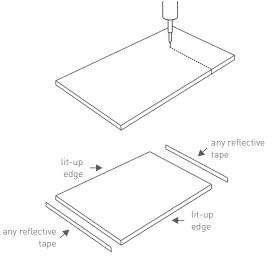# assembly instructions

1. Start the assembly process with the preparation of the acrylic sheet. First, cut the sheet to the desired size using a CNC router or laser cutter (we recommend laser cutter for best results).
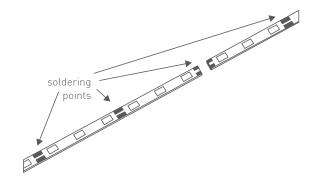Secondly, polish the edges of the acrylic sheet with a flame edge or
polishing machine. Use the polishing paste.
When finished, cover the edges (which will not be used for lighting) with white reflective tape so the light won't escape the acrylic sheet.

any reflective tape

lit-up edge

lit-up edge

any reflective tape

2. Once the acrylic sheet is done, you can start the process of LED lighting preparation. Keep in mind that one LED strip is 500mm long, so for a 1000mm long edge you will have to use two LED strips, for a 750mm edge - one and a half LED strips and so on. To do this, you will have to solder the LED strips together.
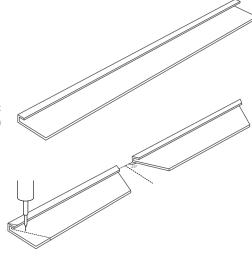
Note: Solder the LED strips a bit further from the edge, so the soldering point should not break. Minimum distance between soldering points is 45mm

Note 2: If one of the lit-up edges is 1500mm or greater (i.e. 3 or more LED strips soldered together), the power supply should be connected from both ends.

soldering points

3. Cut the heat sink according to the size of your acrylic sheet (the full length of the heat sink is 5000mm). CNC, laser, plasma or saw cutting can be used.

Note: the corners of the heat sink have to be cut at precisely 45° degrees which will create a high quality finish at the corners without gaps.
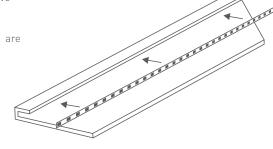
4. Cut the reflector backer. Make it a bit larger than the acrylic sheet. For example, if the size of the sheet is 500 x 500mm, the reflector should be 502 x 502mm.

Note: handle the reflector with care, so you don't bend it, add any dirt or grease because that could impede the performance of the light panel.
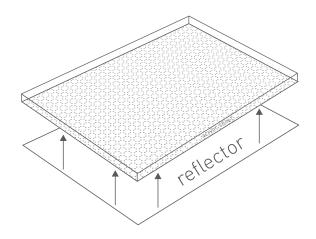
assembly instructions

5. Use the attached 3M double-sided adhesive tape to fix the LED strips to the heat sink(s). Take care not to break the soldering points. Check if LED the strips are working and are fitted correctly and firmly attached.
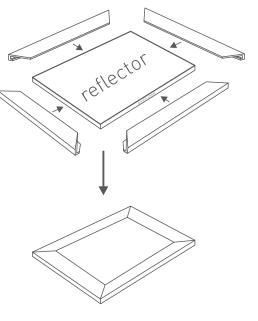
6. Attach the reflector to the back of the acrylic sheet.

Note: reflector is two-sided - gloss and matte. Make sure that the gloss side of the reflector remains on the outside.

7. Attach the heat sink(s) to the acrylic sheet and reflector.

8. Finally, use a strong 3M 30-80mm adhesive tape to attach the heat sink to the reflector to make the construction stronger.