

Description

This invention relates to slider-suspension assemblies for data recording disk files and to a method for making such assemblies. In particular the invention relates to an improved slider-suspension assembly and to a method for mechanically and electrically attaching the slider to the suspension.

Disk files are information storage devices which utilize at least one rotatable disk with concentric data tracks containing the information, a transducer (or "head") for reading data from or writing data to the various tracks, and a head positioning actuator connected to the head for moving it to the desired track and maintaining it over the track centerline during read or write operations. The transducer is attached to a slider having an air bearing surface which is supported adjacent the data surface of the disk by a cushion of air generated by the rotating disk. The slider is attached on its back side (the side opposite the air bearing surface) to the suspension, and the suspension is attached to a support arm of the head positioning actuator.

The suspension provides dimensional stability between the slider and actuator arm, controlled flexibility in pitch and roll motion of the slider relative to its direction of motion on the rotating disk, and resistance to yaw motion. The suspension typically provides a load or force against the slider which is compensated by the force of the air bearing between the slider's air bearing surface and the disk surface. Thus, the slider is maintained in extremely close proximity to, but out of contact with, the data surface of the disk. The suspension typically comprises a load beam, which is mounted at one end to the actuator arm, and a flexure element which is attached to the other end of the load beam and supports the slider. The load beam provides the resilient spring action which biases the slider toward the surface of the disk, while the flexure provides flexibility for the slider as the slider rides on the cushion of air between the air bearing surface and the rotating disk. Such a suspension is described in U.S. patent 4,167,765, which is assigned to the same assignee as this application. An example of a conventional slider is described in U.S. patent 3,823,416, which is assigned to the same assignee as this application.

In the conventional slider-suspension assemblies, the slider is mechanically attached to the flexure of the suspension by epoxy bonding. The electrical connection between the transducer and the disk file read/write electronics is made by twisted wires which run the length of the suspension load beam and extend over the flexure and slider. The ends of the wires are soldered or ultrasonically bonded to the transducer leads on the slider. The

fabrication of such a slider-suspension requires manual assembly and is thus time consuming and costly.

Another type of suspension is a composite or laminated structure comprising a base layer with patterned electrical leads formed thereon and an insulating cover layer, as described in IBM Technical Disclosure Bulletin, Vol. 22, No. 4 (September 1979), pp. 1602-1603 and Japanese Kokai Nos. 53-74414 (July 1, 1978) and 53-30310 (March 22, 1978). In the laminated suspension described in Japanese Kokai 53-74414, the slider is epoxy bonded to the laminated suspension and the transducer leads are soldered to the electrical leads formed on the suspension.

From FR-A- 2 384 315 a further suspension is known. This known suspension includes a platform with at least one integrated magnetic head which is attached by soldering to a flexible conductor. On the side of the platform immediately opposite the flexible conductor, this platform is provided with as many electrical leads as the heads need and in the same pattern as the electrical leads are provided on the flexible conductor. By heating with an appropriate heating element the electrical conductors of the platform are connected to the leads within the flexible conductor. This known flexible conductor together with the attached platform with integrated magnetic heads corresponds to the arrangement which is known of the above mentioned article in the IBM Technical Disclosure Bulletin. The combination of a flexible conductor and a platform with integrated magnetic heads electrically and mechanically connected by soldering, cannot be considered to be a shiftable, arm-like suspension.

A disadvantage with conventional epoxy bonding of the slider to the suspension is that it is difficult to form the assembly such that the slider will have a predetermined pitch or roll relative to its direction of motion on the disk. Since the epoxy bonding can only result in a generally parallel relationship between the back side of the slider and the flexure of the suspension, the flexure must be formed or bent prior to bonding in order to give the slider a predetermined pitch or roll. Also, if it is desired to bond the slider to the suspension at a skew angle in order to optimize the angle between the slider's leading edge and the data track, some type of fixture is required to align the slider at the time the epoxy bond is formed.

An additional disadvantage with epoxy bonding is that because the epoxy is nonconductive, there is no consistent grounding path between the slider and the suspension. Thus in the event of static charge build-up on the slider the closest path for discharge is from the pole tips of the transducer to the disk surface. Static discharge through this path

will destroy a thin film transducer.

Static charge build-up on the disk can also destroy a thin film transducer if the static discharge occurs from the disk to the pole tips of the transducer. This is because in conventional slider-suspension assemblies which have only one active thin film transducer on the slider, there is no grounding path from the pole tips of the inactive transducer.

It is the object of the invention to overcome these drawbacks and to provide an improved slider-suspension assembly.

These and other objects are basically solved in advantageous manner by the measures laid down in the independent claims. The embodiment laid down in independent claim 1 concerns a shiftable, arm-like suspension. The embodiment laid down in independent claim 2 encompasses a slider suspension in general, i.e. a stationary but floating arrangement. Advantageous embodiments and further developments of both main embodiments are laid down in dependent subclaims 3 to 9. The independent method claim 10 concerns both main embodiment forms. The dependent method claims 11 to 14 encompass further advantageous developments.

The invention provides a slider-suspension assembly in which the shiftable, arm-like suspension is mechanically attached to the slider by a plurality of reflowed solder ball connections. When the suspension is the laminated type with patterned electrical leads, the electrical attachment of the transducer leads to the leads on the suspension is also provided by reflowed solder ball connections.

In the preferred embodiment a pattern of solder contact pads is provided on the back side of the slider and a like pattern of solder-wettable regions is provided on the generally planar portion of the suspension to which the slider is to be attached. Solder balls are then formed on either the slider solder contact pads or the solder-wettable regions by, for example, evaporation and subsequent reflow of the solder. The slider is then placed in contact with the suspension so that the solder contact pads are in approximate alignment with respective solder-wettable regions on the suspension and the solder balls are in registration between the two aligned patterns. The solder balls are then heated to reflow, thereby forming a mechanical connection with precise alignment between the slider and the suspension. The above-described solder reflow technique is similar to the controlled collapse chip connection (C4) process for securing semiconductor devices (chips) to printed circuit boards.

When the suspension is the laminated type and the transducer is the thin film type with leads formed on the slider trailing edge and terminating

generally at the corner between the trailing edge and the slider back side, then solder connections between the transducer leads and electrical leads on the suspension are formed simultaneously with the above-described mechanical attachment. Solder balls are formed on the lead terminations of the thin film transducers and on a row of solder-wettable regions near the location where the trailing edge of the slider is to be located when the slider is attached to the suspension. The solder-wettable regions in the row are terminations for the electrical leads formed on the laminated suspension. When the slider is located on the suspension with the solder balls in registration between the two like patterns on the slider back side and the suspension, the solder balls on the transducer leads are then in alignment with but not in contact with the row of solder balls formed on the suspension. When the solder is heated, the solder balls between the back side of the slider and the suspension reflow and collapse, thereby causing the solder balls on the transducer leads to contact those formed in the row on the suspension. This results in the formation of generally right-angled solder joints between the transducer leads and the row of associated solder-wettable regions on the suspension.

The solder-wettable regions for providing mechanical attachment on the suspension are electrically grounded back to the actuator arm so that static charge on the slider will discharge to ground rather than to the disk through the transducer pole tips. In addition, the right-angled solder joints on the inactive thin film transducer end at solder-wettable regions which are electrically connected to certain of the solder-wettable regions for mechanical attachment. Thus, the pole tips of the inactive transducer are grounded through the slider back to the actuator arm so that static charge on the disk can be discharged through the pole tips of the inactive transducer.

The slider-suspension assembly is usable as a mechanical connection for both laminated type suspensions having patterned conductors and the more conventional suspensions, such as the stainless steel suspension described in the before mentioned US patent 4167765. In the case of the conventional suspension, the solder-wettable regions are formed on the suspension by depositing solder-wettable material, such as copper, directly on the stainless steel. In the case of the laminated suspension, the regions are formed by providing openings through the insulating cover layer to expose portions of the conductive pattern.

Because orientation of the slider onto the suspension is determined by the pattern of solder contact pads, the slider can be reliably located on the suspension in a skewed position by merely

orienting the solder contact pads at the time they are formed on the slider back side. Similarly, by altering the size of selected solder contact pads on the slider or the solder-wettable regions on the suspension, selected solder balls securing the slider to the suspension will form shorter solder joints during reflow. This permits the slider to be attached to the suspension with a predetermined pitch or roll orientation when the slider flies above the surface of the rotating disk.

For a fuller understanding of the nature and advantages of the present invention reference should be made to the following detailed description taken in conjunction with the accompanying drawing, showing embodiments of the present invention, and in which:

Fig. 1 is a perspective view of a conventional slider-suspension assembly illustrating mechanical attachment of the slider to the flexure of the suspension and twisted wire connection of the thin film transducer leads to the read/write electronics of the disk file;

Fig. 2 is a perspective view of the slider-suspension assembly according to the present invention illustrating a laminated suspension with the slider mechanically attached by reflowed solder balls to a portion of the patterned conductive layer and the thin film transducer leads electrically connected by right-angled solder joints to electrical leads on the patterned conductive layer;

Fig. 3 is a plan view of the suspension shown in Fig. 2, with the slider outline shown in dashed line, illustrating the patterned conductive layer and the solder-wettable regions thereon for receiving the solder balls for both mechanical and electrical connection to the slider;

Fig. 4 is a view of a portion of a slider and suspension without the solder ball connections, and illustrating representative solder contact pads on the slider back side and solder-wettable regions on the laminated suspension;

Fig. 5 is a view of a portion of a slider and suspension illustrating solder balls formed on the suspension and on the transducer leads prior to reflow of the solder;

Fig. 6 is a view of a portion of the completed slider-suspension assembly illustrating the reflowed solder balls providing mechanical connection between the slider back side and the suspension,

and the generally right-angled solder joints providing electrical connection between the transducer leads and the electrical leads on the suspension; and

Fig. 7 is an illustration of the slider-suspension assembly with a laminated suspension having a stainless steel supporting layer.

A conventional slider-suspension assembly is illustrated in Fig. 1. The suspension comprises a load beam 10 and a flexure 12 located at the end of load beam 10. The suspension is attached to the disk file actuator arm (not shown) by means of a mounting plate 14. The slider 16 is a conventional slider formed of ceramic material, such as a mixture of alumina (Al_2O_3) and titanium carbide (TiC). The slider 16 has an air bearing surface 18, which includes two rails 20, 22, a back side 24 opposite and generally parallel to air bearing surface 18, a leading edge 25 and a trailing edge 26, both of which form end faces oriented generally perpendicular to air bearing surface 18 and back side 24. Slider 16 is secured to flexure 12 by an epoxy bond between back side 24 and flexure 12.

Located on the trailing edge 26 of slider 16 are two thin film read/write transducers 28, 30. Typically, multiple thin film transducers are formed on a single slider, even though only one transducer is active as a read/write element, in order to improve the yield of the slider during the thin film fabrication process. The transducers 28, 30 have pole tips 29, 31, respectively, which extend toward the edge of respective rails 20, 22. Transducer 28 has electrical leads 33, 35 and transducer 30 electrical leads 37, 39 for connection to the read/write electronics of the disk file.

The epoxy connection between flexure 12 and the back side 24 of slider 16 does not provide electrical grounding. Thus any static charge on slider 16 can only be dissipated through the pole tips 29 of active transducer 28 to the disk surface, which results in destruction of the thin film transducer.

In the conventional embodiment shown in Fig. 1, the electrical attachment to the read/write electronics is made by twisted wires 34 which extend from the read/write electronics, through a tube 36 on load beam 10 and out the end of tube 36. The ends of wires 34 are soldered or ultrasonically bonded to the leads 33, 35 of active transducer 28. The electrical connection of the transducer 28 by means of the twisted wires 34 is made by manual fabrication.

Referring now to Fig. 2, the slider-suspension assembly of the present invention is illustrated as slider 16 which is both mechanically and electrically connected to a composite or laminated sus-

pension 40. The suspension 40 comprises a non-conductive base layer 42, a patterned conductive layer 44, and an insulating cover layer 48. The base layer 42 may be a polyimide sheet and the patterned conductive layer 44 a vapor-deposited copper film. The insulating cover layer 48 may be a layer of polyimide formed over the patterned conductive layer 44 and bonded to the base layer 42. The patterned conductive layer 44 is thus formed between base layer 42 and cover layer 48 and is visible in Fig. 2 because of the translucency of cover layer 48. The electrical leads 46 form part of the conductive layer 44 and extend beneath the slider 16 where they end at terminations 47.

The conductive pattern of layer 44 is better illustrated in Fig. 3 and includes electrical leads 46 with terminations 47, and large area portions 52, 54 which form a supporting base for the mechanical attachment of the slider in the manner to be described below.

The slider 16 (Fig. 2) has an air bearing surface 18, including rails 20, 22, and a trailing edge 26. Conventional thin film transducers 11, 13 are formed on the trailing edge with respective pole tips 15, 17 extending to the edges of rails 20, 22 respectively. Each of transducers 11, 13 has a pair of electrical leads 19, 21 and 27, 29, respectively, extending across the trailing edge 26 toward the corner formed by back side 24 and trailing edge 26. As shown in Fig. 2, slider 16 is mechanically bonded to the large area portions 52, 54 of conductive pattern 44 by means of reflowed solder balls 60 between the slider back side 24 and the conductive layer 44. Transducer 11 is the active transducer and electrical connection of it to the terminations 47 formed as part of the conductive pattern 44 is made through generally right-angled solder joints 86. The leads 27, 29 of inactive transducer 13 are connected to extensions 49 of portion 52 of the conductive pattern 44.

The circles shown on Fig. 3 are circular openings 60, 61 and 63 in the insulating cover layer 48 which expose the underlying copper of the patterned conductive layer 44. Circular openings 60 define a pattern of solder-wettable regions on suspension 40 for mechanical attachment of slider 16. Circular openings 61, 63 define a row of solder-wettable regions along the line where the transducer lead terminations will be located when the slider is attached to the suspension. The solder-wettable regions 63 are used for electrical connection of leads 46 to transducers 11.

The manner in which the solder connection of slider 16 is made to suspension 40 can be better understood by reference to Figs. 4, 5, and 6. Fig. 4 illustrates a portion of slider 16 with solder contact pads 70 formed on the back side 24 and solder-wettable regions 60, 63 formed on suspension 40.

The solder-wettable regions 63, one of which is shown in Fig. 4, are formed on the terminations 47 of leads 46 (Fig. 3). The pattern of solder contact pads 70 formed on the back side 24 of slider 16, only two of which are shown in Fig. 4, is a mirror image of the pattern of solder-wettable regions 60 on portions 52, 54 (Fig. 3). Also shown in Fig. 4 is the slider trailing edge 26 with transducer 11 formed thereon, and transducer pole tips 15, lead 21 and lead termination 41.

As shown in Fig. 4, each of the contact pads 70 comprises an adhesion film 74 formed directly onto the slider back side 24 and a solder-wettable film 76 formed on the adhesion film 74. The solder contact pads are formed on the slider back side by a suitable mask having openings which is placed over back side 24. The masked slider is then placed in a evaporation dome and a crucible containing the adhesion material, such as titanium, is evaporated and formed as film 74 on the slider back side 24. Thereafter the solder-wettable film, such as nickel, is evaporated onto the adhesion film. It is preferable that for a short period of time the evaporation of both the titanium and the nickel occur so that an interfacial alloy of titanium and nickel is formed between the adhesion film 74 and the solder-wettable film 76. If the solder balls are not to be formed for some time, then a corrosion-resistant film 78 of, for example, gold is formed over the nickel film. The gold film provides a corrosion barrier for the solder contact pads 70. The solder contact pads 70 formed in this manner provide material which is conducive to the wetting or adhesion of solder and thus permit solder balls to be securely adhered to the back side 24 of slider 16. Chromium may be used in place of titanium as the adhesion film, and copper may be used in place of nickel as the solder-wettable film.

Referring again to Fig. 3, the solder-wettable regions on suspension 40 are formed by removing selected portions of the polyimide insulating layer 48, which thereby exposes the circular openings 60, 61 on large area portions 52, 54 and the circular openings 63 on lead terminations 47. These openings in the polyimide layer are preferably formed by the use of a conventional mask having the pattern of circles. The polyimide is then etched away to expose the underlying copper material, as best shown in Fig. 4.

Referring now to Fig. 5, solder balls 80 are formed on the solder-wettable regions 60 and solder balls 82 are formed on solder-wettable regions 61, 63. The solder balls are preferably formed by first tightly securing a mask with circular openings over the suspension, the openings being aligned with the etched-away portions of layer 48. A solder paste is then spread over the mask and forced through the openings. The mask is removed and

the solder heated to reflow as solder balls 80, 82. The solder balls are then adhered to the regions 60, 61 and 63 of the patterned conductive layer 44. The solder balls 80, 82 may also be formed on the suspension by evaporating solder through openings in a mask placed over insulating layer 48, removing the mask and thereafter heating the evaporated solder to cause the solder to reflow as solder balls 80, 82.

Fig. 5 also illustrates solder balls 84 formed on transducer lead terminations 41. The solder balls 84 are formed on all of the thin film transducers at the wafer level during fabrication of the thin film transducers by evaporating solder through a mask placed over the wafer before the wafer is cut into the individual sliders. Fig. 5 thus illustrates an intermediate step in the method for simultaneously mechanically and electrically attaching the slider to the suspension. During this step the slider 16 is located on solder balls 80 with the solder balls 80 being in registration between solder contact pads 70 and solder-wettable regions 60. Solder balls 84 on the slider trailing edge 26 are aligned with but out of contact with the corresponding row of solder balls 82 on the suspension. With the slider supported in this position heat is then applied to all of the solder balls. This causes solder balls 80 to collapse, thereby permitting solder balls 82, 84 to come into contact and flow together to form generally right-angled solder joints 86 for providing the required electrical connection between transducer 11 and leads 46. The right-angle joints 86 formed on inactive transducer 13 provide electrical connection to conductive portion 52 and thus to slider 16.

The completed slider-suspension assembly is illustrated in Fig. 6, which shows the collapsed solder balls 80 and the joined solder balls 82, 84 forming the right angled solder joints 86. When the solder has cooled and solidified the slider is both mechanically attached to the suspension and the transducer leads 19, 21 are electrically connected to the electrical leads 46 formed on the suspension. Because the slider 16 is mechanically attached to the conductive layer 44 by the electrically conductive solder balls 80, an electrical path is provided for static discharge from the slider 16, thereby preventing destruction of transducer 11 caused by discharge through the pole tip 15 to the disk surface. As shown in Fig. 3, the area 54 of conductive layer 44 includes a ground lead portion 55 which extends back for grounding connection to the actuator arm (not shown). The right-angled solder joints 86 on inactive transducer 13 (Fig. 2) provide electrical connection from pole tips 17 to extensions 49 on conductive portion 52 and the reflowed solder balls 80 on portion 52. Conductive portion 52 in turn is electrically connected to slider 16 by reflowed solder balls 80, and slider 16 is

grounded by path 55 to the actuator arm (not shown). Thus any static charge on the disk will be discharged to ground through the pole tips 17 of inactive transducer 13, thereby avoiding the destruction of active transducer 11.

In the embodiment as just described the solder balls 80 are first formed onto the solder-wettable regions 60, 61 and 63 of the suspension 40. The solder balls 80 could instead be first formed onto the solder contact pads 70 on the slider 16. In addition, rather than spreading solder paste through a mask or evaporating solder through a mask onto either the slider back side 24 or the suspension 40, it is also possible to spread commercially available preformed solder balls over a mask to locate the solder balls through openings in the mask and then heat the preformed solder balls. The solder balls would then be formed and adhered to either the slider back side or the suspension and the mask would then be removed.

It is within the scope of the present invention to provide mechanical attachment of the slider 16 directly to a conventional stainless steel flexure, such as that described in the before mentioned US patent 4167765, provided solder-wettable regions are first formed on the stainless steel flexure. This may be accomplished by any known method of forming, on the stainless steel, metal films which are adherent to solder, and thereafter evaporating or otherwise forming solder onto the metal films formed on the stainless steel flexure. For example, the pattern of solder-wettable regions 60 could be formed on a stainless steel flexure by electroplating copper. If the slider is mechanically attached to the stainless steel suspension in this manner, then the electrical connection of the transducer can be made through the use of conventional twisted wires as previously described.

Referring now to Fig. 7, there is illustrated the identical invention with the exception that the composite suspension 40 now includes an underlying support layer 43, which may be a stainless steel flexure, onto which the base layer 42 is adhered. Portions of nonconductive base layer 42 are etched away in the areas 83 where solder balls 82 are to be aligned. Thus, when the copper layer 44 is formed it is placed in direct contact with stainless steel in the areas 83. This allows solder balls 80 to form both a mechanical connection and an electrical grounding path to the stainless steel support layer 43.

In all of the embodiments shown and described the solder may be any type with a melting point compatible with the other materials used in the slider-suspension assembly. For example, eutectic tin-bismuth (SnBi) or eutectic tin-lead (SnPb) solder is acceptable.

Referring again to Figs. 2 and 3, it should be

apparent that if the pattern of solder contact pads 70 formed on back side 24 of slider 16 is skewed relative to the slider, which is represented by dashed lines in Fig. 3, then the slider can be mounted to the suspension in a skewed manner. This may be desirable when the slider-suspension assembly is used on smaller diameter disk files or on disk files with rotary actuators, where it may be desirable to optimize the yaw angle of the slider relative to the data tracks.

It is only necessary that the slider contact pads be approximately aligned with their corresponding solderwetable regions prior to reflow. During reflow the solder balls will be wetted to both the contact pads and the corresponding solder-wetable regions and will cause the slider to be precisely aligned on the suspension. The solder balls used to mechanically attach the slider result in the slider back side and suspension being generally parallel because any variations in size among solder balls is averaged out by the relatively large number of solder balls used. If, however, certain of the circular slider solder contact pads and/or suspension solder-wetable regions are formed so as to have a larger diameter than others in the patterns, but the mask used to form the solder on those selected pads or regions has openings all of the same diameter, then a larger portion of each of the solder balls that is formed on those selected pads or regions during reflow will be wetted to those pads or regions. This will result in a shorter solder joint at those selected pads or regions. This will permit the slider to be mechanically attached to the suspension so as to be slightly nonparallel to the planar suspension, because those solder balls formed on larger diameter pads and/or regions will form shorter joints when reflowed. For example, with reference to Fig. 7, if the solder contact pads and associated suspension solder-wetable regions near the leading edge (not shown in Fig. 7) of the slider have a larger diameter than those shown near the trailing edge 26 in Fig. 7, then the slider would be slightly tilted with respect to the suspension so that the slider will fly with a slight negative pitch attitude. Thus, with the present invention the slider may be mounted to the suspension with a slight pitch or roll, thereby eliminating the need to preform the flexure.

Claims

1. A shiftable, arm-like suspension (40) for a data recording disk file comprising:
a slider (16) attached to said suspension (40) and having an air bearing surface (18), a back side (24) opposite the air bearing surface (18), a plurality of solder contact pads (70) on the back side, and a trailing edge (26) oriented

generally perpendicular to the air bearing surface and back side for supporting a transducer (11, 13);

said suspension (40) having a corresponding plurality of discret solder-wetable regions (60) thereon, and

reflowed solder balls (80) for mechanically joining the slider to the suspension, each solder ball (80) connecting a solder contact pad (70) on the back side of the slider to an associated solder-wetable region (60) on the suspension.

2. A slider-suspension assembly for a data recording disk file comprising:

a slider (16) having an air bearing surface (18), a back side (24) opposite the air bearing surface (18), a plurality of solder points on the back side, and a trailing edge (26) oriented generally perpendicular to the air bearing surface and back side for supporting a transducer (11, 13);

a suspension (40) having a plurality of solder points (60) thereon; and electrical leads (48) provided for connection with said transducer (11, 13),

the assembly being characterised in that said plurality of solder points of said back side of said slider (16) is formed by discret contact pads (70) and said plurality of solder points on said suspension (40) is formed by a corresponding plurality of solder-wetable regions (60),

reflowed solder balls (80) for mechanically joining the slider to the suspension are provided, each solder ball (80) connecting a solder contact pad (70) on the back side of the slider to an associated solder-wetable region (60) on the suspension,

large area portions (52, 54) on the suspension for the mechanical attachment of said slider (16) to said suspension (40) are provided, and openings (60, 61, 63), preferably in circular form, in an insulating cover layer (48) which expose underlying patterned conductive layer (44) and which define a pattern of solder-wetable regions (60) on said suspension (40) are provided.

3. The slider-suspension assembly according to claim 1 or 2 wherein the suspension (40) is stainless steel (43) and wherein the solder-wetable regions are formed on the stainless steel.

4. The slider-suspension assembly according to claim 1, 2 or 3 wherein the suspension is a composite structure (40) comprising a nonconductive base layer (42), a patterned conductive



apparent that if the pattern of solder contact pads 70 formed on back side 24 of slider 16 is skewed relative to the slider, which is represented by dashed lines in Fig. 3, then the slider can be mounted to the suspension in a skewed manner. This may be desirable when the slider-suspension assembly is used on smaller diameter disk files or on disk files with rotary actuators, where it may be desirable to optimize the yaw angle of the slider relative to the data tracks.

It is only necessary that the slider contact pads be approximately aligned with their corresponding solderwetable regions prior to reflow. During reflow the solder balls will be wetted to both the contact pads and the corresponding solder-wetable regions and will cause the slider to be precisely aligned on the suspension. The solder balls used to mechanically attach the slider result in the slider back side and suspension being generally parallel because any variations in size among solder balls is averaged out by the relatively large number of solder balls used. If, however, certain of the circular slider solder contact pads and/or suspension solder-wetable regions are formed so as to have a larger diameter than others in the patterns, but the mask used to form the solder on those selected pads or regions has openings all of the same diameter, then a larger portion of each of the solder balls that is formed on those selected pads or regions during reflow will be wetted to those pads or regions. This will result in a shorter solder joint at those selected pads or regions. This will permit the slider to be mechanically attached to the suspension so as to be slightly nonparallel to the planar suspension, because those solder balls formed on larger diameter pads and/or regions will form shorter joints when reflowed. For example, with reference to Fig. 7, if the solder contact pads and associated suspension solder-wetable regions near the leading edge (not shown in Fig. 7) of the slider have a larger diameter than those shown near the trailing edge 26 in Fig. 7, then the slider would be slightly tilted with respect to the suspension so that the slider will fly with a slight negative pitch attitude. Thus, with the present invention the slider may be mounted to the suspension with a slight pitch or roll, thereby eliminating the need to preform the flexure.

Claims

1. A shiftable, arm-like suspension (40) for a data recording disk file comprising:
a slider (16) attached to said suspension (40) and having an air bearing surface (18), a back side (24) opposite the air bearing surface (18), a plurality of solder contact pads (70) on the back side, and a trailing edge (26) oriented

generally perpendicular to the air bearing surface and back side for supporting a transducer (11, 13);

said suspension (40) having a corresponding plurality of discret solder-wetable regions (60) thereon, and

reflowed solder balls (80) for mechanically joining the slider to the suspension, each solder ball (80) connecting a solder contact pad (70) on the back side of the slider to an associated solder-wetable region (60) on the suspension.

2. A slider-suspension assembly for a data recording disk file comprising:

a slider (16) having an air bearing surface (18), a back side (24) opposite the air bearing surface (18), a plurality of solder points on the back side, and a trailing edge (26) oriented generally perpendicular to the air bearing surface and back side for supporting a transducer (11, 13);

a suspension (40) having a plurality of solder points (60) thereon; and electrical leads (46) provided for connection with said transducer (11, 13),

the assembly being characterised in that said plurality of solder points of said back side of said slider (16) is formed by discret contact pads (70) and said plurality of solder points on said suspension (40) is formed by a corresponding plurality of solder-wetable regions (60),

reflowed solder balls (80) for mechanically joining the slider to the suspension are provided, each solder ball (80) connecting a solder contact pad (70) on the back side of the slider to an associated solder-wetable region (60) on the suspension,

large area portions (52, 54) on the suspension for the mechanical attachment of said slider (16) to said suspension (40) are provided, and openings (60, 61, 63), preferably in circular form, in an insulating cover layer (48) which expose underlying patterned conductive layer (44) and which define a pattern of solder-wetable regions (60) on said suspension (40) are provided.

3. The slider-suspension assembly according to claim 1 or 2 wherein the suspension (40) is stainless steel (43) and wherein the solder-wetable regions are formed on the stainless steel.

4. The slider-suspension assembly according to claim 1, 2 or 3 wherein the suspension is a composite structure (40) comprising a nonconductive base layer (42), a patterned conductive



- layer (44) formed on the base layer and an insulating cover layer (48) formed over the patterned conductive layer, and wherein the solder-wettable regions (60) are defined on the conductive layer by said openings in the insulating cover layer (48).
5. The slider-suspension assembly according to claim 4 wherein the conductive layer includes a ground lead portion for providing an electrical connection of the slider to ground.
 6. The slider-suspension assembly according to anyone of claims 1 - 5 further comprising a thin film transducer (11, 13) with electrically conductive leads (19, 21, 27, 29) formed on the trailing edge (26) and extending across the trailing edge to near the back side (24) of the slider (16), and a generally right angled reflowed solder joint (41, 86) formed between each of the leads on the trailing edge and an associated solder-wettable region (63) on the conductive layer of the suspension.
 7. The slider-suspension assembly according to anyone of claims 1-6 wherein each of the solder contact pads (70) on the back side (24) of the slider (16) further comprises an adhesion film (74) formed on the slider back side and a film (76) of solder-wettable material formed on and adhered to the adhesion film (74).
 8. The slider-suspension assembly according to anyone of the claims 1-7 wherein the diameter of a portion of either the solder contact pads (70) or the solder-wettable regions (60, 61, 63) is different than the diameter of the remaining solder contact pads or solder-wettable regions, whereby the slider is joined to the suspension with its back side slightly nonparallel to the suspension.
 9. The slider-suspension assembly according to claim 8 further comprising a second like transducer (13) formed on the slider trailing edge (26), wherein the plurality of generally right-angled reflowed solder joints includes joints connecting the second transducer lead terminations (27, 29) to associated solder-wettable regions (49) not in registration with solder contact pads and wherein the solder-wettable regions joined to said second transducer are electrically coupled to said portion of the conductive layer, whereby said second transducer is electrically connected to ground and thereby rendered inactive.
 10. A method for connecting a slider (16) to a suspension (40) comprising the steps of: forming on the generally planar back side of the slider a plurality of discret solder contact pads (70); providing on that portion of the suspension to which the back side of the slider is to be joined a corresponding plurality of discret solder-wettable regions (60); forming solder balls (80) on each of either the solder contact pads (70) on the slider or the solder-wettable regions (60) on said suspension portion; locating the slider back side adjacent said suspension portion such that the solder contact pads (70) are in approximate alignment with corresponding solder-wettable regions (60) and the solder balls (80) are in registration with and located between the solder contact pads and the corresponding solder-wettable regions, and heating the solder balls (80) so as to reflow the solder and thereby mechanically join and precisely align the slider to the suspension.
 11. The method according to claim 10 wherein the step of forming the solder contact pads (70) comprises locating a mask having a plurality of openings over the slider back side, evaporating a first adhesion film onto the slider back side through the mask openings and evaporating a solder-wettable film onto the adhesion film through the mask openings.
 12. The method according to claim 10 wherein the step of forming the solder balls (80) comprises the steps of either evaporating a solder film onto the solder-wettable film through the mask openings or spreading solder paste onto the solder-wettable film through the mask openings, removing the mask and thereafter heating the solder film so as to form solder balls (80) adhered to the solder contact pads.
 13. The method according to claim 12 wherein the step of forming the solder balls (80) comprises the steps of locating a mask having openings therein over said suspension portion, either evaporating solder or spreading solder paste through the mask openings so as to form a solder film onto the solder-wettable regions of said suspension portion, removing the mask and thereafter heating the solder film so as to form solder balls (80) adhered to the solder-wettable regions of said suspension portion.
 14. The method according to anyone of claims 10-13 wherein the slider is the type having a thin film transducer (11, 13) formed on its trailing



edge (26), the thin film transducer having electrical leads (19, 21, 27, 29) formed on the trailing edge and terminating generally at the junction of the trailing edge and slider back side, and wherein a patterned conductive layer (44) is provided on the suspension including electrical leads for connection with the transducer (11, 13), the method further comprising the steps of:

forming solder balls (84) on the transducer lead terminations (41);

providing on the suspension proximate the location for the trailing edge (26) of the slider a second plurality of solder-wettable regions (63), at least a portion of said second solder-wettable regions being connected to an electrical lead on the patterned conductive layer;

forming solder balls (82) on said second plurality of solder-wettable regions (63); and

while heating the solder balls (80) located between the slider back side and said suspension portion, heating the solder balls (84) on the transducer lead terminations (41) and associated second plurality of solder-wettable regions (63) on the suspension to thereby form generally right-angled electrical solder joints (86) between the thin film transducer on the slider and the electrical leads on the suspension.

Revendications

1. Suspension déplaçable (40), du type à bras, pour une unité de disques d'enregistrement de données, comprenant :

un glisseur (16) fixé à ladite suspension (40) et présentant une surface de portée sur air (18), un dos (24) opposé à la surface de portée (18), une pluralité de plots de contact en matière de soudage (70) sur le dos, et un bord de queue (26) orienté sensiblement perpendiculairement à la surface de portée et au dos pour supporter un transducteur (11,13);

ladite suspension (40) comportant une pluralité correspondante de régions discrètes (60) mouillables par la matière de soudage ; et

des gouttes de matière de soudage reliquifiée (80) pour relier mécaniquement le glisseur à la suspension, chaque goutte de matière de soudage (80) reliant un plot de contact en matière de soudage (70), sur le dos du glisseur, à une région associée mouillable par la matière de soudage (60) sur la suspension.

2. Ensemble de glisseur et suspension, pour une unité de disques d'enregistrement de données, comprenant :

un glisseur (16) présentant une surface de

portée sur coussin d'air (18), un dos (24) opposé à la surface de portée (18), une pluralité de points de matière de soudage sur le dos, et un bord de queue (26) orienté sensiblement perpendiculairement à la surface de portée sur coussin d'air et au dos, pour supporter un transducteur (11,13) ;

une suspension (40) comportant une pluralité de points de matière de soudage (60) ; et

des conducteurs électriques (48) prévus pour connexion avec ledit transducteur (11,13); l'ensemble étant caractérisé en ce que :

ladite pluralité de points de matière de soudage dudit dos dudit glisseur (16) est formée par des plots de contact discrets (70) et ladite pluralité de points de matière de soudage sur ladite suspension (40) est formée par une pluralité correspondante de régions (60) mouillables par la matière de soudage ;

il est prévu des gouttes de matière de soudage reliquifiée (80) pour relier mécaniquement le glisseur à la suspension, chaque goutte de matière de soudage (80) reliant un plot de contact en matière de soudage (70) , sur le dos du glisseur, à une région associée mouillable par la matière de soudage (60), sur la suspension ;

il est prévu des parties de grande surface (52,54) sur la suspension, pour la fixation mécanique du dit glisseur (16) à ladite suspension (40) ; et

il est prévu des ouvertures (60,61,63) , de préférence de forme circulaire, dans une couche de couverture isolante (48), qui découvrent une couche conductrice dessinée sous-jacente (44) et qui définissent une configuration de régions mouillables par la matière de soudage (60) sur ladite suspension (40).

3. Ensemble de glisseur et suspension suivant la revendication 1 ou 2, dans lequel la suspension (40) est en acier inoxydable (43) et dans lequel les régions mouillables par la matière de soudage sont formées sur l'acier inoxydable.

4. Ensemble de glisseur et suspension suivant la revendication 1,2 ou 3, dans lequel la suspension est une structure composite (40) comprenant une couche de base non conductrice (42), une couche conductrice dessinée (44) formée sur la couche de base, et une couche de couverture isolante (48) formée sur la couche conductrice dessinée, et dans lequel les régions mouillables par la matière de soudage (60) sont définies sur la couche conductrice par lesdites ouvertures de la couche de couverture isolante (48).



5. Ensemble de glisseur et suspension suivant la revendication 4, dans lequel la couche conductrice comprend une partie de conducteur de terre, pour fournir une connexion électrique du glisseur à la terre.
6. Ensemble de glisseur et suspension suivant l'une quelconque des revendications 1 à 5, comprenant en outre un transducteur à couche mince (11,13), avec des conducteurs électriques (19,21,27,29) formés sur le bord de queue (26) et s'étendant en travers du bord de queue jusqu'au voisinage du dos (24) du glisseur (16), et une jonction en matière de soudage reliquifiée sensiblement à angle droit (41,86) formée entre chacun des conducteurs sur le bord de queue et une région associée mouillable par la matière de soudage (63) sur la couche conductrice de la suspension.
7. Ensemble de glisseur et suspension suivant l'une quelconque des revendications 1 à 6, dans lequel chacun des plots de contact en matière de soudage (70) sur le dos (24) du glisseur (16) comprend en outre un film d'adhérence (74), formé sur le dos du glisseur, et un film (76) de matière mouillable par la matière de soudage, formé et collé sur le film d'adhérence (74).
8. Ensemble de glisseur et suspension suivant l'une quelconque des revendications 1 à 7, dans lequel le diamètre d'une partie des plots de contact en matière de soudage (70) ou des régions mouillables par la matière de soudage (60,61,63) est différent du diamètre des autres plots de contact en matière de soudage ou des autres régions mouillables par la matière de soudage, de sorte que le glisseur est relié à la suspension d'une manière telle que son dos est légèrement non parallèle à la suspension.
9. Ensemble de glisseur et suspension suivant la revendication 8, comprenant en outre un deuxième transducteur semblable (13) formé sur le bord de queue (26) du glisseur, dans lequel la pluralité de jonctions sensiblement à angle droit en matière de soudage reliquifiée comprend des jonctions reliant les terminaisons de conducteurs (27,29) du deuxième transducteur à des régions associées (49) mouillables par la matière de soudage, non en alignement avec les plots de contact en matière de soudage, et dans lequel les régions mouillables par la matière de soudage jointes audit deuxième transducteur sont électriquement couplées à ladite partie de la couche conductrice, de sorte que ledit deuxième trans-

ducteur est électriquement relié à la terre et ainsi rendu inactif.

10. Méthode de fixation d'un glisseur (16) à une suspension (40), comprenant les étapes de :
 - 5 formation, sur le dos sensiblement plan du glisseur, d'une pluralité de plots de contact discrets en matière de soudage (70) ;
 - 10 préparation, sur la partie de la suspension à laquelle on veut fixer le dos du glisseur, d'une pluralité correspondante de régions discrètes (60) mouillables par la matière de soudage ;
 - 15 formation de gouttes de matière de soudage (80) sur chacun des plots de contact en matière de soudage (70) du glisseur ou sur chacune des régions mouillables par la matière de soudage (60) sur ladite partie de la suspension ;
 - 20 positionnement du dos du glisseur près de ladite partie de la suspension, de sorte que les plots de contact en matière de soudage (70) sont sensiblement en alignement avec les régions correspondantes mouillables par la matière de soudage (60) et les gouttes de matière de soudage (80) sont en alignement avec les plots de contact en matière de soudage et les régions correspondantes mouillables par la matière de soudage, et placées entre ces plots et ces régions ; et
 - 25 chauffage des gouttes de matière de soudage (80) de façon à reliquifier la matière de soudage et à relier ainsi mécaniquement et à aligner exactement le glisseur avec la suspension.
11. Méthode suivant la revendication 10, dans laquelle l'étape de formation des plots de contact en matière de soudage (70) comprend le positionnement d'un masque comportant une pluralité d'ouvertures sur le dos du glisseur, l'évaporation d'un premier film d'adhérence sur le dos du glisseur à travers les ouvertures du masque, et l'évaporation d'un film mouillable par la matière de soudage sur le film d'adhérence, à travers les ouvertures du masque.
12. Méthode suivant la revendication 10, dans laquelle l'étape de formation des gouttes de matière de soudage (80) comprend les opérations d'évaporation d'un film de matière de soudage sur le film mouillable par la matière de soudage, à travers les ouvertures du masque ou l'étalement de pâte à souder sur le film mouillable par la matière de soudage à travers les ouvertures du masque, d'enlèvement du masque, puis de chauffage du film de matière



de soudage de façon à former des gouttes de matière de soudage (80) qui adhèrent aux plots de contact en matière de soudage.

3. Méthode suivant la revendication 12, dans laquelle l'étape de formation des gouttes de matière de soudage (80) comprend les opérations de positionnement d'un masque comportant des ouvertures sur ladite partie de la suspension, d'évaporation de matière de soudage ou d'étalement de pâte à souder à travers les ouvertures du masque de façon à former un film de matière de soudage sur les régions mouillables par la matière de soudage de ladite partie de suspension, d'enlèvement du masque, puis de chauffage du film de matière de soudage de façon à former des gouttes de matière de soudage (80) qui adhèrent aux régions mouillables par la matière de soudage de ladite partie de suspension.

14. Méthode suivant l'une quelconque des revendications 10 à 13, dans laquelle le glisseur est du type comportant un transducteur à couche mince (11,13) formé sur son bord de queue (26), le transducteur à couche mince ayant des conducteurs électriques (19,21,27,29) formés sur le bord de queue et se terminant sensiblement à la jonction du bord de queue et du dos du glisseur, et dans laquelle une couche conductrice dessinée (44) est prévue sur la suspension et comprend des conducteurs électriques pour connexion avec le transducteur (11,13),

la méthode comprenant en outre les étapes de :

formation de gouttes de matière de soudage (84) sur les terminaisons (41) des conducteurs de transducteur ;

préparation, sur la suspension et à proximité de l'emplacement du bord de queue (26) du glisseur, d'une deuxième pluralité de régions mouillables par la matière de soudage (63), au moins une partie desdites deuxième régions mouillables par la matière de soudage étant connectée à un conducteur électrique sur la couche conductrice dessinée ;

formation de gouttes de matière de soudage (82) sur ladite deuxième pluralité de régions mouillables par la matière de soudage (63) ; et

pendant le chauffage des gouttes de matière de soudage (80) situées entre le dos du glisseur et ladite partie de la suspension, chauffage des gouttes de matière de soudage (84) sur les terminaisons (41) des conducteurs de transducteur et ladite deuxième pluralité de régions associées mouillables par la matière de soudage (63) sur la suspension afin de

former des jonctions électriques sensiblement à angle droit (86), en matière de soudage, entre le transducteur à couche mince sur le glisseur et les conducteurs électriques sur la suspension.

Patentansprüche

1. Verschiebbare armartige Aufhängung (40) für einen Plattenspeicher zur Datenaufzeichnung, enthaltend:
einen Gleitschuh (16), der an der Aufhängung (40) befestigt ist und eine Fläche (18) für ein Luftpolster aufweist, eine Rückseite (24) gegenüber der Fläche (18) für das Luftpolster, eine Vielzahl von Lötkontaktflecken (70) auf der Rückseite und eine Ablaufseite (26), die für das Tragen eines Wandlers (11, 13) generell senkrecht zu der Fläche für das Luftpolster und der Rückseite orientiert ist, wobei die Aufhängung (40) eine entsprechende Vielzahl von diskreten, durch Lot benetzbaren Bereichen (60) darauf aufweist, und aufgeschmolzene Lotkugeln (80) zur mechanischen Verbindung des Gleitschuhs mit der Aufhängung, wobei jede Lotkugel (80) einen Lötkontaktfleck (70) auf der Rückseite des Gleitschuhs mit einem zugeordneten, durch Lot benetzbaren Bereich (60) auf der Aufhängung verbindet.
2. Gleitschuh-Aufhängungseinheit für einen Plattenspeicher zur Datenaufzeichnung, enthaltend:
einen Gleitschuh (16), der eine Fläche (18) für ein Luftpolster, eine Rückseite (24) gegenüber der Fläche (18) für das Luftpolster, eine Vielzahl von Lötunkten auf der Rückseite und eine Ablaufseite (26) aufweist, die für das Tragen eines Wandlers (11, 13) generell senkrecht zu der Fläche für das Luftpolster und die Rückseite orientiert ist, eine Aufhängung (40), die eine Vielzahl von Lötunkten (60) darauf aufweist und elektrische Leiter (46), die zur Verbindung mit dem Wandler (11, 13) vorgesehen sind, wobei die Baugruppe dadurch gekennzeichnet ist, daß die Vielzahl von Lötunkten auf der Rückseite des Gleitschuhs (16) durch diskrete Kontaktflecken (70) gebildet wird und die Vielzahl von Lötunkten auf der Aufhängung (40) durch eine entsprechende Vielzahl von durch Lot benetzbaren Bereichen (60), aufgeschmolzene Lotkugeln (80) zur mechanischen Verbindung des Gleitschuhs mit der Aufhängung vorgesehen sind, wobei jede Lotkugel (80) einen Lötkontaktfleck (70) auf der Rückseite des Gleitschuhs mit einem zugeord-



- neten, durch Lot benetzbaren Bereich (60) auf der Aufhängung verbindet, große Teilflächen (52, 54) auf der Aufhängung zur mechanischen Befestigung des Gleitschuhs (16) mit der Aufhängung (40) vorgesehen sind und Öffnungen (60, 61, 63), vorzugsweise in runder Form, in einer isolierenden Deckschicht (48) vorgesehen sind, die eine darunterliegende, mit einem Muster versehene leitende Schicht (44) freilegen und die ein Muster von durch Lot benetzbaren Bereichen (60) auf der Aufhängung (40) definieren.
3. Gleitschuh-Aufhängungsbaugruppe nach Anspruch 1 oder 2, bei der die Aufhängung (40) aus rostfreiem Stahl (43) besteht und bei der die durch Lot benetzbaren Bereiche auf dem rostfreien Stahl gebildet werden.
 4. Gleitschuh-Aufhängungsbaugruppe nach Anspruch 1, 2 oder 3, bei der die Aufhängung eine zusammengesetzte Struktur (40) ist, die eine nichtleitende Basisschicht (42), eine mit einem Muster versehene leitende Schicht (44), die auf der Basisschicht gebildet wird, und eine isolierende Deckschicht (48) aufweist, die über der mit einem Muster versehenen leitenden Schicht gebildet wird, wobei die durch Lot benetzbaren Bereiche (60) auf der leitenden Schicht durch die Öffnungen in der isolierenden Deckschicht (48) definiert sind.
 5. Gleitschuh-Aufhängungsbaugruppe nach Anspruch 4, bei der die leitende Schicht einen Masseleiterteil für die elektrische Verbindung des Gleitschuhs mit Masse aufweist.
 6. Gleitschuh-Aufhängungsbaugruppe nach einem der Ansprüche 1 bis 5, weiter enthaltend einen Dünnschichtwandler (11, 13) mit elektrischen Leitern (19, 21, 27, 29), die auf der Ablaufseite (26) gebildet werden und sich über die Ablaufseite bis nahe zu der Rückseite (24) des Gleitschuhs (16) erstrecken, und eine generell rechtwinklige, aufgeschmolzene Lötverbindung (41, 86), die zwischen jedem der Leiter auf der Ablaufseite und einem zugeordneten, durch Lot benetzbaren Bereich (63) auf der leitenden Schicht der Aufhängung gebildet ist.
 7. Gleitschuh-Aufhängungsbaugruppe nach einem der Ansprüche 1 bis 6, bei der jede der Lötkontaktflecken (70) auf der Rückseite (24) des Gleitschuhs (16) weiter einen Adhäsionsfilm (74) umfaßt, der auf der Rückseite des Gleitschuhs gebildet ist, und einen Film (76) aus durch Lot benetzbarem Material, der auf dem Adhäsionsfilm (74) gebildet und daran befestigt ist.
 8. Gleitschuh-Aufhängungsbaugruppe nach einem der Ansprüche 1 bis 7, bei der der Durchmesser eines Teiles entweder der Lötkontaktflecken (70) oder der durch Lot benetzbaren Bereiche (60, 61, 63) verschieden von dem Durchmesser der übrigen Lötkontaktflecken oder durch Lot benetzbaren Bereiche ist, wobei der Gleitschuh mit der Aufhängung verbunden und seine Rückseite leicht nichtparallel zur Aufhängung angebracht ist.
 9. Gleitschuh-Aufhängungsbaugruppe nach Anspruch 8, weiter umfassend einen zweiten gleichen Wandler (13), der auf der Ablaufseite (26) des Gleitschuhs gebildet ist, wobei die Vielzahl von generell rechtwinkligen, aufgeschmolzenen Lötverbindungen Verbindungen einschließt, die die Leitungsabschlüsse (27, 29) des zweiten Wandlers mit den zugeordneten, durch Lot benetzbaren Bereichen (49), die nicht mit den Lötkontaktflecken ausgerichtet sind, verbinden und bei dem die durch Lot benetzbaren Bereiche, die mit dem zweiten Wandler elektrisch verbunden sind, mit dem genannten Teil der leitenden Schicht elektrisch gekoppelt sind, wodurch der zweite Wandler elektrisch mit Masse verbunden ist und dadurch inaktiv gemacht wird.
 10. Verfahren zum Verbinden eines Gleitschuhs (16) mit einer Aufhängung (40), umfassend die Schritte des:
Bildens einer Vielzahl von diskreten Lötkontaktflecken (70) auf der generell ebenen Rückseite des Gleitschuhs,
Vorsehens einer entsprechenden Vielzahl von diskreten durch Lot benetzbaren Bereichen (60) auf dem Teil der Aufhängung, mit dem die Rückseite des Gleitschuhs zu verbinden ist,
Bildens von Lotkugeln (80) auf entweder jedem der Lötkontaktflecken (70) auf dem Gleitschuh oder jedem der durch Lot benetzbaren Bereiche (60) auf dem genannten Teil der Aufhängung,
Festlegens der Rückseite des Gleitschuhs angrenzend an den genannten Teil der Aufhängung so, daß die Lötkontaktflecken (70) in ungefähre Ausrichtung mit den entsprechenden, durch Lot benetzbaren Bereichen (60) gelangen und die Lotkugeln (80) ausgerichtet sind mit und angeordnet sind zwischen den Lötkontaktflecken und den entsprechenden, durch Lot benetzbaren Bereichen und
des Erwärmens der Lotkugeln (80), um das Lot



aufzuschmelzen und dadurch den Gleitschuh mechanisch mit der Aufhängung zu verbinden und genau auszurichten.

1. Verfahren nach Anspruch 10, bei dem der Schritt des Bildens der Lötkontaktflecken (70) umfaßt: das Anbringen einer Maske mit einer Vielzahl von Öffnungen über der Rückseite des Gleitschuhs, das Aufdampfen eines ersten Adhäsionsfilms auf die Rückseite des Gleitschuhs durch die Maskenöffnungen hindurch und das Aufdampfen eines durch Lot benetzbaren Filmes auf den Adhäsionsfilm durch die Maskenöffnungen hindurch. 5
12. Verfahren nach Anspruch 10, bei dem der Schritt des Bildens der Lotkugeln (80) die Schritte umfaßt entweder des Aufdampfens eines Lotfilmes auf den durch Lot benetzbaren Film durch die Maskenöffnungen hindurch oder des Auftragens einer Lotpaste auf den durch Lot benetzbaren Film durch die Maskenöffnungen hindurch, des Entfernens der Maske und des anschließenden Erhitzens des Lotfilmes, um an den Lötkontaktflecken haftende Lotkugeln (80) zu bilden. 10 15 20 25
13. Verfahren nach Anspruch 12, bei dem der Schritt des Bildens der Lotkugeln (80) die Schritte umfaßt des Anbringens einer Maske mit Öffnungen darin über dem genannten Teil der Aufhängung, entweder des Aufdampfens von Lot oder des Auftragens einer Lotpaste durch die Maskenöffnungen hindurch, um auf den durch Lot benetzbaren Bereichen des genannten Teils der Aufhängung einen Lotfilm zu bilden, des Entfernens der Maske und des anschließenden Erhitzens des Lotfilmes, um an den durch Lot benetzbaren Bereichen des genannten Teiles der Aufhängung haftende Lotkugeln (80) zu bilden. 30 35 40
14. Verfahren nach irgendeinem der Ansprüche 10 bis 13, bei dem der Gleitschuh von der Art ist, bei der ein Dünnfilmwandler (11, 13) auf seiner Ablaufseite (26) gebildet ist, wobei der Dünnfilmwandler elektrische Leiter (19, 21, 27, 29) aufweist, die auf seiner Ablaufseite gebildet wurden und die generell an der Verbindung der Ablaufseite und der Rückseite des Gleitschuhs enden, und bei dem eine mit einem Muster versehene leitende Schicht (44) auf der Aufhängung vorgesehen ist, die elektrische Leiter zur Verbindung mit dem Wandler (11, 13) einschließt, wobei das Verfahren weiter die Schritte umfaßt des: 45 50 55
Bildens von Lotkugeln (84) auf den Leiterenden (41) des Wandlers,

Vorsehens einer zweiten Vielzahl von durch Lot benetzbaren Bereichen (63) auf der Aufhängung unmittelbar an der Stelle der Ablaufseite (26) des Gleitschuhs, wobei zumindest ein Teil der zweiten, durch Lot benetzbaren Bereiche mit einem elektrischen Leiter auf der mit einem Muster versehenen leitenden Schicht verbunden ist, Bildens von Lotkugeln (82) auf der zweiten Vielzahl von durch Lot benetzbaren Bereichen (63) und während des Erwärmens der Lotkugeln (80), die zwischen der Rückseite des Gleitschuhs und dem genannten Teil der Aufhängung sich befinden, des Erwärmens der Lotkugeln (84) auf den Leiterenden (41) des Wandlers und der zugeordneten zweiten Vielzahl von durch Lot benetzbaren Bereichen (63) auf der Aufhängung, um dadurch generell rechtwinklige elektrische Lötverbindungen (86) zwischen dem Dünnfilmwandler auf dem Gleitschuh und den elektrischen Leitern auf der Aufhängung zu bilden.