



# Strada-2X2MX Installation guide

The following instructions should be observed before using the product to ensure reliable assembly. Fastening can be done by using screw or adhesive. Recommended operating temperature (PMMA) is  $-40^{\circ}\text{C}$  to  $+80^{\circ}\text{C}$ .

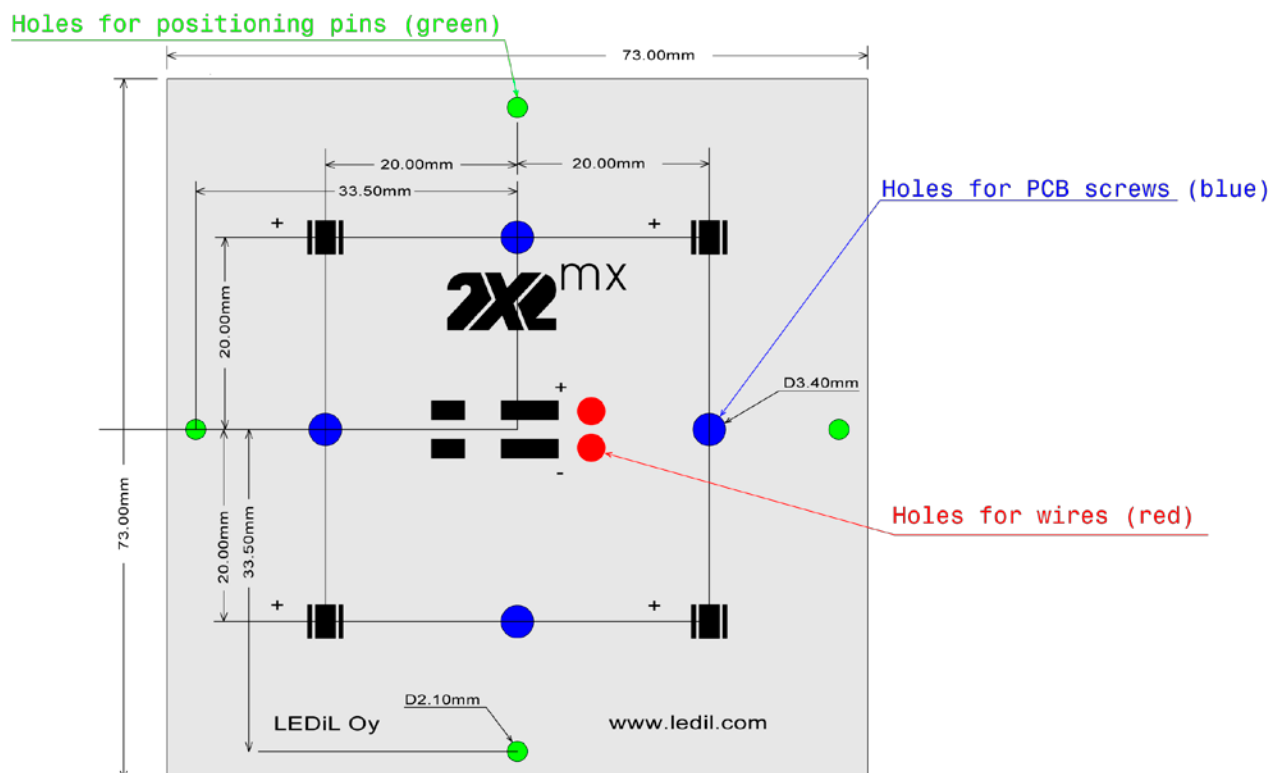
1. Heat sink machining
2. PCB Layout
3. Screw requirements
4. Assembly
5. Fastening

## 1. Heat sink machining

- Cable holes and screw thread holes must be done before lens assembly.
- Ensure that anodized heat sink surface is even
- Correct thickness of the PCB is 1.6 mm (position pin length 1.1 mm)
- Screw thread hole accuracy is  $\pm 0.1$  mm
- Screw vertical straightness tolerance is  $\pm 10.1$  mm A

## 2. PCB Layout

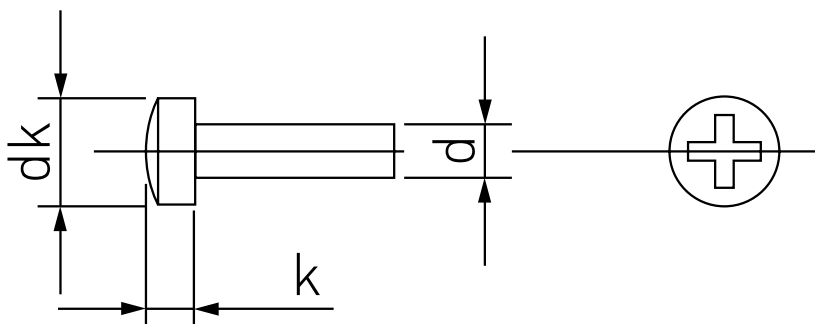
- Minimum of two (2) position pin holes are needed for accurate lens assembly, depending on the desired direction of the lens
- Recommended width for position pin holes is 2.10 mm ( $-0$  mm  $+0.1$  mm)





### 3. Screw requirements

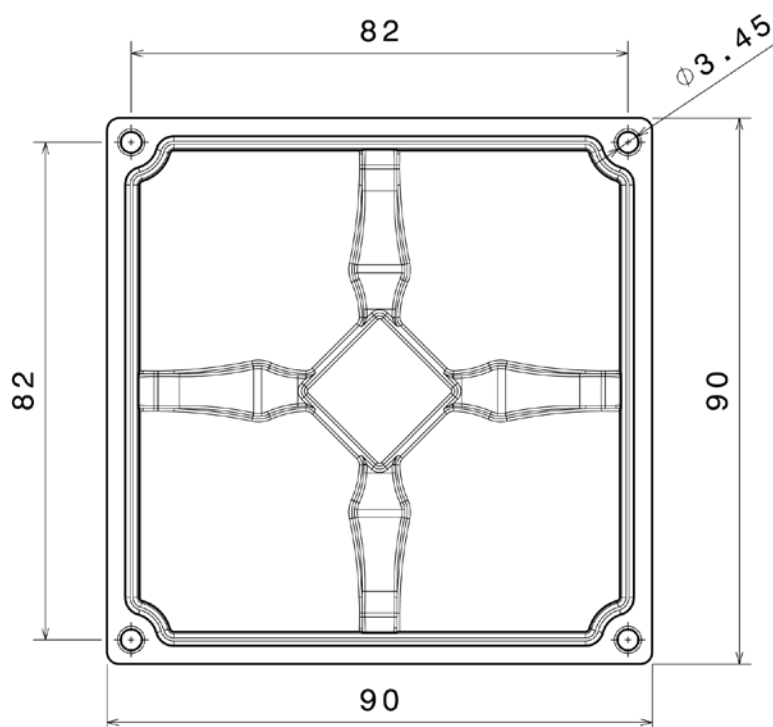
- STRADA-2X2MX lens attachment screws are of type M3 (DIN 7985, ISO 7045/ISO 14583 TX)
- Countersunk screw is not allowed
- Self-tapping screws are not recommended



DIN 7985	
Thread Size	M3
dk	6 mm
d	3 mm
k max	2,52 mm
L	4-22 mm

### 4. Assembly

- Maximum torque for lens assembly is 0.6Nm
- It is recommended to leave at least 1-2mm space between the lenses
- Make sure that the silicone gasket is not twisted in any point under the lens



Like all PMMA lenses STRADA-2X2MX is also prone to environmental stress cracking. Please make sure that chemicals used in the fixture manufacturing do not cause stress cracking risk with PMMA.

For more details about the heat sink machining, chemicals, heat control etc. please refer to the LEDiL Installation Guide: [ledil.com/installation\\_guide](http://ledil.com/installation_guide)