

MODULE ASSEMBLY

v28012019

Date/ Time: Operators: Temp: C°

Module FSM Side (A/B) CB shell CBtop cover
LIS R0: L1: Status

Module+CB+LIS FAM
MODCBLIS

Unpack from

Gas Tightness tests

step	LeakRate [cc/bar/s]	DecayConst [s]	Comments
Db:Module			from Db
Db: CB TopCover			from Db
CB TopCover			remeasured
Module			remeasured with test CB
M+CBShell			Module with CBshell
M+S+Topcover (MODCB)			Module+Shell+TopCover
MODCB+tape			+ aluminum tape

comments:

Check List

Assembling CB Shell and Topcover to Module	Check
Check markings side A / B	
Clean and Check Shell before assembly	
Clean flange surfaces	
Prepare Loctite SI598	
Clean fiber surface with isopropanol and nitrogen. And insert the pins (! small and big !)	
Apply Loctite to the flange surface	
Mount the Shell to the module	
Second check, tighten all rods perfectly	
Place the cover for protection.	
wait 24 h Start: Stop:	
Remove excess Loctite-residues and do the gas tightness test	
Fix (and cover) the bellows	
Clean Shell and fibers with nitrogen	
Clean Topcover surface with nitrogen and check the connectors (ESD!)	
Place the seal on the Shell	
Slowly remove the tape of the SiPM surfaces (ESD!!!)	
Mount the Topcover on to the Shell	
Do the last gas tightness test and cover joints with tinned-copper-tape	
Check all the labels. Now it's ready for other tests	
Assemble LIS boards Right 0: Left 1:	

Place to