



ASSEMBLY PROCEDURES.

- 1) ASSEMBLE ITEMS #1, 2, 3 AND 5 BEFORE INSTALLATION.
- 2) LAY-IN ITEM #18 BOTTOM LINER TO BE RESTING PAD OF ITEM # 13 (Ø4-20) SET SCREWS OF THE BASE PLATE INSIDE OF THE CAVITY.
- 3) INSTALL PARTIALLY ASSEMBLED (ITEMS #1, 2, 3, 5 WITH ALL SET SCREWS) INSIDE OF THE CAVITY.
- 4) THE BASE PLATE SHALL BE ADJUSTED TO THE PROPER HEIGHTS AS SHOWN DWG. K1-430000-00, (-030) AND THE SET SCREWS MUST BE LOWER BY AT LEAST 1/8" FROM THE TOP OF BASE PLATE.
 - ROOM FOR LOCK SET (ITEM #16). USED THE WRIGHT SIZE OF SET SCREW AS NEEDED
 - USED ITEM #11 FOR FILLING THE GAP RE-CUT IF NEEDED.
 - USED YOUR JUDGEMENT AS PER FIELD CONDITIONS.
- 5) BOTH SIDES PLATE SHALL BE ALIGNED AND PARALLEL TO THE CTR. OF BEAM LINE. (-030) USING THE SIDES SET SCREWS FOR ADJUSTMENTS, TO BE RESTED IN ITEM #19 SIDES LINER.
 - USED THE WRIGHT SIZES OF SET SCREW AS NEEDED.
 - USED ITEM #11 FOR FILLING THE GAP RE-CUT IF NEEDED.
- 6) RECHECK THE BASE PLATE POSITION, IF MOVED OR MISALIGNED REPEAT STEP #4 AND #5, OTHERWISE CONTINUE TO STEP #7.
- 7) TIGHTEN THE (4) FOUR SET SCREWS (ITEM #14) ON THE TOP OF SIDES PLATE TO LOCKED.
- 8) INSTALL (3) THREE LOCK SET (ITEM #16) TO THE BASE PLATE TO LOCKED.
- 9) STOP SEE DWG K1-430000-00.
- 10) INSTALL AND ASSEMBLE INPLACE THE LEAD (ITEM # 7 TO #11)
- 11) INSTALL THE RETAINER PLATE (ITEM #6) AND THE FRONT END PLATE (ITEM #4) WITH (8) EIGHT SET SCREWS (ITEM #15) TO SECURED LEAD IN PLACE.

NOTE:

- 1- LEAD LINED PANELS SHALL BE CONSTRUCTED FROM SINGLE UNPIERCED SHEET. FREE OF OXIDE INCLUSIONS, FISSURES, VOIDS AND ALL OTHER DETRIMENTAL DEFECTS. MATERIAL SHALL BE LEAD GRADE 'C' TO COMPLY WITH FEDERAL SPECIFICATION -QQL201. HUTCH SHALL MEET ALL APPLICABLE FEDERAL, STATE AND LOCAL RADIATION GUIDE LINES. NBS HANDBOOK 111 AND 114, ANS N43.2 AND DOE ORDER 5480.11
- 2- ALL DIMENSIONS SHOWN IN [] ARE MILLIMETERS AND FOR REFERENCE USE ONLY.

ITEM #	QUANTITY	DESCRIPTION	MATERIAL / SPEC	UNIT
18	K1-430512-00	K1-43 FE WALL COLL. LINER PLATE		3
16		Ø4-20 x 1/8" LG. HOLLOW LOCK SCREW	ALLOY STEEL	3
15		#8-32 x 5/8" LG. FLAT PT. SET SCREW	STAINLESS STEEL	8
14		#8-32 x 1/2" LG. FLAT PT. SET SCREW	STAINLESS STEEL	4
13		Ø4-20 x 3/8" LG. FLAT PT. SET SCREW	STAINLESS STEEL	11
12		#10-24 x 1/2" LG. SOCKET HD SCREW	STAINLESS STEEL	30
11	K1-430511-01	K1-43 FE WALL COLL. LEAD TOP & SHIM PLATE		16
10	K1-430510-01	K1-43 FE WALL COLL. LEAD UPPER PLATE		16
9	K1-430509-01	K1-43 FE WALL COLL. LEAD UPPER MID. PLATE		16
8	K1-430508-01	K1-43 FE WALL COLL. LEAD LOWER MID. PLATE		16
7	K1-430507-01	K1-43 FE WALL COLL. LEAD BOTTOM PLATE		16
6	K1-430506-01	K1-43 FE WALL COLLIMATOR RETAINER PLATE		1
5	K1-430505-01	K1-43 FE WALL COLLIMATOR BACK PLATE		1
4	K1-430504-01	K1-43 FE WALL COLLIMATOR FRONT PLATE		1
3	K1-430502-01	K1-43 FE WALL COLLIMATOR SIDE PLATE		1
2	K1-430502-01	K1-43 FE WALL COLLIMATOR SIDE PLATE		1
1	K1-430501-01	K1-43 FE WALL COLLIMATOR BASE PLATE		1

K1430511-01	11	K1-430511-01	K1-43 FE WALL COLL. LEAD TOP & SHIM PLATE	16
K1430510-01	10	K1-430510-01	K1-43 FE WALL COLL. LEAD UPPER PLATE	16
K1430509-01	9	K1-430509-01	K1-43 FE WALL COLL. LEAD UPPER MID. PLATE	16
K1430508-01	8	K1-430508-01	K1-43 FE WALL COLL. LEAD LOWER MID. PLATE	16
K1430507-01	7	K1-430507-01	K1-43 FE WALL COLL. LEAD BOTTOM PLATE	16
K1430506-01	6	K1-430506-01	K1-43 FE WALL COLLIMATOR RETAINER PLATE	1
K1430505-01	5	K1-430505-01	K1-43 FE WALL COLLIMATOR BACK PLATE	1
K1430504-01	4	K1-430504-01	K1-43 FE WALL COLLIMATOR FRONT PLATE	1
K1430502-01	2	K1-430502-01	K1-43 FE WALL COLLIMATOR SIDE PLATE	1
K1430501-01	1	K1-430501-01	K1-43 FE WALL COLLIMATOR BASE PLATE	1

PARTS LIST

K1430500-01-01

ARGONNE NATIONAL LABORATORY

ADVANCED PHOTON SOURCE

K1-43 4ID WALL COLLIMATOR FE LEAD ASSEMBLY

DATE	BY	CHKD	APP'D	DESCRIPTION
9/27/98	D. SHU			ISSUE FOR CONSTRUCTION
9/29/98	T. KUZAY			PROJECT SIGN
8/19/98	A. CORCUERA			DESIGN APPROVAL
9/25/98	J. CHANG			ISSUE FOR CONSTRUCTION

01	AS PER REVISION #01	ACC	JC	01/99
01	AS PER REVISION #01	ACC	JC	01/99

SCALE: 1:2
DATE: 1/9

ITEM # K1-430500-01-01