



PIMS kick-off meeting

Questions on drawings and
machining aspects



Questions on drawings and machining aspects

- 10x 7-cell cavities + 2x 5-cell cavities or 12x 7-cell cavities?
- Missing set of drawings for cavity M and 1 drawing for cavity N
- Brazing on central discs?
- Which drawings are up to date: SPLACMBx or SPLACMZx?
- 3D models for each part (for CAM and metrology programming)



Questions on drawings and machining aspects

- Tolerances on outside diameter of discs and rings
($538 \pm 0,01$) – the tolerance is extremely tight and almost impossible to fulfill.
- Especially for rings, they might to deform under any pressure and the diameter can be measured only as a mean value (there is no tolerance for the cylindricity)



Questions on drawings and machining aspects

- Raw material: for all pieces + 10% spare for 2 pieces of each type of elements (discs and rings) as it is easier to purchase it in one delivery.



Questions on drawings and machining aspects

- Test accessories:
 - Calibrated bars for water channels testing – are there any requirements on their shape and tolerances?