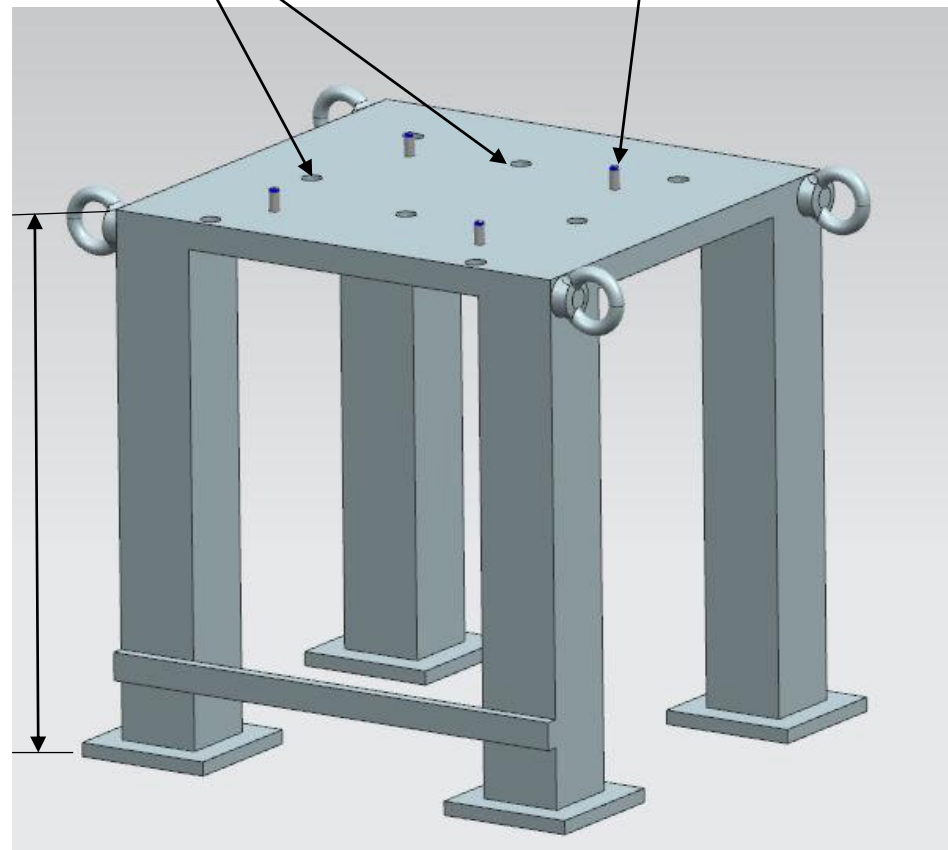


Access holes for yoke bolts

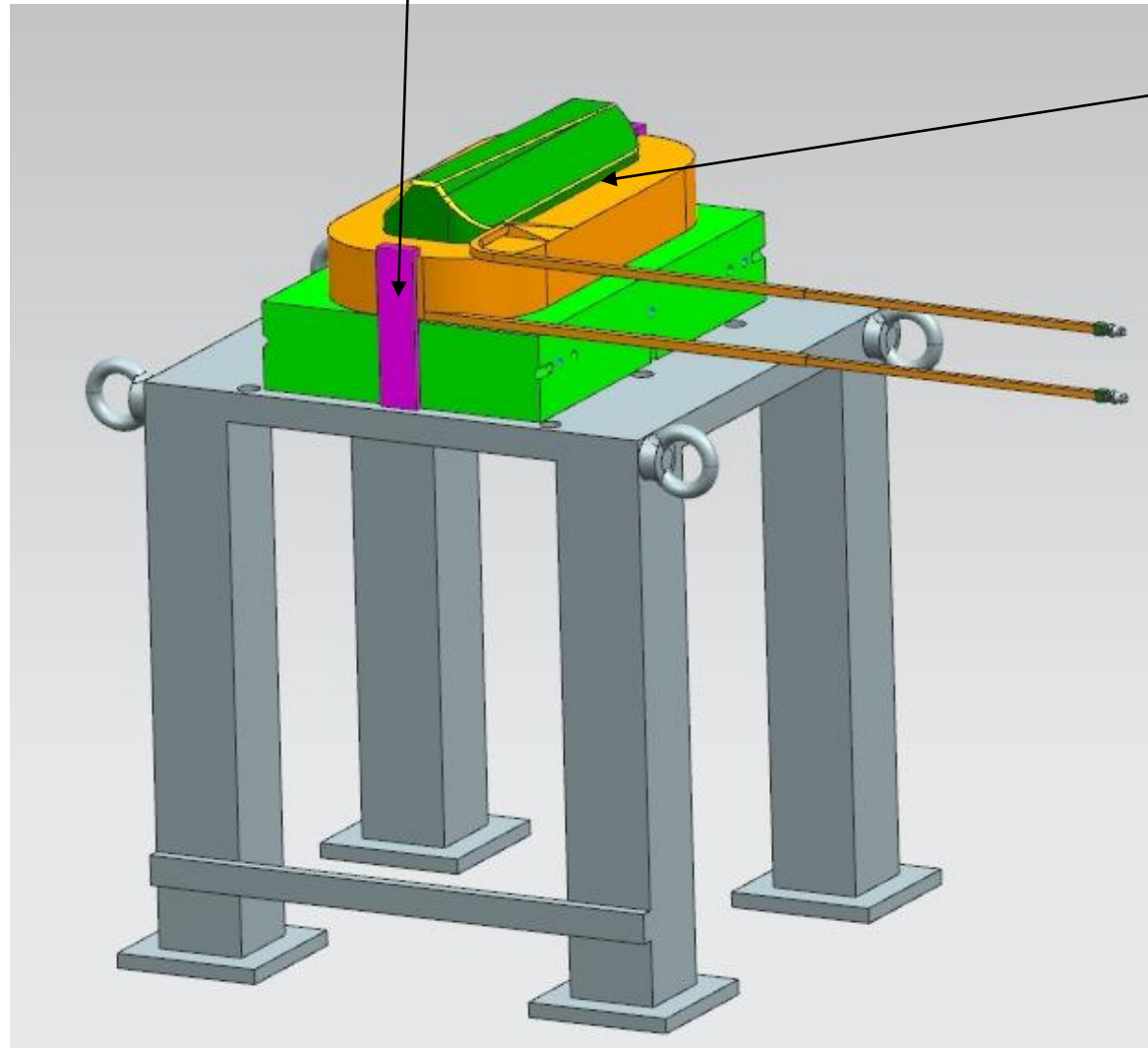
Temporary Bolts to
attach yokes



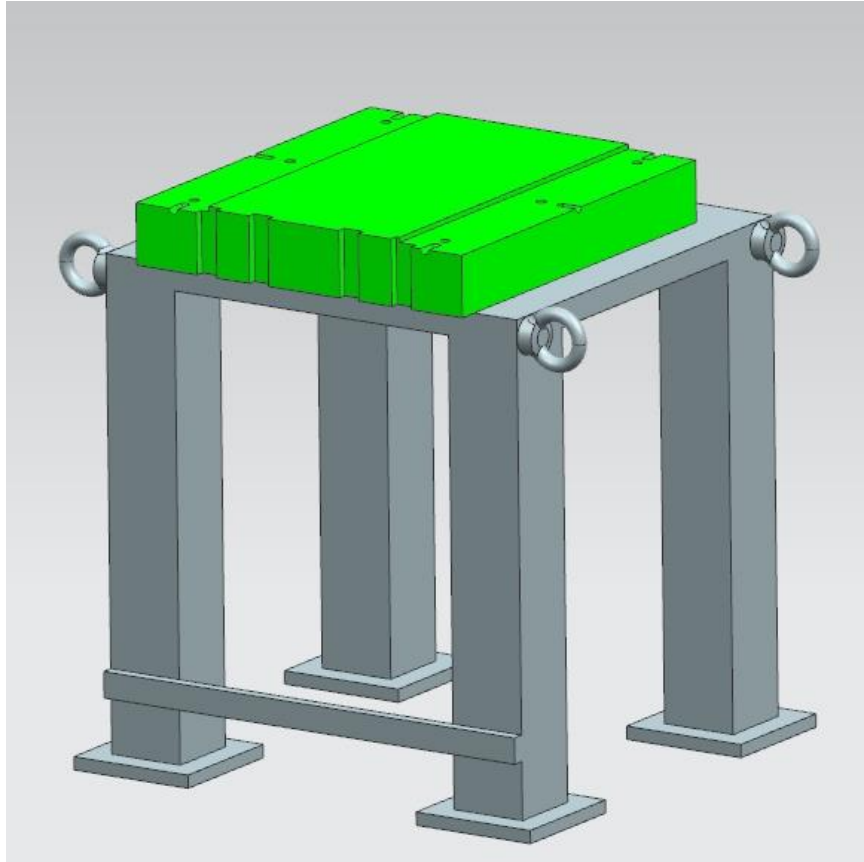
Build stand for magnet assy
and transport to Hall C

2x Pole clamps

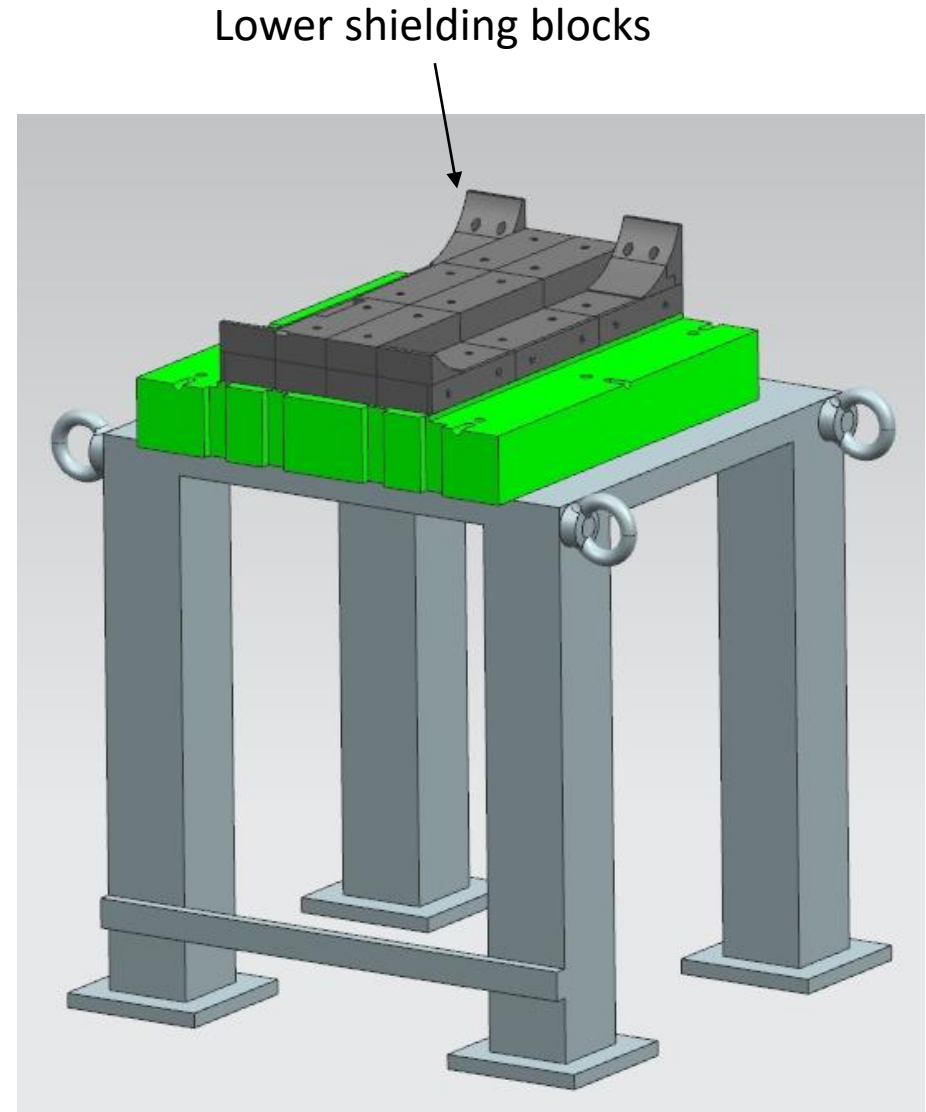
Add shims to pole
(all around)



Step 1 Fasten coil to side yoke and shim, Install pole clamps
(typ for both coils)

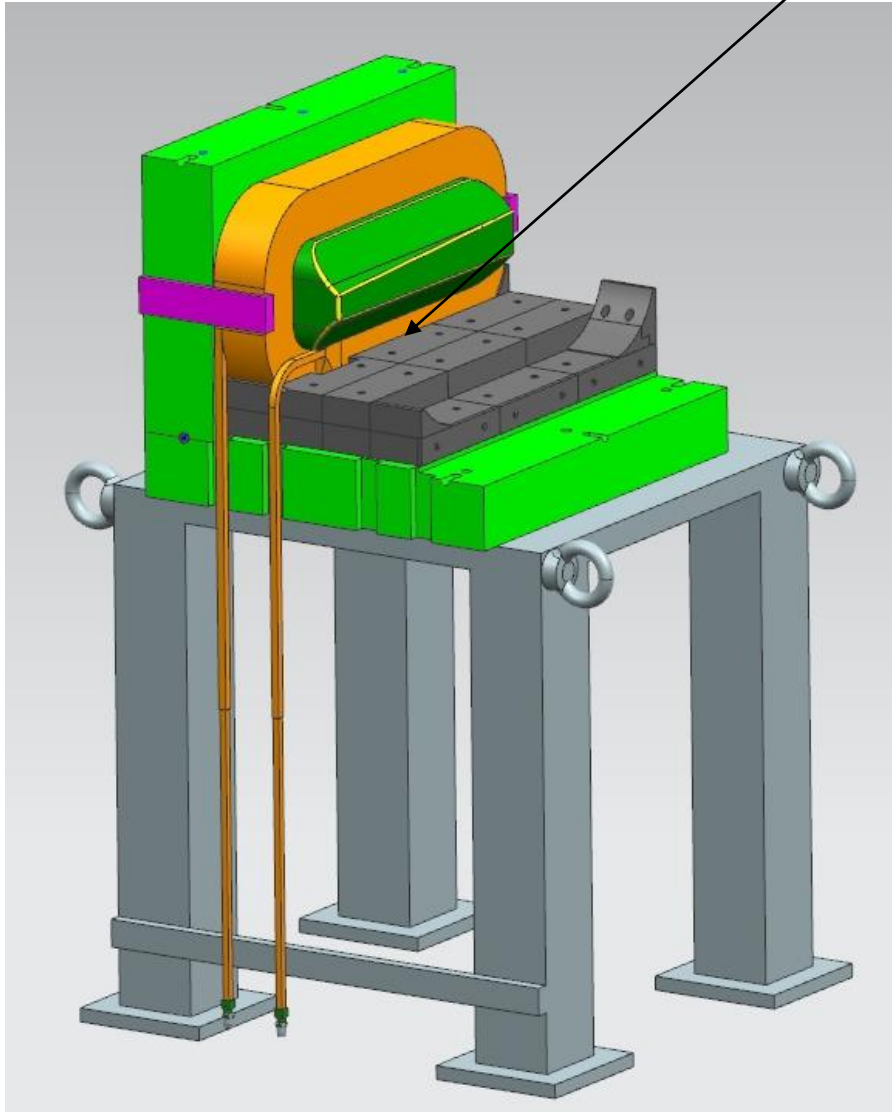


Step 2 Fasten lower yoke to stand using temporary bolts



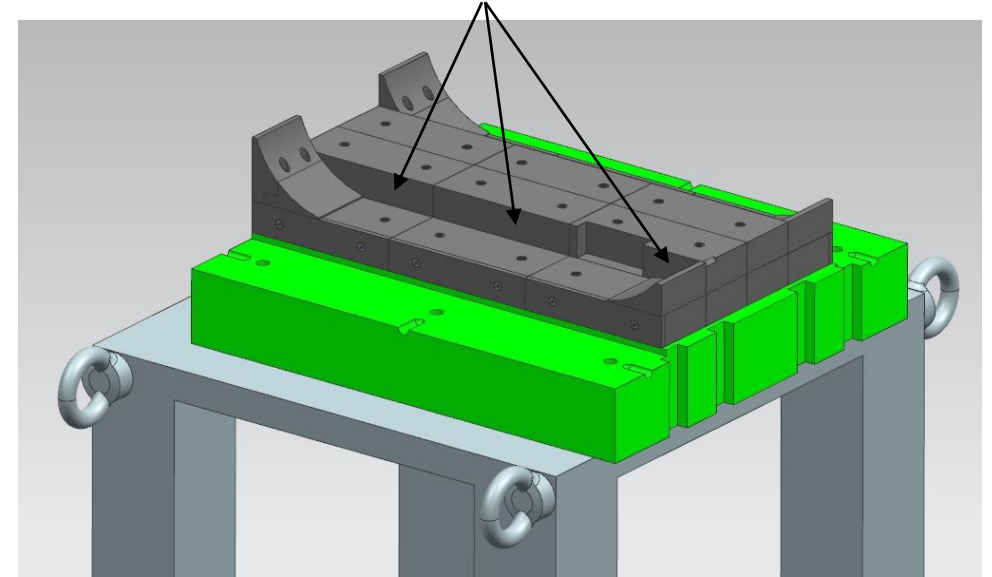
Step 3 Fasten lower shielding blocks to yoke

Check gap between coil and
shielding blocks

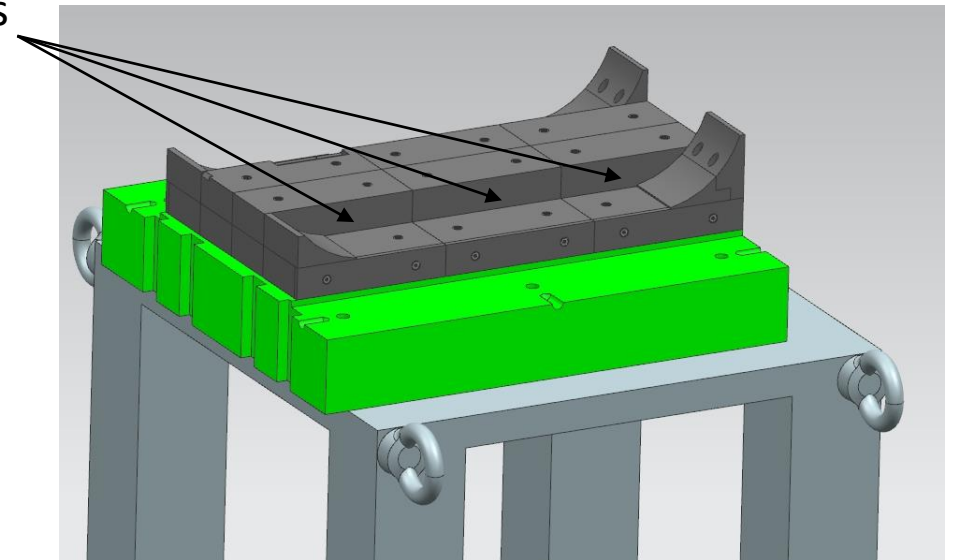


Step 5 Check gap on coil
(Typ for both coils)

Add Shims

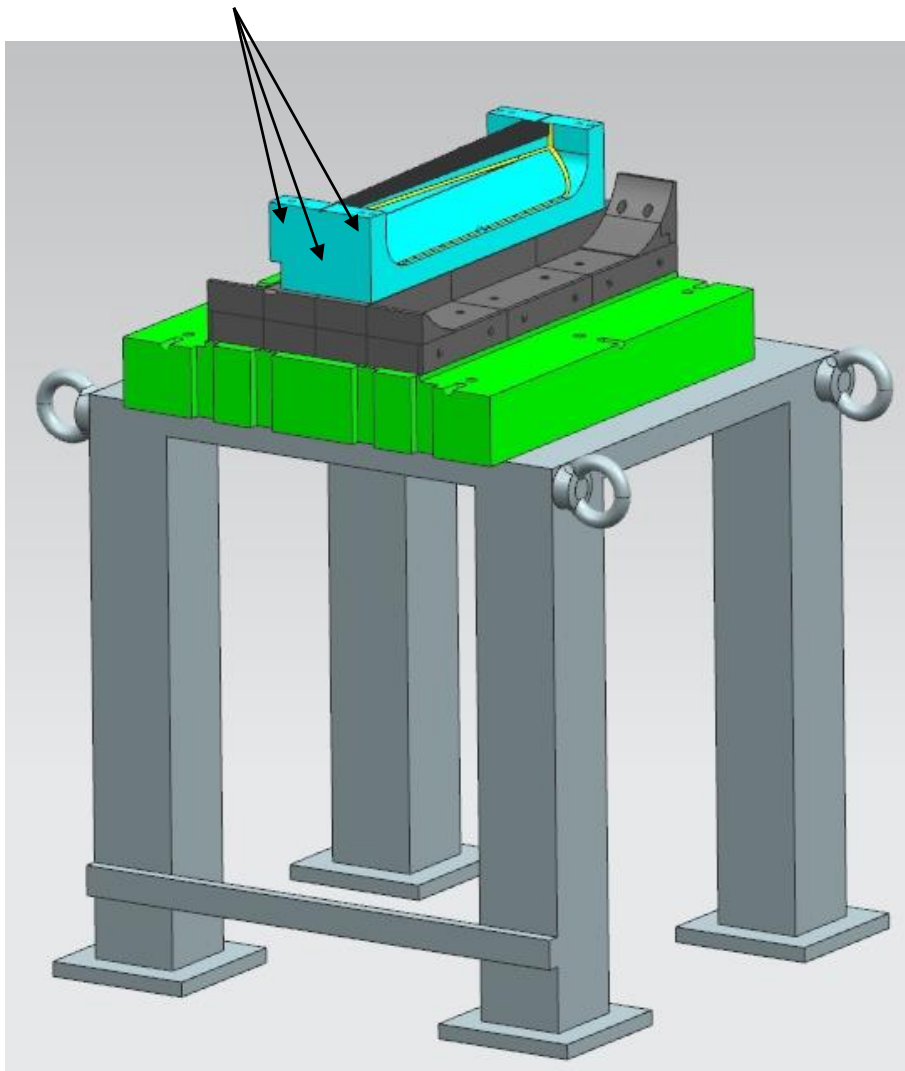


Add Shims



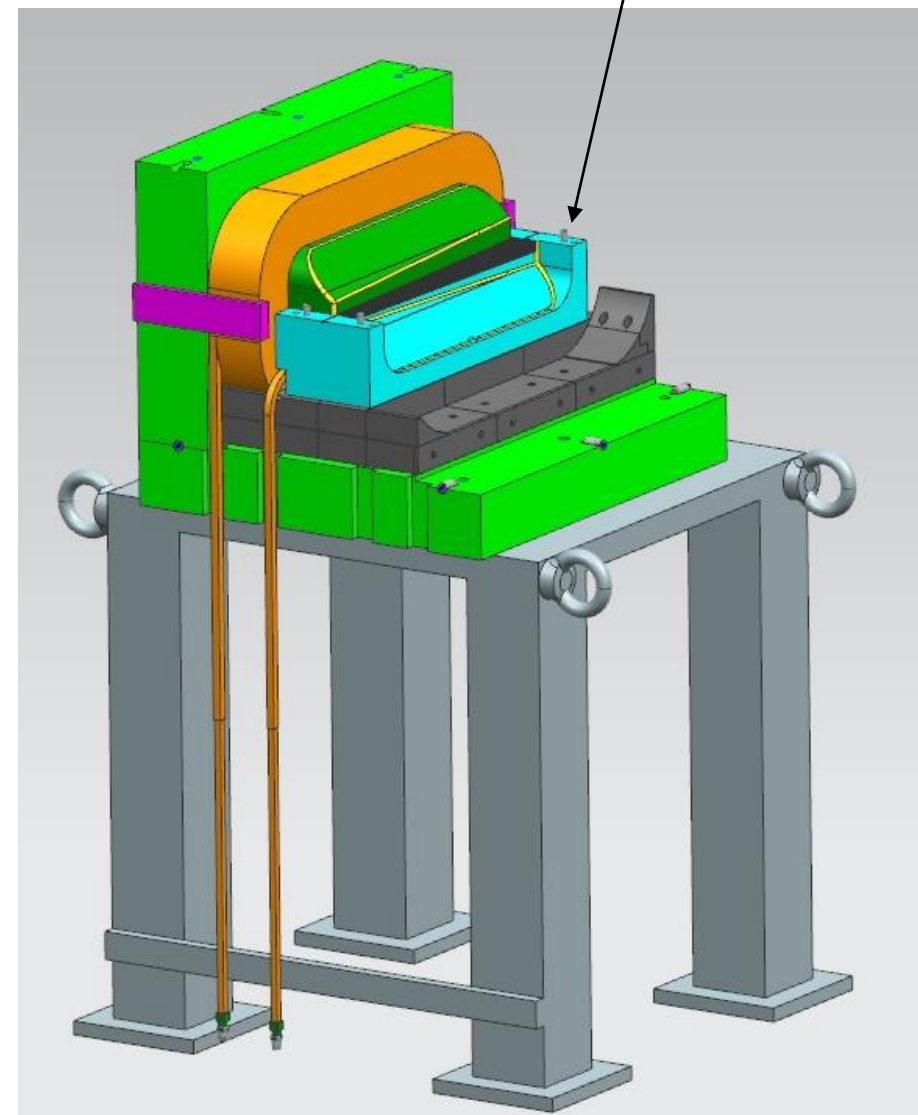
Step 6 add shims (kapton self stick or G10)

survey holes added to absorber
in front and rear

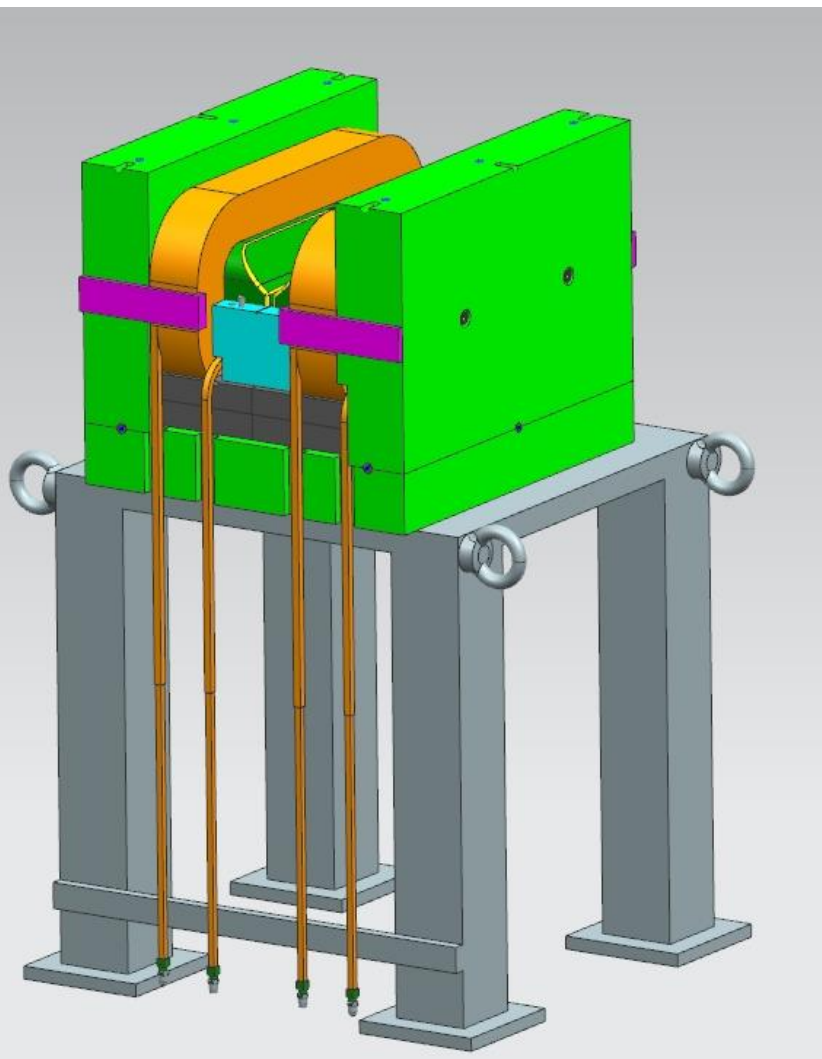


Step 7 Fasten lower absorber

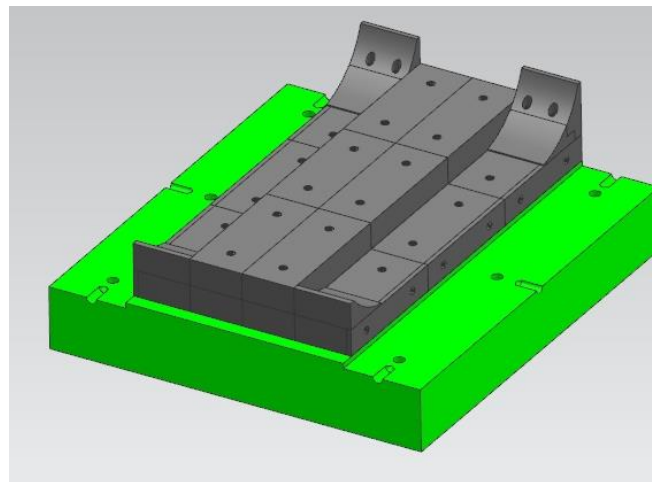
4x Absorber alignment
pins



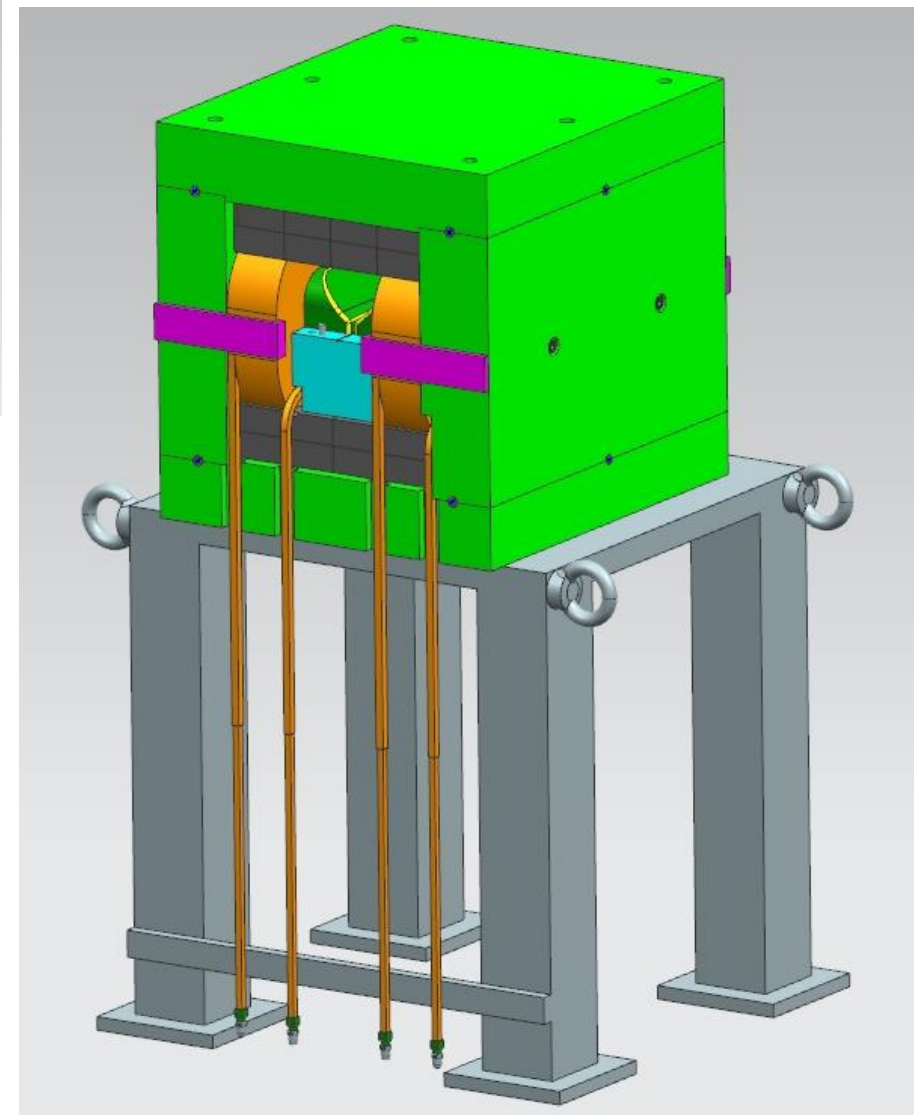
Step 8 Fasten side yoke assy



Step 9 Side yokes installed

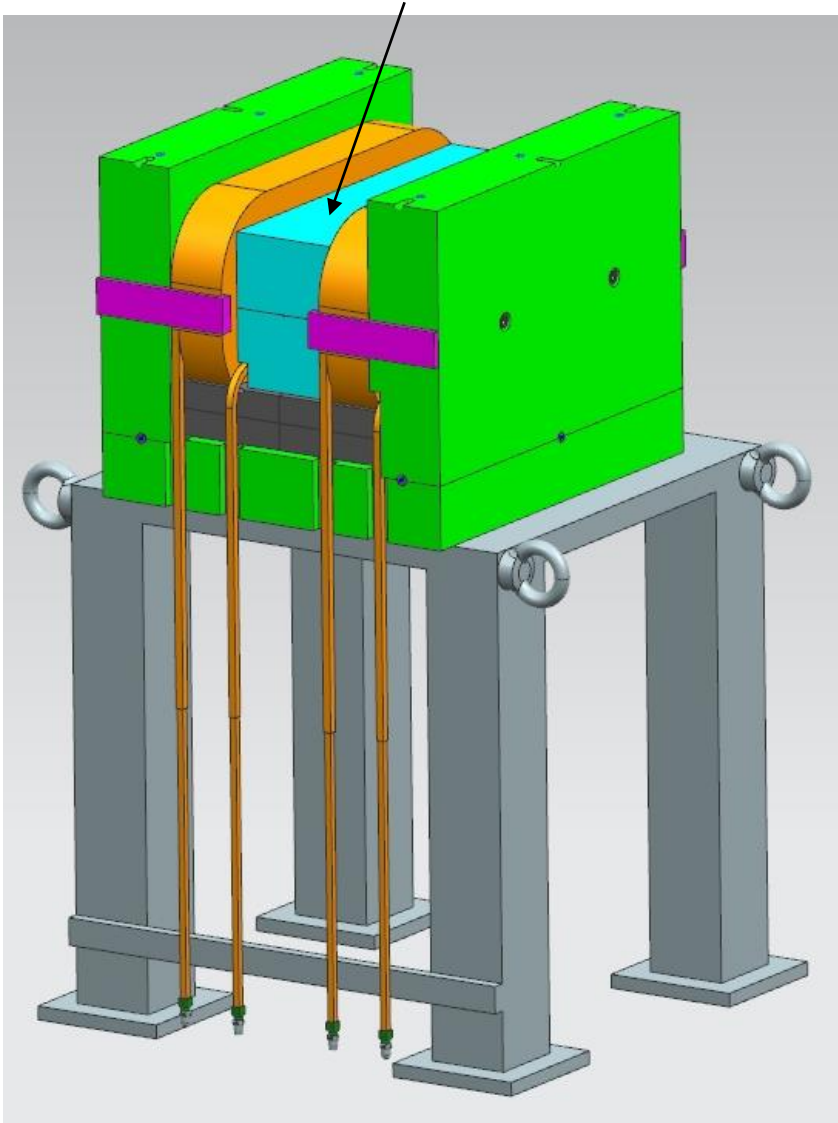


Fasten upper shielding
blocks to upper yoke
(upper yoke flipped over)



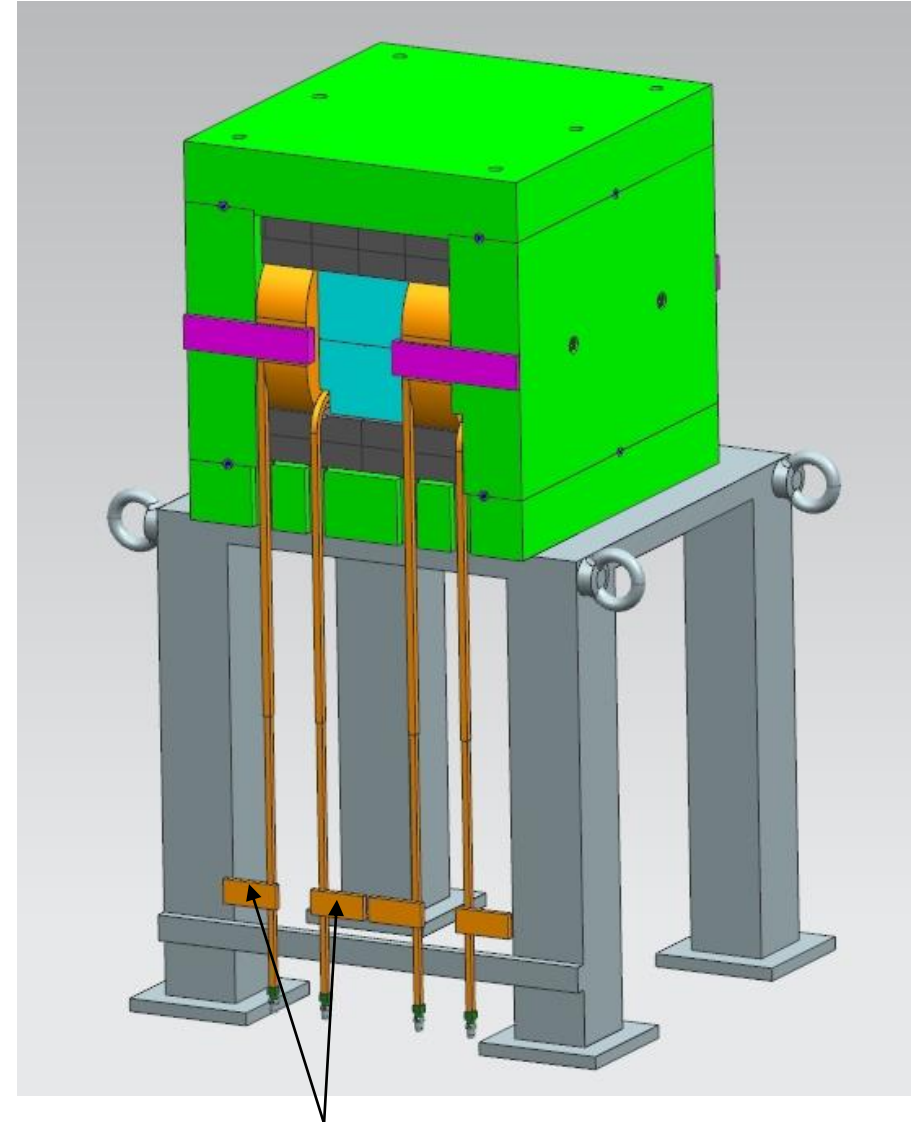
Step 10 Check gap on coil and
upper shield blocks, add shims
(same as step 5, 6)

upper absorber has springs
for downward pressure



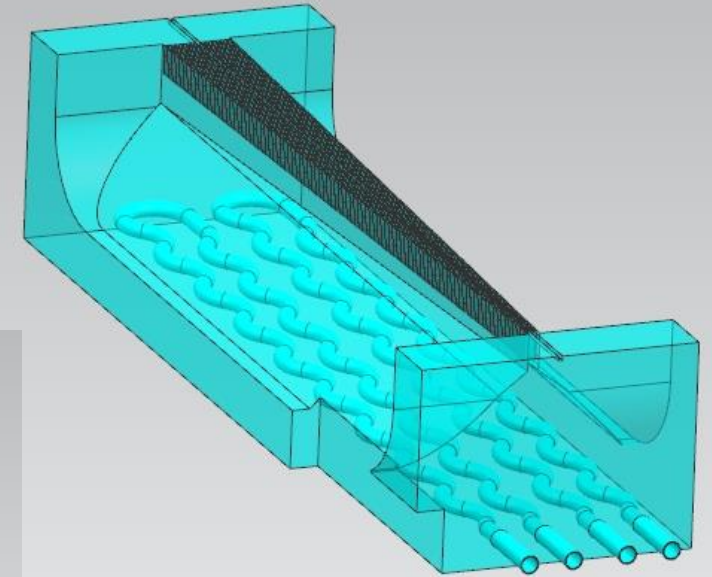
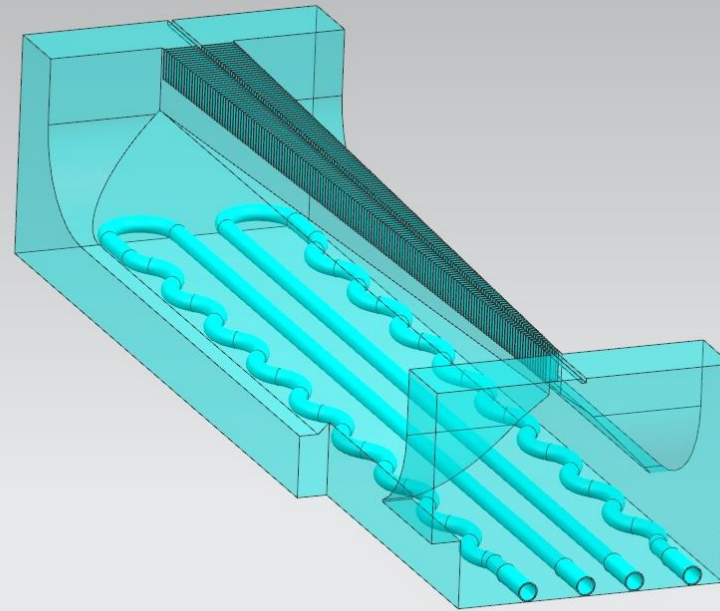
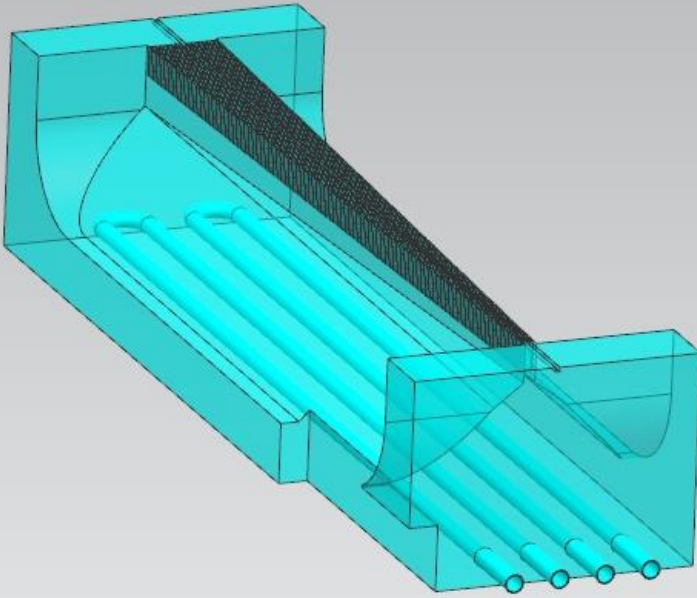
Step 11 Add upper absorber and springs

Step 12 Add upper yoke

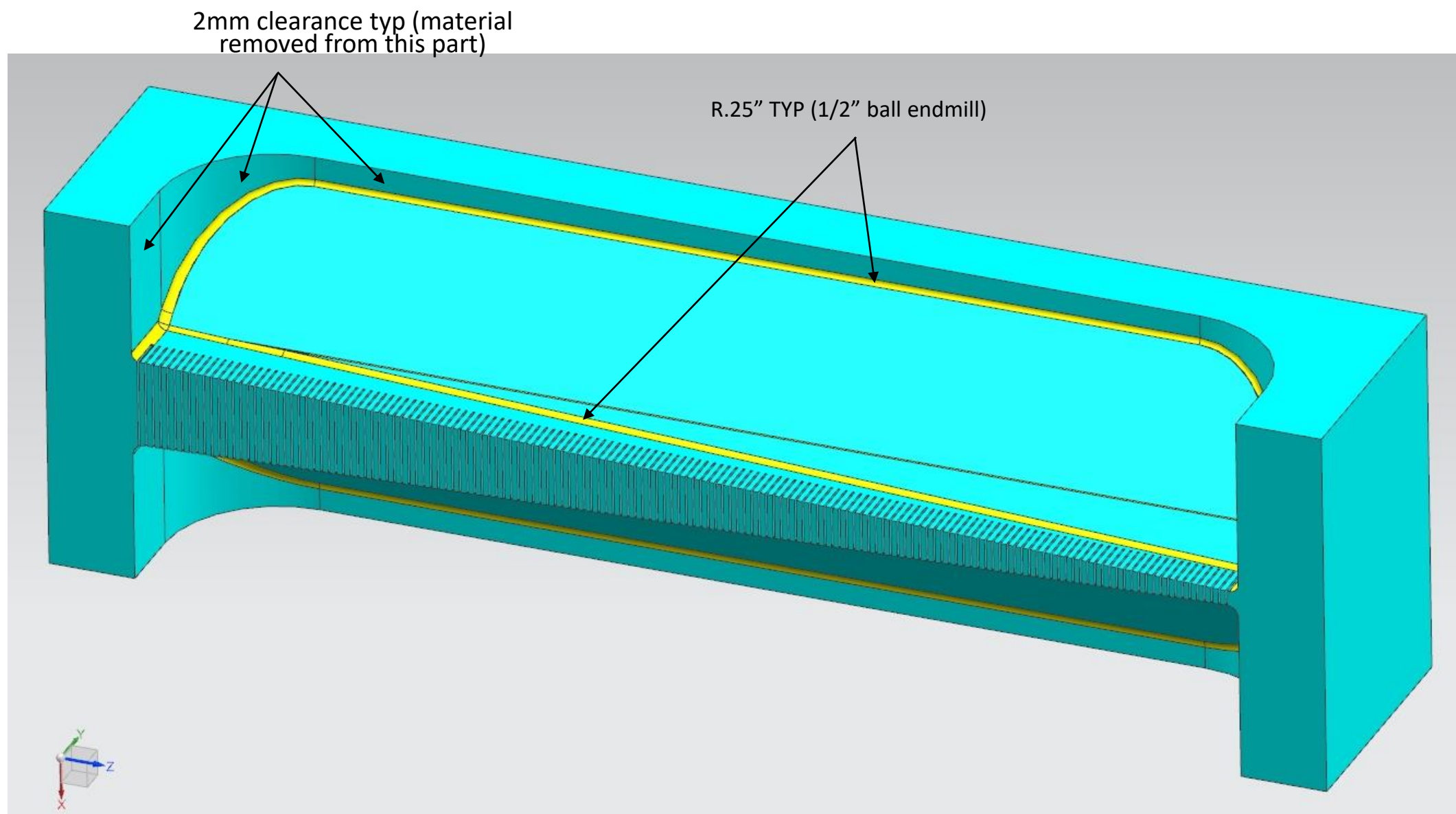


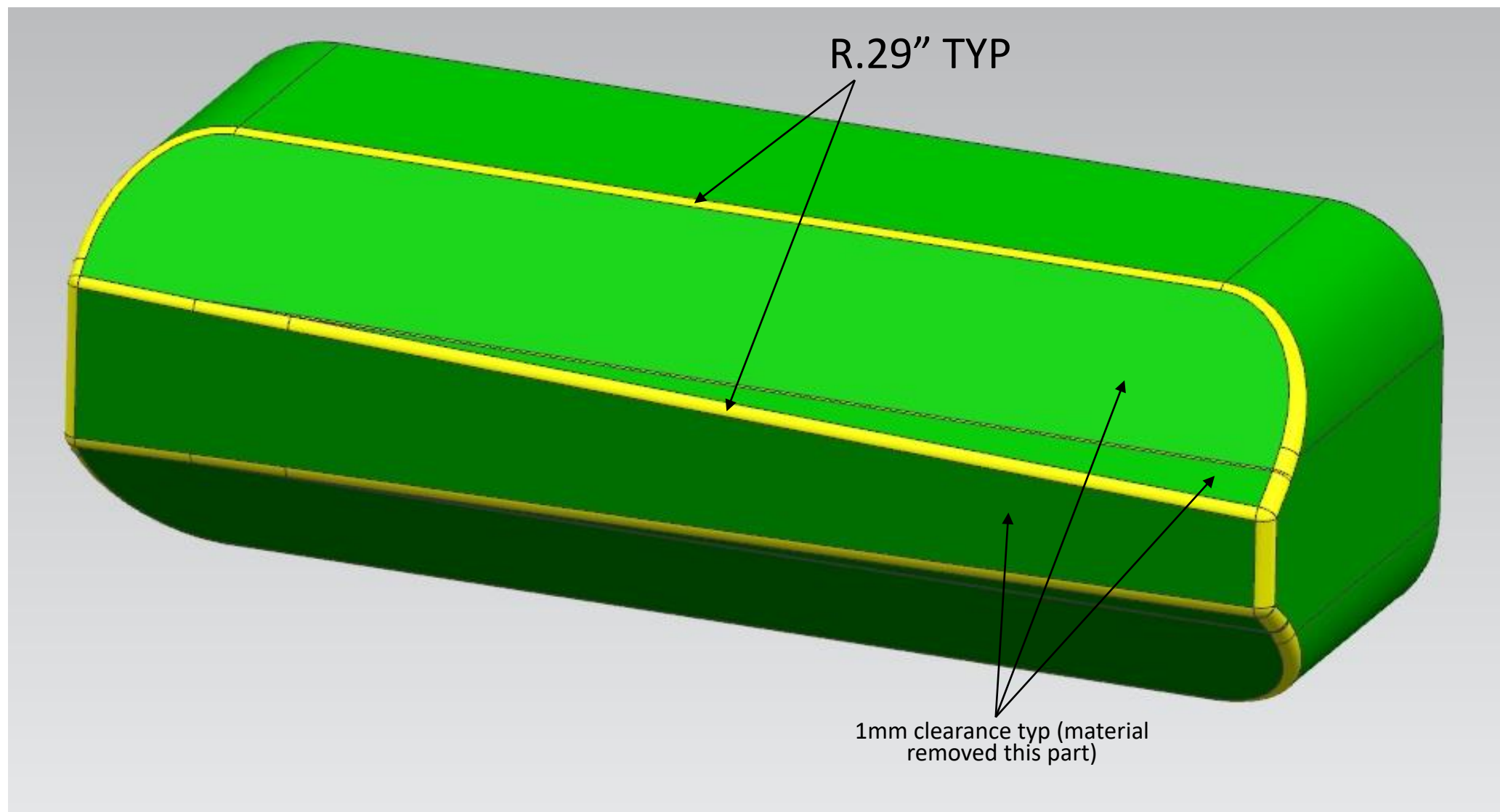
Step 13 Add flags to leads
(secure leads to stand for shipping)

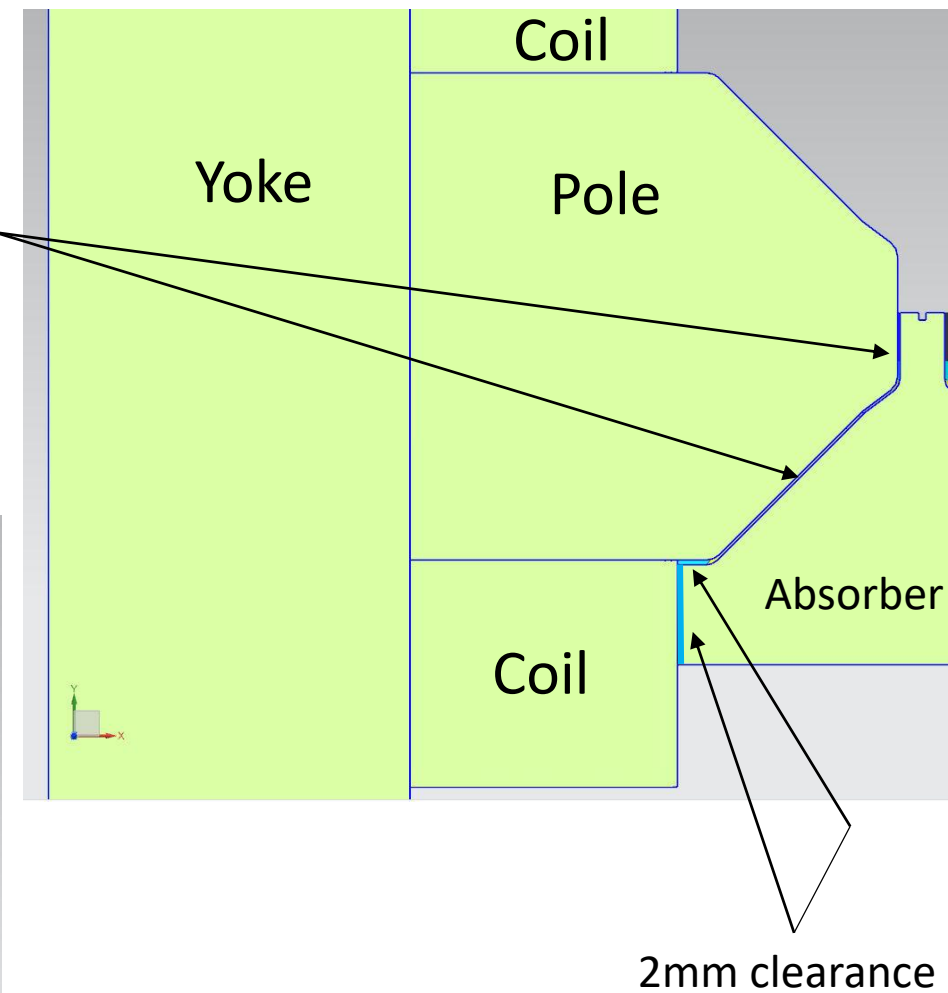
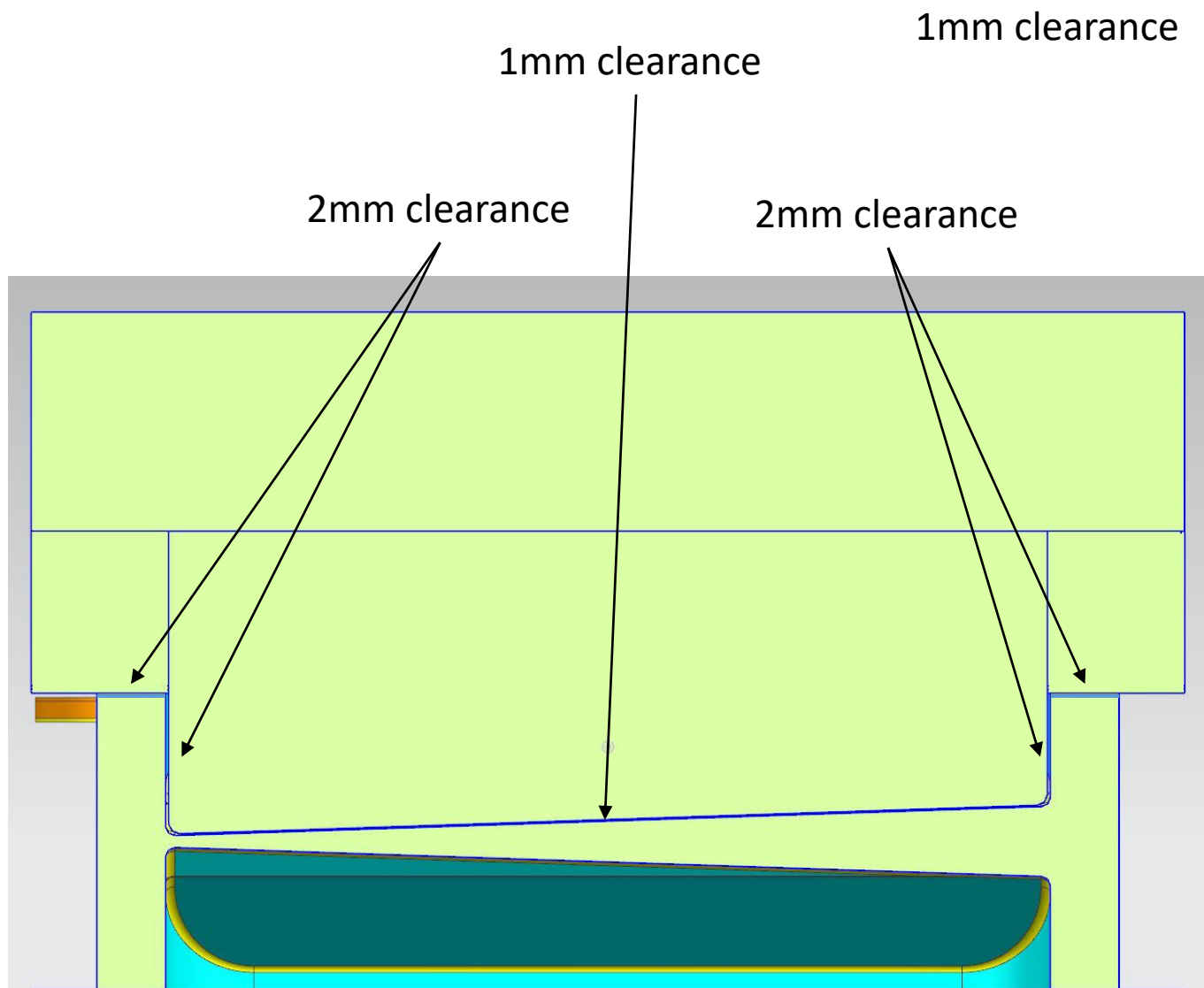
Engineering is currently testing
cooling paths on 3 different models

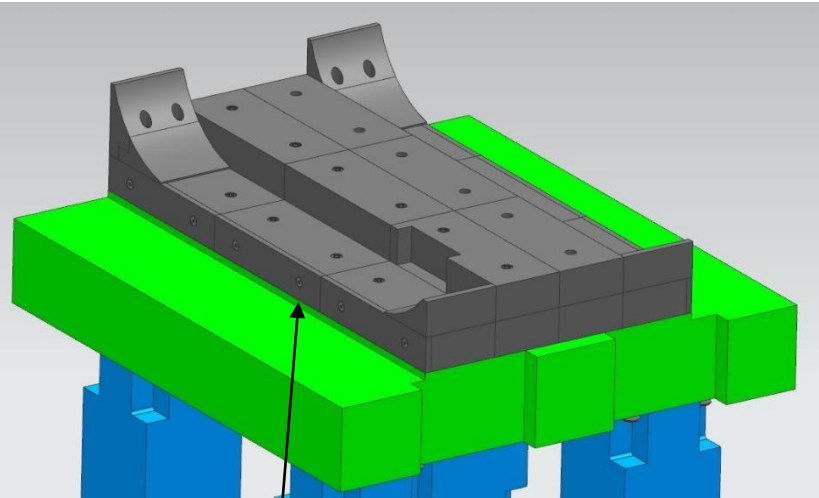


Old slides

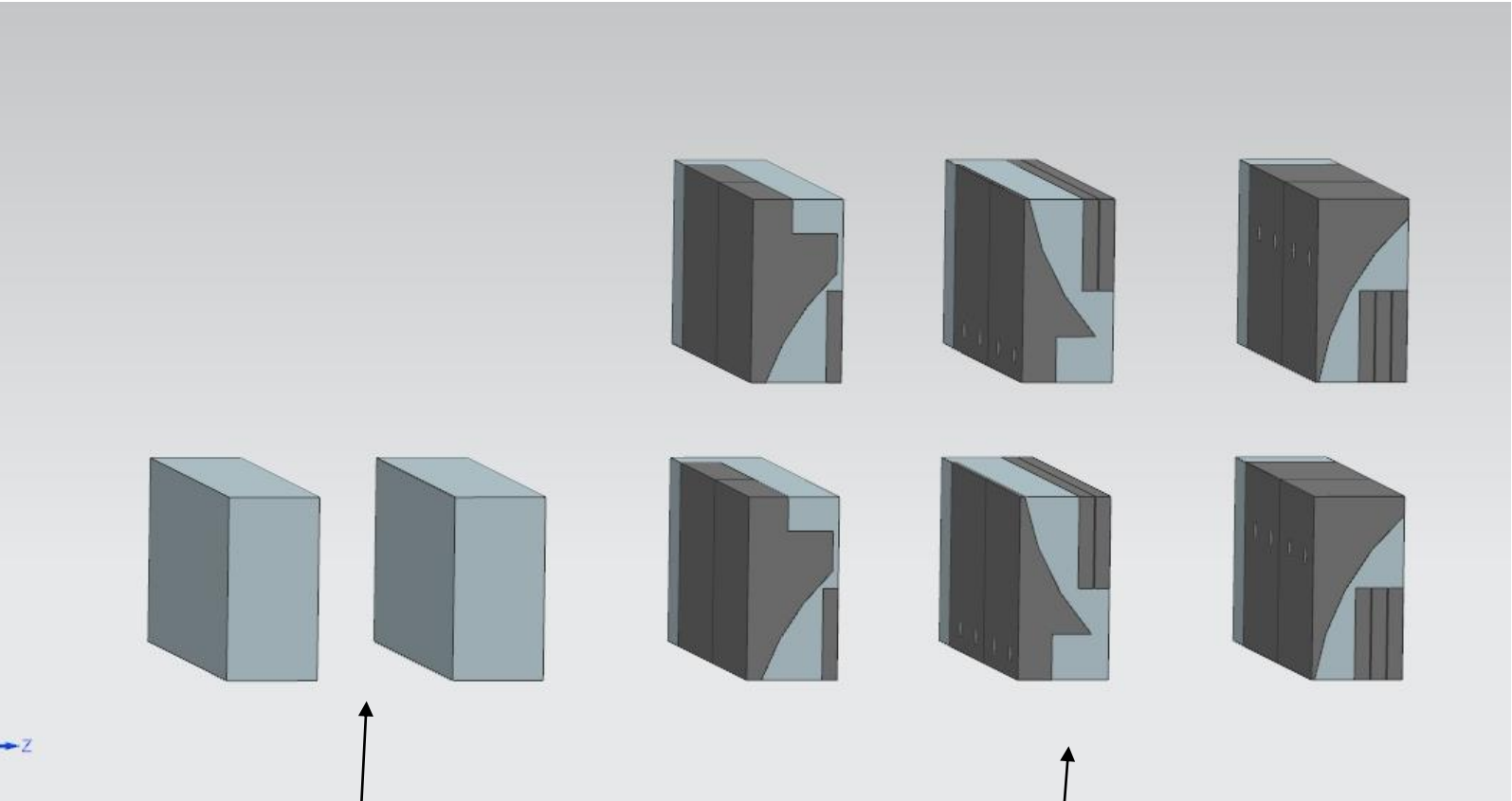








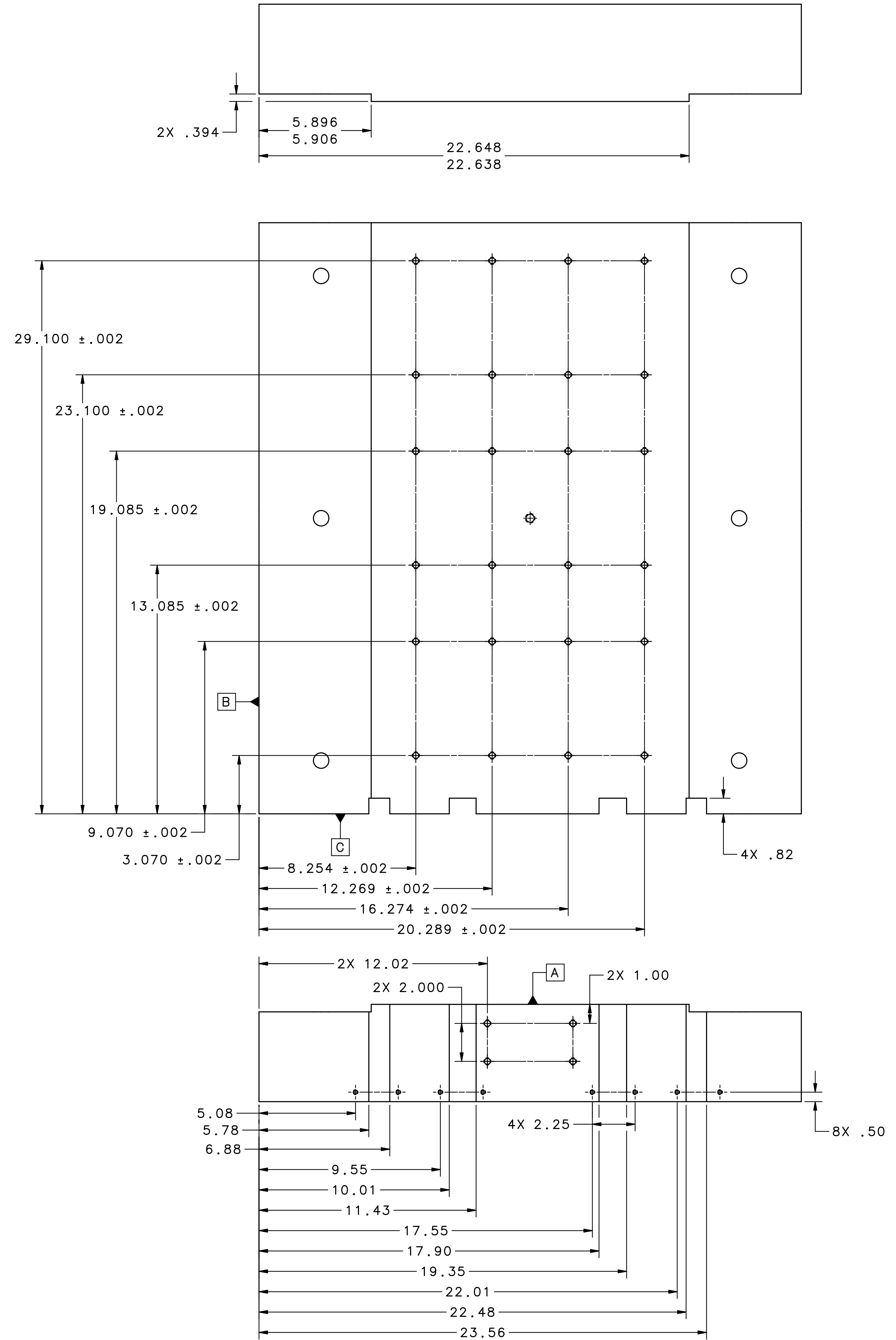
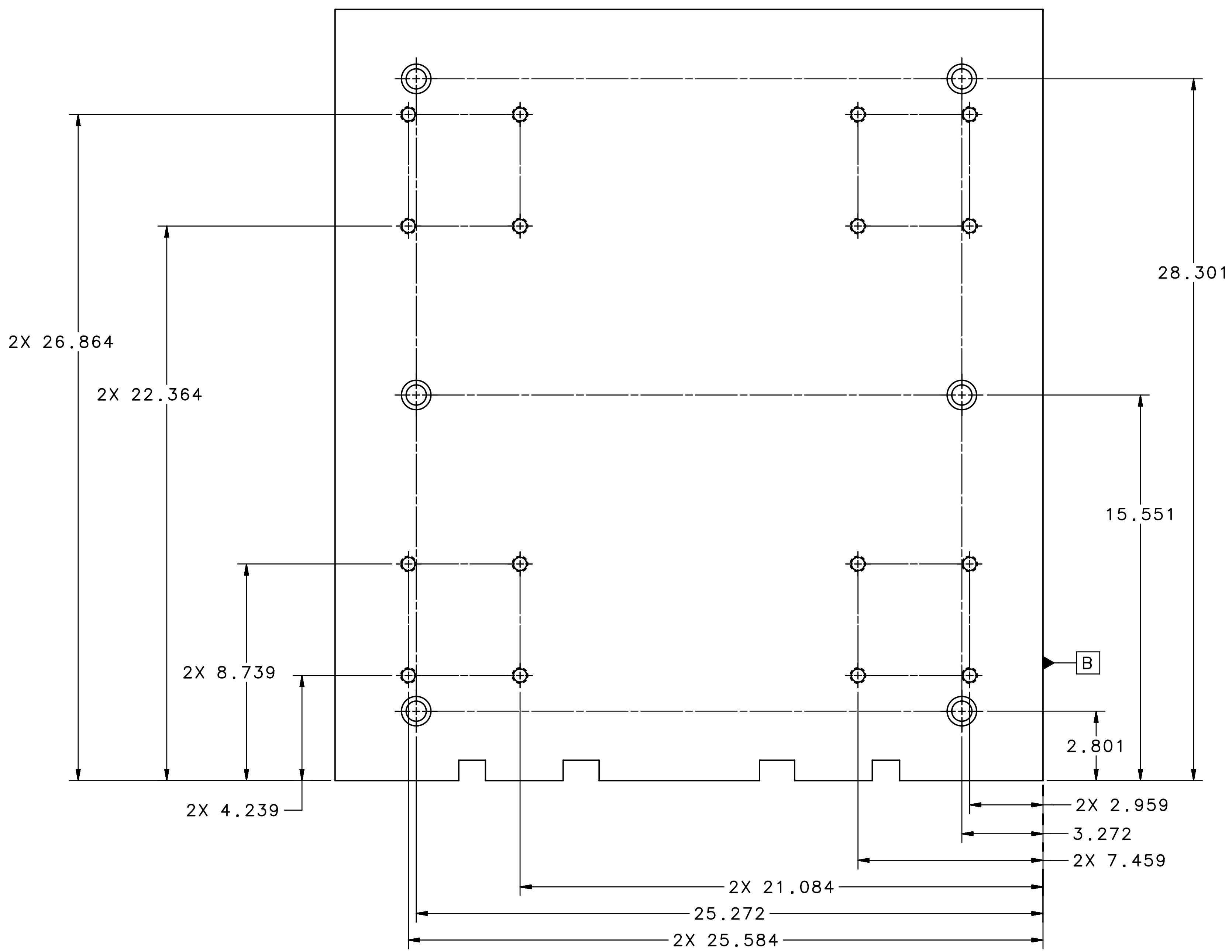
18 W80Cu20 blocks
(36 total lower, upper)



2 extra W80Cu20 blocks


6 blocks Cut out shapes
W80Cu20 blocks

44 W80Cu20 blocks total



NOTES:

1. YOKE MATERIAL SHALL NOT BE HANDLED BY MAGNETS AT ANY TIME.
2. APPLY ANTI-RUST COATING TO ALL FASTENER HOLES AND SURFACES.

QTY REQD	ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	NOTES
PARTS LIST					
EACH SHEET OF MULTI-SHEET DRAWINGS SHALL ALWAYS HAVE THE SAME REVISION LEVEL.					
MATERIAL D.T.M & TOL PER ASME Y14.2-2009. UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMAL ANGLES ± 1/8" .X ± .1" ± .50° .XXX ± .005			United States Department of Energy Jefferson Lab <i>Thomas Jefferson National Accelerator Facility</i>	Newport News Virginia	
THIRD ANGLE PROJECTION			1008 STEEL	HALL C CPS MAGNET ASSEMBLY CPS YOKE ASSEMBLY CPS LOWER YOKE	
			FINISH 125 OTHERWISE MACHINED SURFACES NOTED DEBRIS & BREAK ALL SHARP EDGES	SIZE DWG. NO. E 67509-00207	REV. 1
DO NOT SCALE DRAWING			DATE 7/6/22	SCALE N/A	USED ON ASSY NO. 67509-00205
DRAWN SPIDERS			SHEET 1 OF 1		

In accordance with the Jefferson Lab ESH&Q manual
Subject Matter Expert (SME) signatures may be required

