



SMARTring Rework Instruction

**Subject: SMARTring Sensor Module
Flap to Sensor Module Adhesion
Repair Procedure**

RI00014 | Rev: 01

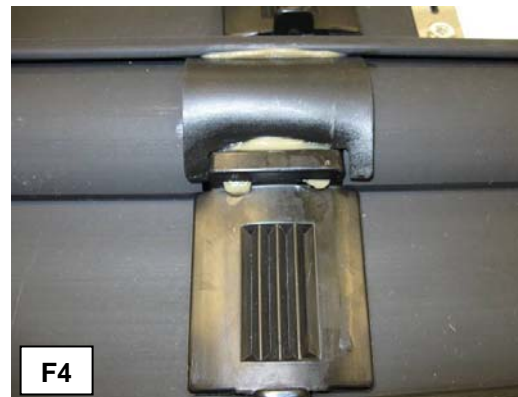
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Purpose:

The purpose of this document is to provide a rework procedure for re-attaching the sensor module flap to the sensor module.

Procedure:

1. Clean remaining dried glue off of flap. (See F1)
2. Apply Chemlok (CiDRA P/N 52536-02) primer to BOTH sides of flap and to BOTH tab channels on sensor module. Allow primer to dry for 30 minutes. (See F2)
3. Apply urethane adhesive (CiDRA P/N 52666-01) to BOTH tab channels on sensor module. (See F3)
4. Install flap into sensor module as shown and push module into band cutout to hold in place. Allow to dry for 2 hours before handling and 24 hours for full cure. (See F4)



Contact Customer Support with any questions or comments.

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Document Change History

Date	Revision	Changed By	ECO #	Description of Change
09/08/11	01	J. Cipriano	E11-0078	Initial Release