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NEUTRAL BEAM LINE INJECTOR SYSTEM- BEAM LINE SYSTEM CONFORMAL COATING DOUBLETT III

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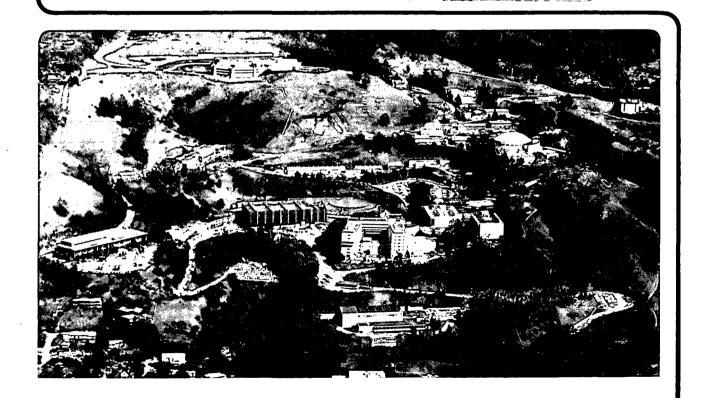
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SUBJECTNEUTRAL BEAM INJECTOR SYSTEM-BEAM LINE SYSTEM	NAME Jan DeVries		
CONFORMAL COATING DOUBLET III		DATE 4 June 1979	)

### I. MIXING RATIO:

Solithane 113 Resin 100 parts C113-300 Catalyser 73 parts

### II. PROCEDURE:

- 1. Clean surface to be coated with either ethyl or isopropyl alcohol.
- 2. Heat unit to be coated to 40°C in oven.
- 3. Mix Solithane according to above ratio; mix small amount, but enough so that you do not run out in the process of coating. (Using a glass container is preferable so you can see).
- 4. Outgas mixed Solithane in vacuum tank in cycles; that is, let air back in, in case of "boiling" effect.
- 5. Heat Solithane to 40°C.
- 6. Coat Solithane with brush onto surface to be coated and outgas again in vacuum 5 15 minutes.
- 7. Let Solithane cure at a temperature of  $40^{\circ}\text{C} 60^{\circ}\text{C}$ .
- 8. If necessary, repeat the procedure additional times if a thicker coating is desirable.
- \* Thiokol/Chemical Division P.O. Box 8296 Trenton, New Jersey 08650 (609) 396-4001

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