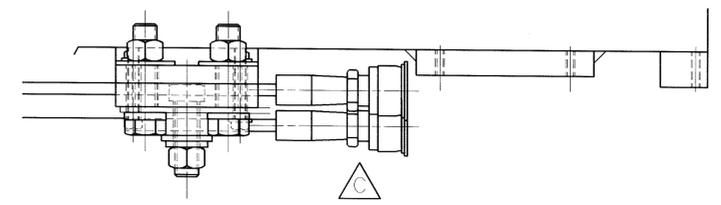
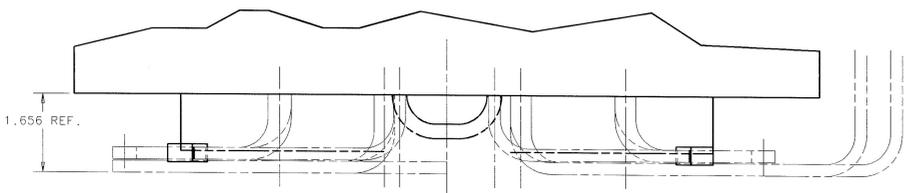
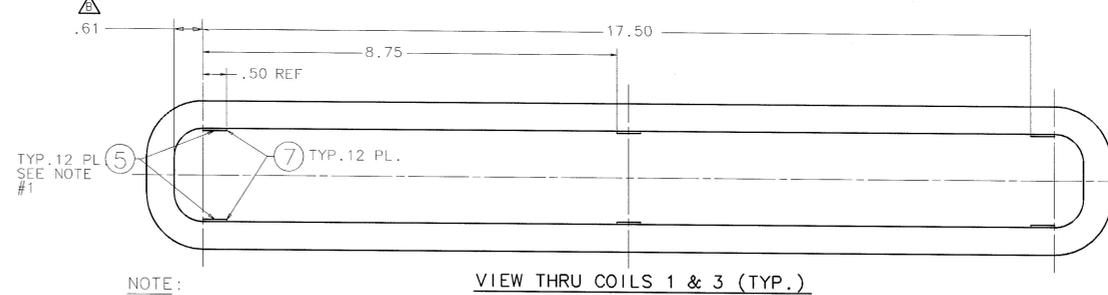
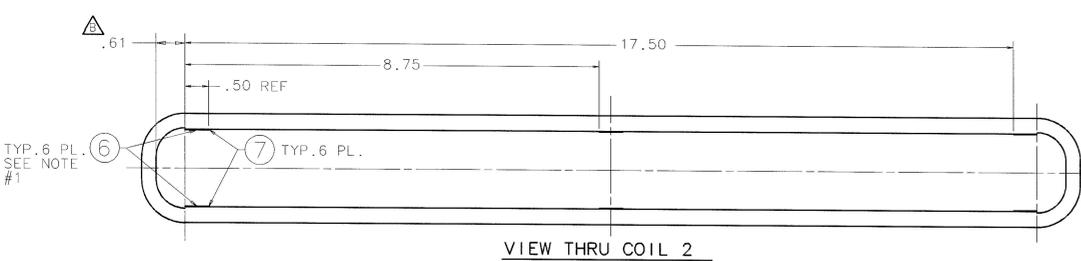
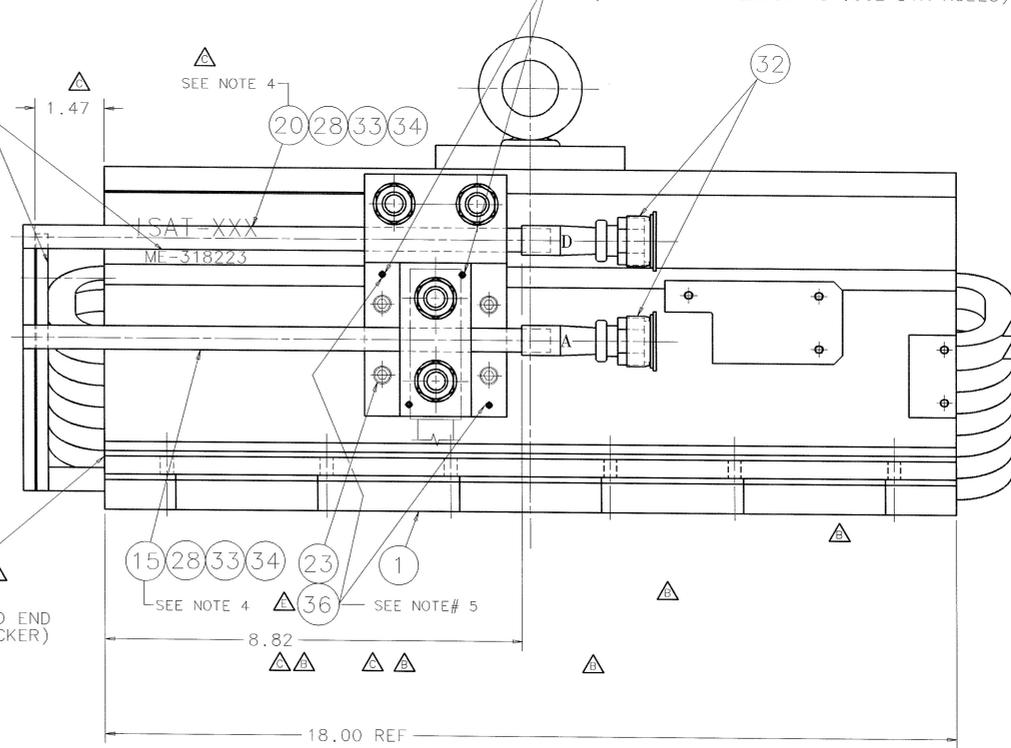
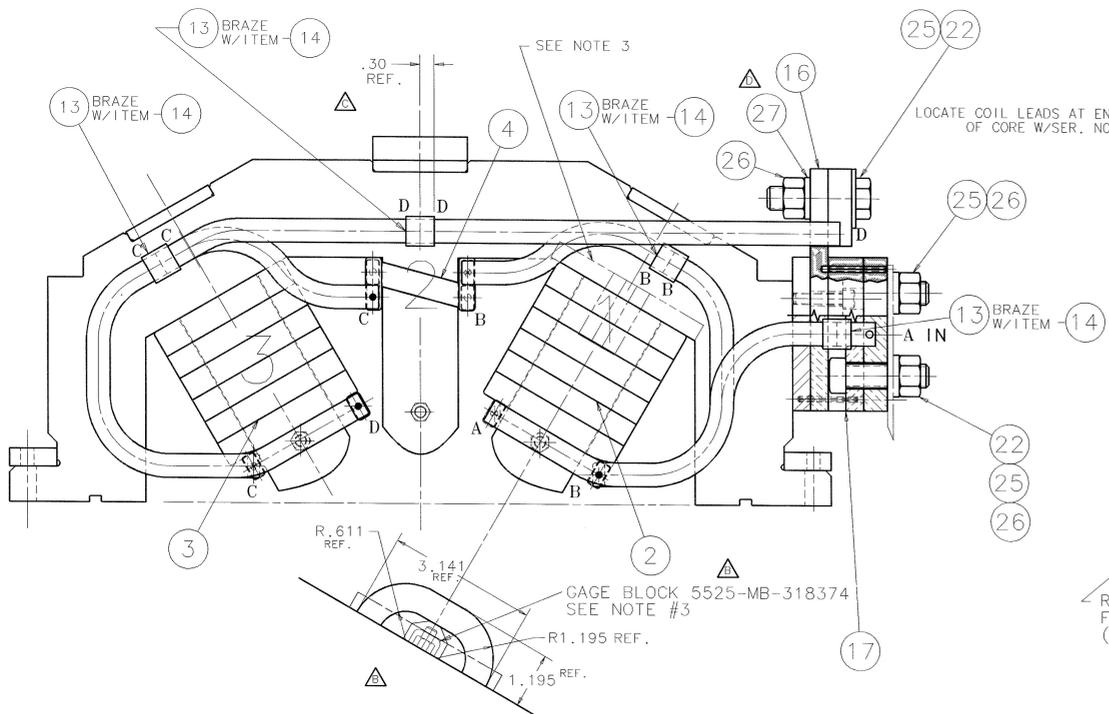


REV.	DESCRIPTION	DRAWN	DATE
	NEW DRG. RELEASE	EO#569	D.L.R. 7-26-93
A	ITEM 1 REV. - E.O. 569	RW	10/13/93
B	ITEM #3 ME-318385 WAS MD-318385 ITEM #12 MA-116597 WAS MA-116500 ITEM #13 QUANTITY OF 4 WAS 2 ADDED ITEM 11 AND 15 THRU 34 REVISED NOTE 2 & 3 AND SERIAL NO. ADDED .61 DIM. 2 PLACES IDENTIFIED FIXED END REMOVED DIM. 1.912 REF. & 1.972 REF. ADDED DIM 18.00 REF. ADDED BRAZE NOTE AND DIM'S. THAT APPLY TO NEW ITEMS. ECO#3733	D.L.R. GEO.Z.	4-11-94 8-26-94
C	REMOVED, MB-318793, MA-331008 REMOVED, MA-331038, MB-318740 REMOVED, MA-331037, MB-331024 REMOVED, MB-331027, MB-318420 REMOVED, MB-331025, MB-318421 REMOVED, MB-318359, MC-318364 REMOVED, MA-225557 DIM. 8.82 WAS 8.75 REMOVED DIM'S, .06, .31 & 2.00 & 9.43 ADDED DIM. 1.47 & NOTE #4 ADDED MA-274444, MA-331171 MD-331157, MD-331158 MA-274445, MA-225104 ADDED NOTE #4 & DIM. .31 TYP. REVISED ITEM 8 & 9 AND NOTE 2 MA-125283 WAS 1 PC. ECO#3753	D.L.R. N.S.C.	10-6-94 11-14-94
D	ITEM 7 .5 GM WAS 310 GM ITEM 33 .015 GAL. WAS 1 PT. ITEM 34 .015 GAL. WAS 1 PT. ECO#3790	D.L.R. GEO.Z.	2-10-95 2-21-95
E	ADDED NOTE # 5 AND ITEM MA-318765 ECO#3877	GEO.Z.	9/18/95 10/3/95



35 DRILL $\phi .125 \pm .002$ X 1.375 $\pm .030$ DEEP (PRESS FIT) FOR .125 DIA X 1.25 LG. ROLL PIN - 4 HOLES AS SHOWN. (LOCATE FROM EXISTING .062 DIA HOLES)



- NOTE:
- SUPER GLUE ITEMS 5 & 6 G-10 SHIMS TO SIDE OF COILS LOCATED AS SHOWN IN ABOVE VIEWS.
 - INSTALL COILS ITEMS 2, 3 & 4 AFTER APPLYING FILLER EPOXY ON BOTH SIDES OF POLES (ENTIRE LENGTH). 3.50 HIGH ON POLE 1 & 3 AND 1.25 HIGH ON POLE 2.
 - GUAGE BLOCK MB-318374 IS TO BE USED TO LOCATE COILS ITEMS 2, 3 AND 4
 - WRAP (1/2 LAP) ALL COIL LEADS UP TO COIL BODY WITH ITEM 28-COAT WITH MIX (1:1) OF ITEMS 33 & 34.
 - SUFFICIENTLY SEAL MACHINED SURFACES. HEADS OF (4) SCREWS AND (2) PINS SO MOISTURE CAN NOT PENETRATE. CURE 24 HOURS AT ROOM TEMPERATURE.

* ITEMS NOT SHOWN

FILLED EPOXY FORMULA: (* BY WT.)
 55% EPON 826 EPOXY RESIN (MA-116501 ITEM 9)
 45% EM-308 EPOXY RESIN (MA-116504 ITEM 8)
 200% TABULAR ALUMINA (MA-116597 ITEM 10)
 ~1.5% CAB-O-SIL (AS NEEDED TO CONTROL THICKNESS) (MA-116557 ITEM 12)

ITEM	PART NO.	DESCRIPTION OR SIZE	QTY.
36	MA-318765	GRAY RTV-157:2.8 OZ. TUBE	A/R
35	MA-331171	ROLL PIN .125 X 1.25 LG.	4
34	MA-274445	EPOXY PAINT CATALYST	.015 GAL.
33	MA-274444	EPOXY PAINT	.015 GAL.
32	MA-125283	CAP PLUG	2
31			
30			
29			
28	MA-225104	FIBERGLASS ADHESIVE TAPE	1 ROLL
27	MA-318688	PLAIN WASHER 1/2"-SS	2
26	MA-318687	HEX NUT 1/2"-13 BRASS	4
25	MA-318686	CONICAL COMPRESSION WASHER PART NO. 8-M-89 SOLON MFG. CO.	4
24			
23	MA-318682	SOC. HD. CAP. SCREW 1/24"-20 X 1 1/4"-SS	4
22	MA-318681	HEX. HD. CAP. SCREW 1/2"-13 X 2" LG. -SS	4
21			
20	MD-331157	LEAD-#3 COIL ASSEMBLY	1
19			
18			
17	MC-318365	TERMINAL SUPPORT BLOCK	1
16	MB-318366	SPACER PLATE	1
15	MD-331158	LEAD #1 COIL ASSEMBLY	1
14	MA-116256	BRAZING ROD	1
13	MA-318160	COPPER CONNECTOR	4
12	MA-116557	CAB-O-SIL	.05 KG
11			
10	MA-116597	TUBULAR ALUMINA	2 KG
9	MA-116501	EPOXY RESIN	.54 KG
8	MA-116504	EPOXY RESIN	.42 KG
7	MA-274442	SUPER GLUE	GRAMS
6	MB-318376	G-10 SPACER	6
5	MB-318375	G-10 SPACER	12
4	ME-318238	SMALL COIL #2	1
3	ME-318385	LARGE COIL #3	1
2	ME-318386	LARGE COIL #1	1
1	ME-318223	UPPER HALF CORE	1

PARTS LIST			
UNLESS OTHERWISE SPECIFIED	ORIGINATOR	N. CHESTER	
.XX	XXX	ANGLES	DRAWN
R.	WEFORTH	8/20/93	
.03	±	CHECKED	N. CHESTER
		APPROVED	N. CHESTER
		USED ON	ME-318246
		MATERIAL	SEE ABOVE

FERMI NATIONAL ACCELERATOR LABORATORY
 UNITED STATES DEPARTMENT OF ENERGY

TECH. SUPPORT - CONVENTIONAL MAGNET
 MIR SEXTUPOLE MAGNET ASSEMBLY
 UPPER HALF CORE-COIL ASSEMBLY

SCALE: 3/4"=1"
 DRAWING NUMBER: 520-ME-318373
 REV. E
 CREATED WITH: I-DEAS 6.1
 USER NAME: RISSMAN

