

Clean all components prior to laser welding per WPF process specification STRCP-003

Laser weld LED assemblies, window assemblies and 4-way connector per WPE process specification STRWLD-005

Thermal cycle 10 times between +25°C and +130°C, ramp time 10 minutes, dwell time 30 seconds minimum per WPE process specification STRTDS-006

Fine leak test to 1×10^{-8} mbar.l/s acc. to MIL-STD-883 Method 1014.12 condition A4 per WPE process specification STRFLT-002

Assemble PCB using RoHS compliant no clean cored solder wire acc. IPC-SF-818-M3CN
per WPE process specification STRPCB-007

Visually inspect solder joints acc. IPC-A-610D Section 7.5.5 Class 2

Vacuum bake all components for minimum 24 hours at 100±5°C (10-1 mbar)
per WPE process specification STRVB-007

Housing to be backfilled with Argon, min. 99.996% pure per WPE process specification STRBF-008

Laser weld lid per WPE process specification STRLWL-009

Gross leak test in bubble chamber at 95°C per WPE process specification STRFLT-002

Store in vacuum (10-1 mbar) for minimum 30 minutes followed by 10 autoclave cycles per WPE process specification STRXXX-XXX

Final acceptance test:

- No gross leaks visible in bubble chamber at 95°C per WPE process specification STRFLT-002.
- Take hot LW Housing Assy out of bubble chamber and immediately flow cold water over top window followed by immediate visual inspection under 4x magnification.
- No condensation to be visible on inside of window.
- LW Housing Assy to pass functional test per Stryker inspection plan hf193850

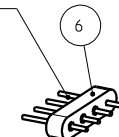
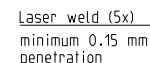
Signed certificate of conformity to be provided

Final clean with isopropyl alcohol (IPA). LW Housing Assy must be free of particulate matter acc. IPC-A-610D Section 10.4.2. Class 2 before packaging.

Package parts to protect feedthrough pins, tolerances and finish during transportation, receipt and storage. Damage caused by carelessness can be cause for rejection. Use only approved ESD protective packaging material. Package using Corstal CB-1 packaging. Packaging to be labelled with part number and name, serial number and date of manufacture.

General notes

- All laser welds to remain hermetic for 500 autoclave cycles
- Handling of PCB and LED assemblies only in ESD protected area (EPA)
- WPE to ensure traceability of all component lot numbers to serial number for 10 years



PCB must lie
flush on boss (3x)

Orient LED such that pins point towards the PCB

| HF193850 | | | | LW Housing Assy | | | | | |
|----------|------|------|----------|-----------------|--------------|----------------------|----------------|-----------|------------|
| Type | Pos. | Anz. | Teilenr. | Part # Instr. | Artikelnr. | Benennung | Werkstoffnr. | Lieferant | Bestellnr. |
| PART | 1 | 1 | HF193674 | -- | kein VK Teil | LW Housing | 3.7165 Ti6Al4V | -- | -- |
| PART | 2 | 1 | HF193851 | -- | kein VK Teil | LW Deckel | Ti Grade2 | -- | -- |
| ASSEMBLY | 3 | 1 | PB000064 | -- | kein VK Teil | LW PCB Assy | -- | -- | -- |
| ASSEMBLY | 4 | 9 | BG300320 | -- | kein VK Teil | LED Assy | -- | -- | -- |
| ASSEMBLY | 5 | 5 | BG300324 | -- | kein VK Teil | Window Assy 4.0 Drm. | -- | -- | -- |
| ASSEMBLY | 6 | 1 | ZT300427 | -- | kein VK Teil | 4-Way Connector | -- | -- | -- |

| | | | | | |
|----------------------|---------------------|--|-----------|------------------|----|
| Artikel-Nr.: | Freimassiolierenz: | | Massstab: | Werkstoff: | -- |
| kein VK Teil | ISO 2768 - m H 8 | | 5:2 | Wärmebehandlung: | -- |
| Projekt-Nr.: 1800F06 | | | | Haltz.-Abm.: | -- |
| | | | | Zugfestigkeit: | -- |

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| | | |
|----------------|-------------|-----------------|
| Datum | Name | Benennung: |
| Gez.: 09.08.06 | P. Warzecha | |
| Gepr.: | | LW Housing Assy |
| Freig.: | | LW Housing Assy |

stryker
Manufacturing

Teil-Nr.: HF193850 Part #: Instruments Blat: 1

| | | | |
|-----|-----------|----------|-------------------|
| E05 | Gm3 | Warzecha | Gepr. am 02.04.19 |
| 01 | Aenderung | Bearb. | Datum |

Strzyker LeibnizgmbH & Co. KG
Böhringer Strasse 4
D-70372 Pforzheim/Germany

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Bl.