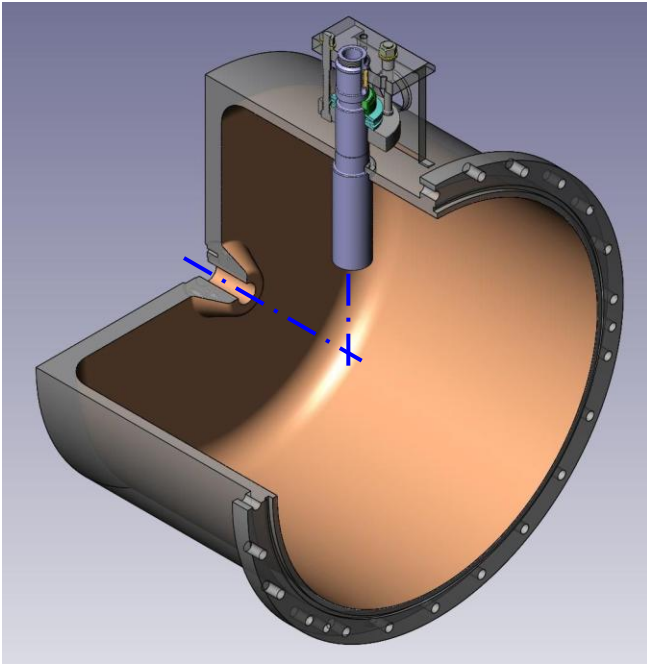




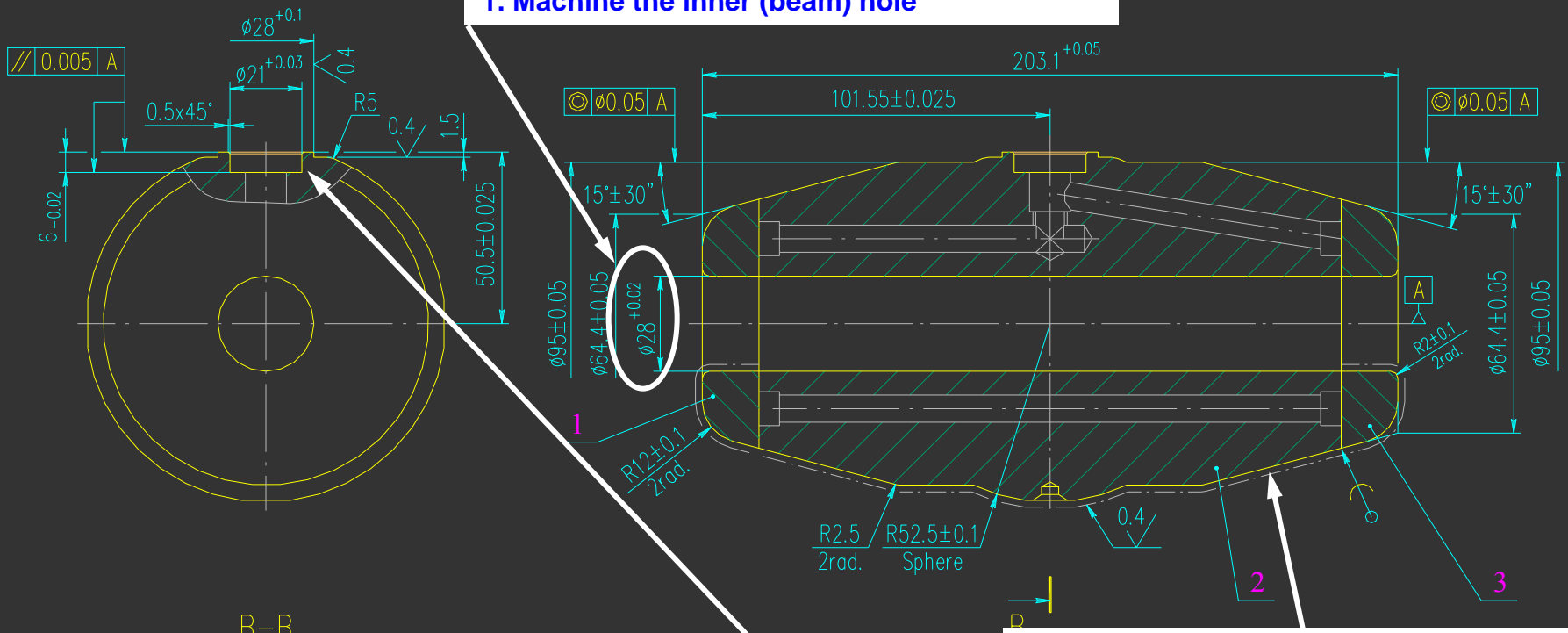
1. Check cavity dimensions on a CMM



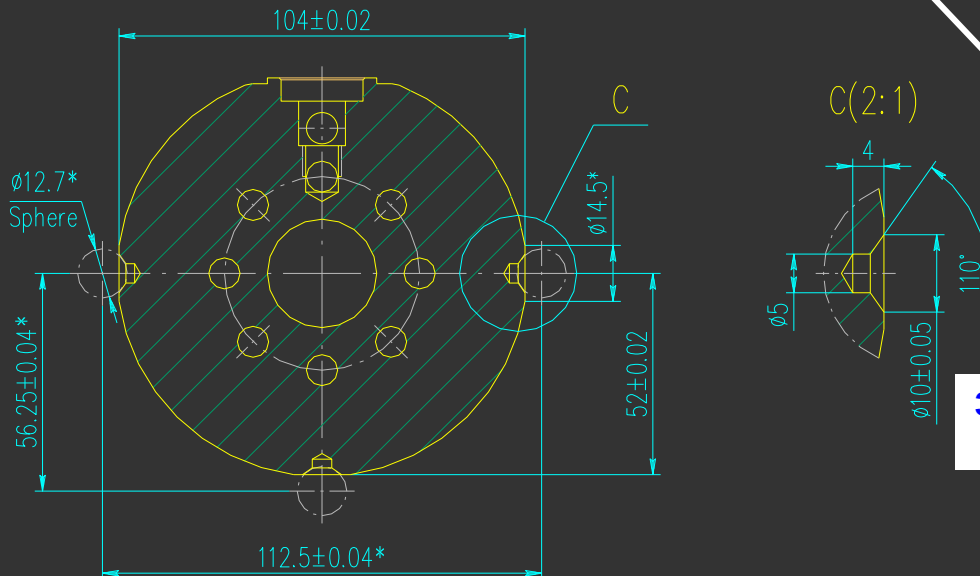
2. Assemble and measure each tank with a few sets of aluminum drift tubes, find correct final dimensions of copper drift tubes.

3. Do final machining of copper drift tube bodies. EB-weld suspension stems to the bodies.

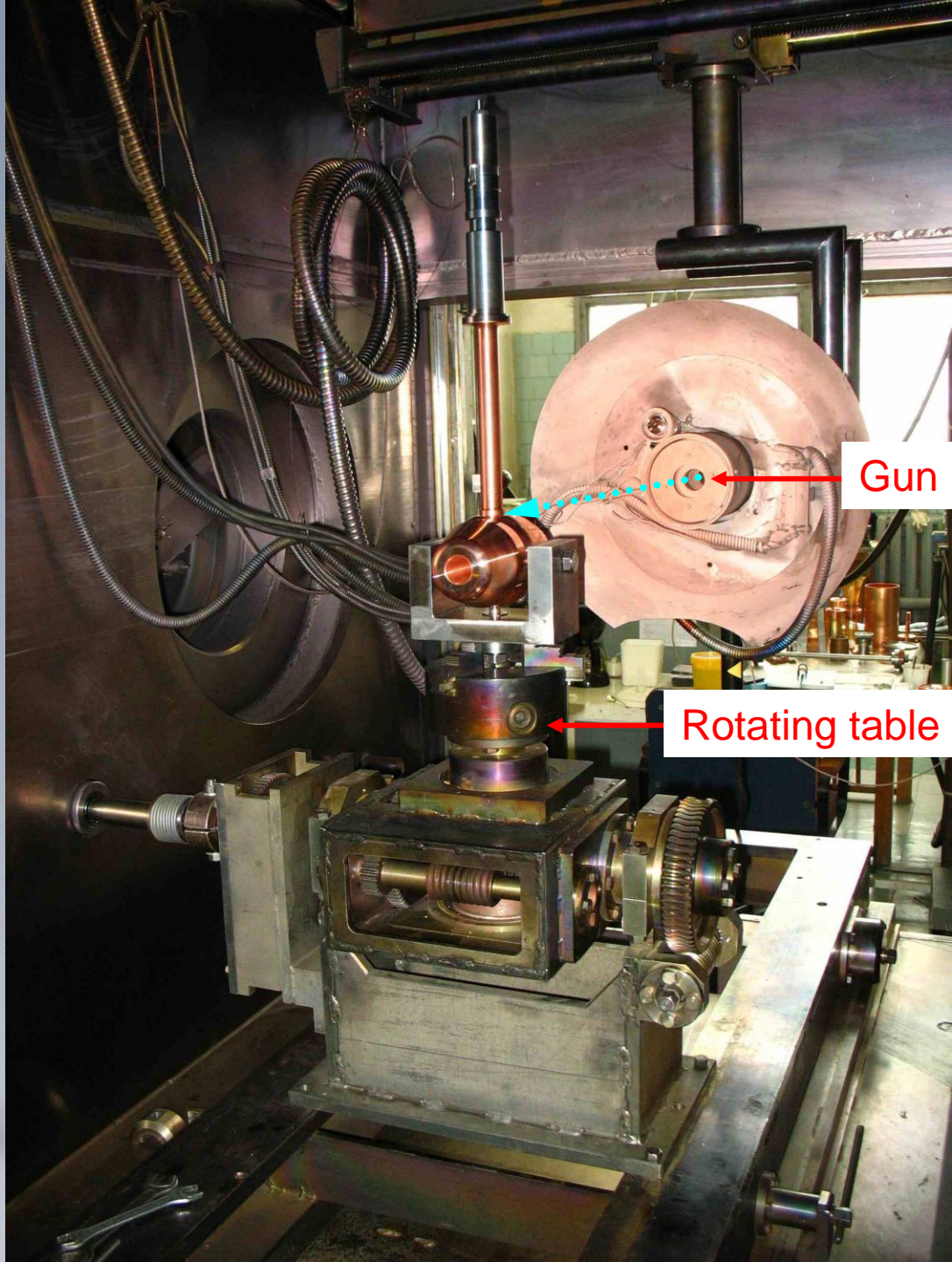
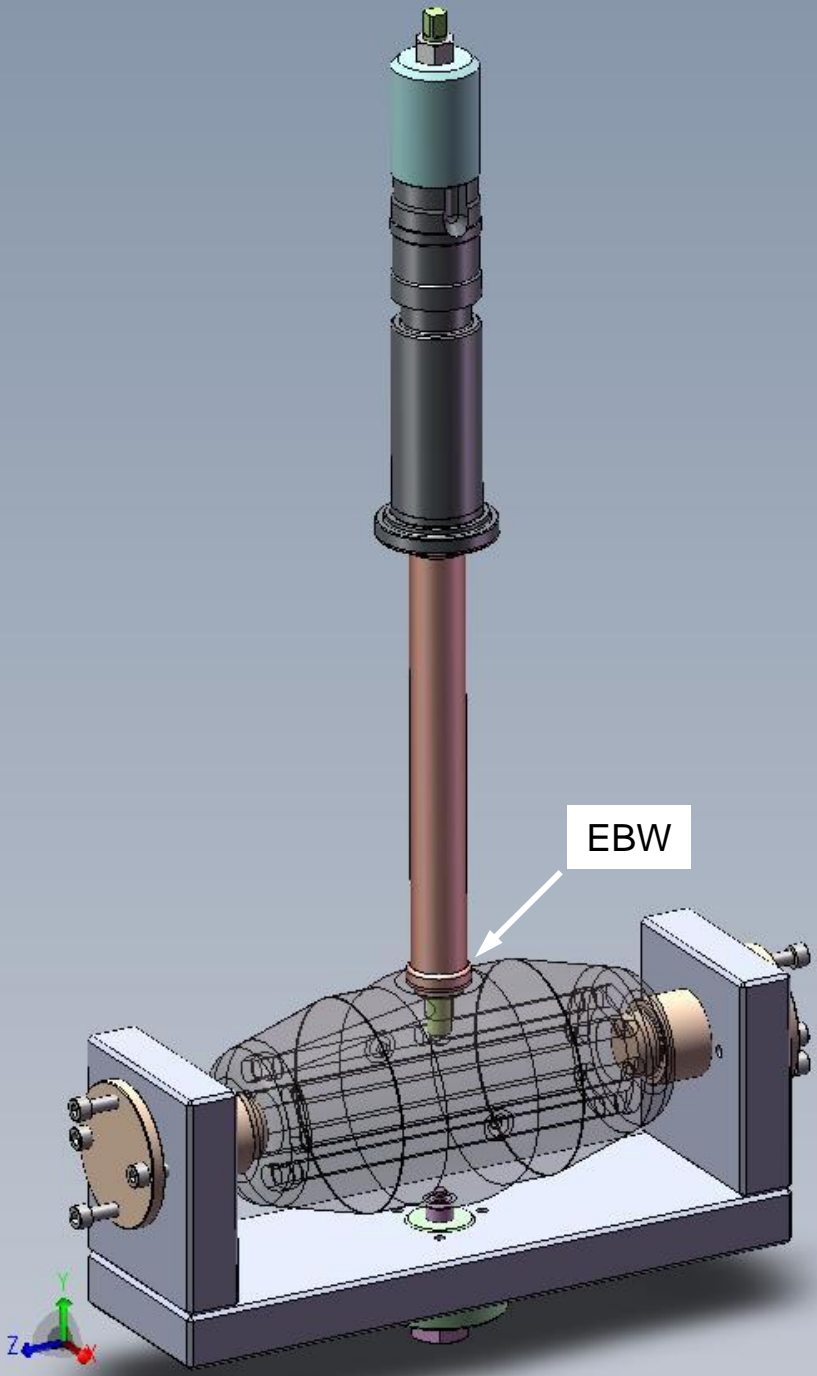
1. Machine the inner (beam) hole



2. Turn the entire outer contour in a continuous pass (without changing the assembly in the chuck)



3. Mill the laser tracker target holders and drift tube suspension connection interface on the same holder



- 3. Do final machining of copper drift tube bodies. EB-weld suspension stems to the bodies.***
- 4. Assemble and measure each tank with copper drift tubes (properly aligned), find correct final dimensions of fixed tuners.***
- 5. Do final machining of AC fixed tuners.***
- 6. While machining and welding drift tubes, measure coupling cells frequencies.***
- 7. Machine coupling cell shell to bring the frequency into the tuning range.***
- 8. Repeat coupling cell frequency measurements and find correct final dimensions of fixed tuners.***
- 9. Do final machining of CC fixed tuners.***
- 10. Assemble the entire module, check the tuning, measure field flatness, Q, find the right position of waveguide short.***
- 11. Assemble the module with Helicoflex gaskets, perform vacuum leak tests.***
- 12. Do 16 bar water tests, measure WFR for individual water cooling channels.***
- 13. Dismount drift tubes from cavities, prepare for shipment to CERN.***
- 14. Negotiate with ISTC for shipment (and Customs) arrangements.***

