

External Dome Lens Installation Guide – D-Series External 7.5” Dome

Recommendations:

- Wear nitrile gloves, for steps requiring handling contact surfaces for adhesion.
- Use a clean installation space, dedicated to seal installations only.
- Use a clean set of cloths for all cleaning steps, with maximum use of 15 installs.



Procedure:

1. Prepare the surface of the **plastic rim** in the D-Series housing and the **flange** in the optical dome lens by sanding with a 220-grit sandpaper.
 - A. Use 3 or 4 light passes with medium pressure.



2. Remove the plastic residue, created from the sanding, with a dust blower.
 - A. Do not blow the particles into the working station to avoid future contamination.



3. Clean the installation surfaces (plastic rim and flange) using alcohol and cloths.

A. Damp a cloth with alcohol solution and clean the surfaces thoroughly.



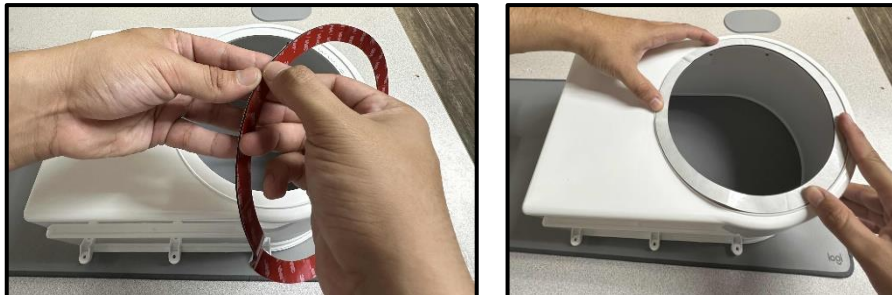
B. Follow with a dry cloth to remove excess alcohol left.



C. Set aside for 5 minutes before continuing installation.

4. Install the **VHB lens seal** and **dome lens**.

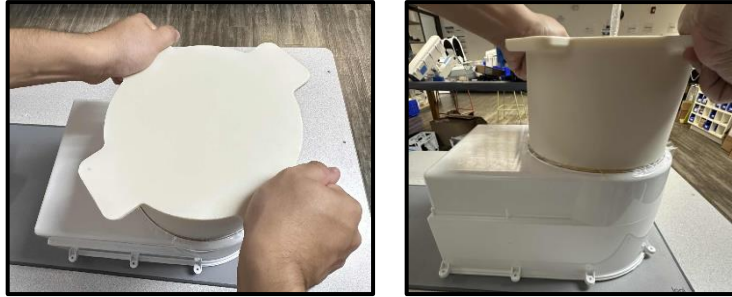
A. Peel off the red liner to expose the adhesive in the VHB seal and press this side into the plastic rim of the D-Series housing.



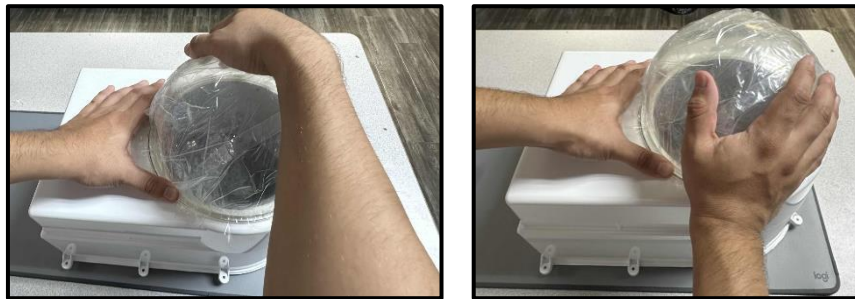
B. Remove the white liner in the VHB seal to expose the adhesive and press the dome lens into it. Remember to maintain proper center alignment while installing the dome lens.



5. Provide proper pressure to all bonding surfaces to completely bond the parts.
- A. Take the “**Press Tool**” over the dome lens (avoid scratching contact with the dome lens) until the tool contacts the flange appropriately.



- B. Apply strong pressure on the tool with your bodyweight for at least 5 seconds in each of the two perpendicular directions available by the handles.
6. Let the housing aside for at least 24 hours before proceeding with **QC** checks.
- A. After resting period, verify the adhesion of the seal by pushing the sides of the dome lens.



- B. If properly bonded, the dome lens should not have any movement nor visible air gaps between the VHB seal and the lens flange.

Replacement Lens: For any orders for dome lens replacements, prepare the surface of the lens (flange) as described in steps 1 through 3.

- The VHB seal will get attached to the lens on the white liner side, leaving the red liner on the seal for shipping (to keep the integrity of the seal during shipping).



- This install also requires proper seal press with the “Press Tool” which can be accomplished on a strong surface or directly on top of a D-series housing for proper holding.

***All orders for lens replacement should include a printed copy of the manual for installation (KT-CLNS-ETX75_D-Series Externally Mounted Dome – Installation Guide for KT-CLNS-EXT)**