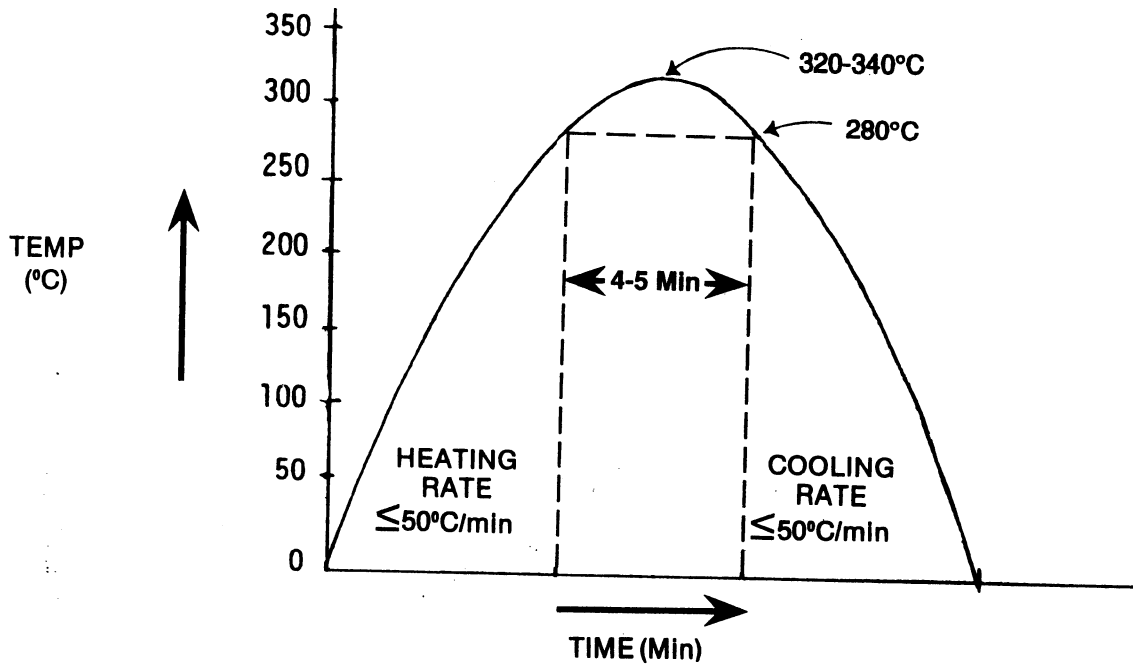


Suggested Furnace Sealing Profile:



Equipment:	Belt Furnace
Atmosphere:	Nitrogen or Forming Gas
Sealing Profile:	4 - 5 mins. above 280° with a peak temperature of 320°C-340°C for 1-1½ min.
Pre-Cleaning:	Blow off COMBOS® surface with clean, dry air or nitrogen
Lid Sealing Clips:	Pressures of 0.5 - 2.0 lbs./linear inch of lid

Hi-Rel Part Number and Description:

<u>Description:</u>	Hi-Rel COMBOS® (Lid and Preform Assembly)
<u>Lid:</u>	F15 OR ALLOY 42 BASE MATERIAL WITH MULTILAYER GOLD AND NICKEL PLATING PER MIL-M-38510
Gold Plating:	25 microinches minimum top layer and a sum of both layers of 50 microinches minimum thickness.
Nickel Plating:	50 to 350 microinches each layer and a sum of both layers not to exceed 450 microinches thickness.
<u>Preform:</u>	GOLD TIN EUTECTIC FRAME