

App. XI

ECD SUB-ASSEMBLY PROCEDURE

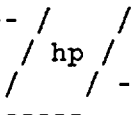
(General License 19233-~~60575~~) **60576**
 (Specific License 19235-~~60535~~) **60536**

I. This document describes the assembly procedure for the EC Detector. In the first section of the procedure are a list of parts and tools needed to assemble the detector. Section II are the procedure steps required to complete the assembly. After you become familiar with the assembly section II can be used as a checklist to see that all of the steps have been performed.

PARTS LIST

<u>ITEM #</u>	<u>DESCRIPTION</u>	<u>PART NUMBER</u>	<u>QTY</u>
1	Anode Retaining Nut	19233-20725	1
2	Screw-Socket M4x0.7	0515-0321	4
3	Seal	19233-20600	1
4	Sealing Cap	19233-20570	1
5	Vent Plug	19233-20580	1
6	General License Label	19233-90715	1
7	Upper Cell Weldment	19233-80525	1
8	Plated Lower Body	19233-80545	1
9	Anode Weldment	19233-80585	1
10	Anode Ferrule	19233-20695	1
11	Specific License Label	19233-90745	1
12	SST Cable Wire - 12" LG	8160-0033	1
13	Lug - Spade	0360-0073	1
14	O-Ring	0905-0464	1

			MODEL 5890A	STK #
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TOOLS NEEDED FOR ASSEMBLY

1. Set of Hex Keys (8710-1366) available only in the Hot Lab
2. Vise
3. Set of metal punches (numbers and letters)
4. Anode Wrench (19233-20735)

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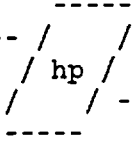
II. STEPS:

1. Holding the Plated Lower Body (Item 8, 19233-80545) so that the larger end is pointing away from you, turn the Sealing Cap (Item 4, 19233-20570) onto the threaded end of the lower body. (See Figure 1)

SAFETY NOTE: To minimize exposure, it is important that you always point the bottom of the plated lower body away from you.

2. Visually inspect the brazed joints where the tubes connect to the Upper Cell Weldment (Item 7, 19233-80525) to see that brazed joints are complete and appear to be leak proof. (See Figure 1)
3. To assemble upper part of cell:
Assemble Anode Weldment (Item 9, 19233-80585) and Anode Ferrule (Item 10, 19233-20695) to Upper Cell Weldment (Item 7, 19233-80525) with Anode Retaining Nut (Item 1, 19233-20725). Tighten Anode Retaining Nut firmly (approx. 11 N-Meters.).
4. Turn the upper weldment so that you are looking at the larger end and see that the tube through the center (the anode) is not touching the inner walls of the weldment. If it is adjust the anode into the center using your fingers.
5. Insert O-Ring in the center of the Seal. Place the Seal (item 3, 19233-20600) & O-Ring (item 14, 0905-0464) onto the base of the lower body lining up the holes in the seal with the holes in the lower body. Place the upper weldment onto the seal again lining up all of the holes. (See Figure 1)

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6. Secure the upper weldment to the lower body by inserting three screws (Item 2, 0515-0321) to the back, front, and right sides of the upper weldment. (See Figure 1)

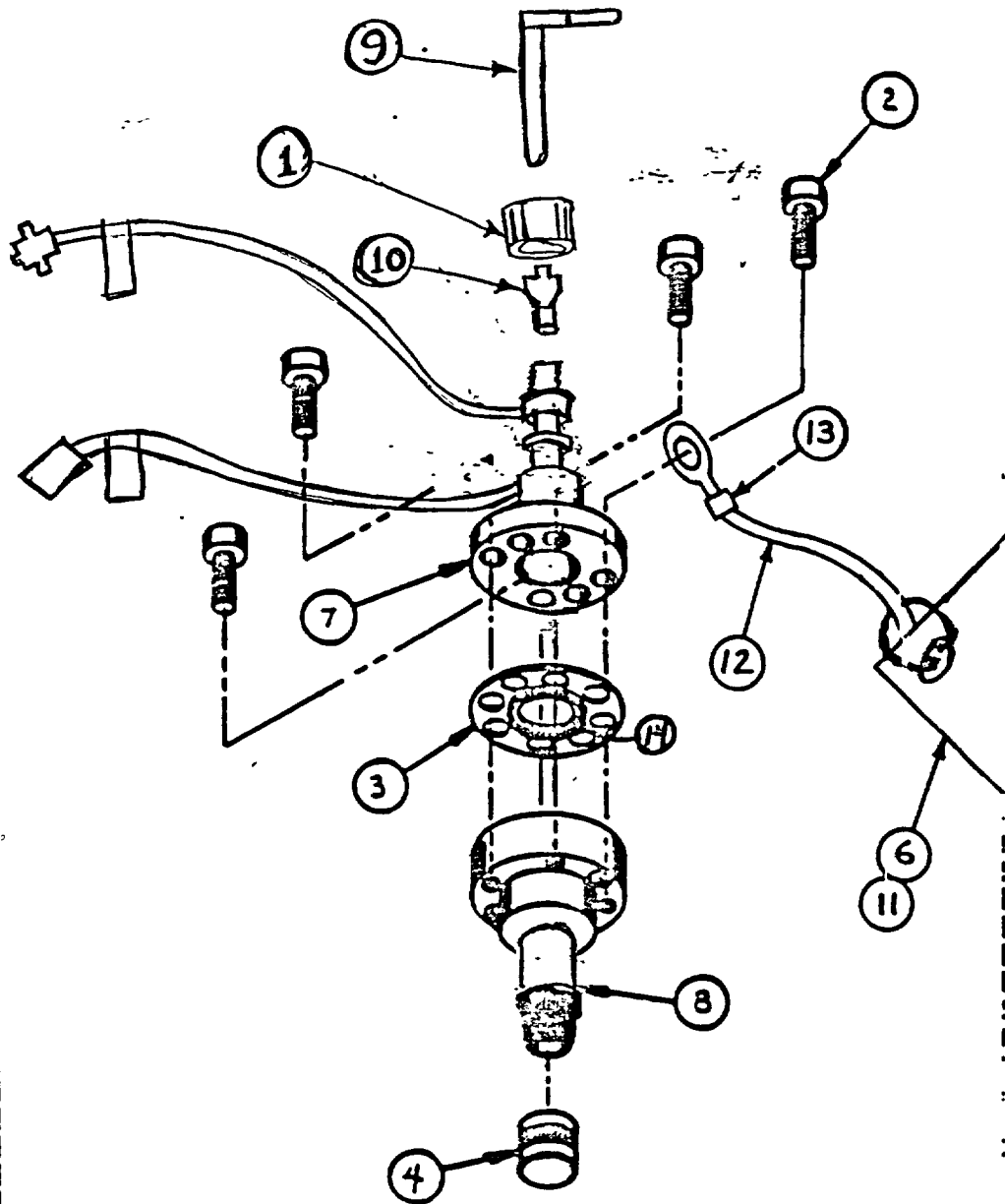
7. Position the small diameter portion of the lower body assembly into a vise (taking care not to crush or damage Sealing Cap (Item 4) and tighten all of the screws firmly (approx. 7 Newton-Meters torque).

8. Assemble per notes #1 & #2 on Drawing C-19233-90505-1. Install either (Item 6, 19233-90715 for the General License or (Item 11, 19233-907450 for the Specific License. (See Figure 1)

9. Position the hex nut of the lower body assembly into a vise and tighten all of the screws firmly (approx. 7N Meters).

10. Stamp the serial number (from the side of the cell) and the date to the correct position on the label.

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(FIGURE 1)

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