Water Target Assembly Traveler

[ Central / Upstream ] Target Super-PØDule Layer # _________________

Date ____________________________________________________________

Assembly Team (1 Leader & at least four members)

Team Leader __________________________

Team Member _______________________ Team Member ___________________

Team Member _______________________ Team Member ___________________

Team Member _______________________ Team Member ___________________

Installed Components

PØDule Number __________________________

LI Holder ______________________________

Water Target Bag Number: LI Side: __________ MPPC Side: __________

Notes:
Assembly Procedure

Inspected By: (Initials and Time)

1. Checkout PØDule dressing and assembly travelers for assembly status
2. Remove PØDule from stand. Note the PØDule number above.
3. Remove black plastic strip holding MPPC cables and bundle MPPC cables safely out of way.
4. Clean PØDule with alcohol.
5. Install correct LI LED holder. See list on north wall. Note the LI holder number above.
6. Clean bushing holes with countersink and razor blade to remove excess glue.
7. Apply double sided tape (2”) to top of PØDule 35mm from top (inside of holes). Verify that bushing holes are not blocked.
8. Apply double sided tape (2”) to sides starting 30 cm from top (near bushing hole).
9. Place brass radiators onto the PØDule. Align with knitting needles.
10. Tape brass together with 1” kapton tape after cleaning with alcohol.
11. Fix radiator onto PØDule with sticky tape:
   a) Make sure there are at least four (4) knitting needles in bottom of brass.
   b) Put spacer under top of brass.
   c) Remove backing from double sided tape on one side and lower radiator onto tape.
   d) Remove backing from double sided tape on other side and lower onto tape.
   e) Remove backing from top double sided tape and remove spacer to lower radiator onto tape.
   f) Verify bushing hole alignment and then roll down tape with wall paper roller.
12. Scribe line on brass to align water gasket using gasket alignment gauge. Apply gasket to brass. Do not press down.
13. Clean water target frames.
14. Install plugs in outer most drain holes (total of 2 plugs) of water target frames.

15. Test fit water target:
   a) Place frames and install central divider on brass. Pin down the frames using knitting needles.
   b) Install 5/16-18 by 1” screw into central divider.
   c) Get two target bags from box. Be very careful since creasing the material will cause leaks. This requires two people.
   d) Place water target bags onto brass. Make sure bags are on correct side by verifying clearance of bushing holes.
   e) Install 1/4-20 by 3” bag holder screws into bottom of target bags.


17. Install water target:
   a) Roll down gasket onto brass.
   b) Apply RTV to frame joints and remove excess from holes. Place frame onto brass.
   c) Apply double sided tape to central divider. Remove backing from tape. While holding tape off of brass, install 5/16-18 screw. Lay divider on brass and install knitting needle in top hole. Roll down tape.
   d) Install target bags. Make sure bags are on correct side by verifying clearance of bushing holes. Note bag numbers above.
   e) Install 1/4-20 by 3” bag holder screws into bottom of target bags.
   f) Install gasket into frame and roll down.
   g) Install safety masking tape to hold bag in place.

18. Install bushings: No bushings in corners. Seven bushings on each side and on the bottom. One bushing in the top center. **Note:** no bushings in the water bag headers.

19. Inspect cables on previous PØDule to make sure they are out of the way.

20. Install PØDule onto super-PØDule frame.
   a) Remove super-PØDule tensioning nuts.
   b) Bring PØDule to super-PØDule, then remove bottom clamps.
   c) Align PØDule with super-PØDule by hand. Push bottom.
against super-PØDule and lower.

d) Remove retaining bar.

e) Release cleats, remove top clamps and rock PØDule into super-PØDule.

f) Verify that water bags are in proper position.

g) Install retaining bar.

h) Remove strong back and place in PØDule rack.


_______ 22. Hammer bushings to the proper position using the “Bushing Insertion Tool”.

_______ 23. Install super-PØDule tensioning nuts. Apply sufficient tension to bring super-PØDule layers together. Corner of PØDule must be tight enough to apply pressure to the RTV.

_______ 24. Bundle cables on the PØDule to make sure that they are out of the way.

_______ 25. Inspect the installed PØDule, water target and radiator.

a) Verify that super-PØDule is secured to assembly cart.

b) Inspect spacing between assemblies (no gaps between components.

c) Verify the horizontal alignment of the layers.

d) Verify that water target bags are in proper position.

e) Verify that cables are properly bundled.

f) Verify that PØDule strong back is secured in PØDule stand (ready for next PØDule).