

**SNS CHOPPER “GLUE UP” PROCEDURE:
9/26/01**

- 1. Measure aluminum plate thickness and dielectric thickness prior to gluing.
Record results.**
- 2. Clean all surfaces with ethanol.**
- 3. Mix Eccobond 45 / Catalyst 15 to a “rigid” mix ratio.**
- 4. Apply a thin layer (.002” - .003”) of epoxy to the underside of the substrate.**
- 5. Assemble meander line board to aluminum base plate.**
- 6. Install .020” shims between meander strips and aluminum separators.**
- 7. Install vented fasteners.**
- 8. Install weight fixture.**
- 9. Apply weight.**
- 10. Allow “weighted” assembly to cure for 48 hours.**
- 11. Fabricate two test specimens with each assembly.**
- 12. Remove shims after assembly has cured.**
- 13. Stamp and date all pieces.**
- 14. Measure glued-up assembly to determine epoxy thickness. Record results.**
- 15. Conduct epoxy strength test on one of the test specimens. Save the second test specimen for future reference.**