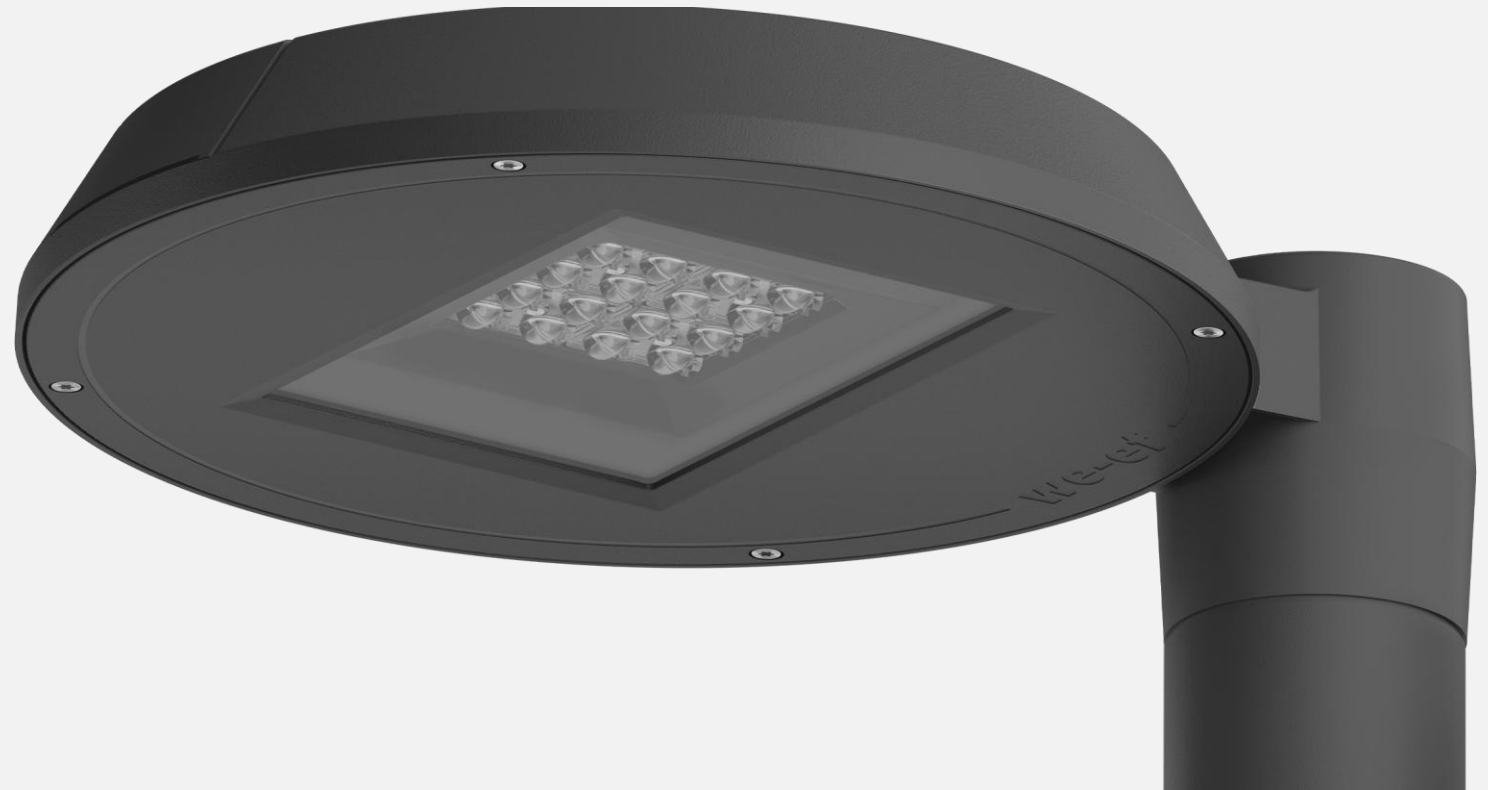


RFL110



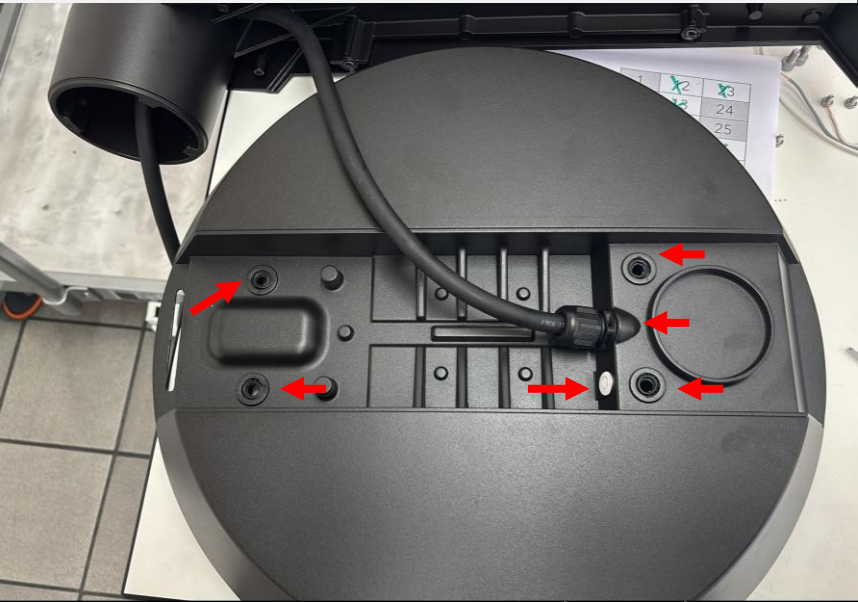
SOP	RFL110			we-ef
Relevant Products	Part No.	Description	Operator Experience Level (1-5)	
	1 - 18	RFL assembly		
Approved	BS		Date	27.06.2025
Reviewed	DMU		Date	27.06.2025
Revision 1.0				

SOP-0005-RFL110

RFL110

we-ef

1



2

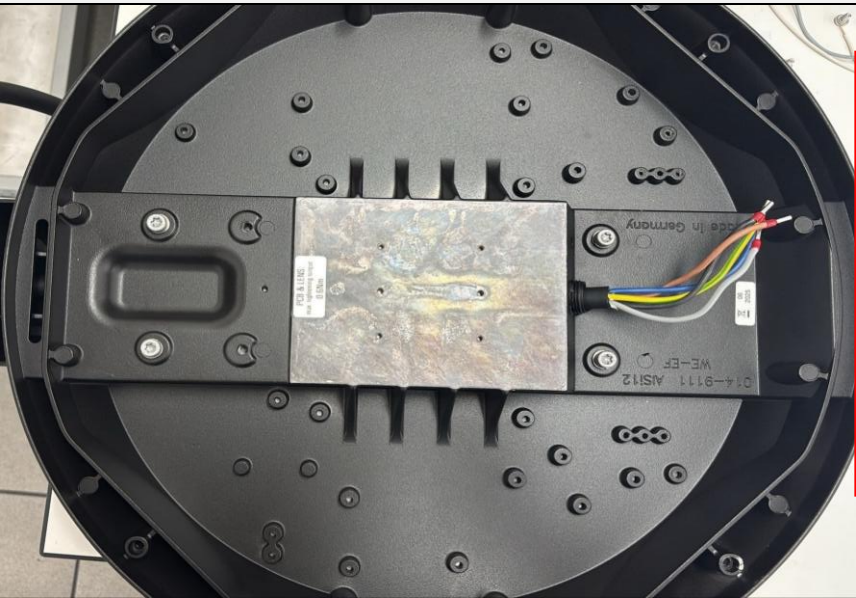


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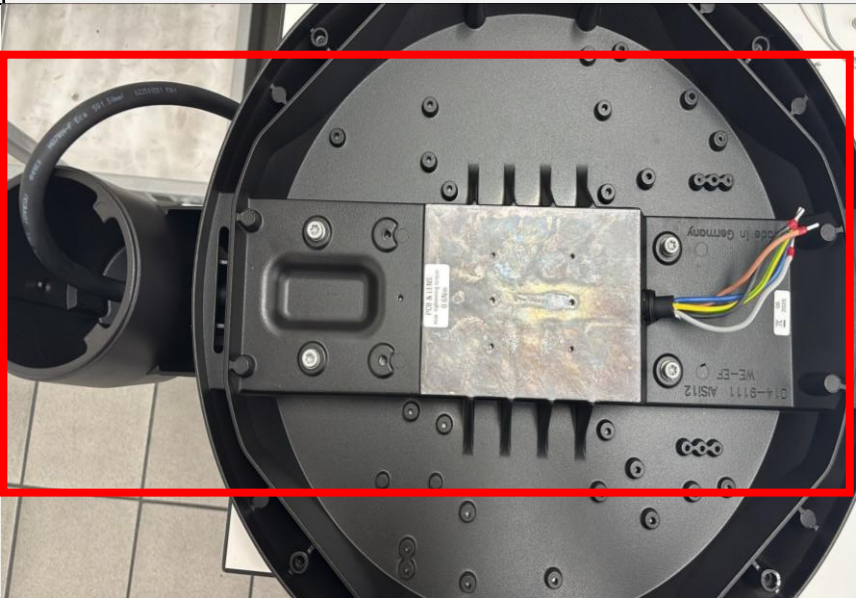


Operation	Step	Sequence	Tool	Bit	No	Type	Set	Inspection
Montage RFL	1	The housing (014-9112) is required for production						(Use for R2C 014-9113)
	1	The cable gland (004-0898) is glued into the housing.						
	1	The pressure equalisation element (004-3462) and the O-rings (003-3690) are glued into the housing						
	2	The next step is to use the required attachment piece (014-9154/014-9118).						

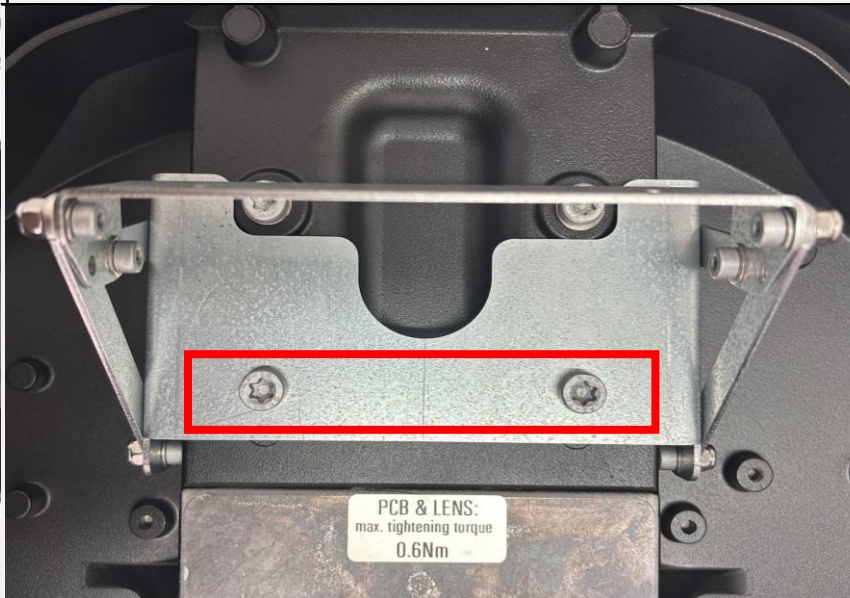
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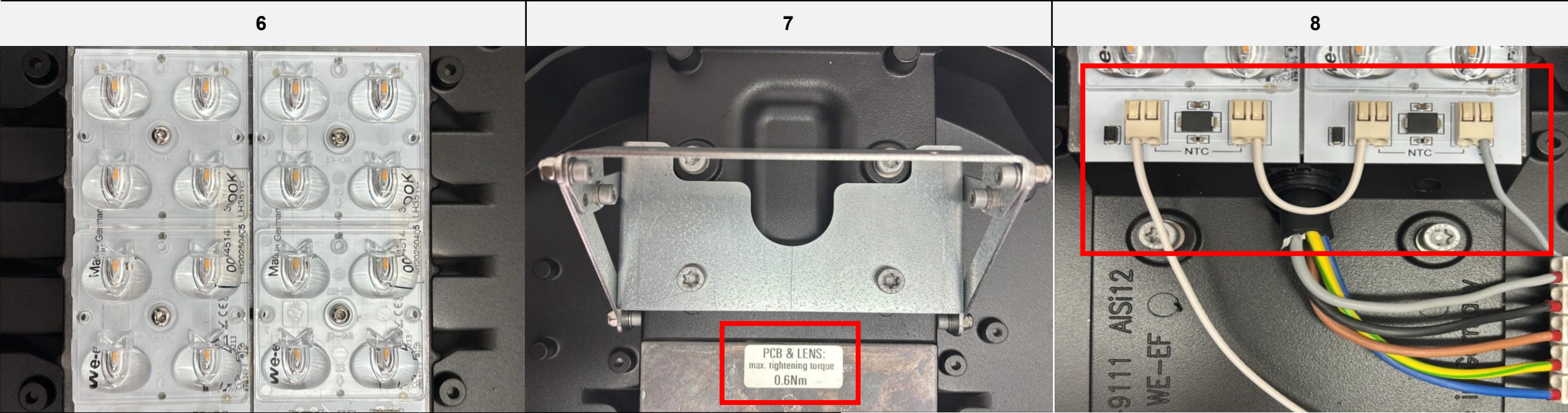
4



5



Operation	Step	Sequence	Tool	Bit	No	Type	Set	Inspection
Montage RFL	3	The attachment piece is fitted with 4x M6x16 (002-3436) and 4x spring ring (002-0433)						
	4	The connection cable (see parts list) is fed through the attachment piece into the inner housing.						
	5	The assembly hinge is permanently mounted in the housing with 2x M6x12 (002-2712).						Achtung das Assembly hinge wird durch die Lebenshilfe gefertigt

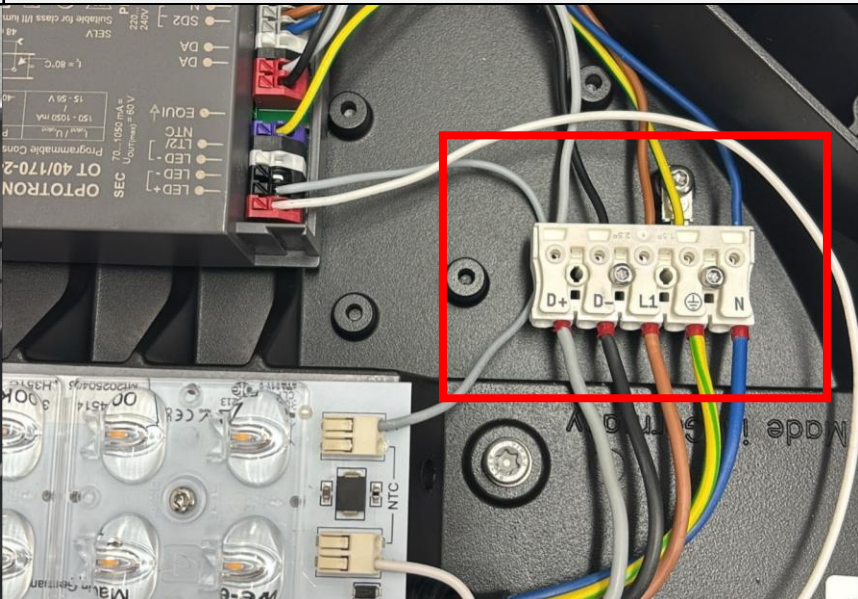


Operation	Step	Sequence	Tool	Bit	No	Type	Set	Inspection
Montage RFL	6	Mount the circuit board and lens (according to parts list) in the housing with 4x 3x8 (002-3291)						Die Schrauben sind mit 0,6Nm festzuziehen.
	7	The sticker (006-1884) with the torque specification must be affixed to the housing.						
	8	Wire the circuit boards as follows.						

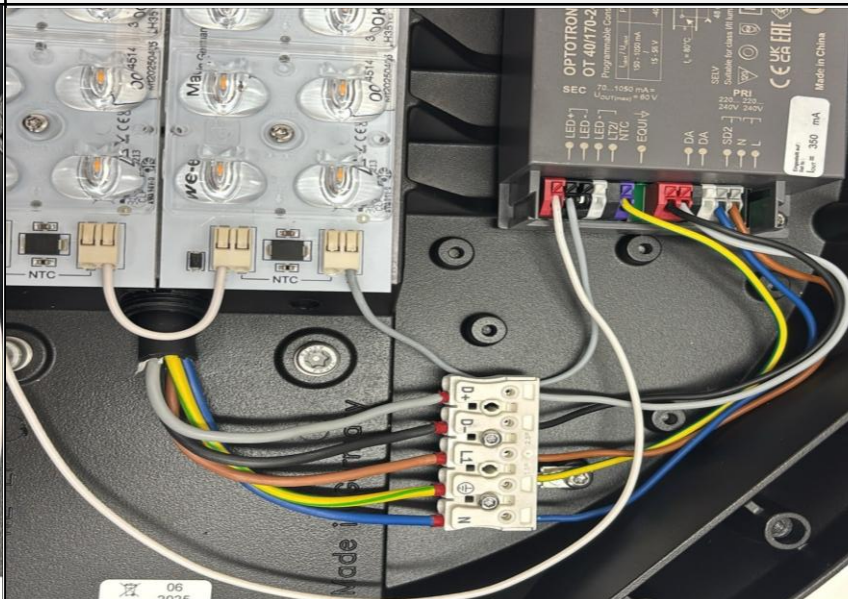
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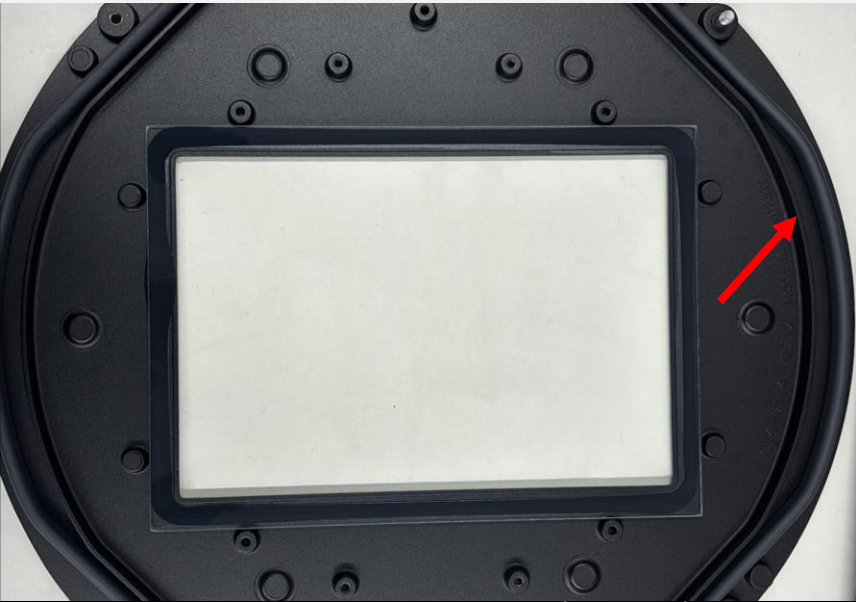


11

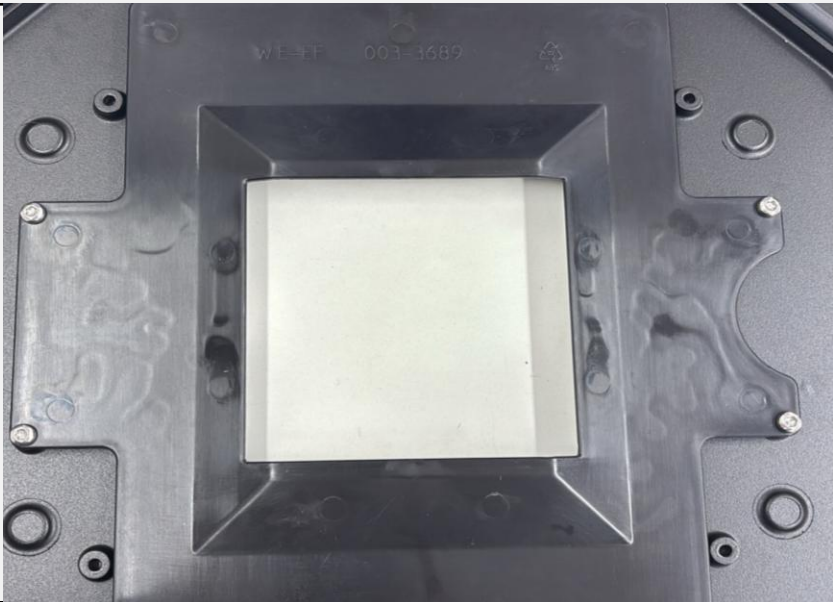


Operation	Step	Sequence	Tool	Bit	No	Type	Set	Inspection
Montage RFL	9	The power supply unit (according to the parts list) is fastened with 2x M4x6 (002-3291)						
	10	The plug-in terminal (see parts list) is fastened with 2x M3x16 (002-3290) and 1x M4x6 (002-3291)						
	11	Wire the light according to the wiring diagram						In b7 verfügbar

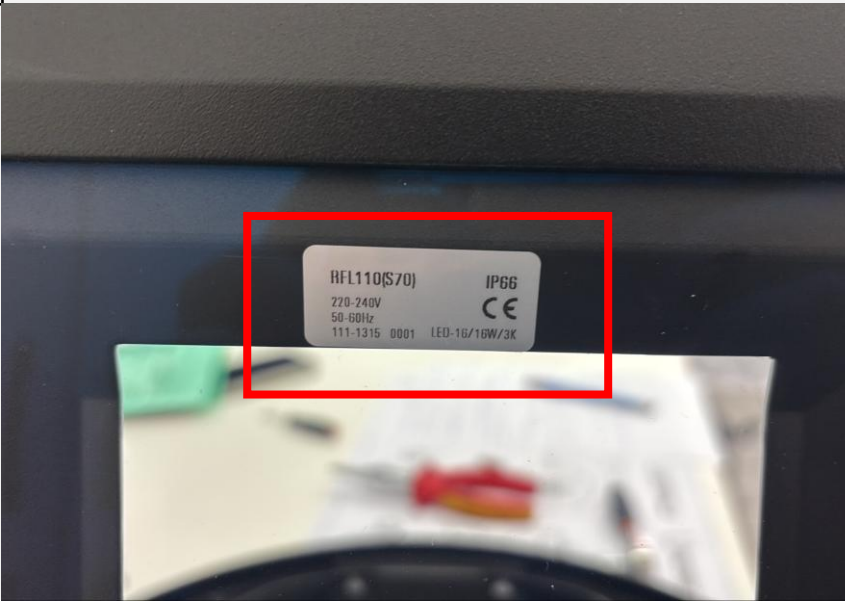
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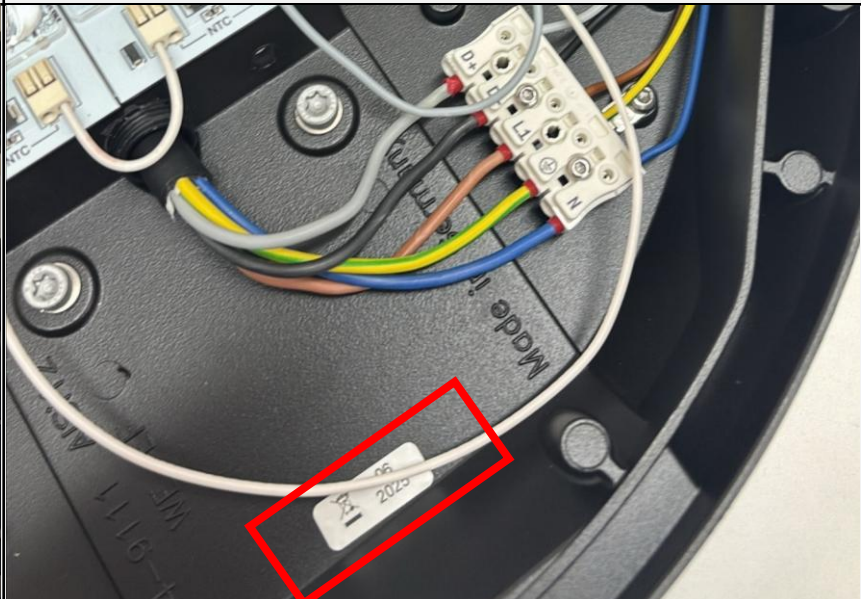


Operation	Step	Sequence	Tool	Bit	No	Type	Set	Inspection
Montage RFL	12	The glass (003-7884) is glued into the frame (014-9114)						The Datron gluing machine is used for this purpose
	12	After the drying time, the seal (003-4102) is glued in with adhesive						
	13	The lamination is screwed to the frame with 4x M4x6 (002-3291)						
	14	The type/performance label (006-0239) must be placed on the inside of the lamination						

15



16



Operation	Step	Sequence	Tool	Bit	No	Type	Set	Inspection
Montage RFL	15	The frame is now screwed tight with the assembly hinge using 2x M4x6 (002-3291)						
	16	The production sticker is placed in the housing.						
		Close the frame and lock the light with 4x M6x18 (002-2720)						

17

18



Operation	Step	Sequence	Tool	Bit	No	Type	Set	Inspection
Montage RFL	17	2x grub screw: (M8) 002-3037 / (M10) 002-3359						
	18	2x grub screw: (M8) 002-3293 / (M10) 002-2359						
	Carry out a 100% functional test of the luminaire							

[illegible]