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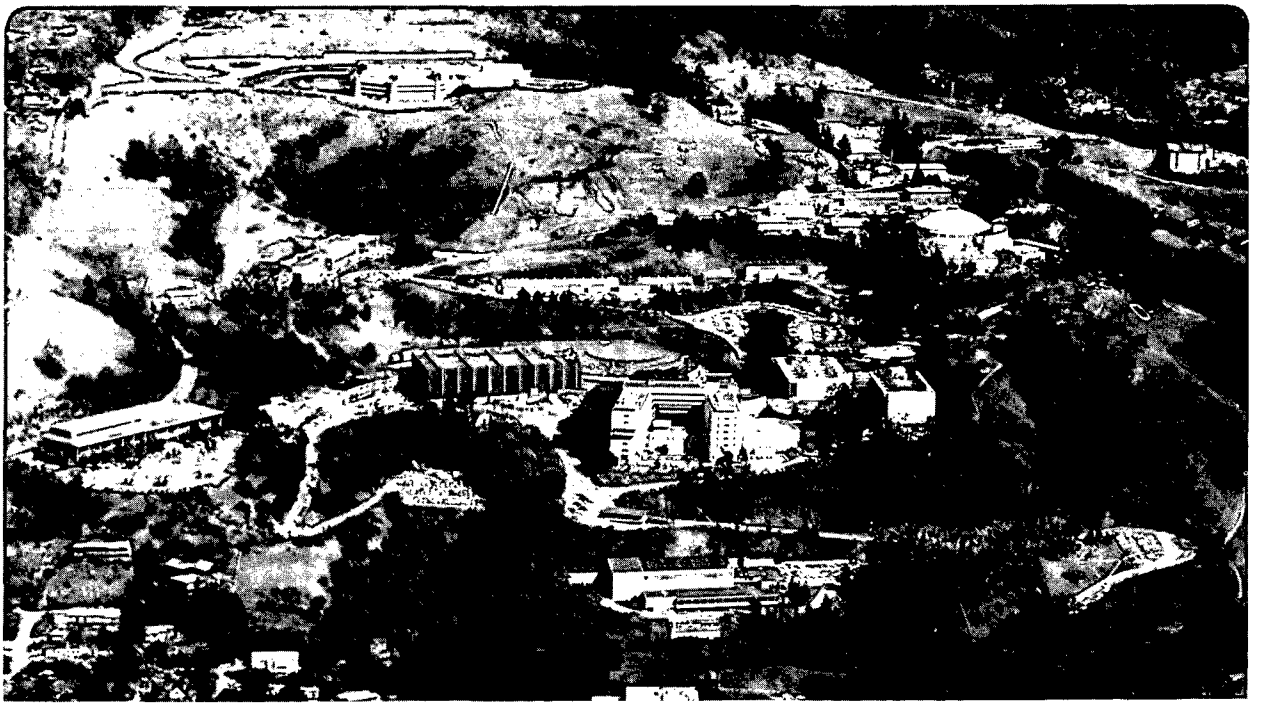

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ENGINEERING NOTE

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SUBJECT NEUTRAL BEAM INJECTOR SYSTEM-BEAM LINE SYSTEM
CONFORMAL COATING DOUBLET III

NAME Jan DeVries

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°C - 60°C.
8. If necessary, repeat the procedure additional times if a thicker coating is desirable.

* Thiokol/Chemical Division
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