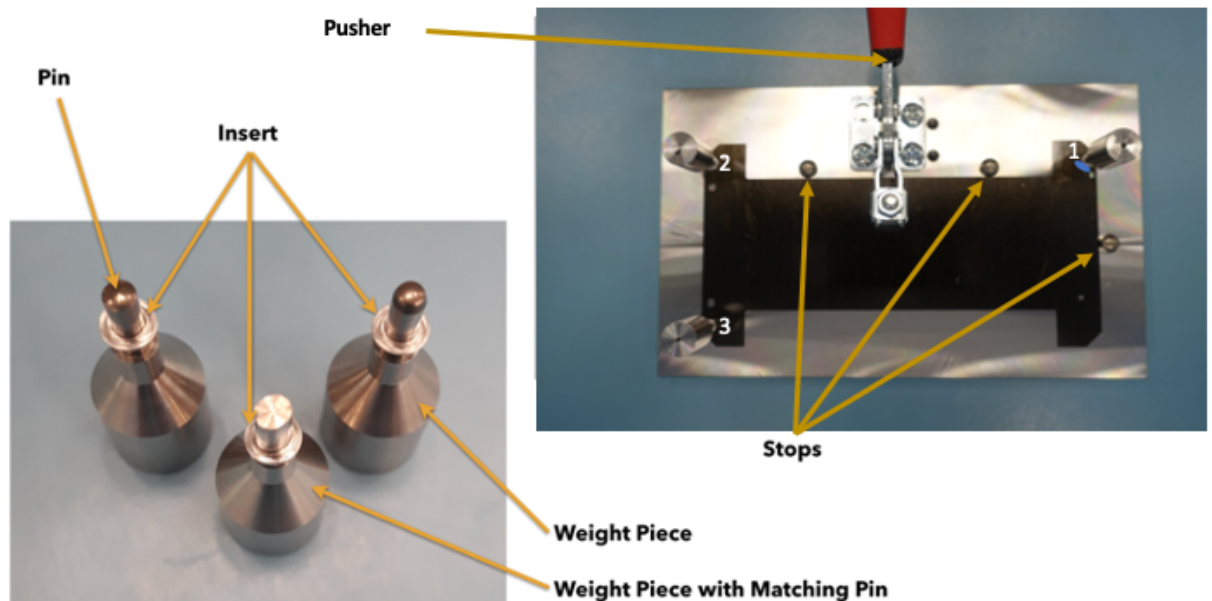


PS Module Base Plate Insert Glueing

To glue the inserts into a PS module base plate do the following steps:

(please go through carefully and check the boxes)

- ❑ Clean the weight pieces and the base plate in the area of the holes with Isopropanol.
- ❑ Place the base plate on the jig and push it against the stops
- ❑ Fix the base plate with the pusher by pushing down the red handle
- ❑ Remove with a scalpel a bit of the baseplate surface resin next to the hole for insert 1 as indicated in the picture below (right) by the small blue pad
- ❑ Place the inserts onto the pins of the weight pieces - **make sure that the side of the insert with the sleeve points away from the weight piece**, see left part of picture
- ❑ Mix the silver epoxy glue
- ❑ Put a small dot of silver epoxy glue onto the scratched pad on the baseplate, you can use a scalpel for this
- ❑ Put the weight piece of insert 1 into the hole
- ❑ Use the scalpel to make the silver epoxy glue touch the insert 1
- ❑ Put the weight pieces with inserts into the glueing jig - **make sure that the inserts touch the base plate but do not push**



- ❑ Mix Polytec 601-LV glue and put into syringe with a **yellow needle** (0.11 mm ID)
- ❑ Connect syringe to the Vieweg DC 300 dispenser and make sure that the pressure is set to **3 bar** and the device is in **timer mode** with **0.1 seconds** dispensing time.



- The glue has to be dispensed at four locations around each insert (except for insert 1: here only 3 remaining locations).
 - Place the needle at an angle of about 45° wrt. to the plane of the base plate at the interface between insert and base plate.
 - When the needle is in place, dispense the glue for **0.1 seconds** and wait for another **5 seconds** before moving to the next location around the insert or to the next insert.
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- When the glue is cured after 24 hours gently remove the weight pieces from the gluing jig. Start with the weight pieces with the round pins by pushing the inserts down with tweezers while slightly turning the weight pieces.

