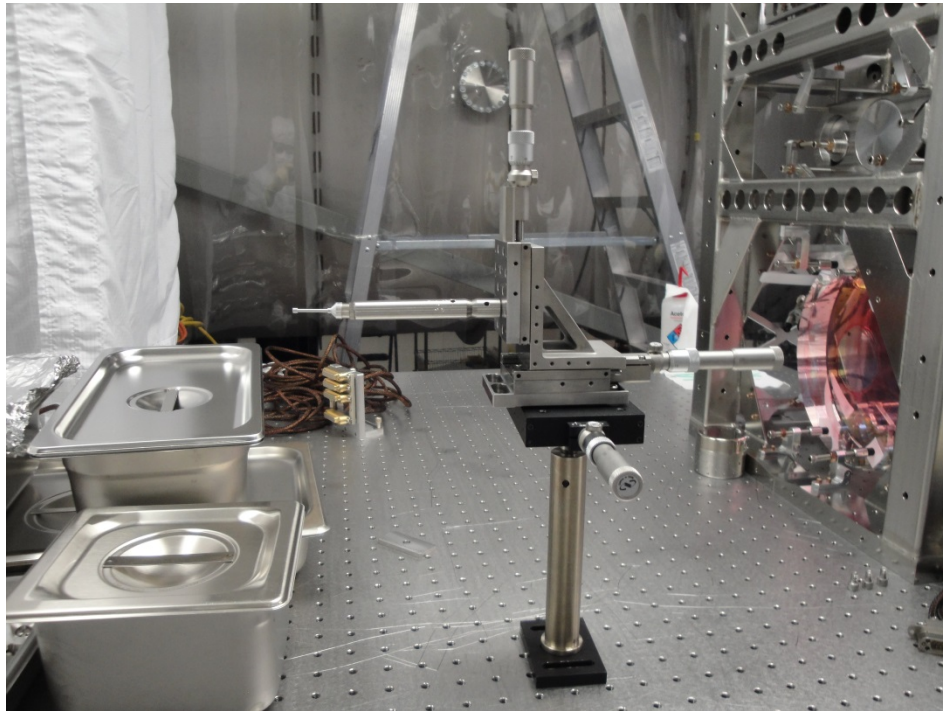


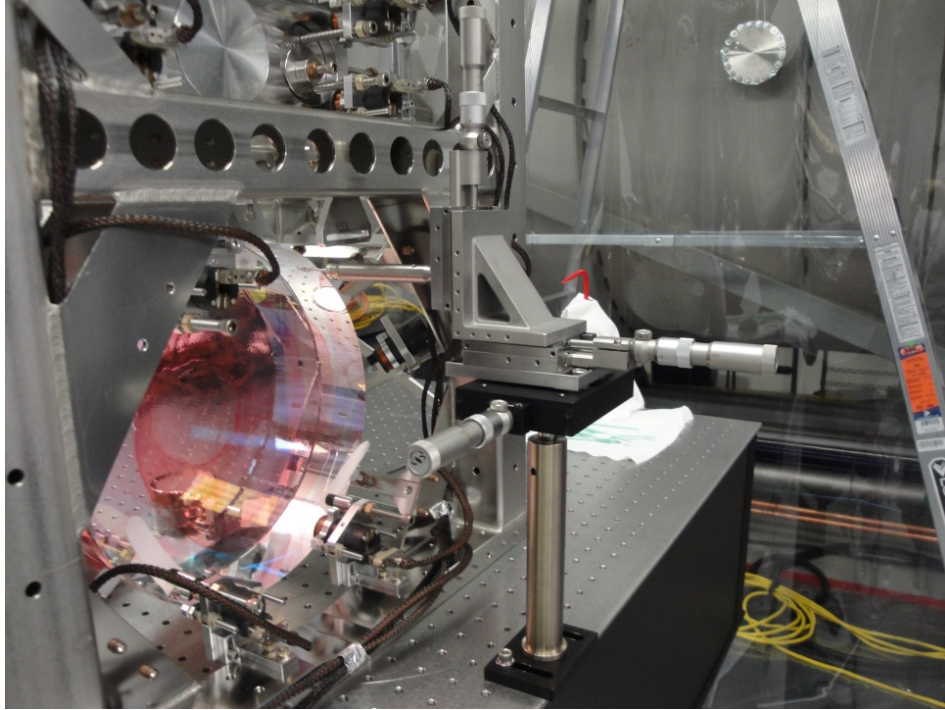
HxTS Magnet Repair

Procedure:

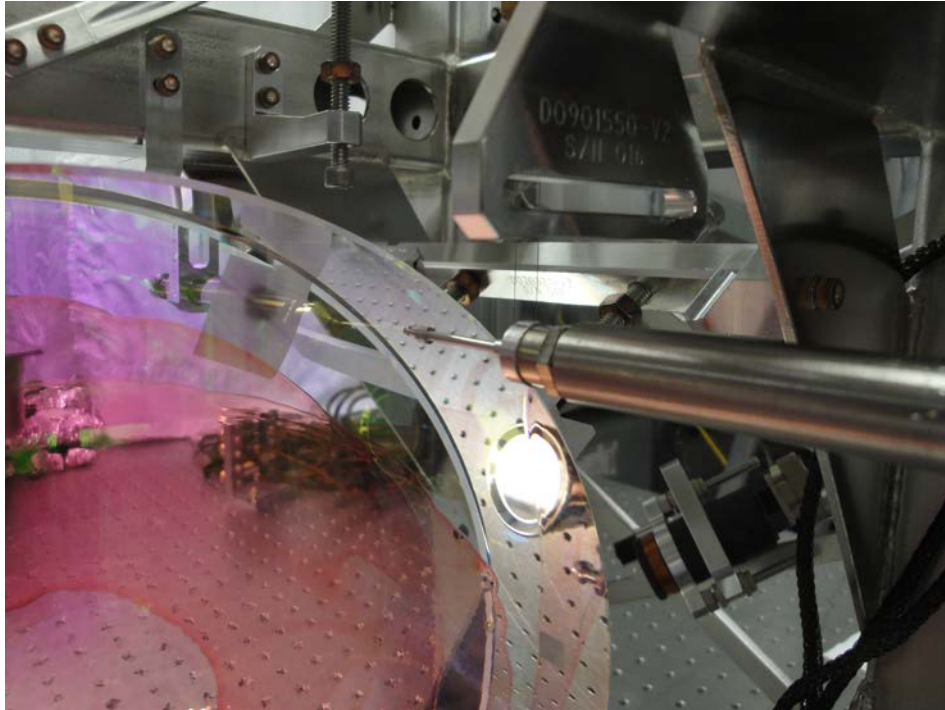
- 1) Lock the Intermediate Mass in its level hanging position; then lock the Optic in its level hanging position.
- 2) Adjust the placement and X, Y, Z location of the 3 axis translation setup so the magnet flag holder is aligned on top of the ring of glue left from the original magnet/dumbbell assembly.
- 3) Lock the Z and Y axis stages of the 3 axis translation setup in place so they cannot shift.
- 4) Retract the X axis stage as far as it can go to pull back the magnet flag holder away from the Optic face.
- 5) Using Acetone and Alpha swabs carefully clean the old glue from the face of the Optic. It helps to hold an Acetone soaked swab against the glue spot for several minutes to soften the old EP-30. Then with a second swab gently rub the glue spot. If the glue does not start to come off hold the Acetone swab against the glue spot for a few more minutes.
- 6) Repeat the wetting and swabbing process until all the old EP-30 has been removed.
- 7) Mount a new magnet/dumbbell assembly into the flag holder and apply a dab of EP-30 epoxy to the dumbbell.
- 8) Slowly turn in the X axis stage until the dumbbell makes contact with the face of the Optic.
- 9) Lock the X axis stage so it cannot shift while the Epoxy cures.



3 Axis Translation Setup



Positioning the Translation Setup to Install Magnet



Holding the Magnet on the Mass while Epoxy Cures