



Shenzhen KTC Technology Group
Shenzhen KTC Technology Co., Ltd.

Operation Instructions

Product Name: 39L61B

Prepared by: **Zhou Yongli**

Examined by: _____

Approved by: _____

Date: 2014-5-19

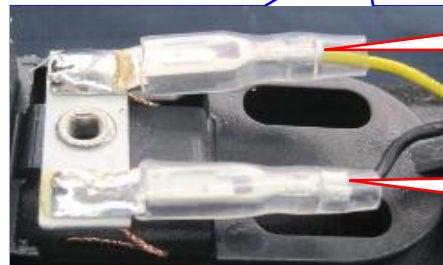
Station Name		Speaker Processing		Model	39L61B	Section/Serial No.	Preprocessing 01	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19
NO	Part Number	Amount	Descriptions	Operations and Requirements				Diagram	Tool Parameters		
1	7711-22858A-50000011	2	8Ω 10W speaker	Insert yellow/black speaker wire to the speaker properly.				Figure 1			
2	6149-200045-02101201	1	200mm 2Pin yellow/black speaker wire	Insert red/black speaker wire to the speaker properly.				Figure 2			
3	6149-650045-03101101	1	650mm 3pin red/black speaker wire	When finished, step on the switch with your foot to send the product to next station.							
4			Specific subject in accordance with work order								
5											
Notice	1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> .										

Figure:

Figure 1



Figure 2



Insert yellow wire to wide terminal.

Insert black wire to narrow terminal.

Note: Photos are for reference only, specific in kind prevail

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			Yongli Zhou			

KTC® Operating Instructions
Kangnan viewTech Center

Station Name		Back Cover Processing-1		Model	39L61B	Section/Serial No.	Preprocessing 02	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19
NO	Part Number	Amount	Descriptions	Operations and Requirements				Diagram	Tool Parameters		
1	7002-39L61B-14B00003	1	39L61B black back cover	Take the back cover and tear off packing bag, then check if it looks fine.				Figure 1			
2			Specific subject in accordance with work order	When finished, step on the switch with your foot to send the product to next station.							
3											
4											
5											
Notice		1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> .								2	
Figure:		Figure 1 									
								Note: Photos are for reference only, specific in kind prevail			
Recent Modification Record				Please read and understand the operating instructions carefully		Prepared by	Reviewed by	Approved by	Project Controlled Seal		
						Yongli Zhou					

Station Name		Back Cover Processing-2		Model	39L61B	Section/Serial No.	Preprocessing 03	Document No.		Version	
		Panel	K390WD6-UB300	Effective from	2014-5-19			Date Updated	2014-5-19		

NO	Part Number	Amount	Descriptions	Operations and Requirements	Diagram	Tool Parameters
1	7030-420L31-4U711101	1	42L31 black button array	Fit the button array to back cover properly.	Figure 1	
2		2	Processed 8Ω 10W speaker	Fit two speakers to back cover as illustrated.	Figure 1	
3			Specific subject in accordance with work order	When finished, step on the switch with your foot to send the product to next station.		
4						
5						

Notice	1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i>.		3
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Figure: Figure 1

Note: Photos are for reference only, specific in kind prevail

Fit button array to the slot of back cover.

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Station Name		Back Cover Processing-3		Model 39L61B	Section/Serial No.	Preprocessing 04	Document No.	Version
		Panel K390WD6-UB300					Effective from 2014-5-19	Date Updated 2014-5-19

NO	Part Number	Amount	Descriptions	Operations and Requirements	Diagram	Tool Parameters
1	7B11-041082-30105113	4	Φ4×10mm round-head(Φ14-Φ15) flat-tail black-zinc-plated tapping screws with flat washers	Fasten speakers to back cover with 4PCS screws.	Figure 1	Electric screwdriver
2				When finished, step on the switch with your foot to send the product to next station.		5±1kgfcm
3						
4						
5						

Notice

1. Wastes produced by this station shall be placed in the assigned position. Refer to *Waste Classification and Disposal List* .

2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.

4

Figure:

Figure 1

Process Requirements:

1. Check for rusted screws, missing slots or bad cross slot.
2. Check if the electric screwdriver torque force is within the specified requirements.
3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
5. Put the defective screws in the defective product box and do not throw them at will.

Note: Photos are for reference only, specific in kind prevail

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Recent Modification Record		Please read and understand the operating instructions carefully	Take only one screw at a time	Prepared by Yongli Zhou	Reviewed by	Approved by
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Station Name		Back Cover Processing-4		Model	39L61B	Section/Serial No.	Preprocessing 05	Document No.		Version	
		Panel	K390WD6-UB300	Effective from	2014-5-19			Date Updated	2014-5-19		

NO	Part Number	Amount	Descriptions	Operations and Requirements	Diagram	Tool Parameters
1	7912-712500-020R1311	4	Viscose paper(50mm)	Fix speaker wires to back cover with 4PCS viscose paper.	Figure 1 	Tape dispenser
2				When finished, step on the switch with your foot to send the product to next station.		
3						
4						
5						

Notice

1. Wastes produced by this station shall be placed in the assigned position. Refer to *Waste Classification and Disposal List* .

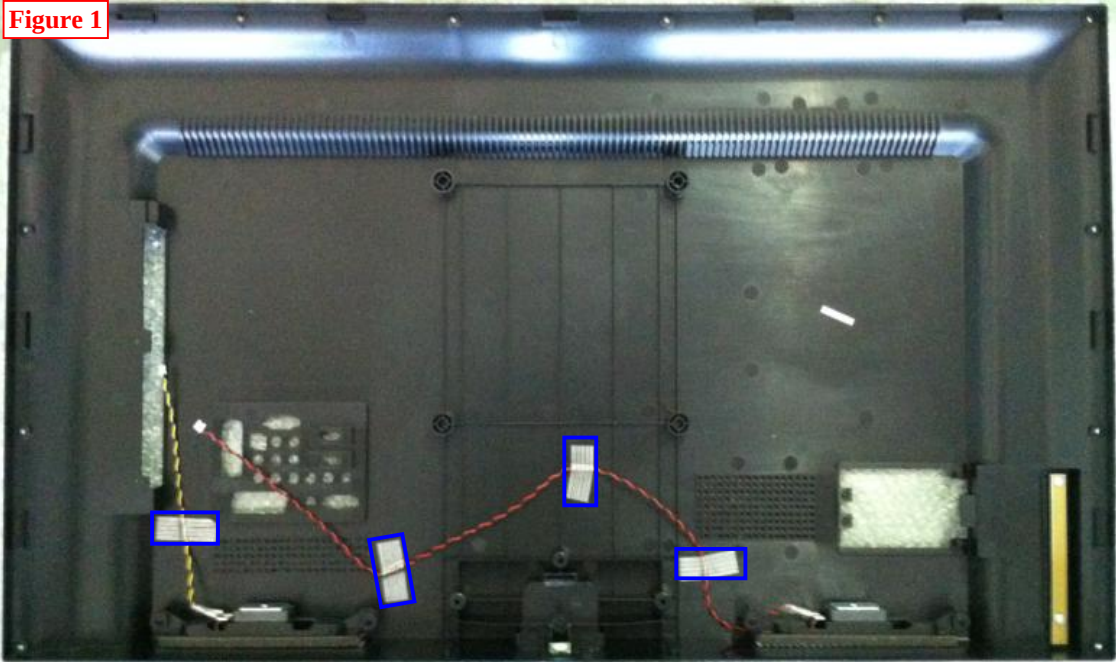


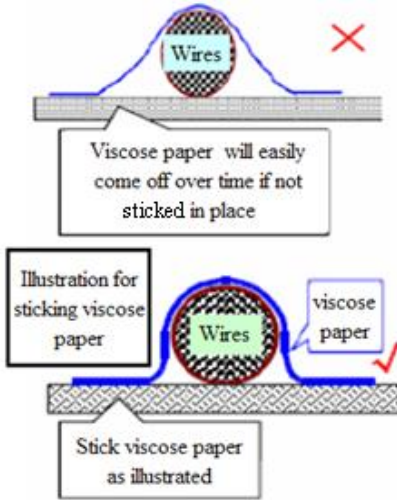
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Figure:

Note: Photos are for reference only, specific in kind prevail

Figure 1



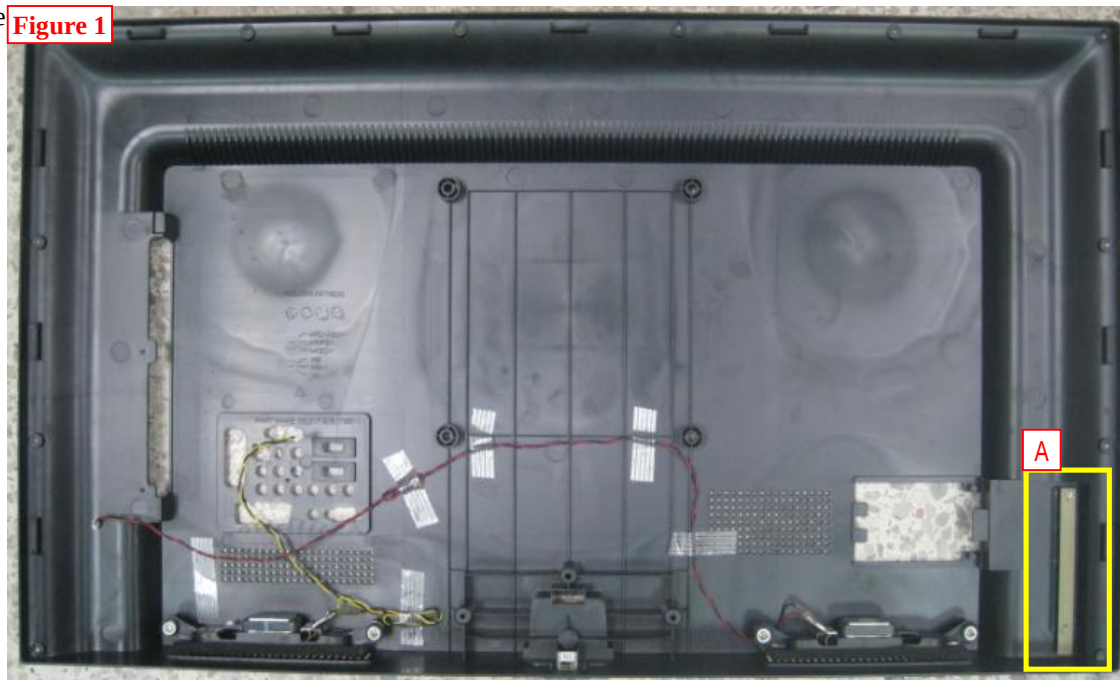


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Recent Modification Record		Please read and understand the operating instructions carefully	Prepared by	Reviewed by	Approved by
			Yongli Zhou		

Station Name		Back Cover Processing-5		Model	39L61B	Section/Serial No.	Preprocessing 06	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19
NO	Part Number	Amount	Descriptions			Operations and Requirements			Diagram	Tool Parameters	
1	9014-112L31-00001011	1	32-42L31 key board assembly A2			Fit key board assmebly to back cover properly.			Figure 1	Electric screwdriver	
2	7B11-0306D4-30102111	2	Φ3×6mm round-head flat-tail white-zinc-plated tapping screws with flat washers			Fasten key board to back cover with two screws.			Figure 1/A 	3±0.5kgfcm	
3						When finished, step on the switch with your foot to send the product to next station.					
4											
5			Note: Photos are for reference only, specific in kind prevail								
Notice		1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> .									
		2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.									

Figure **Figure 1**

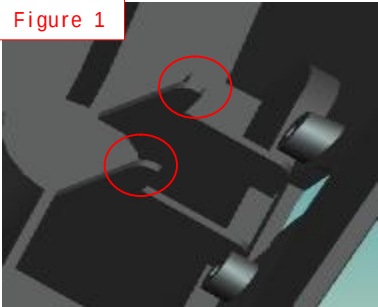
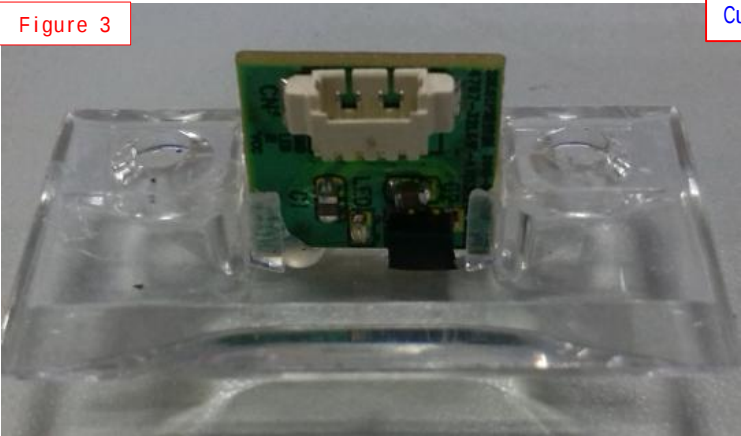


Process Requirements:

1. Check for rusted screws, missing slots or bad cross slot.
2. Check if the electric screwdriver torque force is within the specified requirements.
3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
5. Put the defective screws in the defective product box and do not throw them at will.

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Recent Modification Record		Please read and understand the operating instructions carefully	Take only one screw at a time	Prepared by	Reviewed by	Approved by
				Yongli Zhou		

Station Name		Back Cover Processing-6		Model	39L61B	Section/Serial No.	Preprocessing 07	Document No.	ITBI0107	Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19
NO	Part Number	Amount	Descriptions	Operations and Requirements				Diagram	Tool Parameters		
1			Processed back cover	Cut the rib on back cover as illustrated.				Figure 1	Scissors		
2	7034-32L61F-400ESA03	1	32L61F remote control receiver window	Spread glue on the position of back of remote control receiver window.				Figure 2	Glue gun		
3	9015-112L61-61041011	1	32 above L61F remote control receiver board(blue)	Fit the remote control receiver board to remote control receiver window before the glue clotting.				Figure 3			
			Specific subject in accordance with work order								
Notice		1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> .								7	
		2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.									
Figure 1  Figure 2  Figure 3  Cut the rib as illustrated. Do not exceed the edge of remote control receiver window and do not spread on front side of remote control receiver board. Fit the remote control receiver board to remote control receiver window. Note: Photos are for reference only, specific in kind prevail  ok  NG											
Recent Modification Record		Please read and understand the operating instructions carefully				Prepared by	Reviewed by	Approved by	Project Controlled Seal		
						Yongli Zhou					

Station Name		Back Cover Processing-8		Model	39L61B	Section/Serial No.	Preprocessing 08	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19
NO	Part Number	Amount	Descriptions			Operations and Requirements			Diagram	Tool Parameters	
1		1	Back interface adhesive film of T9 mainboard			Stick 1PCS back interface adhesive film on back cover as illustrated.			Figure 1 		
2		1	Side interface adhesive film of T9 mainboard			Stick 1PCS side interface adhesive film on back cover as illustrated.			Figure 1 		
3		1	Key film			Stick 1PCS Key film on back cover as illustrated.					
4		1	Rear nameplate			Stick 1PCS rear nameplate on back cover as illustrated.			Figure 1 		
	carved aluminum and energy efficiency standard according to customer requirements to past					When finished, step on the switch with your foot to send the product to next station.					
			Specific subject in accordance with work order								
Notice	1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> .										

Figure:

Figure 1



Note: Photos are for reference only, specific in kind prevail

Side interface adhesive film of T9 mainboard

Back interface adhesive film of T9 mainboard

Rear nameplate

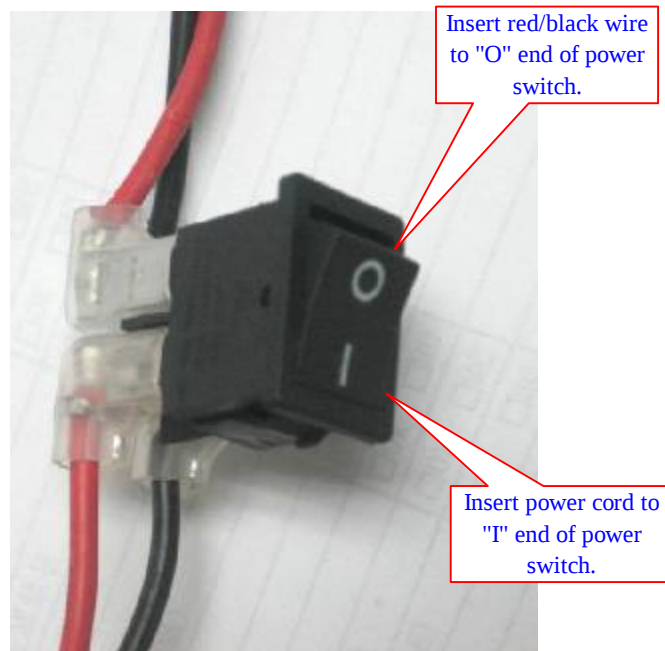
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Recent Modification Record	Please read and understand the operating instructions carefully				Prepared by	Reviewed by	Approved by
					Yongli Zhou		

Station Name		Power Cord Processing		Model	39L61B	Section/Serial No.	Preprocessing 9	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19
NO	Part Number	Amount	Descriptions		Operations and Requirements				Diagram	Tool Parameters	
1	6110-151632-07461701	1	1.5M+0.16M power cord		Insert red/black wire and power cord to the socket of power switch correspondingly.				Figure 1		
2	6264-250008-13210001	1	TV-5 8/128A 250VAG 4pin power switch		When finished, step on the switch with your foot to send the product to next station.						
3	6149-120056-03201101	1	120mm 2pin red/black wire								
4			Specific subject in accordance with work order								
5											
Notice		1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> .									
		2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.									

Figure:

Figure 1



Note: Photos are for reference only, specific in kind prevail

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Recent
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Please read and understand the operating instructions carefully

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Yongli Zhou

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Station Name		Base Processing		Model	39L61B	Section/Serial No.	Preprocessing 10	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19
NO	Part Number	Amount	Descriptions	Operations and Requirements				Diagram	Tool Parameters		
1	7003-37L31D-1U700001	1	37L31D glossy black base(ellipse)	Take the base and check if it looks fine.				Figure 1			
2	7912-223020-0002R521	8	Φ20.0*2.5mm rubber pad(with 3M gummed paper)	Stick 8PCS rubber pad on the base as illustrated.				Figure 1 			
3											
4											
5											
Notice	1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> .										

Figure:

Figure 1



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Recent
Modification
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Please read and understand the
operating instructions carefully

Prepared by

Yongli Zhou

Reviewed by

Approved by

Station Name	Display Screen Placement		Model	39L61B	Section/Serial No.	Unit Assembly 01	Document No.		Version	
			Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19

NO	Part Number	Amount	Descriptions	Operations and Requirements	Diagram	Tool Parameters
1	7422-390AUK-383A0031-F	1	39" K390WD6-UB300 panel(Specific subject in accordance with work order)	Clean power cord、base on the board, put the cushion.	Figure 1	
				Remove its protective package and check if it looks fine.	Figure 1	
				Put the panel on assembly board with display surface facing downwards properly.	Figure 1	
				When finished, step on the switch with your foot to send the product to next station.		

Notice

1. Wastes produced by this station shall be placed in the assigned position. Refer to *Waste Classification and Disposal List*.
2. Hand it with care and be careful to operate to avoid scratch. Please hold the metallic frame of screen and do not touch or crush display screen.
3. Take proper anti-static precautions, such as wearing anti-static gloves.

1

Figure 1

Figure 2

Process Requirements in Screen Operations:

1. When taking the screen, hold its metallic frame and do not touch the display screen by any part of your body.
2. Check if the screen is scratched /dirty/cracked.
3. You are required to wear anti-static clothes and gloves during operating, to avoid damaging the screen by static.

Note: Photos are for reference only, specific in kind prevail

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Recent Modification Record		Please read and understand the operating instructions carefully	Prepared by	Reviewed by	Approved by
			Yongli Zhou		

Station Name		Fixed Pillar for Mainboard Locking		Model	39L61B	Section/Serial No.	Unit Assembly 02	Document No.		Version	
		Panel	K390WD6-UB300					Effective from	2014-5-19	Date Updated	2014-5-19

NO	Part Number	Amount	Descriptions	Operations and Requirements	Diagram	Tool Parameters
1	7B11-0302F0-00102111	4	Φ3×2.5×6mm hexagonal screws	Fasten 4PCS hexagonal screws to panel back with electric screwdriver.	Figure 1	Electric screwdriver
2			Specific subject in accordance with work order	When finished, step on the switch with your foot to send the product to next station.		4±1kgfcm
3						
4						
5						

Note: Photos are for reference only, specific in kind prevail

Notice	1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> .		 	2
	2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.			

Figure:

Figure 1

Process Requirements:

1. Check for rusted screws, missing slots or bad cross slot.
2. Check if the electric screwdriver torque force is within the specified requirements.
3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
5. Put the defective screws in the defective product box and do not throw them at will.

Recent Modification Record		Please read and understand the operating instructions carefully	Take only one screw at a time	Prepared by	Reviewed by	Approved by	Project Controlled Seal
				Yongli Zhou			

Station Name		Fixed Pillar for Power Board Locking		Model	39L61B	Section/Serial No.	Unit Assembly 03	Document No.		Version	
		Panel	K390WD6-UB300					Effective from	2014-5-19	Date Updated	2014-5-19

NO	Part Number	Amount	Descriptions	Operations and Requirements	Diagram	Tool Parameters
1	7B11-0303F1-00102121	4	Φ3×3×8mm hexagonal screws	Fasten 4PCS hexagonal screws to panel back with electric screwdriver.	Figure 1 ○	Electric screwdriver
2				When finished, step on the switch with your foot to send the product to next station.		4±1kgfcm
3						
4						
5						

Note: Photos are for reference only, specific in kind prevail

Notice	1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> .				3
	2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.				

Figure:

Figure 1

Process Requirements:

1. Check for rusted screws, missing slots or bad cross slot.
2. Check if the electric screwdriver torque force is within the specified requirements.
3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
5. Put the defective screws in the defective product box and do not throw them at will.

Recent Modification Record		Please read and understand the operating instructions carefully	Take only one screw at a time	Prepared by	Reviewed by	Approved by	Project Controlled Seal
				Yongli Zhou			

Station Name		LVDS Wire Insertion		Model	39L61B	Section/Serial No.	Unit Assembly 04	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19

NO	Part Number	Amount	Descriptions	Operations and Requirements	Diagram	Tool Parameters
1	6149-450063-306812B1	1	450mm double-terminal LVDS wire(Specific subject in accordance with work order)	Insert LVDS wire to drive board socket on the panel.	Figure 1	
2	7373-000000-10000011	1	Fragile label 38×14mm	Mark the fragile label properly and stick it on panel back.		
3				When finished, step on the switch with your foot to send the product to next station.		
4			Note: Photos are for reference only, specific in kind prevail			
5						

Notice

1. Wastes produced by this station shall be placed in the assigned position. Refer to *Waste Classification and Disposal List* .

4

Figure 1

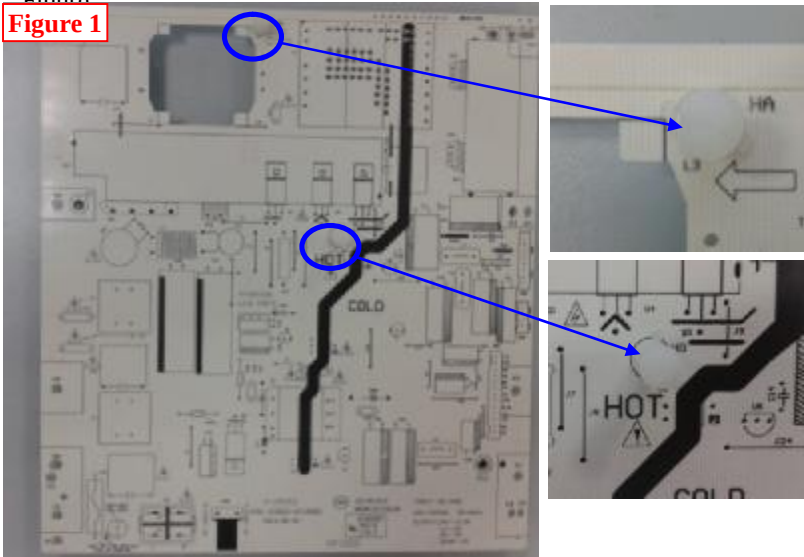
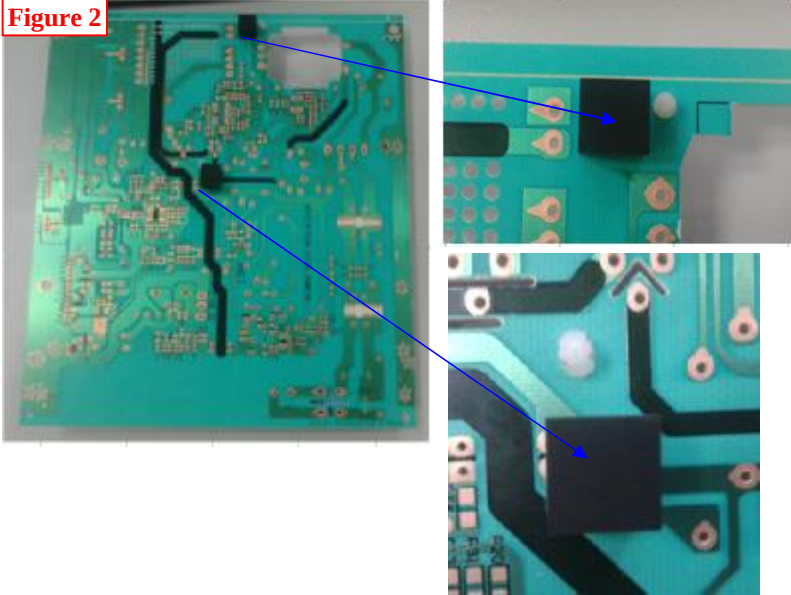
Fragile label

A

Mark production date and warranty deadline of machine on the fragile(Select 13/15/18/24/36 warranty months according to work order,mark it in the blank if it does not warranty, if the number of months of warranty and the number of these groups does not match, please write in the blank space on the specific number of months)stick it on fixing screws for cover plate of drive board on the display screen.

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Recent Modification Record		Please read and understand the operating instructions carefully	Prepared by	Reviewed by	Approved by
			Yongli Zhou		

Station Name		Power Board Locking-1		Model	39L61F	Section/Serial No.	Unit Assembly 05	Document No.	ITB10205	Version	v5.0
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19
NO	Part Number	Amount	Descriptions	Operations and Requirements				Diagram	Tool Parameters		
1	9012-112437-07504051	1	26-37" 150W LED power board	Stick 2pcs silica gel pad beside insulated				Figure 2			
2	7912-122020-01001311	2	20*10*13mm 70° black silica gel pad	Fit 2pcs insulated columns to power board properly				Figure 1			
3	7913-011603-01020011	2	insulated column PSJ33-15(H16.5mm)	When finished, step on the switch with your foot to send the product to next station.							
4			Note: Photos are for reference only, specific in kind prevail								
5											
Notice		1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> . 2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.						 	5		
Figure 1  Figure 2 											
Recent Modification Record		Please read and understand the operating instructions carefully				Prepared by	Reviewed by	Approved by	Project Controlled Seal		
						Yongli Zhou					

Station Name		Power Board Locking-2		Model	39L61B	Section/Serial No.	Unit Assembly 06	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19
NO	Part Number	Amount	Descriptions			Operations and Requirements			Diagram	Tool Parameters	
1	7B11-0307C2-50102111	4	M3×7mm P-head white-zinc-plated machine screws with flat and spring washers			Fasten the power board to panel back with 4PCS screws.			Figure 1/A 	Electric screwdriver	
2						When finished, step on the switch with your foot to send the product to next station.				4±1kgfcm	
3											
4			Note: Photos are for reference only, specific in kind prevail								
5											

Note: Photos are for reference only, specific in kind prevail

Notice

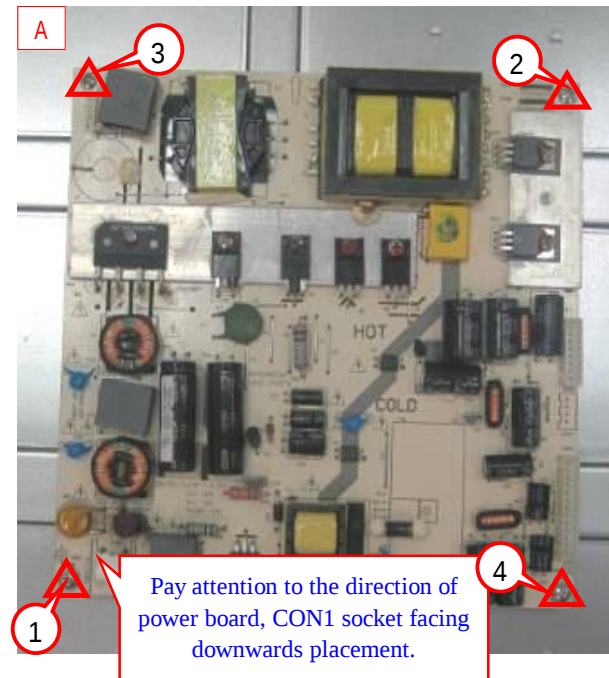
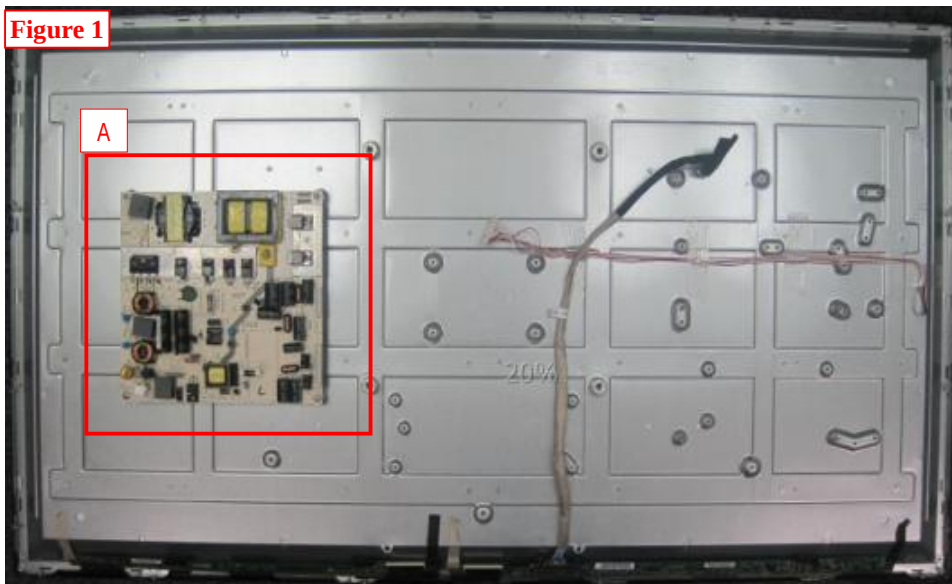
1. Wastes produced by this station shall be placed in the assigned position. Refer to *Waste Classification and Disposal List*.
2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.



6

Figure:

Figure 1



Process Requirements:

1. Check for rusted screws, missing slots or bad cross slot.
2. Check if the electric screwdriver torque force is within the specified requirements.
3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
5. Put the defective screws in the defective product box and do not throw them at will.

Project Controlled Seal

Recent
Modification
Record

Please read and understand the operating instructions carefully

Take only one screw at a time

Prepared by

Yongli Zhou

Reviewed by

Approved by

Station Name		Mainboard Locking		Model	39L61B	Section/Serial No.	Unit Assembly 07	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19
NO	Part Number	Amount	Descriptions			Operations and Requirements			Diagram	Tool Parameters	
1	9011-11T92A-483B6201	1	26" above T9 large mainboard (Specific subject in accordance with work order)			Fit the insulation sleeve to LNB as illustrated.			Figure 1/B	Electric screwdriver	
2	7111-32L61F-41120J01	1	Side baffle plate for mainboard (Specific subject in accordance with work order)			Fit side baffle plate to mainboard, then fit it to panel back as illustrated.			Figure 1/A	4±1kgfcm	
3	7B11-0307C2-50102111	4	M3×7mm P-head white-zinc-plated machine screws with flat and spring washers			Fasten mainboard to panel back with 4PCS screws.			Figure 1/A 		
4	7B11-0306A6-00101111	1	Φ3×6mm flat-head nickel-plated machine screws			Fasten side baffle plate to panel back with 1PCS screw.			Figure 1/A 		
5	70E8-000000-44401101	1	insulation sleeve for LNB			When finished, step on the switch with your foot to send the product to next station.					

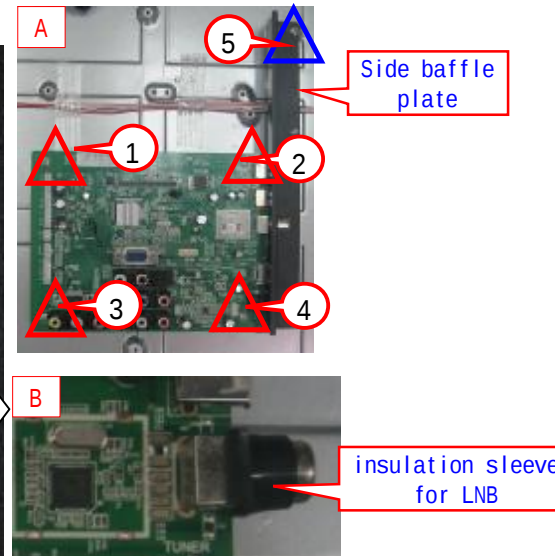
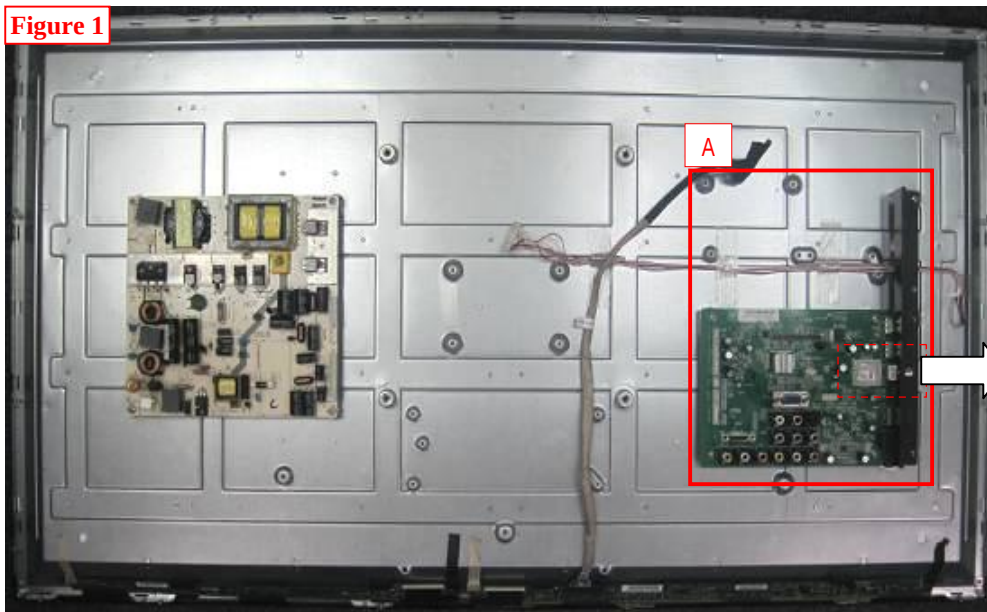
Notice

1. Wastes produced by this station shall be placed in the assigned position. Refer to *Waste Classification and Disposal List*.
2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.



Figure:

Figure 1



Process Requirements:

1. Check for rusted screws, missing slots or bad cross slot.
2. Check if the electric screwdriver torque force is within the specified requirements.
3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
5. Put the defective screws in the defective product box and do not throw them at will.

Note: Photos are for reference only, specific in kind prevail

Project Controlled Seal

Recent
Modification
Record

Please read and understand the operating instructions carefully

Take only one screw at a time

Prepared by

Yongli Zhou

Reviewed by

Approved by

Station Name		Wire Insertion-A		Model	39L61B	Section/Serial No.	Unit Assembly 09	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19

NO	Part Number	Amount	Descriptions	Operations and Requirements	Diagram	Tool Parameters
1	6149-200093-13111201	1	200mm double-terminal wire	Insert 200mm double-terminal wire to CON2 socket on power board, 10pin to CN01 socket on panel.	Figure 1	
2						
3	6149-400034-03111203	1	400mm double-terminal wire	Insert 3pin end of 400mm double-terminal wire to CN102 socket on mainboard, the other end to CN02 socket on power board.	Figure 1	
4						
5				When finished, step on the switch with your foot to send the product to next station.		

Notice

1. Wastes produced by this station shall be placed in the assigned position. Refer to *Waste Classification and Disposal List*.

9

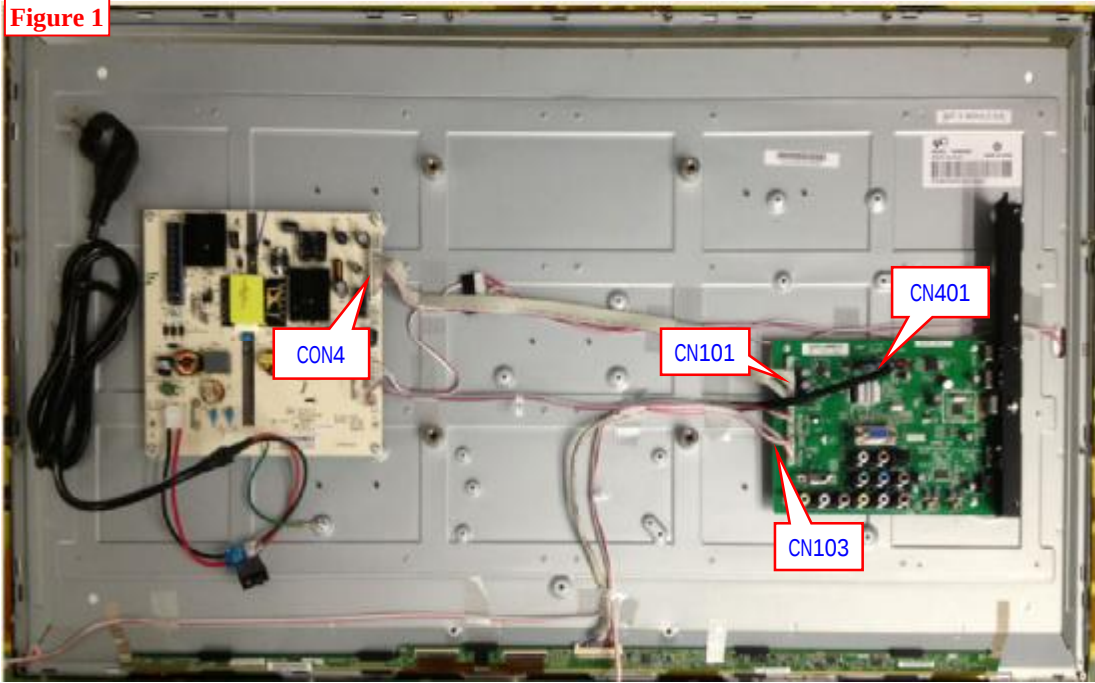
Figure:

Figure 1

Note: Photos are for reference only, specific in kind prevail

Project Controlled Seal

Recent Modification Record		Please read and understand the operating instructions carefully	Prepared by	Reviewed by	Approved by
			Yongli Zhou		

Station Name		Wire Insertion-B		Model 39L61B	Section/Serial No.	Unit Assembly 10	Document No.		Version		
				Panel K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19	
NO	Part Number	Amount	Descriptions	Operations and Requirements			Diagram	Tool Parameters			
1	6142-400033-13111201	1	400mm double-terminal wire	Insert 13pin end of 400mm wire to CON4 socket on power board, 12pin end to CN101 socket on mainboard.			Figure 1				
2	6149-800063-08191301	1	800 450mm three-terminal wire	Insert 8pin end of 800mm wire to CN103 socket on mainboard.			Figure 1				
3				Insert 40pin board end of LVDS wire to CN401 socket on mainboard.			Figure 1				
4				When finished, step on the switch with your foot to send the product to next station.							
5											
Notice		1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> .					 	10			
Figure:		Figure 1   LVDS white spot corresponding to PCB "1" or △" insertion. Note: Photos are for reference only, specific in kind prevail									
Recent Modification Record		Please read and understand the operating instructions carefully			Prepared by	Reviewed by	Approved by		Project Controlled Seal		
					Yongli Zhou						

Station Name		Wire Arrangement-A		Model	39L61B	Section/Serial No.	Unit Assembly 11	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19

NO	Part Number	Amount	Descriptions	Operations and Requirements	Diagram	Tool Parameters
1	7912-712500-020R1311	4	Viscose paper(50mm)	Tear off 4PCS of viscose paper and fix wire in the figure to panel back properly.	Figure 1	Tape dispenser
2				When finished, step on the switch with your foot to send the product to next station.		
3						
4						
5						

Notice

1. Wastes produced by this station shall be placed in the assigned position. Refer to *Waste Classification and Disposal List* .

11

Figure:

Figure 1

Note: Photos are for reference only, specific in kind prevail

Recent Modification Record		Please read and understand the operating instructions carefully	Prepared by	Reviewed by	Approved by	Project Controlled Seal
			Yongli Zhou			

Station Name		Wire Arrangement-B		Model	39L61B	Section/Serial No.	Unit Assembly 12	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19

NO	Part Number	Amount	Descriptions	Operations and Requirements	Diagram	Tool Parameters
1	7912-712500-020R1311	4	Viscose paper(50mm)	Tear off 4PCS of viscose paper and fix wire in the figure to panel back properly.	Figure 1 	Tape dispenser
2				When finished, step on the switch with your foot to send the product to next station.		
3						
4						
5						

Notice

1. Wastes produced by this station shall be placed in the assigned position. Refer to *Waste Classification and Disposal List* .

12

Figure:

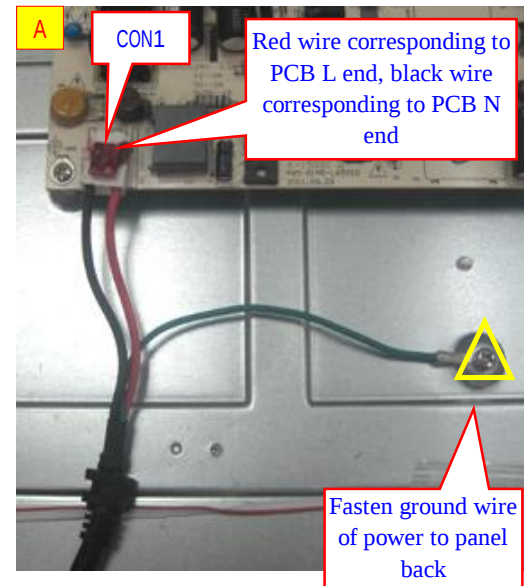
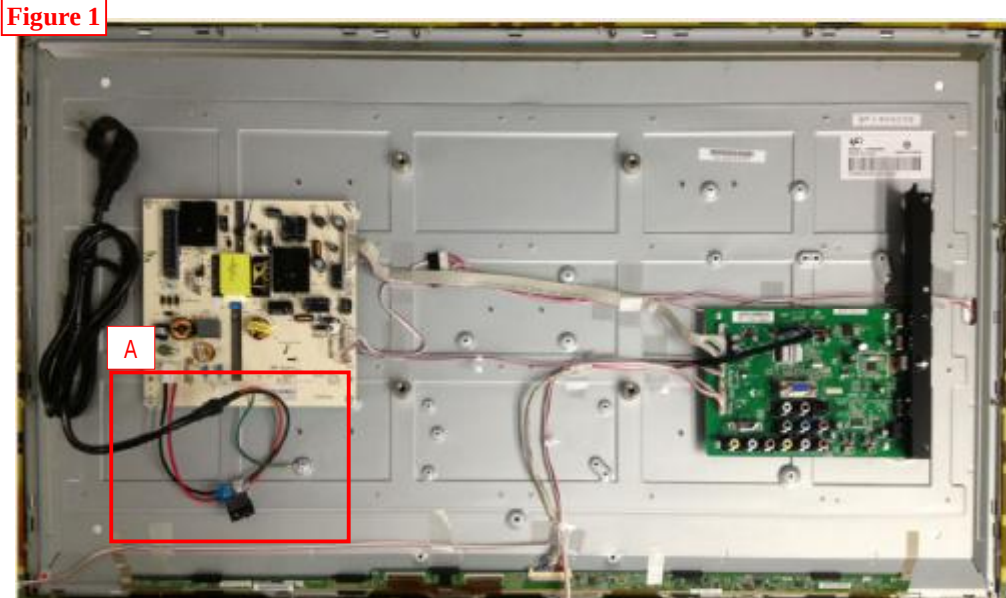
Figure 1

Note: Photos are for reference only, specific in kind prevail

Recent Modification Record		Please read and understand the operating instructions carefully	Prepared by	Reviewed by	Approved by	Project Controlled Seal
			Yongli Zhou			

Station Name		Power Cord Installation		Model	39L61B	Section/Serial No.	Unit Assembly 13	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19
NO	Part Number	Amount	Descriptions		Operations and Requirements			Diagram	Tool Parameters		
1		1	1.5M+0.16M power cord 250V (Specific subject in accordance with work order)		Insert power cord to CON1 socket on power board.			Figure 1	Electric screwdriver		
2					Spread red glue on power board CON1 socket, to fix the wires to socket.			Figure 1	5±1kgfcm		
3	7B11-0405D6-40102111	1	Φ4×5mm round-head white-zinc-plated machine screws with jugged washers (Only apply to three-core power)		Fasten ground wire of power to panel back with 1PCS screw. (Only apply to three-core power)			Figure 1	⚠	Glue bottle	
4	Note: Photos are for reference only, specific in kind prevail				When finished, step on the switch with your foot to send the product to next station.						
5											
Notice		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List .									
		2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.									

Figure 1



Process Requirements:

1. Check for rusted screws, missing slots or bad cross slot.
2. Check if the electric screwdriver torque force is within the specified requirements.
3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
5. Put the defective screws in the defective product box and do not throw them at will.

Project Controlled Seal

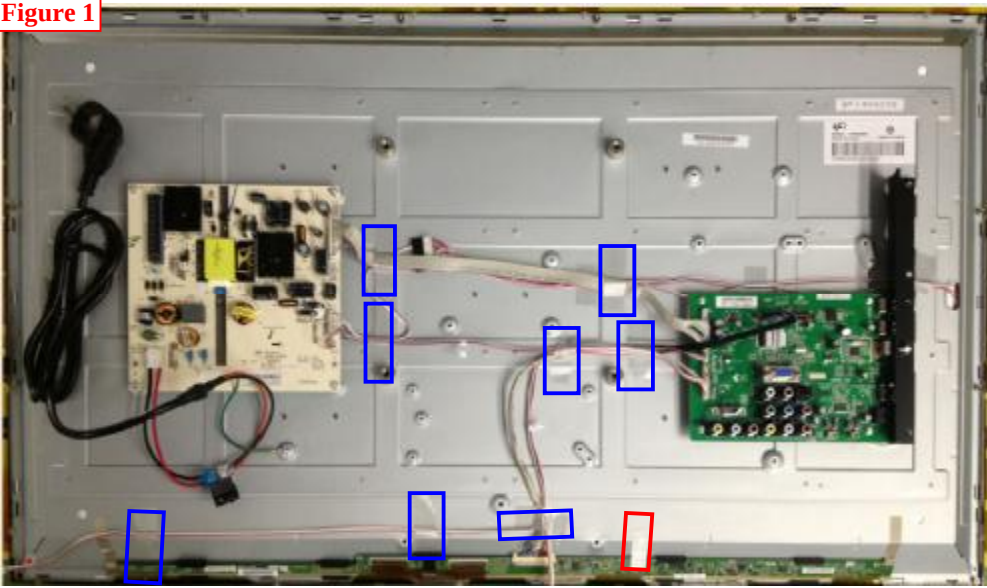
Recent Modification Record			Please read and understand the operating instructions carefully	Take only one screw at a time	Prepared by	Reviewed by	Approved by
					Yongli Zhou		

Station Name	Process Inspection			Model	39L61B	Section/Serial No.	Unit Assembly 14	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19

NO	Part Number	Amount	Descriptions	Operations and Requirements	Diagram	Tool Parameters
1				Check if all processes for each parts in the machine comply with the requirements of operating instructions.	Figure 1	
2				When finished, step on the switch with your foot to send the product to next station.		
3						
4			Note: Photos are for reference only, specific in kind prevail			
5						

Notice	1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List. 2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.	 	14
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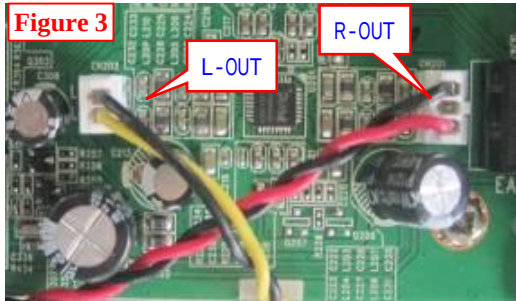
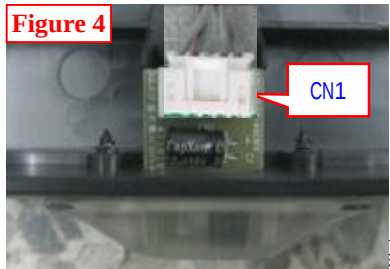
Figure:
Figure 1



Process Inspection Requirements:

1. Connection wires being missed to insert, misplaced, inserted reversely or inserted not in place are not allowed and also do not touch high-power components such as power board and mainboard.
2. Screws can not be missed to install, tilted or made loose; do not drop any screw into PCB board or power board.
3. Keyboard not locked into place or keys hard to be pressed is not allowed.
4. Viscose paper must be attached in the shape of “Ω”, without edges and corners curling up.
5. Connection wires in the machine must be strictly arranged according to the process requirements and keep all wires away from transformer and cushion.
6. Is the connection wire properly inserted into power switch?
7. Make sure no any sundries are left in the machine.
8. Do not change the process and plan at will.
9. Make sure no abnormalities occurs in the machine.

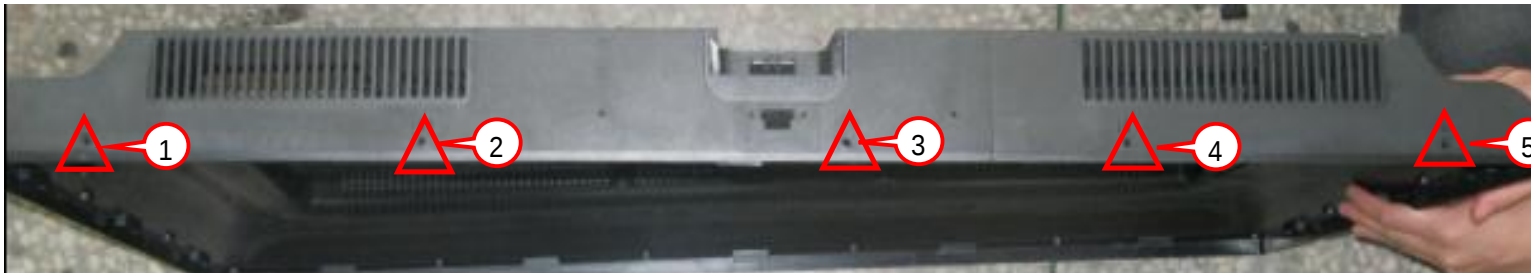
Recent Modification Record		Please read and understand the operating instructions carefully	Take only one screw at a time	Prepared by	Reviewed by	Approved by	Project Controlled Seal
				Yongli Zhou			

Station Name		Back Cover Placement		Model	39L61B	Section/Serial No.	Unit Assembly 15	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19
NO	Part Number	Amount	Descriptions	Operations and Requirements				Diagram	Tool Parameters		
1		1	Processed back cover	Take power cord and pass through power cord hole on back cover.				Figure 1			
2				Insert key board wire to CN1 socket on key board properly.				Figure 2			
3				Insert red/black speaker wire to R-OUT socket on mainboard, yellow/black speaker wire to L-OUT socket on mainboard.				Figure 3			
4			Note: Photos are for reference only, specific in kind prevail	Insert remote control receive board wire to remote control receive board socket.				Figure 4			
5				When finished, step on the switch with your foot to send the product to next station.							
Notice		1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> .								15	
Figure: Figure 1  Reference Figure 2  CN1 Figure 3  L-OUT R-OUT Figure 4  CN1											
Recent Modification Record				Please read and understand the operating instructions carefully			Prepared by	Reviewed by	Approved by		
							Yongli Zhou				

Station Name		Back Cover Installation		Model 39L61B	Section/Serial No.	Unit Assembly 16	Document No.		Version	
		Panel K390WD6-UB300	Effective from 2014-5-19	Date Updated 2014-5-19			2014-5-19			
NO	Part Number	Amount	Descriptions	Operations and Requirements			Diagram	Tool Parameters		
1				Fit the back cover to surface frame properly.			Figure 1			
2				When finished, step on the switch with your foot to send the product to next station.						
3										
4										
5										
Notice		1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> .					 	16		
Figure:		Figure 1  Note: Photos are for reference only, specific in kind prevail								
Recent Modification Record				Please read and understand the operating instructions carefully		Prepared by Yongli Zhou	Reviewed by	Approved by	Project Controlled Seal 	

Station Name		Back Cover Locking-A		Model	39L61B	Section/Serial No.	Unit Assembly 19	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19
NO	Part Number	Amount	Descriptions			Operations and Requirements			Diagram	Tool Parameters	
1	7B11-0306A6-00105111	5	Φ3×6mm flat-head black-zinc-plated machine screws (39L61B use)			Fasten back cover to surface frame with 5PCS screws.				Electric screwdriver	
2						When finished, step on the switch with your foot to send the product to next station.				5±1kgfcm	
3											
4											
5											
Notice		1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> .									
		2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.									

Figure:



- Process Requirements:**
1. Check for rusted screws, missing slots or bad cross slot.
 2. Check if the electric screwdriver torque force is within the specified requirements.
 3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
 4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
 5. Put the defective screws in the defective product box and do not throw them at will.

Note: Photos are for reference only, specific in kind prevail

Recent Modification Record		Please read and understand the operating instructions carefully	Take only one screw at a time	Prepared by	Reviewed by	Approved by	Project Controlled Seal
				Yongli Zhou			

Station Name		Back Cover Locking-B		Model	39L61B	Section/Serial No.	Unit Assembly 17	Document No.		Version			
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19		
NO	Part Number	Amount	Descriptions	Operations and Requirements				Diagram	Tool Parameters				
1	7B11-0306A6-00105111	5	Φ3×6mm flat-head black-zinc-plated machine screws	Fasten back cover to surface frame with 5PCS screws.				△	Electric screwdriver				
2				When finished, step on the switch with your foot to send the product to next station.					5±1kgfcm				
3													
4			Note: Photos are for reference only, specific in kind prevail										
5													
Notice		1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> .						RoHS Lead Free	ATTENTION ELECTRIC STATIC DEVICES 请注意 静电防护	17			
		2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.											
Figure:													
 Process Requirements: 1. Check for rusted screws, missing slots or bad cross slot. 2. Check if the electric screwdriver torque force is within the specified requirements. 3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt). 4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw. 5. Put the defective screws in the defective product box and do not throw them at will.													
Recent Modification Record				Please read and understand the operating instructions carefully		Take only one screw at a time		Prepared by		Reviewed by		Approved by	
								Yongli Zhou					
Project Controlled Seal													

Station Name		Back Cover Locking-C		Model	39L61B	Section/Serial No.	Unit Assembly 18	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19

NO	Part Number	Amount	Descriptions	Operations and Requirements	Diagram	Tool Parameters
1	7B11-0306A6-00105111	5	Φ3×6mm flat-head black-zinc-plated machine screws	Fasten back cover to surface frame with 5PCS screws.		Electric screwdriver
2				When finished, step on the switch with your foot to send the product to next station.		5±1kgfcm
3						
4						
5						

Notice

1. Wastes produced by this station shall be placed in the assigned position. Refer to *Waste Classification and Disposal List*.

2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.

18

Figure:

Note: Photos are for reference only, specific in kind prevail

Process Requirements:

1. Check for rusted screws, missing slots or bad cross slot.
2. Check if the electric screwdriver torque force is within the specified requirements.
3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
5. Put the defective screws in the defective product box and do not throw them at will.

Recent Modification Record		Please read and understand the operating instructions carefully	Take only one screw at a time	Prepared by	Reviewed by	Approved by	Project Controlled Seal
				Yongli Zhou			

Station Name	Back Cover Locking-D		Model	39L61B	Section/Serial No.	Unit Assembly19	Document No.		Version	
			Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19

NO	Part Number	Amount	Descriptions	Operations and Requirements	Diagram	Tool Parameters
1	7B11-030616-00105111	2	Φ3×6mm countersunk-head black-zinc-plated machine screws	Fasten back cover to panel back with 2PCS Φ3×6mm countersunk-head screws.	▲	Electric screwdriver
2	7B11-0306A6-00105111	2	Φ3×6mm flat-head black-zinc-plated machine screws	Fasten back cover to surface frame with 2PCS Φ3×6mm flat-head screws.	▲	5±1kgfcm
3	7B11-031013-00105111	1	Φ3×10mm countersunk-head pointed-tail black-zinc-plated tapping screws	Fasten back cover to mainboard with 1PCS Φ3×10mm screw.	▲	
4			(Specific subject in accordance with work order)	When finished, step on the switch with your foot to send the product to next station.		
5						

Notice

1. Wastes produced by this station shall be placed in the assigned position. Refer to *Waste Classification and Disposal List*.

2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.

19

Figure:

Process Requirements:

1. Check for rusted screws, missing slots or bad cross slot.
2. Check if the electric screwdriver torque force is within the specified requirements.
3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
5. Put the defective screws in the defective product box and do not throw them at will.

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Note: Photos are for reference only, specific in kind prevail

Recent Modification Record		Please read and understand the operating instructions carefully	Take only one screw at a time	Prepared by	Reviewed by	Approved by
				Yongli Zhou		

Station Name	Back Cover Locking-E			Model	39L61B	Section/Serial No.	Unit Assembly 20	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19

NO	Part Number	Amount	Descriptions	Operations and Requirements	Diagram	Tool Parameters
1	7B11-040696-00105111	3	Φ4×6mm B-head black-zinc-plated machine screws	Fasten back cover to panel back with 3PCS screws.		Electric screwdriver
2				When finished, step on the switch with your foot to send the product to next station.		5±1kgfcm
3						
4						
5						

Notice

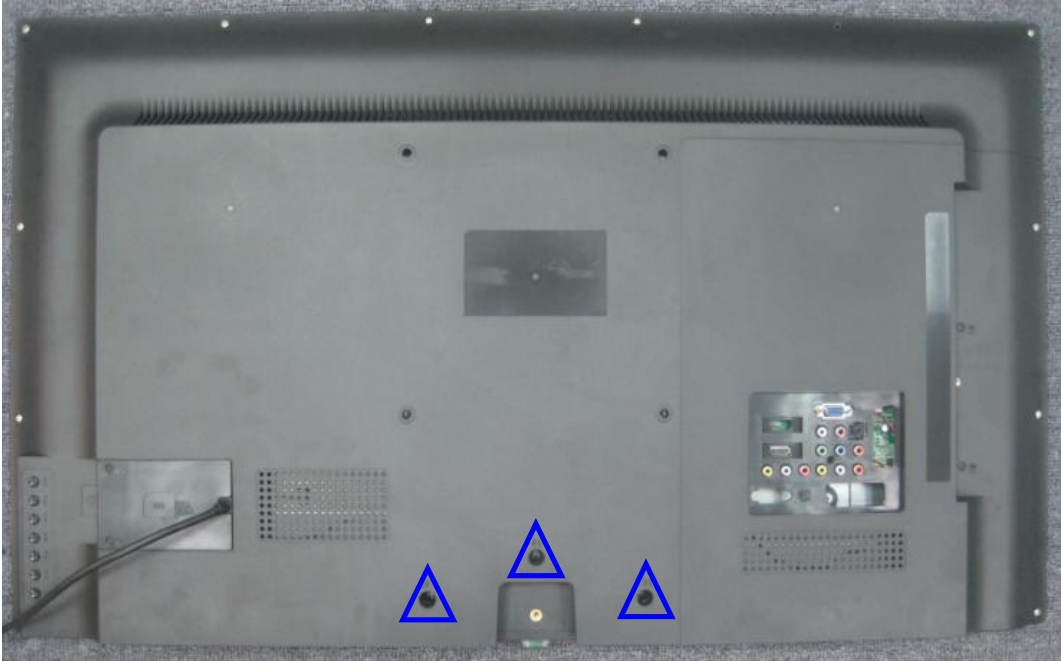
1. Wastes produced by this station shall be placed in the assigned position. Refer to *Waste Classification and Disposal List*.

2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.




20

Figure:



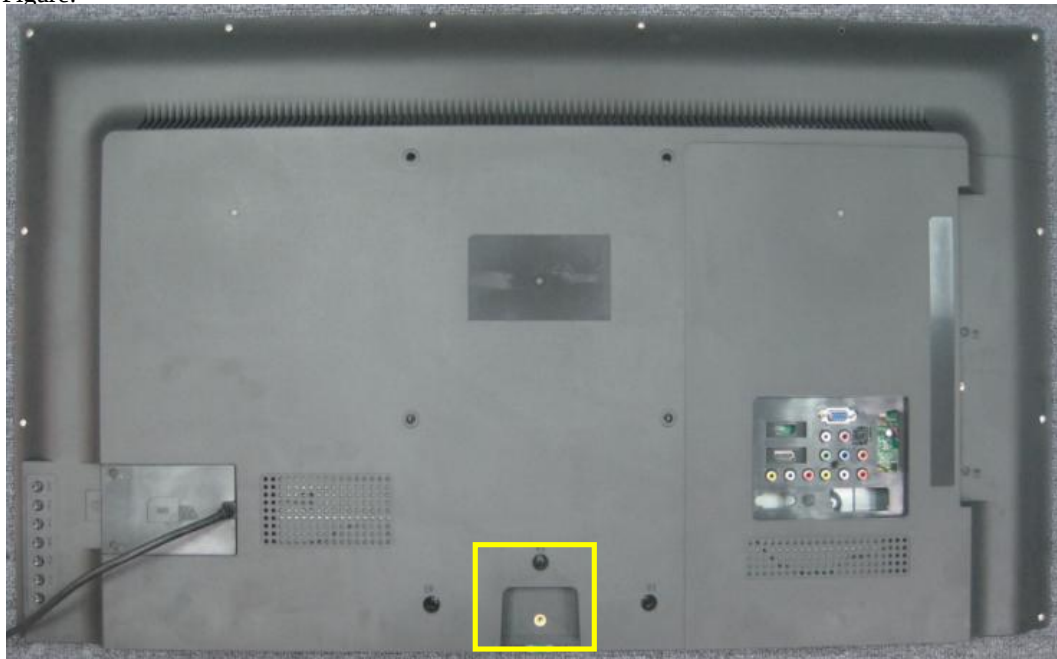
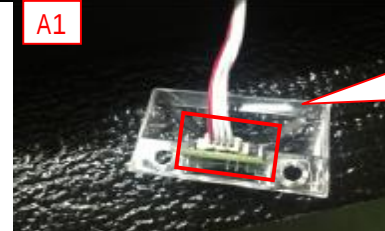
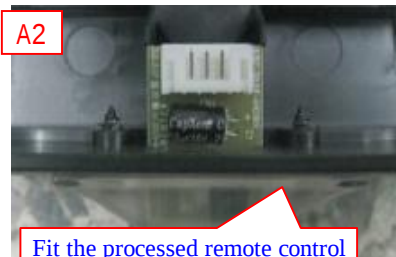
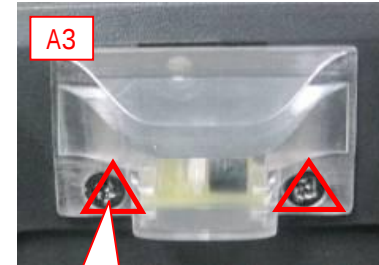
Process Requirements:

1. Check for rusted screws, missing slots or bad cross slot.
2. Check if the electric screwdriver torque force is within the specified requirements.
3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
5. Put the defective screws in the defective product box and do not throw them at will.

Note: Photos are for reference only, specific in kind prevail

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Recent Modification Record		Please read and understand the operating instructions carefully	Take only one screw at a time	Prepared by	Reviewed by	Approved by
				Yongli Zhou		

Station Name		Back Cover Locking-F		Model	39L61B	Section/Serial No.	Unit Assembly 21	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19
NO	Part Number	Amount	Descriptions		Operations and Requirements			Diagram	Tool Parameters		
1					Insert remote control receiver board wire to remote contr			Figure A1		Electric screwdriver	
2					Fit the processed remote control receiver window to the bottom of back cover.			Figure A2		3±0.5kgfcm	
3	7B11-031013-00105111	2	Φ3×10mm countersunk-head pointed-tail black-zinc-plated tapping screws		Fasten remote control receiver window to back cover with 2PCS screws			Figure A3			
4											
5											
Notice		1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> .								21	
		2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.									
Figure:  A1  Insert remote control receiver board wire to remote control receiver board. A2  Fit the processed remote control receiver window to the bottom of back cover. A3  Fasten remote control receiver window to back cover. Note: Photos are for reference only, specific in kind prevail											
Recent Modification Record				Please read and understand the operating instructions carefully		Take only one screw at a time		Prepared by	Reviewed by	Approved by	
								Yongli Zhou			

Station Name	Power Cord Cover Locking		Model	39L61B	Section/Serial No.	Unit Assembly 22	Document No.		Version	
			Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19

NO	Part Number	Amount	Descriptions	Operations and Requirements	Diagram	Tool Parameters
1	7057-32L61F-44B01203	1	32L61F black power cord cover(with hard switch)	Fit power cord to the slot of back cover properly.	Figure 1	Electric screwdriver
2	7B11-031013-00105111	2	Φ3×10mm countersunk-head pointed-tail black-zinc-plated tapping screws	Fasten power cord cover to back cover with 2PCS screws.	Figure 2 ▲	4±0.5kgfcm
3			(Optional according to work order)	When finished, step on the switch with your foot to send the product to next station.		
4						
5						

Notice

1. Wastes produced by this station shall be placed in the assigned position. Refer to *Waste Classification and Disposal List* .

2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.

22

Figure 1

Figure 2

Note: Photos are for reference only, specific in kind prevail

Process Requirements:

1. Check for rusted screws, missing slots or bad cross slot.
2. Check if the electric screwdriver torque force is within the specified requirements.
3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
5. Put the defective screws in the defective product box and do not throw them at will.

Recent Modification Record		Please read and understand the operating instructions carefully	Take only one screw at a time	Prepared by	Reviewed by	Approved by
				Yongli Zhou		

Project Controlled Seal

Station Name	Base Locking			Model	39L61B	Section/Serial No.	Unit Assembly 23	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19

NO	Part Number	Amount	Descriptions	Operations and Requirements	Diagram	Tool Parameters
1						Electric screwdriver
2						12±2kgfcm
3	7B11-0529D6-20105111	1	Φ5×29mm P-head black-zinc-plated machine screws with spring washers	Fit the base to the bottom of machine, then fasten it to support back plate with 1PCS screw.	Figure 1 ▲	
4			(Specific subject in accordance with work order)	When finished, step on the switch with your foot to send the product to next station.		
5						

Notice	1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i>. 2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.	 	23
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Figure:

Figure1

Process Requirements:

1. Check for rusted screws, missing slots or bad cross slot.
2. Check if the electric screwdriver torque force is within the specified requirements.
3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
5. Put the defective screws in the defective product box and do not throw them at will.

Project Controlled Seal

Note: Photos are for reference only, specific in kind prevail

Recent Modification Record		Please read and understand the operating instructions carefully	Take only one screw at a time	Prepared by	Reviewed by	Approved by
				Yongli Zhou		

Station Name		Setting Machine Upringt		Model	39L61B	Section/Serial No.	Unit Assembly 24	Document No.		Version	
				Panel	K390WD6-UB300			Effective from	2014-5-19	Date Updated	2014-5-19
NO	Part Number	Amount	Descriptions	Operations and Requirements				Diagram	Tool Parameters		
1				Set the machine upright in the middle of workbench.				Figure 1			
2				Power on the machine.				Figure 1			
3				When finished, step on the switch with your foot to send the product to next station.							
4											
5											
Notice		1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> .						 	24		
Figure:		Figure 1  Note: Photos are for reference only, specific in kind prevail									
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