



MQYY E-modulus press Status report

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927 – 18 December 2018



Outline

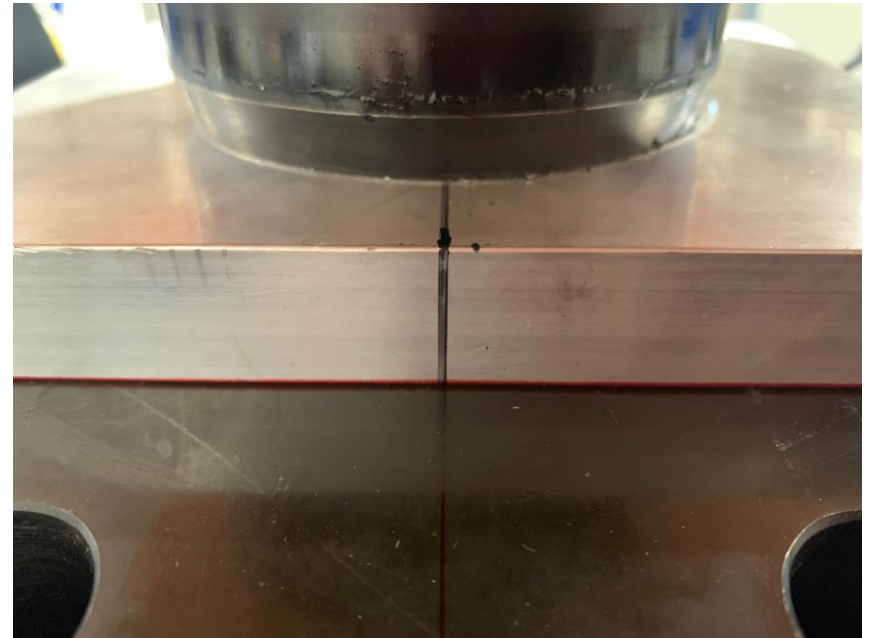
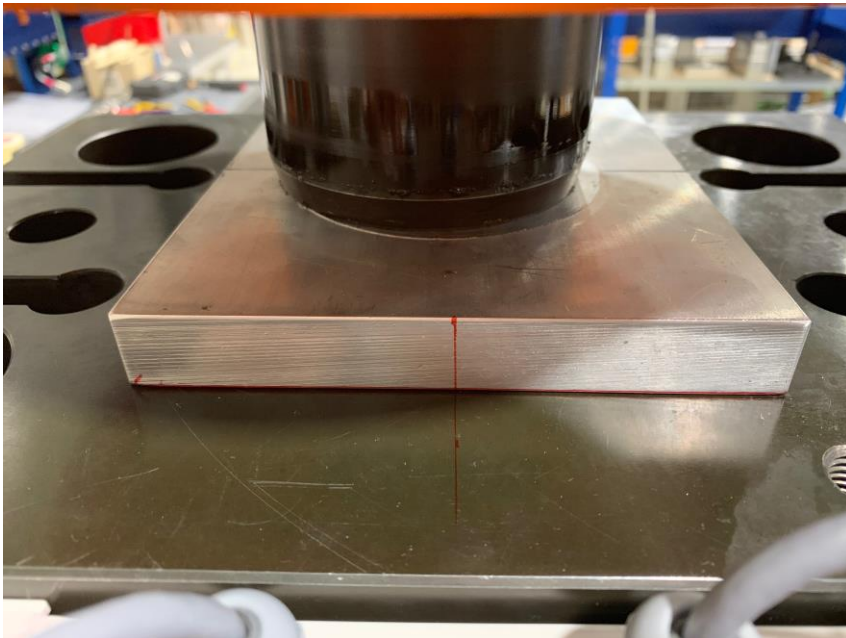
1. Centering of the tooling
2. Shimming of the bars
3. Troubleshooting
4. Conclusions

Outline

- 1. Centering of the tooling**
2. Shimming of the pusher
3. Troubleshooting
4. Conclusions

Centering of the tooling

Centering of the pressure plate

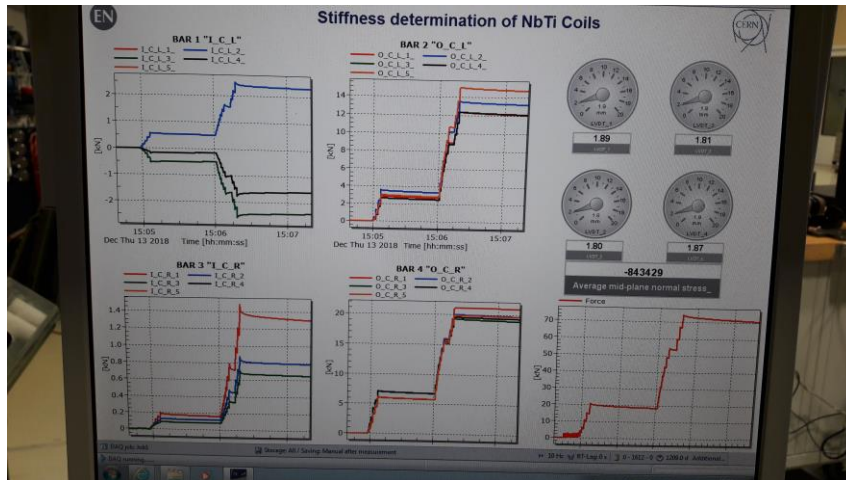


Centering of the tooling

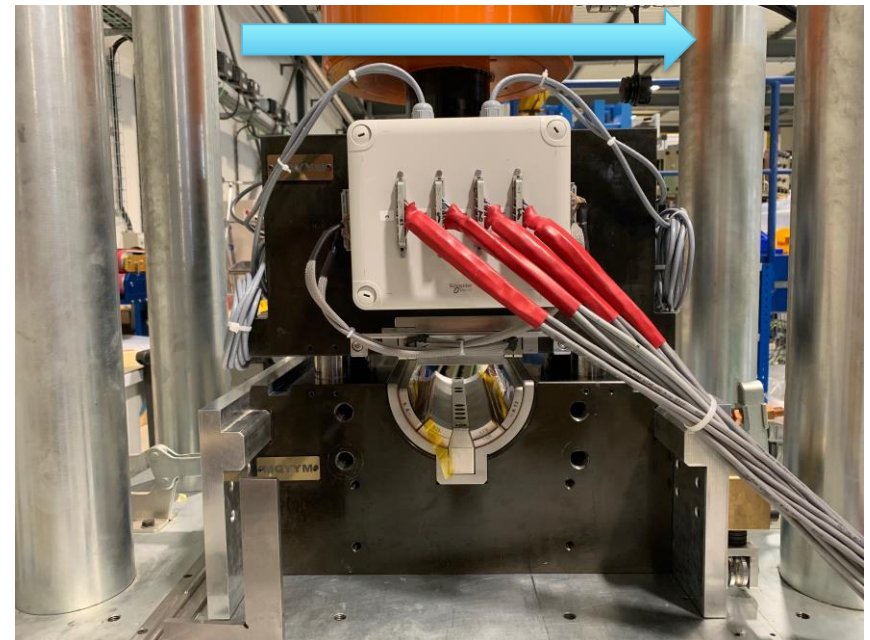
Centering of the main tooling

Thursday 13 December 2018

$$\frac{\text{Outer_Right}}{\text{Outer_Left}} = 1.5$$



Inner bars barely in contact



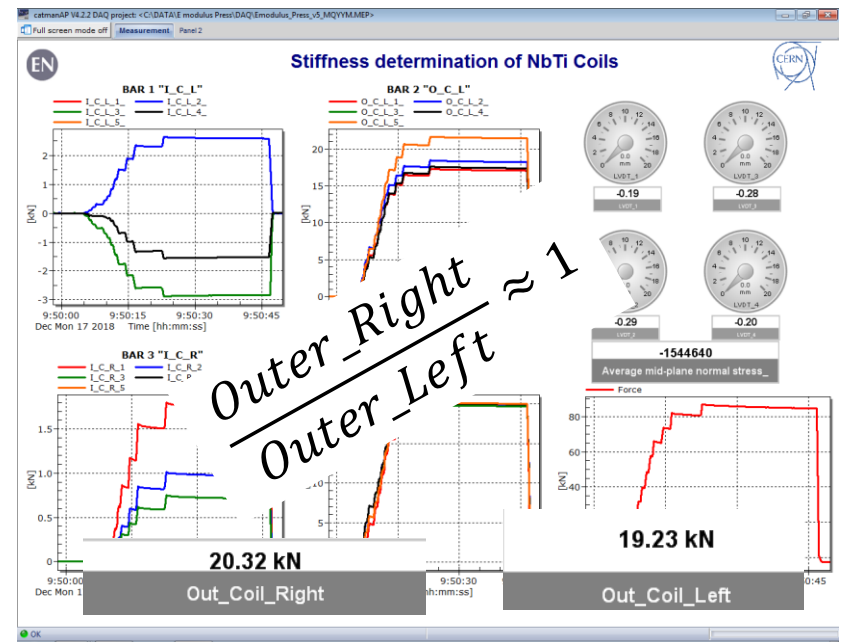
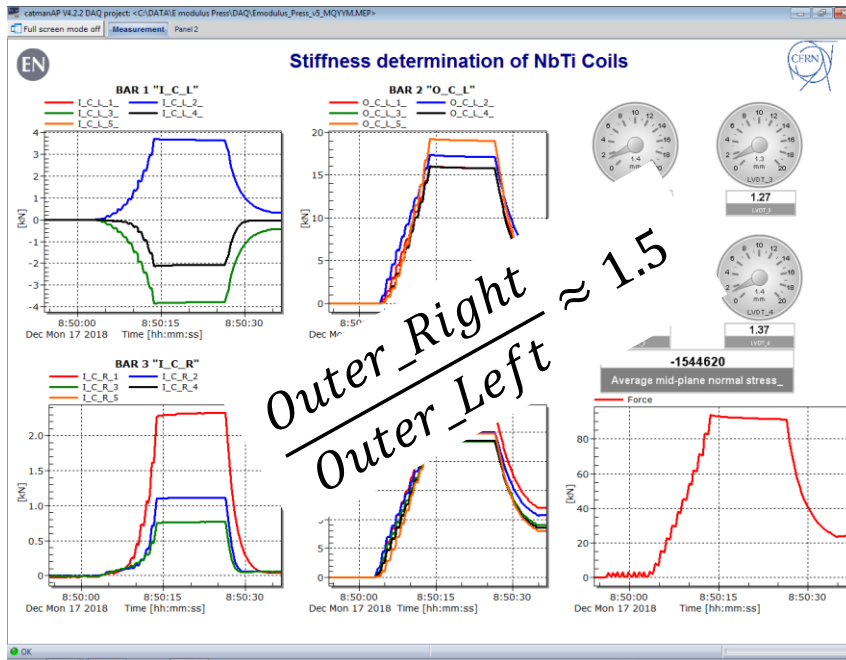
Stainless steel sectors

Centering of the tooling

Centering of the main tooling

Monday 18 December 2018
Iteration 1

Monday 18 December 2018
Iteration 2



Inner bars barely in contact

Stainless steel sectors

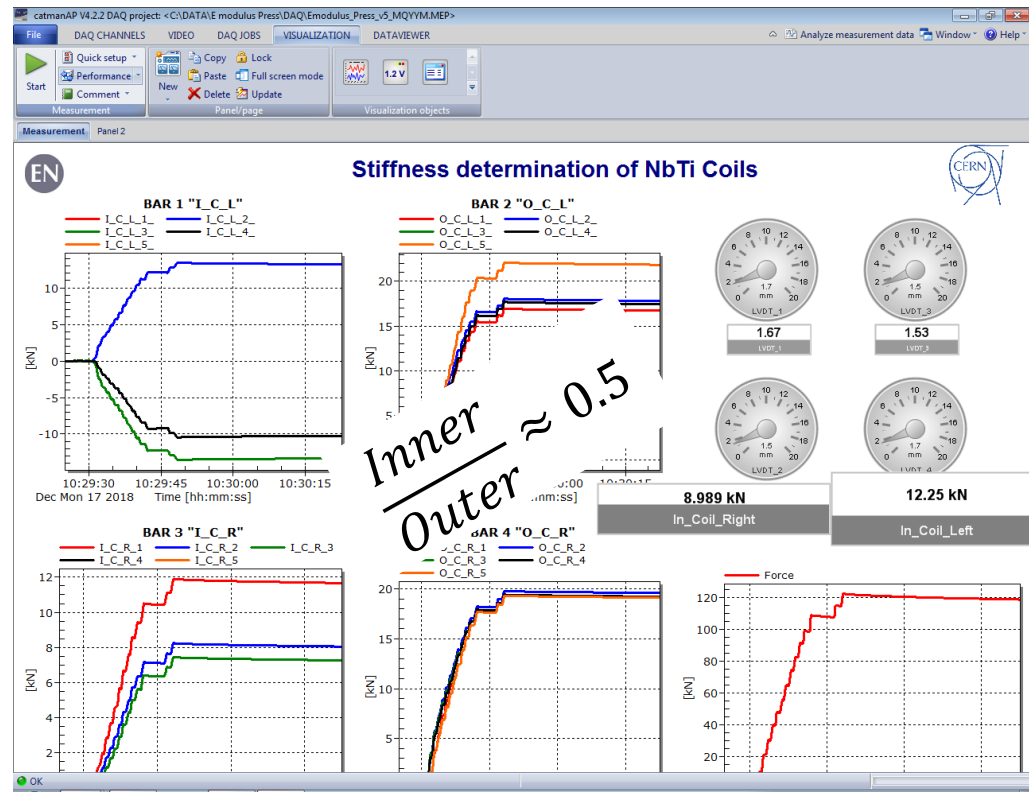
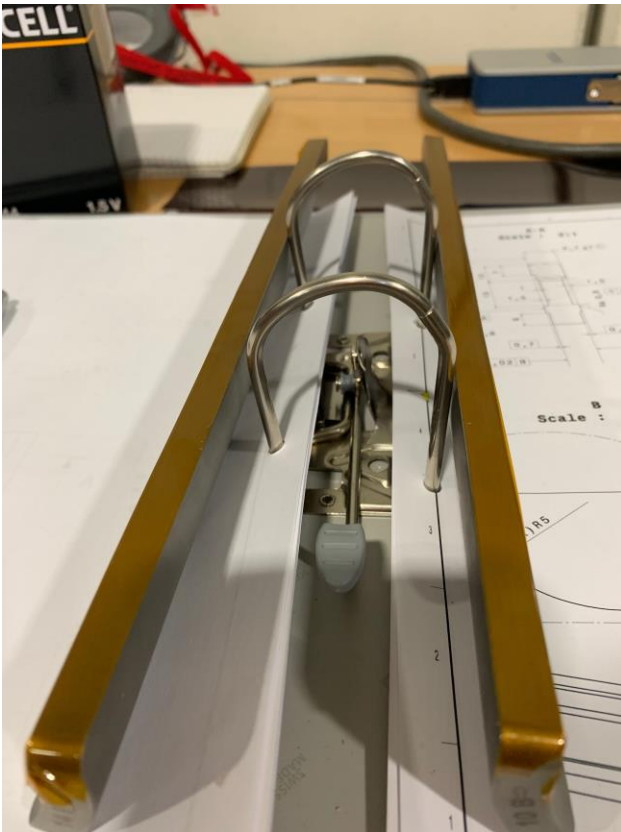
Outline

1. Centering of the tooling
2. **Shimming of the bars**
3. Troubleshooting
4. Conclusions

Shimming of the bars

Monday 18 December 2018

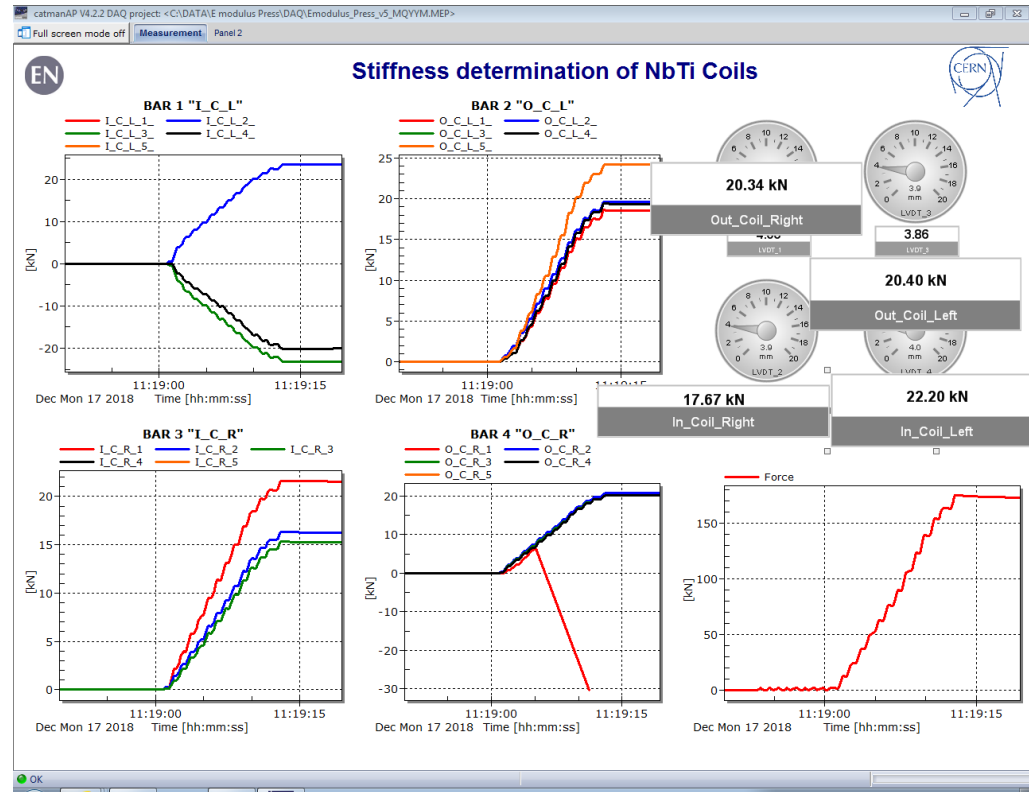
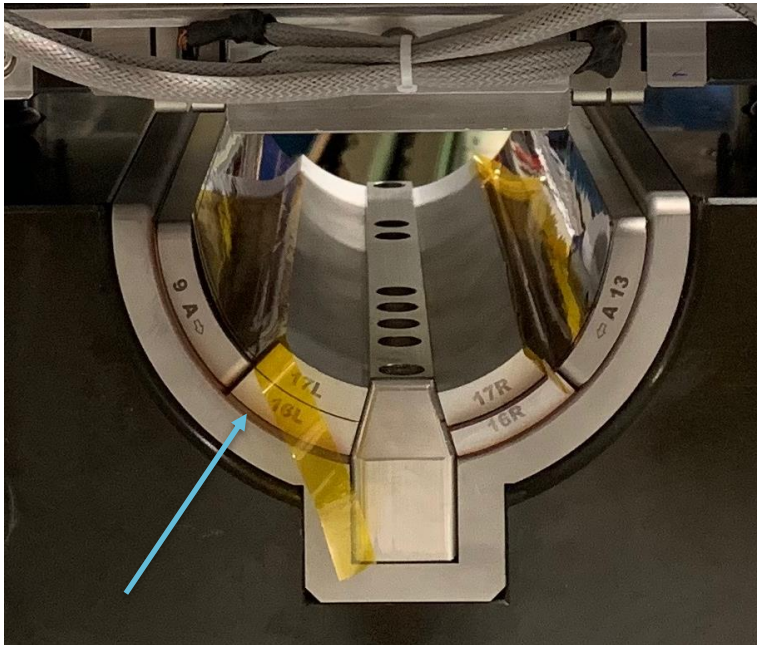
Iteration 3, 0.07 mm shimming on 10B and 14B



Shimming of the bars

Monday 18 December 2018

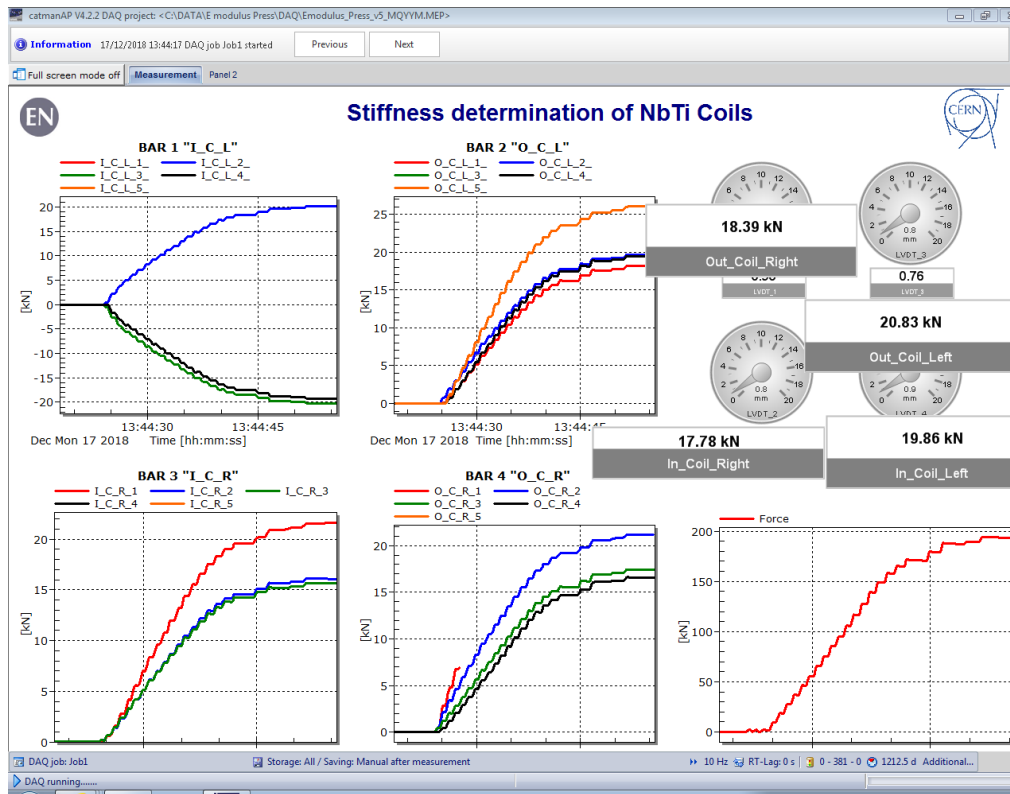
Iteration 4, 0.07 mm shimming on 10B and 14B + 0.025 mm Midplane



Shimming of the bars

Monday 18 December 2018

Iteration 5, 0.07 mm shimming on 10B and 14B + 0.025 mm Midplane



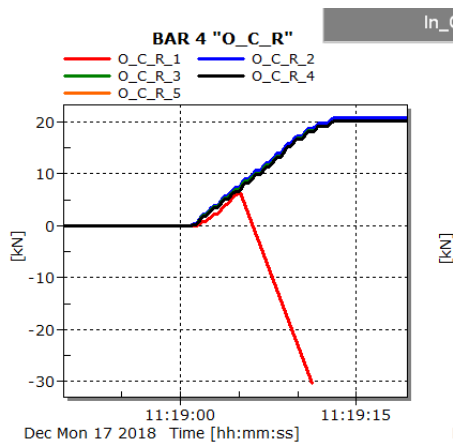
Outline

1. Centering of the tooling
2. Shimming of the bars
3. **Troubleshooting**
4. Conclusions

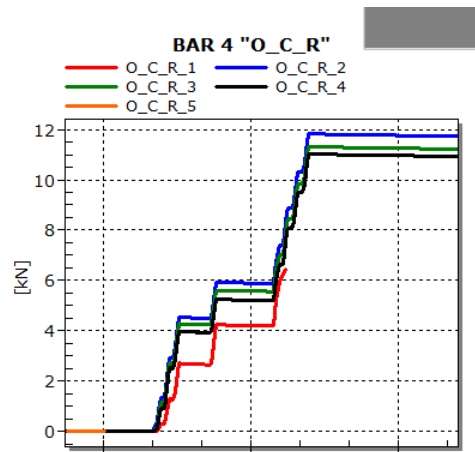
Troubleshooting

1. I_C_R_1 and O_C_L_5 are always ~4kN above the avg.
2. O_C_R was the only bar with 5 working strain gauges (see iteration 1)

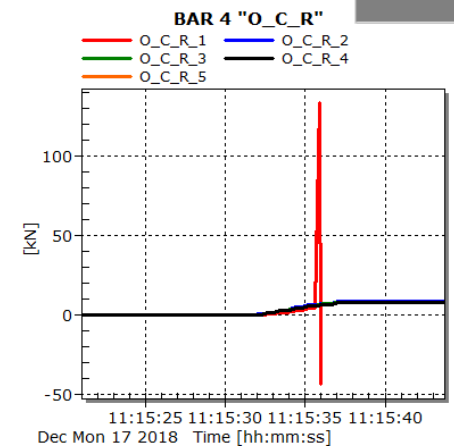
Between the 3rd and 4th iteration O_C_R_1 and O_C_R_5 started to report unexpected values



Iteration 4



Test between Iteration 4 and 5
OCR5 and OCR 1, connection lost



Test between Iteration 4 and 5
OCR1 overshooting

Outline

1. Centering of the tooling
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4. **Conclusions**

Conclusions

1. 0.09 mm of shim on the inner layer
2. List of strain gauges not working:
 1. OCR1
 2. OCR5
 3. ICL1
 4. OCL3
 5. ICR5
 6. ICR4
3. Change the computation sign of ICL3 and ICL4
4. Setup is ready.



Thanks for your attention

