IOLINE™

14140 NE 200th ST. • Woodinville, WA. 98072 • PH: (425) 398-8282 • FX: (425) 398-8383

Procedure: Keypad replacement for the Ioline FlexJet
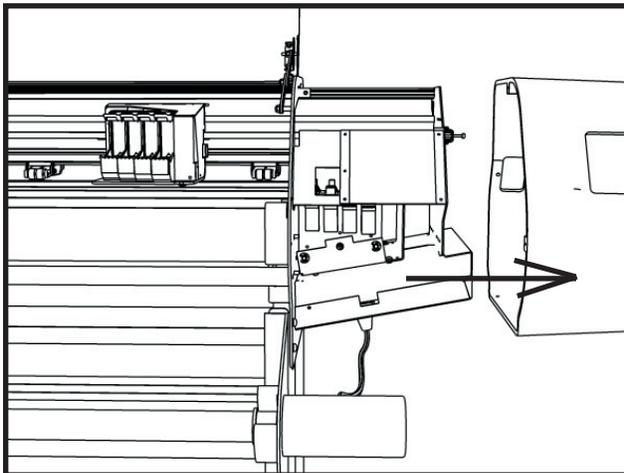
Tools Required:
Phillips screwdriver

ATTENTION

OBSERVE PRECAUTIONS
FOR HANDLING
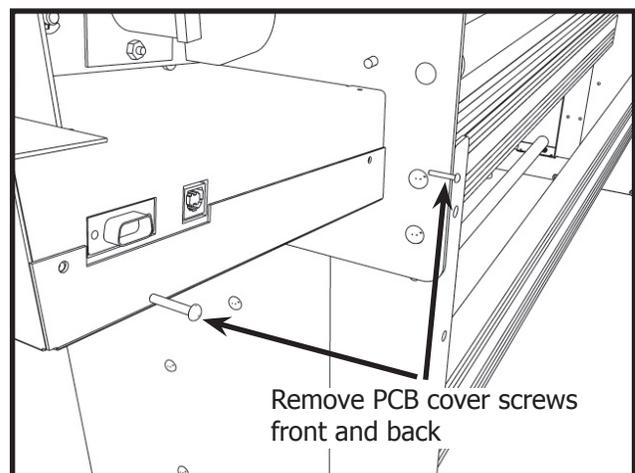**ELECTROSTATIC
SENSITIVE DEVICES**

Notices:
Attention! *The discharge of static electricity may damage the keypad and components. Use the included ground strap during all procedures. Keep plastic objects away from the keypad and logic board assemblies.*

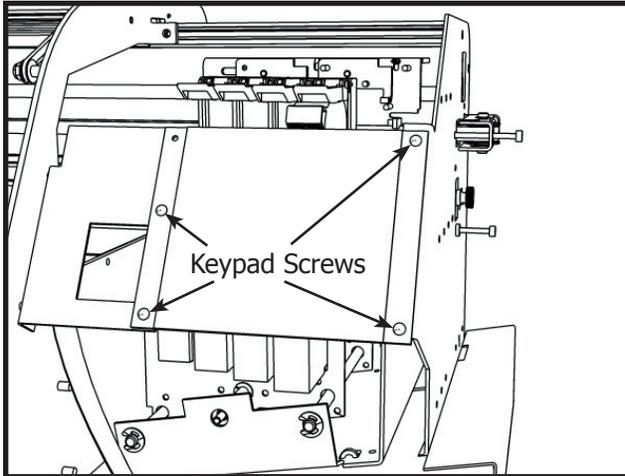---

1 Removing the end cover

A) Turn the FlexJet off and un-plug the power cord from the back of the machine.
B) Unplug the roll feed motor under the right end cover.
C) Remove the 5 screws that hold the plastic end cover on to the right end of the printer. There are two on the flat surface of the endplate, one screw in the back, and 2 screws on the bottom.
D) Pull the cover to the right and off the machine then set it aside.

2 Removing the PCB Cover

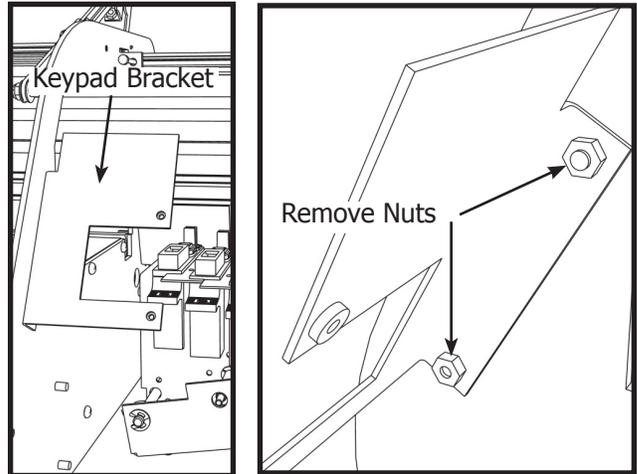Remove PCB cover screws front and back

A) Remove the 4 screws that attach the bottom 'PCB Cover' on the right side of the machine

B) Unplug the old keypad from the logic board.

C) Leave the bottom cover off for now.
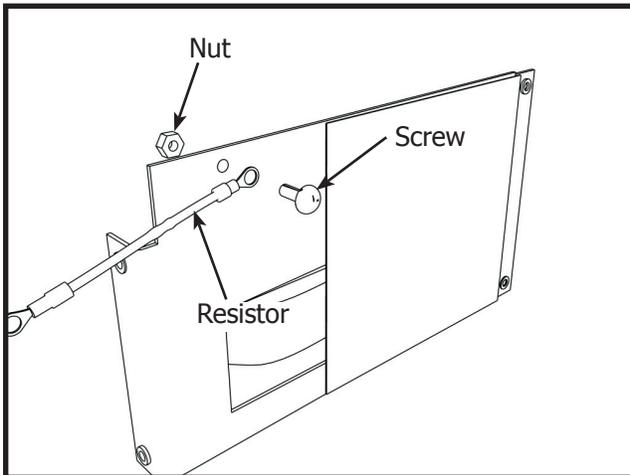
③ Removing the old keypad.

Keypad Screws

A) Remove the (4) four black phillips screws from the keypad and remove the keypad from the machine.
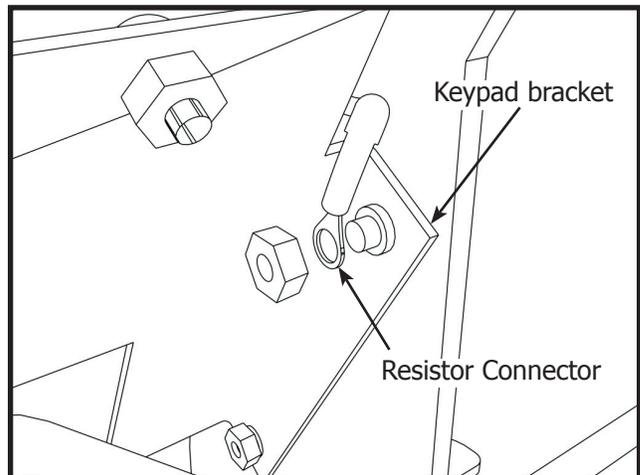
④ Removing the old keypad bracket.

Keypad Bracket

Remove Nuts

A) Remove the old keypad bracket by removing the nuts on the back side of the bracket.

⑤ Installing the keypad resistor

Nut

Screw

Resistor

A) Install the resistor to the new keypad by putting the bolt through the end of the resistor, then put the bolt through the hole in the keypad. Secure the bolt on the back of the keypad with the nut provided but don't fully tighten the nut yet. Leave the resistor loose for now.

⑥ Installing the keypad.

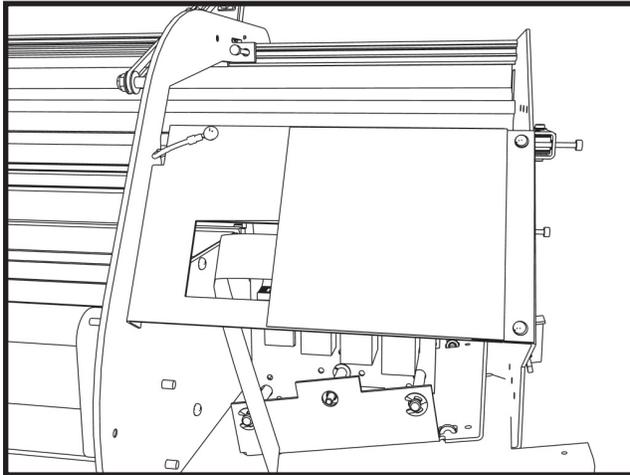Keypad bracket

Resistor Connector

A) Bend the resistor around the front of the keypad and attach the other end of the resistor to the top keypad stud (on the back of the new keypad).

Note: DO NOT overtighten the resistor nuts. The resistor connector MUST NOT come into contact with the metal keypad bracket on the back.

B) Tighten the resistor bolt on the front of the keypad. Again, DO NOT over-tighten.

(7) **Final**

A) Plug in the keypad cable to the PCB connector. Make sure you get 'Pin 1' plugged in to the correct pin on the board.

Note: Make sure you don't miss a row of pins on the board connector. Missing a row of pins may cause un-repairable damage to the main logic board.

B) When you think all the connections are correct plug in and power on the FlexJet to make sure it operates properly.

C) When the machine is back to normal operation install all the covers on the machine.

Note: When installing the PCB cover on the bottom, make sure the keypad cable doesn't get pinched between the cover and the body.

D) Contact Ioline Tech Support if problems arise.