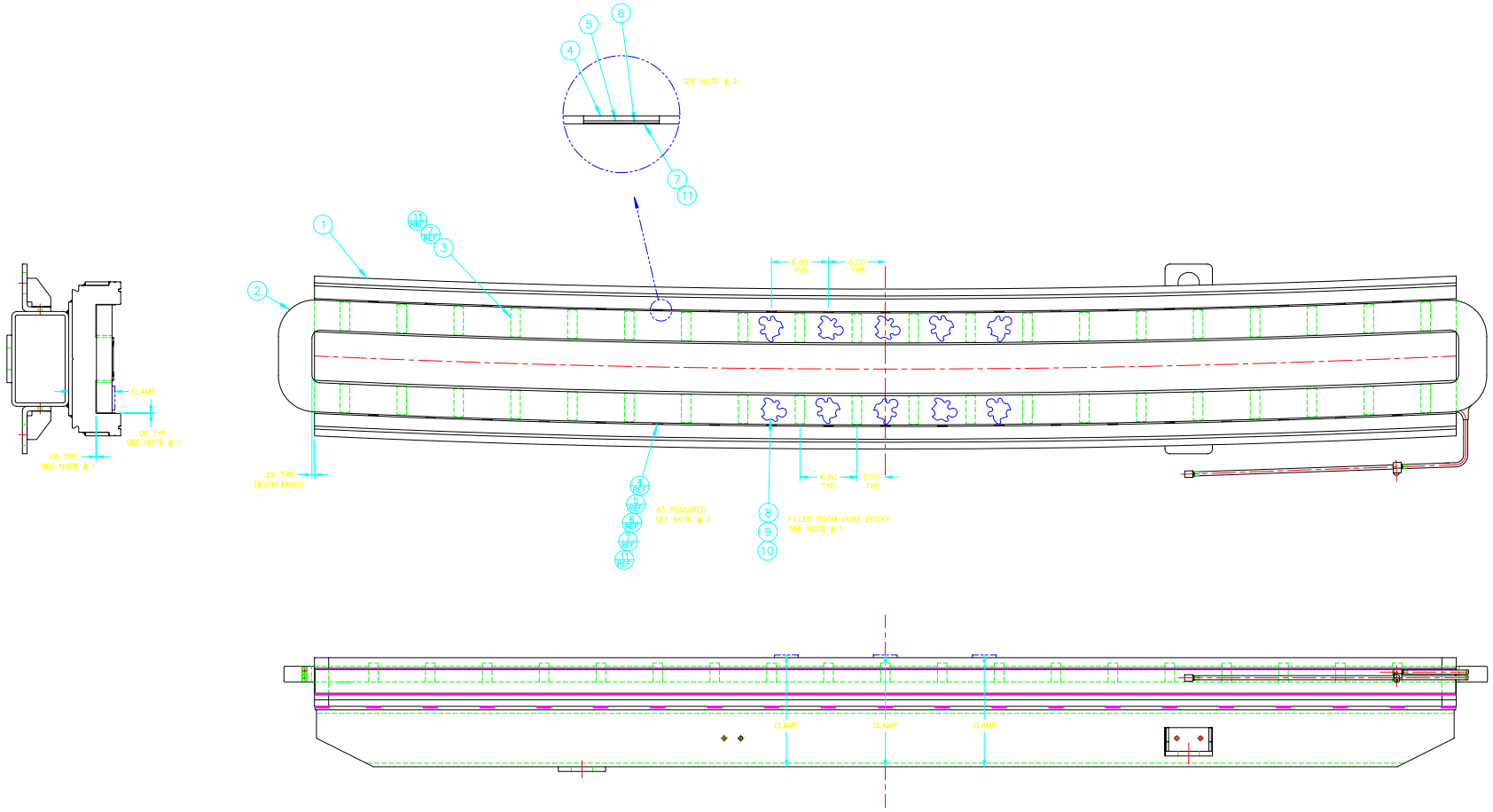
(E)	PLOT SCALE: 1=4.0	DWG. SCALE: 4.0	A06393



INJECTOR SYNCHROTRON DIPOLE MAGNET COIL / CORE – LOWER ASSEMBLY A06393 220101–00298–00

NOTES:

1. MIX EPOXY IN QUANTITY SHOWN:

828	400 gm
EM–308	70 gm
CABOSIL	TO SUIT

APPLY IN LOCATIONS AS SHOWN.

2. AFTER COIL IS CURED, INSTALL SHIMS IN LOCATIONS SHOWN AND SNUG SHIMMING TO COILS.

ESTIMATED WEIGHT: 3000 LBS.

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY.
11		INDUSTRIAL ADHESIVE	HENKEL–77	A/R
10		CABOSIL		A/R
9		EPOXY, 280 gm	EM–308	A/R
8		EPOXY, 400 gm	828	A/R
7	.005 THK. X 1.00 WIDE	KAPTON TAPE, STICK BACK	TYPE – H	A/R
6	.01 X 1.00 X 2.00 LG.	SHIM	G–10	19
5	.03 X 1.00 X 2.00 LG.	SHIM	G–10	19
4	.06 X 1.00 X 2.00 LG.	SHIM	G–10	38
3	.06 X 1.00 X 3.00 LG.	SHIM	G–10	40
2		DIPOLE COIL – LOWER	SEE DETAIL	1
1	220101–00285–00	DIPOLE HALF CORE WELDMENT – LOWER	SEE DETAIL	1

PARTS LIST

SYM	CHANGE DESCRIPTION REVISIONS	BY	CHKD	DATE

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES
TOLERANCES
DECIMALS ANGULAR
.X ± .125 ±.5°
.XX ± .016
.XXX ± .005
SURFACE ROUGHNESS 125√
REMOVE ALL BURRS AND SHARP EDGES
MINIMUM DETAIL IS 0.1 INCH
CONFORM TO ASME Y14.5M-1994
CONFORM TO ANSI Y14.5M-1982
DO NOT SCALE DRAWING

LOG NUMBER A06393
DRAWN BY HANUSKA/CJO DATE 7/17/96
CHECKED BY
DESIGNER
RESPONSIBLE ENGINEER
MATERIAL

THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY

TITLE ADVANCED PHOTON SOURCE
INJECTOR SYNCHROTRON
DIPOLE MAGNET
COIL / CORE – LOWER
ASSEMBLY

SCALE 1:4 SIZE E DRAWING NUMBER 220101–00298–00
SHEET 1 of 1