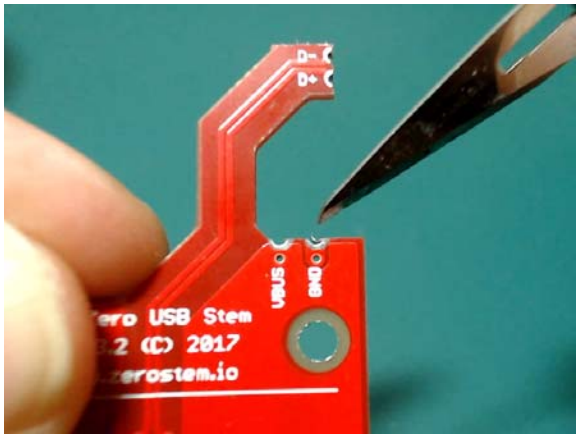
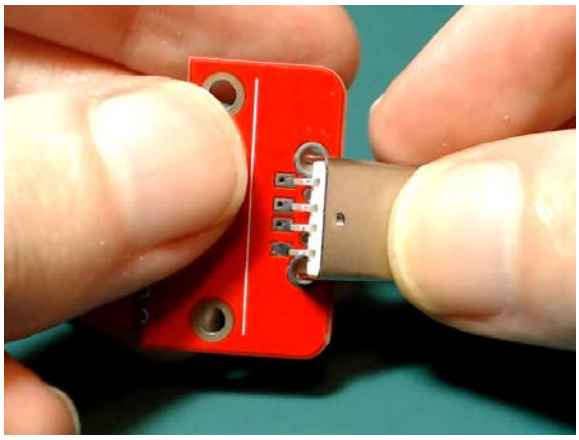
1. Check the kit contents. You will also need a soldering iron, sandpaper, and scalpel.

2. Inspect the board. The castellations should be silver in colour and free of any drilling debris.

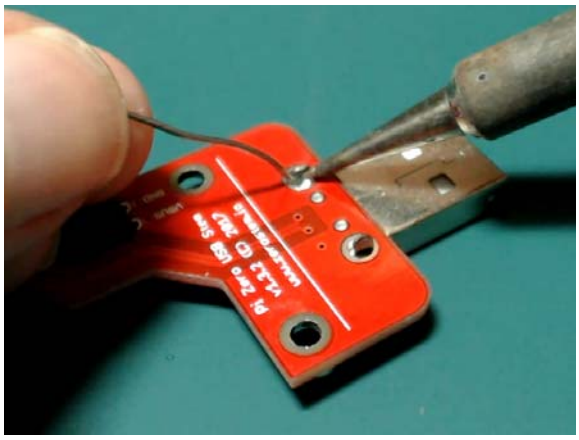


3. If there is any debris in the castellations, remove it with a scalpel. Be careful not to damage the via.

4. You may need to sand the edge of the board to fit the USB connector. You don't want it to be too loose though. You may also want to tidy up any rough edges.

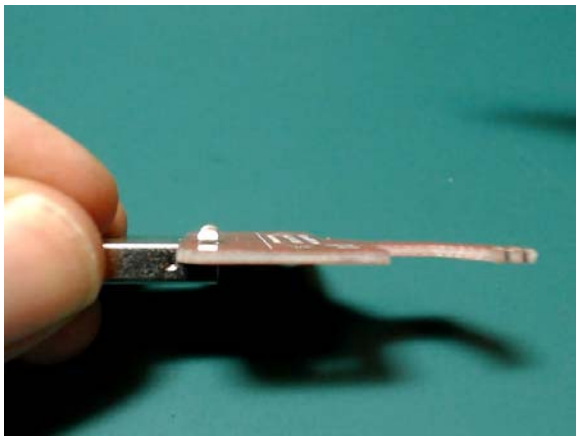


5. Press the USB connector on to the Zero Stem PCB.

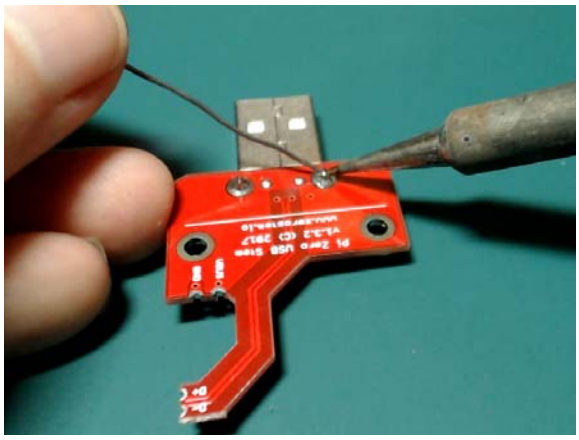


6. Solder one of the USB connector's stress relief tabs. Only put enough solder to hold it in place.

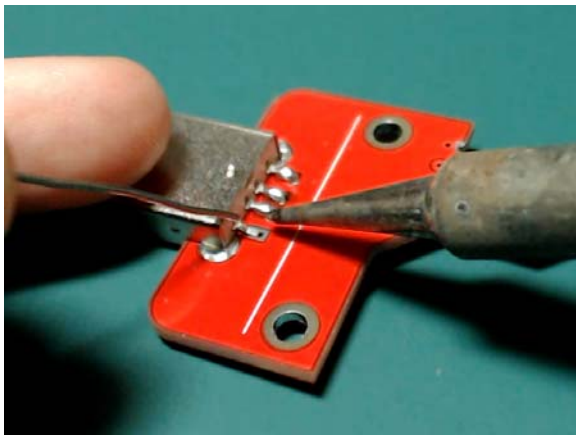
7. To align the connector, reflow the solder on the tab joint while pressing down on the Zero Stem PCB.



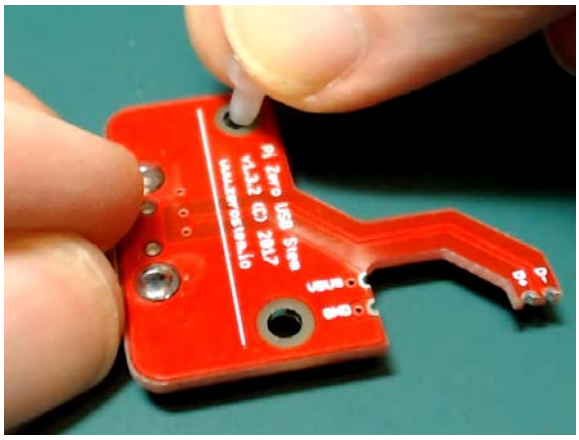
8. Check the connector is aligned correctly. It should be flush with the Zero Stem PCB.



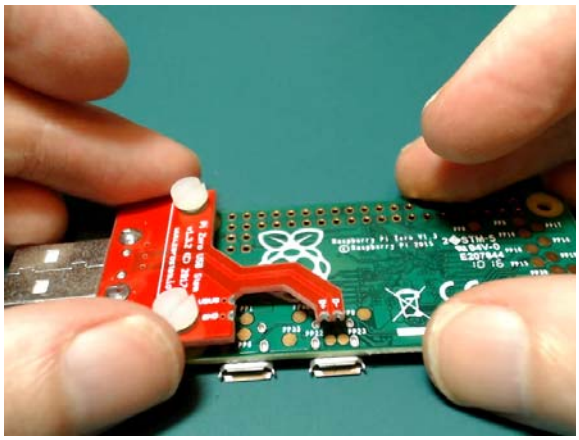
9. Solder the other stress relief tab. Make sure both holes are completely filled with solder.



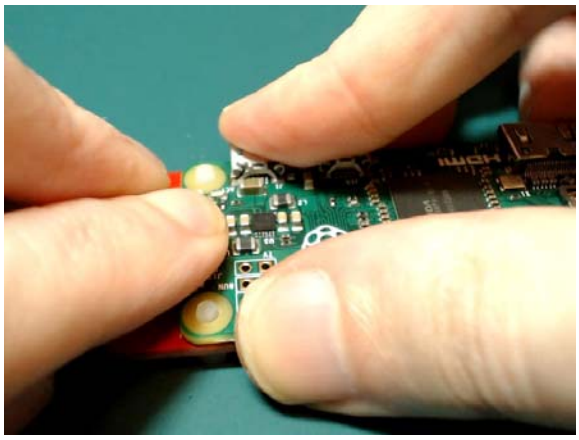
10. Solder the USB connector SMD pads.



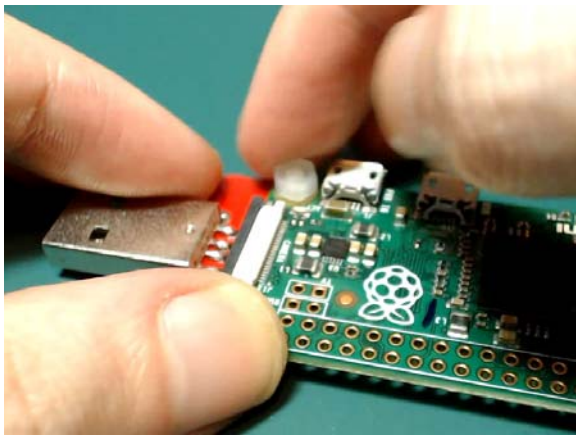
11. Insert bolts. They are a tight fit. This is intentional to prevent any stress on the Pi Zero test points.



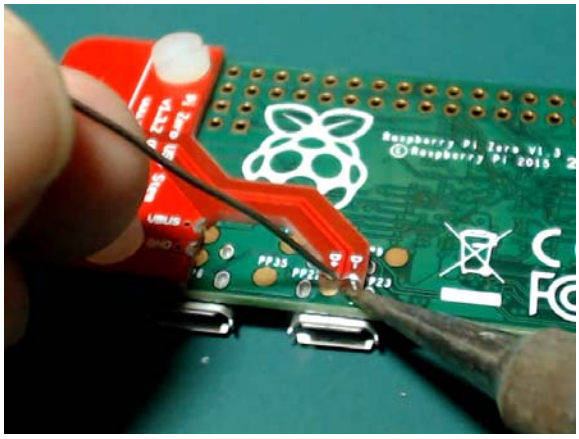
12. Align the Zero Stem PCB bolts with the mounting holes in the Pi Zero.



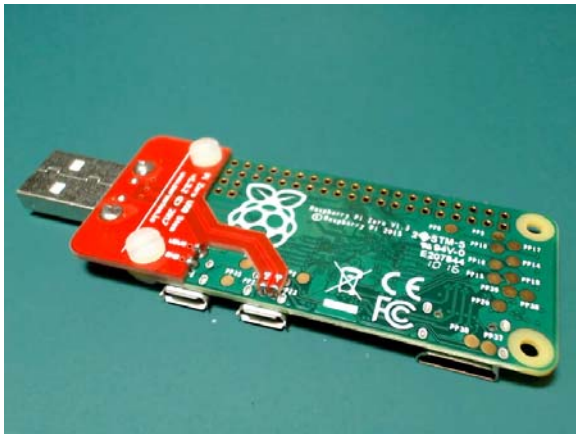
13. Push the Pi Zero onto the Zero Stem bolts. Again, this will be a tight fit.



14. Fix the boards together with the nuts.



15. Solder the four Zero Stem castellations to the Pi Zero test points.



16. Finished!