
Subject: Gluing table modification

Posted by [Clemens Adler](#) on Tue, 20 Apr 2004 10:04:36 GMT

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Dear Chamber builders,

It turned out that the Side profiles (L-profiles) are often slightly bent, i.e. if you fix the profile in the middle (as it is done on the gluing tables) the sides might stand up a little bit. This is a Problem when gluing the frame, since this could create a step on the surface between front and side profiles at the surface where wires are glued on.

Therefore the gluing tables have to be modified: 2 additional clamps have to be introduced at the sides of the L-profiles.

This involves the following work:

1. drill additional holes in the Aluminium plate.
2. cut threads
3. insert helicoil inserts
4. produce additional clamps (this should be done at the individual production sites, if at all possible).

The position of the holes is not extremely critical, therefore I do not see a Problem to do it (we did it for the first holes by hand, with some guide for drilling).

The Helicoil part, seems to be a bigger problem, since at least in Bukarest there is not tool for insertion of helicoils. So it would be good if those holes could still be made at GSI.

For Dubna I do not know, what the status is there in terms of helicoils, maybe Oleg can comment, and then we see how we proceed.

In any case care should be taken during production now, that the ends of the L-profiles are pressed down so that there is no significant gap between surface and gluing table plate.

cheers,
Clemens