

CONFORMAL COAT WORK SHEET

Assembly Work Order

Project:

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Assembly Name:	Drawing Number:	Build To Rev.	Assembly Serial Number:
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SPECIAL INSTRUCTIONS:
 -HANDLE PER M.I.T ANTI-STATIC HANDLING PROCEDURE 99-01003
 -REFERENCE DOCUMENTS
 -NASA-STD-8739.3
 -NASA NHB 5300.4(3J)

Step No.	Type	Description	Perf By:	Date
9	A	CONFORMAL COAT P.C. BOARD PER NHB 5300.4(3J)		
		-WHILE PREPARING CONFORMAL COAT, HEAT BOARD FOR 1 HOUR AT 60C		
		-PREPARE CONATHANE CE1155 PER M.I.T DETAIL SPECIFICATION QAP-D-322		
		-ADD MATERIAL USED, BATCH #, ETC. TO THE "MATERIAL PROCESSING MIXING RECORD" FOR ASSEMBLY BEING COATED		
		-M.I.T. Q.A. VERIFY CONTROL SAMPLE		
		- APPLY CE 1155 BY POURING AND BRUSHING PER NHB 5300.4(3J)		
		-COAT ONE SIDE OF BOARD AT A TIME TO AVOID BUILD UP AND LEAD BRIDGING THAT OCCURS WHEN HANGING TO DRY.		
		-INSTALL PCB ON STANDOFFS WHILE CURING		
		-INSPECT FOR BUBBLES AND BRIDGING WHILE IN CLEAN BENCH. REWORK AS NEEDED.		
		-CURE OVERNIGHT IN CLEAN BENCH AT 75°F±9°F AND 30%-60% RELATIVE HUMIDITY		
		-COAT OPPOSITE SIDE AND CURE AS ABOVE		
		-M.I.T Q.A. INSPECT WITNESS SAMPLE AFTER 24 HOURS FOR TACKINESS		
		-HEAT CURE, IF NECESSARY, PER MANUFACTURERS DATA SHEET		
		-IF HEAT CURED, RAMP UP AND DOWN Δ 1 HOUR		
10	A	REMOVE MASKING MATERIAL, CLEAN OFF RESIDUE		
11	A	CONFORMAL COAT CONNECTOR WIRE TO P.C. BOARD WITH BRUSH. DOUBLE COAT TEFLON WIRES.		
12	I	M.I.T. Q.A. INSPECT		
13	A	TOUCH UP AS NEEDED WITH BRUSH		
14	I	INSPECT BOARD AND WITNESS SAMPLE		
		M.I.T. Q.A.		

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