

WP5.2

Few key production dates for 2025

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All dates given below are subject to the collimator's contractor respect of its own planning.

The last version of the planning is available here:
<https://edms.cern.ch/project/CERN-0000254481>

PRE SERIES JAWS MAIN ACTIVITIES	Start of activity and Completion date
TCSPM Jaw brazing	20/01 to 24/01
Thermal test on TCSPM jaws before block's assemblies	31/01
TCSPM Jaw metrology	7/02 to 10/02
Assembly of TCLPX + TCTPXV jaws	17/02 to 12/03
TCLPX + TCTPXV jaws metrology	3/03 to 14/03
TCLPX + TCTPXV + TCSPM thermal test	21/03 to 24 /03
Testing of Jaws at CERN Metrology UHV test	15/04 to 13/06

PRE-SERIES MECH. TABLES MAIN ACTIVITIES	Start of activity and Completion date
X series tables parts metrology reports approval from CERN	20/01 to 24/01
X series tables assemblies at CINEL	27/01 to 7/02
X series tables torque tests	10/02 to 14/02
TCSPM tables parts metrology reports approval from CERN	27/02 to 5/03
TCSPM tables assemblies at CINEL	6/03 to 19/03
TCSPM tables torque tests	20/03 to 26/03

PRE-SERIES COLLIMATORS MAIN ACTIVITIES AT CONTRACTOR	Start of activity and Completion date
EBW of bellows on shaft; EBW of cooling circuit cover and plots	6/02 to 25/02
5 faces VESSELS EBW followed by a leak test (not reported)	18/04 to 1/05
Metrology of the flange flatness and knife profile after welding of the two compensating bellows	15/05
EBW of edge welded bellows on Tank including the protections and their leak test	13/05 to 26/05
Leak test of tank	4/06 to 10/06
Tank complete metrology, including complete flange metrology flatness and profile of the knife)	11/06
Preliminary BPM tests and Pt100 continuity test before jaws insertion	23/06
Assembly of the jaws into the vacuum vessels and labelling of the BPM and PT100 flanges	24/06 to 26/06
Connection and verification of BPM & Pt100	27/06 to 2/07
Setting of hard stops, flatness and parallelism measurement of the jaw surfaces along mechanical stroke, measurement of BPM positions	2/07 to 4/07
Torque test monitoring RF contact behavior and BPM & Pt100 continuity during motion	14/07 to 16/07
VNA test of the BPM, two by two (tank cover assembled on the vacuum tank, not welded yet)	18/07
PT100 Electrical continuity test (tank cover assembled on the vacuum tank, not welded yet)	21/07
Pumping, leak test, torque test under vacuum	4/08 to 8/08
UHV test	8/08 to 3/09
Torque test + BPM test under vacuum	4/09 to 5/09
Shipment to CERN	24/09

Green light
for series
production

PRE-SERIES COLLIMATORS MAIN ACTIVITIES AT CERN	Start of activity and Completion date
Reception tests	To be scheduled as of 24/09
Torque test	
Assembly with <i>berceau</i> and jackets	
Assembly with vacuum tools	
BPM tests	
Impedance test	
UHV test, torque test	
Assembly with alignment sensors, fiducialisation	
...	

Exact list of activities to be terminated by S1 2025