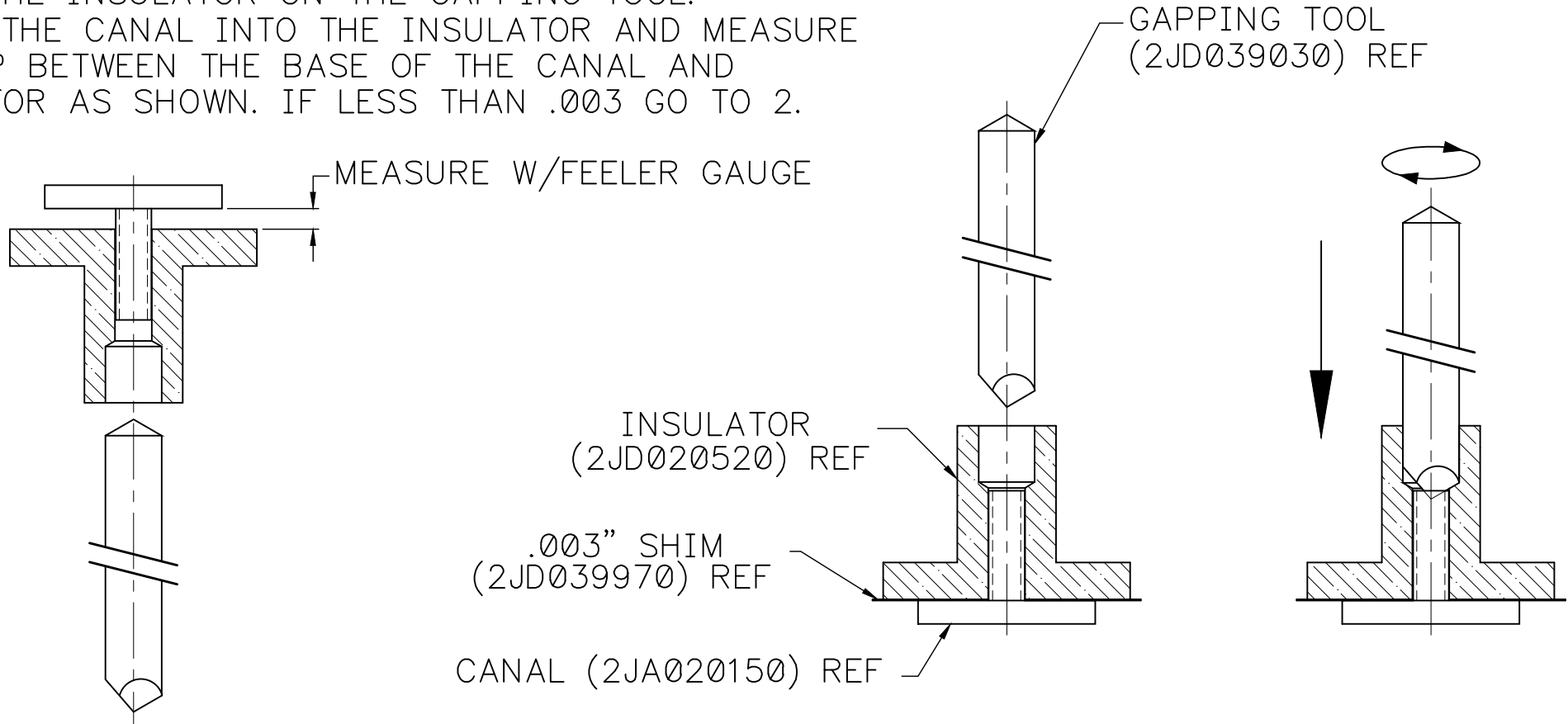


INSULATOR GAPPING INSTRUCTIONS:

- 1.) HOLDING THE GAPPING TOOL WITH CONICAL END UP, PLACE THE INSULATOR ON THE GAPPING TOOL. INSERT THE CANAL INTO THE INSULATOR AND MEASURE THE GAP BETWEEN THE BASE OF THE CANAL AND INSULATOR AS SHOWN. IF LESS THAN .003 GO TO 2.



- 2.) PLACE .003" SHIM WASHER (2JD039970) BETWEEN THE CANAL AND INSULATOR AS SHOWN.
- 3.) INSERT FACETED END OF GAPPING TOOL AND LIGHTLY ROTATE BY HAND WHILE APPLYING SLIGHT PRESSURE TO CARVE AWAY THE BORON NITRIDE OF THE INSULATOR UNTIL CONTACT IS MADE WITH THE CANAL.
- 4.) CLEAN UP PARTS AND ASSEMBLE IN SOURCE.
- 5.) IF PROBE CURRENT IS TOO LOW (LESS THAN 1.8mA), INCREASE THE SHIM THICKNESS (.001" STEPS) UNTIL CURRENT RISES ABOVE 2.0mA.

A SHIM WAS .008"		JTN	6/11/12	AJS	6/11/12	DRAWN	NLP	08/08/06	NATIONAL ELECTROSTATICS CORPORATION MIDDLETON, WISCONSIN	
NO.	REVISION	BY	DATE	CKD	DATE	CHECKED	JTN	INSULATOR GAPPING INSTRUCTIONS		
TOLERANCES AND FINISH UNLESS OTHERWISE SPECIFIED						DESIGNED	AJS	PART NO. 2JS039680		
FRACTIONAL ±1/64"	.XXX ±.005	ANGLE ±.5°	MACH 125√	THIRD ANGLE PROJECTION		SCALE	4=1	DWG NO. 11-3968		LOC CV