

Replacement of 2400 Keyboard Membrane

- 1 Switch off the converter and wait 5 minutes before you remove any covers / panels to replace the Capacitor Board.



Warning!

Capacitors remain charged to dangerous voltages.
Discharge time: 5 minutes



Notice!

To prevent PCB damage from electrostatic discharge, wear ESD wrist strap when servicing.

Caution!

Check that DC Voltage on the DC-Busbar, has discharged before proceeding.

- 2 Remove the display module. Refer to display replacement procedure for more details.

- 3 Gently remove the existing keyboard membrane. Use an electric heat gun to heat up the glue, if the existing membrane is sticking.

Avoid use of mechanical tools, as they might damage the GPU door.

Clean the area with isopropyl alcohol or other non-damaging cleaning agent. Observe local rules and regulation and personal safety when working with cleaning detergents.

- 4 Remove the adhesive covers on the back of the new keyboard membrane.

Ensure that the flat ribbon cable is free from the adhesive.



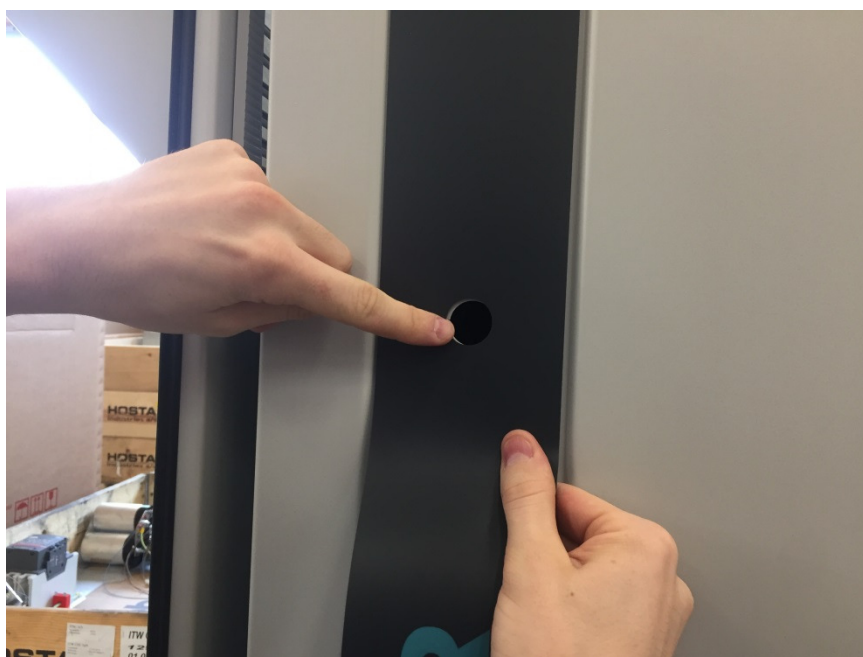
- 5 Insert the flat ribbon cable in the vertical hole in the door, as shown below.



- 6 Align the membrane approx. 1mm from the top. Check from the inside that the LCD screen and LEDs are centered.



- 7 Align the hole for the emergency stop pushbutton.



8 Align the lower part of the membrane. Attach the rest of the membrane.



9 Re-install the display. The unit is now ready for operation