

**TITLE** T0-5 CRYSTAL MOUNT/CURE

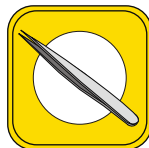
**DOC. NUMBER** 9-02-92

**DESC.** T0-5 (HC-35) HEADER, PRECISION  
CRYSTAL MOUNT AND OVEN CURE.

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**APVL.**

FIND	PART#	DESCRIPTION	QTY.
1	XT-129	HEADER T05	1
2	XM-142	X-TAL BONDING	A/R
3	XX-175	30 GA. NEEDLE	1

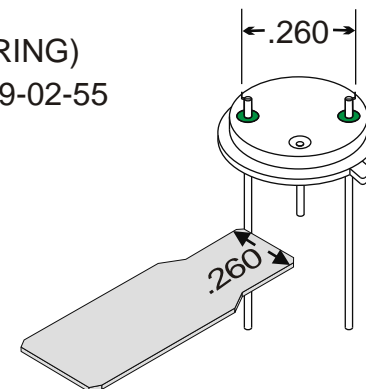
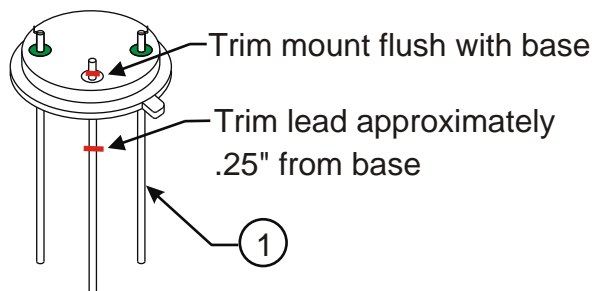


REFER TO GENERAL  
RULES (MANUFACTURING)  
WORK INSTRUCTION 9-02-55

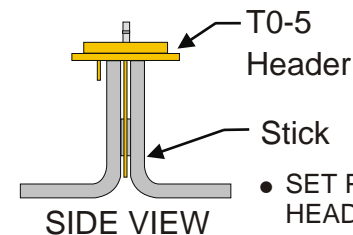
## STEP 1 WORK SETUP

PREPARE HEADER FOR CRYSTAL MOUNT

- TRIM LEAD AND MOUNTING TAB ON HEADER AS SHOWN.



- PLACE .26 GAUGE BETWEEN MOUNTING TABS TO SET CORRECT SPACING



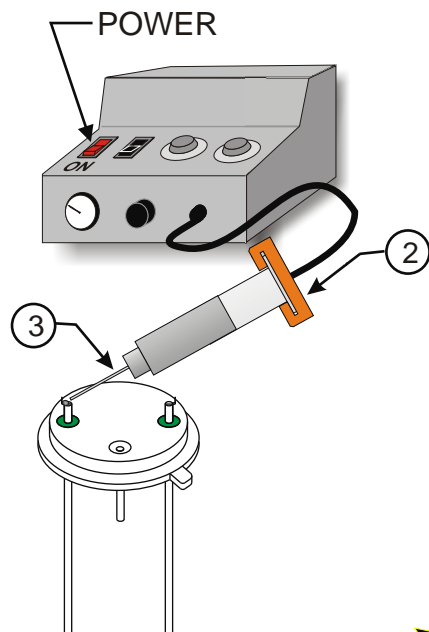
## STEP 2 PROCESS STEPS

CEMENT ONE MOUNT OF  
HEADER

- TURN ON DISPENSER, DIAL SHOULD READ APPROXIMATELY 25 PSI.

NOTE: TRANSFER EPOXY FROM 1 cc SYRINGE TO 3cc SYRINGE BEFORE USING.

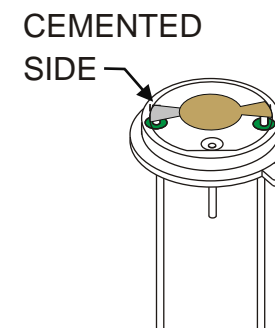
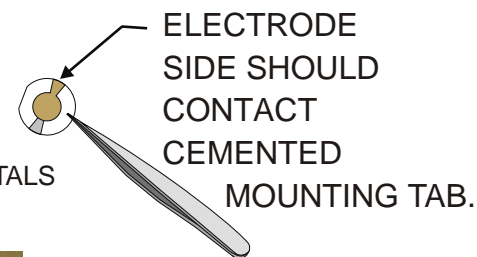
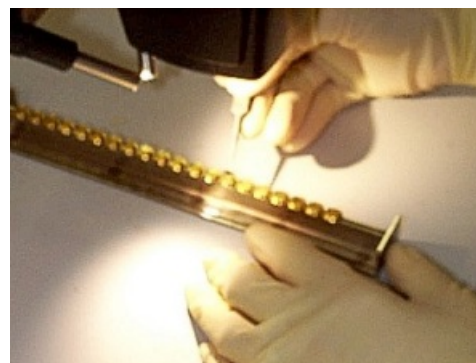
- APPLY A SMALL DOT OF CEMENT TO ONE MOUNT OF HEADER BY DEPRESSING FOOT PEDAL.



## STEP 3 PROCESS STEPS

MOUNT CRYSTAL

- SUPERVISOR WILL SUPPLY CRYSTALS FOR MOUNTING.





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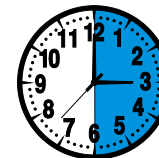
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### STEP 4 PROCESS STEPS

#### BAKE IN IR OVEN

- BAKE MOUNTED CRYSTALS IN 20" IR OVEN FOR 1/2 HOUR AT 150 DEGREES CENTIGRADE.
- MAKE SURE CRYSTAL ASSEMBLIES ARE PROPERLY IDENTIFIED BEFORE GOING INTO OVEN.



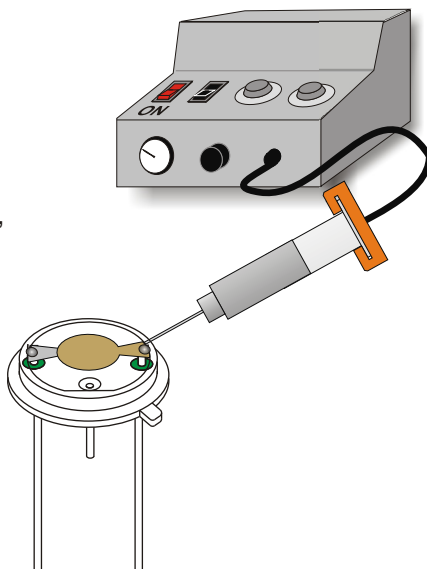
← 150°C.

### STEP 5 PROCESS STEPS

#### FINISH CEMENTING CRYSTAL

- APPLY CEMENT TO BOTH SIDES OF CRYSTAL..
- COMPLETE YIELD LOSS DATA SHEET.
- FOLLOW NON-CONFORMING PRODUCT PROCEDURE 13-01, SEGREGATE ALL NON-CONFORMING PARTS.
- SWITCH OFF EPOXY DISPENSER AND CLEAN NEEDLE WHEN FINISHED.

STORE CEMENT IN FREEZER WHEN NOT IN USE, DISCARD CEMENT ONE WEEK AFTER OPENING.



### STEP 7 PROCESS STEPS

#### BRUSH SCRUB

- HOLD BASE OF CRYSTAL WITH TWEEZERS AND LIGHTLY BRUSH WITH ALCOHOL.
- BLOW OFF EXCESS ALCOHOL WITH NITROGEN.



### STEP 6 PROCESS STEPS

#### BAKE IN IR OVEN

- BAKE MOUNTED CRYSTALS IN 20" IR OVEN FOR 1 HOUR AT 180 DEGREES CENTIGRADE.



← 180°C.

### STEP 8 PROCESS STEPS

#### BAKE IN IR OVEN

- BAKE MOUNTED CRYSTALS IN 30" IR OVEN FOR PROGRAMMED CYCLE.

#### PROGRAMED CYCLE

- 1 HOUR @ 200°C
- 2 HOURS @ 290°C
- 8 HOURS @ 200°C