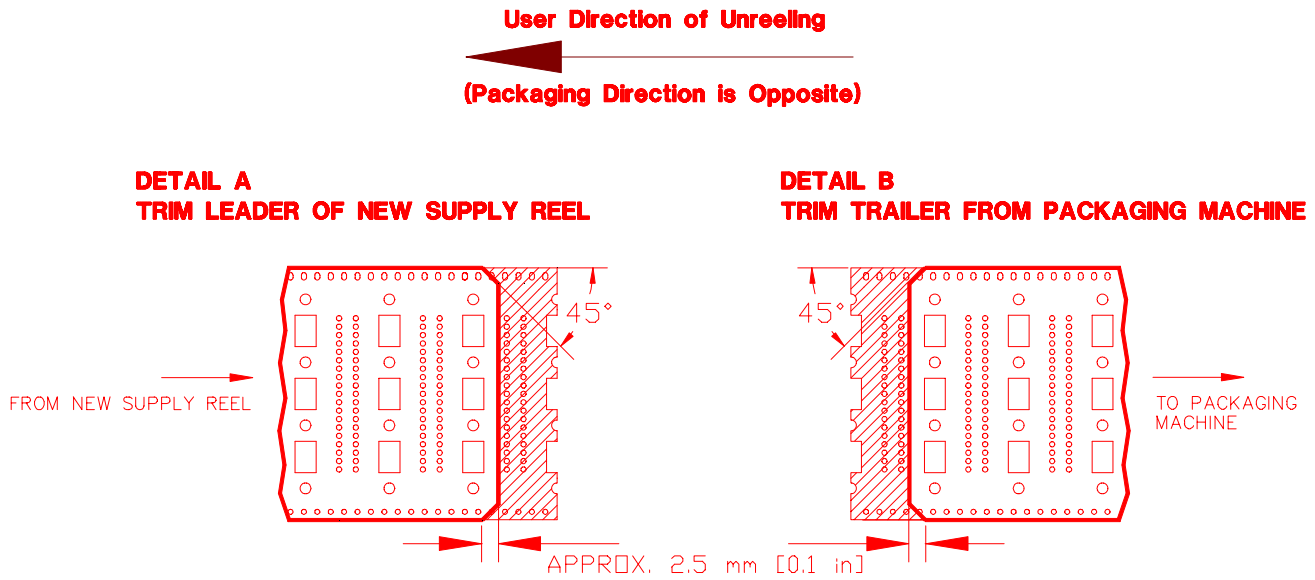


6.0 PACKAGING OPERATION

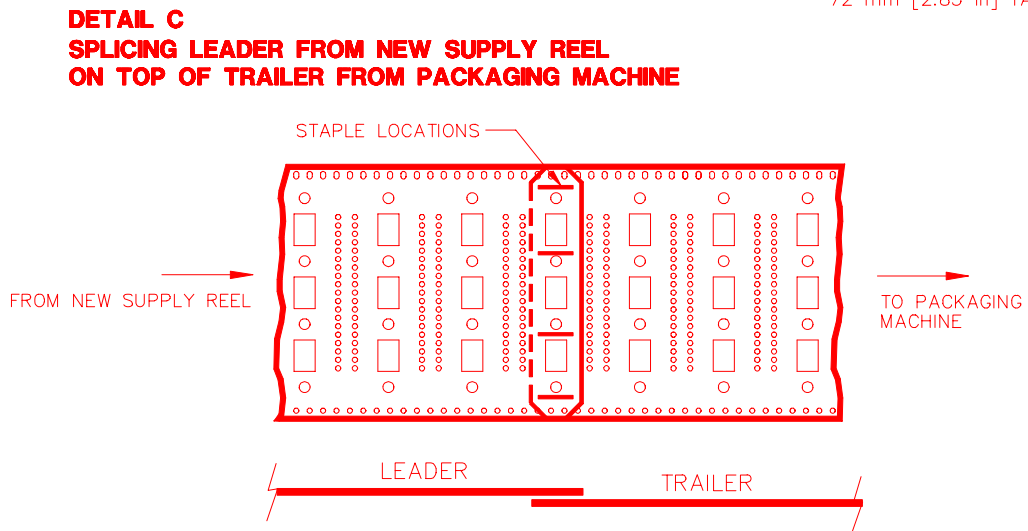
- 6.1 The following materials, or approved equivalents, are to be used when packaging components:
- Flanges, hubs and flange retainers as specified on the Component Control Specification
 - Component Control Specification (see *Figure 7 in attachments 2, 3 or 4*).
 - Tapes as specified on the Component Control Specification.
 - Adhesive tape for carrier tape attachment to hub.
 - Outside wrap to maintain packaged tape tension on reel.
 - GPAX MultiPak, or equivalent shipping carton.
- 6.2 Exterior of reel flanges shall be marked with an arrow to indicate user direction of unreeling (opposite packaging wind-up direction).
- 6.3 A protective wrap of anti-static foam interleave tape shall be applied to the reel hub if specified on the Component Control Specification. The protective wrap must be applied in the same direction as the arrow on the flanges. Apply adhesive tape to both ends of the foam interleave tape extending 50.8 mm [2.0 in] on either end, wrap foam interleave tape around reel hub, and overlap the other end of the adhesive tape onto the starter piece of adhesive tape at the reel hub.
- 6.4 Reels shall be assembled by inserting reel flange retainers through flanges and locking them into the reel hub. Reel flange retainers should be hammered with a rubber mallet to assure that the flanges bind tightly against the reel hub, preventing flanges from rotating freely. The reel assembly must have all pieces locked together.
- 6.5 Loading components on the packaging machine shall be performed in accordance with the equipment manufacturer's instructions.
- 6.6 All GPAX tapes may be spliced in accordance with the procedures presented herein for continuous loading and elimination of scrap with minimal setup.
- 6.7 Carrier tape shall be lap-joint staple spliced at the input end of the packaging machine as follows:
- The carrier tape leader from the new supply reel shall be trimmed as shown in *Figure 13 Detail A*.
 - The carrier tape trailer from the packaging machine shall be trimmed as shown in *Figure 13 Detail B*.
 - The **leader must be placed on top of the trailer** and the rectangular holes and round index holes shall be overlapped as shown in *Figure 13 Detail C*.
 - Using a GPAX Splicing Stapler (GPAX P/N 3100) place staples in the proper locations to insure proper operation as shown in *Figure 13 Detail C*.
- 6.8 StitchLock cover tape shall be butt joint spliced at the packaging machine as follows:
- The StitchLock index holes shall be overlapped as shown in *Figure 14 Detail B*.
 - Both layers of the StitchLock cover tape shall be cut at a slight angle and the small scrap sections shall be discarded. The StitchLock cover tape will then have mating ends for establishing a butt-joint splice as shown in *Figure 14 Detail C*.
 - Mating ends of the StitchLock cover tape shall be butted together as shown in *Figure 14 Detail D*. A piece of 3M Scotch brand adhesive tape or equivalent shall be placed across the length of the splice. Adhesive tape shall be placed on the opposite side of the StitchLock cover tape in the same fashion.
 - The edges of the StitchLock cover tape shall be trimmed of any excess adhesive tape as shown in *Figure 14 Detail E*. The StitchLock cover tape shall not be over-trimmed more than 0.4 mm [0.02 in] per side.

- (e) The splice shall be inspected to assure that the ends are properly butted together, no adhesive tape is overhanging the sides of the StitchLock cover tape or covering any cutouts, and the StitchLock cover tape pitch (P_s) is correct by scale measurement.
- 6.9 Anti-static foam interleave tape, if applicable, shall be butt-joint spliced at the packaging machine as follows (similar to StitchLock splicing shown in *Figure 14*):
- (a) The anti-static foam interleave tape shall be overlapped.
 - (b) Both layers of the anti-static foam interleave tape shall be cut at a slight angle and the small scrap sections shall be discarded. The anti-static foam interleave tape will then have mating ends for establishing a butt-joint
 - (c) Mating ends of the anti-static foam interleave tape shall be butted together. The splice shall be fastened securely on the underside **only** with adhesive tape, such that component leads do not touch the adhesive tape when wrapped.
 - (d) The edges of the anti-static foam interleave tape shall be trimmed of any excess adhesive tape.

FIGURE 5: CARRIER TAPE STAPLE SPLICING DURING THE PACKAGING OPERATION



APPLIES TO ALL TAPE WIDTHS
 72 mm [2.83 in] TAPE SHOWN



IMPORTANT! PLACE LEADER FROM NEW SUPPLY REEL
 ON TOP OF TRAILER FROM PACKAGING MACHINE AS SHOWN.

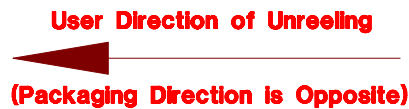


FIGURE 6: CARRIER TAPE STAPLE SPLICE LOCATIONS - EIA CARRIER WIDTHS

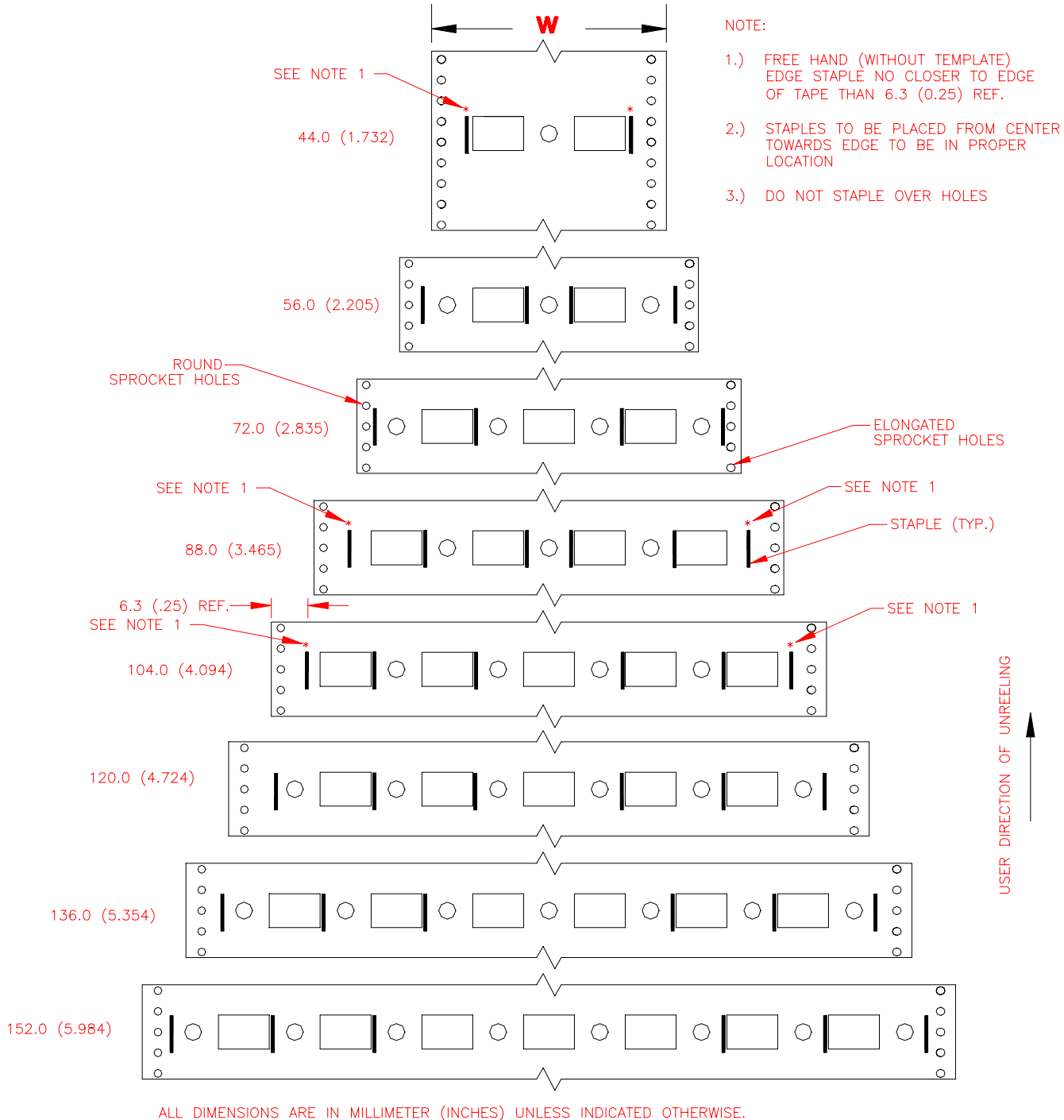
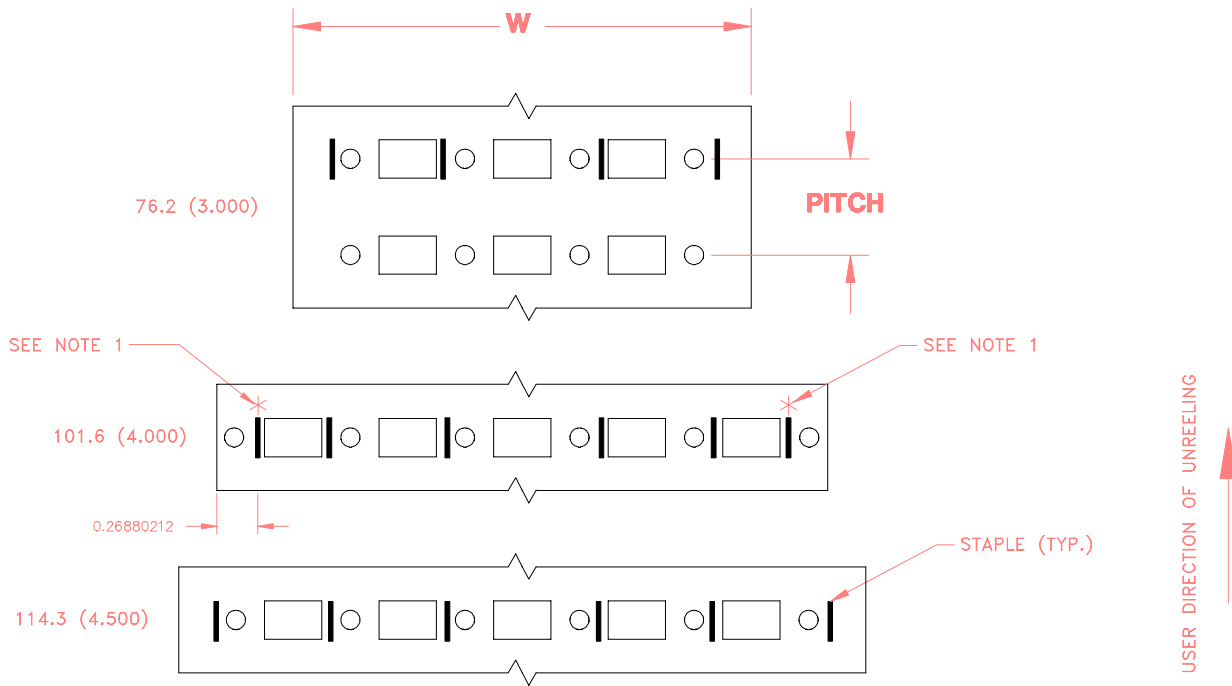


FIGURE 7: CARRIER TAPE STAPLE SPLICE LOCATIONS - INCH WIDTHS

NOTE:

- 1) FREE HAND (WITHOUT TEMPLATE) EDGE STAPLE NO CLOSER TO EDGE OF TAPE THAN 6.3 (0.25) REF.
- 2) STAPLES TO BE PLACED FROM CENTER TOWARDS EDGE TO BE IN PROPER LOCATION
- 3) DO NOT STAPLE OVER HOLES

DO NOT STAPLE SPLICE 1.5" CARRIER TAPE



ALL DIMENSIONS ARE IN MILLIMETER (INCHES) UNLESS INDICATED OTHERWISE.