

1. The tank must be clean and free of all foreign matter.
2. Inspect the gasket on the lid and the sealing surface on the container. The gasket must be free of all foreign matter to ensure a good vacuum seal.
3. Inspect the paddle assembly, it must be clean.
4. Put the required epoxy mix (as referenced in the traveler or vendor/requisitioner documentation) into the tank. (Minus DMP-30).
5. Put the cover on and tighten evenly.
6. Close the vent valve.
7. Attach the vacuum hose.
8. Turn on the liquid nitrogen supply or ensure that the dewar is full.
9. Start the vacuum pump and open the vacuum valve. The required vacuum is 100 microns or less (as referenced in the traveler or vendor/requisitioner documentation).
10. Turn on the mixing motor and mix for two (2) hours.
11. After mixing for two (2) hours, turn off the mixing motor, close the vacuum valve, and open the vent valve.
12. When the vacuum is released, add DMP-30 through the opening in the cover of the tank. Replace the cover.
13. Close the vent valve, open the vacuum valve and allow the tank to pump to 100 microns or less (as referenced in the traveler or vendor/requisitioner documentation).
14. When the vacuum reaches desired level, start the mixing motor and mix for one (1) hour.
15. Upon the completion of the mixing, close the vacuum valve and disconnect the vacuum line. Turn off the liquid nitrogen. Shut off the vacuum pump, shut off the mixing motor.

REV.	DESCRIPTION	DRAWN	DATE
		APPD.	DATE

UNLESS OTHERWISE SPECIFIED			ORIGINATOR	W. ZIMMERMAN	8/8/94
FRACTIONS	DECIMALS	ANGLES	DRAWN	J. LANGE	6/28/96
*	*	*	CHECKED	<i>[Signature]</i>	7/22/96
1. BREAK ALL SHARP EDGES 1/64 MAX. 2. DONOT SCALE DWG. 3. DIMENSIONING IN ACCORD WITH ANSI Y14.5STD's.			APPROVED	<i>[Signature]</i>	7/27/96
			USED ON	N/A	
<input checked="" type="checkbox"/> MAX. ALL MACHINED SURFACES			MATERIAL-	N/A	
 FERMI NATIONAL ACCELERATOR LABORATORY U.S. DEPARTMENT OF ENERGY					
EPOXY MIXING TANK OPERATING PROCEDURE					
SCALE	FILMED	DRAWING NUMBER		Page	REV.
N/A		5525-OP-318882		1 of 2	

16. Relocate the tank to the large vacuum oven and attach the hoses as required for the device to be potted.
17. Pot the device as outlined in the appropriate traveler or vendor/requisitioner documentation.
18. Remove the hoses and return the tank to the epoxy room.
19. Remove the cover and clean the tank, cover, and the mixing paddle for next use.

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 FERMI NATIONAL ACCELERATOR LABORATORY U.S. DEPARTMENT OF ENERGY			MATERIAL-	N/A	
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N/A		5525-OP-318882	2 of 2		