

# Face Plate & Front Board

## Installation Instructions

1. Solder all the SMD components to the Front board and the Face Plate on both sides.
2. Be aware that it is very difficult to differentiate between the cathode or anode side for the special reversed mounting SMD LED's for the Face plate. Use a DMM in the Diode mode to make sure you mount them correctly.
3. While adding the THT parts, the silkscreen can be used to figure out to what side of the board the components need to go, but take extra care of soldering them to the right side.
4. The 100uF caps can now be mounted on the Front board. Note that C79 is a 35V version. Before you clip the leads, use a DMM and check for shorts.
5. Make sure that the two DUT connectors will fit the rectangular holes in the Face plate. There are no specifications for them, so we don't know if they will always fit. Use a fine file to make them fit if needed, but use tape to protect the front of the Face plate in case you slip, to avoid scratches.
6. Solder the two DUT connectors flush to the Front board. Solder only one pin each to allow for easy removal and adjustments.
7. You can now solder the 3 terminal blocks to the Front board, facing away from the Face plate.
8. You can also add the 2.54mm male connector strips, they are used to connect the Front board to the Main board.
9. There are a number of test points, now is a good time to populate them.
10. Add the trim pots.
11. Add the wire bridge just above the DUT switch. It is there to preserve signal integrity.
12. We can now start to add the parts that will determine the mechanical connection between the Front board and the Face plate.

The distance between the Face Plate and the Front Board should be 18mm, measured on the inside of the two boards. This allows for just enough room for the Current Range selector and the Step selector, which are the tallest components. The 18mm distance is mainly created by the toggle switches.
13. Remove all rings from the toggle switches and add just one nut about half way on the shaft.
14. Verify that the Current Range rotary switch S101 has 6 positions. If not, remove the nut and the anti-slippage ring from the switch and check that the blocking ring of the switch is in position 6. Add the anti-slippage ring and tighten the nut well. Verify that you now have 6 positions.
15. Put the Current range switch in position on the bottom of the Front board and measure the height from the board to the top of the nut. It should be a bit less than 18mm. If not, you can use a fine file to remove up to 1mm from the four plastic stand-off pins. Solder only the center pin of the Current Range rotary switch so it is flush to the Front board and can still be easily removed.

16. The lock of the Steps rotary switch S3 needs to be adjusted so that there are only 8 positions. Secure that well with a nut. Position the Step selector rotary switch on the board. Be careful of the position and solder only the middle pin. It's not easy to have it flush and vertically centered to the board so you may have to adjust it.
17. Mount the Offset toggle switch S20 and the X-Amp toggle switch S70 to the Face plate. You should have already one nut on the shaft. Mount the two switches with a nut on the Face plate such that the shaft still protrudes a fraction above the nut on the Face plate. This is only such that it is visually pleasing and there is enough room for the nut. Loosely tighten the other nut so the switch is in position but can still be moved and turned.
18. Put the Face plate on top of the Front board and position the two switches so the pins are in the holes of the Front board. While using a caliper, adjust the distance between the two boards by raising or lowering the switch pins in the board. Start with the X-Amp switch and position it well. The pins of the switch could be flush with the board. Solder only one pin of the switch in position. Soldering only one pin will allow you to readjust the 18mm distance between the boards.
19. Now do the same with the Offset switch. Verify that the distance between the boards is 18mm.
20. Remove the nuts from the two switches on the Face plate side and separate the two boards again. Make sure you keep the other nuts on the switches undisturbed.
21. Mount the DUT selector toggle switch S71 and the Voltage Range selector switch S100 on the Face plate in the same way and put the Face plate again in position on top of the Front board such that the pins of the two switches are in their respective holes on the PCB.
22. Verify the 18mm distance between the Face Plate and the Front Board again and proceed to solder one pin of each switch to the Front board.
23. Remove the two nuts of these switches and separate the two boards again.
24. Mount the Polarity switch S72 to the Face plate and adjust the height with the two nuts but keep them loose enough.
25. Put the two boards together again and position the Polarity switch. When the distance is 18mm, solder one pin. Remove the nut from the Face plate side.
26. Now add the BJT/FET and the Sweep/DC switches the same way, checking the 18mm and solder just one pin.
27. You can now also mount the Current and Voltage potmeters. You can remove the nuts and rings from the Current potmeter as they are not needed, but keep only the nut on the Volt potmeter. It is used to adjust the 18mm distance. Hold the potmeters flush to the board and solder one pin.
28. Finally, you can mount the Step Output rotary switch S21. Because this switch does not have a stop, it does not really matter how you position it on the Front board. However, the bottom hole on the Front board is pin 1 (the 50nA/50uV position), so you could position it using that way. It can be mounted rather flush to the board, but don't bend the fragile pins. The total height of the switch is such that the shaft may not protrude enough through the Face plate to secure the knob. Raise the switch as much as possible from the bottom of the Front board while the pins are still protruding 0.5-1mm on the solder side to make good soldering easy. Solder

only the center pin first. Leave the nut on this switch. It will be used to adjust the 18 mm distance.

29. Once you have all switches and potmeters soldered and positioned, you can now make a final adjustment of the sandwich before you solder everything permanently. Mount the two boards together and adjust all nuts on the switches and the Step Output rotary switch and Volt potmeter for a precise adjustment of the 18mm distance across all four sides of the two boards. If needed, you can now still reposition the depth of the switches in the Front board with a solder iron.
30. Once you are satisfied, you can go ahead and solder all the pins of the switches, the DUT sockets and the potmeters.
31. The Offset and Delay potmeters are mounted on the Face Plate itself. The Step Delay potmeter has a locking pin. To secure the Offset potmeter, use the anti-lock ring between the potmeter and the Face plate to better secure it. Both parts will be connected to the Front Board by short wires. Note where the Tap pin of P20, the Offset potmeter goes to. Also note where the two pins of the switch from the Step Delay potmeter need to go to. With the potmeter in the fully CCW position, the switch should be closed.
32. Add a piece of shielded cable between pin 5 of S22 labeled B/G to pin 2 of S71, the DUT selector switch also called B/G. The cable should be grounded only on one end, you can use the large hole called ISO just below the B/G pin of the DUT switch. Use a bit of shrink tube to make sure the shield at the S21 side is covered.
33. The 2mm banana jacks are mounted on the Face Plate and will be connected to the Front board through short wires. Make sure that the C and E wires can handle 2Amps. Do not connect the wires and do not solder them to the Front board until you have verified the complete operation of the Curve Tracer, by using the Verification and Calibration document. Soldering these connections makes it much harder to take the Sandwich apart.
34. To make room for the sandwich in the enclosure, use a side cutter to remove the two most forward mounting studs on the bottom and top of the enclosure to make it fit. You can use a sharp side-cutter to do that. Note that the top cover can only be mounted one way because there are slots. The cover with the holes for the screws is the bottom of the enclosure.