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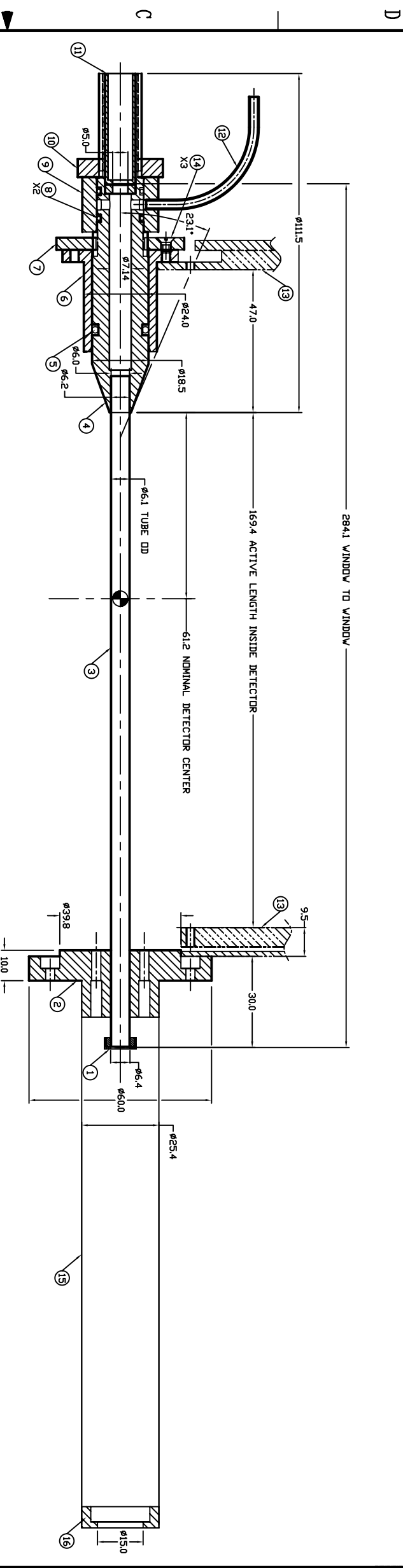
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DWG. NO.		REV. A		DATE		APPROVED	
ZONE	REV.	DESCRIPTION	DATE	APPROVED	DATE	APPROVED	DATE
C2	A	CHANGED EXIT WINDOW ASSY FOR 15 MICRON WINDOW. CORRECTED DETECTOR ENDPATE-ENDPATE DISTANCE.	9/19/05				



- NOTES:
- 1) ALL GLUE JOINTS ARE TO BE MADE WITH 3-M DP-190 EPOXY. SAND ALL NON-METALIC SURFACES WITH 320 GRIT PAPER. WET SAND ALL METALIC GLUE FACES WITH EPOXY USING 320 GRIT PAPER EXCEPT FOR THE END CAP AND WINDOW.
 - 2) ORDER OF ASSEMBLY:
 - A) GLUE ITEM 6 TO UPSTREAM DETECTOR ENDPATE.
 - B) GLUE ASSEMBLY ITEM 11 TO ITEM 4.
 - C) ASSEMBLE ITEMS 1, 2, 3, AND 4.
 - D) ASSEMBLE O-RINGS, ITEMS 5 & 8 ON ITEM 4.
 - E) APPLY VACUUM GREASE TO DETECTOR MATING SURFACE OF ITEM 4.
 - F) THREAD ASSEMBLY THROUGH DETECTOR FROM UPSTREAM END. IT MAY BE NECESSARY TO DO THIS HORIZONTALLY, IN WHICH CASE YOU WOULD USE A INSERTION TOOL 4314 TO GUIDE IT THROUGH.
 - G) THREAD ON TENSIONING NUT TILL IT TOUCHES ITEM 6.
 - H) SECURE ITEM 2 TO DETECTOR ENDPATE USING 4, 4-40 X1/2 SCREWS.
 - I) INSTALL ITEM 14S THROUGH THE SLOTS IN THE TENSIONING NUT AND INTO THREE OF THE THREADED HOLES IN ITEM 6 TO PREVENT FURTHER ROTATION OF THE NUT.
 - J) WELD ITEMS 9 AND 12 AND INSTALL ON ITEM 4 THEN SECURE WITH ITEM 10.
 - K) GLUE ITEM 15 TO ITEM 16.
 - L) TAPE ITEM 15 TO ITEM 2 TO MAKE GAS TIGHT SEAL.

QTY	ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	NOTES/MATERIAL SPECIFICATION
1	16	66850-A-04377	HELIUM WINDOW ASSEMBLY	STAINLESS STEEL
1	15	66850-A-04375	HELIUM TUBE	SHOWN FOR REFERENCE ONLY
3	14		M3 X 0.5 X 5 LONG FLAT HEAD SCREW	STAINLESS STEEL
1	13	66850-A-04169	BONUS DETECTOR ENDPATES	SHOWN FOR REFERENCE ONLY
1	12	66850-A-04311	GAS INLET TUBE	
1	11	66850-A-04372	BOM ADAPTER/ENTRANCE WINDOW ASSEMBLY	
1	10	66850-A-04307	GAS COLLAR	
1	9	66850-A-04306	GAS COLLAR	
2	8	PARKER # 2-014	ETHYLENE PROPYLENE E540-80 O-RING	1/2" ID X 5/8" OD X 1/16" THICK
1	7	66850-A-04305	TENSIONING NUT	
1	6	66850-A-04304	TARGET - DETECTOR FLANGE	
1	5	PARKER # 2-113	ETHYLENE PROPYLENE E540-80 O-RING	9/16" ID X 3/4" OD X 3/32" THICK
1	4	66850-A-04371	BASE	
1	3	66850-A-04370	CELL WALL	
1	2	66850-A-04369	DOWNSTREAM ENDPATE	
1	1	66850-A-04388	15 UM X 6.35 MM EXIT WINDOW ASSEMBLY	

UNLESS OTHERWISE NOTED DIMENSIONS ARE IN MILLIMETERS TOLERANCES ARE: DECIMAL ANGLES .XX ± .1

FINISH UNLESS OTHERWISE NOTED

DEBUR & BREAK ALL SHARP EDGES

DO NOT SCALE DRAWING

APPROVALS	DATE	APPROVALS	DATE
DRAWN s. christo	7/20/05	CHECKED DHK	8/1/05
APPROVED/ORIGINATOR DHK	8/1/05	APPROVED DHK	8/1/05

CLAS
BONUS 6 mm DIA. TARGET ASSEMBLY

Thomas Jefferson National Accelerator Facility
UNITED STATES DEPARTMENT OF ENERGY

SCALE: 1:1

DWG. NO. 66850-C-04367

REV. A

SHEET 1 OF 1