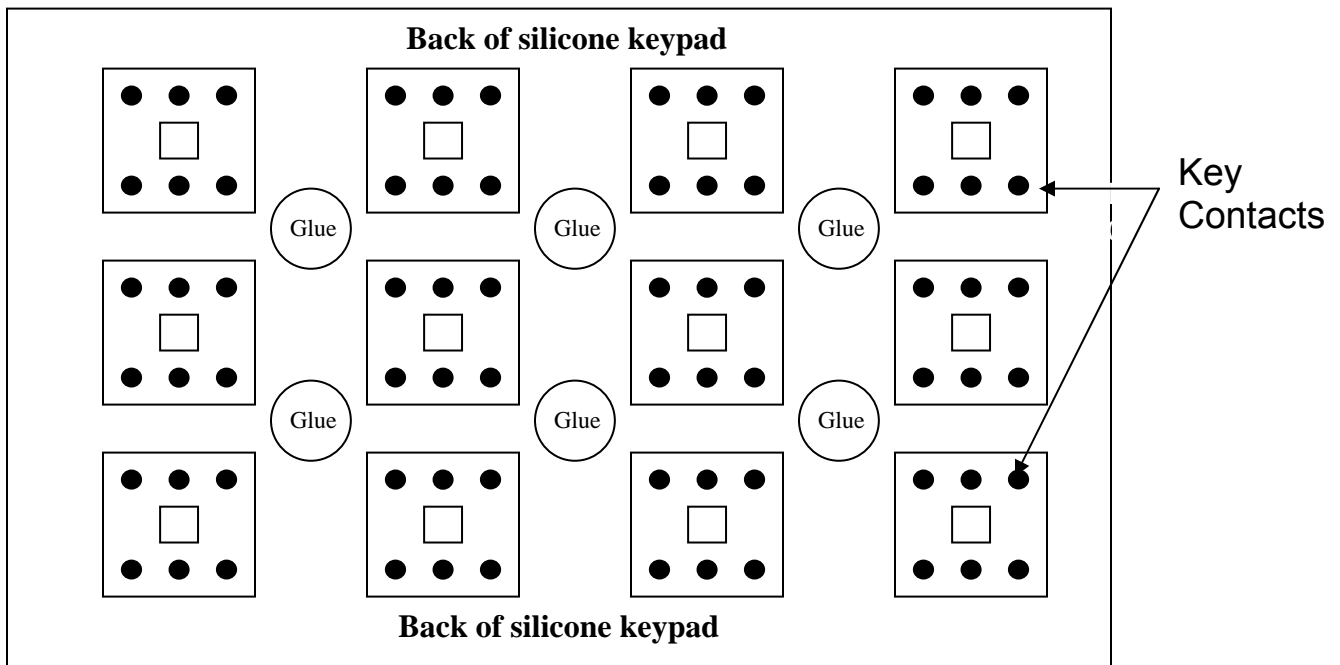


Step 1: Materials Needed for an OEM Assembly



1. OEM Printed Circuit Board
2. Silicone Rubber Keypad Overlay
3. Cable
4. Silicone RTV Glue

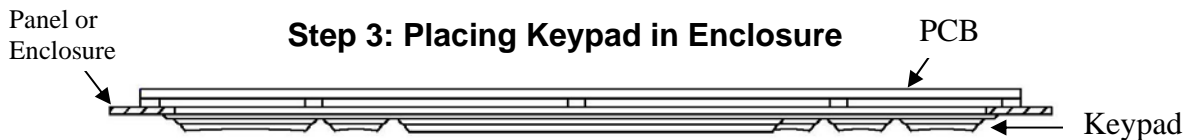
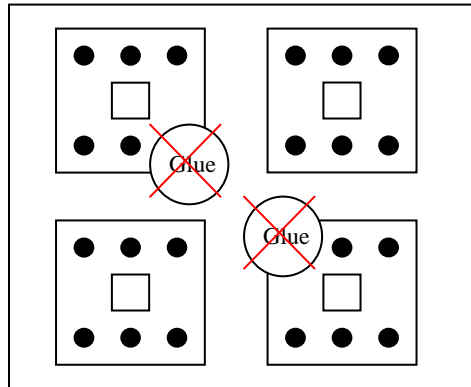
Step 2: Applying Adhesive to Silicone Overlay



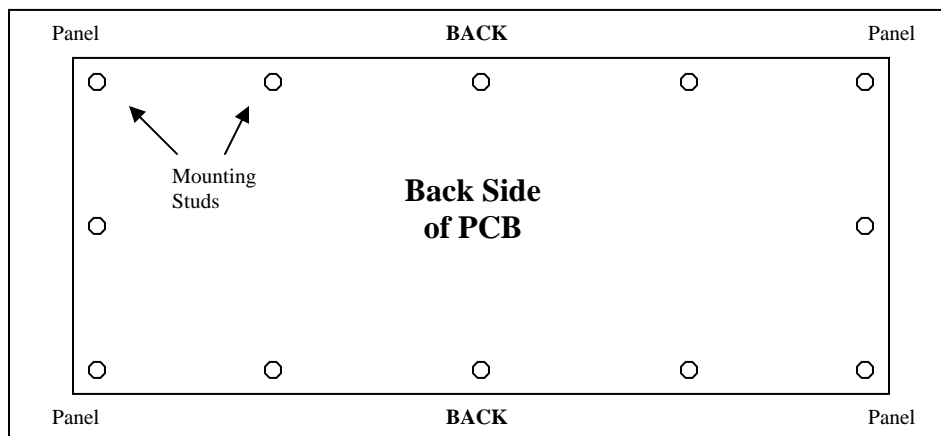
Apply silicone adhesive [Stealth recommends SuperFlex by Loctite] to back side of silicone overlay (keypad). Sparingly dab glue on the middle of each key intersection across the whole keyboard as seen in this picture. Also apply to inside of center portion of HulaPoint™ pad (where the sensor/joystick lies) if OEM kit incorporates the HulaPoint™

Be careful not to drop silicone on any key contacts.

INCORRECT GLUING PROCEDURE

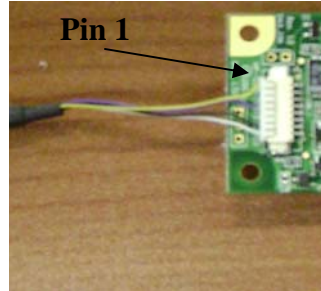


1. Put the silicone rubber keypad into place on the panel or enclosure you are using. Do not place PCB yet.
2. Seat the keypad in the mounting cutout by sliding one edge at a time into the cutout space.
3. Spread the keypad to be sure it is well seated on all four sides. Ensure that the lip is through the cutout all the way around the pad.
4. When the keypad is in place, gently allow the board to fall into place on top of the keypad so no glue is displaced onto a key trace, or key contact.
(**Note:** make sure the PCB and pad are oriented in the same direction.)



5. Tighten hex nuts until keypad is just SLIGHTLY compressed between panel and PCB. We recommend 1.5 in/lbs. of torque when tightening.
6. Run fingers between all keys to ensure a good silicon and PCB bond.
7. Allow glue to cure for 1 hour

Step 4: Wiring for Pointer



Pointer Cables: PS/2 – Yellow, Purple, Black, White
USB – Red, Brown, Blue, Black

Custom Cables Signal Layouts

USB	
CON_1 (1x8 Header)	
PIN	Connectivity Function
1	Ground
4	+5V
7	Clock
8	Data

PS/2	
CON_1 (1x8 Header)	
PIN	Connectivity Function
1	Ground
4	+5V
7	Clock
8	Data

Slip the cable connector CON_1 into the header as pictured above. There should be a slight snap when it is properly connected.

Your Stealth unit is now ready to use with your set up.

If you should have any additional questions, please feel free to contact Stealth directly at (888) 783-2484 or <http://www.stealth.com/support.htm>