

# MEMBRANE SWITCH APPLICATION PROCEDURE



## CROSS SECTION OF APPLICATION PROCESS FOR MEMBRANE SWITCH ASSEMBLIES

### STEP 1

Very carefully cut and remove 1/8" of adhesive liner on the bottom side of the membrane switch (Fig.1).

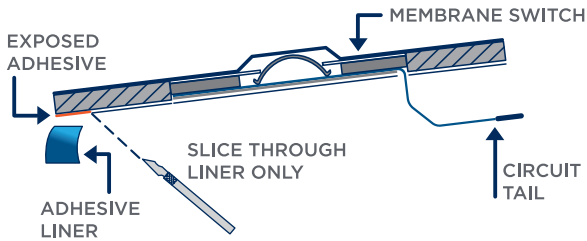


Fig. 1

### STEP 2

Turn the membrane switch over and pass the flex cable through the tail exit slot of the unit the switch will be mounted to. With precision, position the membrane on the back support recess and adhere the membrane switch to the surface of the unit with the exposed adhesive (Fig.2).

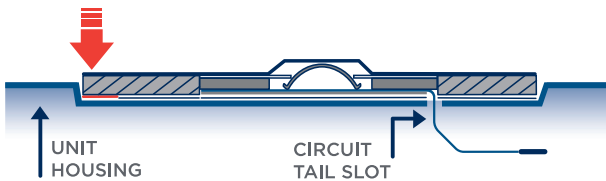


Fig. 2

### STEP 3

(Fig.3) Position the membrane with an angle around 30 degrees, peel off the rest of the adhesive liner keeping the set up the same as before.

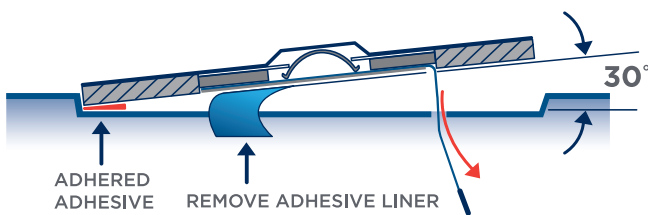


Fig. 3

### STEP 4

Gently laminate the membrane switch starting from the side with the removed adhesive liner, using a soft roller, apply slight pressure as rolled across the top surface of the membrane switch (Fig.4).

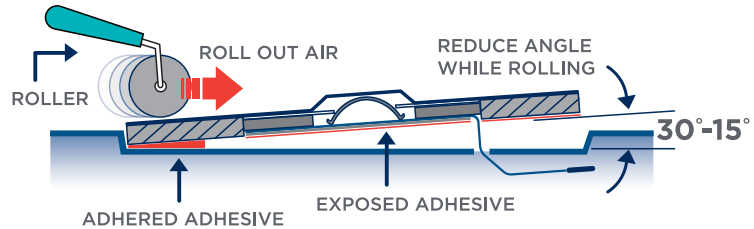


Fig. 4

### STEP 5

Lower the angle of the membrane switch gradually (Fig.5) until the lamination is completed (Fig.6). You can bend the circuit slightly without damaging the switches but use extreme caution so that the metal domes/buttons are not inverted then becoming non-functional.

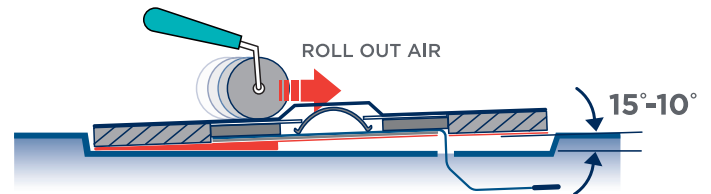


Fig. 5

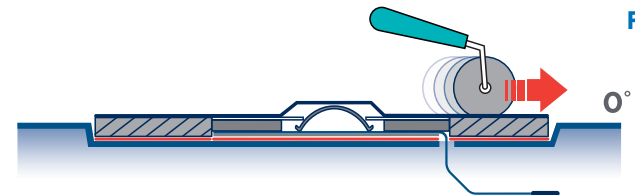


Fig. 6

**CAUTION: DO NOT BEND THE CIRCUIT AND/OR DOMES.**

It's important to keep a minimal angle in front of the roller to complete the lamination and to also keep air bubbles from forming in-between layers.

### ! IMPORTANT:

Once in place the membrane switch should not be lifted or repositioned! The domes may invert rendering the part non-functional. \*\*\*Inverted domes are not a manufacturer warranty item\*\*\*

### ! IMPORTANT:

When positioning the flex tail for the final electrical connection, it is very important to not crease the cable. This could change the resistance or in worse case the electrical contact will be broken.



**WHEN BENDING THE CABLE THE MINIMUM RADIUS WILL BE 0.150".**

