

IT1335-000 Cal-Stand Assembly Procedure

Materials needed:

1. (1) – National Instruments USB-6343 DAQ
2. (1) – IT1335-900 Cal-stand PCBA
3. (1) – IT1335-011 PCB Mount
4. (1) – IT1335-012 PCB Cover
5. (6) – 9551-00440-8C 4-40 IQ+ screws
6. (1) – IT1335-013 DB-37 Support Bracket
7. (2) – 9551-10832-1 Pan Head 8-32 Screws (or equivalent, needs to be 3/8" max length)
8. (2) – 51-160-002 Jack screws
9. (1) – IT1335-015 Cable Kit

Assembly Procedure:

1. Remove magnetic cover on front of DAQ. Remove large pan head screws and cable retention bar from inside DAQ enclosure (Bag bar and screws for storage):



2. Remove (2) – socket head cap screws from rear of DAQ (set aside for reassembly):



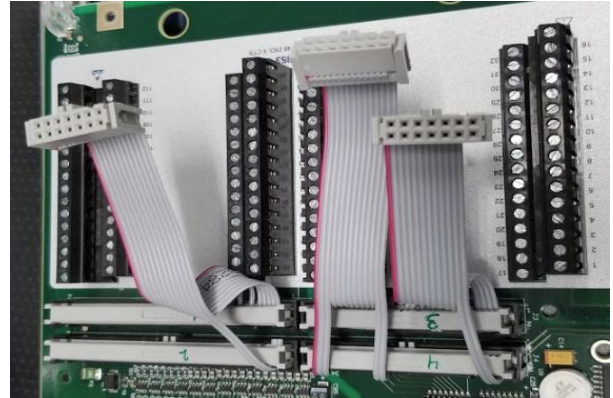
3. Carefully slide internal circuit board out of aluminum enclosure:



4. Remove (2) pan head screws holding blue divider between headers and screw terminals(Bag for storage):



5. Install IT1335-015 Ribbon Cables into mating connectors in middle of DAQ PCBA. Connectors should be labeled corresponding with the marking on PCBA Silkscreen. Gently manipulate cables to be flat against the tops of the large connectors, and arrange the small connectors between the screw terminals as shown:



6. Insert the end of the DAQ PCBA back into the aluminum enclosure, and tuck the connectors so they will clear the opening. Guide the wires flat as they enter the enclosure:
7. Reattach the (2) – SHCS from step 2, and tighten to snug.



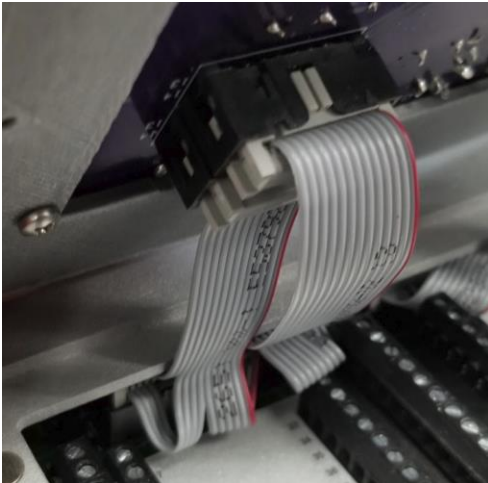
8. Insert IT1335-013 Support bracket into front of DAQ enclosure, and attach with 8-32 pan head screws. Align back of bracket with enclosure as shown before tightening to snug:



9. Stack IT1335-012 PCB cover, IT1335-900 PCBA, and IT1335-011 PCB Mount together, aligning the screw holes:



10. Attach with (4) – 4-40 IQ+ screws to snug, then back off $\approx 1/8^{\text{th}}$ turn. PCB should be held in place but be able to shift into place during steps 13 & 14.
11. Attach free ends of ribbon cables as shown:



12. Slide DB-37 connector into support bracket, and gently press the PCB assembly down to seat in enclosure:



13. Attach jack screws to DB-37 through support bracket (PCB may need to be shifted to line holes up):



14. Attach (2) – 4-40 IQ+ screws through the PCB mount into the aluminum enclosure. The PCB mount may need to be shifted back to line up with the threaded holes on the enclosure:



15. Using a small flat head driver, attach IT1335-015 power cable to the connector at the back of the PCB cover above the “N”:



16. Attach other end of power cable to back of the DAQ:



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