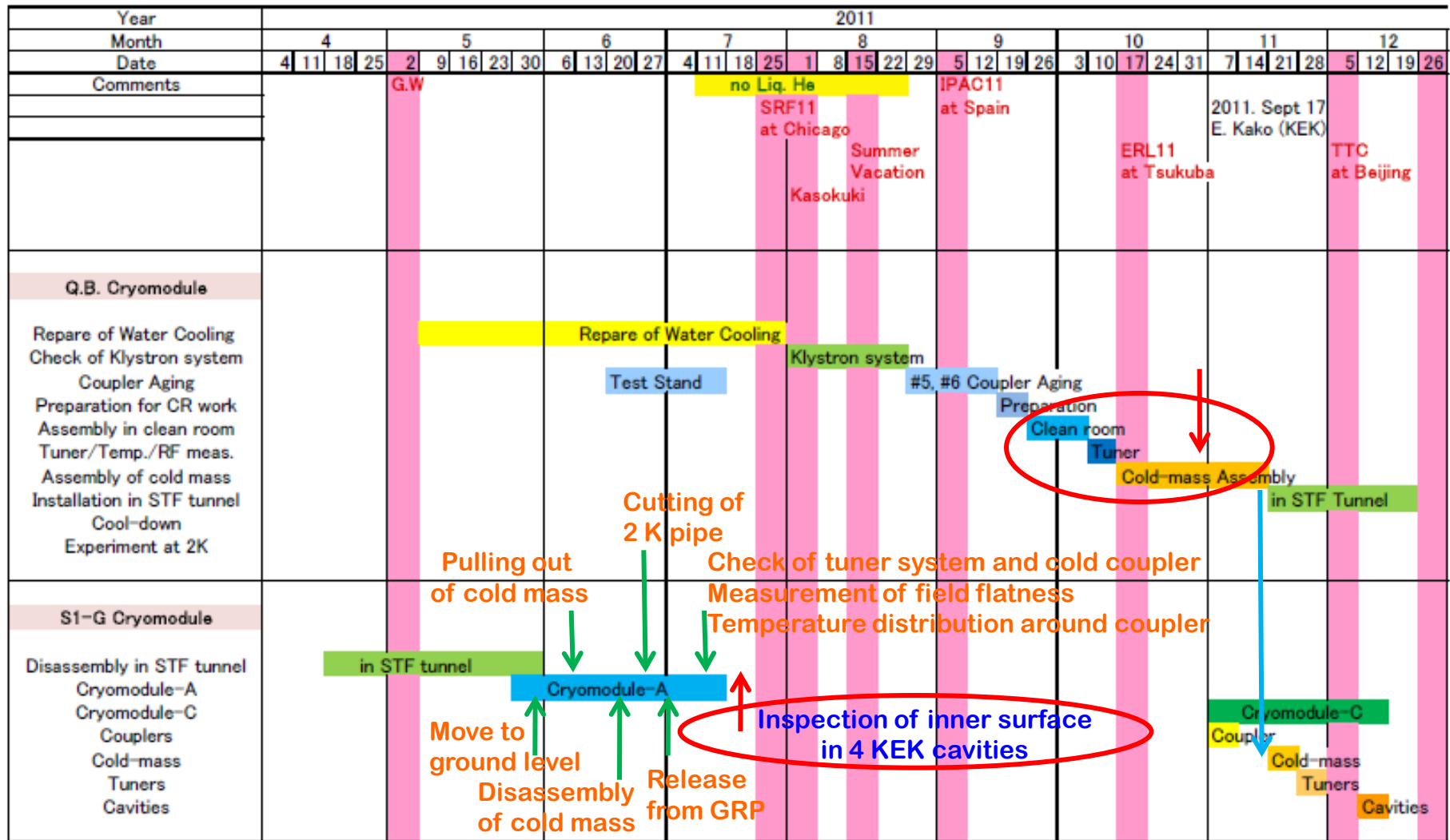


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# **Assembly of QB Cryomodule & Disassembly of S1-G Cryomodule**

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# Assembly/Disassembly Schedule at STF



# Assembly Status of QB Cryomodule (1)



Before string assembly,  
Class-10, Oct. 04, 2011



Attachment of 2K He pipe,  
Class-1000, Oct. 07, 2011



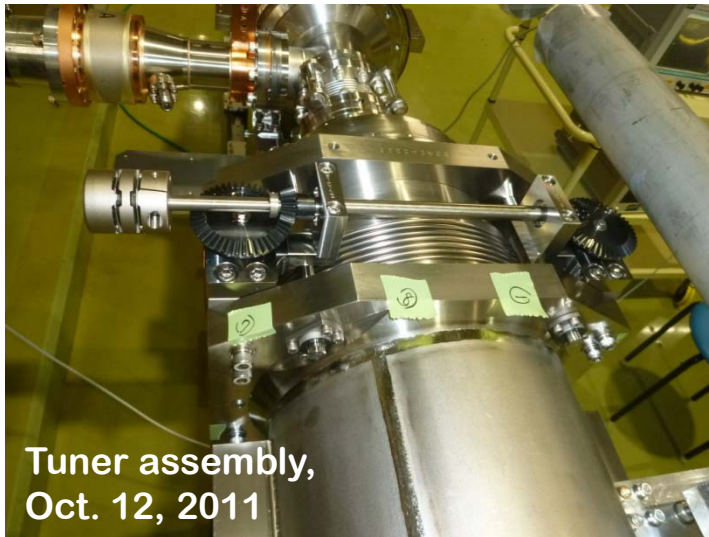
After string assembly,  
Class-10, Oct. 05, 2011



Out of clean room, Oct. 11, 2011



# Assembly Status of QB Cryomodule (2)

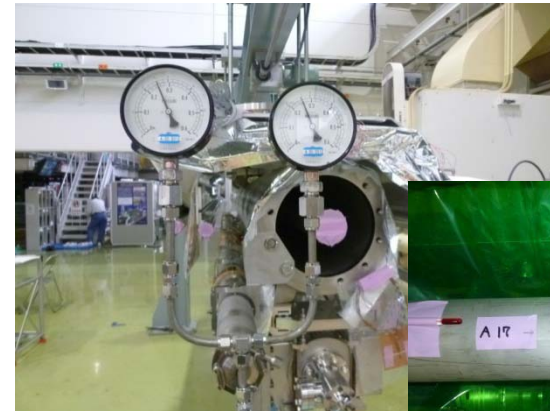




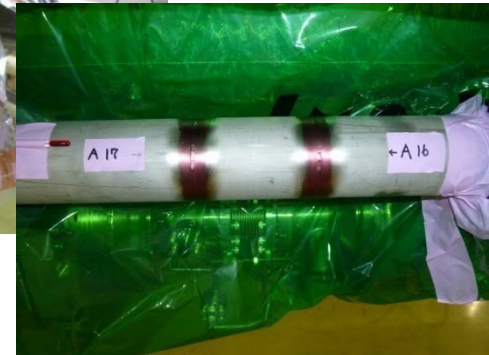
# Assembly Status of QB Cryomodule (3)



Alignment of cavities,  
Oct. 18, 2011

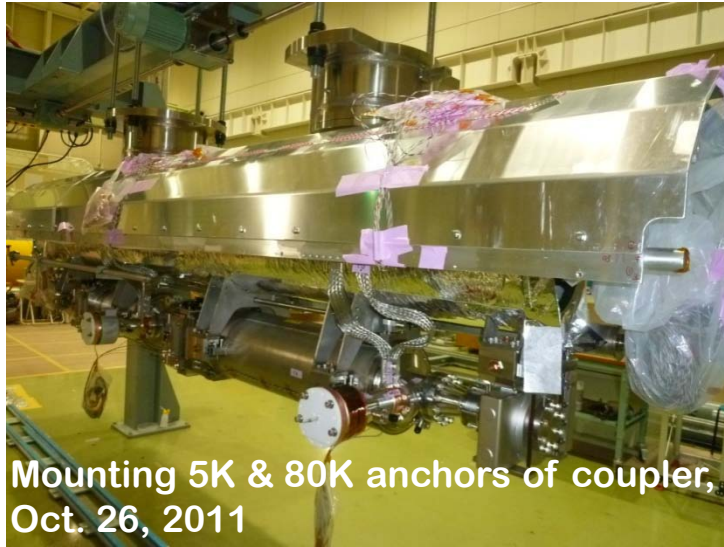


High pressure gas test,  
Oct. 24, 2011





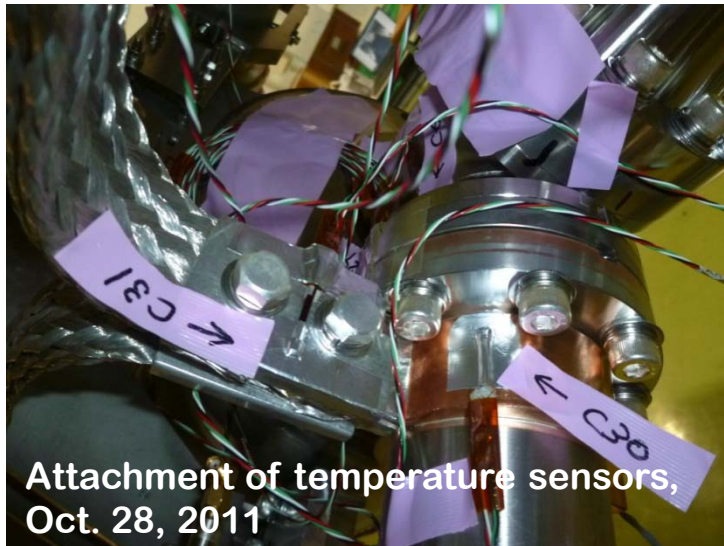
# Assembly Status of QB Cryomodule (4)



Mounting 5K & 80K anchors of coupler,  
Oct. 26, 2011



Setting the endplate of cryomodule,  
Oct. 24, 2011

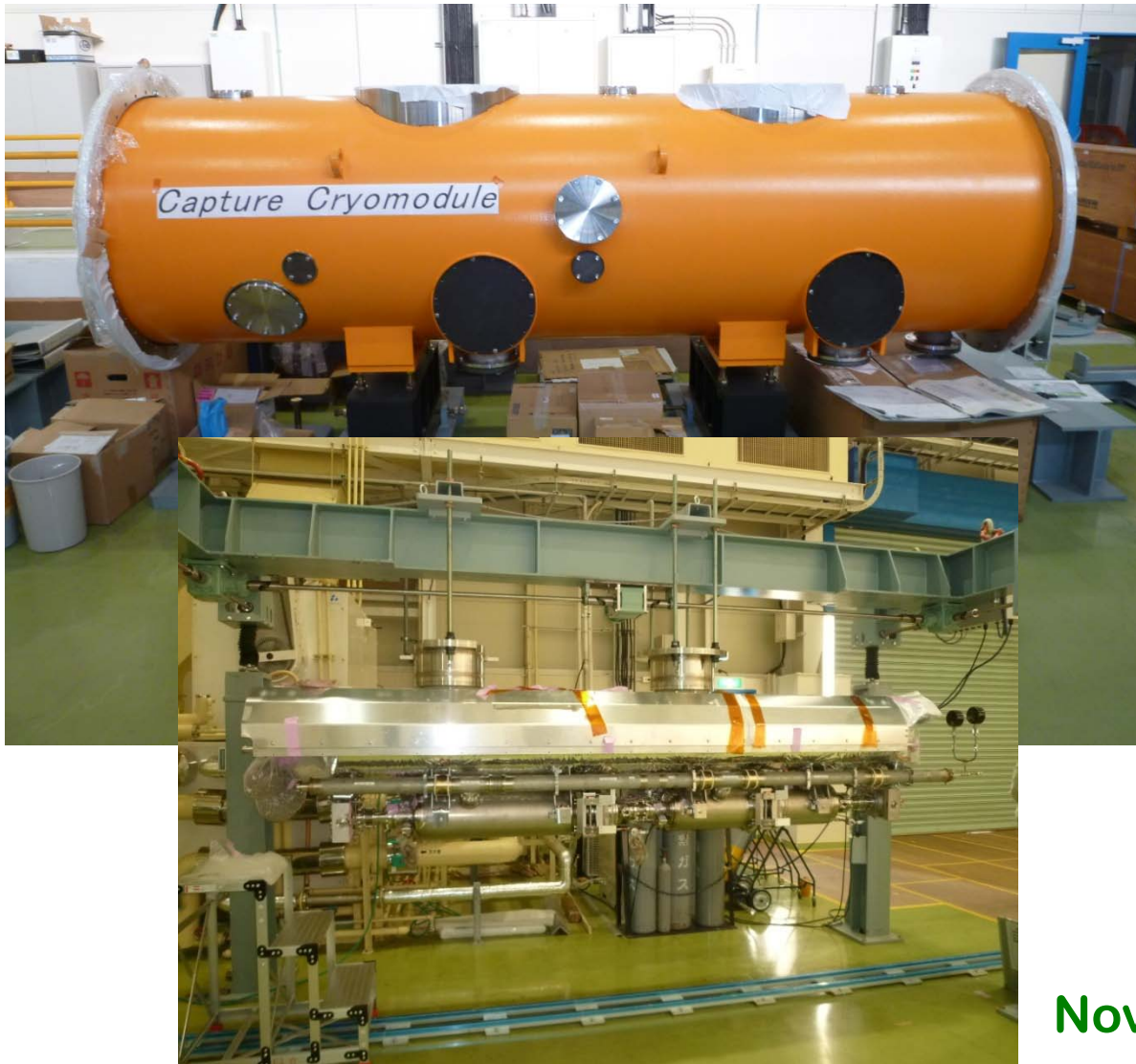


Attachment of temperature sensors,  
Oct. 28, 2011



Welding transfer tubes,  
Oct. 26, 2011

# Assembly Status of QB Cryomodule (5)



Nov. 01, 2011

# Assembly of QB-Cryomodule

November, 2011

SUN	MON	TUE	WED	THU	FRI	SAT
		1 KHK	2	3 文化の日 5K shield, SI	4	5
6	7	8 80K temp.-sensor & 80K shield, SI	9	10	11	12
13	14 Insertion into vacuum vessel	15	16	17 Installation Tunnel	18	19
20	21 Cryomodule-C	22	23 勤労感謝の日	24 Lower-stream side Bam tube	25	26
27	28	29 Upper-stream side Bam tube	30	12/1 Warm coupler Assembly	12/2	12/3



# Disassembly of Cryomodule-C

Nov. 01, 2011



Cryomodule-C will be covered with a clean booth during disassembly of warm couplers.



# Disassembly plan of Cryomodule-C

November, 2011

SUN	MON	TUE	WED	THU	FRI	SAT
		1	2	3 文化の日	4	5
6	7	8 9 10 11 Disassembly of warm couplers			12 Denis/DESY	
13	14	15	16	17 Installation QB cryomodule in tunnel	18	19
20	21 22 Pulling out of cold- mass, 80K/5K shield		23 勤労感謝の日	24 25 Disassembly of cold -mass (KEK)		26 Nakai/KEK Kako/KEK
27	28 29 30 Disassembly of Mag.-shield, Check of tuners Dismount of tuners (INFN/FNAL)					Rocco/INFN Angelo/INFN Yuriy/FNAL

# Disassembly plan of Cryomodule-C

December, 2011

SUN	MON	TUE	WED	THU	FRI	SAT
				1	2	3
4	5	6	7	8	9	10
	← TTC at IHEP-Beijing			ILC meeting →		
11	12	13	14	15	16	17
	Disassembly of string cavities (FNAL+DESY)					Tug, Brian Marco, Mark /FNAL
18	19	20	21	22	23 天皇誕生日	24
	Spare days (KEK)					
25	26	27	28	29	30	31



# Delivery of Coupler Disassembly Tools from DESY



Arrival at  
Oct. 28, 2011

# Delivery of Coupler Top Hats from FNAL



For DESY couplers,  
Kept at KEK.

For FNAL couplers,  
Arrival at Nov. 01, 2011



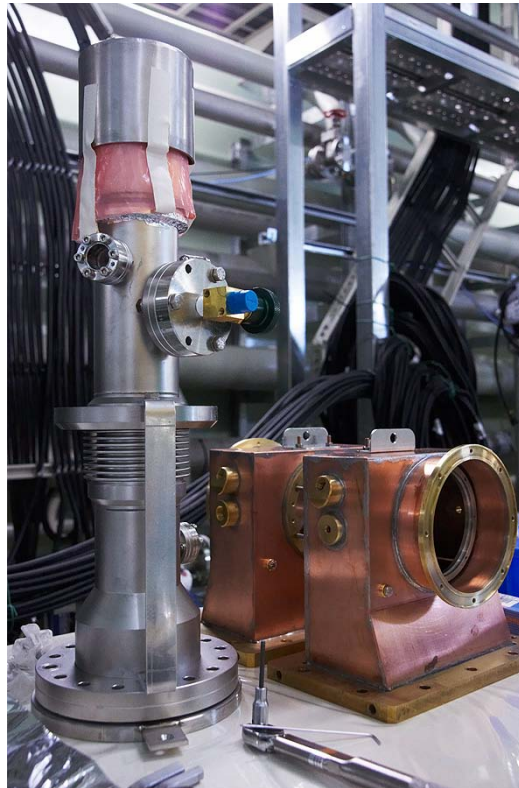


# Jigs of Warm Couplers after dismounting



Before assembly  
of warm couplers  
in March, 2010.

All parts at KEK  
for DESY couplers



Missing all parts  
for FNAL couplers





# Delivery of Coupler Support Arms and Blade Tuner Spanner Rods from FNAL

Arrival at  
Oct. 27, 2011

Coupler support arms  
for FNAL/DESY couplers

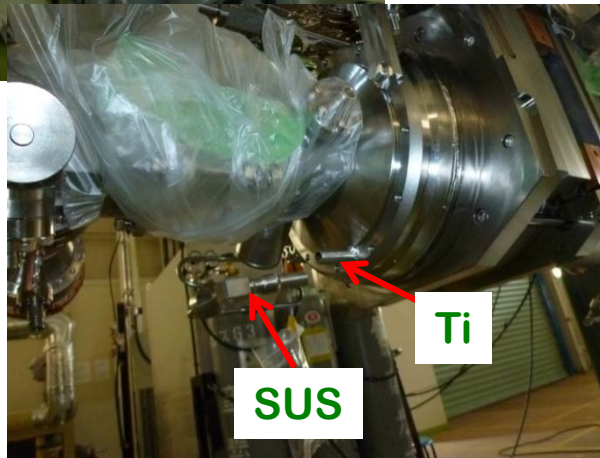


Spanner rods for  
Blade tuner (FNAL)



# Disassembly of Cryomodule-A in S1-G

Cutting 2K Pipes (Ti) by sawing machine



June 23, 2011

# Tools for Cutting of 2K Ti Pipe



Information from FNAL



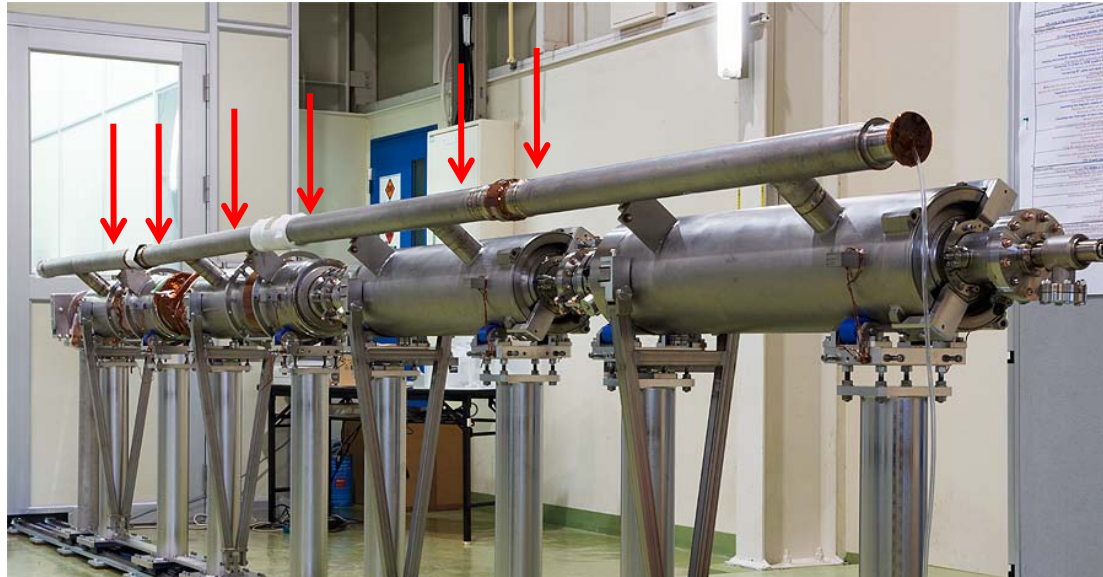
603SBCM

Information from DESY

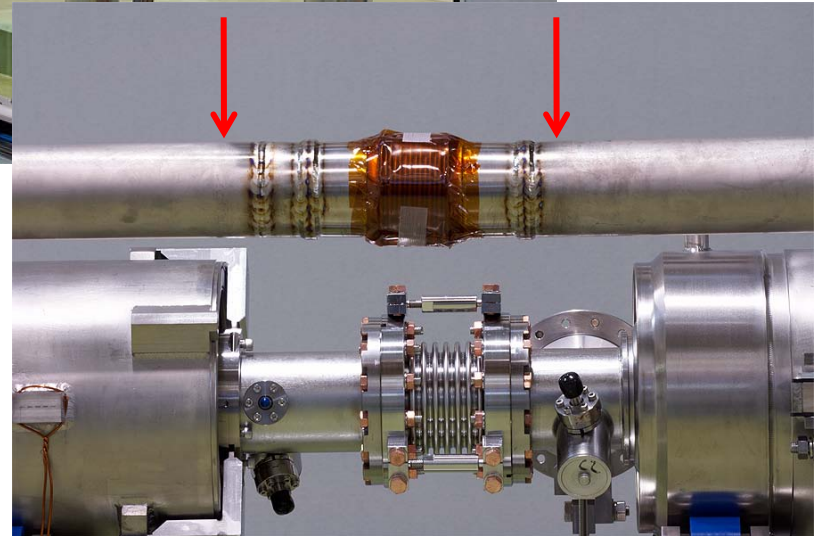
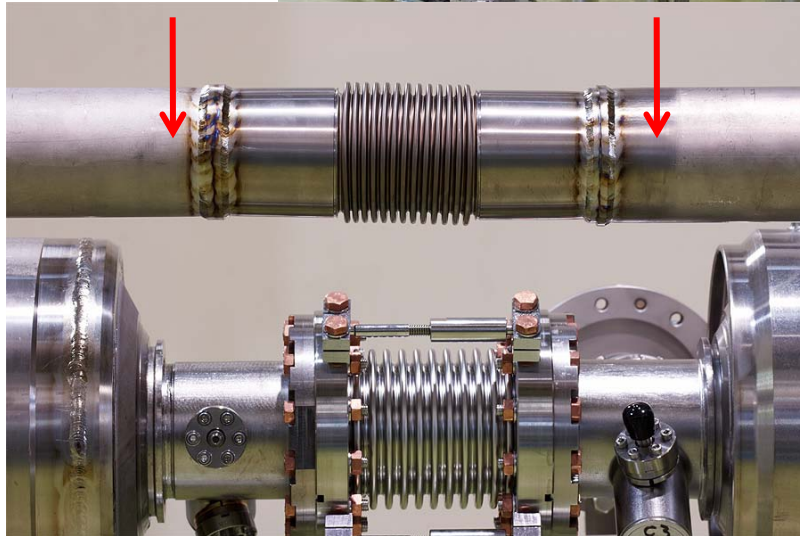
**If possible, KEK will purchase this cutting tool in Japan.**



# Location ? : Cutting of 2K Ti Pipe



Feb., 2010



# Other requests for disassembly work

- **To Rocco, Angelo and Yuriy;**  
If you need special tools for tuner disassembly, please send them.
- **To Tug;**  
Please send supporting jigs of warm couplers for transportation.

Tug, for the confirmation;  
please explain the disassemble procedure  
of string cavities in a clean room.

**Thanks for your collaborative work.**