5 Cell Dummy Stack

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V-Block Setup
Stacking & Fixturing Components

- STOPYT G2A applied to contact areas to keep from bonding
- Stack Preparation ~1hr

- Stack Base
- Air Cylinder
- Stack Press
- Base Clamp
- Stack Clamp
- Graphite Pie Wedges
- Latex Gloves
- Stack Rods
- Stack Top
- Fixturing Screws
Setup Fixturingin V-Block
Stack Base Fixtured to V-Block

- process can take 1-2 hours
- critical to success of stack
- back rod must be positioned before base
Graphite Pie Wedges
Cell 1 Stacked
Cell 1 Pressed into V-Block
Cell 1 Pressed into Base

- this step is to insure flatness
- press out air
Cells Pressed into V-Block
Cells Rotationally Aligned by Sight on Notch
Graphite Pie Wedges on Top of Cell
Tweezers Used to Evenly Space Wedges
Top Plate Set on Stack
Top Plate Set on Stack

- lift rod
- slide into slot
- gently place top on pie wedges
- replace rod
Clamp Cells Flush in V-Block
Other Rods Placed into Fixture
Air Cylinder Placed on Top of Stack
Below Stacking Setup
Air Cylinder Setup
Stack Compressed with Pressure from Air Cylinder
Air Cylinder Engaged
Fixtured and Compressed Stack
Fixturing to V-Block Removed
Fixturing to V-Block Removed
Cell Transported to “Furnace”
Stack Placed on Base of Furnace
Stack Stabilized and Weight Placed on Stack
Stack Compressed by Weight and Air Pressure
Air Cylinder Removed