



**10 kW HCF e-GUN ASSEMBLY
SHUNTS ADJUSTMENT**

IF BEAM IS AWAY FROM THE CENTER OF THE CRUCIBLE AND IT IS TOWARD THE EMITTER SIDE, IT MEANS THAT THE MAGNETIC IS TOO STRONG. BY ADDING A SHUNT EITHER TOP OR BOTTOM SIDE OF THE SWEEP COIL COVER, IT WILL WEAKEN THE MAGNETIC FIELD AND IT WILL MOVE THE BEAM TOWARD THE CENTER. VERY IMPORTANT THAT THE SHUNTS MUST TOTALLY TOUCH THE RIGHT AND LEFT POLE PIECES FOR THE SHUNTS TO FUNCTION PROPERLY.

REF. WITH ONE SHUNT 112161-XX ADDED.

- a) -.03 .03" THICK WILL WEAKEN THE MAGNETIC FIELD APPROX. 5 GAUSS. IT WILL MOVE THE BEAM BY ABOUT .05 OF AN INCH.
- b) -.01 .06" THICK WILL WEAKEN THE MAGNETIC FIELD APPROX. 10 GAUSS. IT WILL MOVE THE BEAM BY ABOUT .10 OF AN INCH.
- c) -.02 .12 THICK WILL WEAKEN THE MAGNETIC FIELD APPROX. 15 TO 20 GAUSS. IT WILL MOVE THE BEAM BY ABOUT .15 OF AN INCH.

NOTE: ALL SHUNTS ARE NICKEL PLATED AND OF LOW CARBON MATERIAL.

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DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± N/A ANGULAR: MACH ± BEND ± .5° ONE PLACE DECIMAL ± .1 TWO PLACE DECIMAL ± .01 THREE PLACE DECIMAL ± .005 SURFACE FINISH 63 R.M.S.		FINISH:				DO NOT SCALE DRAWING	REVISION
DESIGN/ENG.		NAME				SIGNATURE	DATE
CHK'D						GEN. USE	
APPV'D							
MFG							
Q.A							
		MATERIAL:				DWG NO.	A3
		WEIGHT:				SCALE:1:1	SHEET 1 OF 1

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