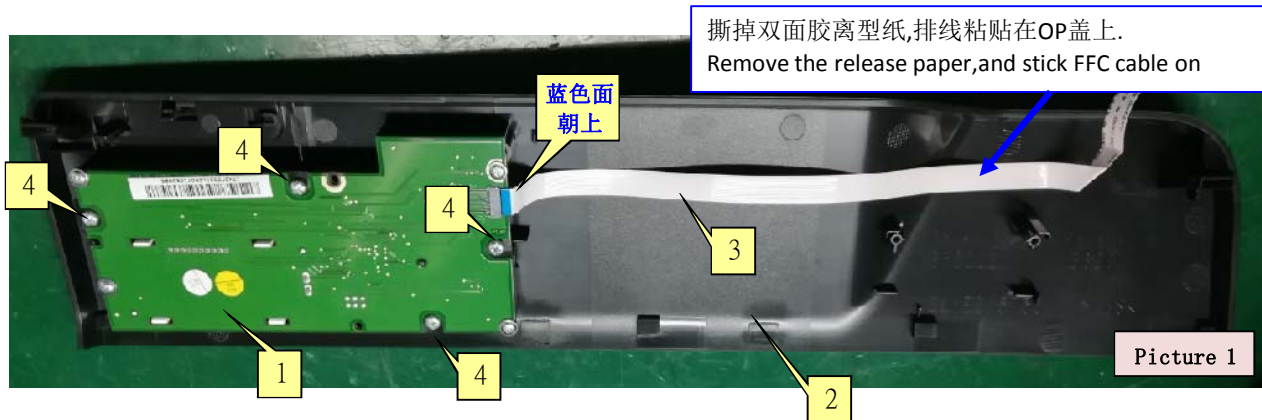
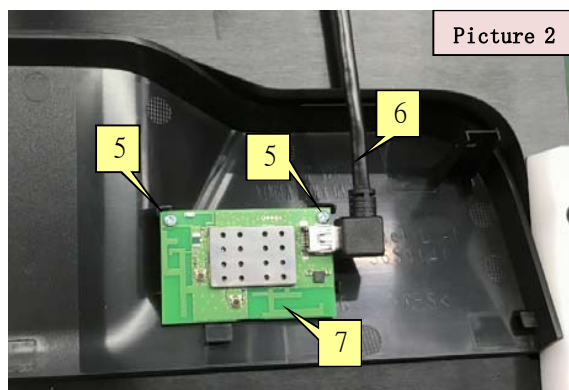


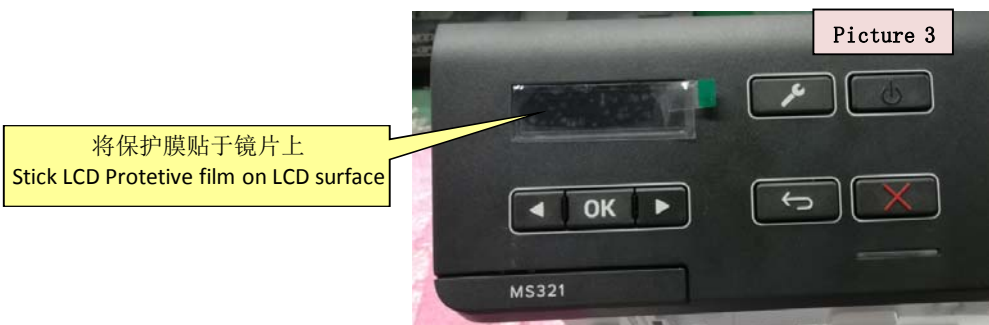
1. 取OP盖与OP按键模组组装在一起，用4颗螺丝<28-01427-00A>固定。
2. 取OP排线插入OP PCBA接头上。
1. Assembly <Cover,Op> on <Frame,Button OP>,use 4screw <28-01427-00A> fasten it (torque force: 4.0kfg.cm) as picture 1.
2. Insert FFC cable in OP PCBA connector as show picture 1.



- 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.



4. 将保护膜贴于镜片上。

Model: 540A-LM OP
产品别: Gold-LM OPStation:S16-3
作业别:OP3Install Button
按键组装

36S2330



物料号码 P/N		物料名称 Name & Description	数量 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:

Model:

产品别:

540A-L/M/H1 Main line

Gold-L/M/H1 Main line

Station: M26

作业别: A26

Assembly rear cover

组装后盖



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



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: