

Building L4-C Pod's T080261-v1 (was T080261-00-R)

- 1) Install cable onto the L4-C using spacers and 4-40 x .75 SHCS (P1 to E pin on the L4-C)
- 2) Place (part 20007822-1) Base Plate with knife edge up. Inspect knife edge for debris or damage



- 3) Then loosely fasten (part 20007824-1) Clamp to the Base Plate using (3) 4-40 x .625 SHCS and (3) NAS620C-4L washers, also install the (6) 4-40 x .75 SHCS and (6) NAS620C-4L washers loosely attaching both halves of the clamp.



- 4) Now slide the L4-C into the Clamp. The horizontal L4-C should be orientated as so the arrow on the bottom is pointing to the Align Mark on the Base Plate. The vertical has no orientation.



- 5) Now tighten the (6) 4-40 screws that mate the Clamp, and then tighten the (3) 4-40 screws that hold it to the Base Plate.
- 6) Place a 6" gasket G-600 onto the Base Plate knife edge, then carefully lower the (part 20007823-1) Chamber over the L4-C while carefully feeding the cable through the side port. Line up the Align Marks for the Base Plate and the Chamber
Keep in mind that the cable will not adjust (slide in or out) once the Chamber is seated, so only allow about 1" of the cable to protrude from the Side Port. Also do not to let the cable drop below the Clamp.

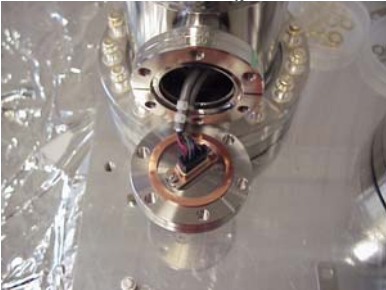


- 7) Install the (16) TWP-3120-NA (5/16-24 x 1.25) 12pt bolts and WFV-31 vented washers, then torque to 190 in lbs

(I made a special tool to torque the bolts under the Side Port)



- 8) Next install a 2.75 gasket (hang on the 1" of cable protruding from the Side Port) Now fasten the cable to (part 100200) Flange Feed Through with (2) 4-40 x .5 SHCS



- 9) Now carefully install the Feed Through (100200) onto the Side Port making sure the gasket is in position over the knife edge. Install the (6) TWP-2814-NA $\frac{1}{4}$ -28 x 7/8 12pt bolts and WFV-25 vented washers and torque to 110 in lbs

I have made tags for the pods that indicate witch L4-C is inside and weather it is a Horiz or Vert , I also made covers to protect the Feed Through pins. We should make these in bulk when we go into production.

Parts list for L4-C Pod

- 1) 4ea .5 spacers
- 2) 4ea 4-40 x .75 SHCS
- 3) 1ea L4-C Cable
- 4) 1ea L4-C
- 5) 1ea 20007822-1 Baseplate
- 6) 1set ea 20007824-1 L4-C Clamp
- 6) 3ea 4-40 x .625
- 7) 6ea 4-40 x .75 SHCS
- 8) 9ea NAS620C-4L washer
- 9) 1ea G-600
- 10) 1ea 20007823-1 Chamber
- 11) 16ea TWP-3120-NA 5/16-24 x 1.25 12pt
- 12) 16ea WFV-31
- 13) 1ea 100200 Feedthrough
- 14) 6ea TWP-2814-NA 1/4-28 x 7/8 12pt bolts
- 15) 1ea G-

This list uses hardware # from UC Components

Documents used
20007820