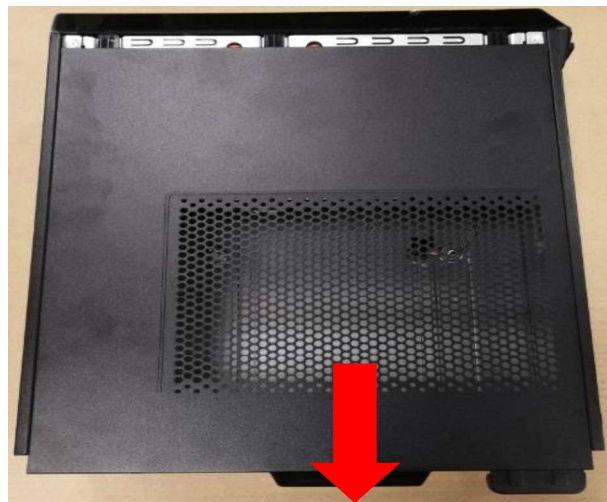# Standard Assembly Process

1. Opening the chassis and bezel

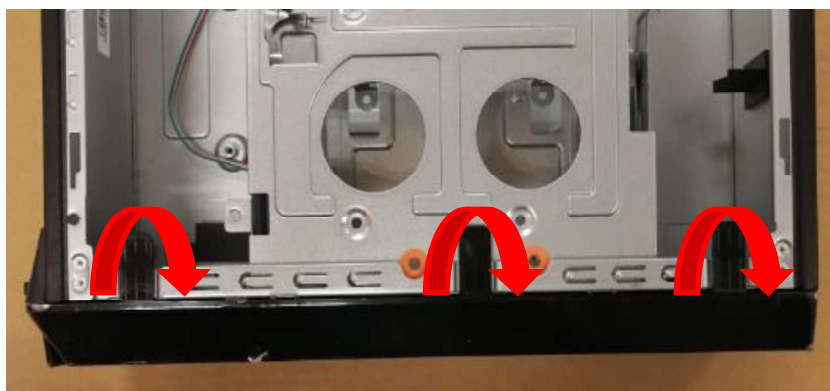**1.1** Remove the screw(#6-32x5mm)

1.2 Remove the left side cover

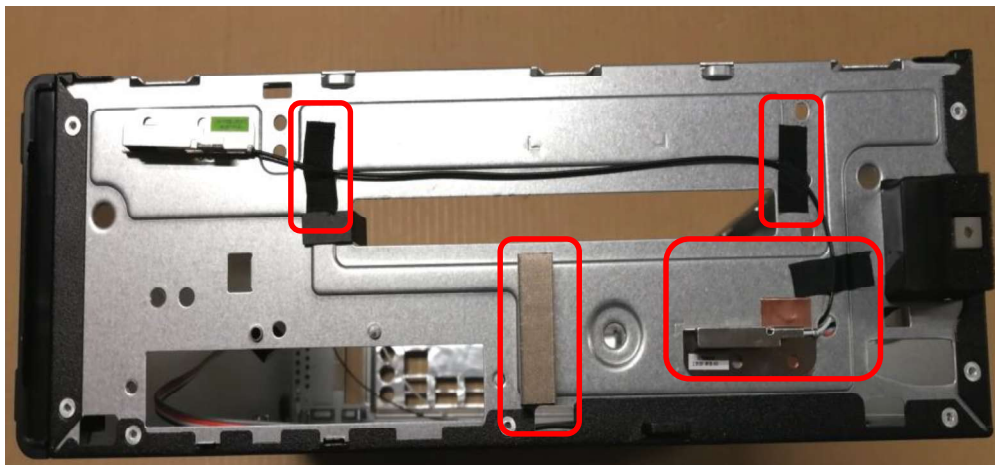**1.3** Push three hooks then you can remove front bezel.

1.4 Remove five screws of HDD cage then disassemble the HDD cage from chassis

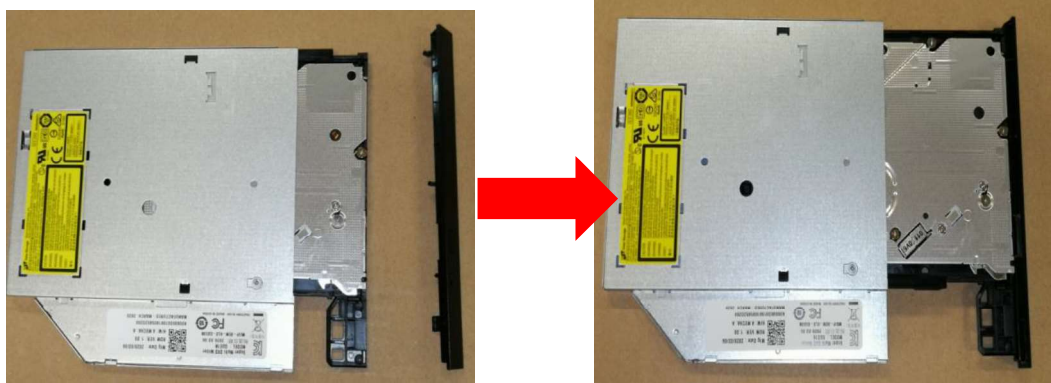**1.5** Remove two screw and disassemble the FIO bracket from chassis

2. Paste the Cu foil &gasket assemble the WLAN antenna and paste acetate tape
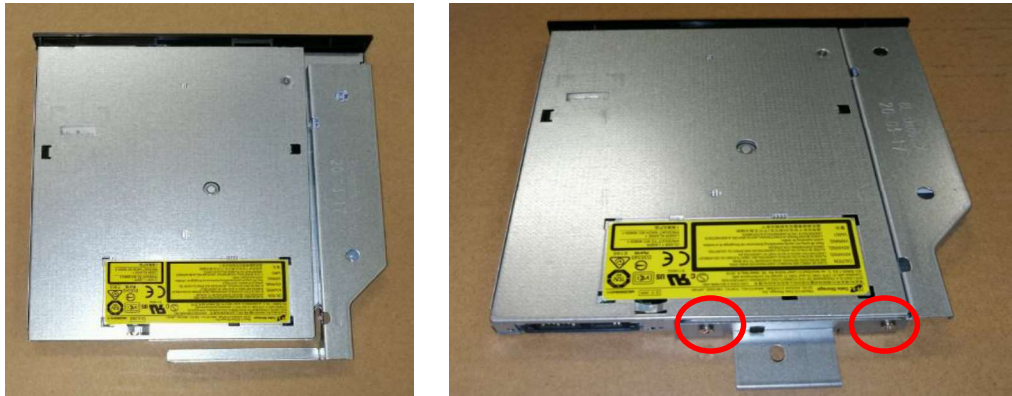
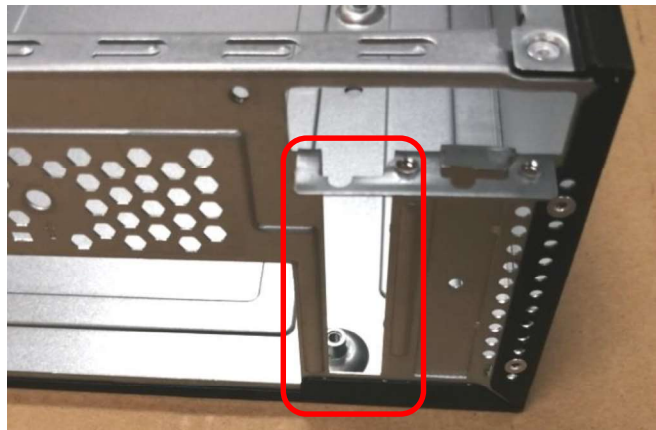### 3. Assemble the slim ODD

3.1 Assemble the slim ODD bezel

3.2 Assemble the slim ODD metal bracket and fix two screws

Step	Screw	Quantity	Screw Type	Part Number	Torque/ kgfcm
Slim ODD	M2*3mm	2pcs		22-232-200325	1.0~1.2kgf.cm

4. Assemble the IO shielding and remove the PCI slot cover
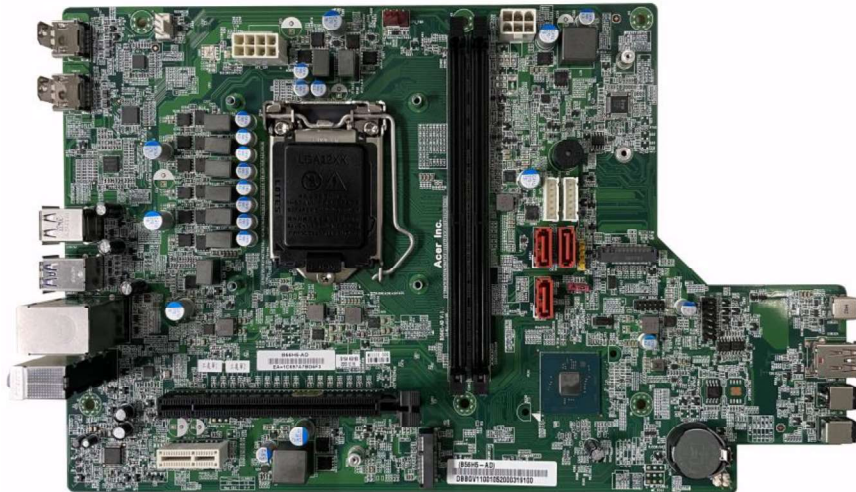
4.1 Remove the PCI slot cover
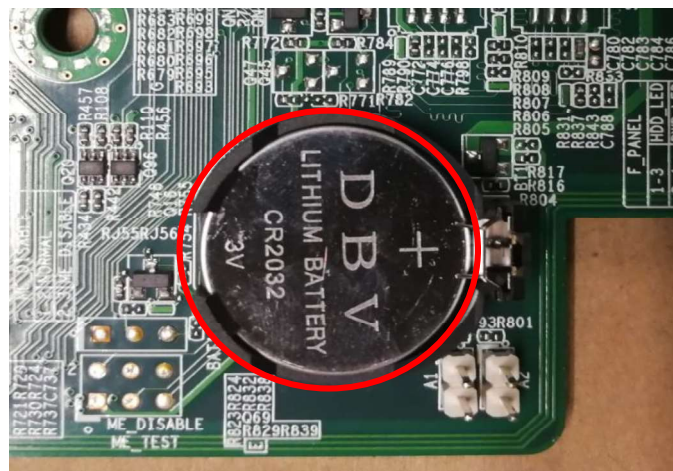
4.2 Assemble the IO shielding

5. Assemble the MB
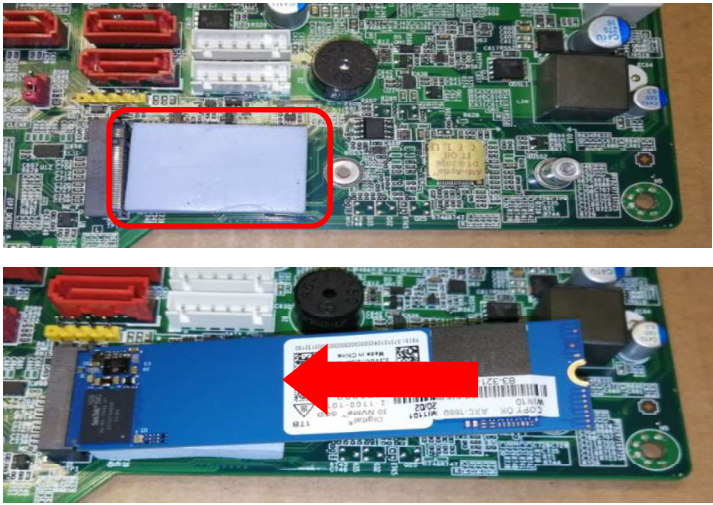
5.1 Motherboard view

5.2 Assemble the battery

5.3 Positioning the thermal pad next to M.2 SSD slot and install M.2 SSD card
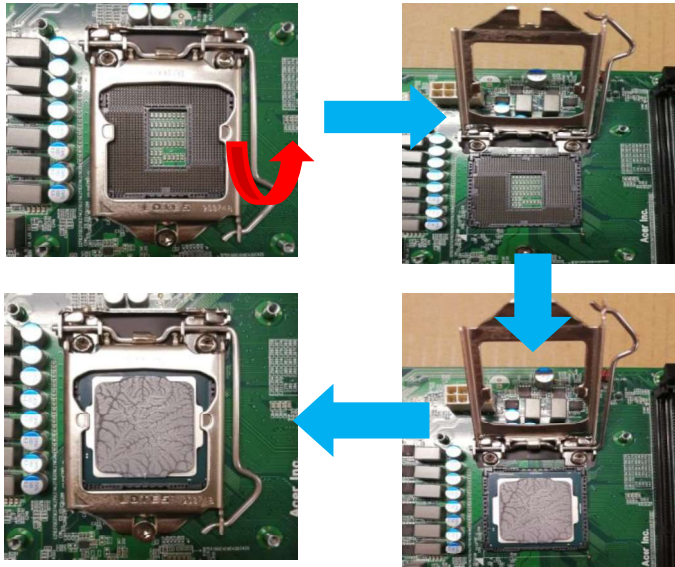
Note: Thermal Pad Size: 20*30*7mm and K Value: 3.2W/mK

5.4 Fastening a screw on M.2 SSD card
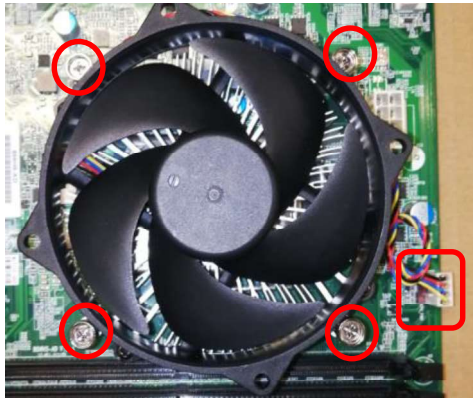

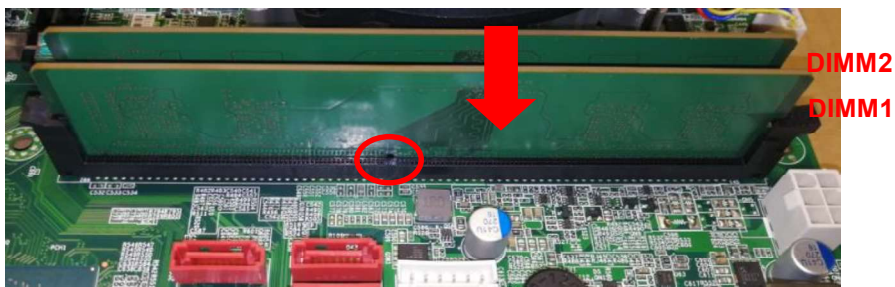| Step	Screw	Quantity	Screw Type	Part Number	Torque/ kgf.cm
M.2 SSD card	M2*3mm	1pcs		22-232-200327	1.6~20kgf.cm

5.5 Assemble the CPU

5.6   Assemble the CPU fan fix these four screws and connect the cable with MB


5.7   Install memory into MB

| Total Memory	DIMM1	DIMM2
4	4G	\
8	4G*	4G*
8	8G	\
12	8G*	4G*
16	8G*	8G*
16	16G	\
20	16G*	4G*
24	16G*	8G*
32	16G*	16G*
32	32	\
36	32*	4*
40	32*	8*
48	32*	16*
64	32*	32*

Note:

1. ” * ” : Support Dual Channel.
2. you can install memory modules in any combination as long as they match the specifications about memory information please reference the latest AVLc list.
3. In case of different size Memory, must put the big size on the top.
4. Not recommend more than 2 (including the same capacity conditions) Memory combination.
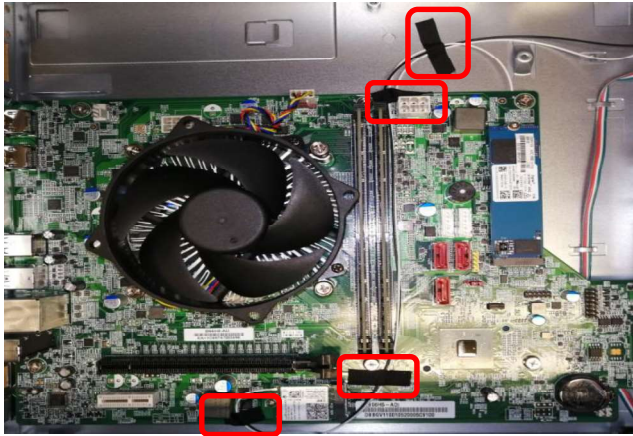
5.8 Assemble the WLAN card and fix the screw
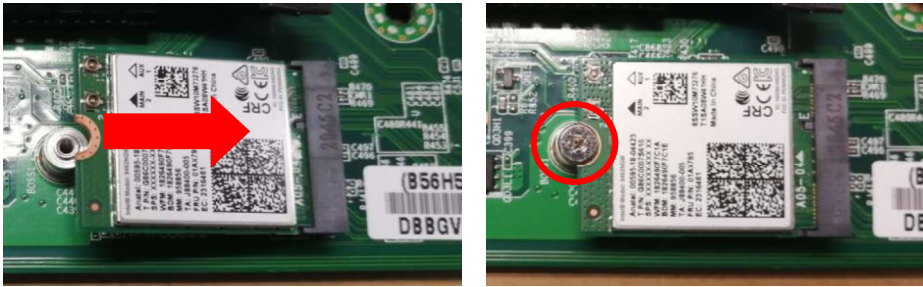
Step	Screw	Quantity	Screw Type	Part Number	Torque/ kgf.cm
WLAN card	M2*3mm	1pcs		22-232-200327	1.6~20kgf.cm

5.9 Put MB into chassis and fix these six screws
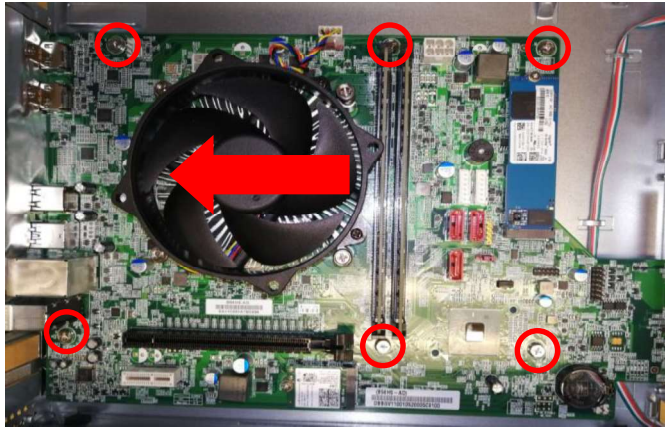
Step	Screw	Quantity	Screw Type	Part Number	Torque/ kgf.cm
MB	#6-32*5mm	6pcs		22-352-630505	6~7kgf.cm

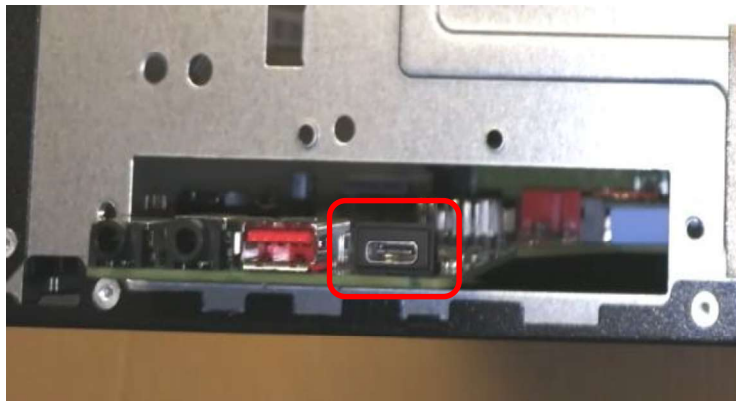**5.10** Paste four piece of acetate tape to fasten WLAN antenna
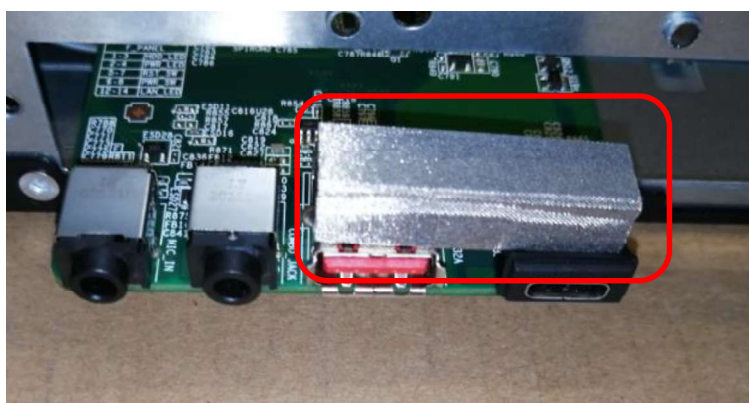
5.11 Connect the front panel cable with MB
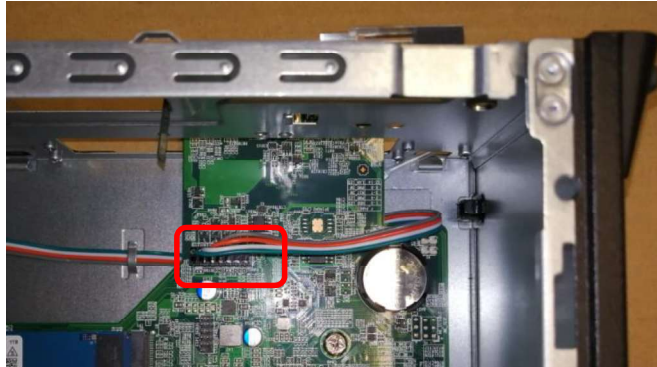
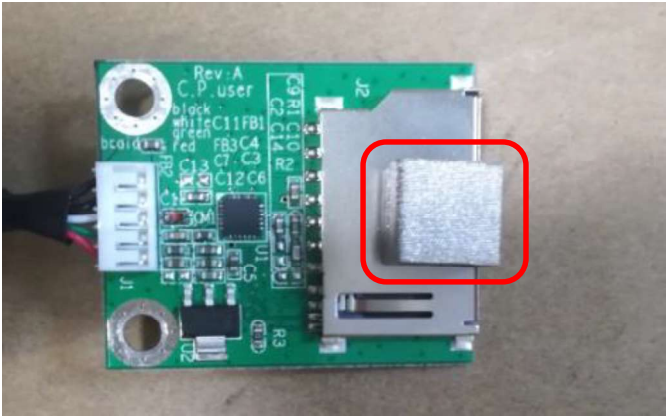## 6. Assemble the FIO bracket
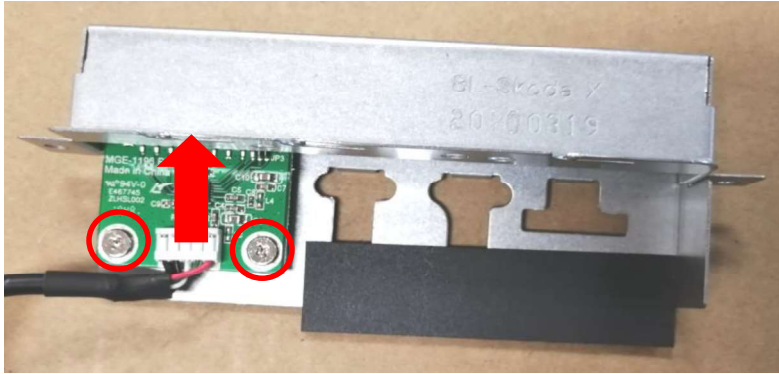
6.1 Assemble the type-C cover

6.2 Paste the gasket for USB connector

6.3   Paste the gasket on SD card

6.4   Fix two screws and assemble the SD card
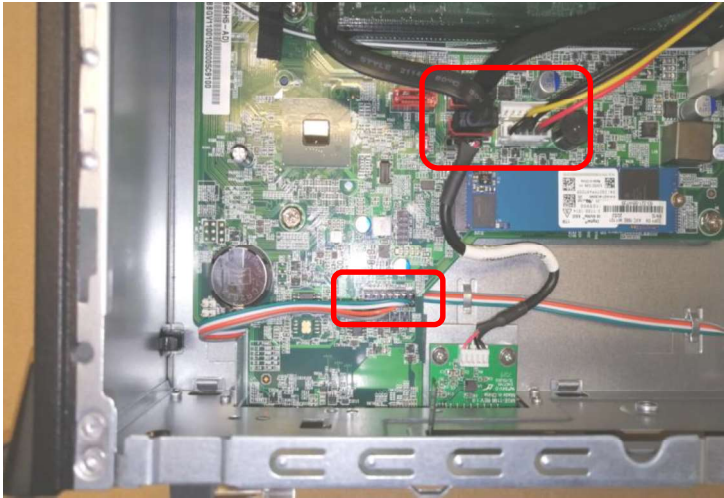

Step	Screw	Quantity	Screw Type	Part Number	Torque/ kgf.cm
SD Card	M3*4mm	2pcs		22-232-300406	4.5~5.5kgf.cm

6.5   Assemble the front IO metal bracket and fix the screw
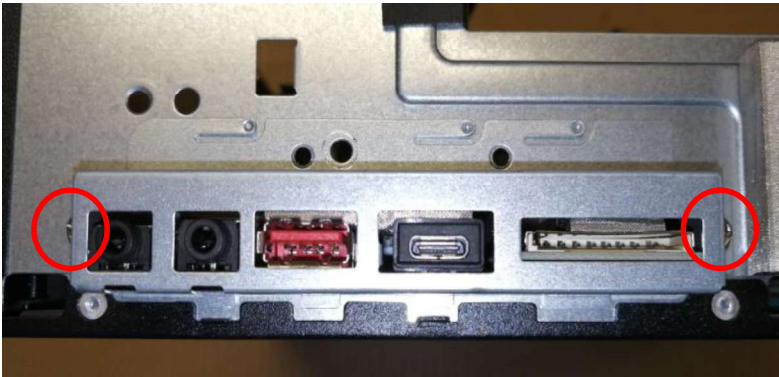
Step	Screw	Quantity	Screw Type	Part Number	Torque/ kgf.cm
IO bracket	#6-32*5mm	2pcs		N/A	6~7kgf.cm

6.6   Connect the SATA cable and front SD card cable with MB

7.   Assemble the PSU

7.1   Assemble the PSU bracket and fix the screw

Step	Screw	Quantity	Screw Type	Part Number	Torque/ kgf.cm
PSU bracket	#6-32*5mm	1pcs		22-352-630505	6~7kgf.cm

7.2   Put the PSU into the chassis

7.3 Fix five screws

Step	Screw	Quantity	Screw Type	Part Number	Torque/ kgf.cm
PSU	#6-32*5mm	5pcs		22-352-630505	6~7kgf.cm

7.4 Connect PSU cable with MB
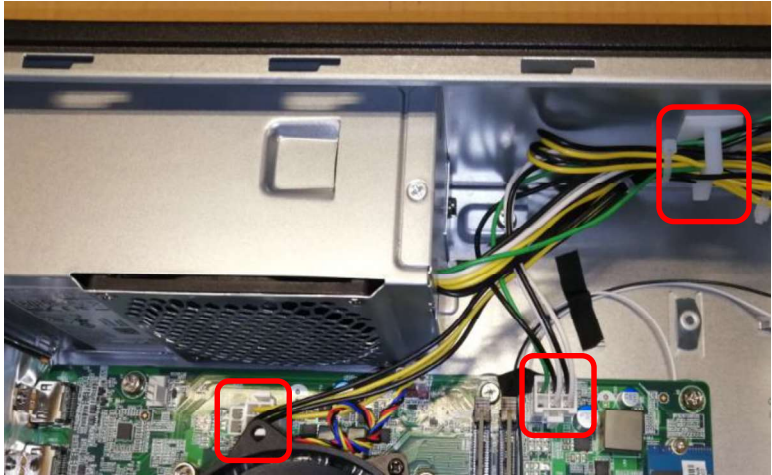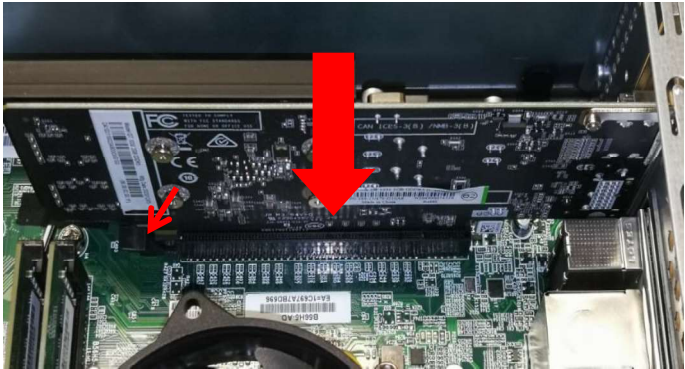

8. Assemble the VGA

8.1 Assemble the spacer

8.2 Assemble the VGA

8.3 Fix the screw of VGA

Step	Screw	Quantity	Screw Type	Part Number	Torque/ kgf.cm
VGA	#6-32*5mm	1pcs		22-352-630505	6~7kgf.cm

9. Assemble the 3.5"HDD

9.1 Fix these four screws of 3.5"HDD

Step	Screw	Quantity	Screw Type	Part Number	Torque/ kgf.cm
HDD	#6-32*3.5mm	4pcs		22-332-630505	5.5~6.5gf.cm

9.2 Assemble the HDD-ODD cage and fix five screws
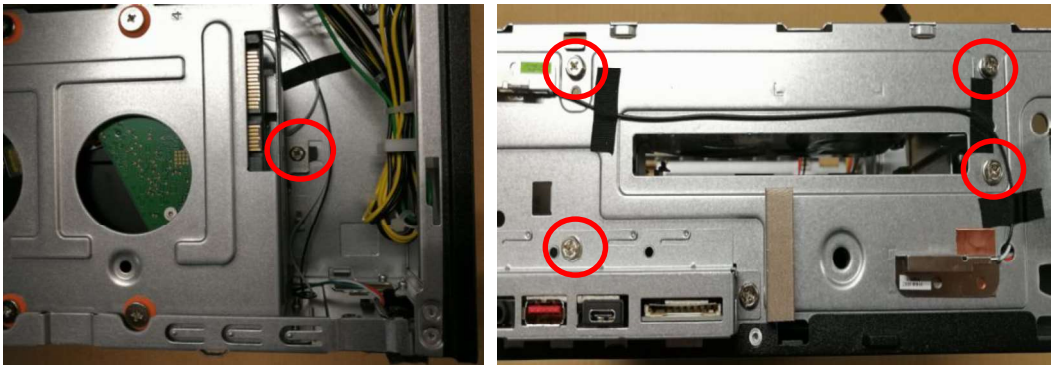
Step	Screw	Quantity	Screw Type	Part Number	Torque/ kgf.cm
HDD-ODD Metal bracket	#6-32*5mm	5pcs		By Vendor	6~7kgf.cm

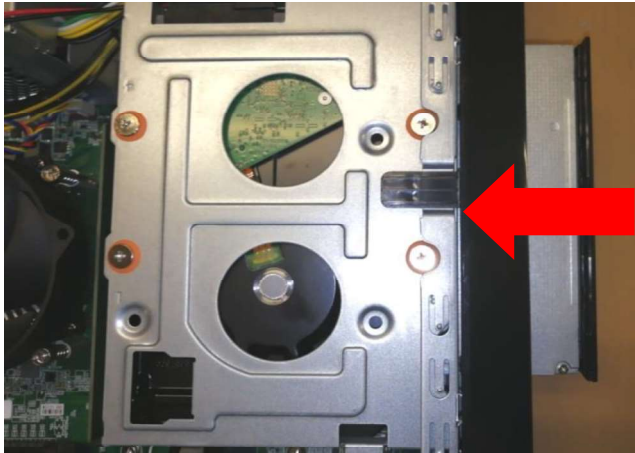**9.3** Connect the HDD SATA cable and HDD SATA power cable
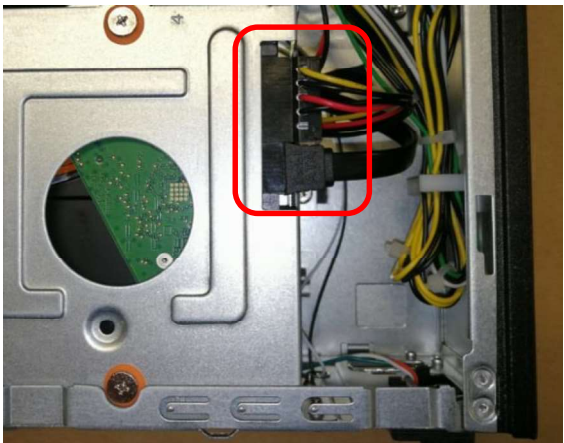
10. Assemble the bezel
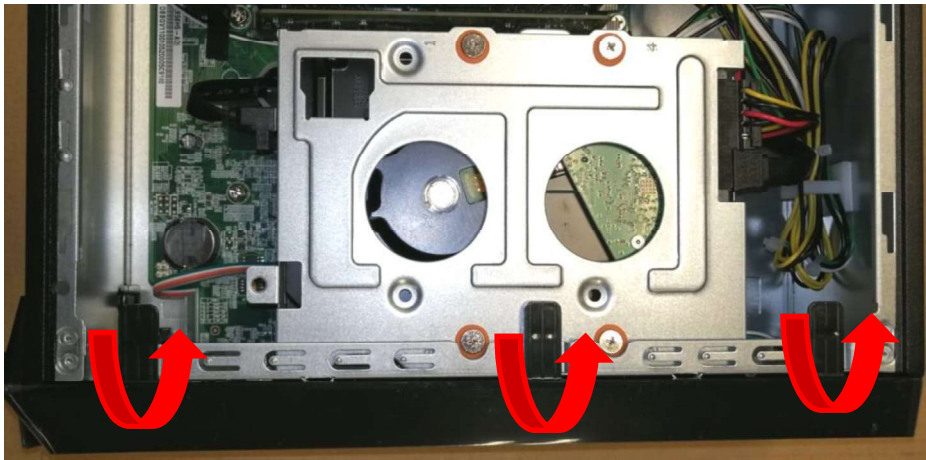
11. Assemble the slim ODD

11.1 Assemble the slim ODD into the chassis

11.2 Fix the screw

Step	Screw	Quantity	Screw Type	Part Number	Torque/ kgfcm
ODD bracket	#6-32*5mm	1pcs		**22-352-630505**	6.0~7.0Kgf/cm

11.3 Connect the ODD SATA cable and ODD SATA power cable

12. Assemble the side cover and fix two screws of left side cover

Step	Screw	Quantity	Screw Type	Part Number	Torque/ kgfcm
side cover	#6-32*5mm	2pcs		N/A	6.0~7.0Kgf/cm

Antenna and Wifi Assembly Process

1. **Opening the chassis and bezel**

   1.1 Remove the screw(#6-32x5mm)

   1.2 Remove the left side cover
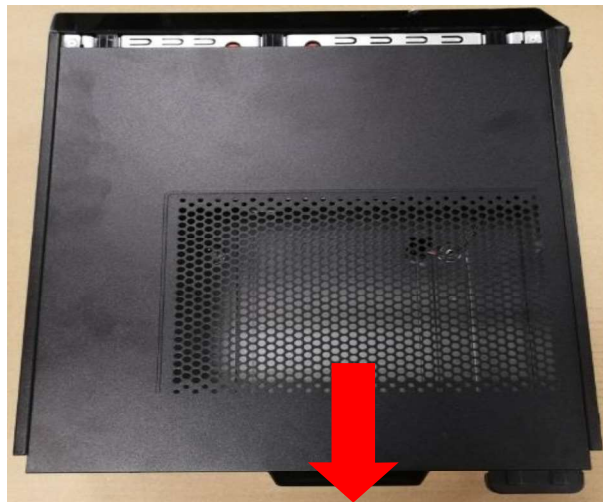
   1.3 Push three hooks then remove front bezel
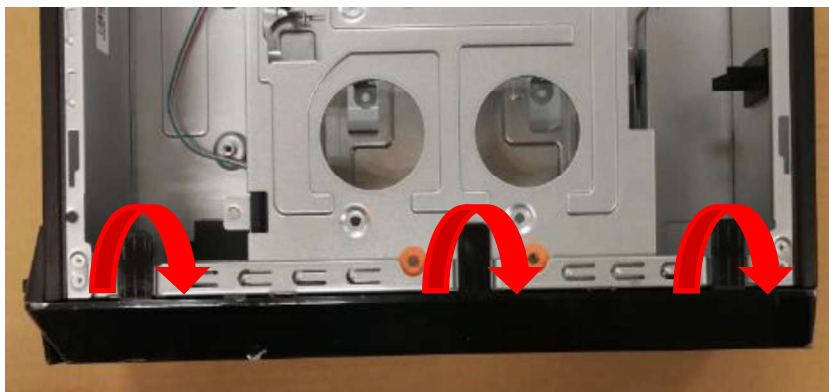
2. Assemble the WLAN antenna

2.1 Paste the Cu foil/gasket assemble the WLAN antenna and paste acetate tape
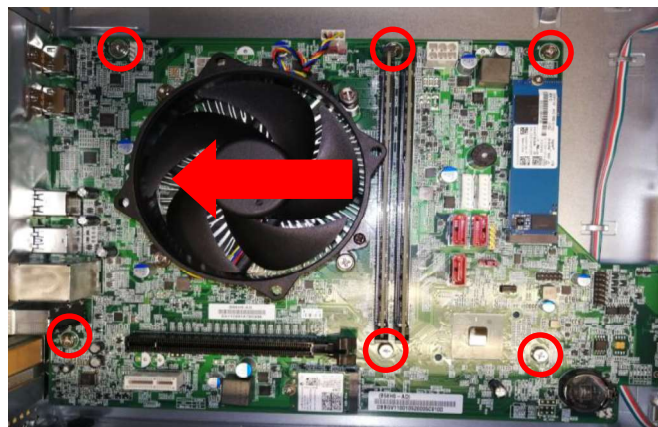

Black L650mm   White L524mm
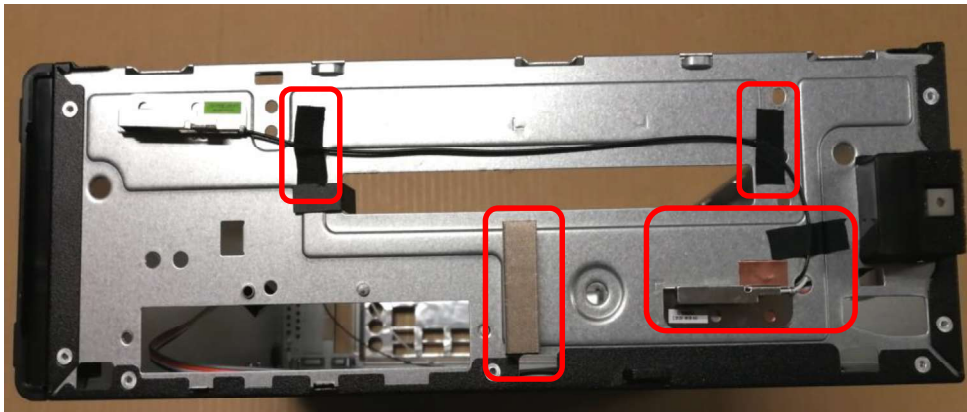
3. Install M.2 WLAN card
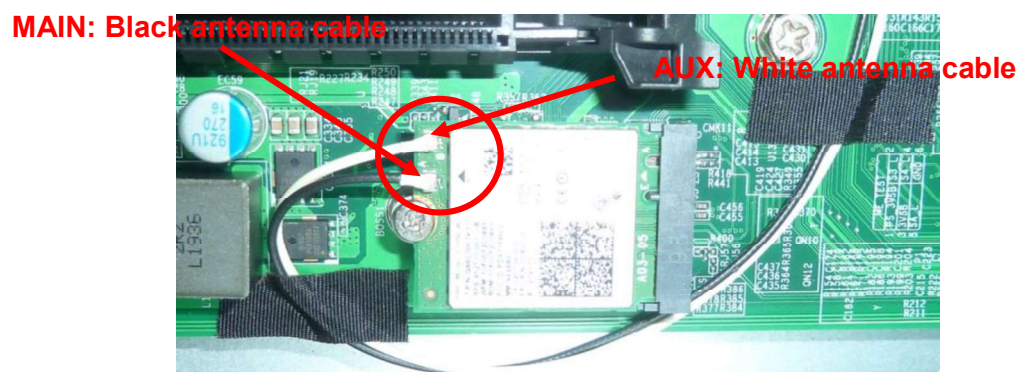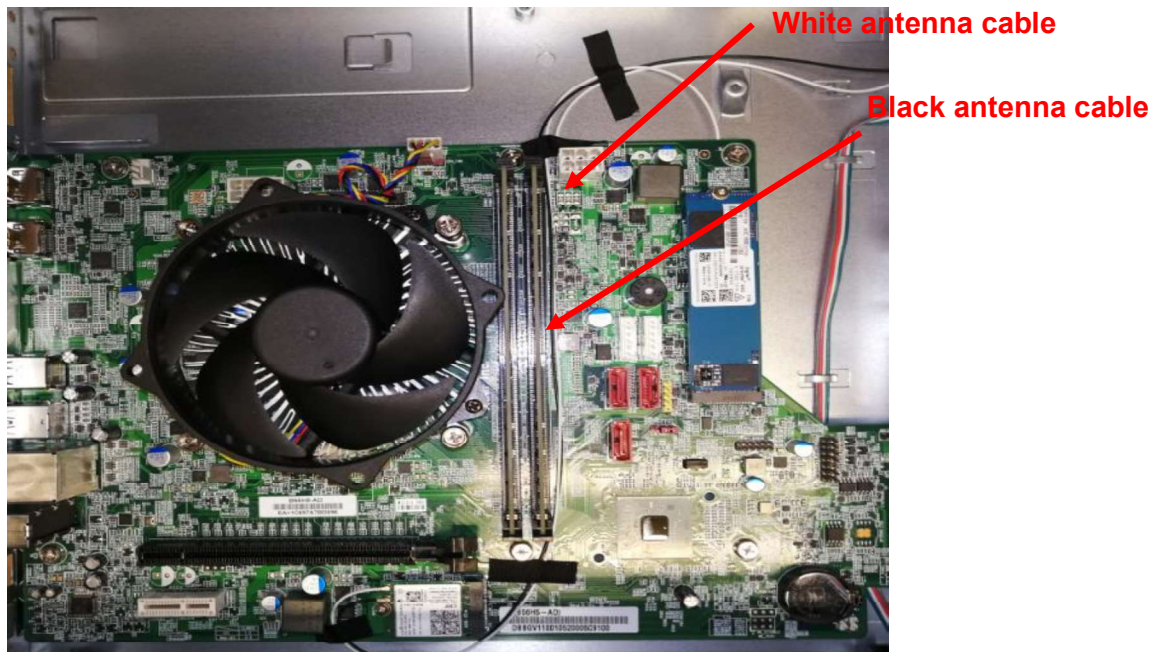
3.1 Install M.2 WLAN card on MB and fix a screw

3.2 Assemble the MB into chassis and fix six screws
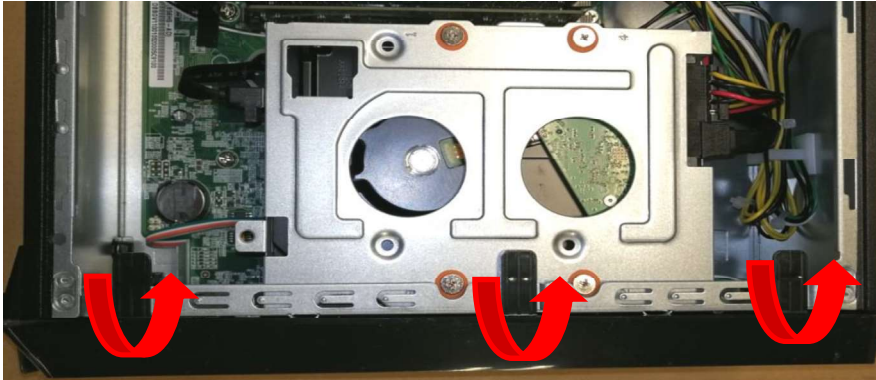
3.3 Assemble antenna cable

White antenna cable

Black antenna cable

MAIN: Black antenna cable

AUX: White antenna cable

3.4 Over view

4. Assemble the bezel

5. Assemble the side cover and fix two screws of left side cover

Standard Disassembly Process

1. Open the computer

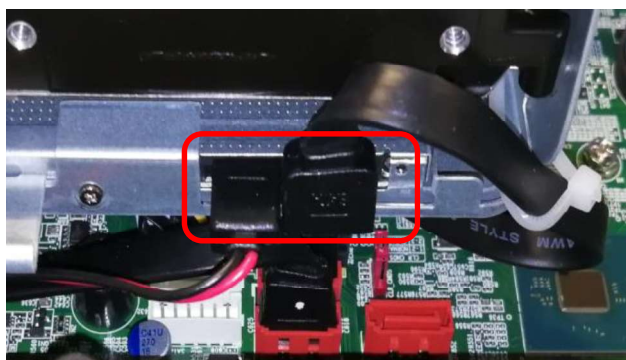**1.1** Remove the two screws fixed from the side-panel.

1.2 Shift the left side-panel and take out it

2. Remove SATA cable, SATA power cable and slim ODD

2.1 Disconnect SATA cable and SATA power-cable from slim ODD

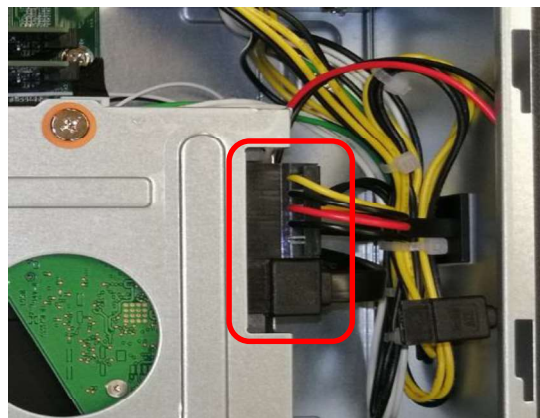**2.2**   Remove the screw of slim ODD and take out slim ODD from the Chassis

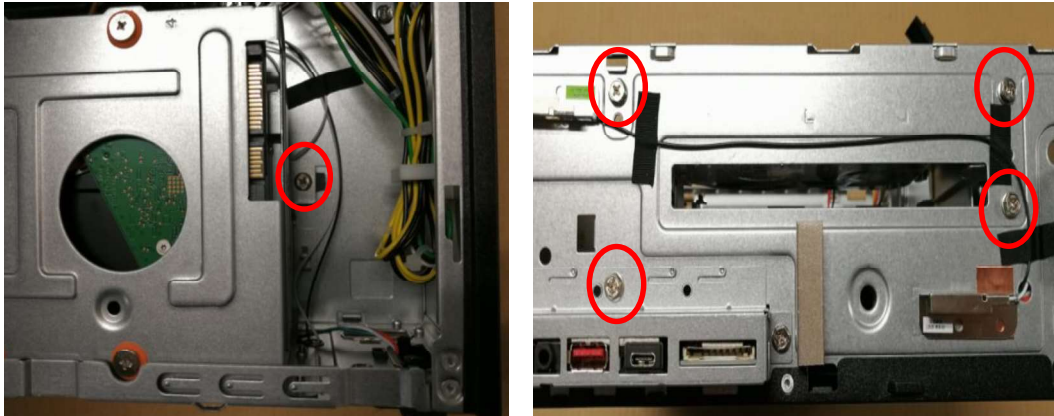**3.   Relax three hooks and remove the main Bezel from the case**
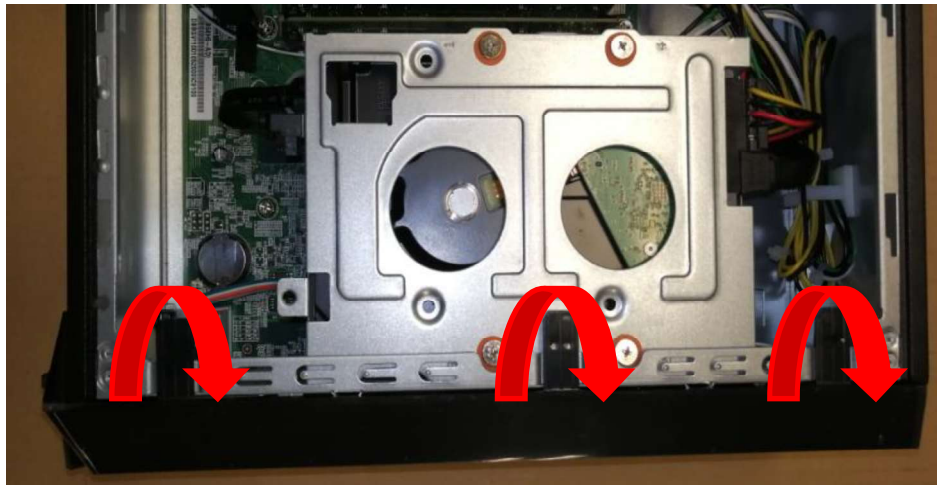
4.   Disassemble the HDD bracket and HDD

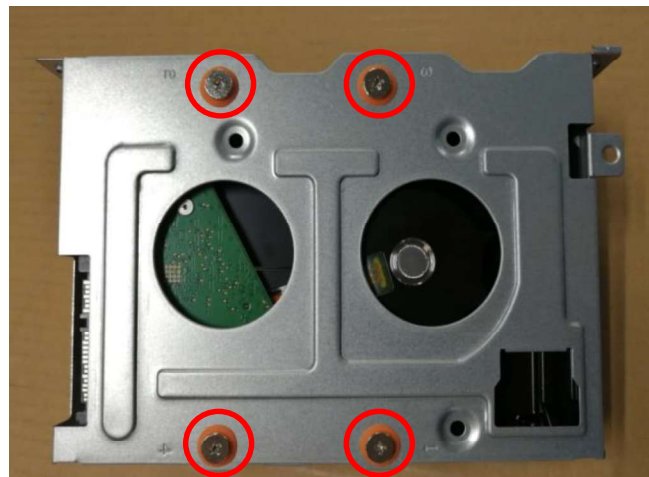   **4.1**   Disconnect the SATA cable and SATA power cable

4.2   Remove five screws from chassis
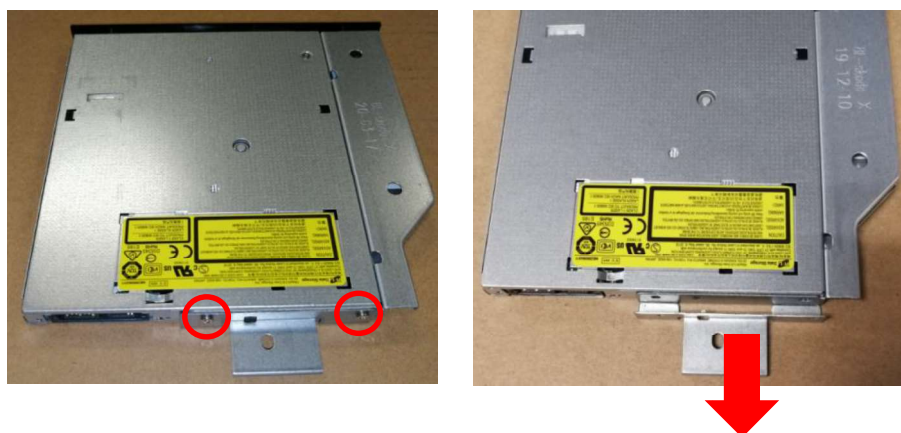

4.3   Remove four screws of HDD and take out it from the HDD cage

5.   Disassemble the slim ODD

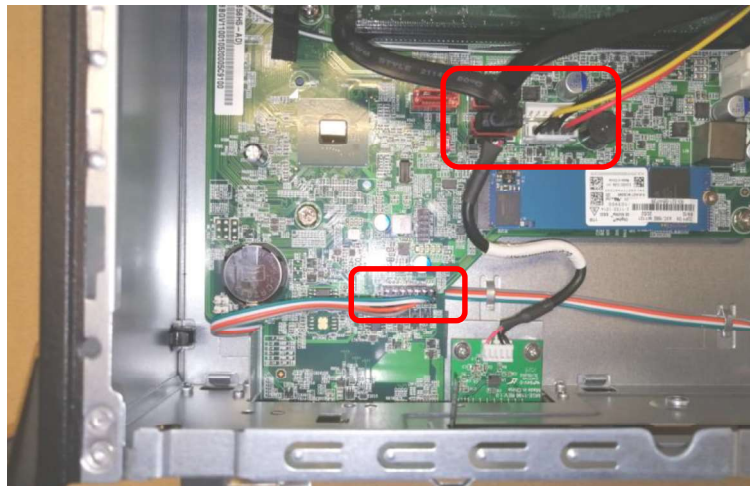**5.1**   Remove two screws from the slim ODD and remove the metal bracket

5.2 Remove the metal bracket from the slim ODD

5.3 Remove the slim ODD bezel

6. Disconnect SATA cable /front SD card cable/front panel cable

7. Disassemble the SD card

7.1 Remove two screw of FIO bracket and take out the FIO bracket from chassis

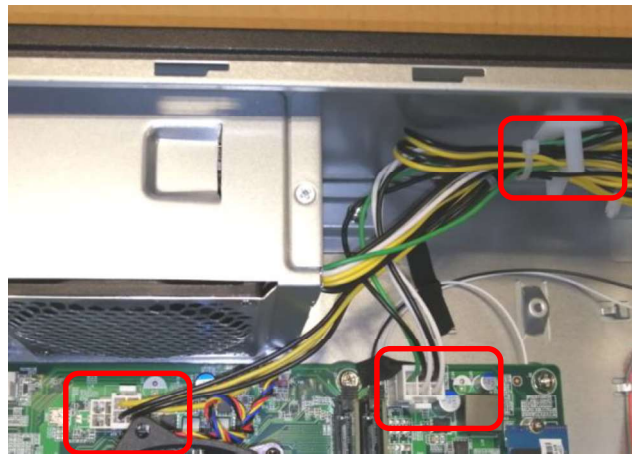**7.2** Remove two screw of SD card and take out card from FIO bracket
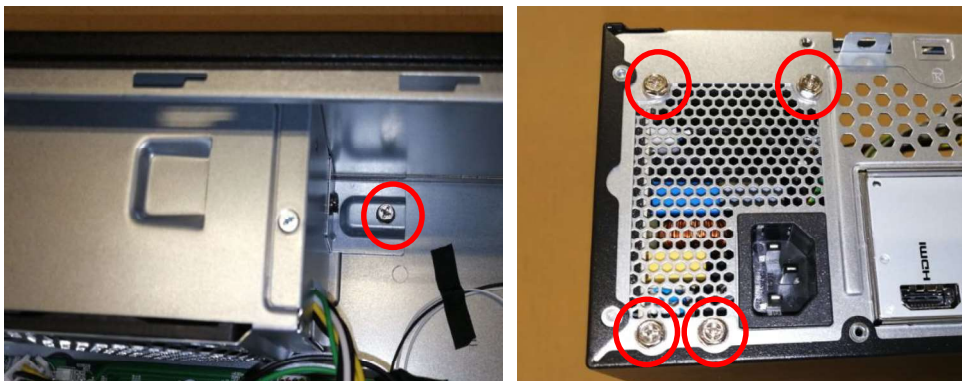

7.3 Remove the gasket from SD card

8. Disassemble the PSU

8.1 Disconnect these PSU cable
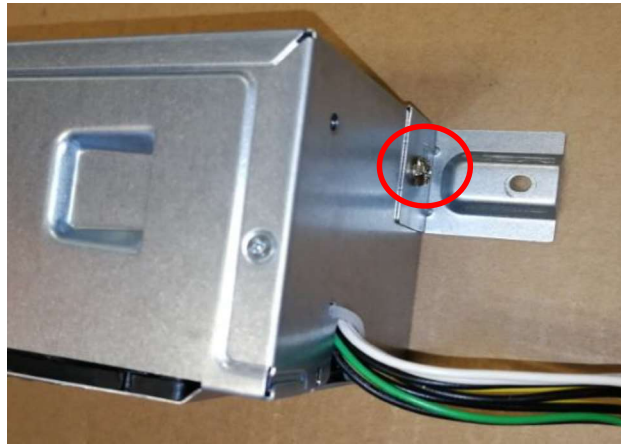

8.2 Remove five screw of PSU

8.3 Take out the PSU from chassis

8.4   Remove the screw and the PSU bracket
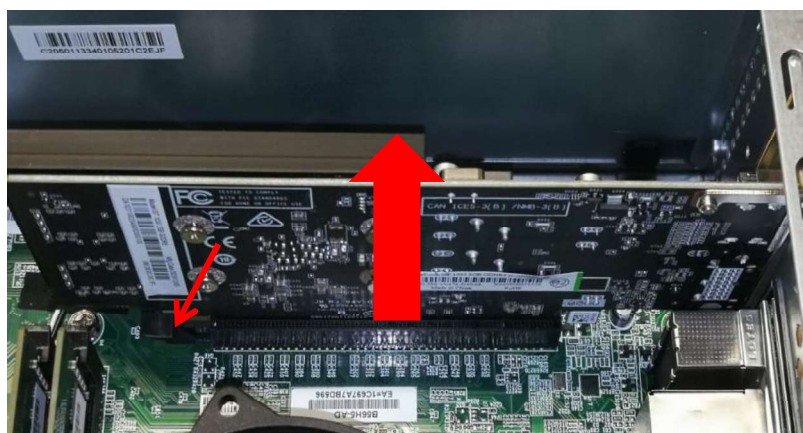

9.   Disassemble the VGA from MB

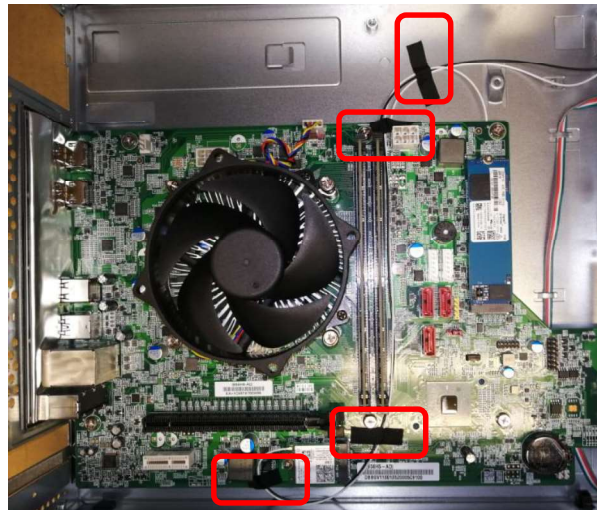**9.1**   Remove the screw

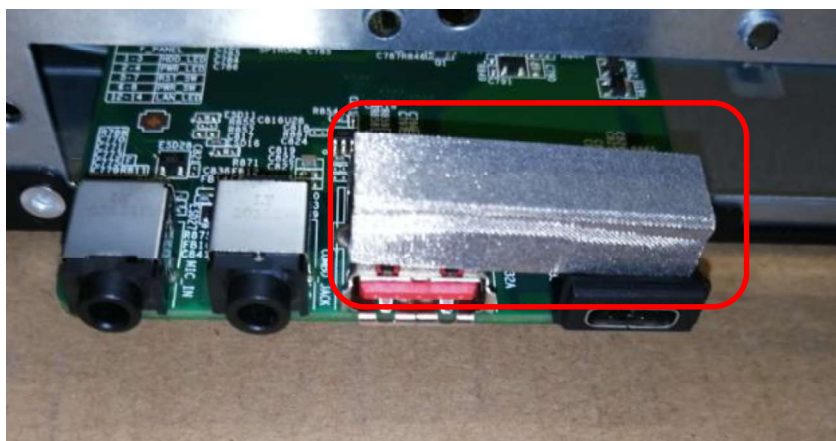**9.2**   Remove the VGA from MB

9.3 Remove the spacer

10. Disassemble the MB from chassis
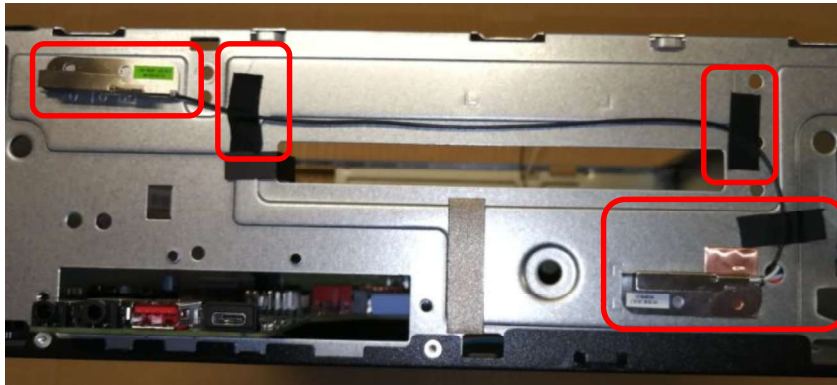
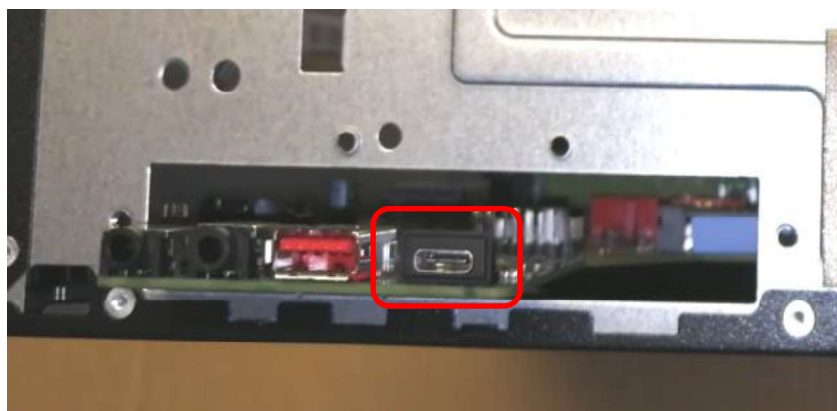**10.1** Remove acetate tape of WLAN antenna
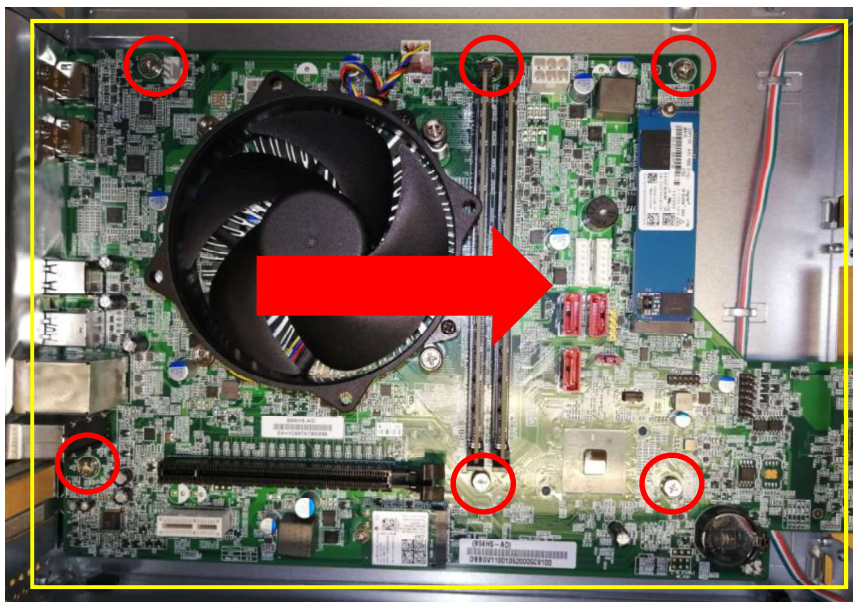

10.2 Remove the sponge

10.3 Remove the WLAN antenna module
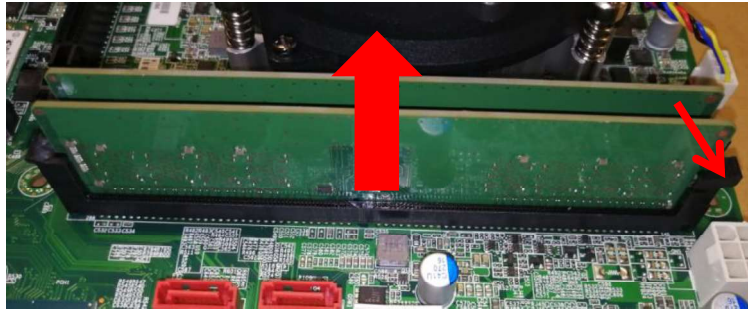

10.4 Remove the type-C cover

10.5 Remove these six screws and take out MB from chassis
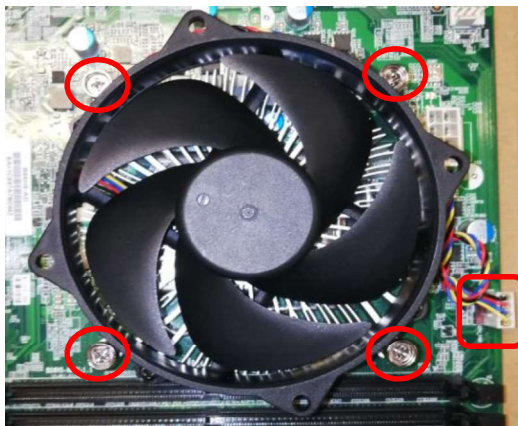

NOTE: Circuit boards >10 cm² has been highlighted with the yellow rectangle as above image shows. Please detach the Circuit boards and follow local regulations for disposal.
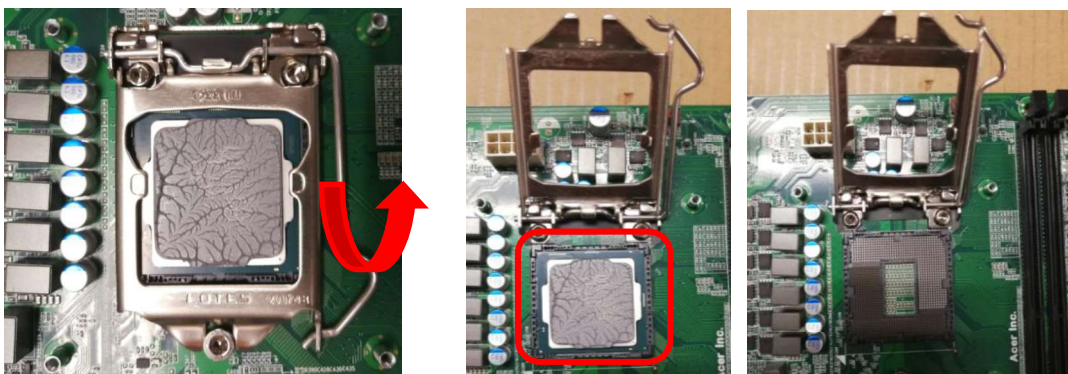
10.6 Remove the memory card

10.7 Loosen these four screws and disconnect CPU fan connector
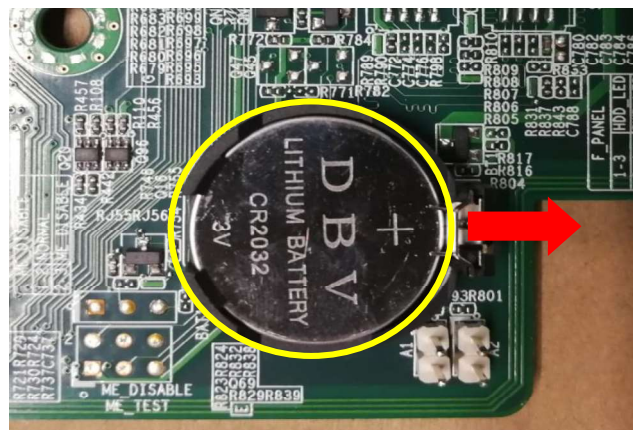

10.8 Disassemble CPU

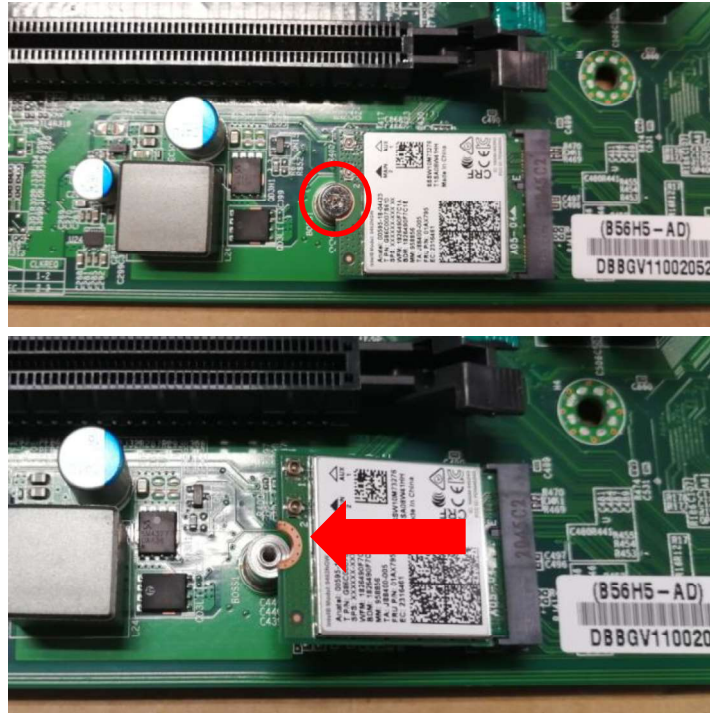**10.9** Remove the screw and take out the M.2 SSD card/thermal pad from MB

10.10 Remove the battery from MB

⚠️ **NOTE:** RTC battery has been highlighted with the yellow circle as above image shows. Please detach the RTC battery and follow local regulations for disposal.

10.11 Remove the screw and take out the WLAN card from MB

10.12 Disassemble the IO shielding