Ion Pump Connector Kit Assembly Instructions

B-100-X (Bakeable)

(revised October, 2007)

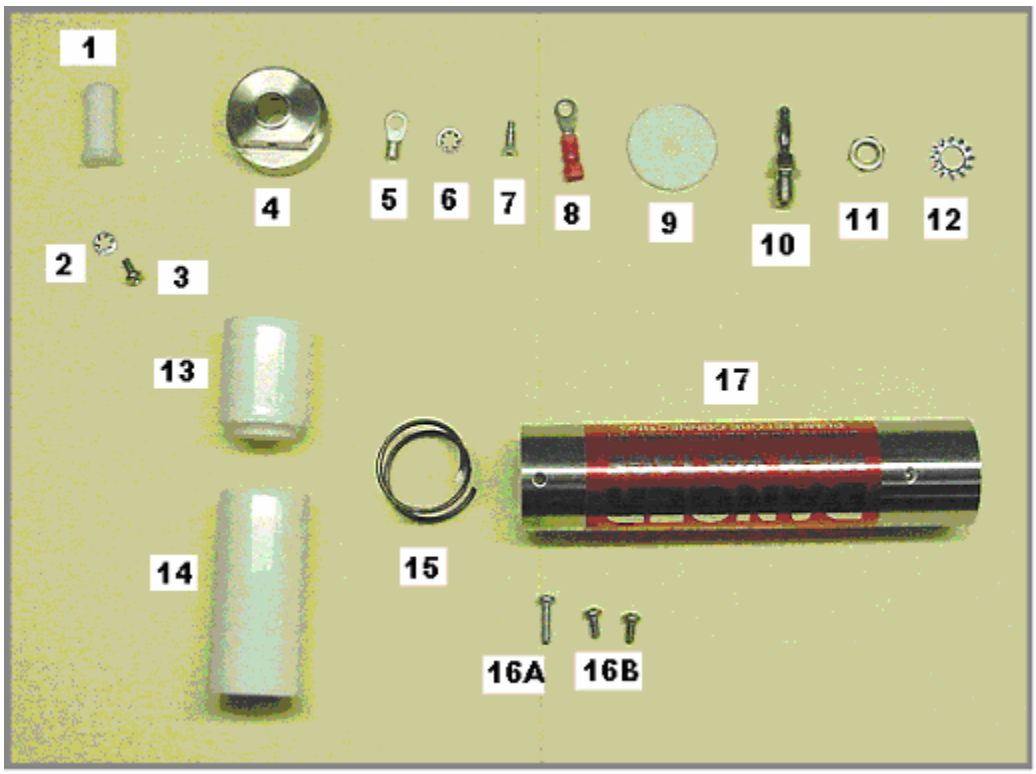

Figure 1 - Parts List

1 – PEEK Bushing – 0.195 ID
2 - Star Washer – Ground Lug
3 - Screw – Ground Lug
4 - Adaptor Plug
5 - Ground Lug
6 - HV Washer
7 - HV Screw
8 - HV Lug
9 - Tefzel® Washer
10 - HV Banana Plug
11 - HV Banana Nut
12 - HV Banana Star Washer
13 - Ceramic - Small
14 - Ceramic - Large
15 - Spring
16A – Long Screw - Shell
16B – Short Screws (2) - Shell
17 - SST Shell

Assembly Instructions:

1. Put the small diameter end of the PEEK Bushing (1) into the hole in the center of the large diameter end of Adaptor Plug (4) (See Figure 4 for relationship.)
2. Thread the Shielded High Voltage Cable (Not included in Kit) through the larger diameter end of the PEEK Bushing (1). Leave 8-10 inches of cable exposed for working room.
3. Prepare the cable end as shown in Figure 2, so as to have a separate braided grounding wire approximately 1-1/4" long and a high voltage wire with 1" of insulation and 1/4" of conductor.
4. Crimp the #4 Ground Lug (5) onto the end of the braided grounding wire.

Figure 2 – HV Cable Prep Through Step 4

5. Install the 1" Tefzel washer (9) over the insulated portion of the high voltage wire.
6. Remove the red insulating coating on the #6 Spade Lug (8) and crimp it onto the end of the high voltage wire. Bend the Spade lug 90 degrees away from the high voltage wire where the flat part meets the crimped portion.

Figure 3 – HV Cable Prep Through Step 6

7. Install the Spring (15) over the High Voltage Wire between the Tefzel Washer (9) and the braided grounding wire.
8. Using the #4-40 Screw-Ground Lug (3) and #4 Star Washer – Ground Lug (2), fasten the Stud Lug for Ground Braid to the only threaded hole on the flattened portion of the Adaptor (4). Bend the crimped end of the Lug (5) inward toward the center cable..

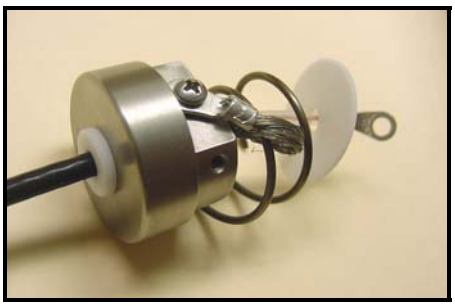

Figure 4 – Cable Assembly Through Step 8

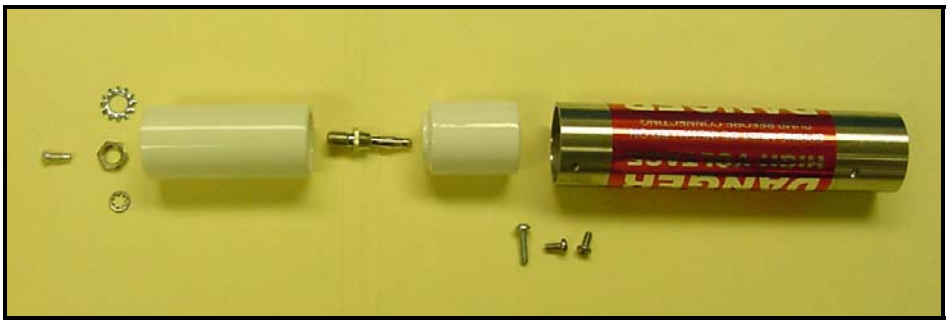

Figure 5 – Cable Assembly and Parts Ready to Start Step 9

9. Install the Banana Plug (10) into the Large Ceramic Insulator (14) using the Nut (11) and. Large X-Lock Washer (12)
10. Attach the #6 Lug for HV Wire (8) to the Banana Plug (10) with the Hex Head #6-32 Screw for HV Wire Lug (7) and the #6 Star Washer (6).
11. Insert the Small Ceramic Insulator (13), large ID portion first, into the SST Shell (17) through the end with the three holes.
12. Insert the assembled High Voltage Cable with Large Ceramic Insulator (14) into the SST Shell (17), being sure that the three threaded holes on the OD of the Adaptor Plug (4) line up with the three holes in the SST Shell (17)..
13. Compressing the Spring (15), press the HV Cable Assembly into the SST Shell (17), line up the three holes in the SST Shell (17) and the Adaptor Plug (4), and install the three remaining #4-40 Screws (16A and 16B).

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