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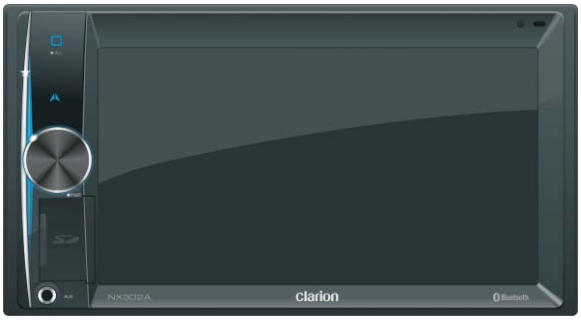
Service Manual



MULTIMEDIA STATION WITH BUILT-IN NAVIGATION & 6.2" TOUCH PANEL CONTROL

NX302A

Model TX-1090K-A

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.

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.
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About the Registered Marks,etc.

* "Made for iPod," and "Made for iPhone" mean that an electronic accessory has been designed to connect specifically to iPod, or iPhone, respectively, and has been certified by the developer to meet Apple performance standards.
  Apple is not responsible for the operation of this device or its compliance with safety and regulatory standards. Please note that the use of this accessory with iPod or iPhone may affect wireless performance.
  iPhone and iPod are trademarks of Apple Inc., registered in the U.S. and other countries.
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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 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. Caution 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 for 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 for 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℃. 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 30cms away from the lens. Prolonged viewing of the laser within 30cms 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.

Package Contents

Source unit 1
Wire connector 1
GPS antenna 1
CLAMP for GPS antenna's cable 3
DOUBLE FACE TAPE for GPS Antenna... 1
2Din Trim ring (wide) 1
2Din Trim ring (narrow)..... 1
Cleaning cloth..... 1
Quick Start Guide 1
Owner's manual (CD-R) 1
Electro tap 2
Flush mount bolts(M5x6) 8
Hexagon Head Screw(M5x6) 8
AV cable 1

SPECIFICATIONS

FM Tuner

Frequency range: 87.5-108.0MHz
Usable sensitivity: 13dBf
Frequency response: 30Hz-15kHz
Stereo separation: 30dB(1kHz)
Signal/noise ratio: >55dB

AM Tuner

Frequency range: 531-1629kHz
Usable sensitivity (S/N=20dB): 30dBμ

MP3/WMA mode

MP3 sampling rate: 8 kHz to 48 kHz
MP3 bit rate: 8 kbps to 320 kbps / VBR
WMA bit rate: 8 kbps to 320 kbps

USB

Specification: USB 1.0/2.0
Playable audio format:
MP3(.mp3): MPEG 1/2/Audio Layer-3
WMA(.wma): Ver 7/8/9.1/9.2
Playable video format:
M4V(.m4v), MP4(.mp4):
MPEG4part2(Simple),MPEG4 AVC/
H.264(Baseline@2.1)
3GP(.3gp): MPEG4part2(Simple)
Resolution : 480x272
Audio format :AAC,AMR,MP3,WMA,WAV

Bluetooth

Specification: Bluetooth Ver. 2.0+EDR
Profile: HFP (Hands-free Profile)
A2DP (Advanced Audio Distribution Profile)
AVRCP (AV Remote Control Profile)
PBAP (Phone Book Access Profile)
Send/Receive Sensitivity: Class 2

Audio Amplifier

Maximum power output:
180W (45W x 4)
Speaker impedance: 4Ω (4 to 8 Ω allowable)

6.2 Inch TFT LCD

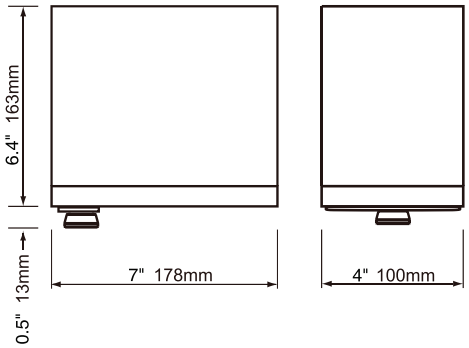
Display resolution (dot): 800RGB (H) x 480(V)
Active area (mm): 137.52(H) x 77.232 (V)
Screen size (inch): 6.2 (Diagonal)
Dot pitch (mm): 0.1719(H) x 0.1609(V)

Input

Audio input sensitivity:
High: 320mV (at 1V output)
Mid: 650mV (at 1V output)
Low: 1.3V (at 1V output)
(input impedance 10 kΩ or greater)
AUX-in Audio level : ≤2V
Video level : NTSC/PAL 1Vp-p@75Ω

General

Power supply voltage:
14.4VDC (10.8 to 15.6V allowable),
negative ground
Fuse: 15A
Dimensions of the Main Unit:
7"(Width) × 4"(Height) × 6.4"(Depth)
[178(W) × 100(H) × 163(D)mm]
Weight of the Main Unit: 3.2lb (1.45kg)

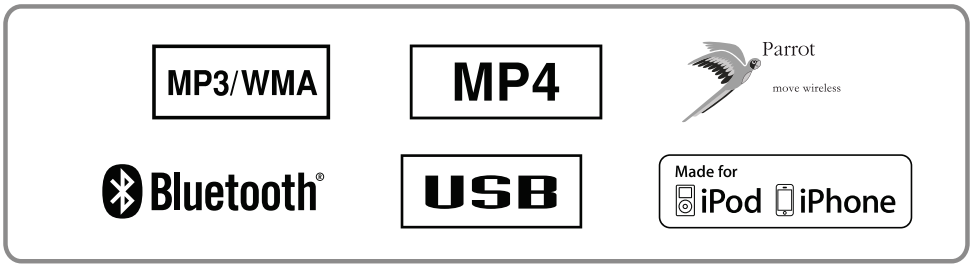


Note:

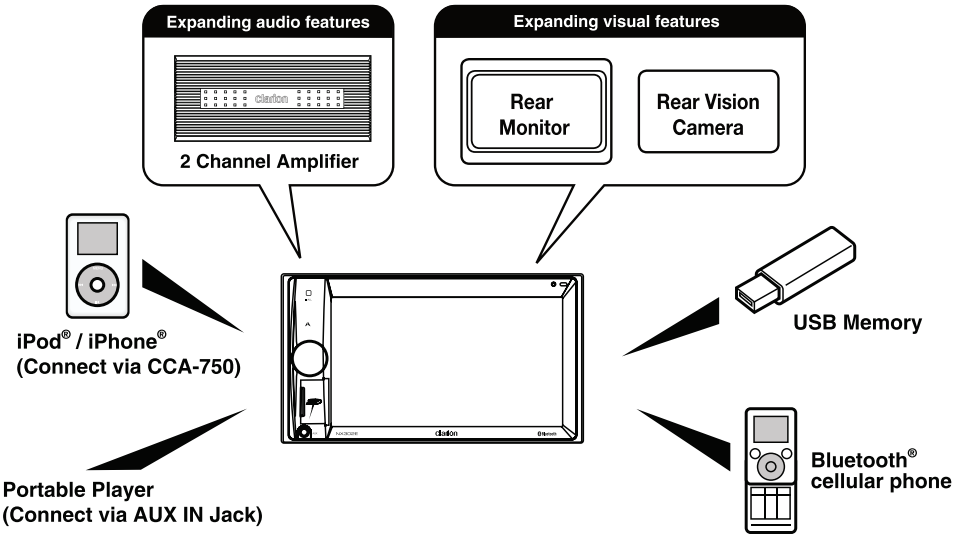
- *Specifications and design are subject to change without notice for further improvement.*

FEATURES

- **6.2” Wide-VGA Color LCD Touch Panel**
- **Front-Panel Auxiliary Input and 2ch RCA Output with Subwoofer Control**
- **BEAT-EQ with 3 Band Parametric Equalizer and MAGNA BASS EX Dynamic Bass Enhancement**
- **Latest Map Guarantee**



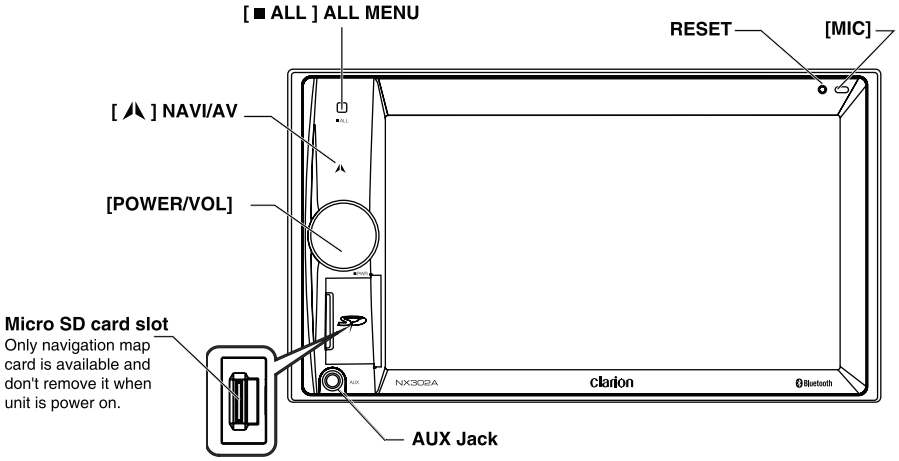
Expanding Systems



Notes:
• The items listed outside of the frames are the commercial products generally sold.
• CCA-750: Sold by separately.

CONTROLS

Operational Panel



Names of Buttons

[POWER/VOL] Knob
- Press to power on the system when ignition on.
- When power on, short press to mute the volume.
- Rotate the knob to increase or decrease the volume.
- Press and hold this key more than 1 second to turn off the system.

[■ ALL] ALL MENU Button
- Short press to show/exit shortcut menu.
- Long press to show/exit main source menu.

[⅄] NAVI/AV Button
- Press to enter navigation mode;
- Press again to return current source.

[MIC] Hole
- Internal microphone

[RESET] Button
- Press to load original settings.

  Note: When the [RESET] button is pressed, frequencies of radio stations, titles, etc. stored in memory are cleared.

TROUBLE SHOOTING

GENERAL

Problem	Cause	Measure
Unit can not power on.	Unit fuse blown.	Replace with new fuse of correct rating.
	Car battery fuse blown.	Replace with new fuse of correct rating.
Unit can not power on. Nothing happens when buttons are pressed. Display is not accurate.	The microprocessor has malfunctioned due to noise, etc.	Turn off the power and press the [**RESET**] button with a thin rod. ***Note:*** *When the [**RESET**] button is pressed, turn off the power.** ** When the [**RESET**] button is pressed, frequencies of radio stations, titles, etc. stored in memory are cleared.*
Remote control does not work.	Battery depleted.	Change the battery.
	Battery installed incorrectly.	Install the battery correctly.
No/low audio output	Improper audio output connection.	Check wiring and correct.
	Volume set too low.	Increase volume level.
	Speakers damaged.	Replace speakers.
	Heavily biased volume balance.	Adjust the channel balance to center position.
	Speaker wiring is in contact with metal part of car.	Insulate all speaker wiring connections.
	Speaker power rating does not match unit.	Replace speakers.
	Wrong connections.	Check wiring and correct.
	Speaker is shorted.	Check wiring and correct.
Unit resets itself when engine is off.	Incorrect connection between ACC and Battery.	Check wiring and correct.
The display is dark.	The brightness control is too low.	Adjust the brightness properly.
	The operating condition is not good.	The temperature inside the vehicle may be 0°C or lower. Set to an appropriate temperature (25°C or so) and check it again.
	The headlight of the vehicle is lit.	The display is made dark at night to prevent the glare (When the headlight of the vehicle is lit in the daytime, the display gets dark.)
There are red, green, and blue points in display	———————	This is not a faiure, but a phenomenon peculiar to a liquid crystal panel (The liquid crystal panel is produced according to technology with very high precision. Note that, though there are effective pixels of 99.99% or more, pixel missing or normally lit pixels account for 0.01%).

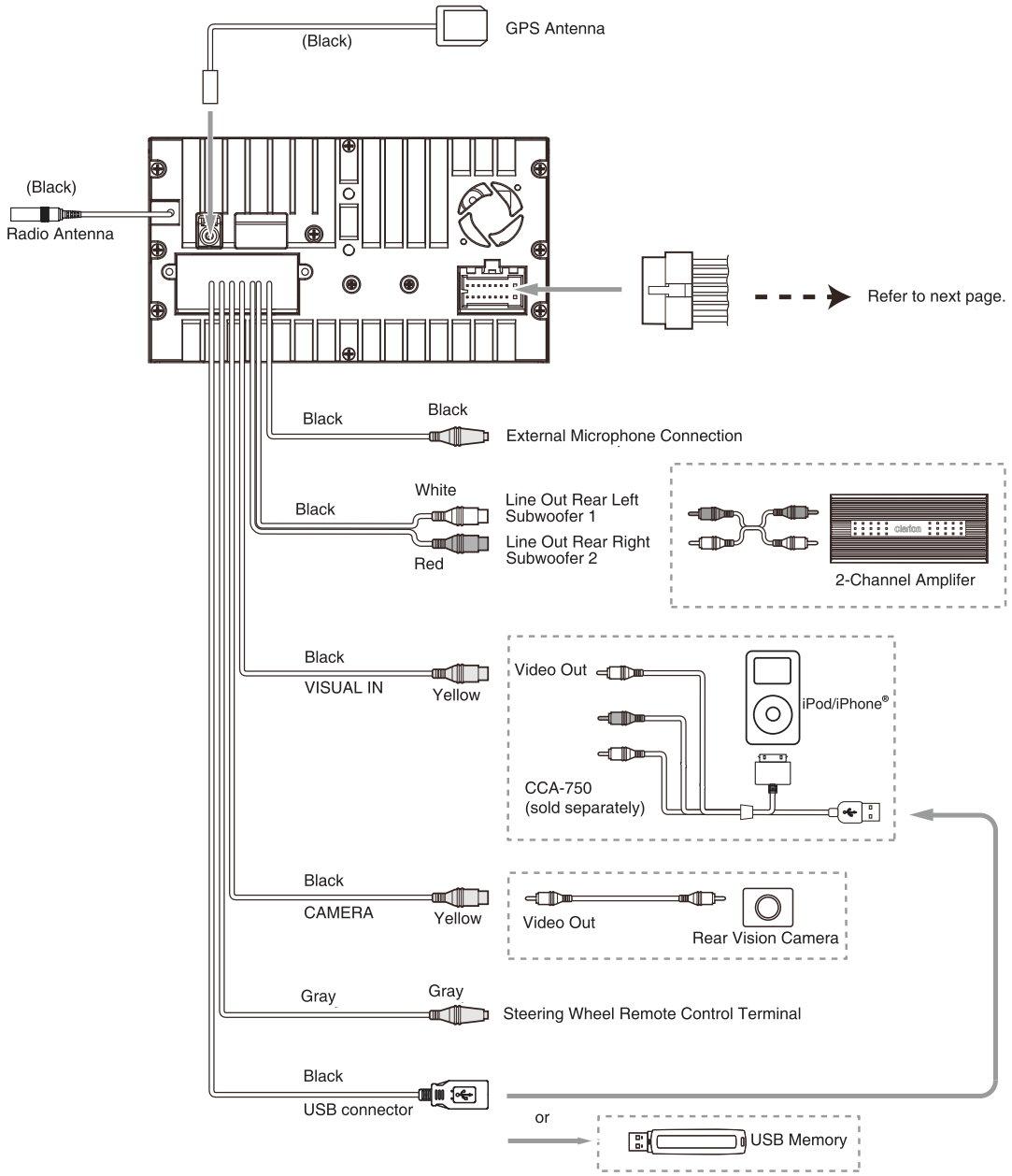
USB Devices

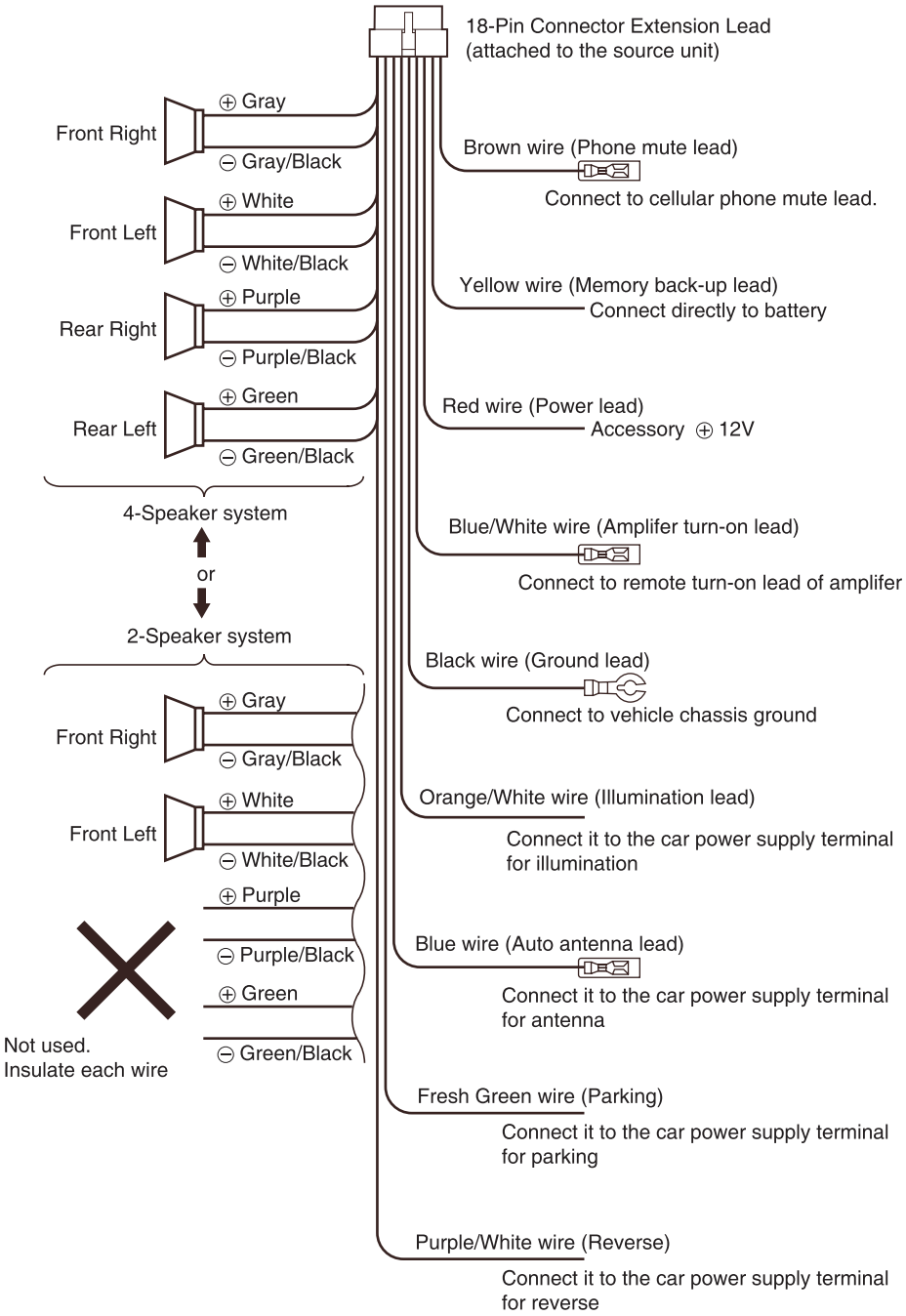
Problem	Cause	Measure
USB device cannot be inserted.	The USB device has been inserted with wrong direction.	Reversing the connection direction of the USB device, try it again.
	The USB connector is broken.	Replace with a new USB device.
USB device is not recognized.	The USB device is damaged.	Disconnect the USB device and reconnect. If the device is still not recognized, try replacing with a different USB device.
	Connectors are loose.	
Sound skips or is noisy.	MP3/WMA files are not encoded properly.	Use MP3/WMA files encoded properly.
No sound heard with the display “NO FILE” shown.	No MP3/WMA file is stored in the USB device.	Store these files properly in the USB device.
The video image of iPod/iPhone is disturbed.	The TV Signal setting of the iPod/iPhone is not set correctly.	Set the TV Signal setting (NTSC/PAL) of the iPod/iPhone correctly.

Bluetooth

Problem	Cause	Measure
Cannot pair the Bluetooth enabled device with the car audio system.	The device does not support the profiles required for the system.	Use another device to connect.
	The Bluetooth function of the device is not enabled.	Refer to the user manual of the device for how to enable the function.
The audio quality is poor after connection with a Bluetooth-enabled device.	The internal microphone gain is not set correctly.	Adjust the gain of the internal microphone in System Setup.
	The external microphone is not set correctly nor properly positioned.	Adjust the gain and position of the external microphone. For example, stick the microphone onto the dashboard so it is close to the driver.

WIRING CONNECTION

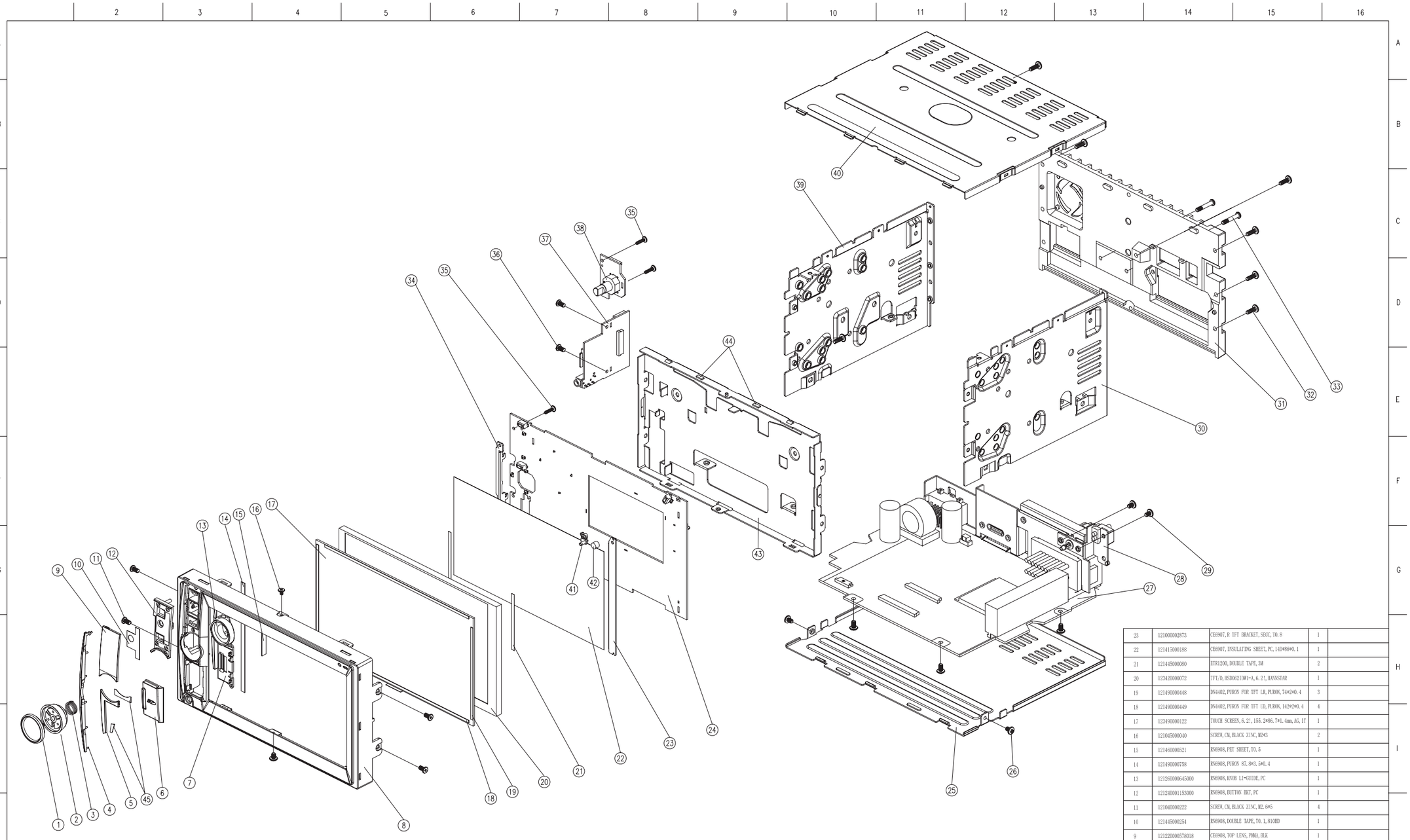



18-Pin Connector Extension Lead
(attached to the source unit)
Front Right
⊕ Gray
⊖ Gray/Black
Front Left
⊕ White
⊖ White/Black
Rear Right
⊕ Purple
⊖ Purple/Black
Rear Left
⊕ Green
⊖ Green/Black
4-Speaker system
or
2-Speaker system
Front Right
⊕ Gray
⊖ Gray/Black
Front Left
⊕ White
⊖ White/Black
⊕ Purple
⊖ Purple/Black
⊕ Green
⊖ Green/Black
Not used.
Insulate each wire
Brown wire (Phone mute lead)
Connect to cellular phone mute lead.
Yellow wire (Memory back-up lead)
Connect directly to battery
Red wire (Power lead)
Accessory ⊕ 12V
Blue/White wire (Amplifer turn-on lead)
Connect to remote turn-on lead of amplifer
Black wire (Ground lead)
Connect to vehicle chassis ground
Orange/White wire (Illumination lead)
Connect it to the car power supply terminal
for illumination
Blue wire (Auto antenna lead)
Connect it to the car power supply terminal
for antenna
Fresh Green wire (Parking)
Connect it to the car power supply terminal
for parking
Purple/White wire (Reverse)
Connect it to the car power supply terminal
for reverse

PARTS LIST

Quotation of assembly parts for NX302A(CAP)							
							Updated: 17th,JUL 2012
NO.	Clarion Model	Part NO #	Qty	MOQ	Description	Lead time(day)	Assembly parts Picture
1	9480RN6908194D	843RN6908MB012	1	30	RN6908 MB MI ASSM	TBC	
2	9480RN6908194D	845RN6908AS010	1	30	RN6908 TFT MI ASSM	TBC	
3	9480RN6908194D	121270000493000	1	30	Outter Escutcheon	TBC	
4	9480RN6908194D	121270000494000	1	30	Outter Escutcheon	TBC	
5	9480RN6908194D	124845000139	1	30	ANT,CE6907,GPS ANTENNA,5M	TBC	
6	9480RN6908194D	143830001340	1	30	I/O,CE6906,18P,POWER,SPEARK 150MM	TBC	
7	9480RN6908194D	123830000571	1	30	I/O,DM4281,4P,L/R AV,32V,0.5m	TBC	
8	9480RN6908194D	123830001358	1	30	I/O,RN6908,15P,REAR AV,USB,SWC,200MM	TBC	
9	9480RN6908194D	121000002878	1	30	TOP COVER	TBC	
10	9480RN6908194D	121000002876	1	30	BOT COVER	TBC	
10	9480RN6908194D	845RN6908IC000	1	30	TF CARD,4G	TBC	

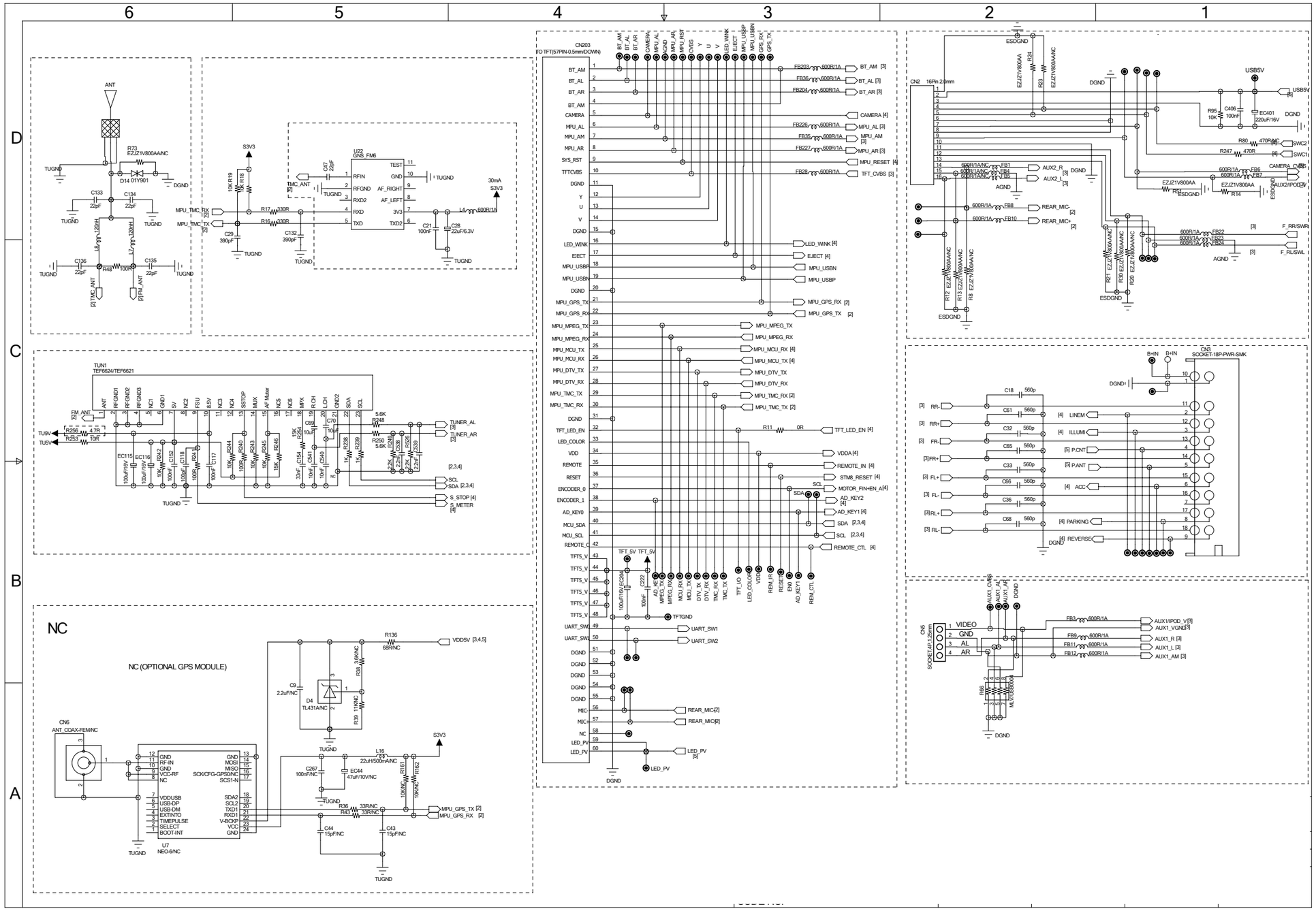
EXPLODED VIEW / PARTS LIST



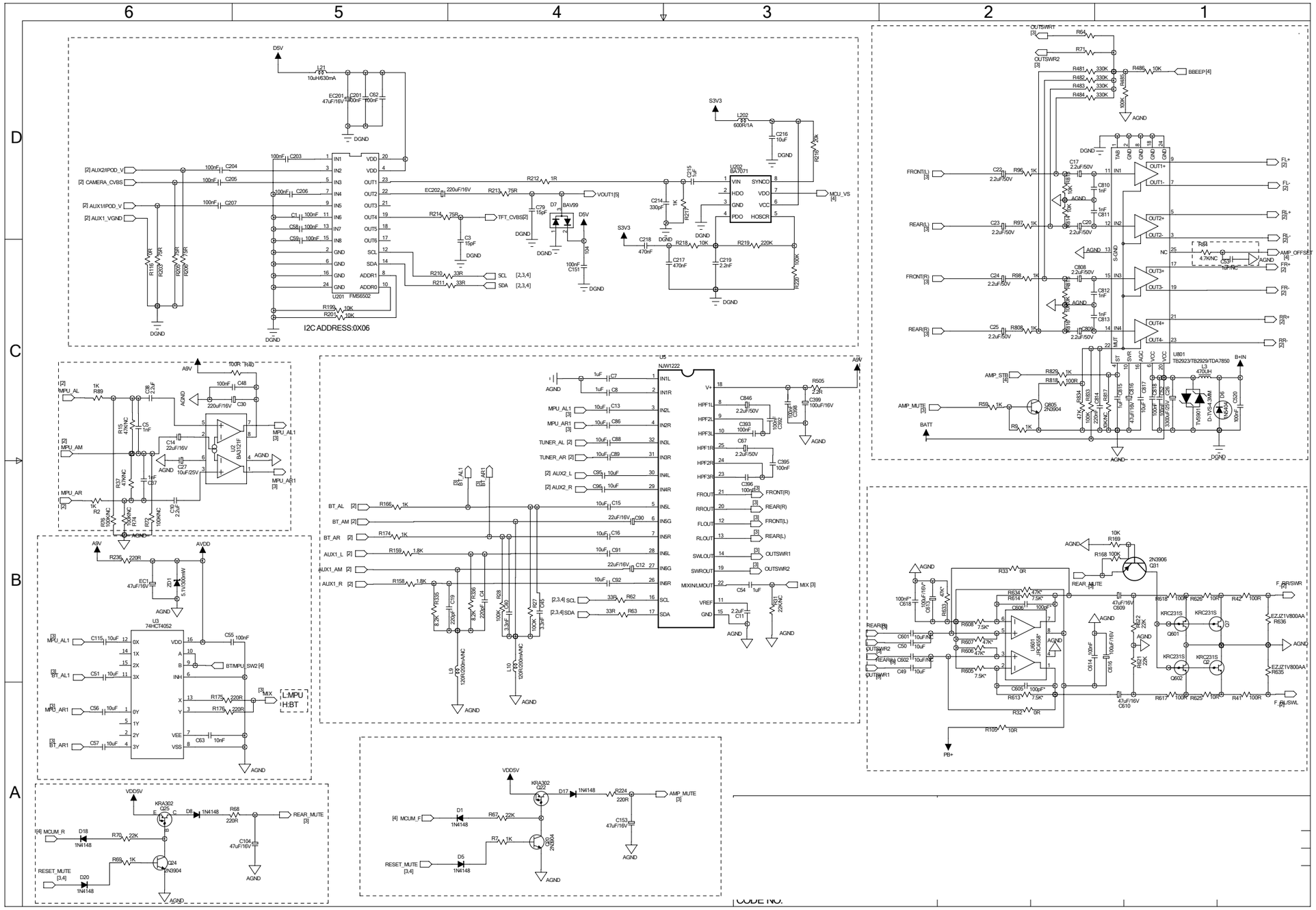
NO.	P/N.	NAME	QTY.	REMARK
45	121445000274	CE6907, DOUBLE TAPE, 810HD, 20.2*4	1	
44	121410000177	DN-7310, MAT 5, EVA, 6*15*1	2	
43	121000002871	CE6907, P-BOT COVER, SECC, T0.8	1	
42	123660000014	MIC, FA4530L300DCC, 2PIN, -42±2dB	1	
41	121230003232000	CE6907, RESET BUTTON, PC	1	
40	121000002878	RN6908, TOP COVER, SECC, T0.6	1	
39	121000021221	DM428, LEFT BRACKET, SECC, T1.0	1	
38	121658000130	ENCODER, EC12015644022, ALPS, H17.5, BA	1	
37	7228N6908ASDPP0	RN6908ASD	1	
36	121040000313	SCREW, BTS, BLACK ZINC, M2*5	2	
35	121040000120	SCREW, BTP, BLACK ZINC, M2*8	4	
34	121000002875	RN6908, TFT LEFT BKT, SECC, T0.8	1	
33	121106070007	SCREW, BTB, BLUE ZINC, M2.6*16	2	
32	121104070017	SCREW, BTS, BLUE ZINC, M2.6*7	9	
31	121015000210	CE6907, HEAT51NK, AL-ADC12	1	
30	121000011219	DM428, RIGHT BRACKET, SECC, T1.0	1	
29	121100070081	SCREW, BK, BLUE ZINC, M2.6*4	2	
28	121000002879	RN6908, MPCB RE BKT, SECC, T1.0	1	
27	7238N6908ESBPP0	RN6908ESB	1	
26	121104070007	SCREW, BTS, BLUE ZINC, M2.6*5	6	
25	121000002876	RN6908, BOT COVER, SECC, T0.8	1	
24	7238N6908ATFTPP0	RN6908ATFT	1	
23	121000002873	CE6907, R TFT BRACKET, SECC, T0.8	1	
22	121415000188	CE6907, INSULATING SHEET, PC, 140*86*0.1	1	
21	121445000080	ETR1200, DOUBLE TAPE, 3M	2	
20	123420000072	TFT/D, HSD062IDW1-A, 6.2I, HANNSTAR	1	
19	121490000448	DN4402, PURON FOR TFT LR, PURON, 74*2*0.4	3	
18	121490000449	DN4402, PURON FOR TFT UD, PURON, 142*2*0.4	4	
17	123490000122	TOUCH SCREEN, 6.2I, 155.2*86.7*1.4mm, AG, 1T	1	
16	121045000040	SCREW, CM, BLACK ZINC, M2*3	2	
15	121460000521	RN6908, PET SHEET, T0.5	1	
14	121490000788	RN6908, PURON 87.8*3.5*0.4	1	
13	121260000645000	RN6908, KNOB LI-GUIDE, PC	1	
12	121240001153000	RN6908, BUTTON BKT, PC	1	
11	121040000222	SCREW, CM, BLACK ZINC, M2.6*5	4	
10	121445000254	RN6908, DOUBLE TAPE, T0.1, 810HD	1	
9	121220000578018	CE6908, TOP LENS, PMMA, BLK	1	
8	121210001345028	CE6908194D, PANEL, PC, BLK, NX302A	1	
7	121240001155000	RN6908, SD DOOR FIX BRACKET, PC	1	
6	121290002367000	CE6907, SD DOOR, PC	1	
5	121220000583018	CE6908, BOTTOM LENS, PMMA, BLK	1	
4	121270500485017	CE6907, DECO BAR, ABS, PLT+SIL	1	
3	121035000569	CMV129, SPRING FOR VOL KNOB, PWR, φ0.7	1	
2	121230403230018	CE6907, VOL KNOB, ABS, RUB+GEN+BLK	1	
1	121090000404	CE6907, KNOB CAP, AL	1	
NO.	P/N.	NAME	QTY.	REMARK

CIRCUIT DIAGRAM

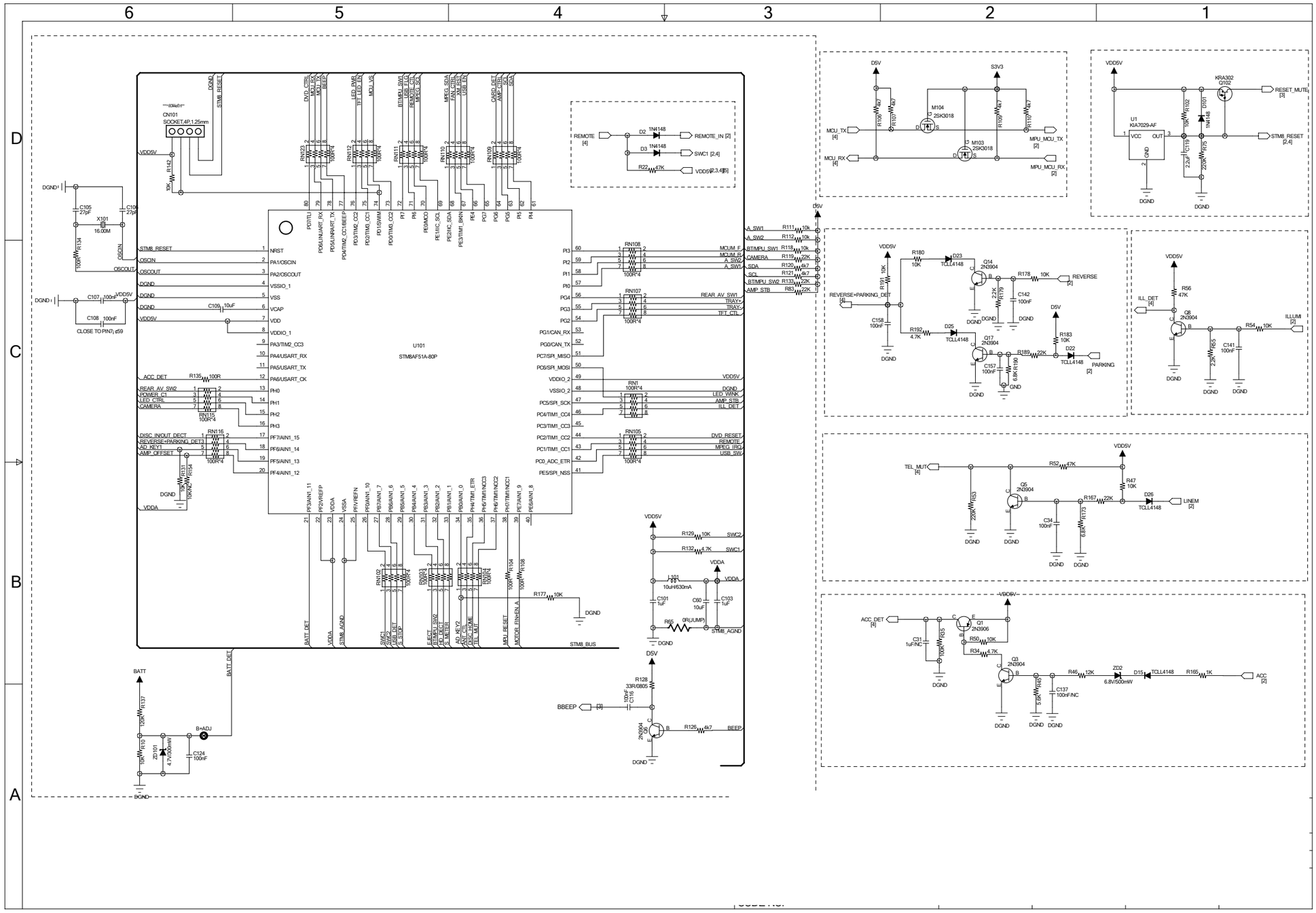
Main PWB section-1



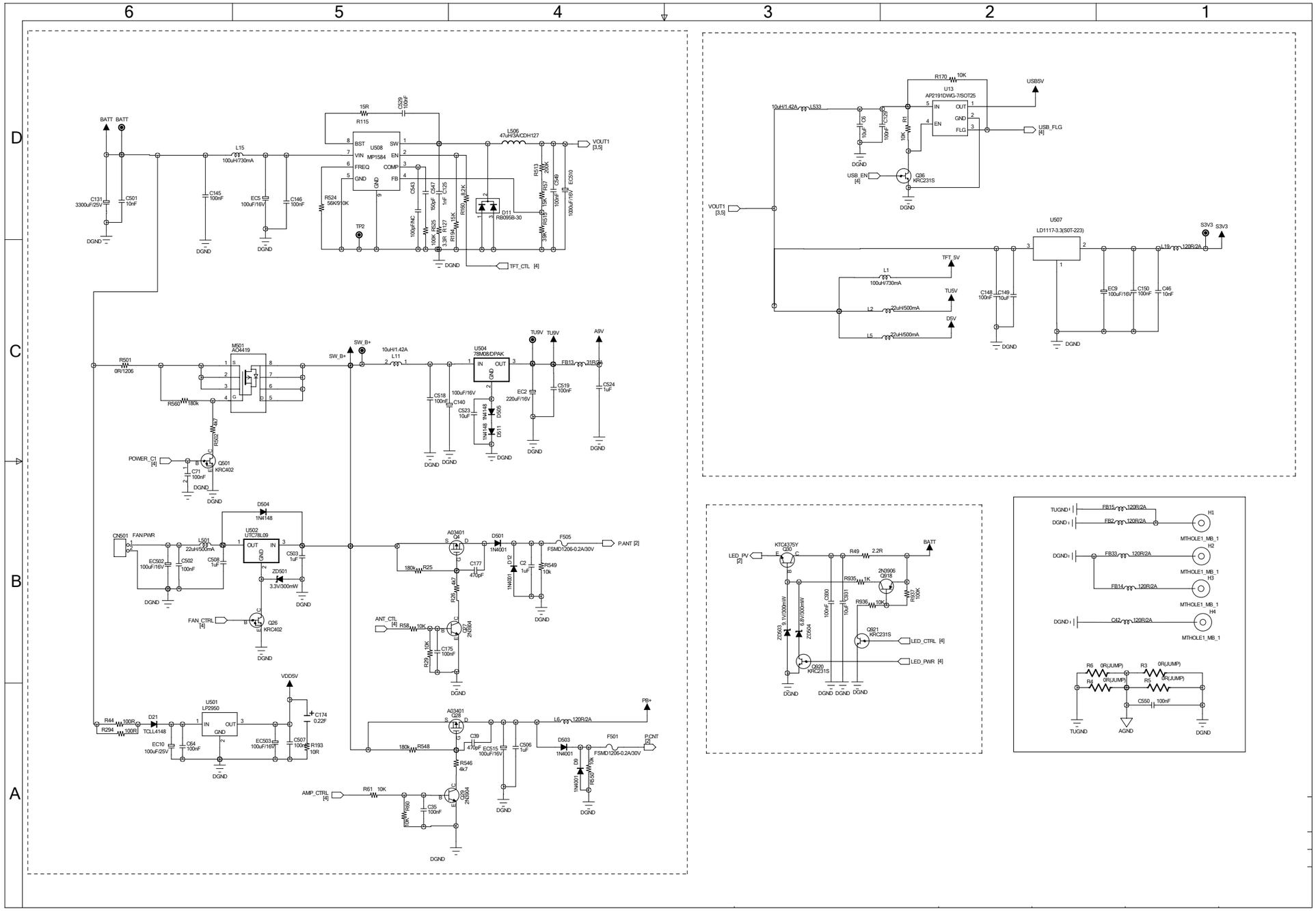
Main PWB section-2



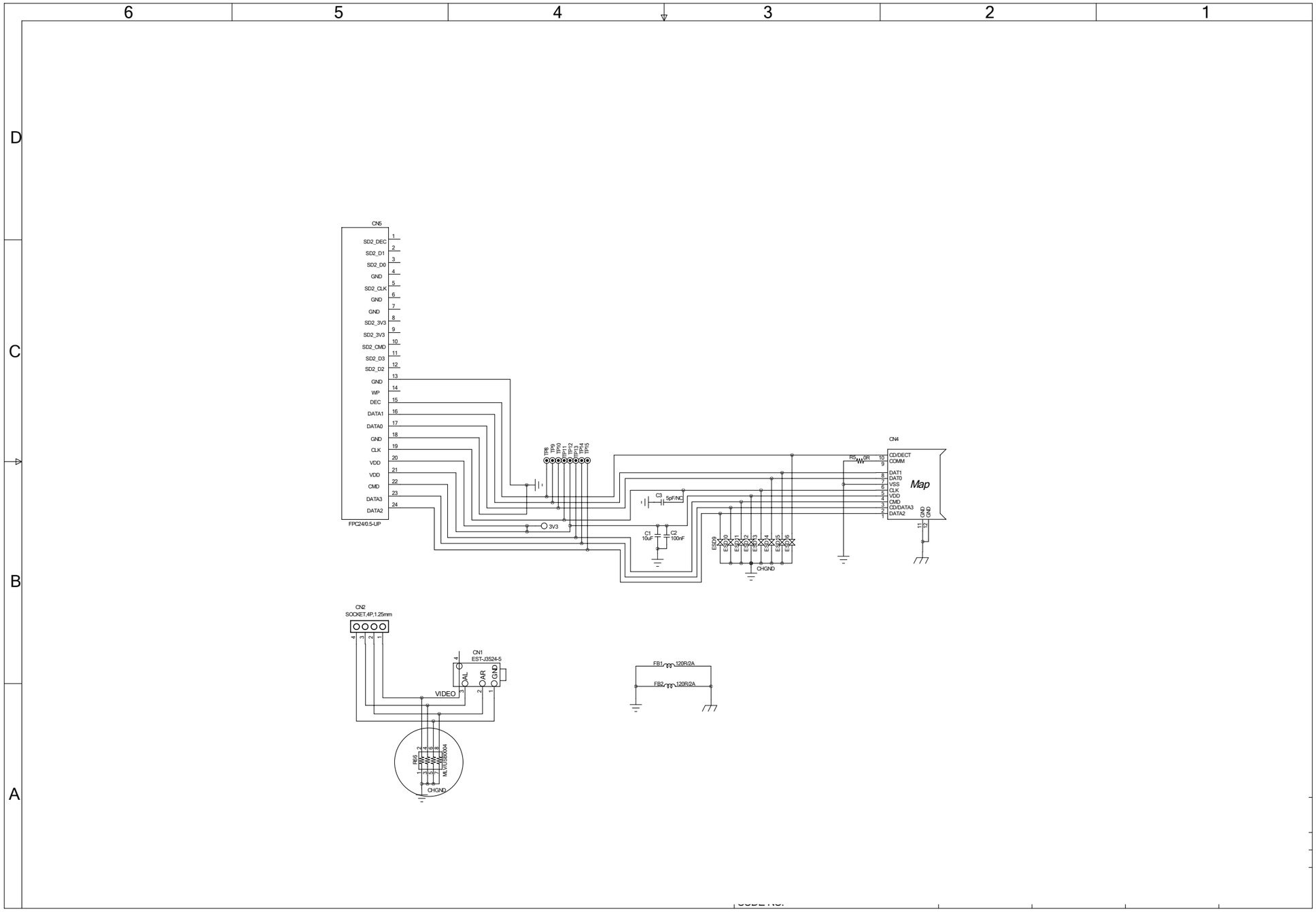
Main PWB section-3



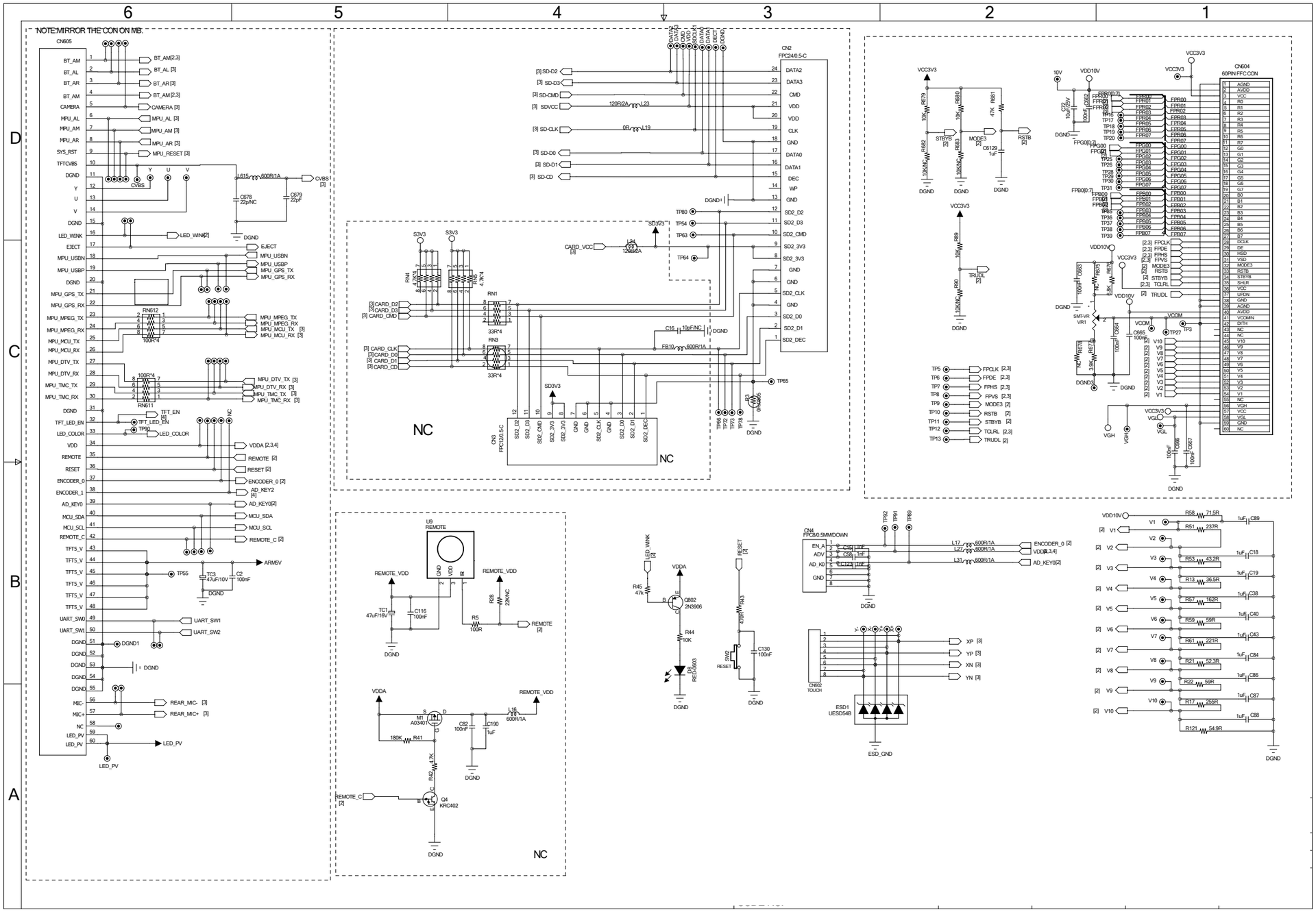
Main PWB section-4



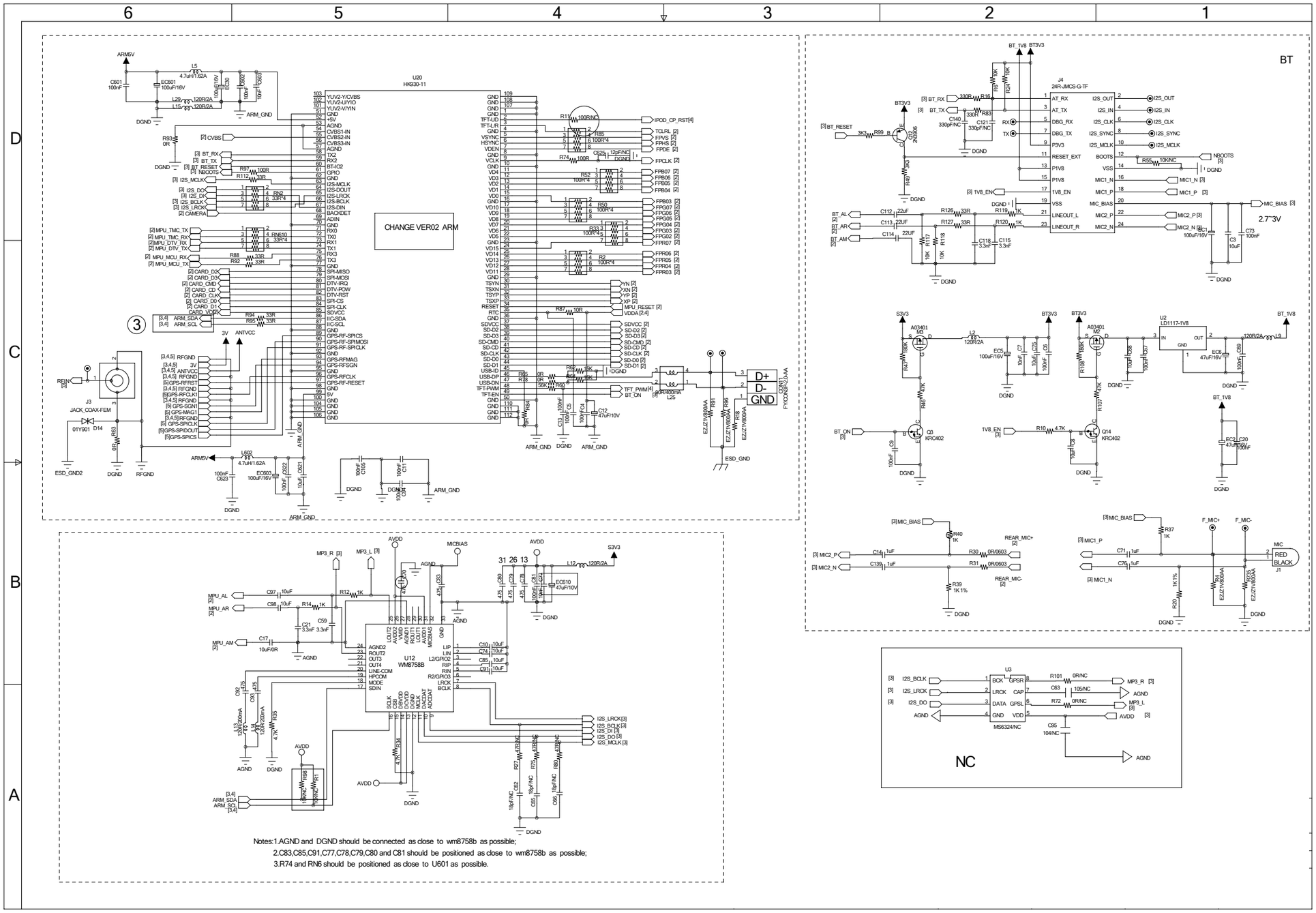
AUX-IN/SD/MINI SD PWB section



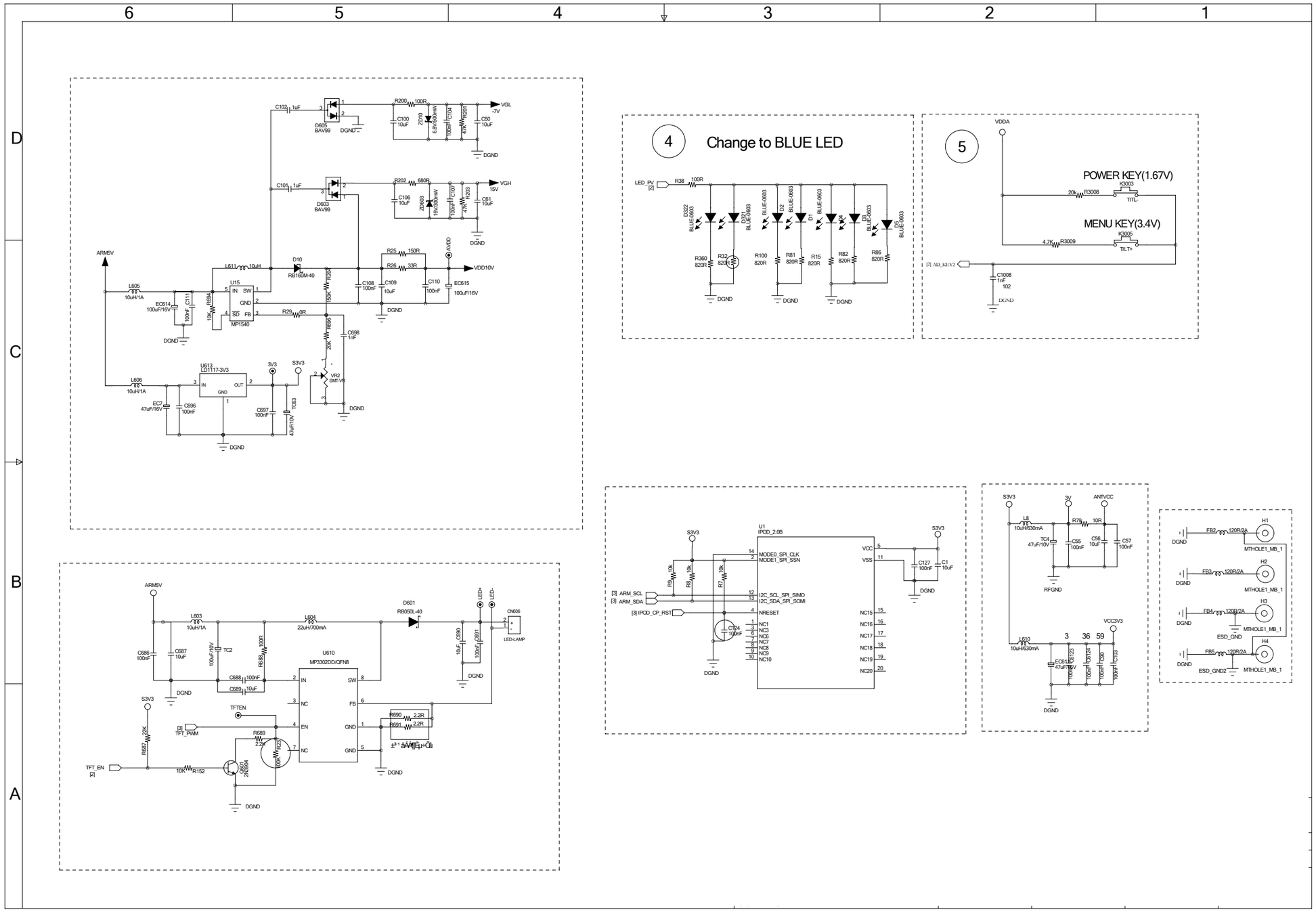
TFT PWB section-1

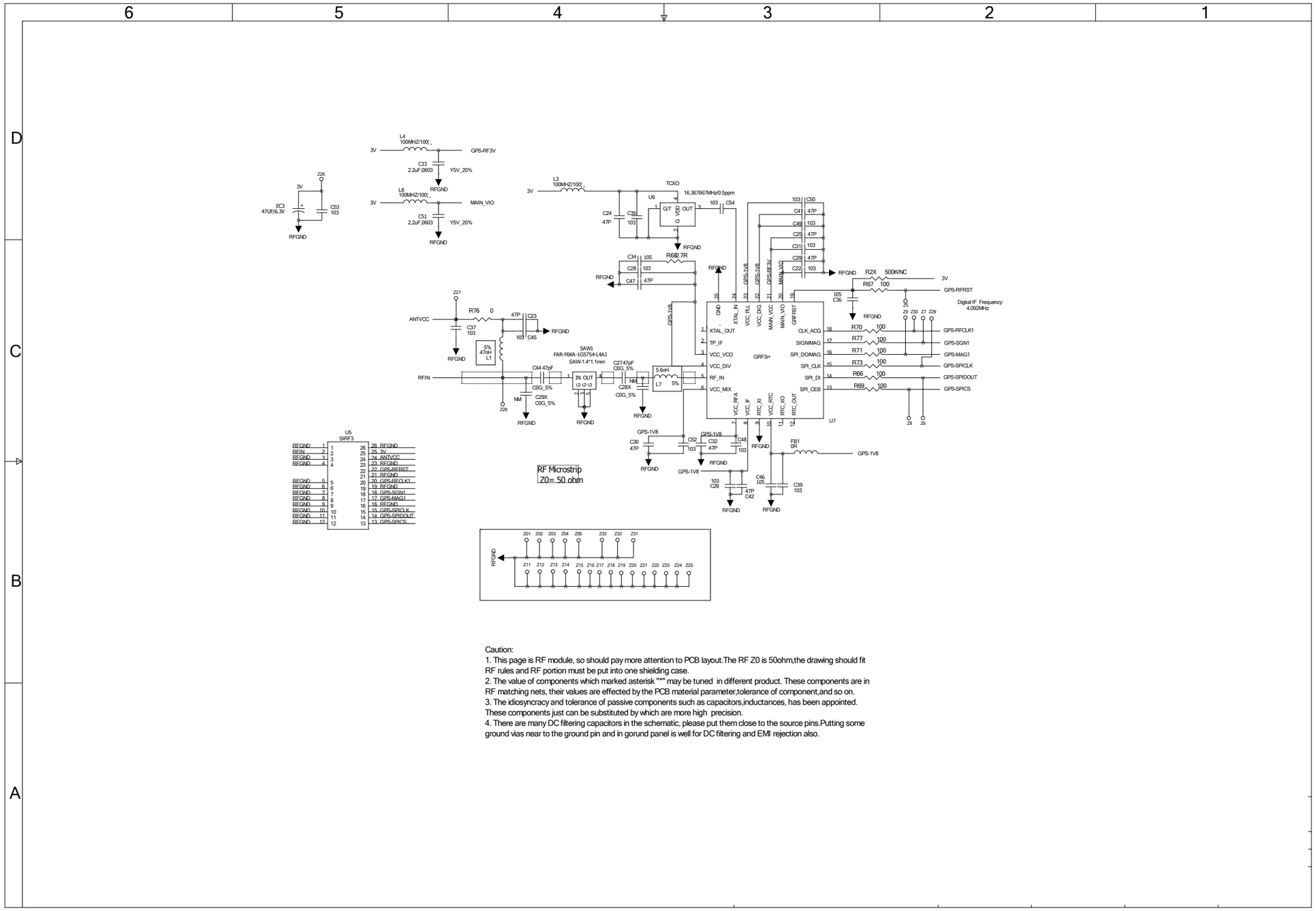


TFT PWB section-2



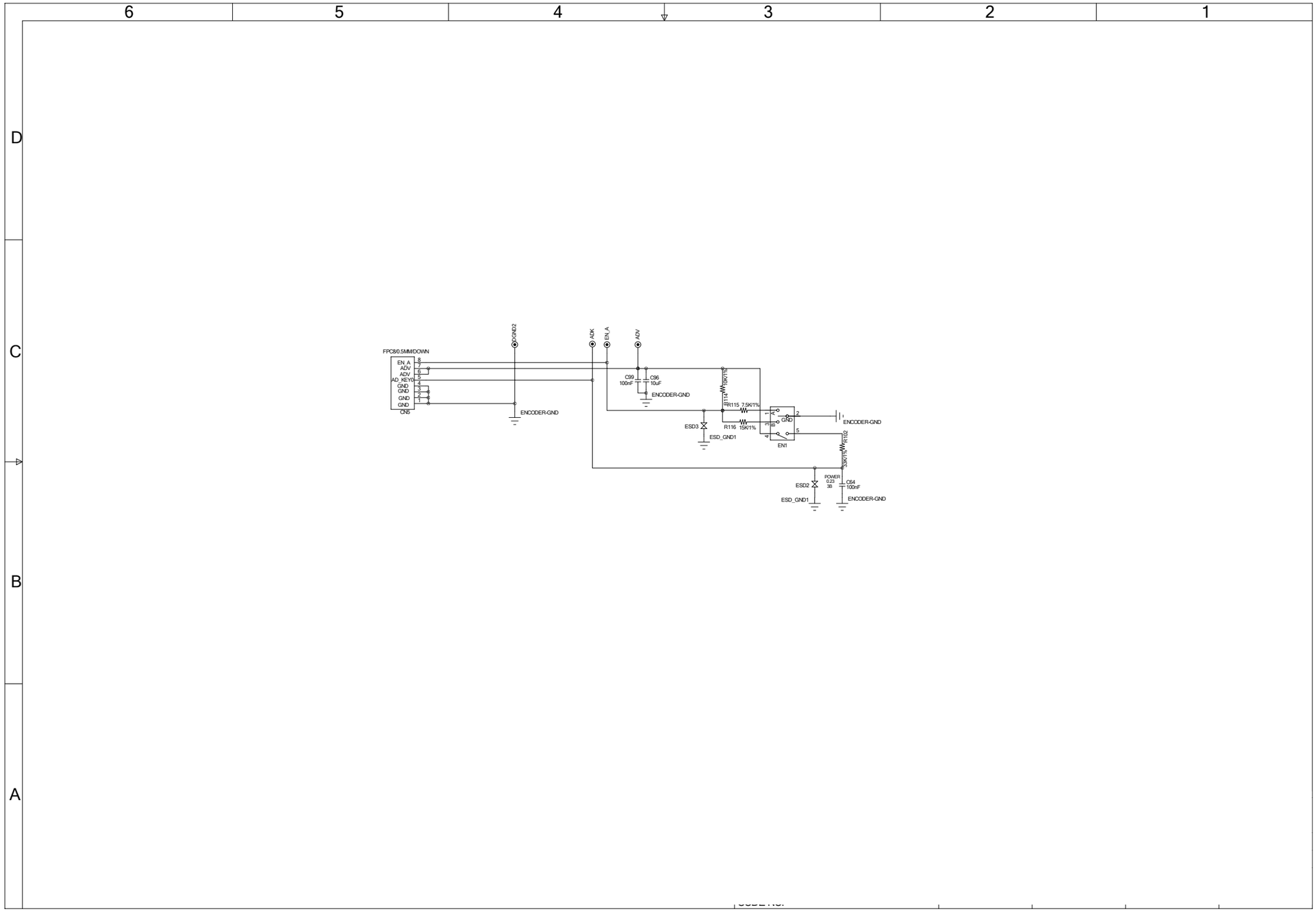
TFT PWB section-3





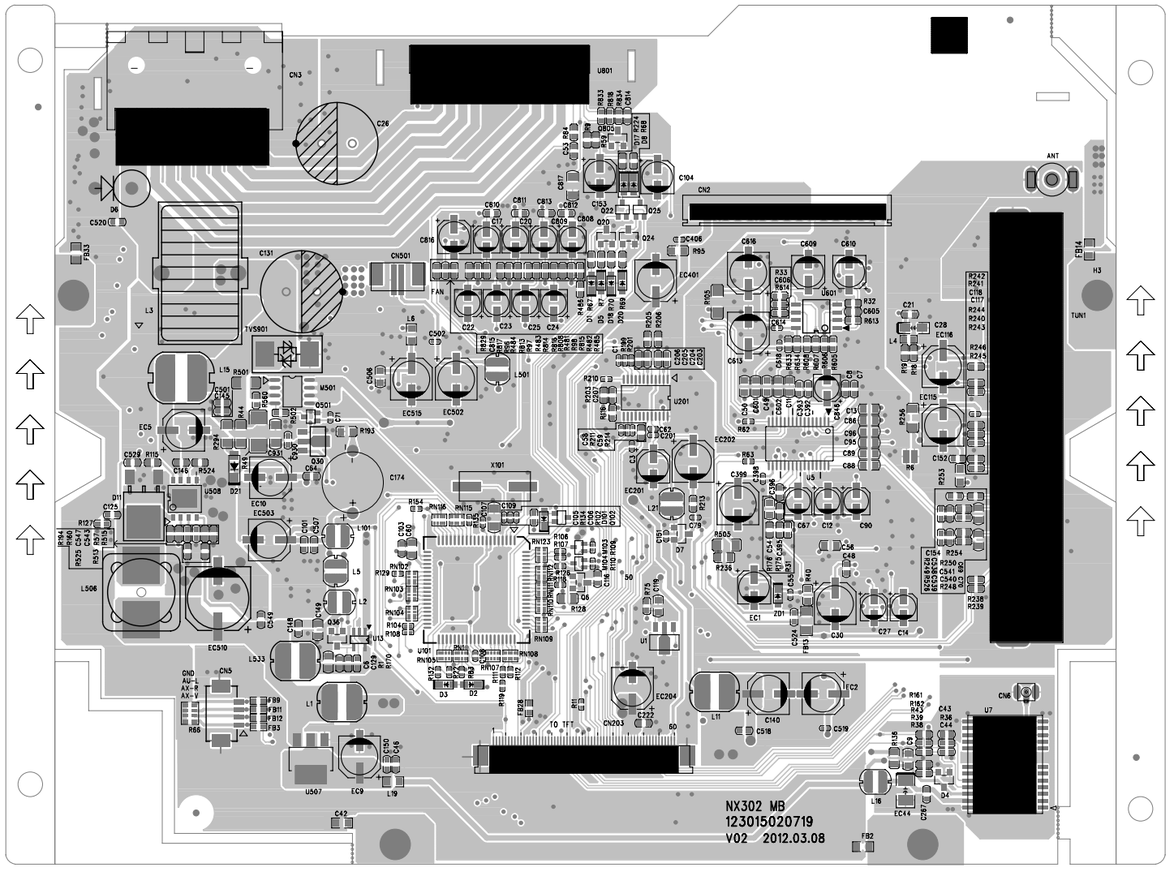
Caution:
1. This page is RF module, so should pay more attention to PCB layout.The RF Z0 is 50ohm,the drawing should fit RF rules and RF portion must be put into one shielding case.
2. The value of components which marked asterisk "*" may be tuned in different product. These components are in RF matching nets, their values are effected by the PCB material parameter,tolerance of component,and so on.
3. The idiosyncracy and tolerance of passive components such as capacitors,inductances, has been appointed. These components just can be substituted by which are more high precision.
4. There are many DC filtering capacitors in the schematic, please put them close to the source pins.Putting some ground vias near to the ground pin and in gorund panel is well for DC filtering and EMI rejection also.

TFT PWB section-5

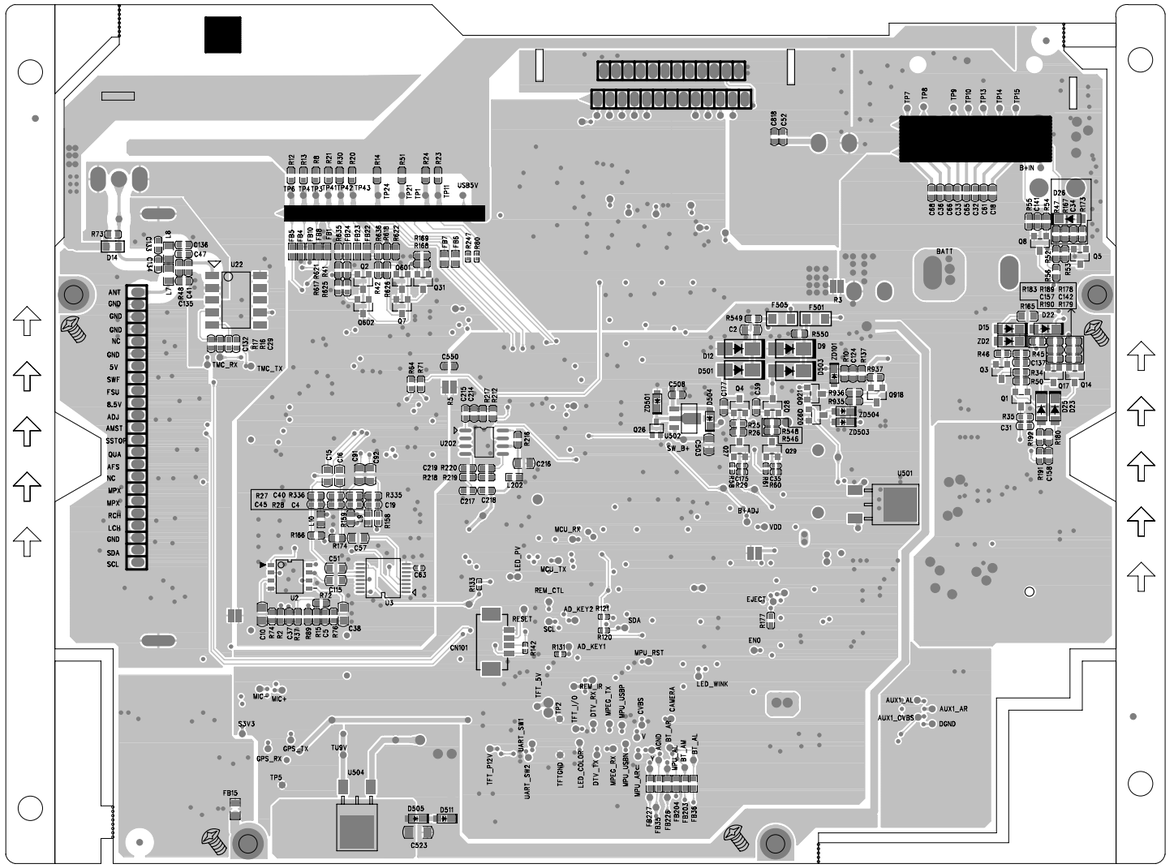


PRINTED WIRING BOARD

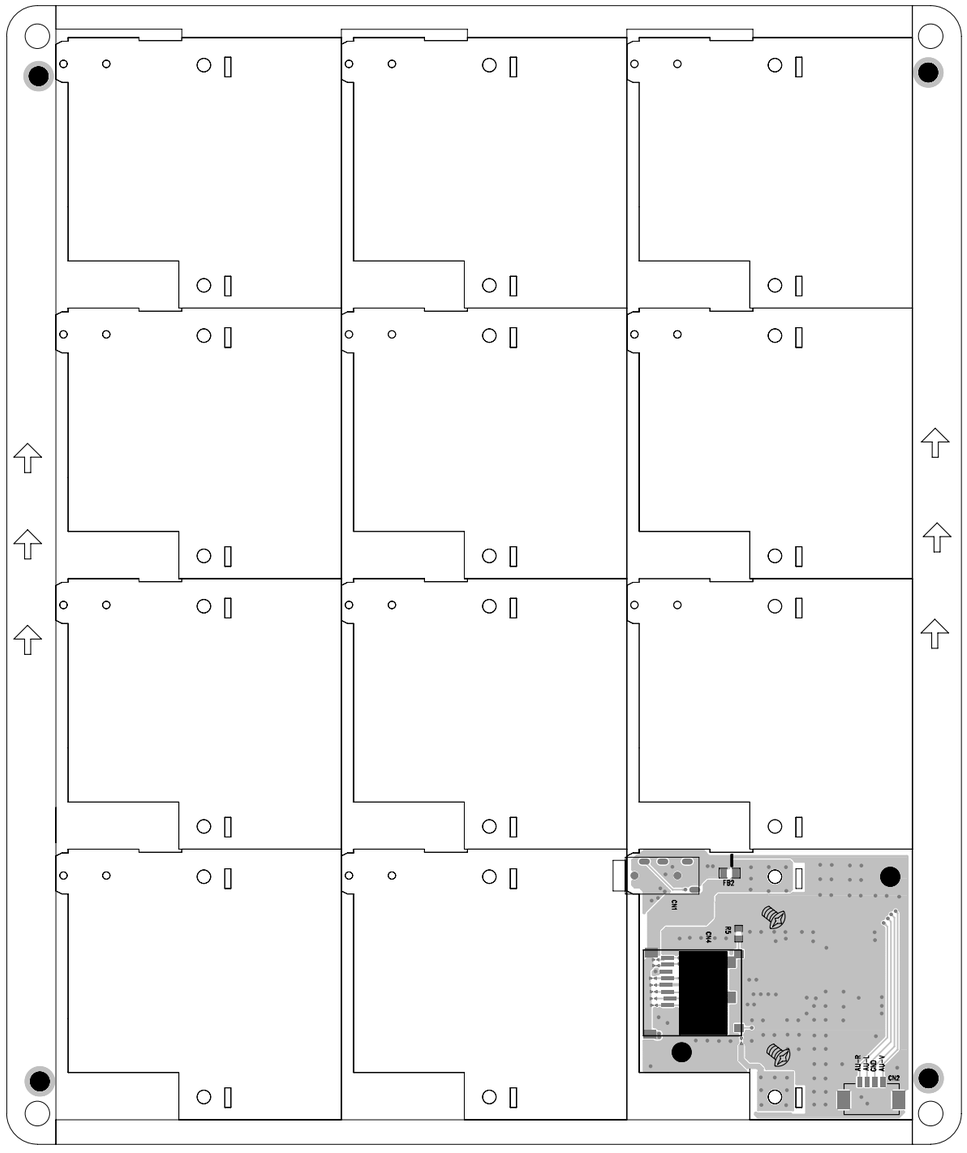
Main PWB section (top view)



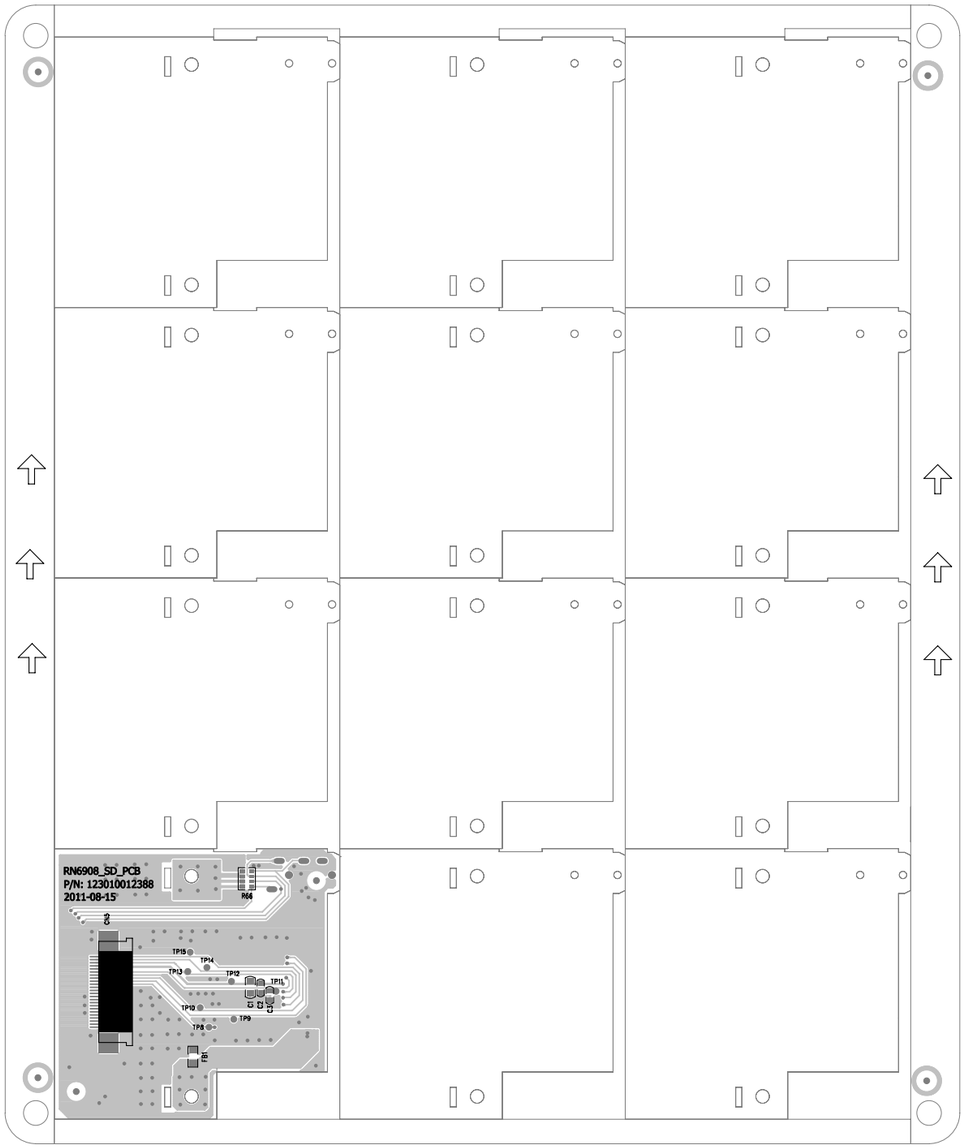
Main PWB section (bottom view)



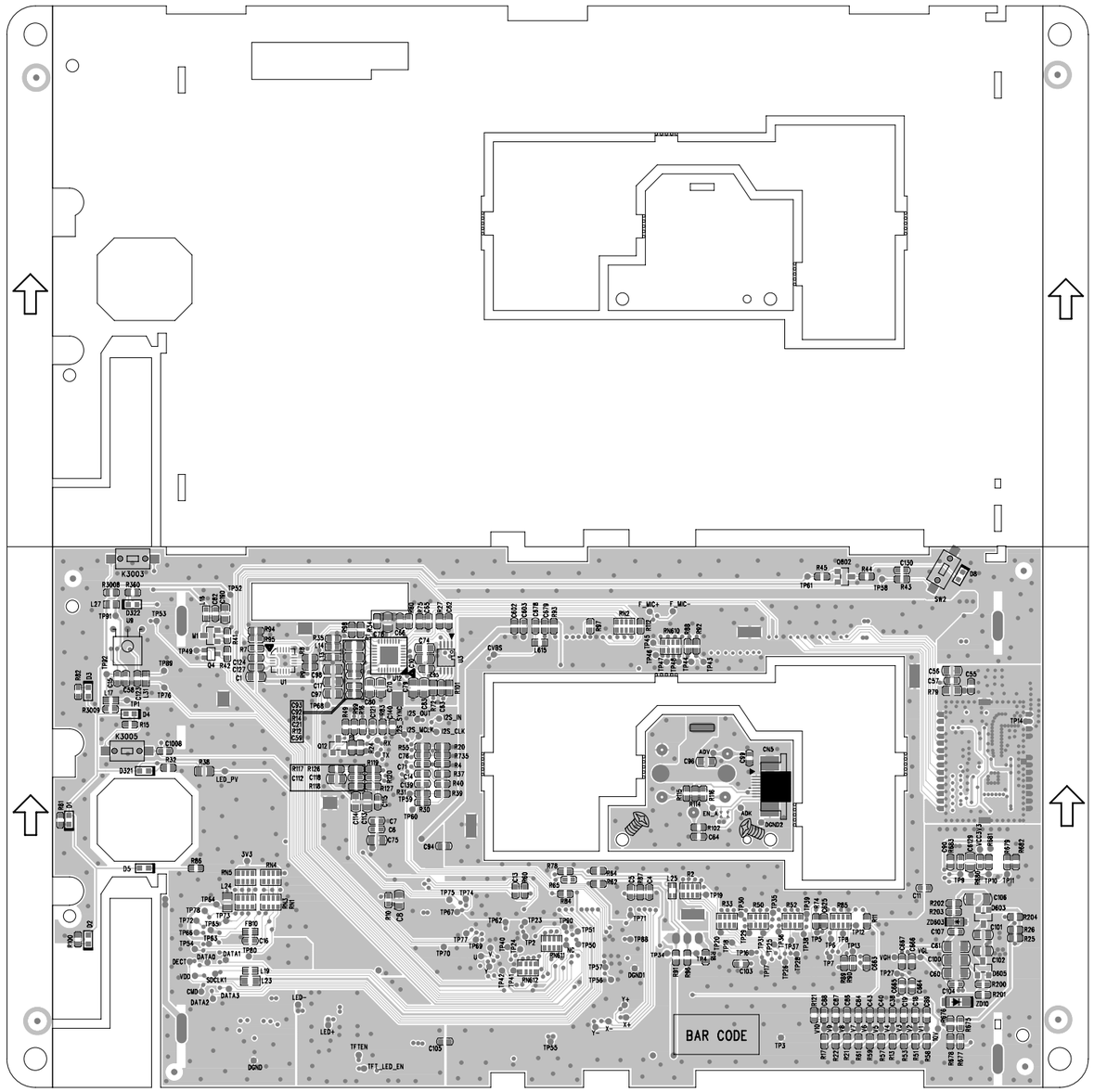
AUX-IN/SD/MINI SD PWB section (top view)



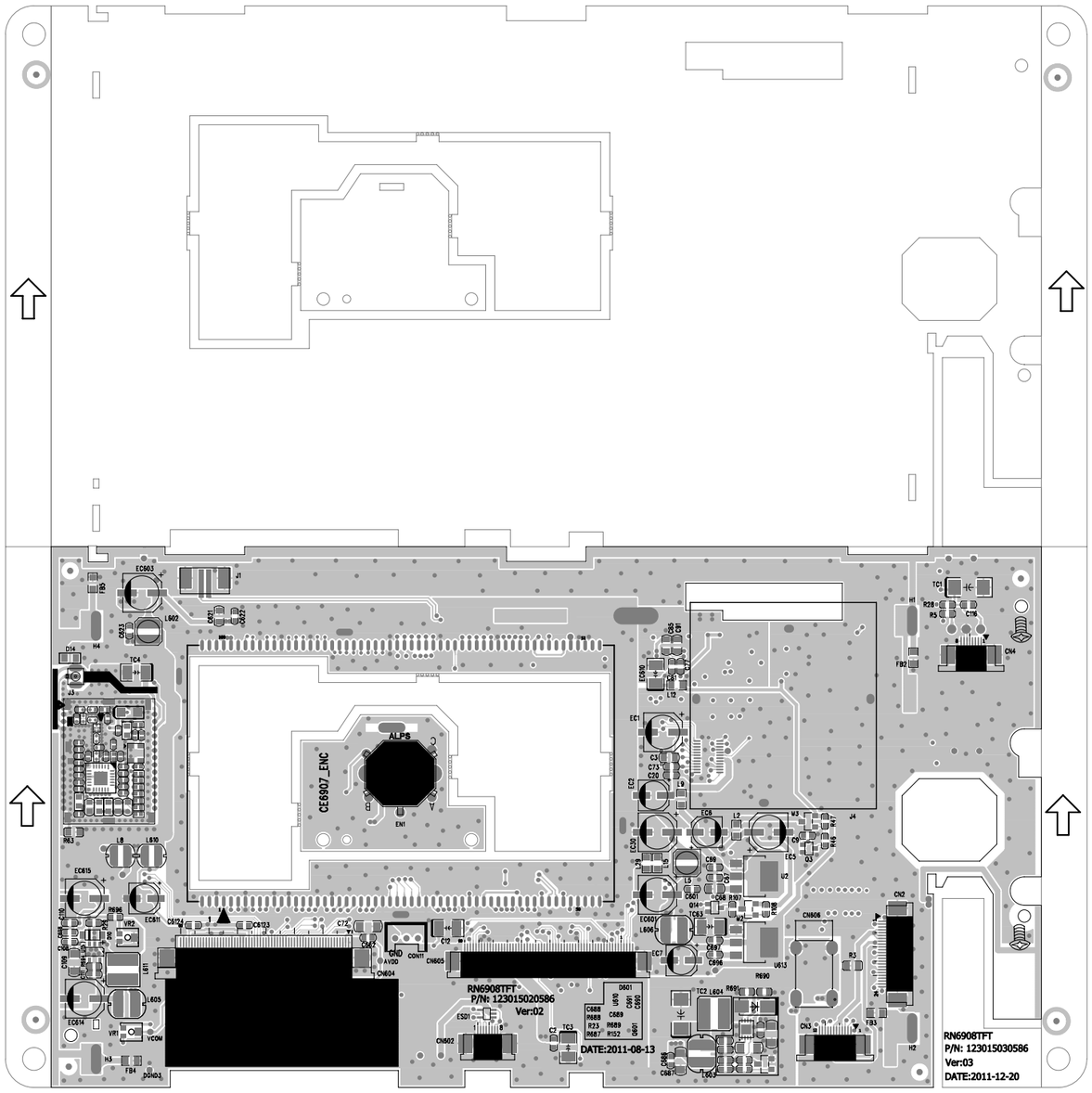
AUX-IN/SD/MINI SD PWB section (bottom view)



TFT PWB section (top view)



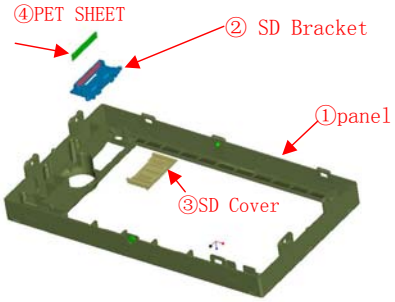
TFT PWB section (bottom view)



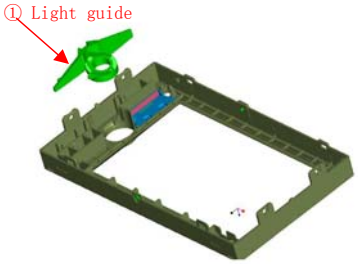
ASSEMBLY

1.Processing of Panel ASSY

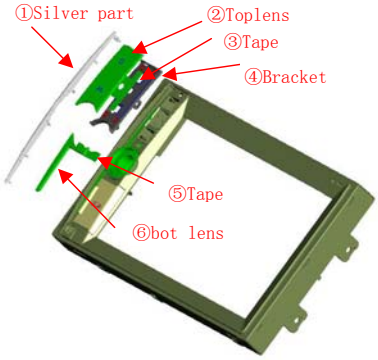
1-1.Installation of SD Cover

WORKING DIAGRAM	WORKING PROCESS	NO.	PARTS NUMBER	Q'TY	WORKING POINT
	1.Install the SD cover③and SD bracket②on the	①	141210001345028	1	
	front panel①, press to fasten them and use iron	②	121240001155000	1	
	to fix the positioning bar; place the cushion④	③	121290002367000	1	
	(make sure it stick to SD bracket② red side.)	④	121460000521	1	

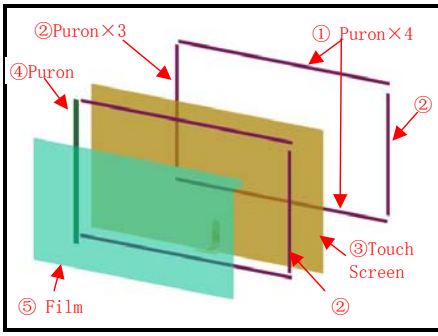
1-2.Installation of Light Guide

	1.Install the knob light guide①, press and	①	121260000645000	1	
	fasten it, then use the iron to fix the				
	positioning bar.				

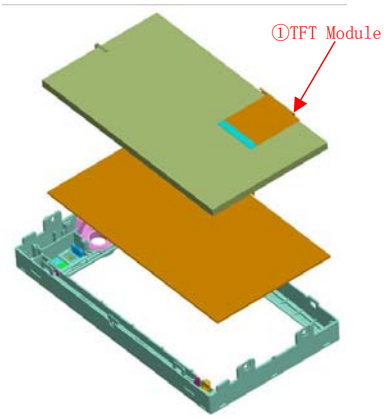
1-3.Installation of Lens&Silver Part

	1. Install Silver part①, press to	①	141270500495017	1	
	fasten it and use iron to fix the	②	141220000578018	1	
	positioning bar.	③	121445000254	1	
	2. Place the double sided tape③ on the	④	121240001153000	1	
	bracket④, place the top lens② on the brak	⑤	121445000274	1	
	3. Place the double sided tape⑤ on the	⑥	141220000583018	1	
	front panel, and stick the bottom lens⑥				
	to the tape.				

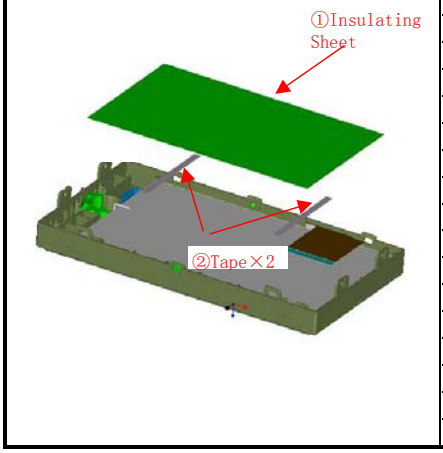
1-4.Installation of Touch screen

	1. Stick on each side of the touch screen	①	121490000449	4	the bubble cushion should
	the bubble cushion along each edge.	②	121490000448	3	not be within the touch
	2. Stick the protective film on the touch	③	143490000122	1	sensor area.
	screen.	④	121490000758	1	
		⑤	121455010053	1	

1-5.Installation of TFT Module

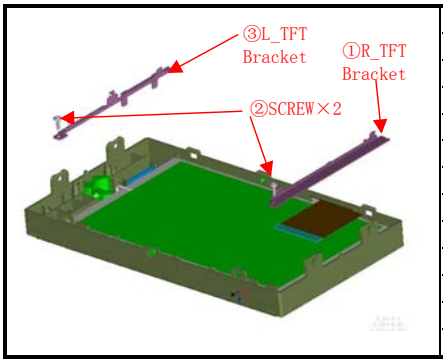
	1. Install the touch screen and TFT module	①	143420010072	1	
	into the front bracket.				

1-6. Installation of Insulating Sheet



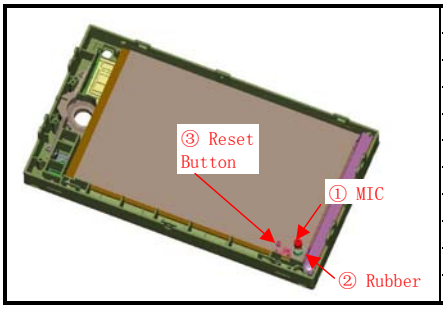
1. Stick 2 strip of double sided tape on the TFT module backside②.	①	121415000188	1
	②	121445000080	2
2. Place the Insulating sheet onto the TFT module①.			

1-7. Installation of TFT Bracket



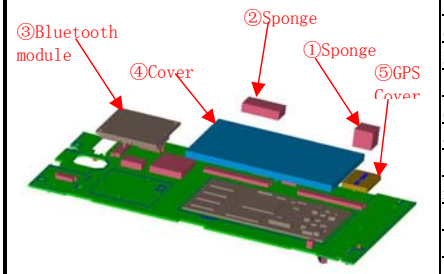
1. Install the R TFT bracket① on the right side.	①	121000002873	1
Use screw② to fix it.	②	121040000185	2
2. Install the L TFT bracket③ on the left side.	③	121000002873	1
Use screw② to fix it.			

1-8. Installation of MIC&Reset Button

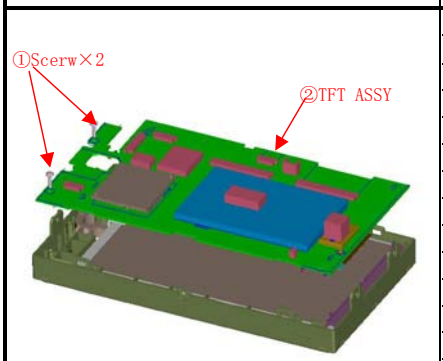


1. Place the rubber② to the micphone① and the press them into the corresponding whole, and use the glue to fix them.	①	123600000014	1
	②	121490000155	1
	③	121230003232000	1
2. Place the reset button③ to the right position in the front panel.			

1-9. Installation of TFT ASSY

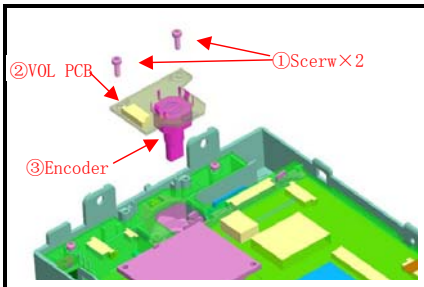


1. Place the Bluetooth module③ at the right place, and use iron to joint it.	①	121405000112	1
	②	121405000084	1
2. Install the shielding cover④, and use iron to fix it, and place on the middle of cover a insulating sponge②.	③	144830010198	1
	④	121002010153	1
	⑤	121002000159	1
3. Install another shielding cover⑤, and use iron to fix it, and place on the middle of cover a insulating sponge①.			
4. Stick at the right place a remote sensor sponge⑥, and install the remote control receiver IC.			



1. Place the TFT Assembly into the front panel bracket, and use screw① to fix it.	①	121040000185	2
	②	TFT ASSY	1
2. Plug in the TFT module and Touch screen FPC cable into corresponding sockets.			

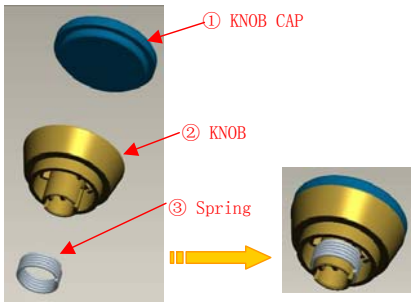
1-10. Installation of VOL PCB ASSY



1. Place the encoder③ to the PCB② and use iron to fix it.
2. Install the encoder assembly, and use screw① to fix in on the front panel bracket.

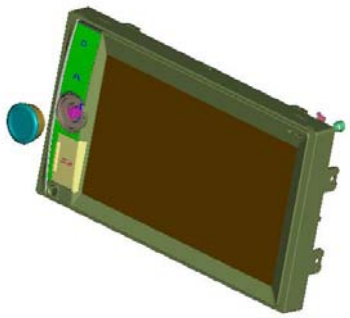
①	121040000185	2	
②	VOL PCB ASSY	1	
③	141658000130	1	

1-11. Installation of VOL KONB



1. Press the metal cap① into the knob②
2. Install the spring③ onto the knob

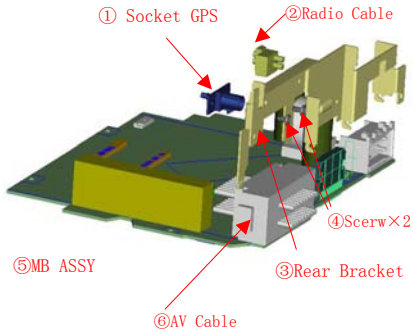
①	121090000404	1	
②	141230403230018	1	
③	121035000569	1	



1. Press the knob assembly onto the encoder pole on the front panel.

2. Processing of Unit ASSY

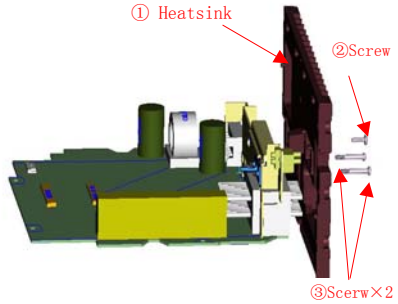
2-1. Installation of Rear Bracket



1. Install the GPS socket① onto the rear bracket③, and use screw④ to fix it.
2. Insert radio antenna② at the right place on the rear bracket and AV cables⑥ as well.
3. Place finished rear bracket onto the MB, use the needle nose plier at the other side to twist the foot of bracket to fix it.

①	123805000860	1	
②	123830001305	2	
③	121000002879	1	
④	121100070081	2	
⑤	MB ASSY	1	
⑥	123830001358	1	

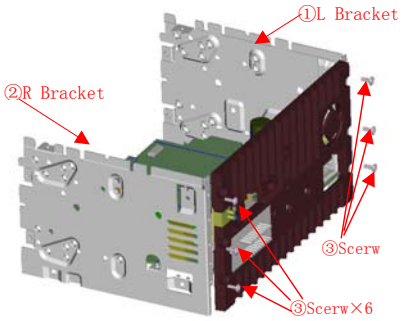
2-2. Installation of Heatsink



1. Put the heat sink① onto the MB, fasten the screws②&③.

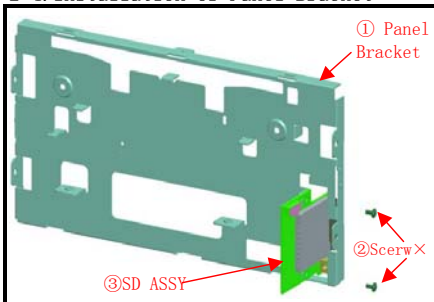
①	141015000210	1	
②	121104070017	1	
③	121106070007	2	

2-3. Installation of R&L Bracket

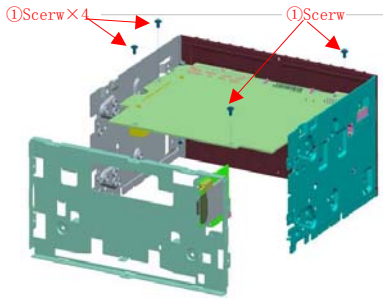


1. Install the L Bracket① and R Bracket② onto	①	121000021221	1	
the MB assembly	②	121000011219	1	
2. Fasten the screws③ on the heatsink,	③	121104070017	6	
total 6 screws.				

2-4. Installation of Panel Bracket

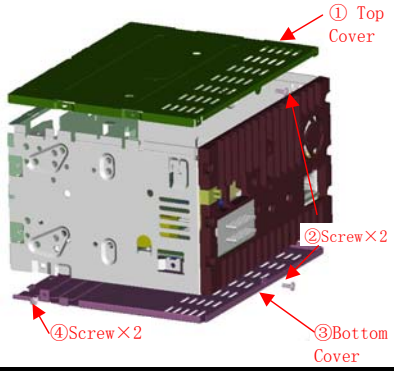


1. Install the SD PCB assembly③ onto the rear	①	121000002871	1	
panel bracket①, and use 2 screws② to fix it.	②	121104050025	2	
	③	842RN6908SD001	1	



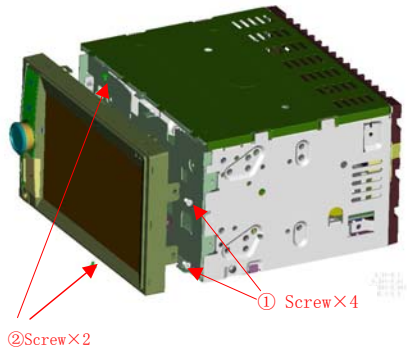
1. Install the rear panel bracket onto unit,	①	121104070007	4	
and fasten the 4 screws① on the bottom.				

2-5. Installation of T&B Cover



1. Install the top cover① onto the head unit.	①	121000002878	1	
2. Install the bottom cover③ onto the head unit.	②	121104070017	2	
3. fix the screws② on the back of the	③	121000002876	1	
heat sink to fasten the top cover and	④	121104070007	2	
bottom cover.				
4. Install 2 screws④ on the sides of the				
bottom cover.				

2-6. Installation of Panel ASSY



1. Plug the FPC and GPS cable in the	①	121040000222	4	
corresponding sockets between head unit	②	121045000040	2	
and front panel				
2. Install the front panel onto the unit,				
and use screws② to fix upper and lower sides,				
and another 4 screws① to fix right and left side.				