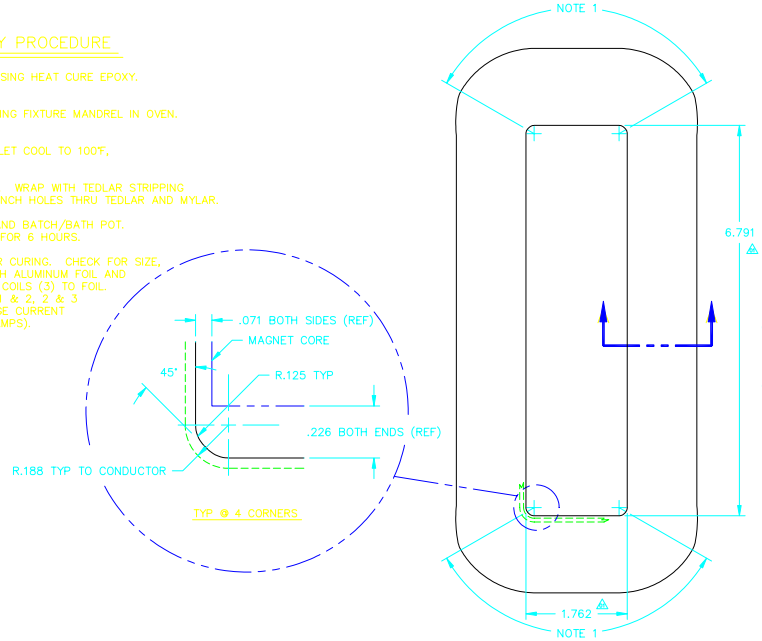
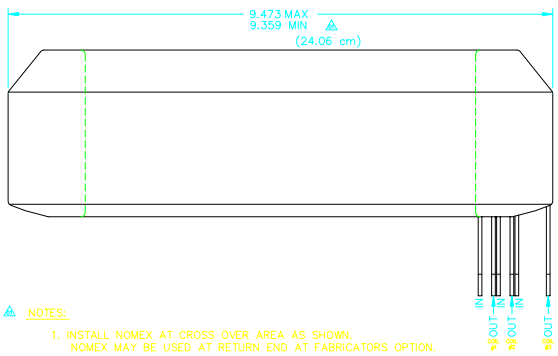
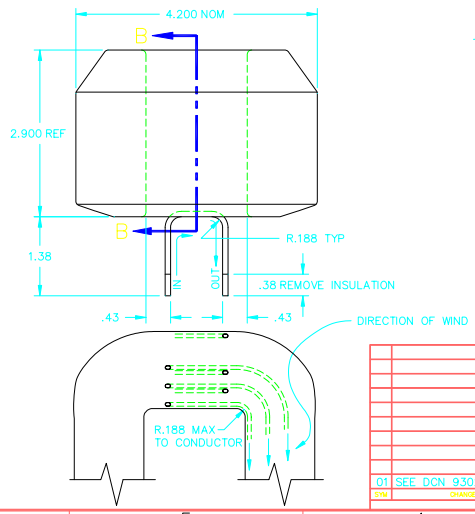
(D)	PLOT SCALE: 1=1	DWG. SCALE: 1	A08949

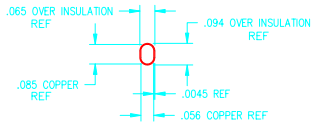
SUGGESTED ASSEMBLY PROCEDURE

1. WET WIND COILS ON FIXTURE USING HEAT CURE EPOXY. SEE NOTE 3.
2. CURE COIL ASSEMBLY ON WINDING FIXTURE MANDREL IN OVEN. CURE AT 300°F FOR 2 HOURS.
3. REMOVE FIXTURE FROM OVEN, LET COOL TO 100°F, REMOVE COIL FROM MANDREL.
4. GROUND WRAP COIL ASSEMBLY. WRAP WITH TEDLAR STRIPPING TAPE AND SHRINK MYLAR. PUNCH HOLES THRU TEDLAR AND MYLAR.
5. PLACE COIL IN CURING MOLD AND BATCH/BATH POT. SEE NOTE 4. CURE AT 300°F FOR 6 HOURS.
6. CLEAN-UP AND INSPECT AFTER CURING. CHECK FOR SIZE, Ls, Q, RESISTANCE. WRAP WITH ALUMINUM FOIL AND HI-POT TO 500V DC BETWEEN COILS (3) TO FOIL. ALSO HI-POT BETWEEN COILS 1 & 2, 2 & 3 AND 1 & 3. MAXIMUM LEAKAGE CURRENT NOT TO EXCEED 5ua (MICRO-AMPS).

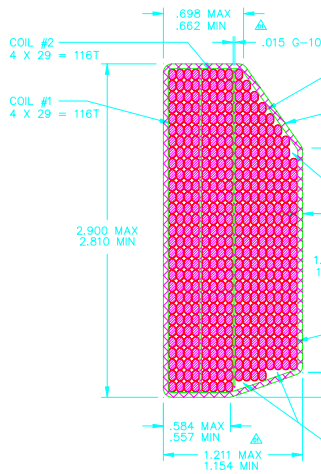




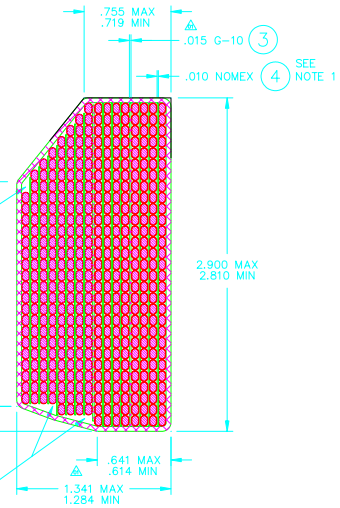




CONDUCTOR DETAIL
SCALE 4=1



SECTION A-A
SCALE 2=1



SECTION B-B
SCALE 2=1

NOTES:

1. INSTALL NOMEX AT CROSS OVER AREA AS SHOWN. NOMEX MAY BE USED AT RETURN END AT FABRICATORS OPTION.
2. FILL VOIDS WITH FIBER GLASS TAPE, CHOPPED FIBER GLASS OR MATT. OTHER MATERIAL MAY BE USED WITH PRIOR APPROVAL BY A.N.L.
3. HEAT CURE FILLED EPOXY, DER 332, DER 736, NMA AND CABOSIL.
4. HEAT CURE EPOXY, DER 332, DER 736, NMA.

PARTS LIST

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
6		FILLER FOR EPOXY, CABOSIL		AR
5		HEAT CURE EPOXY DER 332 75 PBW DER 736 25 PBW NMA 90 PBW		AR
4		CROSS OVER DIVIDER, .010	NOMEX	AR
3		COIL DIVIDER, .015 G-10	NEMA G-10 INSUL	2
2		GROUND WRAP 1/2" WIDE X .007	DRY GLASS TAPE	AR
1	250103-00011	PAR CORRECTOR MAGNET CONDUCTOR	SEE DETAIL	AR

REVISIONS

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
01	SEE DCN 930205-05	KWC		

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES
TOLERANCES
DECIMALS: .X ± .1, .XX ± .03, .XXX ± .015
ANGULAR ± .5°
SURFACE ROUGHNESS 125 √
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5
DO NOT SCALE DRAWING

LOG NUMBER: A08949

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DRAWN BY: K. COSTELLO	DATE: 9-22-92	GP LEADER: J. JAGGER	DATE: 9/22/92
CHECKED BY: J.JAGGER	9/22/92	PROJECT MGR	
DESIGNED: K. COSTELLO	9-22-92	APPROVED/RELEASED	
RESPONSIBLE ENGINEER: J. JAGGER	9/22/92		

TITLE: ADVANCED PHOTON SOURCE
INJECTOR
POSITRON ACCUMULATOR RING
SEXTUPOLE
SIDE COIL ASSEMBLY

MATERIAL: SEE PARTS LIST
SCALE: 1:1
SHEET 1 of 1
SIZE: D
DRAWING NUMBER: 250103-00008-01