



- Notes cont.
- Pre-assemble items 7,11&13 (see assembly notes, sht1) using DP-190. Allow to cure.
 - Assemble items 15,16,4,17&6 in that order without adhesive.
 - Apply DP-190 to both surfaces of interface between subassembly from Note 4 and item 6. Slip items from Note 4 over item 17 till cell wall is seated. If its determined that the cell wall does not maintain its roundness and does not contact item 6 around its circumference, then a small band or retainer made from 0.003" thick Kapton may be used on the top ID of item 6 to keep the cell wall in place. Allow adhesive to cure.
 - Disassemble the parts that are not glued together.
- continue on Sheet 3.

ITEM NO.	ITEM	QTY	UNIT	DESCRIPTION
1	66850-A-04768			CONE CENTERING FIXTURE
1	66850-D-04761			TARGET CENTERING FIXTURE
1	66850-A-03820			TARGET FIXTURE BASE
1	15			NON-SCALE PART
1	17			NON-SCALE PART

QTY & TOR REQ ANSI Y14.5
 DIMENSIONS ARE IN MM
 UNLESS OTHERWISE SPECIFIED
 FRACTIONS DECIMAL ANGLES
 .XX ±
 .X ±
 ±

CADD I.D. NO.
 christo\c:\A040 DRAWINGS\dmg1\
 for_dvcs_lind\dmg

APPROVALS
 DRAWN s. christo
 CHECKED
 APPROVED/ORIGINATOR
 APPROVED

DATE 6/2/08

FINISH XXX ✓ INTERSECT NOTED
 DEBurr & BREAK ALL SHARP EDGES

DO NOT SCALE DRAWING

Thomas Jefferson
 National Accelerator Facility
 CLAS CRYOTARGET
 e1-DVCS-b TARGET CELL
 ASSEMBLY

SIZE DWG. NO. 66850-D-04768
 SCALE 1:1 (SD) (N ASSY NO. 66840-E-04772) SHEET 2 OF 3