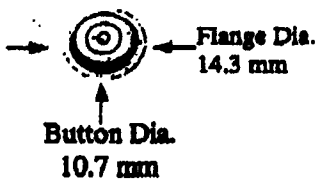
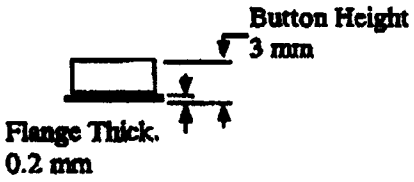
MiniButton™
(Note: Not Shown to Scale)

Part #BMEWK8
Cage Code 03BF3



Dimensions:
Flange Dia. = 14.3 mm
Flange Thick. = 0.2 mm
Button Dia. = 10.7 mm
Button Height = 3 mm

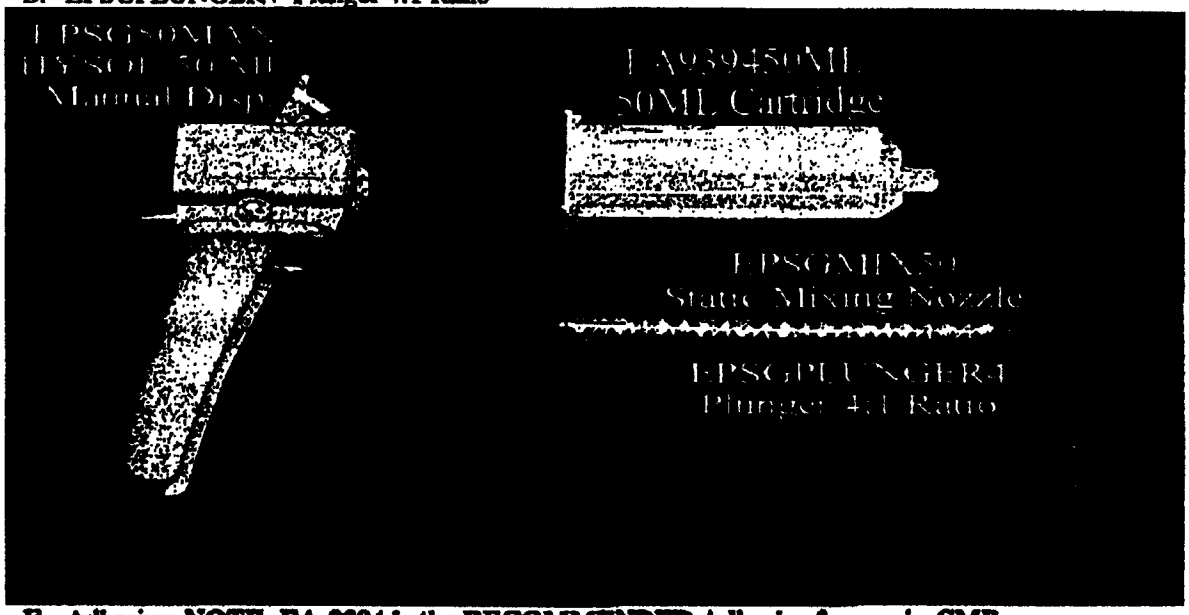


CONTACT MEMORY BUTTON INSTALLATION MANUAL

Application Instructions for Contact Memory Buttons

1. Materials Required.

A. Contact Memory Button
B. EPSG50MAN HYSOL 50 ML Manual Dispenser
C. EPSGMIX50 Static Mixing Nozzle
D. EPSGPLUNGER4 Plunger 4:1 Ratio



E. Adhesive: NOTE: EA-9394 is the RECOMMENDED Adhesive for use in CMB Applications as per NAWC-AD TEST PLAN.
F. Cleaning Solvent (One of the below listed recommended)
G. Trichloroethylene (preferred)
H. Perchloroethylene
I. Methylethylketone
J. Isopropyl Alcohol
K. Medium Grit Emery Paper
L. Lint Free Cloth
M. Latex Type Gloves
N. Safety Glasses
O. Heat Lamp (to speed curing time).
P. Scotch Brite

Hysol® is a registered trademark of Dexter Corporation.
Sempak® is a registered trademark of Courtaulds Aerospace, Glendale, CA.
Dexter Adhesive & Coating Systems
2850 Willow Pass Road, Bay Point, CA. 94565 Tel: (925) 458-8000 Fax: (925) 458-8030

2. Safety Precautions

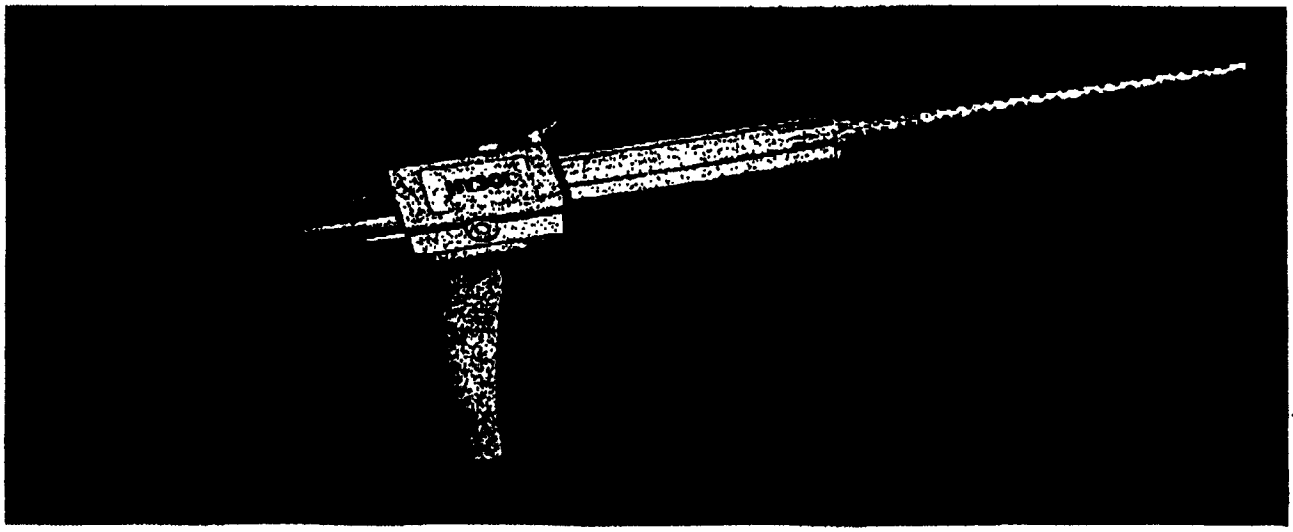
A. Use cleaning solvents and HYSOL EA 9394 in a ventilated area.
B. Wear protective clothing, gloves, and safety glasses as required.
C. Refer to Material Safety Data Sheets for cleaning solvents and HYSOL EA 9394 for safe handling and use.

3. Surface Cleaning and Preparation.

A. Find Manufactures nameplate / agreed upon location on component and choose an area near to it for placement of the Contact Memory Button. If the Manufactures Name Plate/ agreed upon location is not accessible when component is installed on the weapon system, then locate an area for placement of the CMB that is accessible. If there is no Manufactures nameplate on the component, then locate an area that is accessible when component is installed on the weapon system for CMB placement.
B. Clean the selected location using one of the cleaning solvents listed in 1.C., preferably Trichloroethylene.
C. Use a lint free cloth to apply the cleaning solvent. Remove all oil and/or solids.
D. Prepare surface for installation of CMB.
E. Clean area with cleaning solvent.
F. Allow area to dry completely.

4. Application of Contact Memory Button.

The following is a picture of the Manual Dispenser with EA9394 Cartridge and EPSGMIX50 Static Mixing Nozzle installed:



A. Using Hysol EPSG50MAN Manual Dispenser insert 4:1 Ratio Plunger into manual dispenser. To insert 4:1 Ratio Plunger push up on silver lever on back of Manual Dispenser and slide Plunger through slot on front of Dispenser.

B. Insert EA 9394 50ML Cartridge onto manual dispenser. To do this push up on top lever on manual dispenser and insert EA 9394 cartridges into the groove provided and close top.

C. Uncap EA 9394 50ML cartridge and insert EPSGMIX50 Static Mixing Nozzle.

D. Thoroughly mix HYSOL EA 9394 as per manufactures mixing instructions. See Instructions below:

WARNING: THIS HYSOL KIT SHOULD BE USED WITH ADEQUATE VENTILATION. AVOID EXPOSURE TO VAPORS. AVOID CONTACT WITH SKIN AND EYES. REFER TO PRODUCT MATERIAL SAFETY DATA SHEET FOR SPECIFIC HANDLING AND SAFETY PRECAUTIONS BEFORE USING THIS HYSOL SEMPAK PACKAGE. FOR OPTIMUM PERFORMANCE, MATERIAL AND KIT SHOULD BE 77°F/25 °C.

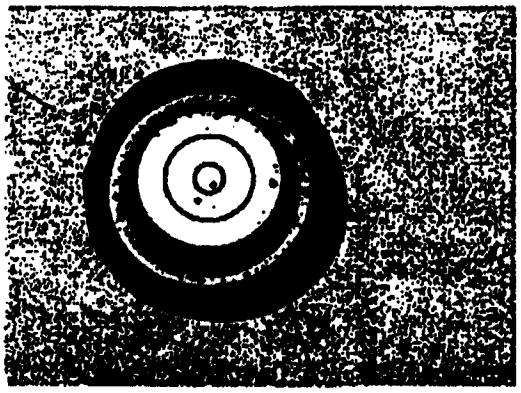
HYSOL® SEMPAK® DUAL CARTRIDGE/ STATIC MIXER KIT INSTRUCTIONS FOR USE

1. Place kit into applicator gun.
2. Remove cap and expel a small amount to assure even ratio and even flow, typically a one to two inch bead is satisfactory.
3. Clear orifice if necessary and attach static mix nozzle.
4. Dispense a quarter inch wide bead the length of the static mixer to assure proper mixing before usage. Do not use this purged material, or any material, which does not appear homogenous in color or consistency.
5. Repeat step 4 upon every change of static mixer nozzle.
6. Replace cap to store.

E. RECOMMENDATIONS FOR USE OF THIS PRODUCT ARE BASED UPON TESTS WE BELIEVE TO BE RELIABLE. MANUFACTURER AND/OR SELLER ARE NOT RESPONSIBLE FOR RESULTS WHERE PRODUCT IS USED UNDER CONDITIONS BEYOND OUR CONTROL. UNDER NO CIRCUMSTANCES WILL MANUFACTURER AND/OR SELLER BE LIABLE FOR DAMAGES TO ANYONE IN EXCESS OF THE PURCHASE PRICE OF THIS PRODUCT.

F. Apply only enough HYSOL EA 9394 to the area, so that when the CMB is installed a small bead will form around the outer edges of the CMB. Be sure to use latex type gloves when handling HYSOL EA 9394.

G. Lightly press the CMB on to the HYSOL EA 9394. Ensure a small bead of adhesive forms around the edges of the CMB. The following picture shows a CMB with the bead of EA 9394 around the edges:



H. Hold the CMB in place with slight pressure for about 5 to 10 minutes. If any adhesive gets on the top of the CMB, gently wipe clean with one of the cleaning solvents.

I. Handling strength for HYSOL EA 9394 will occur in 8 hours at 77F/25C. HYSOL EA 9394 maybe cured for 3 to 5 days at 77F/25C to achieve normal performance. Curing can be accelerated by placing a heat lamp on the area for 1 hour at 150F/66C. When using heat lamp for curing, be sure to follow heat lamp manufacture instruction for safe operations. Ensure all flammable materials are clear of the area to be heat-treated.

J. Have a Quality Assurance Representative (QAR) inspect area for FOD in all critical area's or on safety of flight critical components. Have a Collateral Duty Inspector (CDI) inspect area for FOD in non-critical area or non-safety of flight critical components.

K. Clean and paint any exposed component surface area after curing of the HYSOL EA 9394. Follow proper maintenance procedures in type weapon systems Maintenance Instruction Manuals. Do not get primer or paint on top portion of CMB, because this could affect the reading and writing to the CMB.