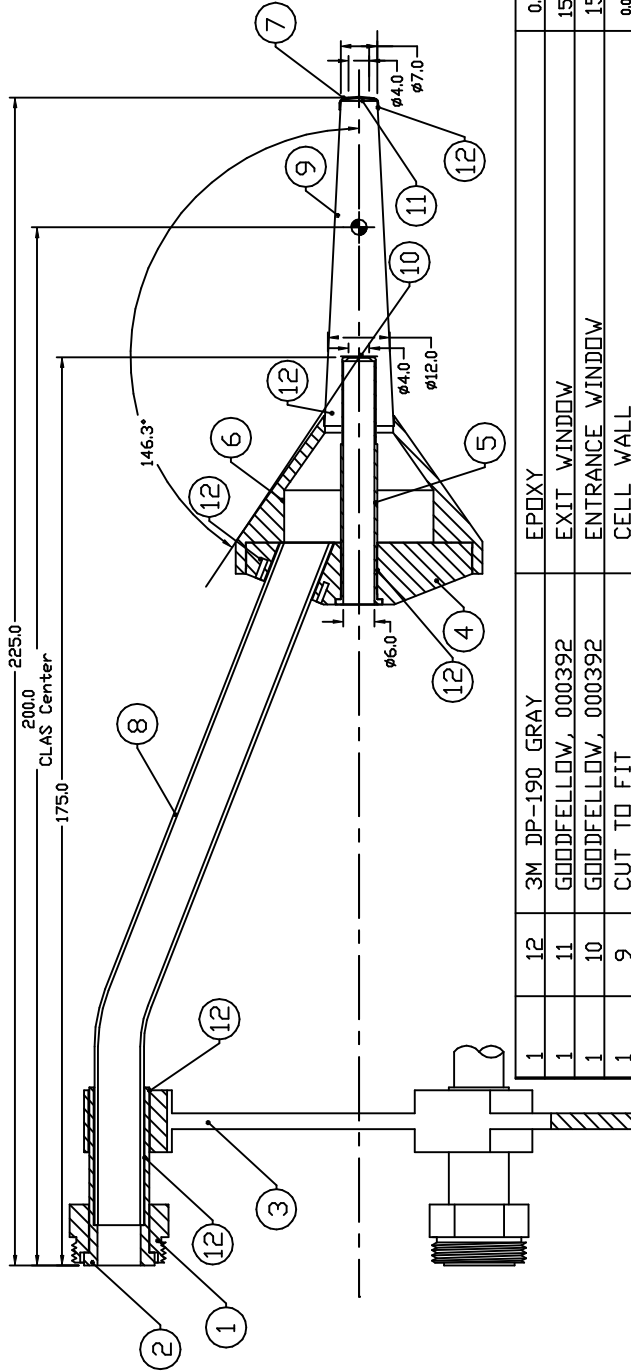


REVISIONS

REV.	DESCRIPTION	DATE	APPROVED
A	Enlarged base of cell wall and narrow end of base tube to allow gas bubbles to escape easier.	1/14/02	DHK



TOTAL TARGET ASSEMBLY VOLUME =  
35.46 CU. CM.

ITEM NO.	QTY REQD	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	NOTES/MATERIAL SPECIFICATION
1	12	3M DP-190 GRAY	EPOXY	0.001-0.005" FILM ON ALL CONTACT SURFACES
1	11	GOODFELLOW, 000392	EXIT WINDOW	15um AL, 99.0% x 7mm dia. Glue to inside of item 7.
1	10	GOODFELLOW, 000392	ENTRANCE WINDOW	15um AL, 99.0% x 7mm dia.
1	9	CUT TO FIT	CELL WALL	0.001" KAPTON FILM, FORM USING TOOLING 66850-A-03507 AND 03511
3	8	66850-A-03512	DISTRIBUTION TUBE	
1	7	66850-A-03513	CELL END CAP	
1	6	66850-A-03510 rev. A	BASE CONE	
1	5	66850-A-03509	BASE TUBE	
1	4	66850-A-03508	BASE RING	
1	3	66850-A-03322	GAS MANIFOLD SUPPORT RING	
3	2	66850-A-02984	GLAND	
3	1	66850-A-02984	CONDENSER CONNECTING NUT	

PARTS LIST

DIM & TOL PER ANSI Y14.5 UNLESS OTHERWISE SPECIFIED. DIMENSIONS ARE IN MM TOLERANCES ARE:		CADD I.D. NO. christo\id: \ACAD DRAWINGS\dwg\ tar_e6a_final.dwg	
±	.X ±	APPROVALS	DATE
.XX ±	° ±	DRAWN s. christo	12/3/01
MATERIAL		CHECKED DHK	12/6/01
FINISH <input checked="" type="checkbox"/> UNLESS OTHERWISE NOTED		APPROVED/ORIGINATOR s. christo	12/6/01
DEBURR & BREAK ALL SHARP EDGES		APPROVED DHK	12/6/01
DO NOT SCALE DRAWING		SCALE 2:3 USED ON ASSY NO. 66840-E-03521	

*Jefferson Lab*  
Thomas Jefferson National Accelerator Facility  
NEWPORT NEWS, VIRGINIA  
UNITED STATES DEPARTMENT OF ENERGY

e6a TARGET CELL ASSEMBLY

REV.	A
DWG. NO.	66850-A-03506
SIZE	A
SHEET	1 OF 3

Notes

- Clean all surfaces with acetone before sanding. Wet sand metal surfaces (except for the windows) with epoxy and 320 grit paper before gluein. Sand polymer surfaces with 320 grit paper before glueing. Clean all polymer surfaces with acetone after sanding.
- Align the seam of the cell wall with the center of the top leg.
- Use cell centering fixtures, as shown on Shts. 2 & 3 of this drawing to keep cell wall centered during assembly.