

MODULE ASSEMBLY

v28012019

Date/ Time: Operators: Temp: C°

Module FSM Side: CB shell CBtop cover
LIS R0: L1: Status

Module+CB+LIS MODCBLIS FAM Side(A/B):

Unpack from

Gas Tightness tests

step	LeakRate [cc/mbar/min]	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 CB Topcover to Module	Check
Find the correct Module nr. and delete it out the box position in DB	
Check markings side A / B	
Fill in the datasheet; check DB for values of gas tightness module	
Make a new gas tightness test of the module	
Clean and check CB Shell before assembly	
Clean flange surfaces	
Prepare Loctite SI598	
Clean fiber surface with isopropanol with 50% H2O and ionized nitrogen and insert the pins (small and big pins)	
Apply Loctite to the flange surface	
Mount the CB Shell to the module	
Second check, tighten all rods perfectly	
Place the cover for protection	
Wait for 24 hours Start: Stop:	
Remove excess Loctite-residues and do the gas tightness test	
Select/choose a CB Topcover from the DB	
Fix (and cover) the bellows on the CB Topcover, ESD Safe!	
Clean CB Shell and fibers with ionized nitrogen	
Clean the CB Topcover and check the connectors, ESD Safe!	
Place the seal on the CB Shell	
Slowly remove the tape of the SiPM surfaces, ESD Safe!	
Mount the CB Topcover on the CB Shell (corners: 3-Makita others: 4-Makita)	
Do the gas tightness test	
Cover joints with tinned-copper-tape	
Do the final gas tightness test	
Place all the labels on the Module	
Assemble LIS boards	