

Summary of NCRF

Conveners

Normal conducting RF

Tetsuo Abe (KEK)

Walter Wuensch (CERN)

Ankur Dhar (SLAC)

Evgenya Simakov (LANL)

David Alesini (INFN-LNF)

The 2024 International Workshop on Future Linear Colliders (LCWS2024)

on July 11th, 2024 at the University of Tokyo, Japan

16 presentations in NCRF

X-LAB: A VERY HIGH-CAPACITY X-BAND RF TEST STAND FACILITY AT THE UNIVERSITY OF MELBOURNE <i>Matteo Volpi</i>		HOM Detuning and Damping of C-Band Distributed Coupling Structure <i>Zenghai Li</i>	
<i>1320, Science building n.4 (CHANGED)</i>		<i>1320, Science building n.4 (CHANGED)</i>	
	11:00 - 11:20		11:00 - 11:20
X-band activities for the EuPRAXIA@SPARC_LAB Linac <i>1320, Science building n.4 (CHANGED)</i>	<i>Fabio Cardelli</i> 	A Wakefield Resilient, High Shunt Impedance Accelerating Structure for the Cold Copper Collider <i>1320, Science building n.4 (CHANGED)</i>	<i>Muhammad Shumail</i> 
	11:20 - 11:40		11:20 - 11:40
Smartcell X-Band Normal Conducting Accelerator Structure Prototype Fabrication <i>1320, Science building n.4 (CHANGED)</i>	<i>Pedro Morales Sanchez</i> 	Update on CARIE high gradient photocathode test stand at LANL <i>1320, Science building n.4 (CHANGED)</i>	<i>Evgenya Simakov</i> 
	11:40 - 12:00		11:40 - 12:00
X-band dielectric assist accelerating structure. <i>1320, Science building n.4 (CHANGED)</i>	<i>Daisuke Satoh</i> 	Next Generation LLRF Control Platform for Compact C band Linear Accelerator <i>1320, Science building n.4 (CHANGED)</i>	<i>Chao Liu</i> 
	12:00 - 12:20		12:00 - 12:20
Capture Cavities for the CW Polarized Positron Source Ce+BAF <i>1320, Science building n.4 (CHANGED)</i>	<i>Shaoheng Wang</i> 	Distributed Coupling Linac for Efficient Acceleration of High Charge Electron Bunches <i>1320, Science building n.4 (CHANGED)</i>	<i>Ankur Dhar</i> 
	09:00 - 09:20		16:00 - 16:20
Status and Plans for the C3 Quarter Cryomodule <i>1320, Science building n.4 (CHANGED)</i>	<i>Mr Haase Andy</i> 	RF breakdown studies at nanosecond timescales using structure wakefield acceleration <i>1320, Science building n.4 (CHANGED)</i>	<i>Xueying Lu</i> 
	09:20 - 09:40		16:20 - 16:40
High Gradient Testing of a Meter-Scale Distributed-Coupling C3 Accelerating Structures <i>1320, Science building n.4 (CHANGED)</i>	<i>Dennis Palmer</i> 	Summary of RF Breakdown Studies using Single Cell Standing Wave Accelerating Structures <i>1320, Science building n.4 (CHANGED)</i>	<i>Valery Dolgashev</i> 
	09:40 - 10:00		16:40 - 17:00
Cold Copper High Gradient Single-Cell Structure Tests <i>1320, Science building n.4 (CHANGED)</i>	<i>Emilio Nanni</i> 	Longitudinally-split side-coupled high-shunt-impedance C-band structure fabricated in two halves <i>1320, Science building n.4 (CHANGED)</i>	<i>Abe Tetsuo</i> 
	10:00 - 10:20		17:00 - 17:20

16 presentations in NCRF

C-band: 8

X-band: 6

L-band: 1

S-band: 1

X-LAB: A VERY HIGH-CAPACITY X-BAND RF TEST STAND FACILITY AT THE UNIVERSITY OF MELBOURNE <i>Matteo Volpi</i>	X		
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Update on CARIE high gradient photocathode test stand at LANL <i>1320, Science building n.4 (CHANGED)</i>	C	<i>Evgenya Simakov</i>	11:40 - 12:00
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Updates of the High-power test facilities

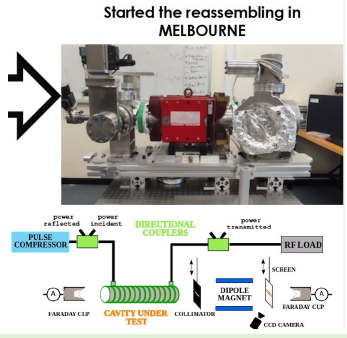
X

X-LAB: A VERY HIGH-CAPACITY X-BAND RF TEST STAND FACILITY AT THE UNIVERSITY OF MELBOURNE

Matteo Volpi on behalf of the X-LAB group:
S. L. Sheehy, P. J. Giansiracusa, R. P. Rassool, G. Taylor, P. Pushkarna, (The University of Melbourne, Melbourne, Victoria), R. Dowd, E. Tan (AS - ANSTO, Clayton), M. Cherrill (University of South Australia), RF CERN group.

Conditioning summary

Component	Pulse Width	Peak Power [MW]	Max Rep. Rate [Hz]	NOTE
KlyC	2 us	6.2	100	
KlyD	2 us	5.5	100	"Old" klystron
RF window - C	2 us	6.2	100	"Pulse length ramping" conditioning
RF window - D	2 us	5.5	100	
PC-3	1.8 us	34	100	Breakdown -> new cup required
PC-4	2 us	40	100	Conditioning going on
LOAD 3	1.8us	34	100	Conditioning limited by PC-3 BDs
LOAD 4	1.8us	40	100	Conditioning going on



Nex steps and long-term goals

- ✓ Has been constructing and commissioning an X-band test facility.
- ✓ Various components have been conditioned.
- ✓ Also developing beam diagnostic systems.
- ✓ So that they will develop the facility to an accelerator physics lab.

Novel diagnostics using Cherenkov radiation

- Transport of radiation to detector challenging
- Optical fibres enable transport under geometric constraints
- CR intensity in fibres proportional to incident charge
- Already employed as distributed Beam Loss Monitors
- Explore application to
 - longitudinal diagnostics
 - breakdown science
 - and bunch profile reconstruction

The Future of XLAB - Accelerator Physics Lab

- Build on the RF test stand
- Develop hands-on skills in accelerator systems
- Compression cavity
 - DRX Works
 - 30Hz
- Electron Gun
 - DRX Works
 - 100 kV Photogun
 - 12.3 MV/m
 - Copper cathode
 - Illumination with a 1 µJ 266 nm 1fs laser pulse can produce 1 pC-electron bunches
 - Looking for advice on a suitable laser

X

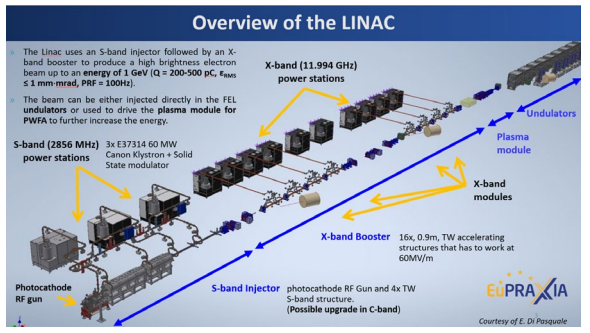
LCWS2024 International Workshop on Future Linear Colliders

X-band activities for the EuPRAXIA@SPARC_LAB Linac

F. Cardelli, INFN-LNF
on behalf of the TeX technical team and the EuPRAXIA@SPARC_LAB team
fabio.cardelli@lnf.infn.it



- ✓ Has been developing an X-band test facility.
- ✓ Various components fabricated, purchased, and HP tested.
- ✓ 20 cells structure under high power testing
- ✓ A full-scale 0.9m prototype for high power test in production



Full-Scale Mechanical Prototype Brazing

2x Full scale mechanical prototype for brazing optimization and test

To maintain the alignment and cell to cell straightness during and after the brazing process, each cell is fixed to the next one by means of screws and mounted on a very precise granite support. This ease also the cells assembly.

Results on the brazed structure

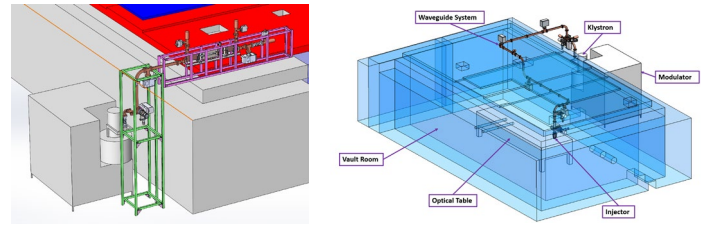
- Vacuum test OK (except one coupler for a mis-positioning of the brazing alloy)
- Straightness $< 15 \mu m$ obtained after brazing on both the prototypes (130 μm required by BD)

C

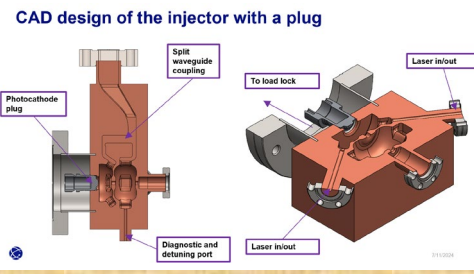
Update on CARIE high gradient photocathode test stand at LANL
1320, Science building n.4 (CHANGED)
Evgenya Simakov
11:40 - 12:00

LANL C-band Engineering Research Facility (CERF-NM)

- CERF-NM was built with \$3M of LANL's internal infrastructure investment.
- Powered with a C-band Canon klystron
 - Conditioned to 50 MW
 - Frequency 5.712 GHz
 - 300 ns - 1 μs pulse length
 - Rep rate up to 200 Hz (typical 100 Hz)
 - Nominal bandwidth 5.707-5.717 GHz



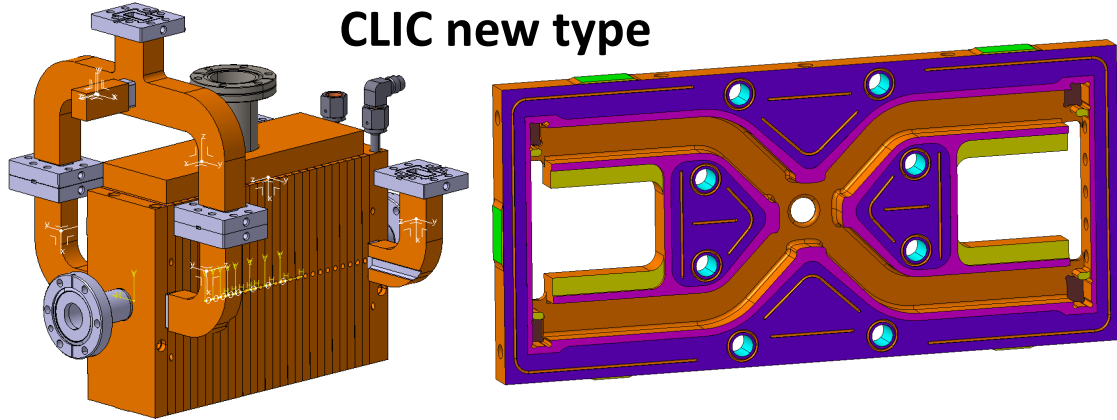
- ✓ Has been developing an C-band test facility
- ✓ To build a HG RF breakdown study facility
- ✓ To build a cryo-cooled photoinjector study facility
- ✓ To conduct material studies
- ✓ To demonstrate high-quantum-efficiency cathodes in a HG RF injector



RF photoinjector cold testing

- Tuning of the photoinjector was successful.
- Tuned frequency 5710.53 MHz in air (5712.15 MHz in vacuum).
- Measured Q-factor 11869 (computed Q-factor 11934).

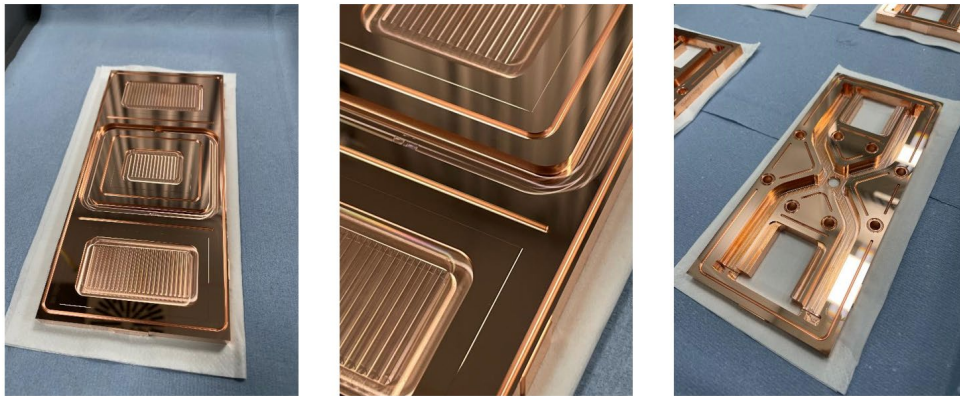
Structure fabrication



CLIC new type

- ✓ New type of CLIC accelerating structure: smartcell
- ✓ The production of a full prototype is ongoing together with a deep analysis about the bonding technique.
- ✓ The prototype production will start before the end of the year

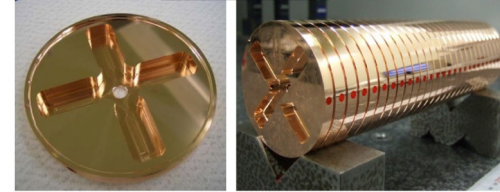
Brazing Mock-up



- Pre-machining done at CERN by MME, metrology OK.
- All cells with UP-Machining at external company.

Two "Orthogonal" Fabrication Methods

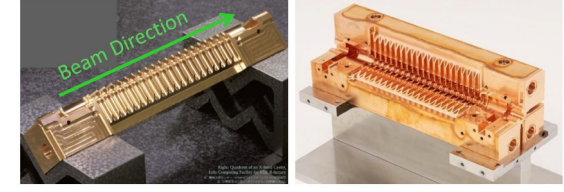
Disk-type



A damped disk Disks stacked and bonded

- Advantages
 - ✓ Machining by turning for main parts
 - ✓ Very smooth surface ($R_a < 100 \text{ nm}$) easily achieved
- Disadvantages
 - ✓ **Many parts** of dozen of disks to be made by ultraprecision machining
 - Followed by delicate stack and bonding
 - ✓ Great care needed to be taken
 - ✓ **Surface currents due to the accelerating mode flow across many disk-to-disk junctions.**

Longitudinally-split type



A Quadrant Three Quadrants

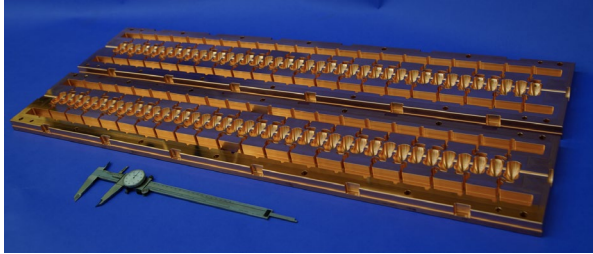
- Advantages
 - ✓ **Only two or four parts** to be made by simple machining with (five-axes) milling machines
 - ✓ Simple assembly process
 - Possibility of significant cost reduction
 - ✓ **Surface currents due to the accelerating mode do not flow across any bonding junction.**
- Disadvantages
 - ✓ Not very smooth surface ($R_a > 100 \text{ nm}$)
 - ✓ Possible **virtual leak** from halves or quadrants junctions
 - Solved in our improved version
 - ✓ **Field enhancements** at the edges of halves or quadrants
 - Partially solved in our improved version

Application to Compact Medical Linac (C-band: 5.71 GHz)

- ✓ Relatively new fabrication method: split-type
- ✓ Adopted in the C3 accelerating structure fabrication
- ✓ Mentioned later

Various developments for C³ (hardware)

High Gradient Testing of a Meter-Scale Distributed-Coupling C3 Accelerating Structures
 1320, Science building n.4 (CHANGED)
 Dennis Palmer
 09:40 - 10:00



3rd C³ Meter-Scale Prototype Completed Spring '24

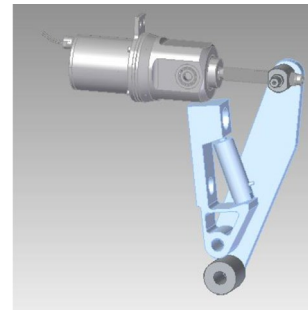
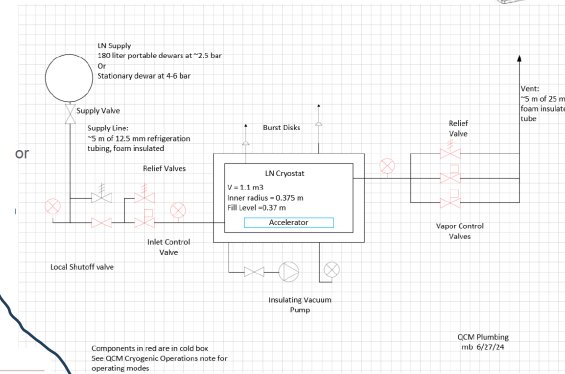
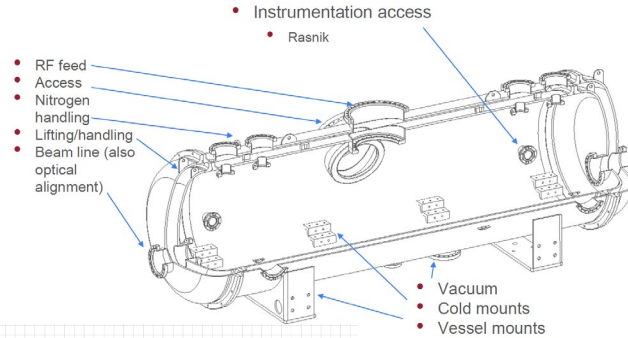
- Previous structures tested warm at high power
- Max power 15 MW into structure – klystron limited
- Braze process and fixturing was improved iteratively
- Third structure for cold operation



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Status and Plans for the C3 Quarter Cryomodule
 1320, Science building n.4 (CHANGED)
 Mr Haase Andy
 09:20 - 09:40

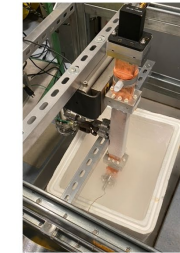
QCM Vessel/Cryostat



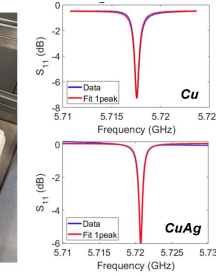
Cold Copper High Gradient Single-Cell Structure Tests
 1320, Science building n.4 (CHANGED)
 Emilio Nanni
 10:00 - 10:20

Characterization at 77K

- Improvement of 2.5 X for Cu and 2.9X for CuAg(!)
- 2.9 is consistent of Cu sample measurements at UCLA (may be material batch specific)

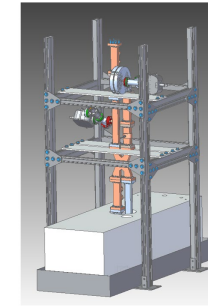


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Parameter	CuAg	Cu
Temp	77K	
Frequency	5.71455 GHz	
Length	1.58 cm	
β	2.97	2.683
Q_0	29,695	25,697
R_s (M Ω /m)	352	305
E_a MeV/m/ \sqrt{MW}	141	131

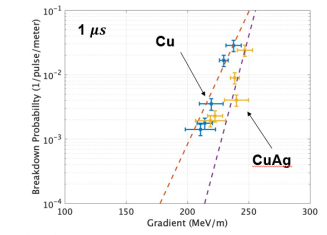
Two Cell Assembly for Hig



SLAC LCWS 2024

Structure Processing

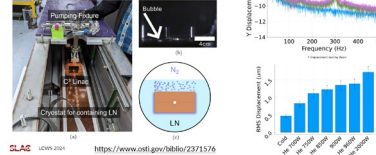
- ~20M Pulses (two weeks)
- Increased pulse length – 400 ns, 700 ns, 1 microsecond



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Vibration Measurements Resistive Heater in Beam Tunnel

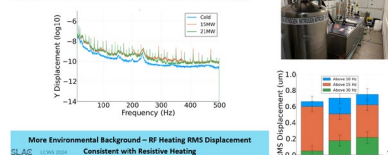
For main linac structures vibration tolerance is ~10 μ m
 Prototype C3 Linac with a resistive heater was used to test vibration with LN up to 2 kW (thermal load of main linac)



SLAC LCWS 2024 https://www.slac.stanford.edu/biblio/2371576

Vibration Measurements with RF Heating

Vibration Data Collected at 10 Hz and 1 μ s
 Accelerometer measurements at max power showed sub-micron displacements, even with mechanical propagation from outside the bunker



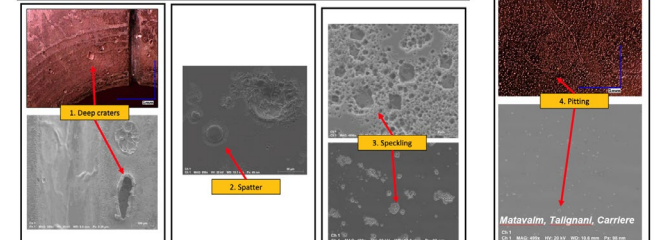
More Environmental Background – RF Heating RMS Displacement Consistent with Resistive Heating

- ✓ Hardware developments for C3 have been performed vigorously.
- ✓ Fabricated full-scale accelerating structures based on the DC scheme, and perform LP/HP RF tests.
- ✓ Measured vibrations due to bubbling in LN
- ✓ Designing the Quarter Cryomodule is on-going.
- ✓ HPT of single-cell DCS is also on-going at Los Alamos at LN temperature together with microscopic investigations

E-field Defect types classification



- Deep craters (observed only in Hi-E regions)
- Spatter (observed in Hi-E but not significantly on Low-E regions)
- Speckling (observed in Low-E regions only)
- Pitting (observed in Hi-E & Low-E regions)



Matavaini, Tallignani, Carriere

Various developments for C³ (designing)

HOM Detuning and Damping of C-Band Distributed Coupling Structure

Zenghai Li

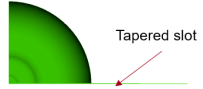
1320, Science building n.4 (CHANGED)

11:00 - 11:20

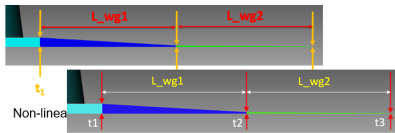
180 deg/cell Structure HOM Damping with Tapered Lossy Slot – Dongsung Kim

SLAC

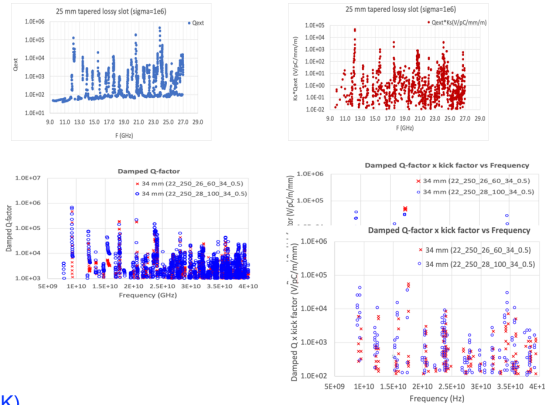
Slot surface conductivity (Ni-Cr) 1.0E+6 S/m



Linear taper: slot height: from 300 micron to 100 micron



- Optimization in progress
- Need more studies in
 - Lossy materials at cold temperature (77K)
 - Coating or thin layers brazing on to structure



17

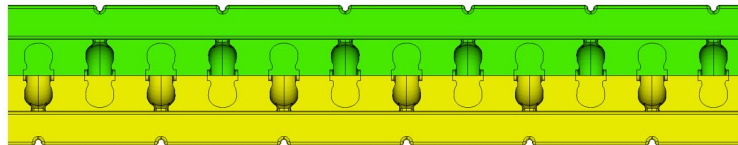
135/cell Structure – Possible Damping Scheme (power feed V1)

SLAC

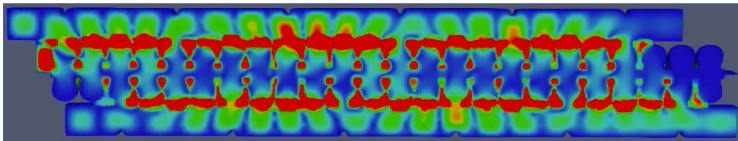
- Parallel feed waveguide acting as damping manifold
 - similar to NLC DDS structure
- Narrow slot cutting through the iris couples the cells to waveguide
- HOM calculation in progress



NLC RDDS



(illustration of damping)



HOM power extraction

16

A Wakefield Resilient, High Shunt Impedance Accelerating Structure for the Cold Copper Collider

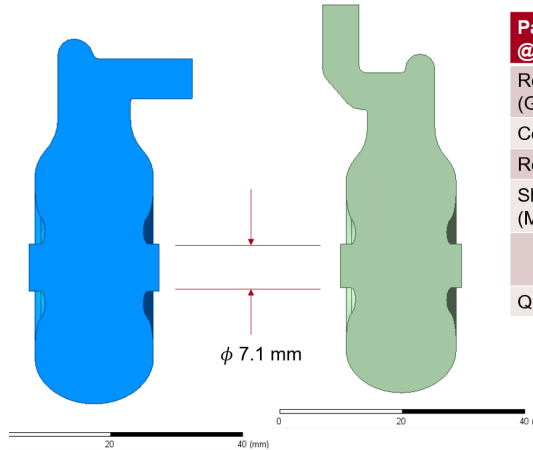
Muhammad Shumail

1320, Science building n.4 (CHANGED)

11:20 - 11:40

Cavity (with two different coupler implementations) Parameters Determined Through HFSS® Simulations

SLAC



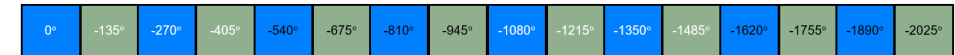
Parameters @ 77 K	Cavity Left	Cavity Right
Resonant Frequency, f_0 (GHz)	5.712	5.712
Coupling Coefficient, β	1.8625	1.8634
Reflection Coefficient, Γ	0.3013	0.3015
Shunt Impedance, r_s (M Ω /m)	317.22	317.22
$\frac{\eta_0 H_{surf peak}}{Gradient}$	1.14	1.14
Quality Factor, Q_0	30124	30122

5

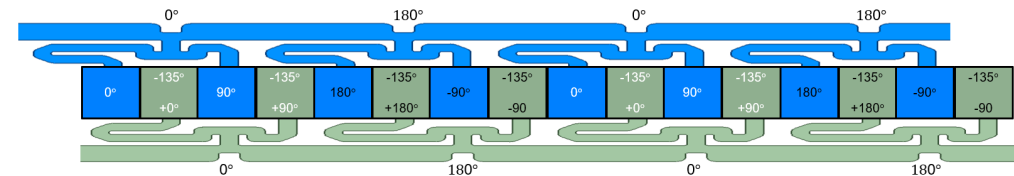
Cavity Phases in an Accelerator Made of 135° Phase Advance Cavities ($e^{i\omega t}$ convention)

SLAC

→ Beam Direction



Equivalent phases and Feeding Scheme:



There has to be a phase difference of 135° between the upper and lower rf feeding manifold.

Applications

Distributed Coupling Linac for Efficient Acceleration of High Charge Electron Bunches

Ankur Dhar

1320, Science building n.4 (CHANGED)

16:00 - 16:20

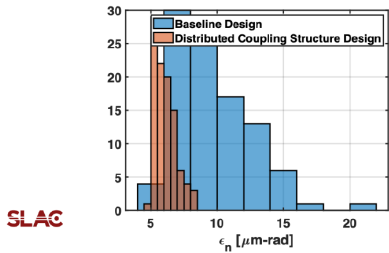
Distributed Coupling as applied to Injector Linac Design

Design balances shunt impedance with aperture size

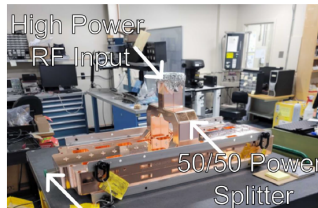
- S-band cavities designed with aperture ratio $a/\lambda=0.135$

Better output emittance compared to baseline traveling wave structures with 14 nC bunches

- Emittance calculated for $a/\lambda=0.125$ cavities
- Baseline design informed by EIC specs



Linac Properties			
Freq (GHz)	2.856	E_{max}/E_{acc}	2.63
a (mm)	14.12	$E_{acc}/Z_0 H_{max}$	0.995
a/λ	0.135	R_s (M Ω /m)	58
P_{diss} (MW)	5	E_{acc} (MV/m)	18



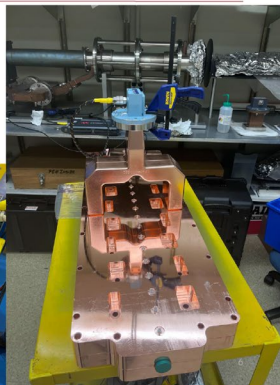
- Based on the C3 technology applied to Injector Linac
- Large Aperture distributed coupled Linac in S-band.
- The assembly and brazing performed in SLAC.
- Proposals for testing the structure

Assembly of Injector Linac

Linac formed from two slabs, which are brazed

Y-Coupler is brazed on afterwards to provide even power splitting between each side

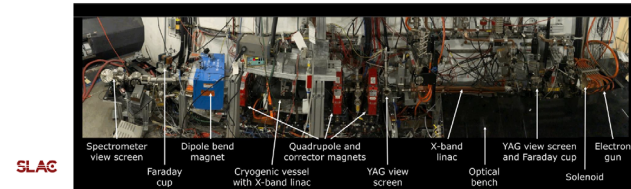
Assembly and brazing was done in house at SLAC



Future Test Plans

Various proposals to testing the structure are in preparation:

- High power test measuring breakdown rate with 35 MW klystron at Station S-band at NLCTA
- ASSET-style wakefield measurement without high power at FACET-II
 - Also potentially at XTA within NLCTA
- Full power + beam tests at CLEAR and/or APS
- Open to further suggestions for test sites



Longitudinally-split side-coupled high-shunt-impedance C-band structure fabricated in two halves

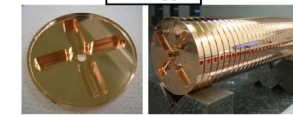
Abe Tetsuo

1320, Science building n.4 (CHANGED)

17:00 - 17:20

Two "Orthogonal" Fabrication Methods

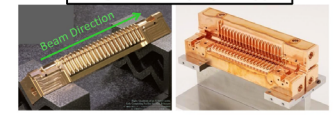
Disk-type



A damped disk Disks stacked and bonded

- Advantages
 - Machining by turning for main parts
 - Very smooth surface ($R_a < 100$ nm) easily achieved
- Disadvantages
 - Many parts of dozen of disks to be made by ultraprecision machining
 - Followed by delicate stack and bonding
 - Great care needed to be taken
 - Surface currents due to the accelerating mode flow across many disk-to-disk junctions.

Longitudinally-split type



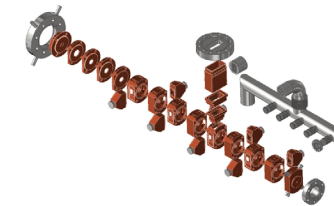
A Quadrant Three Quadrants

- Advantages
 - Only two or four parts to be made by simple machining with (five-axes) milling machines
 - Simple assembly process
 - Possibility of significant cost reduction
 - Surface currents due to the accelerating mode do not flow across any bonding junction.
- Disadvantages
 - Not very smooth surface ($R_a > 100$ nm)
 - Possible virtual leak from halves or quadrants junctions
 - Solved in our improved version
 - Field enhancement at the edges of halves or quadrants
 - Partially solved in our improved version

Application to Compact Medical Linac (C-band: 5.71 GHz)

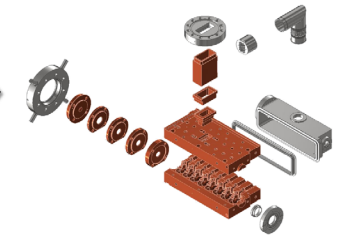
Conventional-versus-New

Conventional disk type structure consisting of 59 parts



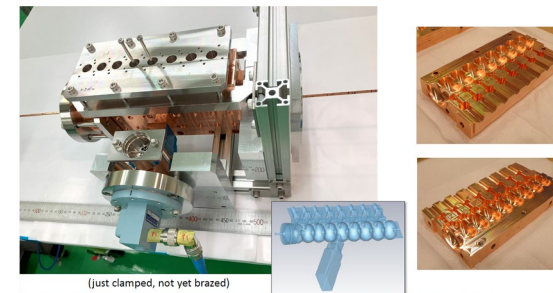
Brazed into one through two steps

Longitudinally-split type structure consisting of 25 parts



To be brazed into one in a single step

Fabrication of a full-scale prototype (2024)

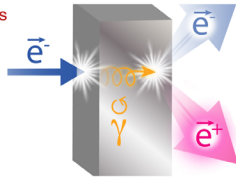


Quantitative comparison of cost-effectiveness between the longitudinally-split and disk-type fabrication methods for the linac with (almost) the same specifications to estimate sustainability effects

Capture cavity, LLRF

Capture Cavities for the CW Polarized Positron Source Ce+BAF

- The capture cavity design strategy and initial results
- Initial beam dynamics results of capture cavities acting on the positron shower



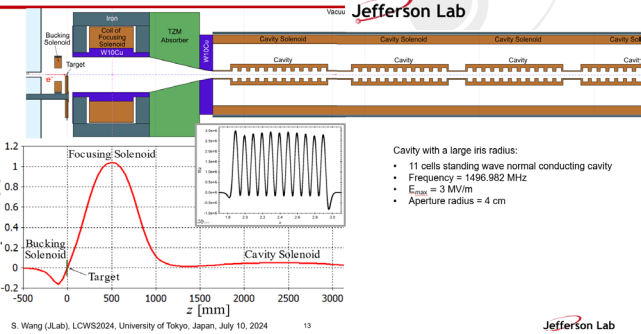
Shaoheng Wang (Jefferson Lab)
on behalf of the Ce+BAF Working Group

International Workshop on Future Linear Colliders (LCWS2024),
July 8-11, 2024, University of Tokyo, Japan

Work supported by the U.S. Department of Energy Office of Nuclear Physics under contract DE-AC05-06OR23177
and Office of High Energy Physics US-Japan Science & Technology Cooperative Program

The Matching Section and Capture Cavity

Jefferson Lab



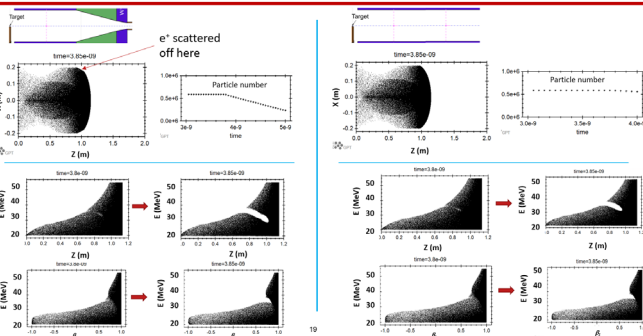
Cavity with a large iris radius:

- 11 cells standing wave normal conducting cavity
- Frequency = 1496.982 MHz
- $E_{\text{cell}} = 3 \text{ MV/m}$
- Aperture radius = 4 cm

S. Wang (JLab), LCWS2024, University of Tokyo, Japan, July 10, 2024

Jefferson Lab

How the Energy Bands Form



- The design and related simulated results were shown.
- Particularly, the influence of solenoid magnetic field to the e^+ transportation before entering cavity,
- Including an Initial studies of the action of RF field of cavities on 20, 60 MeV positrons

C³ High Power Test Setup with NG-LLRF and C3

SLAC

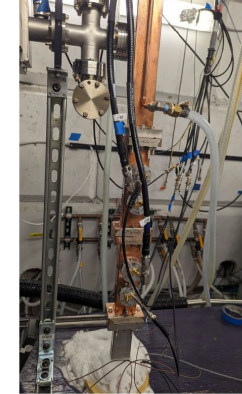
RFSoc DAC drives the Klystron



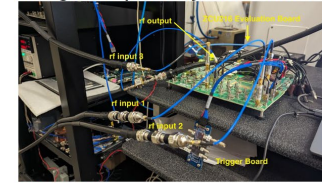
RF power injected to C3



FWD and REF via coupler



RF signals captured by RFSoc ADCs



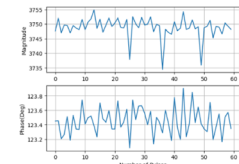
SLAC TID TECHNOLOGY INNOVATION DIRECTORATE

- ✓ New LLRF system is presented based on RFSoc.
- ✓ RFSoc is an Rf system-on-chip technology which integrates all the essential components including programmable logic, and processors
- ✓ RFSoc based LLRF significantly reduces hardware complexity and enables more flexibility in operation
- ✓ They fabricated the LLRF based on RFSoc, and test it on pulse-to-pulse fluctuation, etc.

Pulse-to-pulse Fluctuation with SSA

SLAC

Averaged phase and amplitude values for 60 pulses



Pulse-to-pulse fluctuation for 60 pulses

- Magnitude
 - RMS (SD/Mean): 0.09%
- Phase
 - RMS (SD) : 0.18° (87.54 femtoseconds)

Test Summary

- 60 consecutive pulses captured in IQ format and the average phase and magnitude calculated for each pulses.
- RFSoc-based LLRF with the custom SSA delivers considerably lower phase jitter than required for Cool Cooper Collider (C³).

3.2.1 Low level rf and klystron controls

The rf phase requirements of 0.1% and 0.3° C-band phase (150 femtoseconds) are comparable to the requirements of β^+ generation light sources. A recently developed Low Level rf (LLRF) system at SLAC provided < 20 femtosecond RMS drive noise and < 5 femtosecond RMS readback noise in a 1 MHz bandwidth, considerably better than required for C³. The klystron modulator interlocks are comparable to those on existing accelerators.

E. Nanni et al., "Status and future plans for C3 R&D", Journal of Instrumentation, vol. 18, no. 09, p. 09040, 2023. <https://doi.org/10.1088/1748-0221/18/09/P09040>

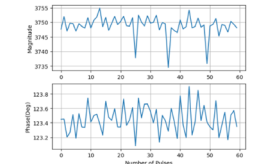
SLAC TID TECHNOLOGY INNOVATION DIRECTORATE

C. Liu et al., IPAC2024, <https://arxiv.org/abs/2405.08219>

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SLAC

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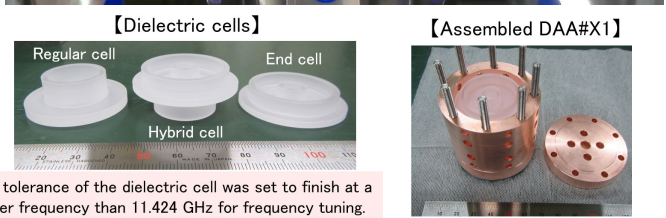
E. Nanni et al., "Status and future plans for C3 R&D", Journal of Instrumentation, vol. 18, no. 09, p. 09040, 2023. <https://doi.org/10.1088/1748-0221/18/09/P09040>

SLAC TID TECHNOLOGY INNOVATION DIRECTORATE

C. Liu et al., IPAC2024, <https://arxiv.org/abs/2405.08219>

Basic studies

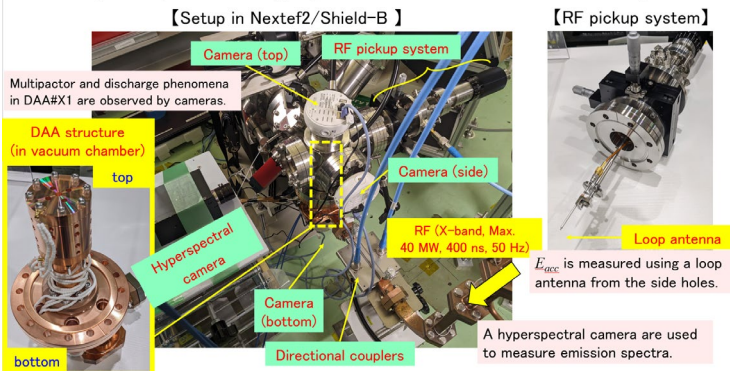
X-band dielectric assist accelerating structure



The tolerance of the dielectric cell was set to finish at a higher frequency than 11.424 GHz for frequency tuning.

- ✓ Very high R_{sh}
- ✓ $E_{acc} < \sim 10$ MV/m
- ✓ Understand the physics
- ✓ Break the E_{acc} limit

【 Setup for the high-power test in Nextef2/Shield-B】



RF breakdown studies at nanosecond timescales using structure wakefield acceleration

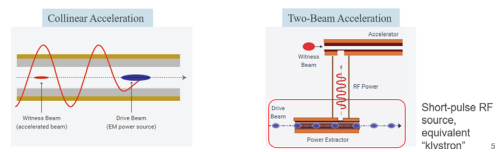
Xueying Lu
Northern Illinois University (NIU)
& Argonne National Laboratory (ANL)

July 10, 2024
The University of Tokyo, Japan

Argg

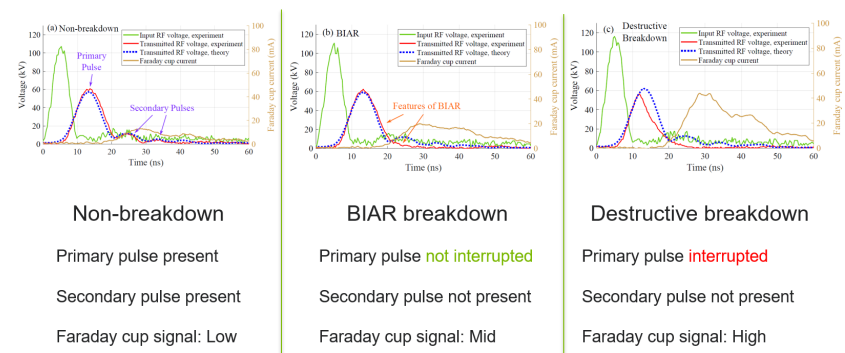
Structure wakefield acceleration (SWFA)

- SWFA could be a testbed for short-pulse high-gradient acceleration
 - Klystron-driven linacs: ~ 100 ns to $\sim \mu$ s
 - SWFA at AWA: a few ns pulse length
- SWFA: one promising AAC scheme
 - Extract wakefield from a "drive" beam to accelerate a "witness" beam
 - Happens in structures in vacuum

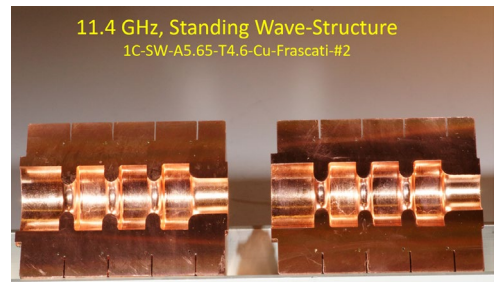


- ✓ Significant point is that they are developing BIAR with a very short RF pulse.
- ✓ In this example, there is a big Faraday cut signal, so BD occurred, but transmission was not affected due to a non-zero grow time of vacuum arcing or discharge.
- ✓ Understanding of this phenomenon
- ✓ We could accelerate beam bunches even when BD occurs?
- ✓ We will be freed from BD limit?

Breakdown insensitive acceleration regime (BIAR)



No visible light detected in all three cases- possibly a new feature for short-pulse breakdown



High Power Tests of Single Cell Standing Wave Accelerating Structures

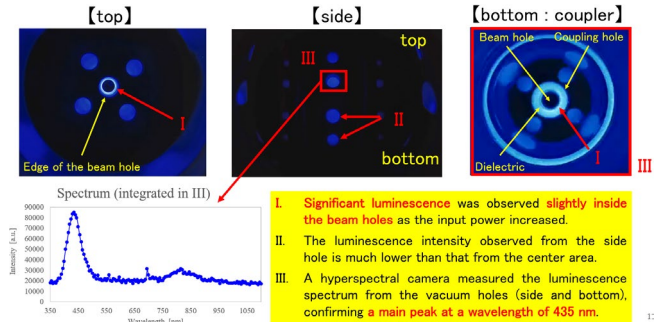
To be able to rely on experimental results, the effort has been directed towards:

- Material optimization
- Surface treatment
- Manufacturing consistency
- Reproducibility

Total of 54 structures tested in up to date

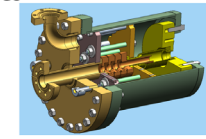
- ✓ At SLAC, many single cell cavities were tested, more than 50.
- ✓ A lot of data has been accumulated, that is very useful to understand new HGT results.
- ✓ Recently we found hard copper and copper alloy have good HG performance.
- ✓ We will investigate such materials in the near future.

【Luminescence in DAA#X1 : 0.6 MW, 200 ns, 50 Hz】



Development of Hard Copper and Copper Alloy Structures

- We had to develop an apparatus for testing accelerator structure without brazing
- The results shows a great improvement of possible gradients at very low breakdown rates
- It is now possible to talk about reliable gradient higher than 150 MV/m



News construction techniques which preserve hardens of the metal

- Electron Beam Welding
- Tungsten Inert Gas Welding
- Clamping