


<p><i>Istituto Nazionale di Fisica Nucleare</i></p> 	Document # <b>INFN-LAT-MECH-009-02</b>	Date Effective 28 September 2004
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	Subsystem/Office GLAST Tracker Tray	
	Document Title Adhesive Preparation	

## Adhesive Preparation

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## Change History Log

<b>Revision</b>	<b>Effective Date</b>	<b>Description of Changes</b>
1	Sept. 16, 2004	Initial Release
2	Sept. 28, 2004	Update

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## 1 Purpose

The present document describes the preparation of adhesive to use before all bonding.

The vacuum bell jar will be reserve for the exclusive use of the GLAST program, only for epoxy adhesive.

## 2 Scope

The goal is to increase the bond adhesion, avoid contamination during the process the bonding.

## 3 Acronyms and Definitions

EM	– Engineering Model
GLAST	– Gamma-Ray Large Array Telescope
Plyform	– Trays Manufacturing
MEK	– Methyl Ethil Kethone
IPA	– Isopropyl Alcohol
TKR	– Tracker
TVAC	– Thermo vacuum Test

## 4 Applicable Documents

Documents relevant to the development of this procedure include:

- [1] LAT-PS-01584, Mid Tray Assembly Procedure
- [2] Tart Report, Pisa 09/02/2004

## 5 Preparation of Adhesive

Degas the mixed adhesive before application to surfaces to be bonded:

- a. Mix larger quantities than need.
- b. Degas mixed adhesive in bell jar. – Pump on mixture until bubbles stop appearing and have broken, release vacuum, then repeat at least one more time.
- c. Transfer needed quantity to clean surface.
- d. Transfer small quantity on aluminum disk for coupon hardness test (ASTM D2240-91).