

E0900131-v2
35 Watt Air Cooled Beam Dump Assembly procedures
D0900177 and D090095

D0900345 Si –Substrate Mounting Procedure

1. Clean the si-Mirror and Heat Sink body with alcohol before bonding.
2. Mix the Silver epoxy [McMaster part 7595A33] one to one.
3. Apply to the backside of the si-Mirror, spread a layer .005”-010” thick, using a razor blade.
4. Press the si-Mirror and Heat Sink together and let the parts cure for 24 hours at room temperature.

D090095 Beam Dump General Assembly Instructions.

1. Attach the feet to the Heat Sink body, as shown in the drawing,
2. Put two Part 17 washers between the part 10 bracket and the part 1 Heat Sink body typ.
3. Push Part 5 & 22 against the heat sink body flange as shown so there is no gap.
4. Part 16 to contact Part 5 & 22, check the orientation of the drill point feature, and tighten the top and bottom 4-40 button hd. screws.

D0900177 Beam Dump General Assembly Instructions.

1. Attach the feet to the Heat Sink body, as shown in the drawing.
2. Push part 5 & 4 against the heat sink body flange as shown so there is no gap.
3. The longer part of the foot part D0900809 should be forward as shown.
4. Part 12 to contact Part 5 & 4, check the orientation of the drill point feature, and tighten the top and bottom 4-40 button hd. screws.

D0900177 and D090095 Beam Alignment Procedure

1. There are two target tools (D0900843 & D0900901) one with a mirror, and one with a center hole.
2. Target D0900843 is used to center the beam (step 1), then is replaced with the mirror D0900901 to retro reflect the beam back on itself (step 2).
3. In Beam Dump D090095, the part D0900814 should be clamped to pivot the entire assembly about the shoulder screw which is centered at the aperture opening.
4. The D0900177 will need to have step (step 2) done manually after the beam is first centered in the aperture hole with target D0900843