



A2034900  
 250104-830000-00  
 12-09-94  
 POSITRON ACCUMULATOR RING  
 PAR MAGNETS  
 AC SEPTUM MAGNET  
 COMPLETE CORE ASSEMBLY

- NOTES:
- 1) START WITH ITEM 1 MAKE SURE PUSHER FEET ARE IN CORE AND APPLY ITEMS 2 & 3 TO THE CORE.
  - 2) MAKE BEND TO THE STRAIGHT LENGTH OF TUBE ON COIL ASSY.(SAME AS OPPOSITE END - SEE DWG. 250104-820001).
  - 3) APPLY ITEMS 4 & 5 TO CORE WITH ITEMS 6 & 7.
  - 4) APPLY ITEMS 20 & 22 WITH (6) OF ITEMS 23 & 24 TO ITEM 4 AS SHOWN.
  - 5) APPLY ITEMS 12, 13 & 21. CENTER TUBES ON SEPTUM PLATE & HAND TIGHTEN ITEM 22.
  - 6) PUT ITEM 15 ON ITEM 9 AND SLIDE ITEM 9 OVER INNER ELECTRODE OF COIL ASSY.
  - 7) PUT ITEM 8 INTO HOLES IN ITEM 10-(UPPER BOX).
  - 8) SLIDE ITEM 10 OVER CORE UNTIL ROLL PINS LINE UP WITH HOLES IN ITEM 5.
  - 9) CENTER ELECTRODE AND TUBING IN OPENINGS OF UPPER BOX, THEN TIGHTEN SET SCREWS IN BACK OF CORE & ITEM 22.
  - 10) REMOVE UPPER BOX FROM CORE ASSY.
  - 11) WELD ITEM 9 TO BACK OF SEPTUM PLATE AND CLEAN OFF EXCESS RESIDUE.
  - 12) WELD ITEM 19 TO SEPTUM PLATE & BACKLEG CONDUCTOR AND CLEAN OFF EXCESS RESIDUE.
  - 13) TACK WELD ALL OF ITEMS 22 & 23 TO ITEM 20.
  - 14) APPLY ITEM 16 IN CORRECT LOCATION & APPLY ITEMS 17, 18 & 23 TIGHTEN JAM NUTS THEN TACK WELD THEM.
  - 15) WELD ITEMS 14 & 25 IN CORRECT LOCATIONS ON UPPER & LOWER BOXES AS SHOWN.
  - 16) RE-APPLY UPPER BOX AFTER WELDING IS COMPLETED.
  - 17) APPLY ITEM 11 TO CORE AND LINE UP WITH ITEM 10 AND WELD AS SHOWN.
  - 18) SEE DWG. 250104-800000 FOR FINAL ASSEMBLY INSTRUCTION.

SOURCE:  
 HINVEST VACUUM  
 201 EAST OGDEN AVE. SUITE 15  
 HINSDALE, IL 60521  
 (708) 323-5399

ITEM	DESCRIPTION	QUANTITY	DESCRIPTION	MATERIAL / SPEC.	QTY
26	# 1/4		FLAT WASHER	SST	6
25	807898-04-#		ELECTRICAL ISOLATOR	PUR.	6
24	#1/4-20 x 3.0 N.L.G.		THREADED ROD	18-8 SST	6
23	1/4-20 UNC		JAM NUT	18-8 SST	18
22	250104-830009		SCREW ALTERATION	SEE DWG.	32
21	250104-830008		TOGGLE CLAMP	SEE DWG.	2
20	250104-830007		PUSHER PLATE	SEE DWG.	2
19	250104-830005		JUMPER	SEE DWG.	1
18	250104-830003		FIELD-FREE INSULATOR	SEE DWG.	6
17	250104-830002		FIELD-FREE CLAMP	SEE DWG.	3
16	250104-830001		FIELD-FREE TUBE	SEE DWG.	1
15	250104-800009		OUTER SPACER	SEE DWG.	1
14	250104-800008		HEATER PORT	SEE DWG.	3
13	250104-830003		UPPER TUBE	SEE DWG.	1
12	250104-830002		LOWER TUBE	SEE DWG.	1
11	250104-800001		LOWER BOX	SPE DWG.	1
10	250104-800002		UPPER BOX	SEE DWG.	1
9	250104-830000		JUMPER SUB-ASSY.	SEE DWG.	1
8	# 1/4 x .50 N.L.G.		ROLL PIN	STD.	4
7	3/8-16 UNC x .75 N.L.G.		FLAT HEAD SCREW	STD.	12
6	250104-800027		PAN HEAD SCREW	SEE DWG.	8
5	250104-800007		LAMINATION INSULATOR BLOCK	SEE DWG.	4
4	250104-830004		FIELD FREE PLATE	SEE DWG.	6
3	250104-810008		SHIM	SEE DWG.	1
2	250104-820000		COIL ASSEMBLY	SEE DWG.	1
1	250104-830000		SEPTUM PLATE SUB-ASSY.	SEE DWG.	1

ARGONNE NATIONAL LABORATORY  
 ADVANCED PHOTON SOURCE  
 PAR MAGNETS  
 AC SEPTUM MAGNET  
 COMPLETE CORE ASSEMBLY

DATE: 12-09-94  
 DRAWN BY: [Name]  
 CHECKED BY: [Name]  
 APPROVED BY: [Name]

SEE PARTS LIST