

Specs For Applying Heat Seals

There are 3 settings that are critical:

- 1) Heat setting
- 2) Downward force
- 3) Dwell time (time that heat and pressure are applied)

HEAT SETTING	DOWNWARD FORCE	DWELL TIME
Machine setting: 210 - 230°C (410 - 446° F) Heat seal melt temperature: 160 - 180°C (320 - 356° F)	Pressure: 35 - 45kg/cm2 (497.70 - 639.9 psi)	Time - 5 - 7 seconds

Affected Refurb Supplies Products

NORTEL PHONE	M3902	M3903	M3904	M3905	M39XX DISPLAY
Part Number	HEAT SEAL 36200	HEAT SEAL 36100	HEAT SEAL 36000	HEAT SEAL 36000	HEAT SEAL 36250
Description	LCD Connector	LCD Connector	Large LCD Connector	Large LCD Connector	Display Based Exp. Module
Part Number			HEAT SEAL 36050	HEAT SEAL 36150	
Description			Small LCD Connector	Small LCD Connector	
Part Number	LCD GLASS 36425	LCD GLASS 36460	LCD GLASS 36520	LCD GLASS 36575	
Description	with Heat Seal Attached	with Heat Seal Attached	with Heat Seal Attached	with Heat Seal Attached	