

## **TB054 (Rev1) - Glass Replacement in an M-400**

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### **Procedure:**

1. Remove the front panel of the M-400.
2. Remove the motherboard & LCD screen. The removal of the jog panel & keyboard is recommended but not necessary if caution is taken not to damage them.
3. Carefully remove all remnants of broken glass.
4. Scrape any remaining silicone from the front panel.
5. Wipe the inside edges with a cleaner to remove any remaining silicone. Lighter fluid works well, but be careful not to get any on the painted side of the front panel.
6. Run a thin bead of silicone around the edge.
7. Place the glass into the panel. (Glass is non - glare, 8 3/4" x 6 3/4" x 3/16" )
8. Let the glass set into place at least 1 hour. It will take 24 hours for complete curing.
9. Clean the inside of the glass thoroughly, removing all streaks and/or excess silicone.
10. Place a new foam poron strip around the edges of the glass. This will provide a cushion for the LCD.
11. Use an air hose to blow off the screen and glass.
12. Replace the LCD screen & motherboard.
13. Reattach the front panel.

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### **Document History**

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