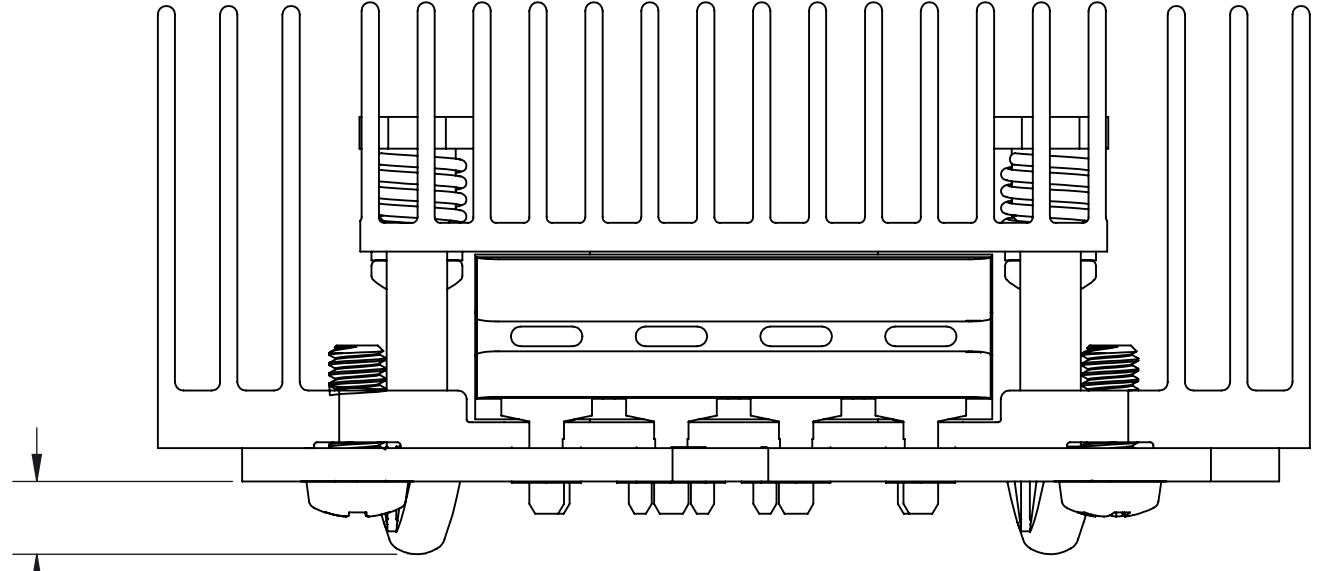
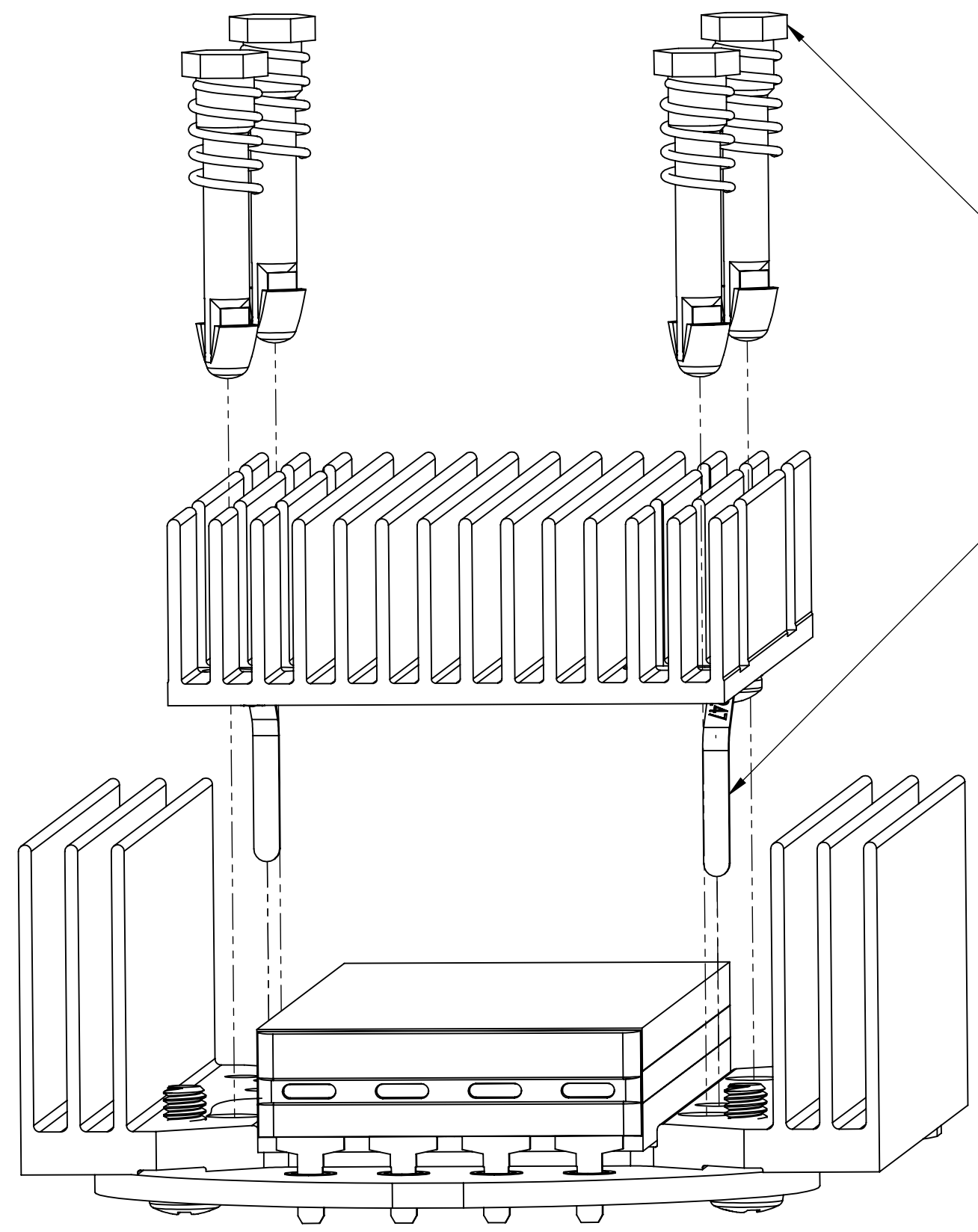
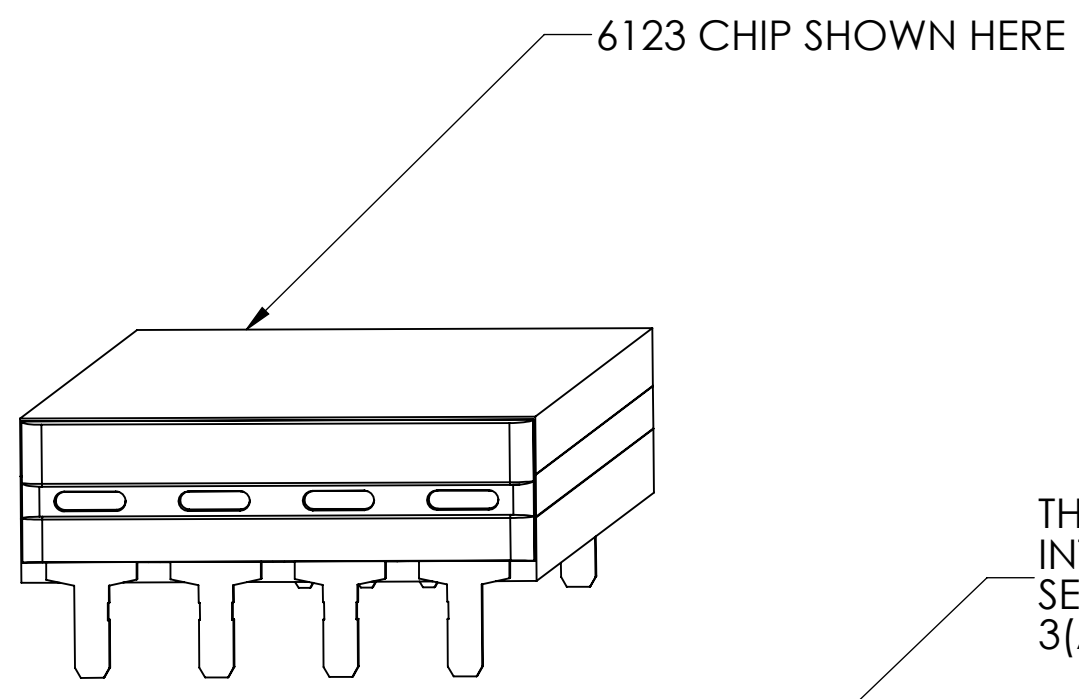
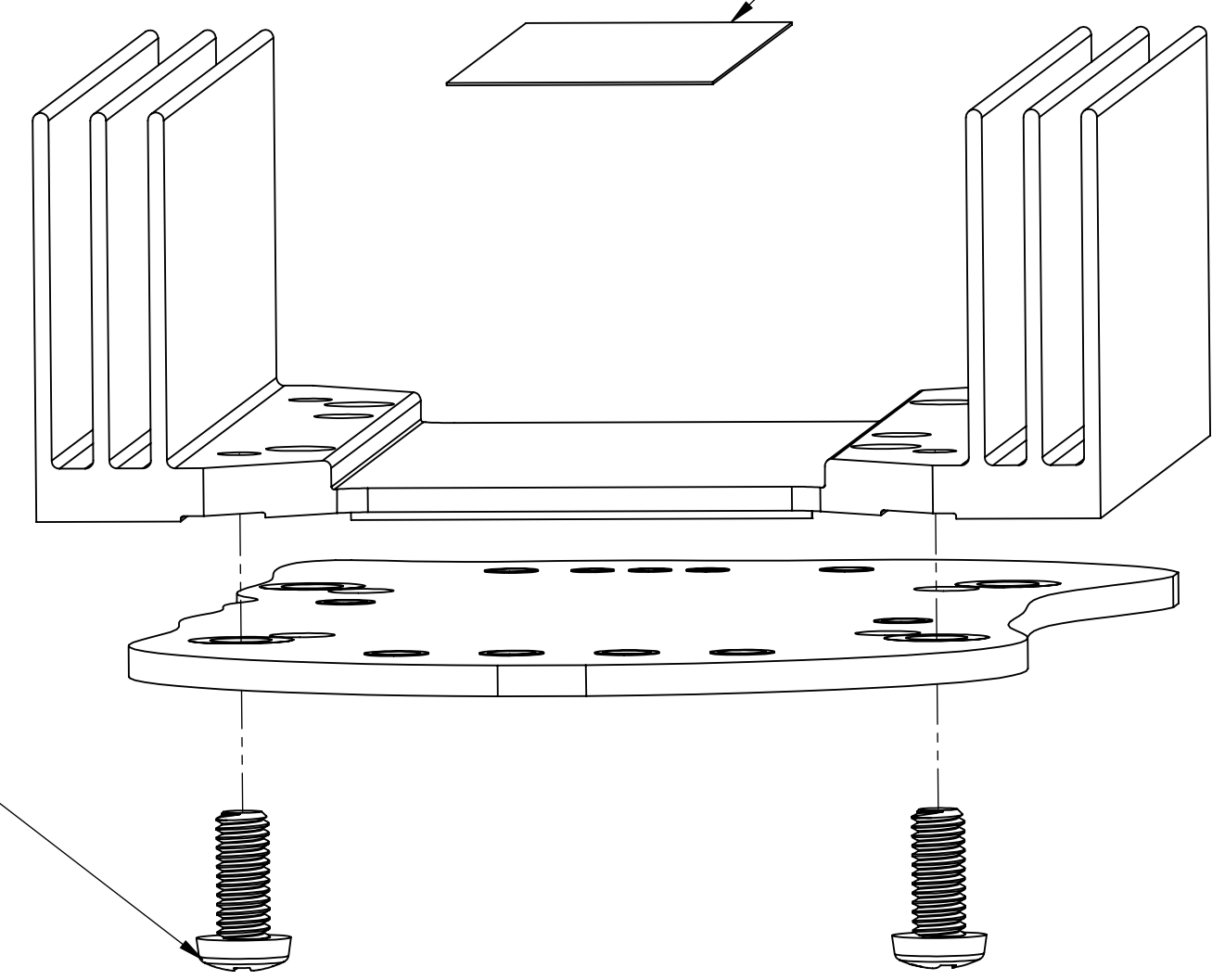


REV.	DESCRIPTION	INTL	DATE	APVD
1	RELEASE PER E140060	REJH	01/17/14	REW
2	REVISED PER E140151	SR	01/30/2014	REW
3	REVISED PER E141039	SJW	09/03/14	RH
4	REVISED PER E170887	JM	09/26/17	REJH



SCREW (40578)  
INSTALLED FROM  
BOTTOM SIDE OF PCB.  
TORQUE TO 6 IN-LBS.  
(2) PL OR (4) PL  
OPTION



**BOTTOM HEATSINK APPLICATION  
SEE NOTE 3**

**TOP HEATSINK APPLICATION  
SEE NOTES 3**

**ASSEMBLED FRONT VIEW**

**NOTES:**

- FOR PCB LAYOUT SEE VICOR APPLICATION DRAWING 40438.
- ROHS COMPLIANT PER CST-0001 LATEST REVISION.
- THE SOLDERING METHOD USED FOR CHIPS (AND OPTIONAL HEATSINK GROUNDING) IS IMPORTANT WHEN SELECTING A THERMAL INTERFACE MATERIAL (TIM). THE PHASE-CHANGE TIM SHOWN IN THESE ILLUSTRATIONS MAY BE DAMAGED BY TEMPERATURES OVER 125C, SO TWO ASSEMBLY PROCEDURES ARE DESCRIBED BELOW:  
(A) FOR HAND-SOLDERING ONLY,  
(B) FOR WAVE-SOLDERING AND/OR HAND-SOLDERING.  
  
(A) PLACE BOTTOM-SIDE HEATSINK (WITH PRE-ATTACHED PHASE-CHANGE TIM) ON PCB. PLACE CHIP AND TOP-SIDE HEATSINK (WITH PRE-ATTACHED TIM AND GROUNDING TABS). WHILE SUPPORTING PCB, INSERT PLASTIC PUSH-PINS THROUGH BOTH HEATSINKS AND PCB. (SELECT PROPER PUSH-PIN LENGTH FROM TABLE ON THIS DRAWING.) IMPORTANT: TO SET FINAL THICKNESS OF PHASE-CHANGE TIM ENSURE THAT THE ENTIRE ASSEMBLY IS RAISED ABOVE 65C FOR SEVERAL MINUTES. HAND-SOLDER ALL CHIP AND GROUNDING PINS. ADDITIONAL SOLDERING IRON HEAT MAY BE REQUIRED TO COMPENSATE FOR LOSSES TO THE HEATSINKS.  
  
(B) WAVE SOLDERING TEMPERATURES ARE UNSUITABLE FOR PLASTIC PUSH-PINS AND PHASE-CHANGE TIM, SO VICOR TIM 40325 (PARKER CHOMERICS GEL8010) IS RECOMMENDED. APPLY A UNIFORM .003" (.076MM) LAYER OF TIM 40325 TO THE TOP AND BOTTOM SURFACE OF THE CHIP, OR TO THE CORRESPONDING HEATSINK SURFACES. PLACE BOTTOM-SIDE HEATSINK, CHIP, AND TOP-SIDE HEATSINK ON PCB. WITH A CUSTOM FIXTURE APPLY APPROX. 10 LBS LOAD TO THE TOP-SIDE HEATSINK AND THEN WAVE-SOLDER ALL PINS. REMOVE FIXTURE AND INSERT PLASTIC PUSH-PINS THROUGH BOTH HEATSINKS AND PCB. (SELECT PROPER PUSH-PIN LENGTH FROM TABLE ON THIS DRAWING.)
- CARE SHOULD BE TAKEN TO AVOID FULLY COMPRESSING THE PUSH-PIN SPRING DURING INSTALLATION AS THIS WOULD EXPOSE THE CHIP TO FORCES GREATER THAN THE RECOMMENDED LIMIT OF 3.1 LBF (13.8 N) PER PUSH-PIN.

	HEATSINK TYPE	P/N ASSY HEATSINKS, TIM AND GROUND TAB	P/N ASSY HEATSINK W/GROUND TAB ONLY
SOLDERING METHOD (SEE NOTE 2)	-	2(A) HAND SOLDER ONLY	2(B) WITH VICOR 40325 THERMAL GEL
4623	DUAL 11MM	40519	40527
	DUAL 19MM	40408	-
6123	DUAL 11MM	40520	40528
	DUAL 19MM	40409	-

**HEATSINK OPTIONS**

PUSH-PINS W/ SPRINGS (100/BAG)	COLOR	PCB THK NOMINAL RANGE	PCB THK MINIMUM	PCB THK MAXIMUM
32436	BLUE	1.143 MM TO 1.854 MM [.045"] TO [.073"]	1.041 MM [.041"]	2.057 MM [.081"]
32437	GRAY	1.880 MM TO 2.438 MM [.074"] TO [.096"]	1.676 MM [.066"]	2.692 MM [.106"]

**PUSH-PIN SELECTION**

DRAWN BY Robert Wasik	DATE 7/12/2013	<b>VICOR</b> <small>swd</small>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE: INCH / (MM)		<b>APP DWG, DUAL HEATSINK, 6123, 4623</b>	
TOLERANCES ARE: DECIMALS ANGLES X.XX (X.X) = +0.01 (0.25) ±1° X.XXX (X.XXX) = ±0.005 (0.127)		SIZE <b>D</b>	CAGE CODE <b>67131</b>
THIRD ANGLE PROJECTION 		DWG NO <b>40191</b>	REV <b>4</b>
DO NOT SCALE DRAWING		SCALE 3:1	SHEET 1 OF 1