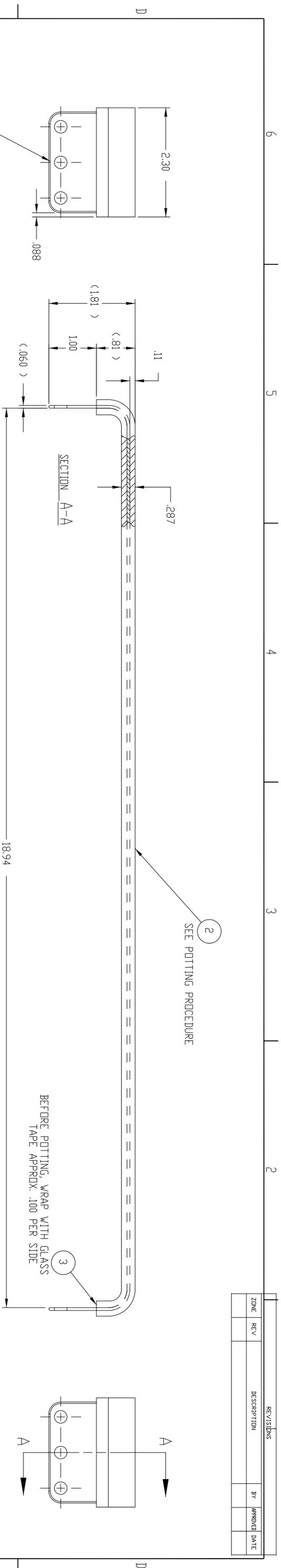


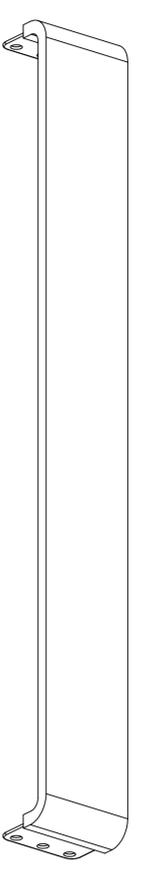
REVISIONS					
ZONE	REV	DESCRIPTION	BY	APPROVED	DATE



AFTER COIL IS POTTED AND REMOVED FROM FIXTURE, REMOVE EXCESS EPOXY AS SHOWN ON THE ENDS OF COIL

POTTING PROCEDURE BY RICK PUTNAM EXT. 5915

1. COAT FIXTURE WITH RAM MOLD RELEASE ON INSIDE SURFACES. ALLOW MOLD RELEASE TO DRY.
2. INSERT WRAPPED COIL IN FIXTURE AND APPLY PINK RTV PRIMER TO SEALING SURFACES. ALLOW TO DRY.
3. MIX RTV 21 WITH T-12 CURING AGENT AND APPLY TO MOLD AT JOINTS AND AREAS TO BE SEALED.
4. PUT FIXTURE IN 150°F OVEN AND HEAT OVER NIGHT TO CURE RUBBER AND PREHEAT MOLD.
5. WEIGH 400 GRAMS OF (DDW) DER 332 AND 400 GRAMS OF DER 736 RESINS. MIX AND HEAT TO 150°F
6. WEIGH OUT 720 GRAMS NMA AND HEAT TO 150°F
7. ATTACH FILL HOSE TO BOTTOM OF POTTING MOLD AND A 1 PINT OVERFLOW CAN ON PUMP OUT PIPE.
8. PUT FIXTURE IN PUMP OUT TANK. ATTACH HOSES TO FILL PORT. ATTACH EPOXY MIXING TANK TO FILL PORT AND PINCH OFF HOSE. REPLACE COVER ON VACUUM TANK.
9. START VACUUM PUMP AND VACUATE PUMP OUT TANK.
10. MIX DER 332 - DER 736 MIXTURE WITH NMA. WEIGH OUT 7.2 GRAMS OF BDMA AND ADD TO 332-736-NMA MIXTURE. ALSO, WEIGH OUT AND ADD 8 GRAMS OF DDW Z-6040 SILANE COUPLING AGENT.
11. ADD EPOXY TO MIX TANK AND PUT COVER ON. MIX EPOXY INSIDE TANK WITH STIRRER. EVACUATE MIX TANK AND DE-GAS.
12. ONCE PUMP OUT TANK REACHES 350μ OF VACUUM, LET EPOXY MIXING TO ATMOSPHERE. OPEN FILL LINE VALVE AND SLOWLY FILL POTTING FIXTURE UNTIL RESIN APPEARS IN OVERFLOW CAN. FILL TO A DEPTH OF .1 TO 1.5 INCHES IN CAN.
13. CLOSE FILL VALVE AND LET PUMP OUT TANK UP TO ATMOSPHERE.
14. CLAMP OFF FILL HOSE AND PUT MOLD IN OVEN. CURE AT PROPER OVEN TEMP. AND TIMES. (4 HRS. @ 190°F THEN 6 HRS @305°F COOL TO 170°F AND HOLD.)
15. AFTER CURING REMOVE FROM OVEN AT A TEMP. 170°F AND DISASSEMBLY MOLD HOT. ALLOW COIL TO COOL SLOWLY TO ROOM TEMP.



TRIMETRIC VIEW  
SCALE 1/2"

NOTE:

1. ITEM 2, PART NO. 31010503-104002 AND ITEM 3, REQUIRE NO INDIVIDUAL DETAILING

ITEM	DRAWING/PART NUMBER	DESCRIPTION	MATERIAL/SPEC	QTY
3	SEE NOTE	GLASS TAPE ENCLOSURE	EPOXY RESIN	1
2	31010503-104002	EPOXY POTTING ENCLOSURE (SEE NOTE)	SEE PROCEDURE	1
1	31010503-104001	MAGNET COIL	DHC COPPER	1

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES		PARTS LIST/BILL OF MATERIALS	
DECIMALS	ANGULAR	DRAWN BY:	M. GIVENS
1/16	±.05°	CHECKED BY:	L. MORRISON
1/32	±.02°	DESIGNED BY:	L. MORRISON
1/64	±.01°	DATE:	06-Feb-02
1/128	±.005°	RESPONSIBLE ENGINEER:	L. MORRISON
1/256	±.0025°	DATE:	
1/512	±.00125°	DATE:	
1/1024	±.000625°	DATE:	
1/2048	±.0003125°	DATE:	
1/4096	±.00015625°	DATE:	
1/8192	±.000078125°	DATE:	
1/16384	±.0000390625°	DATE:	
1/32768	±.00001953125°	DATE:	
1/65536	±.000009765625°	DATE:	
1/131072	±.0000048828125°	DATE:	
1/262144	±.00000244140625°	DATE:	
1/524288	±.000001220703125°	DATE:	
1/1048576	±.0000006103515625°	DATE:	
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