

NOTES:

- THIS PART IS MADE IN ONE OF 36 DIFFERENT DASH NUMBER VARIATIONS DEPENDING ON WHICH OF THE 4 DASH NUMBER VARIATIONS OF THE A0140 DIODE-SPACER ASSEMBLIES ARE USED, WHICH OF 2 CAPACITOR VALUES ARE USED, WHETHER THE DIODE LEAD ATTACHED TO THE SPACER IS TRIMMED OR LEFT LONG, AND WHETHER THE DIODE LEADS ARE LEFT STRAIGHT OR ARE BENT. THE TABLE AT THE RIGHT SHOWS THE CORRESPONDANCE BETWEEN DASH NO. AND THE VARIOUS COMBINATIONS.
- THE PROCEDURE ON THIS SHEET MAKES A -X0X0- PART, (I.E. THE VERSION WITH STRAIGHT LEADS). IF THE BENT LEAD -X0X0- VERSION IS NEEDED, THE CONTINUATION PROCEDURE ON SHEET 2 IS USED.
- THE CAPACITORS (ITEMS 2 AND 3) MUST BE HANDLED WITH GLOVED HANDS AND NON-METALLIC TOOLS ONLY. TOUCHING THE CERAMIC TO A METAL SURFACE WILL LEAVE MARKS ON THE CERAMIC WHICH ARE PARTIALLY CONDUCTING AND CAN CAUSE BREAK DOWN AT HIGH VOLTAGE.

DIODE-CAPACITOR ASSY FABRICATION PROCEDURE

- REMOVE ITEM 1 FROM THE DEEP FREEZER, SQUEEZE BUT THE AMOUNT WHICH WILL BE NEEDED, AND RETURN THE REMAINDER TO THE FREEZER.
- SELECT THE APPROPRIATE CAPACITOR PER THE DASH NO. TABLE (ITEM 2 OR 3) AND COAT THE METALIZED AREA ONLY ON ONE SIDE WITH A VERY THIN LAYER OF ITEM 1.
- PLACE THE CAPACITOR EPDXY SIDE UP IN THE SPACE PROVIDED IN THE FIXTURE.
- IF THE DASH NUMBER OF THE PART IS OF THE FORM -XX-TX-CCXX, (I.E. IF THE PART IS TO HAVE A TROWED LEAD, THEN USE A SHARP FLUSH CUTTING DYKES TO TRIM THE LEAD ATTACHED TO THE SPACER AS CLOSE AS POSSIBLE TO THE EDGE OF THE SPACER.
- APPLY ITEM 1 TO ITEM 4, TO THE SIDE OF THE CORRIGATED SPACER ON WHICH THE DIODE LEAD IS SOLDERED. APPLY TO THAT ONE SIDE ONLY. FILL THE GROOVES FLUSH TO THE TOP, THEN ADD AN ADDITIONAL AMOUNT OF APPROX. 2 CU. MILLIMETERS IN THE CENTER. USE EXTREME CARE TO AVOID GETTING EPDXY ON ANY PART OF THE LEAD EXCEPT WHERE IT IS SOLDERED TO THE SPACER.
- CAREFULLY LOWER ITEM 4 INTO PLACE OVER THE CAPACITOR IN THE FIXTURE. USE EXTREME CARE TO INSURE THAT EPDXY DOES NOT CONTACT ANY PART OF THE CAPACITOR EXCEPT THE METALIZED AREA. ANY EPDXY ON THE BARE CERAMIC PORTION OF THE CAP WILL CAUSE REJECTION OF THE ASSEMBLY.
- SLIDE THE PLUNGER DOWN ONTO THE ASSEMBLY, AND PUT THE SPRING MECHANISM IN PLACE TO PROVIDE GREATER DOWNWARD FORCE ON THE PLUNGER.
- BAKE THE COMPLETED ASSEMBLY ONE HOUR AT 100 DEG C.
- REMOVE THE COMPLETED PART FROM THE FIXTURE AND INSPECT FOR ANY EPDXY ON THE BARE CERAMIC PORTION OF THE CAPACITOR. PACK THE PARTS IN FOAM LINED CONTAINER WHICH HAS SEPARATE COMPARTMENTS FOR EACH PART SO THAT THE CERAMIC PART OF THE CAPS CAN NOT COME INTO CONTACT WITH THE METAL PORTION OF OTHER PARTS.

REV	DESCRIPTION	BY	DATE
A	INITIAL RELEASE	HEH	10CT94
B	CHANGED CAPACITORS	PCB	200CT97

DASH NUMBER TABLE		
DASH NO.	DESCRIPTION	PICTURE OF COMPLETED PART
-PD-TX-CCXX	POSITIVE, OUTER, TRIMMED LEAD	
-PD-EX-CCXX	POSITIVE, OUTER, EXTENDED LEAD	
-PI-TX-CCXX	POSITIVE, INNER, TRIMMED LEAD	
-PI-EX-CCXX	POSITIVE, INNER, EXTENDED LEAD	
-ND-TX-CCXX	NEGATIVE, OUTER, TRIMMED LEAD	
-ND-EX-CCXX	NEGATIVE, OUTER, EXTENDED LEAD	
-NI-TX-CCXX	NEGATIVE, INNER, TRIMMED LEAD	
-NI-EX-CCXX	NEGATIVE, INNER, EXTENDED LEAD	

-PDR C000-0000, USE ITEM 3 C000 PF CAP
FOR C000-0000, USE ITEM 2 C000 PF CAP

X+8 SPECIFIES THE STRAIGHT LEAD PART (AS PRODUCED BY THE PROCEDURE ON THIS SHEET).

X+8 SPECIFIES THE BENT LEAD PART (WHICH IS MADE FROM THE -S PART BY THE PROCEDURE ON SHEET 2).

10	USE A0145	FIXTURE, CAPACITOR BONDING	
4	1	A0140	DIODE-SPACER ASSEMBLY UCB
3	1	020C003603BA	CAPACITOR, BARE CERAMIC, 2200PF CERAMITE
2	1	020C003603BA	CAPACITOR, BARE CERAMIC, 2200PF CERAMITE
1	A/R	967-	SILVER LOADED EPDXY ABLESTICK
ITEM NO.	QTY	PART NO.	DESCRIPTION
LIST OF MATERIALS			

THIS Dwg MADE ON AUTOCAD REV 12

FILE NAME: CAPDIAS7

DRAWN BY: H. HEETDERKS

4 OCTOBER, 1994

SHEET 1 OF 2

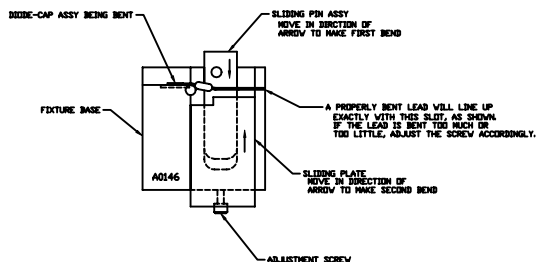
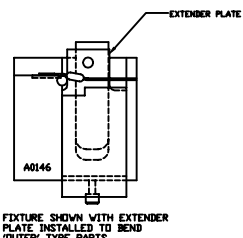
DIODE-CAPACITOR ASSEMBLY LEAD BENDING

NOTES:

- THIS PROCEDURE TAKES ANY OF THE 16 VERSIONS OF THE -XX-XS-CCXX DIODE CAPACITOR ASSEMBLY (THE STRAIGHT LEAD VERSIONS), AND CONVERTS IT INTO A -XX-XB-CCXX (BENT LEAD) VERSION.
- THE A0146 FIXTURE IS USED FOR THIS PROCEDURE. WHEN BENDING PARTS WITH DASH NUMBERS OF THE FORM -X1-XS-CCXX (I.E. 'INNER' VERSIONS OF THE PART), THE FIXTURE IS USED AS SHOWN IN THE FIGURE BELOW. WHEN BENDING AN 'OUTER' TYPE PART, C-XDX-S-CCXX THE EXTENDER PLATE MUST BE ADDED TO THE FIXTURE ASSEMBLY AS SHOWN IN THE FIGURE AT THE RIGHT.

BENDING PROCEDURE:

- USING A GLOVED FINGER, HOLD THE DIODE-CAPACITOR ASSY WITH THE CAPACITOR IN THE SHALLOW DEPRESSION PROVIDED IN THE FIXTURE AS SHOWN IN THE FIGURE BELOW.
- SLIDE THE SLIDING PIN ASSEMBLY ALL THE WAY AGAINST THE SCREW STOP TO FORM THE FIRST BEND.
- THEN SLIDE THE SLIDING PLATE AWAY FROM YOU TO STOP AGAINST THE PIN AND THUS FORM THE SECOND BEND.
- WHILE CONTINUING TO HOLD THE CAPACITOR IN PLACE, WITHDRAW THE PIN AND THE SLIDING PLATE ABOUT 10 INCHES AND VERIFY THAT THE END OF THE LEAD OF THE BENT PART IS ALIGNED WITH THE SLOT CUT INTO THE FIXTURE BASE. IF THE PART IS BENT TOO MUCH, OR TOO LITTLE, ADJUST THE SCREW SLIGHTLY UNTIL THE PARTS ARE BEING BENT CORRECTLY.
- REMOVE THE COMPLETED PART FROM THE FIXTURE AND PLACE IT IN A FOAM LINED STORAGE CONTAINER WHICH HAS INDIVIDUAL POKETS FOR EACH PART. BE VERY CAREFUL THAT THE CERAMIC SURFACES OF THE CAPACITORS DO NOT CONTACT ANY METAL SURFACE.



THIS Dwg MADE ON AUTOCAD REV 12

FILE NAME: CAPDIAS7

DRAWN BY: H. HEETDERKS

4 OCTOBER, 1994

SHEET 2 OF 2