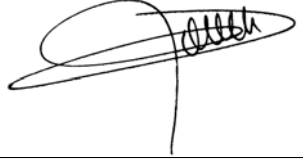




PROCEDURE FOR GRINDING THE FOUR SMEC PADS ON THE SOB

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THE FOUR SMEC PADS ON THE SOB**

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1. INTRODUCTION

The SMEC mechanism is very sensitive to the flatness default and to the local slope as well at interface level. The existence of local slope at the attachment point has never been verified and must be absolutely avoided. For this, it has been decided to carry out, prior to the integration of the mechanism, a very slight grinding of the contact area on the SOB in order to make sure that any local slope of the pads has been removed. This operation will also allow improving the four contact area flatness and to put in within the specification.

The aim of this document is to give the process to carry out the grinding operation

2. REFERENCE DOCUMENTS

n°.	Nom du document	Reference, Iss./Rév.
AD1	SMEC DCI	LAM.SSP.SPI.DCI.040611_01_11
AD2	Instructions for SMEC bench geometry control tool	LAM.MEC.SPI.NOT.040330_01_11

3. GRINDING PROCEDURE

The grinding operation will be conducted with a special glass tool that has been specially manufactured for this purpose. The area that will be grinded is the four contact points of the SMEC on the SOB

1. The I/F area of the SMEC will be cleaned and ready for this operation
2. Verify the existence of local slope by putting a drop of alcohol on each pads and by applying the tool in glass on the four pads
3. Install 4 threaded rods in the attachment points of the SMEC in order to avoid the abrasive dust to get into the threaded holes. The upper part of the rods will be slightly below the contact area of the pads (The four threaded rods will be provided by RAL)
4. Equip the special tool in glass with a sheet of special diamond abrasive paper (ground side of the glass tool)
5. Wet slightly the abrasive sheet with demineralised water
6. Apply the glass tool (abrasive sheet side) on the four pads and move it , by small circular motion, to grind the pads
7. Carry out this operation till getting an uniform grey colour on the upper part of the pads
8. Clean carefully the SMEC interface area , and in particular the four pads, with alcohol
9. Check , as per operation 2, the presence of local slope
10. Remove the four threaded rods
11. A flatness verification of the four pads will be carried out after the grinding (AD2)
12. The SMEC integration can be done