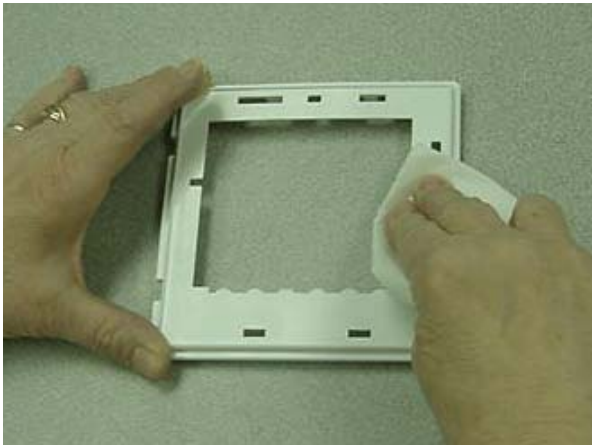


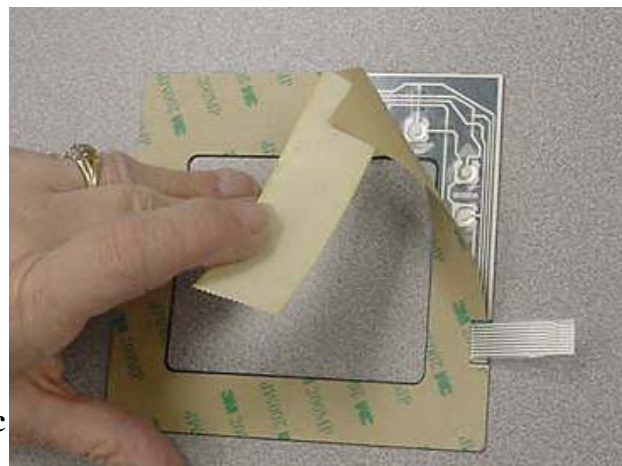
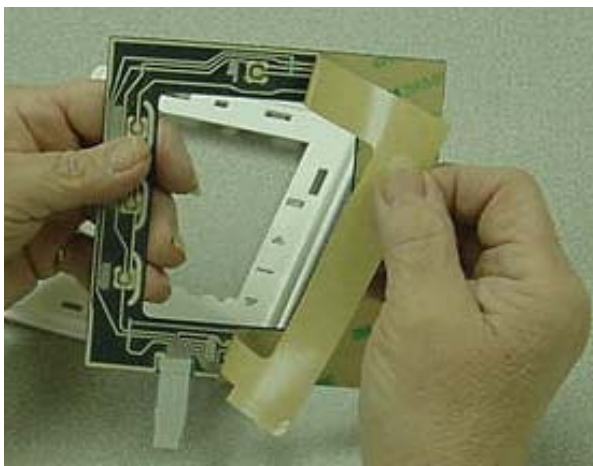
Applying Membrane Switch to Backing Panel

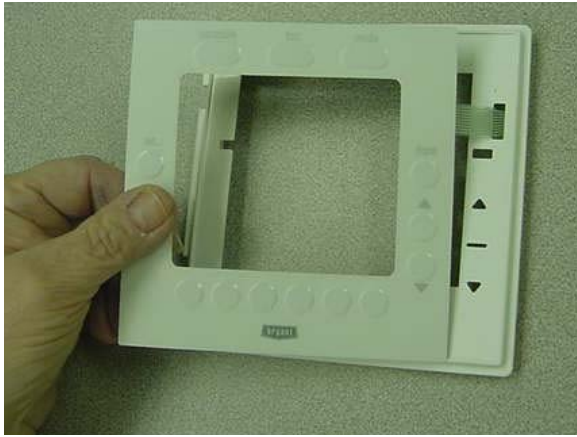
Purpose: This guide is to help customer to properly place membrane switches to its backing panel. It also defines proper handling of membrane.

1. Using A Tacky cloth with IPA alcohol clean the entire surface of plastic backer to remove any dirt or debris (As shown in picture). **CTQ: Debris on panel will cause a bump after membrane is assembled to backer.** After membrane is placed on backer and debris is found it cannot be removed without risk of damaging or bending the metal dome.

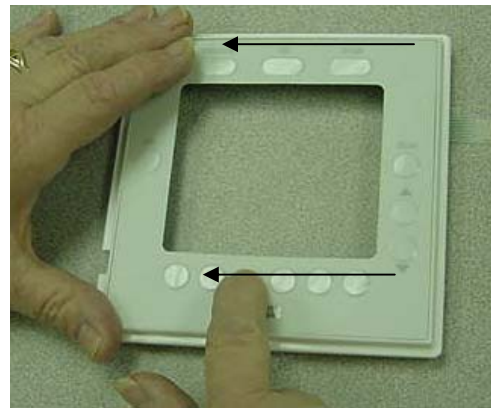
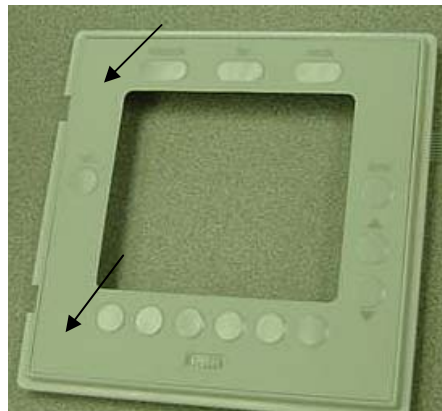
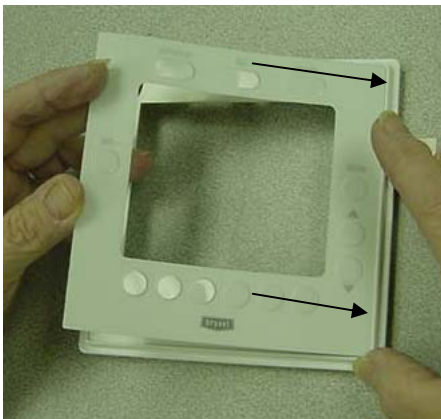


2. Remove adhesive liner from backside of membrane switch. When removing the adhesive liner do not bend the membrane switch. If removing liner is difficult for operator use a piece of tape to help operator grip liner for removal.



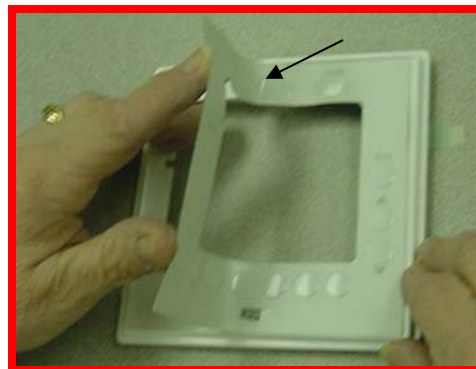
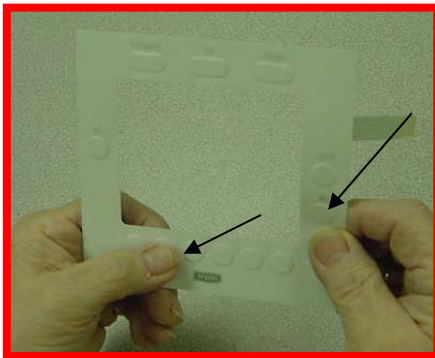


4. Edges align the membrane switch to the right side as shown. Then drop membrane into alignment. Then using your fingers from right to left laminate the switch to the panel. **CTQ: Do not bend membrane into place it will bend the domes and make the switch defective.**



Common Membrane Switch Handling Issues

Improper handling is the number one reason for switch failures.



Only press keypad on a flat surface.

If operator presses domes or key in the air like as the picture shows you risk bending the legs on the metal dome because not all-4 legs of dome are not on a flat surface. When Testing or activating keys, Always have keypad on solid surface.

Proper Assembly and Handling of Membrane Switch

Never bend a membrane switch as shown in picture.

If you place down in wrong position you need to make sure you do not bend switch during rework. If a metal dome leg is bent. The dome will oil -can and not properly snap back, this may occur on first attempt or shortly after. If Led is on part the bond can be damaged creating failure.

09/20/10

Prevent Creasing of Tail

Severe Creasing causing silver ink to crack, causing an open circuit or Keypad failure.

