

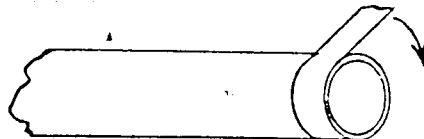
# EPOXY PROCEDURE (229B & 320 ANTENNA)

Step 1 Weigh mixing container on postal scale. Add 4 oz. of Part A (EA901) and 1 oz. Part B (HCB-1).  
NOTE: This amount will make enough Epoxy for one antenna.

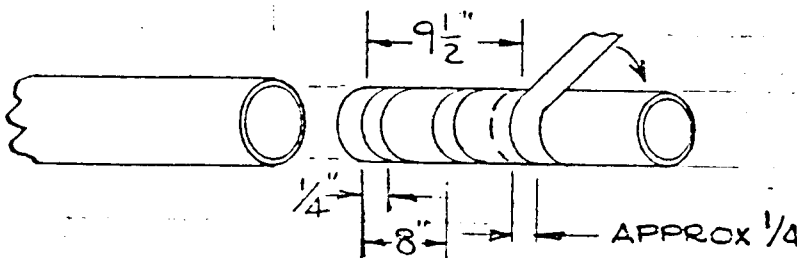
Step 2 Mix thoroughly until mixture turns red.

Step 3 Surfaces to be epoxied can be cleaned with alcohol.

Step 4 Place a strip of masking tape around the top of base pipe.



Step 5 After establishing depth of radome in base pipe, mark the radome at depth dim.  $9\frac{1}{2}$ " and place a strip of masking tape approximately  $\frac{1}{4}$ " back. To insure proper alignment of radome in base pipe place two pieces of masking tape on radome  $\frac{1}{4}$ " and 8" from end as shown.



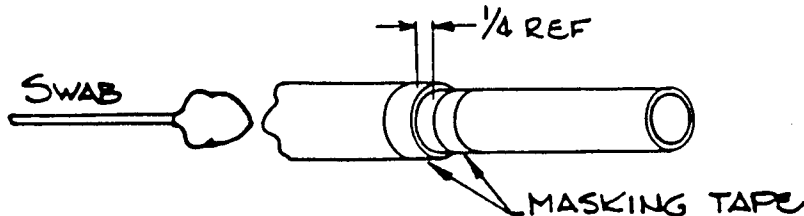
Ant 320/450  
460

ITEM	PART NUMBER	DESCRIPTION	QTY
<b>BILL OF MATERIAL</b>			
DRAWN <i>OKRANT</i> CHECKED ENG. <i>E. Sinclair</i> NEXT ASS'Y 350065, 350102 MATERIAL FINISH	DATE 1/4/75 TOLERANCES UNLESS OTHERWISE SPECIFIED FRACTION ANGLE X XX XXX	DO NOT SCALE THIS DRAWING ALL DIM. IN INCHES TITLE 229B & 320 SERIES ANT <u>EPOXY PROCEDURE</u> SHEET 1 OF 2 SHEETS SCALE DRAWING NO. A 025032	 SINCLAIR TORONTO - VANCOUVER - MONTREAL ISSUE 1

# EPOXY PROCEDURE (229B & 320 ANTENNA) (CONT'D.)

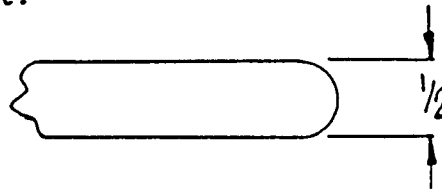
Step 6 Coat both surfaces with epoxy (inside of base and out side of radome, to dim.  $9\frac{1}{2}$ ). Place base pipe over radome and turn in a clock wise direction until dim.  $9\frac{1}{2}$  is obtained. (Curing time is 24 hrs.)

Step 7 Clean excess epoxy from inside of base pipe and radome using a swab.

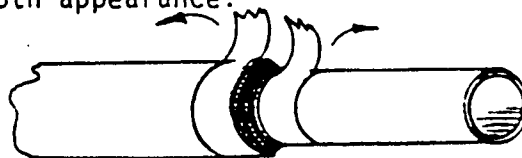


NOTE: Inside base of radome must be free of epoxy to allow coil assembly to slide freely into radome.

Step 8 Bead joint with applicator tool to ensure a good water proof joint.




Step 9 After epoxy sets for about one hour, remove tape CAREFULLY pulling away from the joint. Inspect joint to make sure it is sound and of smooth appearance.



Step 10 Carefully place assembly in a secure position for 24 hours curing time before handling.

229/249

ITEM	PART NUMBER	DESCRIPTION		QTY
<b>BILL OF MATERIAL</b>				
DRAWN <i>OCKRANT</i>		DATE <i>1/4/75</i>	TOLERANCES UNLESS OTHERWISE SPECIFIED	 <b>SINCLAIR</b> TORONTO · VANCOUVER · MONTREAL
CHECKED			-X FRACTION	
ENG. <i>H. Oshiro</i>		DATE <i>70-8-25</i>	-XX ANGLE	<b>TITLE</b> 229B & 320 SERIES ANT <b>EPOXY PROCEDURE</b> <b>SHEET 2 OF 2 SHEETS</b>
NEXT ASSY <i>350065,350102</i>			-XXX	
MATERIAL		SCALE		DRAWING NO. <i>025032</i>
FINISH				ISSUE <i>1</i>