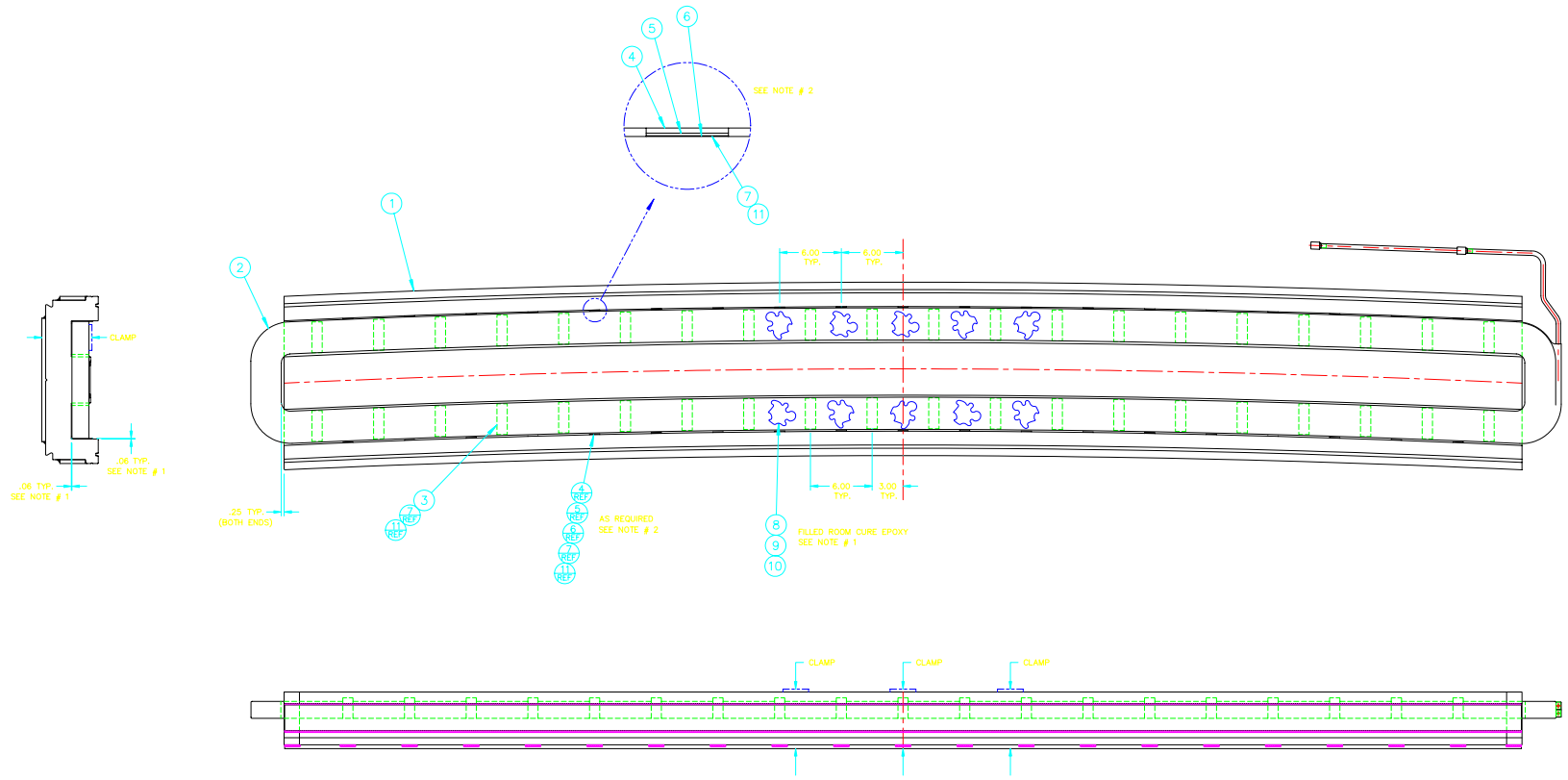
(E)	PLOT SCALE: 1=4	DWG. SCALE: 4	A06394



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: 2600 LBS.

INJECTOR SYNCHROTRON DIPOLE MAGNET COIL / CORE – UPPER ASSEMBLY A06394 220101-00299-00

PARTS LIST

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	220101-00190-00	DIPOLE COIL – UPPER	SEE DETAIL	1
1	220101-00212-00	DIPOLE HALF CORE WELDMENT – UPPER	SEE DETAIL	1

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
	REVISIONS			

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES
TOLERANCES
DECIMALS ANGULAR
.X ± .125 ±.50°
.XX ± .010
.XXX ± .005
SURFACE ROUGHNESS 125√
REMOVE ALL BURRS AND SHARP EDGES
MATERIAL SHALL BE FREE FROM ROLL MARKS
MATERIAL SHALL BE A CONFORMANCE WITH ASTM
MATERIAL SHALL BE FREE FROM ROLL
DO NOT SCALE DRAWING

LOG NUMBER A06394
DRAWN BY HANUSKA/CJO 7/17/00
CHECKED BY
DESIGNER
RESPONSIBLE ENGINEER
MATERIAL
DATE
SF DRAWER
DATE
PROJECT MGR.
APPROVED/RELEASED

THIS DRAWING IS THE PROPERTY OF
ARGONNE NATIONAL LABORATORY

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

SCALE 1:4
SHEET 1 of 1
SIZE E
DRAWING NUMBER 220101-00299-00