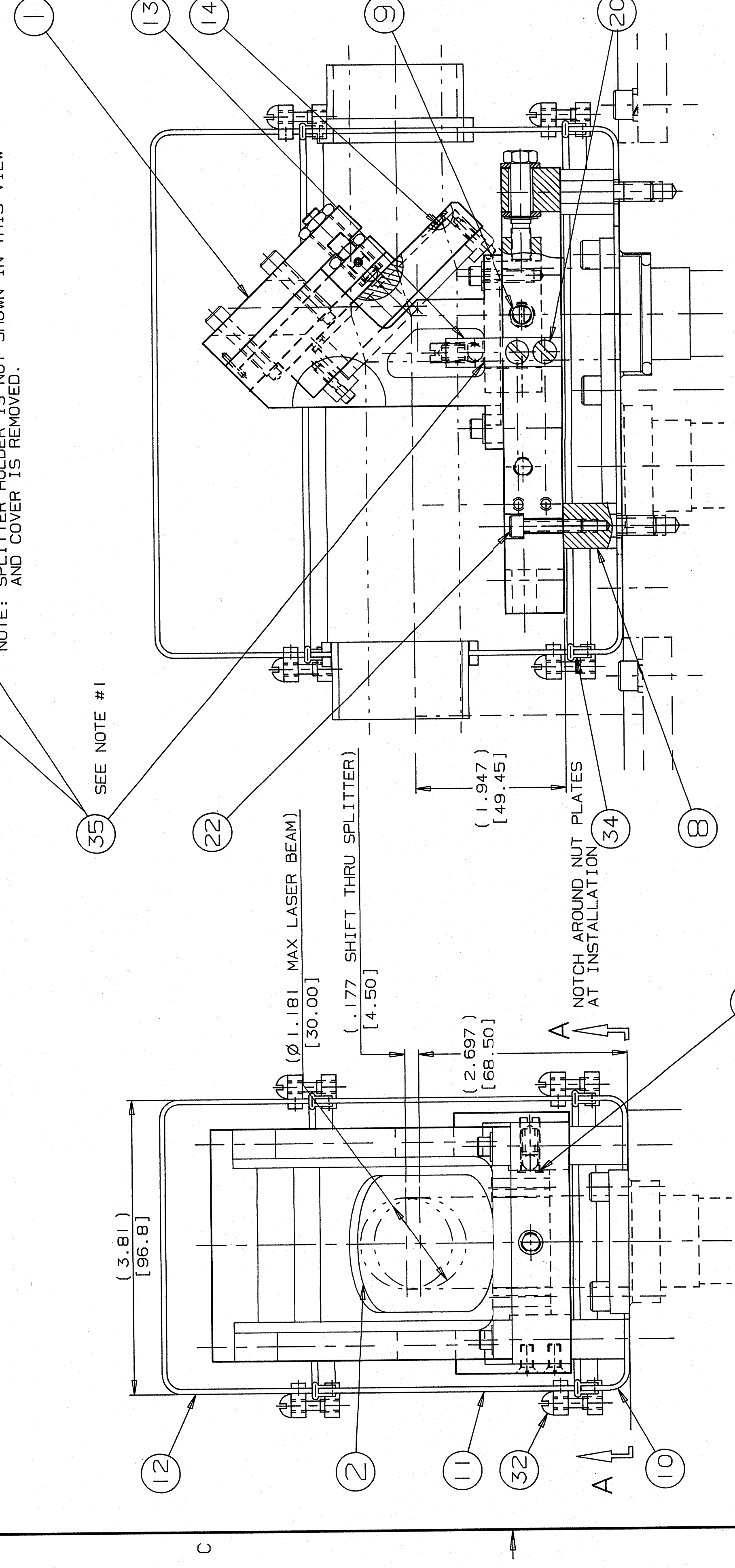
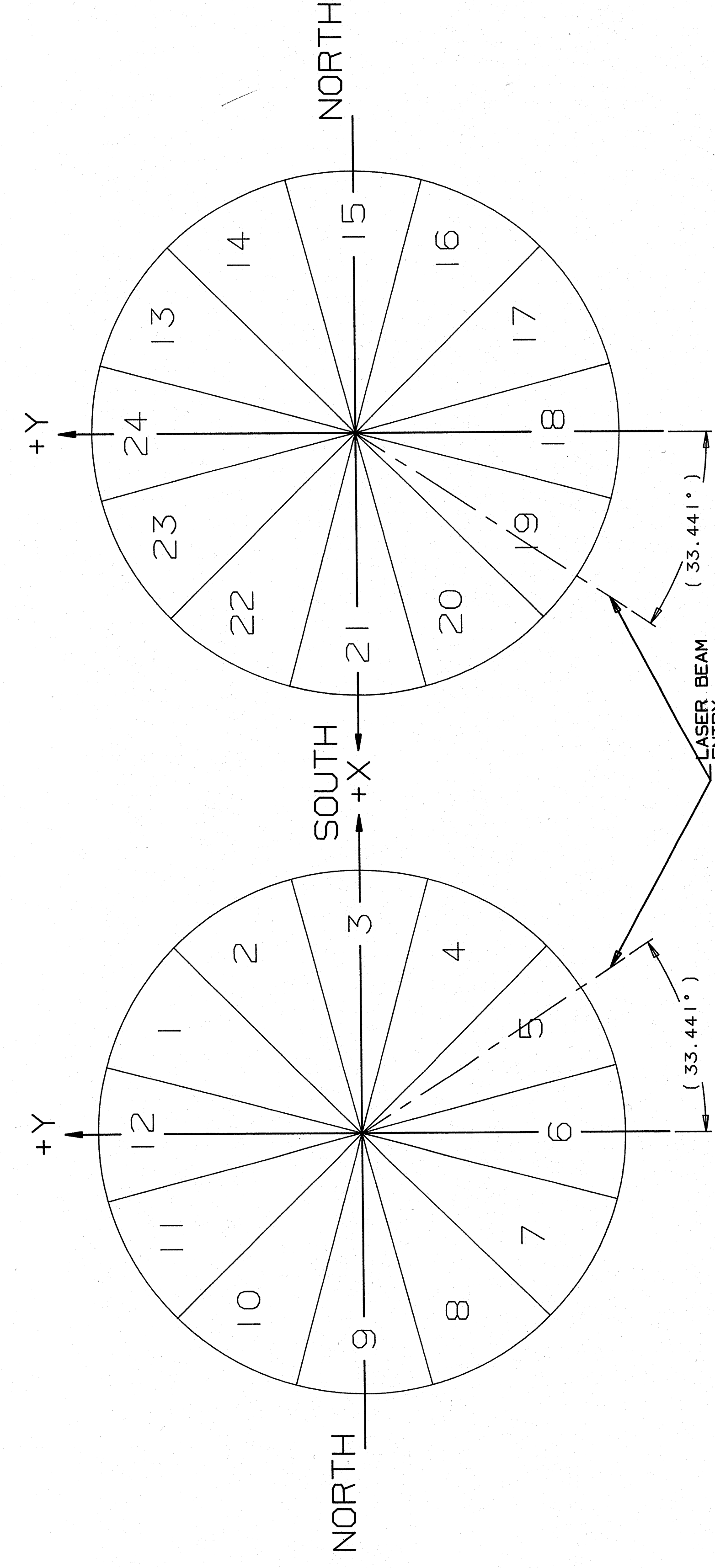


NOTE: SPLITTER HOLDER IS NOT SHOWN IN THIS VIEW AND COVER IS REMOVED.



24A9656-L#
LEFT SECONDARY SPLITTER

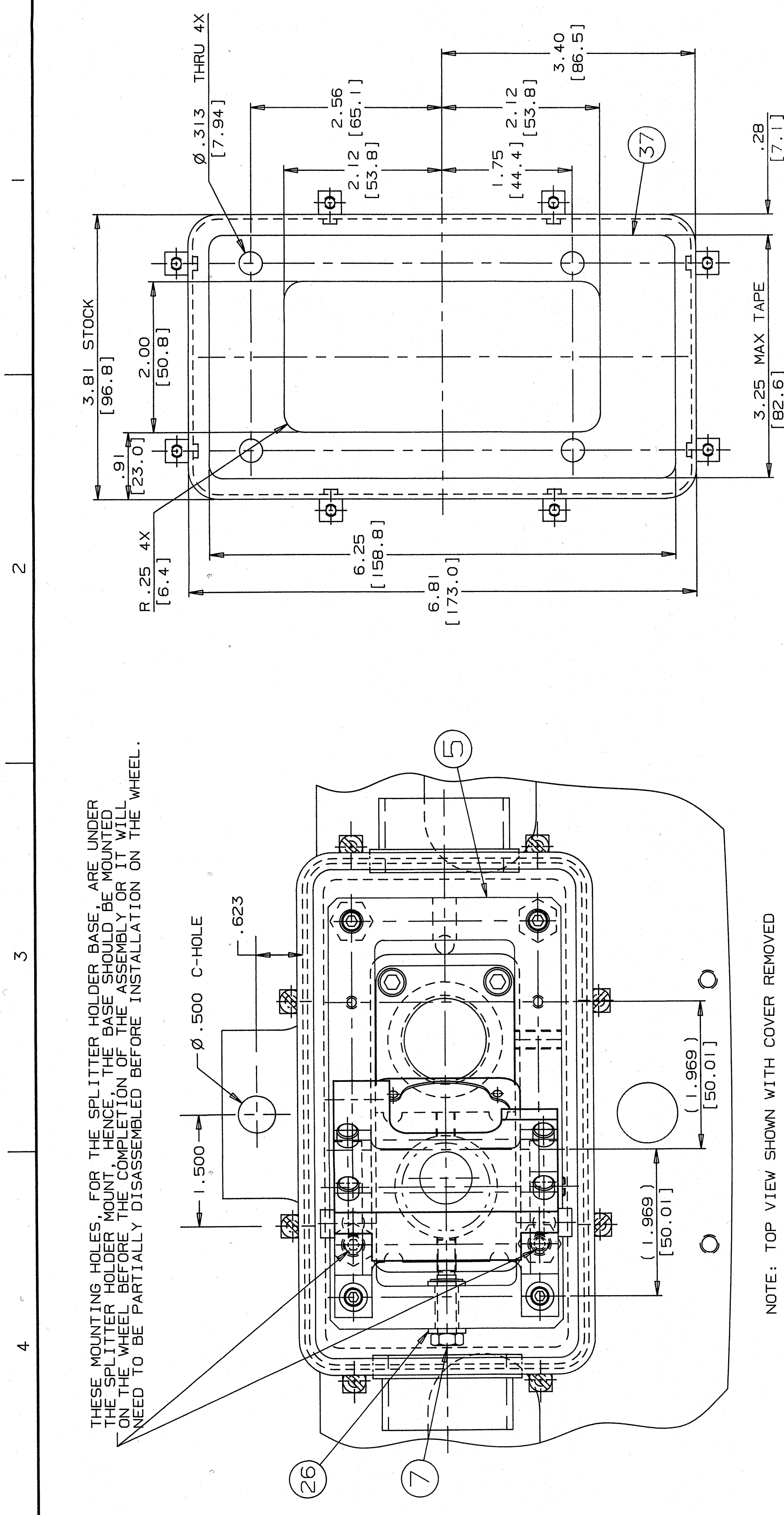
LOCATED IN SECTORS 6, 8, 10, 20, 22 & 24
SECTOR 6 & 20 SHOWN



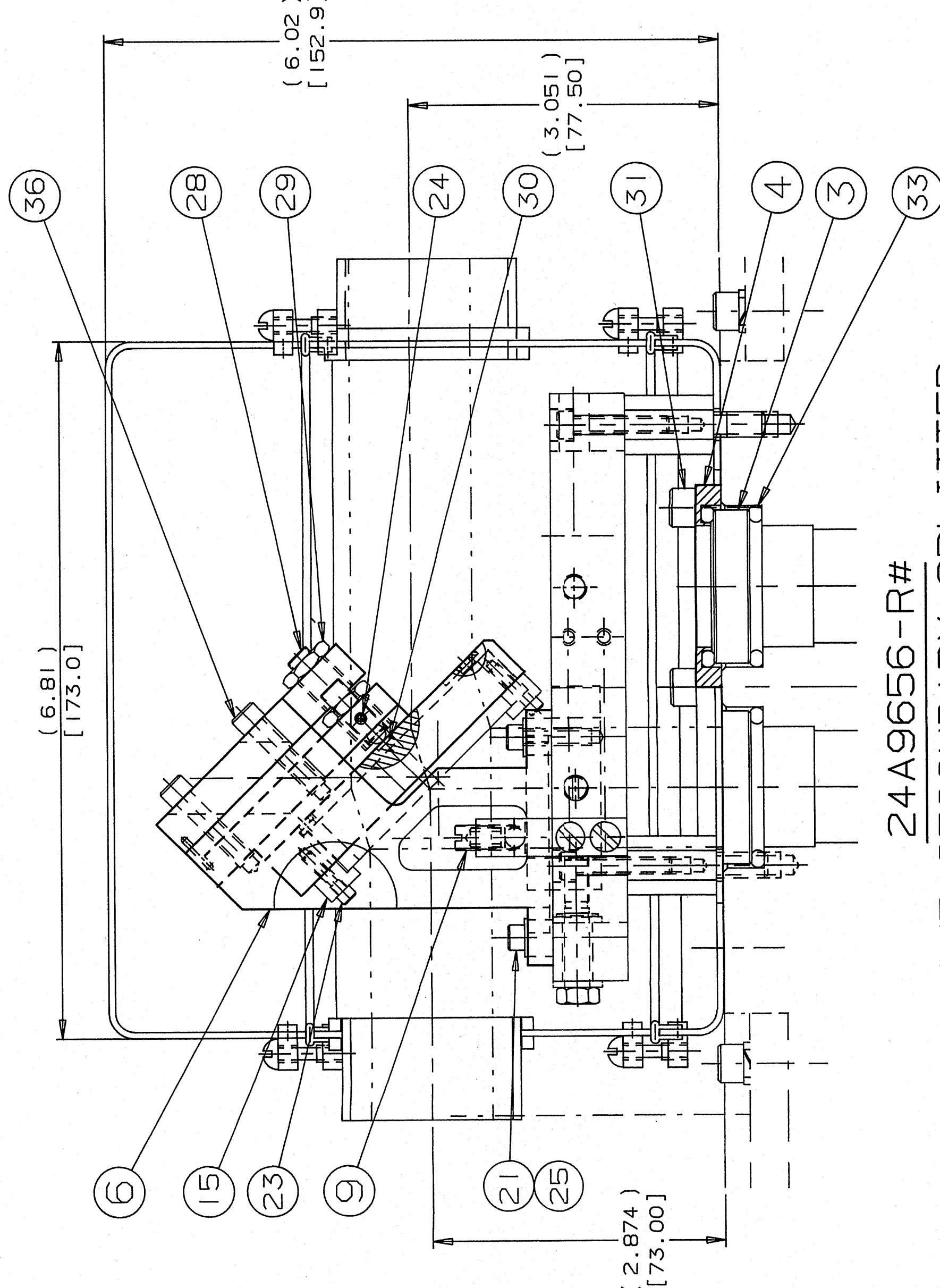
LOOKING AT WEST END +Z

LOOKING AT EAST END -Z

TPC WHEEL SECTOR IDENTIFICATION



NOTE: TOP VIEW SHOWN WITH COVER REMOVED



24A9656-R#
RIGHT SECONDARY SPLITTER

LOCATED IN SECTORS 2, 12, 18, 16 & 14
SECTOR 2 & 16 SHOWN

ASSEMBLY No.	SPLITTER PART No.	BASE STANDOFF PART No.	WEST END SECTOR #2 LOCATION	EAST END SECTOR #2 LOCATION
24A9656-L1	24AG582-1	24A9642-1	6	20
24A9656-L2	24AG582-2	24A9642-2	8	22
24A9656-L3	24AG582-3	24A9642-3	10	24
24A9656-R1	24AG582-1	24A9642-1	4	18
24A9656-R2	24AG582-2	24A9642-2	2	16
24A9656-R3	24AG582-3	24A9642-3	12	14

- NOTES:
- SECURE ITEM #35 IN PLACE WITH HYSOL #9309 EPOXY ADHESIVE. THREE PLACES TO THE SPLITTER HOLDER MOUNT. ITEM #6. THICKNESS OF THE ADHESIVE TO BE LESS THAN .005
 - QUANTITIES LISTED FOR ITEM CALLOUTS ARE PER SPLITTER POSITION. THERE ARE TWELVE POSITIONS.
 - AT INSTALLATION OF THE SPLITTER ENCLOSURE BOTTOM 24A9656 APPLY SHIM ADHESIVE TO THE TOP OF THE SPLITTER HOLDER AND CLEARANCE OPENINGS TO MATCH. INSERT SHORT STUDS IN SCREW HOLES FOR GUIDANCE OF THE BOTTOM IN PROPER LOCATION. REMOVE PROTECTIVE LINER FROM TRANSFER TAPE AND SET THE TOP OF STUDS IN PLACE. TAPE MUST BE CONTINUOUS TO PROVIDE A SEAL AT THE INTERFACE.

ITEM NO.	REV.	DESCRIPTION	QTY	REV. DATE	REV. BY	REV. NO.
37	1	3M ADHESIVE TRANSFER TAPE #4709C X .325 WIDE X 6.25 LING				
38	4	SOC. TO CAP SCREW #10-32 LINE X .75 LINE BRASS OR SILICONE BRONZE				
39	3	WINDOW #7.50 MM X 6.40 THICK SAPPHIRE, EDWARD SCIENTIFIC #EA1608				
34	2	BAKED 7850 PART #25P-F-50-20-3, BLACK EPOXY FOR BOX #7850-09				
33	4	O-RING #7.25 O.D. X 1.75 I.D. X .125 W.D. 90° VEE, BRUNNEN #1004				
32	1	FLAT TO WASH SCREW #6-32 LINE X .375 LINE BRASS OR SILICONE BRONZE				
31	16	SOC. TO CAP SCREW #10-32 LINE X .75 LINE BRASS OR SILICONE BRONZE				
30	2	WINDOW #5.0 MM X 1.0 MM THICK SAPPHIRE, EDWARD SCIENTIFIC #EA1606				
29	2	THOR LASE NUT ANODLS, BRASS, 25-80 LINE DIA. X .375-40 LINE O.D.				
28	2	THOR LASE ADJUST SCREW #5555-075 SILICONE BRONZE W/BERYLUM BALL				
27	1	BAKED EXTERNAL RETURNING TUNG TUNG #5501-25 BERYLLIUM COPPER				
26	2	WASHER #550 O.D. X .250 I.D. X .062 TOLON MANUFACTURER #550042				
25	2	SOC. TO CAP SCREW #10-32 LINE X .75 LINE BRASS OR SILICONE BRONZE				
24	3	SOC. TO CAP SCREW #10-32 LINE X .75 LINE BRASS OR SILICONE BRONZE				
23	3	SOC. TO CAP SCREW #10-32 LINE X .75 LINE BRASS OR SILICONE BRONZE				
22	4	SOC. TO CAP SCREW #10-32 LINE X .75 LINE BRASS OR SILICONE BRONZE				
21	4	SOC. TO CAP SCREW #10-32 LINE X .75 LINE BRASS OR SILICONE BRONZE				
20	4	SOC. TO CAP SCREW #10-32 LINE X .75 LINE BRASS OR SILICONE BRONZE				
19	1					
18	1					
17	1					
16	1					
15	3	24AG742 SPLITTER RETAINER				
14	3	24AG732 SPLITTER SFT PHD				
13	2	24AG722 SPLITTER MOUNT LHM ARM				
12	1	24AG703 SPLITTER ENCLOSURE COVER				
11	1	24AG693 SPLITTER ENCLOSURE COVER				
10	1	24AG683 SPLITTER ENCLOSURE BOTTOM				
9	3	24AG672 PLUNKER SCREW				
8	4	SEE TABULATION BASE STANDOFF				
7	1	24AG652-1 SPLITTER POSITION ADJUSTING SCREW				
6	1	24AG652-2 SPLITTER HOLDER MOUNT				
5	1	24AG652-3 SPLITTER HOLDER MOUNT				
4	2	24AG652-4 SPLITTER RETAINER (CONSISTS OF TWO PEESES)				
3	2	24AG652-5 PORT WASHER				
2	1	24AG652-6 SPLITTER HOLDER				
1	1	24AG652-7 SPLITTER HOLDER				

REV.	DATE	DESCRIPTION	REV. NO.
4.2.6		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
		ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED	
		FINISH UNLESS OTHERWISE SPECIFIED	
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED	
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED	

APPROVAL	DATE	REV.	DESCRIPTION