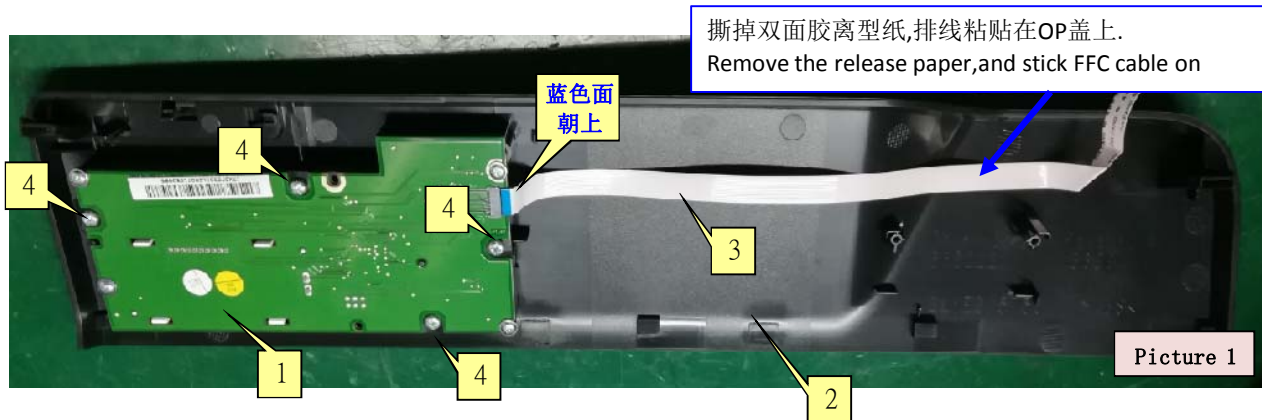
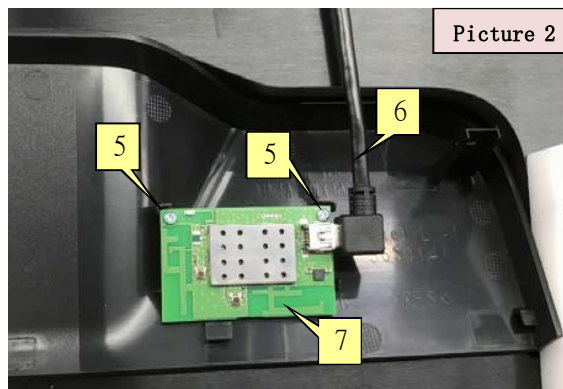


1. 取OP盖与OP按键模组组装在一起，用4颗螺丝<28-01427-00A>固定。
2. 取OP排线插入OP PCBA接头上。
1. Assembly <Cover,Op > on <Frame,Button OP>,use 4screw <28-01427-00A> fasten it (torque force: 4.0kfg.cm) as picture 1.
2. Insert FFC cable in OP PCBA connector as show picture 1.



Picture 1

- 3.取<无线网卡线>插到<无线网卡>上，再将<无线网卡>组装到OP盖上，用2颗螺丝(88B1301)固定。
- 3.Cable,wifi insert into Wireless Card,then assembly them on OP Cover, use 2 screw (88B1301)fix it.



Picture 2

4. 将保护膜贴于镜片上。



Picture 3

Model: 540A-LM OP
产品别: Gold-LM OP

Station:S16-3
作业别:OP3

Install Button
按键组装

36S2330



| 物料号码 | | 物料名称 | 数量 |
|------|--------------|---|-----|
| P/N | | Name & Description | Qty |
| 1 | 52-10129-00A | Assy,Operator Panel | 1 |
| | 36S2222 | OP按键模组 | |
| 2 | 54-16489-00A | Cover,OP | 1 |
| | 36S2221 | OP 盖 | |
| 3 | 23-01026-00A | FFC cable | 1 |
| | 36S5047 | OP 排线 | |
| 4 | 28-01427-00A | Screw,M3.0 x 1.50 x 8 | 4 |
| | 88B1313 | 螺丝 | |
| 5 | 28-01476-00A | Screw,M3.0 x 1.50 x 8 | 2 |
| | 88B1301 | 螺丝(用于无线网卡) | |
| 6 | 23-01069-00A | Cable,wifi 无线网卡线 | 1 |
| | 36S3417 | For(36SC120;36SC130 36SC220;36SC230) | |
| 7 | 33-00489-00A | 无线网卡 Wireless Card | 1 |
| | 27X1100 | For(36SC120;36SC130 36SC220;36SC230) | |

| Fixtures/Tools/Equipment | | Qty | Spec |
|--------------------------|-------------------------|-----|---------------|
| 1 | Screw driver | 1 | 4.0±0.5kgf/cm |
| 2 | 540A-L OP Cover fixture | 1 | |
| | | | |
| | | | |

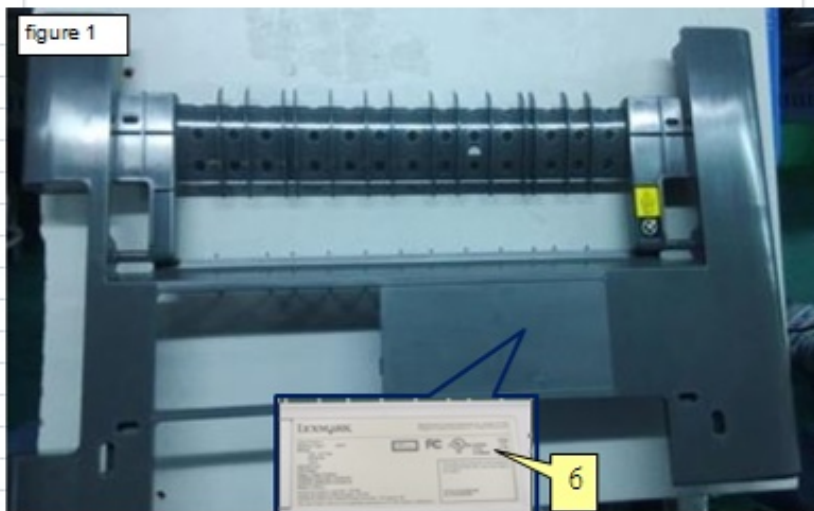
Operation Specs

| 版次 VER | 日期 DATE | 制作 PREPARE | MFG | QRA | ENG |
|-----------|------------|---------------|-----|-----|-----|
| | | | | | |
| | | | | | |
| | | | | | |

Revision:

1. 将内控标签扫入系统中,取安规标签贴附于标签后盖上,如图1所示.再将安规标签条扫入系统中,显示Pass为OK,如显示Fail,需与班长确认。

1.then paste Label Power Rating (6)to the cover rear as shown in Figure 1



2. 将后盖组装于机器上,取两枚28-01485-00A螺丝将其固定,如图3所示:

3. 取单一出纸板卡于后盖,卡勾要卡到位,如图4所示:

2. Mount Cover Rear Asm to Main assembly then fix it with 2 screw as shown in Figure 2.

3. Mount Cover Rear Exit Door (5) to assembly as shown in Figure 3.



28-01485-00A
torque force 2.75±0.5kgf.cm



Station: M26
作业别: A26

Assembly rear cover
组装后盖



| 物料号码 P/N | 物料名称 Name & Description | 数量 Qty |
|-------------|--|-----------|
| 4 | 28-01485-00A 88B1413 Screw 螺丝 | 2 |
| 5 | 54-16312-00A 36S2095 Cover Rear Exit Door 单一出纸板 | 1 |
| 6 | 36-04914-00B 35S2084 Label,Power Rating 安规标签 | 1 |

| Fixtures/Tools/Equipment | Qty | Spec |
|--------------------------|-----|----------------|
| 1 电动起子/screw drive | 1 | 2.75±0.5kgf.cm |
| 2 电脑/PC | 1 | |
| 3 扫描枪/Scan gun | 1 | |

| Operation Specs | | | | | |
|-----------------|--|--|--|--|--|
| | | | | | |

| 版本 VER | 日期 DATE | 制作 PREPARE | MFG | QRA | ENG |
|-----------|------------|---------------|-----|-----|-----|
| | | | | | |

Revision: