

## Quorum Emitech

Unit 1 &2  
Eden Business Center  
South Stour Avenue  
Ashford Kent

Works instructions For: -

**K575X**  
**AL-117-015**

Author	A New	Issue 1	
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Push 4 M3 S/S nuts [14203001](#) into the insulator [A4110028](#) and secure with Araldite [12000012](#), making sure you block off the holes with 4 M3x6 pan head screws. After it has set, screw the hermetically sealed receptacle [08040005](#) into the top plate [A1117034](#) and fit the insulator using the 4 M3x8mm pan head screws (14003202). Push an o-ring [51000016](#) over the insulator after wrapping it with T8855 foil tape and another o-ring (51000053) over the conductor [A4110252](#). Sit the cooling plate [A4110254](#) on top of the first o-ring and push the conductor through the top plate and screw to the cooling plate using an M3x6 Csk screw [14003107](#). Make sure the tapped hole in the conductor lines up with the hole in the plate. Lay the insulator sheet [A4110056](#) on top of the cooling plate and screw the target cover [A4110039](#) into the insulator using 4 M3x10 cap head screws [14003203](#) and spring washers [14203501](#). Bend the end of a contact spring [A4310139](#) into a loop, coil the spring into the recess in the target cover and solder the loop over the spigot from the sealed receptacle. Drop the magnets [24200003](#) and [24200004](#) into the cover so that their polarities are facing the opposite way (repelling) and dab a small amount of paint on the tops of the magnets. Fit the target holder [A4110038](#) into the cover using the target clamp [A4110037](#). Then fit the dark space shield (A3117131) using 3 M3x6 and 1 M3x8 cap head screws.

