

# STANDARD OPERATING PROCEDURE

Section : Package Manufacturing

Revision : 1 11/3/04

Title : Assembly Procedure for Package Body and Base

## 1.0 PURPOSE

- This procedure defines a standard procedure, used to bond R-Pack plastic bodies to gold plated heat sink bases.

## 2.0 SCOPE

- This procedure applies to R-Pack plastic bodies that require sealing to metal heat sink type bases, or ceramic type bases.

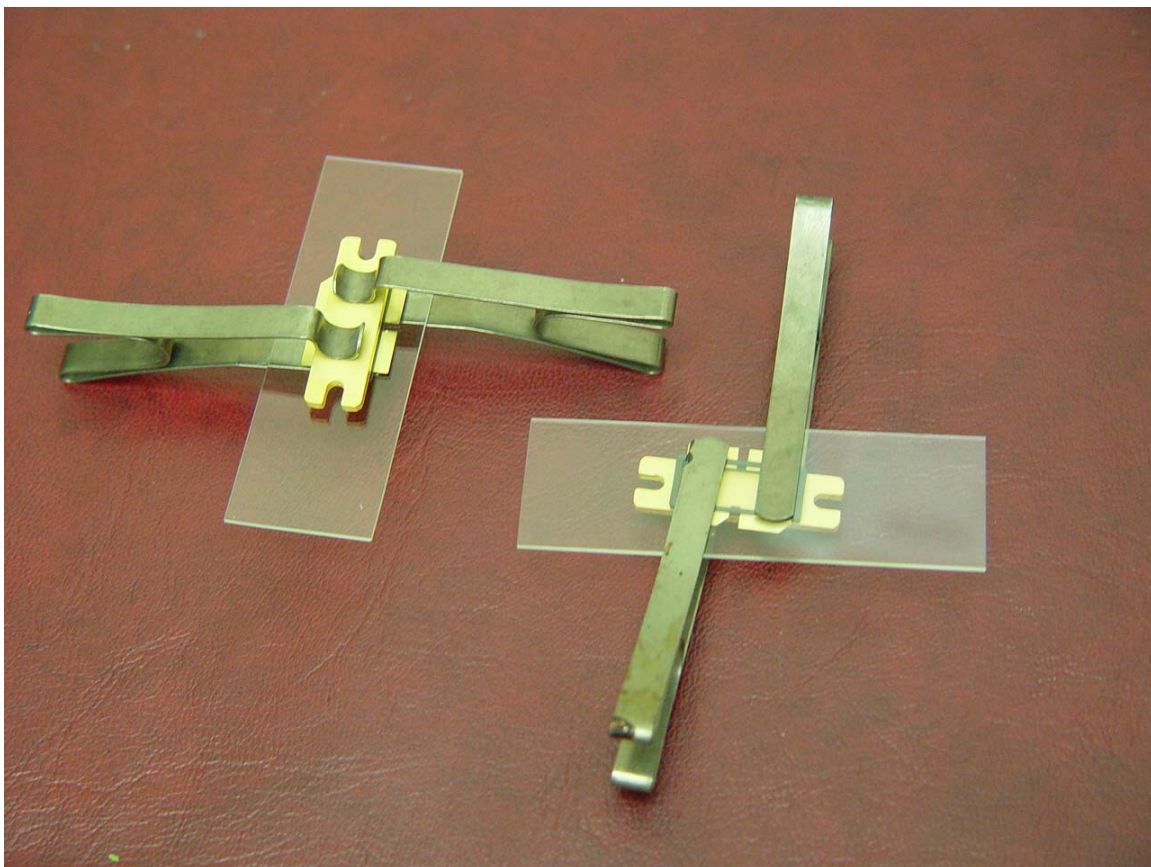
## 3.0 DEFINITIONS

- N/A

## 4.0 REQUIREMENTS

## 5.0 PROCEDURE

- 5.1 The bodies are clamped onto the Heat sink bases with a glass slide on the top of the assembly where the lid will eventually be sealed. Multiple clamps are used as shown.



# STANDARD OPERATING PROCEDURE

Section : Package Manufacturing

Revision : 1 11/3/04

Title : Assembly Procedure for Package Body and Base

5.2 The test assemblies are then placed in the oven after the oven's temperature has stabilized at 165°C ( $\pm 5^\circ\text{C}$ ).

5.3 After 60 minutes, the assemblies are removed from the oven.

- Allow the assemblies sufficient time to cool, with the clamps in place.
- Do not proceed to step 5.4, until the assemblies are cool.

5.4 Remove the clamps from the assemblies.

## 6.0 MATERIALS and EQUIPMENT

- Finger Cots or Gloves
- Microscope Slides - Glass Laboratory Type
- Oven - capable of temperature control of  $\pm 3^\circ$  Celsius
- Spring (type) Clamps – individual clamp pressure of 0.75 lbs. to 1.0 lbs.
- 60 minute timer

## 7.0 REFERENCED DOCUMENTS

- N/A

## 8.0 ATTACHMENTS

- N/A