

DETAIL SPECIFICATION -SPOT BONDING COMPOUND-COMPONENTS

<u>MATERIAL</u>	LSE SPEC #	PREPARED BY:
URALANE 5753A		QA:
URALANE 5753B	QAP-D-321	PROJECT:

1.0 SCOPE

THIS SPECIFICATION COVERS THE PREPARATION, HANDLING, AND DISPOSAL OF URALANE 5753 A AND B FOR USE IN SPOT BONDING ELECTRONIC COMPONENTS ON P.W.B.'S AND HARNESSSES ON ELECTRONIC ASSEMBLIES.

2.0 APPLICABLE DOCUMENTS

- NASA SPECIFICATION NHB 5300.4(3J).
- GSFC INSPECTION OF POLYMERIC MATERIALS-APPLICATIONS MANUAL.
- FURANE PRODUCTS CO. TECHNICAL INFORMATION BULLETIN FOR URALANE 5753 A/B
- FURANE PRODUCTS CO. MSDS SHEET FOR URALANE 5753 A/B.

3.0 HANDLING

- HANDLING IN ACCORDANCE WITH URALANE 5753 A/B MSDS SHEET.
- FIRE AND REACTIVITY- HAZARDS SLIGHT.
- TOXICITY- HAZARDS HIGH FOR PART A
- HANDLE WITH VINYL GLOVES. MIX IN FUME HOOD.
- PRE-HEAT UPON RECEIPT IF CRYSTALLINE. 1 HOUR@60C

4.0 DISPOSAL

- CURED SAMPLE TO BE STORED AS WITNESS SAMPLE FOR A MINIMUM OF 30 DAYS; THEREAFTER, DISPOSE WITH DAILY TRASH DISPOSAL.
- UNCURED LIQUID TO BE DISPOSED OF VIA CSR SAFETY PERSONNEL THROUGH M.I.T. SAFETY OFFICE.

5.0 MIXING PROCEDURE

- URALANE 5753 'A' WILL REACT WITH MOISTURE; THEREFORE:

-CLEAN BEAKERS, MIXING RODS, SPATULAS, ALUMINUM DISHES, ETC WITH REAGENT GRADE ISOPROPYL ALCOHOL PRIOR TO USE.

-PREPARE URALANE 5753 B

-MIX CAN CONTENTS, THOROUGHLY, WITH METAL SPATULA

-USING OHAUS CT 1200 SCALE, PLACE 5 GRAMS OF URALANE 5753B IN AN ALUMINUM DISH.

-PURGE URALANE 5753B CAN WITH NITROGEN AND COVER.

-ADD PART A TO PART B

-USING OHAUS CT 1200 SCALE, ADD 1 GRAM OF URALANE 5753A TO PART B IN ALUMINUM DISH.

-DO NOT MIX OR AGITATE WHILE POURING. LEAVE PRECIPITATE AT BOTTOM OF BOTTLE. INSURE PRECIPITATE IS NOT ABOVE 3/8" MEASURED FROM BOTTOM OF BOTTLE.

-PURGE URALANE 5753A BOTTLE WITH NITROGEN AND COVER.

-ADD ~5 GRAMS OF ALUMINUM OXIDE TO THICKEN.

-MIX WITH METAL SPATULA FOR 1 MINUTE.

-SEPARATE CONTROL SAMPLE FROM BEAKER AND PLACE IN OVEN AT 100°C FOR 5 MINUTES

-EVACUATE BEAKER FOR 2-3 MINUTES.(OPTIONAL)

-USE AS IS OR TRANSFER TO SYRINGE FOR APPLICATION.

-CURE

-24 HOURS AT 25°C - FULL CURE. (USABLE AFTER OVERNIGHT CURE)

-8 HOURS AT 95°C - FULL CURE.