Overlay Assembly Procedure

Assembly Procedure for PulseIR™ LS/MS Overlays

PulseIR Overlay Assembly Process

1. Prepare Front Panel
2. Install Filter units
3. Attach PCB Modules
4. Test LED/PCB Function
5. Place Glass Pane
6. Assemble Back Panel
7. Test Assembly

Start: Prepare Front Panel

Start with the front panel facing down.

Step 1: Install Filters

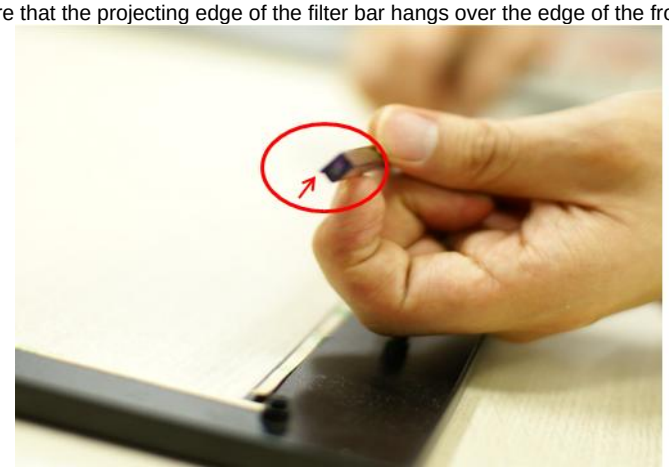
Apply double-sided tape along the inside edge of the front panel – do this for all 4 sides.

Position the edge of the tape about 1mm inside of the panel edge.



Step 2: Install Filters

Be sure that the projecting edge of the filter bar hangs over the edge of the front panel as shown below.




Carefully mate the filters so that there is no gap at each corner.

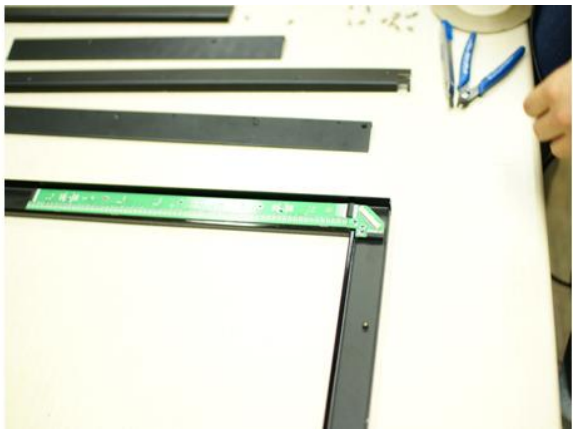
This is how the unit looks once the filters are attached to the front panel.

Step 2: Attach PCB Modules

2a. Apply sponge tape on the panel surface (along the edge of the filter).

2b. Start placing the PCB Modules.

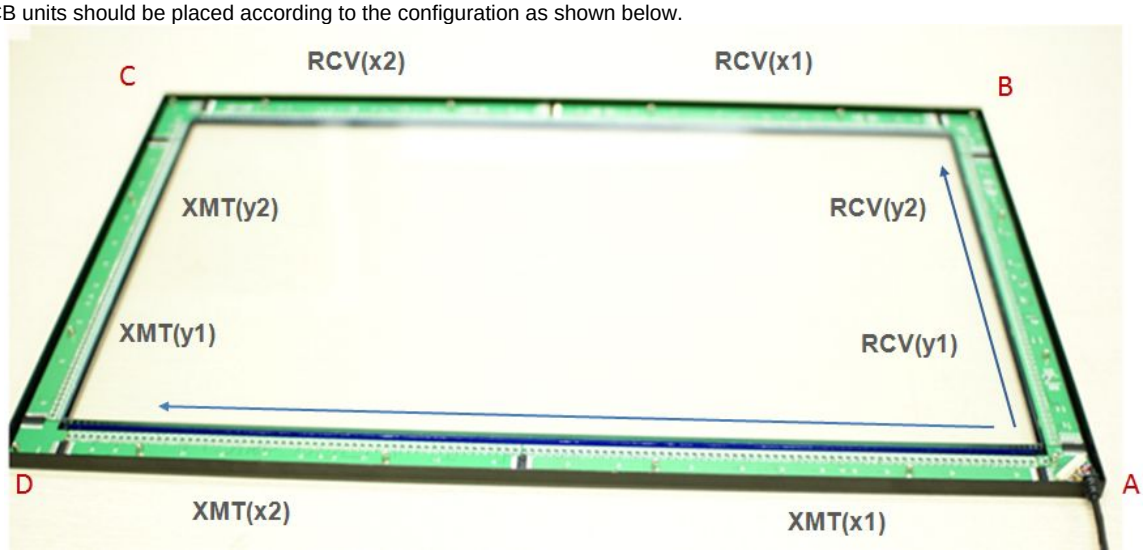
Start at lower left coner. Position the first module with component sides facing down.



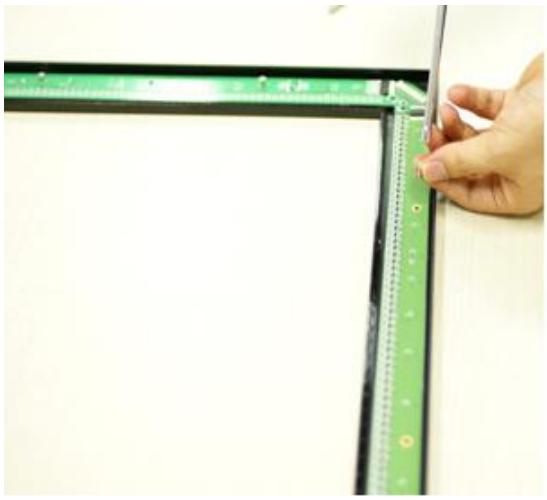
2c. Connect next module and position the PCB along the filter surface.

Proper placement of each PCB relative to one another is crucial. Follow the labels to position the PCB's correctly.

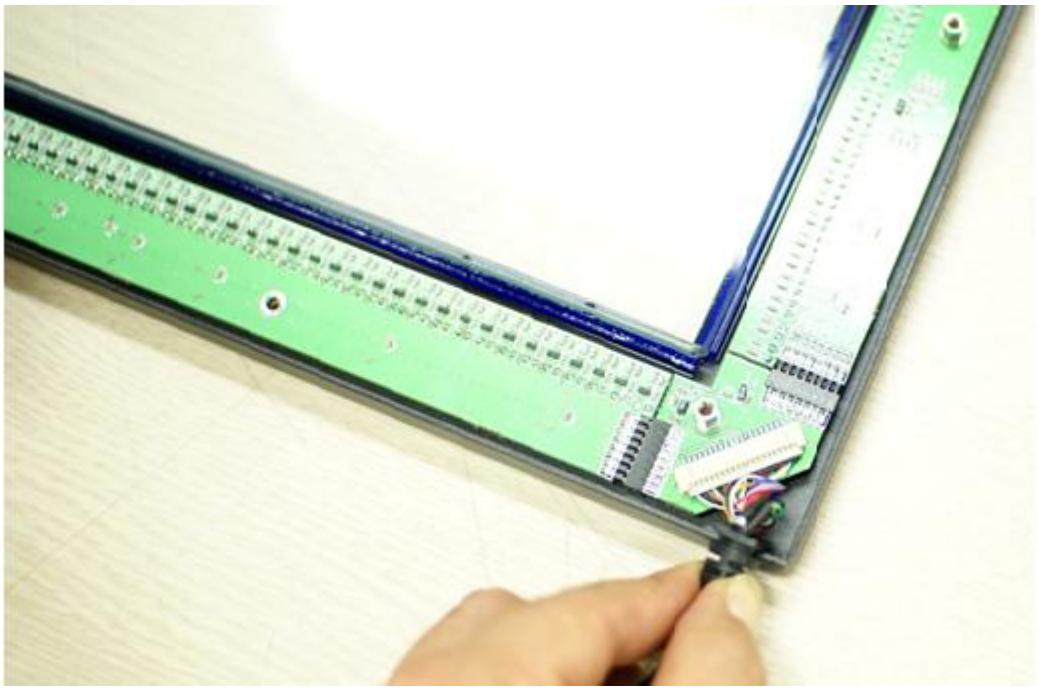
The PCB units should be placed according to the configuration as shown below.



2d. Fix PCB modules with M3 screws.



2e. Plug in cable.

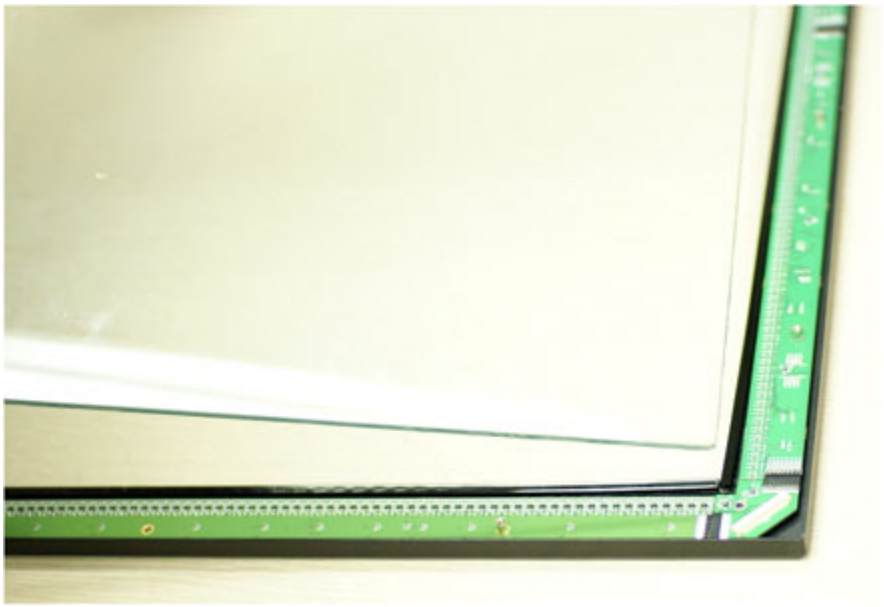


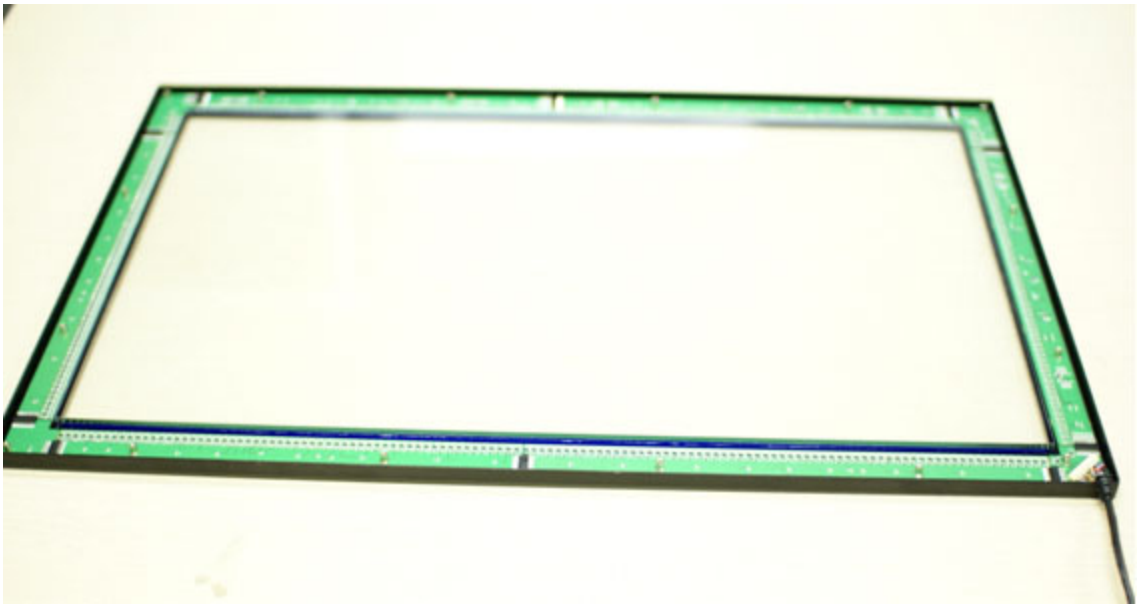
Step 3: Test PCB Function

Follow instructions provided in LED Testing Instruction to check proper function of LED and control elements.

Step 4: Install Glass Pane

The glass pane is secured by the back panel only – no adhesive or double-sided tape is applied here. *(This applies to standard units only)*.





Step 5: Attach Back Panel

This completes the assembly process.