

CSI KEYBOARDS, INC.



CUSTOMER ASSEMBLY PROCEDURE FOR FLEXIBLE MEMBRANE KEYBOARDS

It should be noted in advance that great care is taken at CSI to protect any clear windows from scratches and blemishes. This care needs to be continued by the customer to insure acceptable parts. Flexible membrane keyboards which incorporate surface mounted LED's or Tactile Metal Domes must be handled carefully and NOT flexed, bent or rolled prior or during the application process. The metal domes and LED's are susceptible to varying degrees of damage when flexed, etc. If testing prior to assembly, the keypad MUST be placed flush on a flat surface so as not to overstress the domes. Once the keypad is laminated to the mounting surface the domes and LED's will not be damaged from normal use.

STEP 1

- Check your mounting surface for "bumps" or irregularities. Surface must be clean and flat. A tack cloth or lint free cloth and isopropyl alcohol are the proper tools for the cleaning process.

STEP 2

- Remove any separate release liner material that may be present in the flex-tail or shield tab areas and discard. Fold back approx. 1" of the main rear release liner (preferably at the tail exit side of the keypad, and not underneath any LED's or metal domes) exposing the pressure sensitive adhesive (PSA).
- Feed the tail through the tail(s) exit slot(s) and place the keyboard flat on the mounting surface. Align it within the center of the recess or to the edges of the backer plate.
- Apply pressure to the face of the keypad above the exposed PSA.

STEP 3

- Carefully reach underneath the keypad and begin pulling the release liner away from the adhered part of the keypad. While removing the liner with one hand, apply uniform pressure using a soft rubber roller. The roller should be used to assure complete bonding and to prevent air entrapment.

STEP 4

- Hold the assembled keypad on a 45 degree angle and reflect light off of the front surface. It should appear uniform, without bumps (air entrapment).

NOTE: If a keypad is misaligned or needs to be removed, the removal process will render the keypad unusable and should be discarded.

Please contact our service department if you require further assistance.