



Trizact™ Diamond Tile 677XA Machine Prep & Pad Mounting Procedure

Technical Application Bulletin

September 2003

Machine Preparation

3M™ Trizact™ Diamond Tile 677XA Pads can be custom converted for all double or single-sided flat lapping machines. Pads are manufactured to any diameter with any hole size and hole configuration, and can be mounted to most plate material types or geometry. Grooves or other small recesses in the plate do not present a mounting problem.

Tools Required

- Rubber Roller
- Paper Toweling
- Scotch-Brite™ Heavy Duty Scouring Pad (Green #96) or Scotch-Brite™ Hand Pad 7447 (Maroon)
- Pressurized water
- Pressurized air

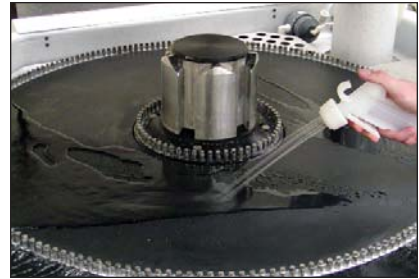


Mounting of 3M™ Trizact™ Diamond Tile 677XA pads to machine plates is basic and rapid. To ensure adhesion of our pads, all plates must be thoroughly cleaned and dried:

1. Rinse the plate with high-pressure water to remove particulate contamination from the plate surface and recessed areas. Use a bristle brush to loosen particulate in hard to reach places.
2. Remove surface oxidation by scrubbing the plate with Scotch-Brite™ Hand Pads.



3. Rinse the plate thoroughly.



4. Blow the plate dry, paying particular attention to any grooves or other recessed areas of the plate. If pressurized air is not allowed, then a vacuum is recommended to pull moisture from the grooves or recessed areas.



5. Paper toweling should be used to remove rust, dust, or other loose particles on the surface. If light oxidation is evident after the initial clean, lightly scrub the oxidized areas with a Scotch-Brite Hand Pad followed by a damp paper towel clean and dry. Repeat as necessary.



3M™ Trizact™ Diamond Tile Pads stick very well to clean and dry surfaces. They DO NOT stick to wet or contaminated surfaces. Be certain the plate is dry and contamination free before continuing.

Pad Mounting

When the machine plate is clean and dry, application of 3M™ Trizact™ Diamond Tile 677XA Pad can begin:

1. Peel the release liner approximately 6" away from the edge of the pad.



2. Fold the release liner back onto itself.



3. Center the pad on the plate, paying particular attention to align holes in the pad with holes in the plate. Do not touch the exposed adhesive to the plate until the pad is properly aligned.



4. Using a rubber roller, roll the exposed adhesive to the plate.



5. Incrementally roll the pad to the plate while peeling the remainder of the release liner off the backside of the pad.



6. To ensure adhesion, roll the entire pad again focusing on the pad edges.



If the pad adhesive accidentally contacts the plate before the pad is rolled, and if the plate is clean and dry, it is possible to remove small portions of the adhered pad from the plate for repositioning purposes. However, once the pad is rolled to the plate or has been in contact with the plate for a long period of time, it is not possible to remove the pad from the plate for repositioning or re-mounting.

Loose abrasive residue from slurry lapping processes will drastically reduce the life and performance of 3M™ Trizact™ Diamond Tile 677XA Pads. For this reason, it is highly recommended that slurry delivery lines be replaced or thoroughly cleaned. Please see Technical Application Bulletin “*Lubricant Use and Filtering Technique*” for more information relating to use, and re-use, of lubricants.

For pads that have been converted into 2 or more pieces (47"+ diameter plates,) slight undercuts at the splice allow for small misalignments. In this scenario, aligning the holes in the pad to the holes in the plate is critical since mating of the pad edges at the splice will not ensure that holes are in alignment.

Use 3M™ 5-Way Penetrant to protect metallic machine plates from corrosion after Trizact Diamond Tile 677XA Pads are removed.

FOR ADDITIONAL INFORMATION: To request additional product information or to arrange for sales assistance, call 1-800-251-8634. Address correspondence to: 3M Industrial Business Customer Response Center, Building 21-1W-10, 900 Bush Avenue, St. Paul, MN 55106. Our fax number is 651-733-9175. In Canada, phone: 1-800-364-3577. In Puerto Rico, phone: 1-787-750-3000. In Mexico, phone: 52-70-04-00.

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Electronics Markets Materials Division
Building 21-1W-10
900 Bush Avenue
St. Paul, MN 55106
phone: 1-800-251-8634
or 1-651-736-3068
www.3M.com/electronicmaterials



Minimum 30% Post-Consumer Fiber

Printed in U.S.A.
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IBD311
60-5002-0022-9