

ESR pre-shaping procedure

Document prepared by Vladimir Berdnikov and Josh Crafts
Approved by Alexander Somov

Procedure preparing steps:

Step 1. Make sure that APE (appropriate protective material) is used. For pre-shaping procedure only rubber gloves is required.

Step 2. Make sure that working area is clean.

Step 3. Prepare pre-shape assembly. Clean all surfaces and contacts with ESR material with isopropil alcohol. See pic.1



Pic 1. Assembly preparing

Step 4. Make sure oven is empty and clean for procedure to continue. See pic.2

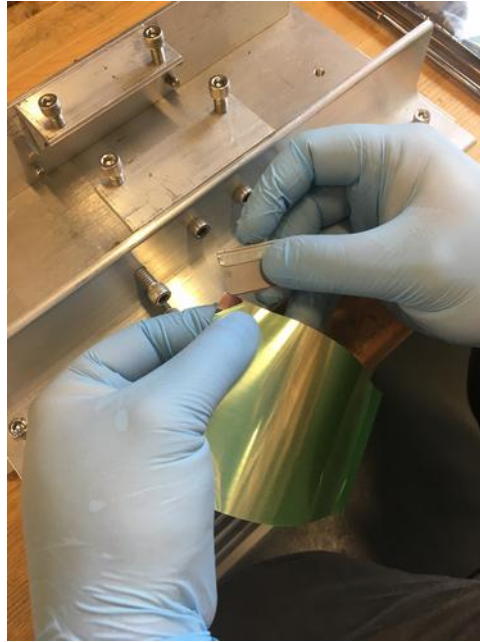


Pic 2. Oven overlook

Assembly steps:

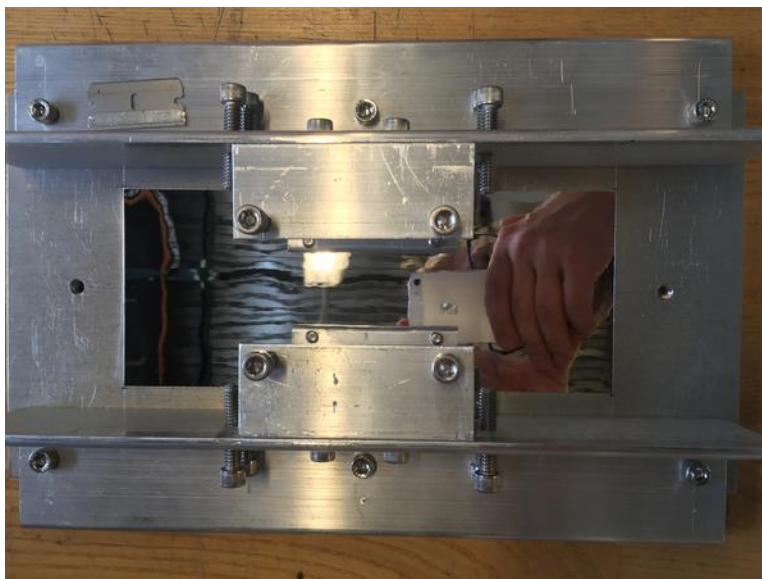
Step 5. Remove ESR foils from static bag. Make sure that ESR forms ready (cut appropriate), clean and have no deformation.

Step 6. Use razor blade to peel off corner of ESR protective coating. See pic.3 Use fingers to peel back one side off protective coating. Green coating go first, than clear coating.



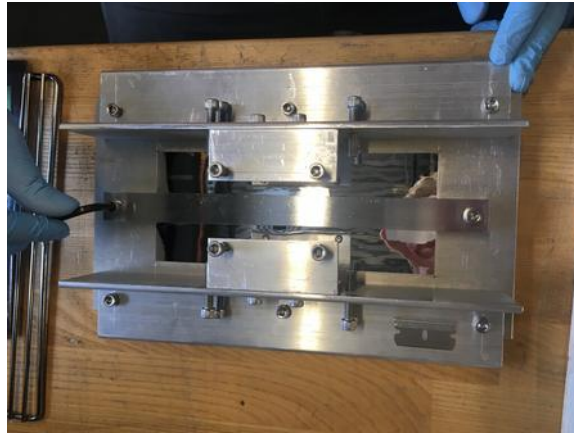
Pic.3 Protective coating removing

Step 7. Put ESR in the middle of assembly using prescribed markers. See pic. 4 Make sure side with clear protecting cover is facing up.



Pic 4. ESR film installation

Step 8. Put central bar, line it with the holes in the plate. Screw down central bar tightly. See pic. 5



Pic 5. Central bar installation

Step 9. Use fingers to gently peeled up one side of ESR and insert first side bar from the side and make sure arrows point toward to center. See pic. 6

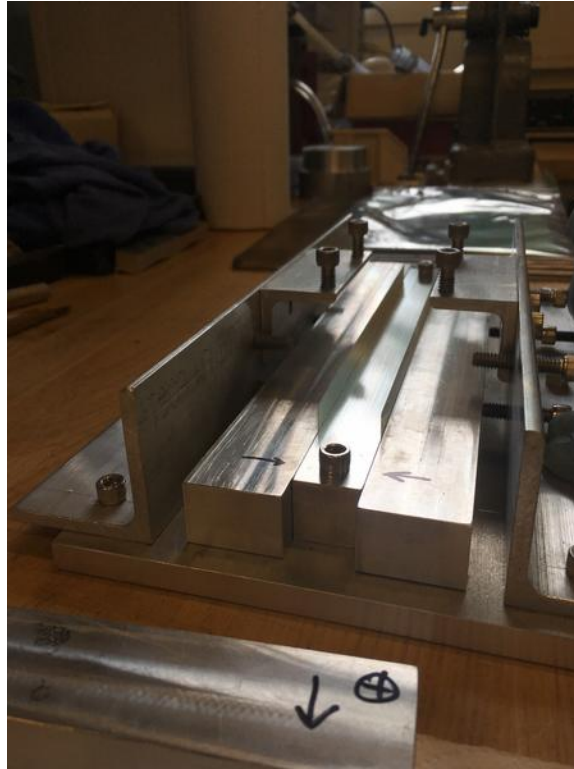


Pic 6 . Side bar installation

Step 10. Repeat step 9 for opposite side.

Step 11. Select one side then using finger applied tension to ESR upwards. Tighten bottom side screws while alternating.

Step 12. Repeat step 11 for opposite side. See pic 7.



Pic.7 Side bars installed

Step 13. Insert top plate from the side. Lift top plate to fold down the top of ESR. See pic. 8 . When plate is in place use top screws to provide pressure downwards.



Pic. 8 Top plate insert

Step 14. Repeat step 13 for opposite side.

Step 15. Tighten top side screws. Make sure all screws are tight. Pre-shape assembly is ready for oven.

Heating procedure :

Step 16. Make sure the oven is plugged. Place the assembly to the oven.
See pic. 9



Pic.9 Assembly in the oven

Step 17. Turn the oven on. Adjust the dial indicator between the end of white marking and first yellow triangle. See pic.10



Pic10. Dial indicator position

Step 18. Heat oven up to 100° C. Keep eye on temperature, if needed adjust indicator.

Step 19. Prepare to set a timer. Once stable 100° C achieved start timer for 10 minutes.

Step 20. After 10 minutes on the timer return dial full left. Leave oven to control the temperature. Wait till oven indicator shows 50° C.

Step 21. Using shop rags remove the assembly from the oven. Be caution hot metal parts!

Step 22. Remove preshaped ESR from the assembly using the reverse assemble process. Start from step 15 proceed to step 7 .

Step 23. Place preshape ESR to static bag. See pic 11.



Pic11. Pre-shaped ESR

Step 24. Repeat assembly an heating process as needed.

Step 25. Turn off the oven, return all used material to appropriator locations, clean working place.