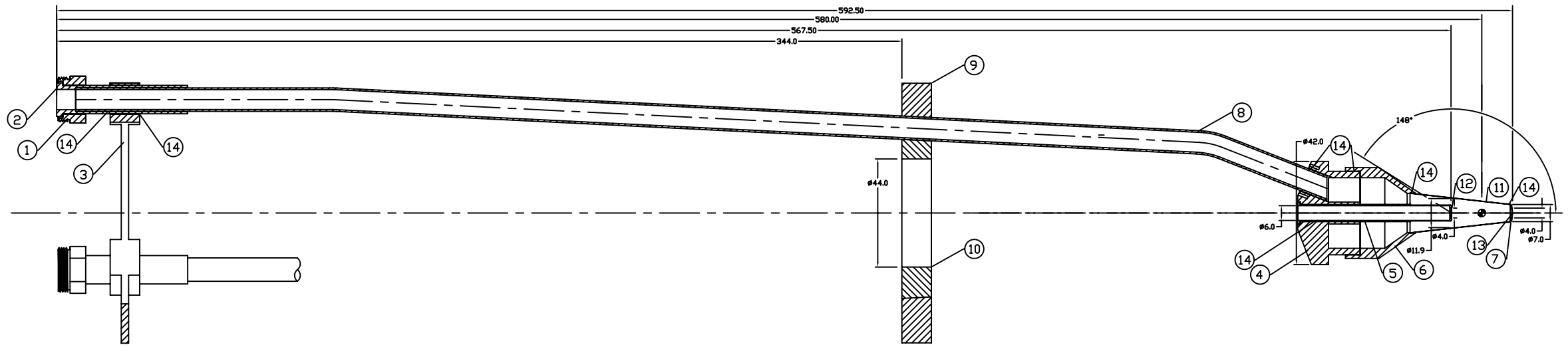
DWG. NO.	66850-D-04250	SHT. 1	REV. —

REVISIONS

ZONE	REV.	DESCRIPTION	DATE	APPROVED



TOTAL TARGET ASSEMBLY VOLUME=

101.7 CU. CM.

Notes

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

PARTS LIST

QTY PER DRAW	ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	NOTES/ MATERIAL SPECIFICATION
1	14	3M DP-190 GRAY	EPOXY	0.001-0.005" FILM ON ALL CONTACT SURFACES
1	13	GOODFELLOW, 000392	EXIT WINDOW	15um Al, 99.0% x 7mm dia. Glue to inside of Item 7.
1	12	GOODFELLOW, 000392	ENTRANCE WINDOW	15um Al, 99.0% x 7mm dia. Glue to end of Item 5.
1	11	CUT TO FIT	CELL WALL	0.005" KAPTON FILM. FORM USING TOOLING 66850-A-04252 AND 04253
1	10	66850-A-04256	INNER CENTERING RING	
1	9	66850-A-04255	OUTER CENTERING RING	
3	8	66850-D-04257	DISTRIBUTION TUBE	
1	7	66850-A-03513	CELL END CAP	
1	6	66850-A-03730	BASE CONE	
1	5	66850-A-03729	BASE TUBE	
1	4	66850-A-03728	BASE RING	
1	3	66850-A-03322	GAS MANIFOLD SUPPORT RING	
3	2	66850-A-03259, rev A	GLAND	
3	1	66850-A-03259, rev A	CONDENSER CONNECTING NUT	

DIM & TOL PER ANSI Y14.5. UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MM
TOLERANCES ARE:
FRACTIONS ± DECIMAL .X ± .XX ± ANGLES ±

MATERIAL

FINISH XXX UNLESS OTHERWISE NOTED

DEBURR & BREAK ALL SHARP EDGES

DO NOT SCALE DRAWING

CADD I.D. NO.
christo\\c:\ACAD DRAWINGS\dwg1\tar_dvcs_final.dwg

APPROVALS	DATE
DRAWN s. christo	12/21/04
CHECKED DHK	12/22/04
APPROVED/ORIGINATOR s. christo	12/22/04
APPROVED DHK	12/22/04

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

CLAS CRYOTARGET DVCS TARGET CELL ASSEMBLY

SIZE	DWG. NO.	REV.
D	66850-D-04250	—

SCALE 1:1 | USED ON ASSY NO. 66840-E-04248 | SHEET 1 OF 3