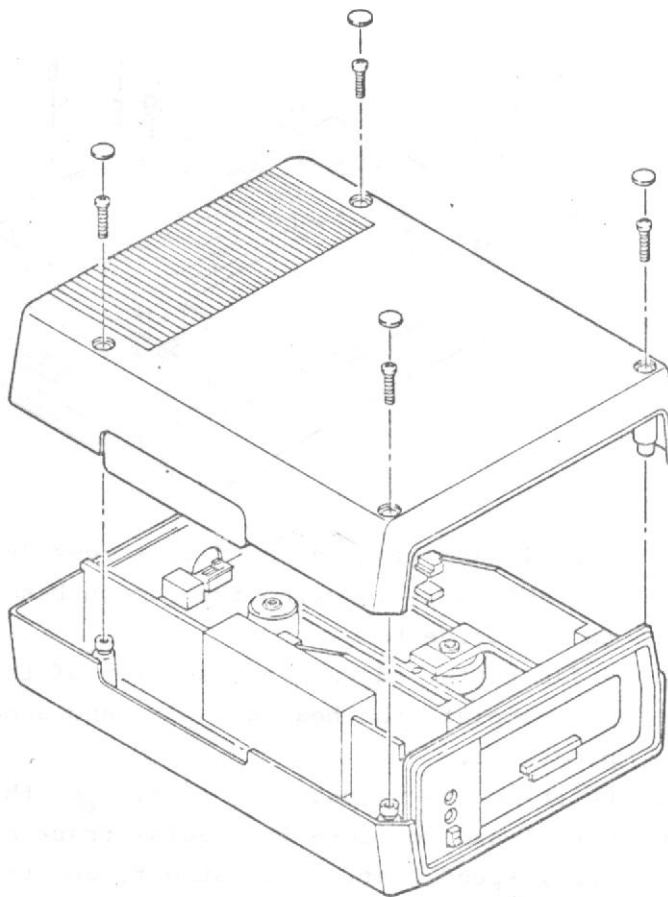
1. Ensure that every boss in the base (even those not used to secure the baseplate) is topped with a rubber isolation washer.
2. Position the front coverplate onto the baseplate/transport/PCB assembly.
3. Carefully lower the baseplate into position in the Drive base, ensuring that the cover-plate is also correctly positioned in the base.



4. Install and tighten the five screws (6 - 1/2" BT. PHIL HD.) securing the common baseplate to the Drive base.
5. Refer to the adjustments section of this manual and complete the head cleaning and demagnetization procedure.
6. Refer to the adjustments section of this manual and complete the radial track alignment, speed control adjustment, and track ØØ end stop adjustment.
7. Reassemble the Drive case.

ASSEMBLING THE DRIVE CASE

1. Carefully position the tophousing onto the base and coverplate.



2. Install and tighten the four screws (#6 - 3/4" SHTMTL PHIL HD.) securing the tophousing to the coverplate. Install the screw hole covers.
3. Refer to the final checkout section of this manual and complete the full checkout procedure for the Drive.