



SCR CLAMP MOUNTING PROCEDURES

1. Clean heatsink mounting surfaces of all foreign material, oxides and films.
2. Be sure the pressure pad is properly seated and the springs are in place in the insulated clamp housing.
3. Insert the bolts through the insulated clamp housing until the bolt heads are flush with the springs.
4. Install heatsink A, the device, and heatsink B (if required), and/or optional brace block.
5. Apply interface material between the device(s) and heatsink(s).
6. Install the device such that it is positively located between the heatsinks and centered under the insulated clamp housing with the bolts through the holes in the heatsink, as shown below.
7. Tighten the nuts evenly until finger tight.
NOTE: Never-Seez, anti-seize lubricating compound, may be used on the bolt heads and threads to reduce torque required to establish mounting force.
8. Tighten the bolts $\frac{1}{4}$ turn each rotation increment to prevent uneven torque.
9. Place the Force Indicator PIP Gauge (P/N VE1055G) firmly against the springs, such that both ends and the middle of the gauge are in solid contact with the spring surface (shown below). The gauge notch location (found at the top of the PIP gauge) will then indicate the spring deflection, or force. Correct mounting force is indicated when the gauge notch locations (degree lines close by the clamp part number) coincide. For more specific load details, refer to your clamp datasheet.

