

# S1-G Modules assembly status (20100511)

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# S1-G Module-A assembly status

(Completed jobs: April 21~May 11)

- April 21 ~30

1. Wrapping the SI around the 80K shields.
2. Inserting the cold mass into the vacuum vessel.
3. Assembling support posts and structures.
4. Moving the Module-A into the STF tunnel.

- May 6~11

1. Welding cooling pipes between Module-A and -C.
2. Assembling the radiation shield.
3. Connecting signal wires to the feed-throughs.

- April 21 ~30

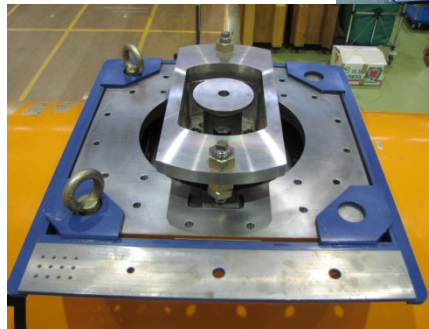
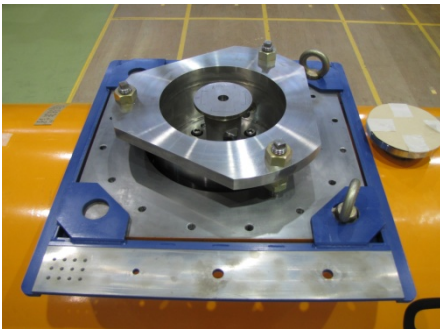
1. Wrapping the SI around the 80K shields.
2. Inserting the cold mass into the vacuum vessel.
3. Assembling support posts and structures.
4. Moving the Module-A into the STF tunnel.



Wrapping the SI around the 80K shield



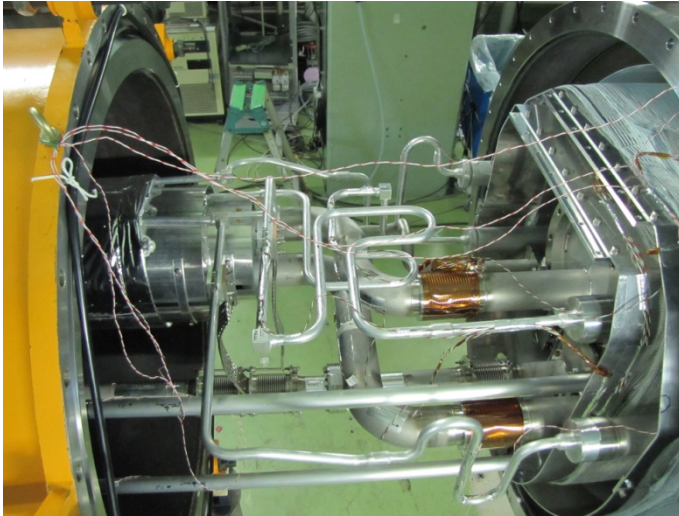
Moving the Module-A into the STF tunnel



Assembling support posts and structures

- May 6~11

1. Welding cooling pipes between Module-A and -C.
2. Pre-assembling the radiation shield.
3. Connecting signal wires to the feed-throughs.



Welding cooling pipes between 2KCB and Module-C



Cooling pipes between Module-C and Module-A



Module-C feed-through



Module-A feed-through



Module-A feed-through



# Assembly Schedule of Module-A

	2010					March					April				May			
	1	8	15	22	29	5	12	19	26	3	10	17	24					
KEK cavity string in the clean room	←→																	
Preparation	←→																	
Class 10/1000 assembly work	←→																	
KEK cavity string outside of the clean room and assembling tuners			←→															
Module-A assembly	←→																	
Attaching T-sensors and Pin-diodes on the cavity string						←→												
Mounting the KEK cavity-string to GRP						←→												
Welding LHe supply pipe and cool-down pipes								←→										
PT and LT of cooling pipes								←→										
Mounting sensors on pipes and wiring for sensors on cavity string and pipes								←→										
SI on LHe supply pipe and GRP								←→										
Assembling 5K shield								←→										
Attaching and wiring sensors on the 5K shield								←→										
SI on 5K shield								←→										
Assembling 80K shield								←→										
Attaching and wiring sensors on the 80K shield								←→										
SI on 80K shield								←→										
Checking sensors								←→										
Inserting the cold mass into V.V.								←→										
Installing Module-A in the tunnel								←→										
Intermediate area between Modules and 2K cold box										←→								
Welding pipes between Module-C and Module-A										←→								
Welding pipes in the Module-A end and PT, LT of cooling pipes										←→								
Assembling thermal shields/SI/Wiring										←→								
STF-2 warm coupler installation												←→						
Closing Modules/Vacuum pumping Modules/Final vacuum LT													←→					

- Leak tests of cooling pipes in this week.
- Assembling the thermal shields and SI.
- Assembling KEK input couplers.
- Closing cryostats, pumping vacuum vessel and the final leak test of the S1-G cryomodule.