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Production of the End Cap sub-structures for the CMS Tracker

The poster will explain the production of the 292 petals needed to build both CMS Tracker End Caps (TECs). There will be first a description of the petal itself integrating many components, the main ones being the silicon modules. The organisation of the production involving 7 Institutes all over Europe will then be explained. The assembly and testing of the petals will be detailed next. The production rates that have been achieved will be explained, clearly driven by the logistic aspects. The quality assurance strategy will be detailed next, resulting in a very high petal quality. Some overall plots will be shown like the module leakage currents, the noise flatness, the number of flagged channels, the silicon temperature in cold, together with some "strip" histograms (pedestal, risetime, noise). Finally some details about part failures will be given. The conclusion will state that 292 petals have been built and are of excellent quality. They have been delivered to the End Caps Integration Centres in time and behave well after integration.

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