



PIMS Construction Planning

Marcin Wojciechowski



Who is who

- IPJ-ZdAJ machining group (Marek Marczenko)
 - Machining (Michał Grabowski)
 - Metrology (Grzegorz Brzeziński)
 - Logistics
- CPL (Jan Litwiniuk)
 - Machining
- IPJ-ZdAJ assembly group (Michał Matusiak)
 - Cleaning
 - Leak tests (water and vacuum)
 - Brazing
- IPJ-PX (Marcin Wojciechowski)
 - X-ray tests



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- Machining tasks will be splitted in three parallel groups:
 - Rings
 - Disks
 - „Small” elements and tools
- Subcontracting model:
 - Discs and „small” parts machined and brazed by IPJ
 - Rings machined by CPL
 - Heat treatment and brazing of central ring in IPJ



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- Construction plan for the first cavity is prepared.
 - [Gantt chart: PIMS Cavity M](#)
 - Test are included in the plan (17th Jan 2011- 28th Jan 2011)
 - CAM programming and tooling delivery expected before 17th Jan 2011
 - Time assumed for EBW: 3 weeks including transport
 - Complete delivery to CERN expected after 20th Apr 2011



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- Parallel operations: once the main final machining is done, one element passes to next operation (cooling channels drilling, heat treatment etc.) and main machining of a next element begins



Cooling liquids specification

- Our standard metalworking fluid is Shell SITALA® D 201.03, water extended (ingredients below):

2. COMPOSITION/INFORMATION ON INGREDIENTS

Chemical Identity	CAS No.	Concentration
Triethanolamine	102-71-6	10.00 - 30.00 %
2-Aminoethanol	141-43-5	1.00 - 5.00 %

Highly refined mineral oils, water and additives.