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# Part Replacement Instruction

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**Product:** EM 1, EM 6, EMC 6, EMC 6M, and CH 1

**Part Replaced:** CPU/X-Y Driver Board

**Required Tools:**

#2 Phillips Screw Driver  
1/16 Allen Wrench  
Anti-Static Wrist Strap

**Procedure:**

1. Turn the peripheral off and unplug the Power Cord from the wall socket.
2. Unplug the Network Cable(s) from the rear of the peripheral.
3. Remove the Electronics Cover from the peripheral.
4. Put on the Anti-Static Wrist Strap and attach the free end to any unpainted metal area of the peripheral.
5. Carefully unplug the Encoder Cable (Figure 1-A) from the CPU Board (Figure 1-B).

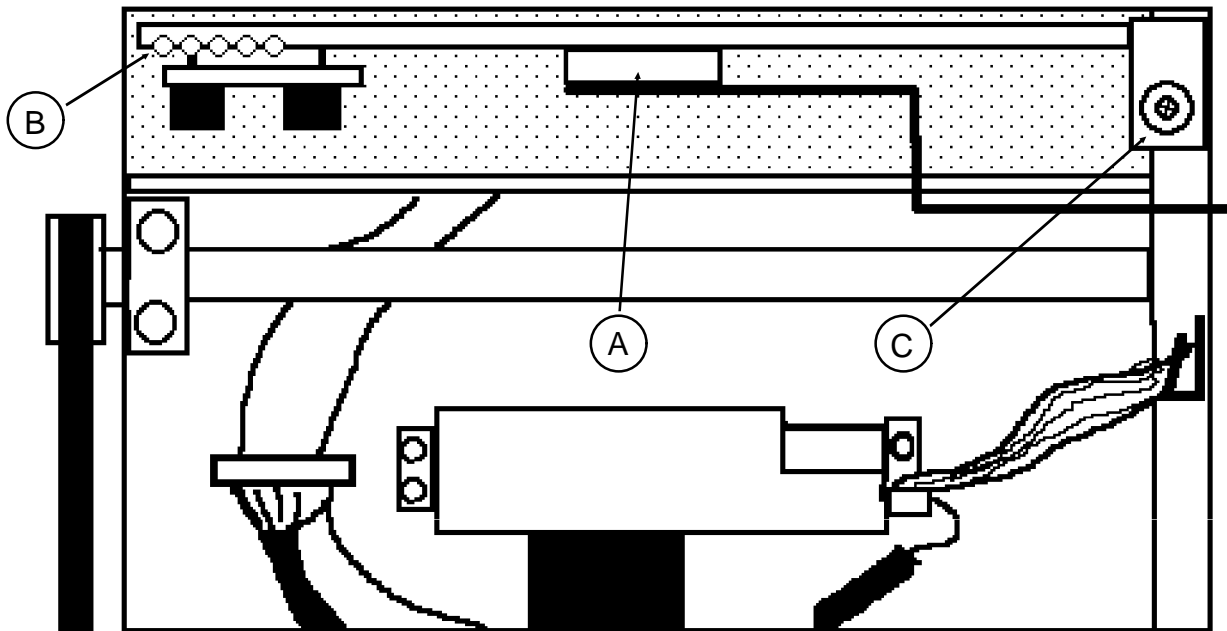


Figure 1

NOTE: Take care not to drop any of the small parts removed in the next step into the interior of the Chassis.

6. Remove the Retaining Screw and Washer (Figure 1-C) holding the CPU Board inside the Chassis.
7. Grasp the CPU Board by the top corners and gently rock the board upward until it is loose.
8. Pull the Board up and out of the Chassis and lay it on a clean, static free surface.
9. Remove the Retaining Screw (Figure 2-D) holding the X-Y Driver Board (Figure 2-E) to the CPU Board Standoff.

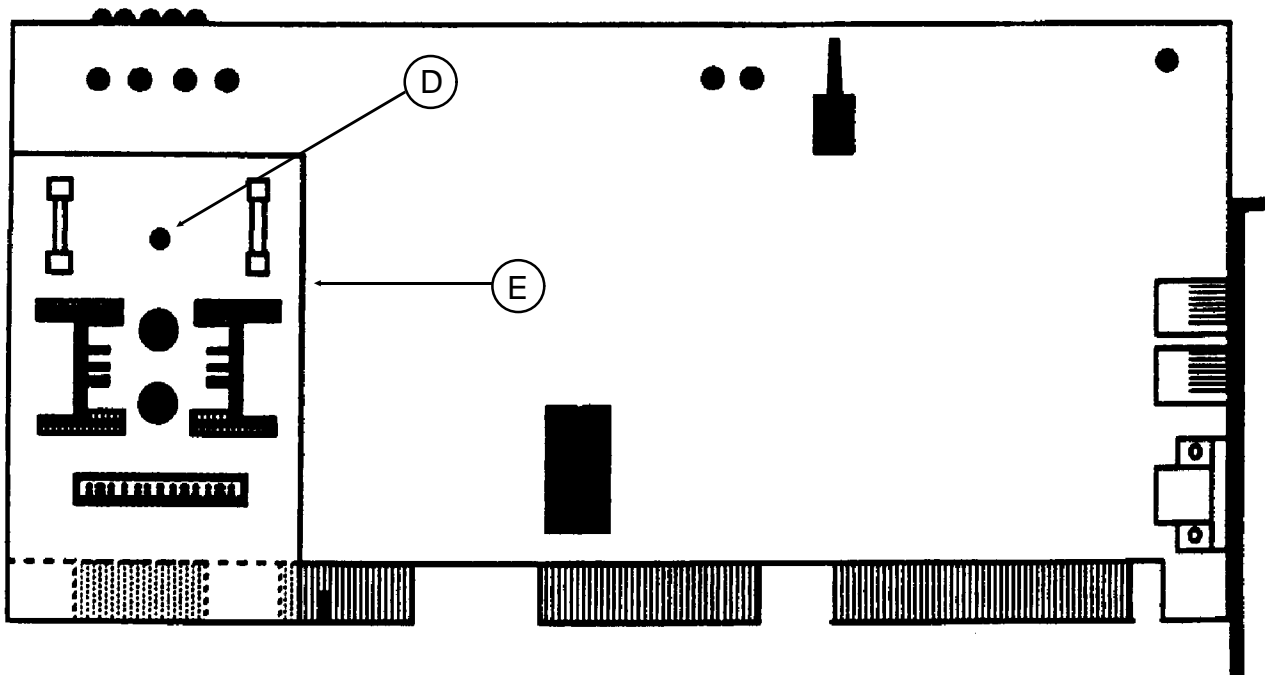


Figure 2

10. Grasp the X-Y Driver Board by its sides and gently pull it free of the CPU Board.

NOTE: If you are only replacing the X-Y Driver Board, go to step 14.

11. Turn the CPU Board over to its back side.
12. Remove the Retaining Screw holding the CPU Board Standoff to the CPU Board.
13. Install the CPU Board Standoff onto the new CPU Board, using the Retaining Screw removed in step 12.
14. Plug the X-Y Driver Board into the receptacle on the CPU Board and secure it with the Retaining Screw removed in step 9.

15. Slide the CPU Board into the Chassis, making sure that the Edge Connectors on the bottom of the CPU Board line up with their Receptacles.
16. Press the CPU Board Edge Connectors firmly into their Receptacles.
17. Secure the CPU Board in the Chassis with the Retaining Screw and Washer removed in step 6.
18. Plug the Encoder Cable into its receptacle on the CPU Board.
19. Remove and disconnect the Anti-Static Wrist Strap.
20. Replace the Electronics Cover on the peripheral.
21. Plug in the Network Cable(s).
22. Plug the Power Cord into the wall socket.
23. Turn the peripheral on in the Configuration Mode.
24. Configure the peripheral correctly.
25. Perform a test sew out.

END OF PROCEDURE