

Assembly of QB Cryomodule & Disassembly of S1-G Cryomodule

Assembly/Disassembly Schedule at STF

Year	2011																																																											
Month	4			5			6			7			8			9			10			11			12																																			
Date	4	11	18	25	2	9	16	23	30	6	13	20	27	4	11	18	25	1	8	15	22	29	5	12	19	26	3	10	17	24	31	7	14	21	28	5	12	19	26																					
Comments	G.W.															no Liq. He			IPAC11 at Spain			ERL11 at Tsukuba			2011. Sept 17 E. Kako (KEK)			TTC at Beijing																																
Q.B. Cryomodule	<p>Repare of Water Cooling Check of Klystron system Coupler Aging Preparation for CR work Assembly in clean room Tuner/Temp./RF meas. Assembly of cold mass Installation in STF tunnel Cool-down Experiment at 2K</p> <p>Repare of Water Cooling</p> <p>Klystron system</p> <p>#5, #6 Coupler Aging</p> <p>Preparation</p> <p>Clean room</p> <p>Tuner</p> <p>Cold-mass Assembly</p> <p>in STF Tunnel</p>																																																											
S1-G Cryomodule	<p>Disassembly in STF tunnel</p> <p>Cryomodule-A</p> <p>Cryomodule-C</p> <p>Couplers</p> <p>Cold-mass</p> <p>Tuners</p> <p>Cavities</p> <p>in STF tunnel</p> <p>Cryomodule-A</p> <p>Move to ground level</p> <p>Disassembly of cold mass</p> <p>Release from GRP</p> <p>Inspection of inner surface in 4 KEK cavities</p> <p>Cryomodule-C</p> <p>Coupler</p> <p>Cold-mass</p> <p>Tuners</p> <p>Cavities</p>																																																											

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)



Tuner assembly,
Oct. 12, 2011



Adjustment of HOM filter,
Oct. 13, 2011



Measurement of tuning frequency,
Oct. 13, 2011



Movement under He-GRP
Oct. 17, 2011

Assembly Status of QB Cryomodule (3)



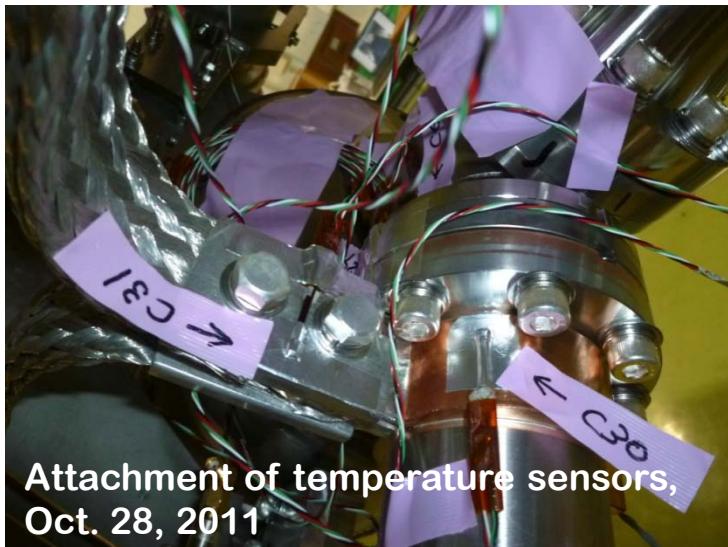
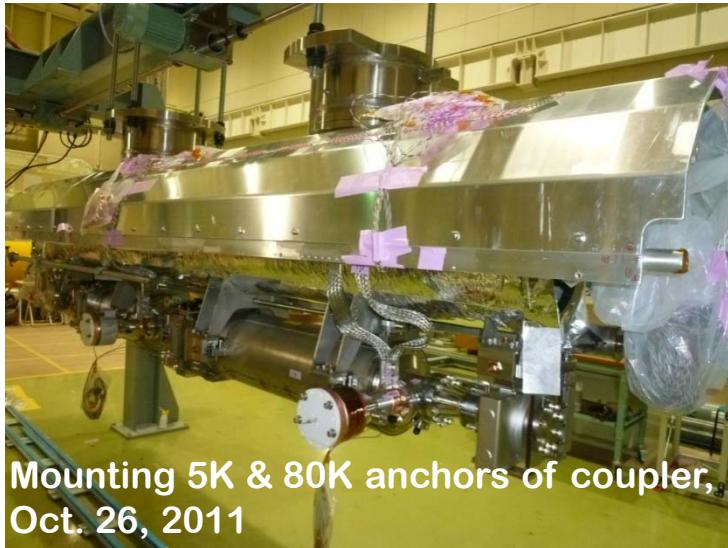
Alignment of cavities,
Oct. 18, 2011



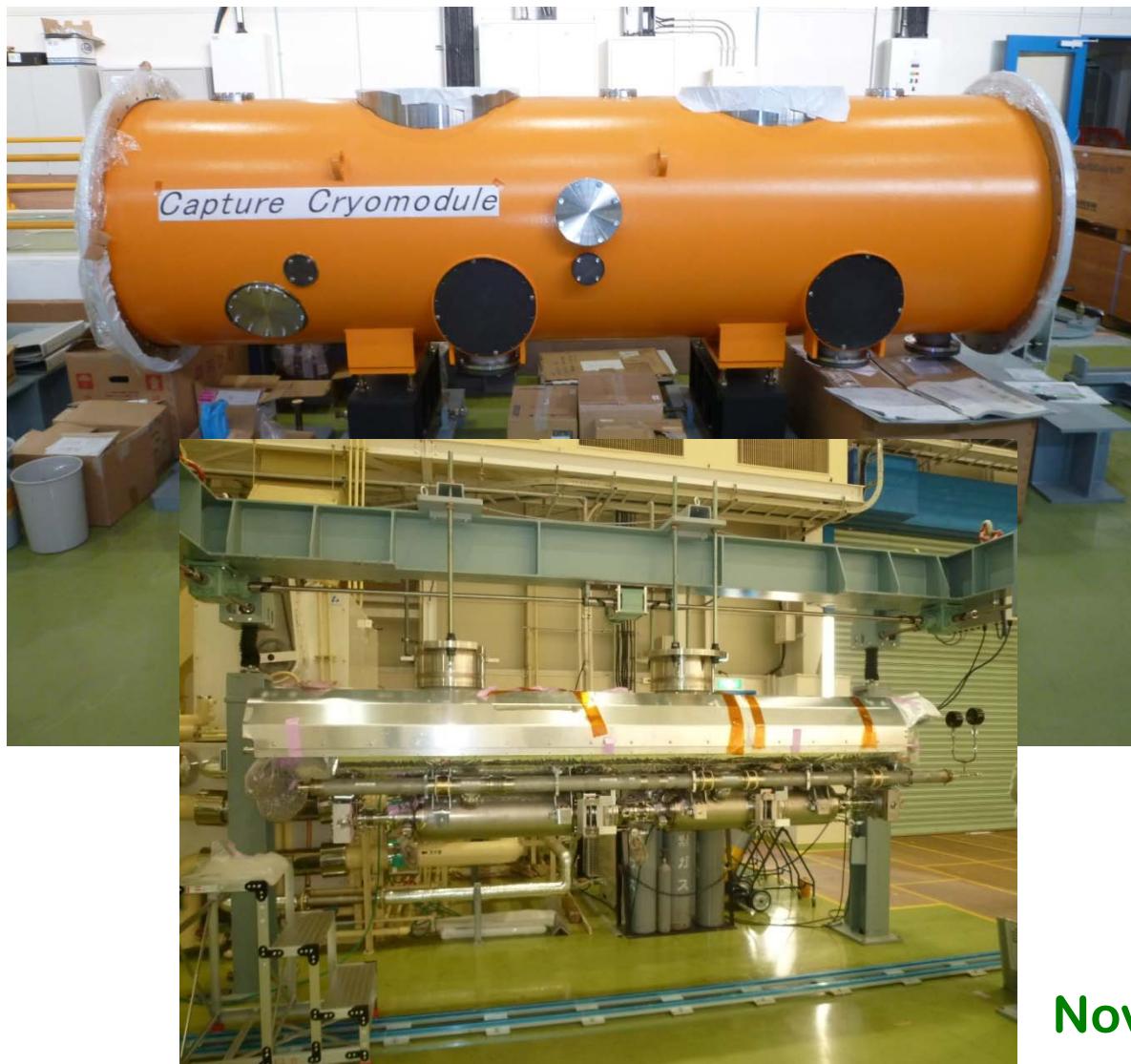
High pressure gas test,
Oct. 24, 2011



Assembly Status of QB Cryomodule (4)



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	9	10	11	12
		80K temp.-sensor & 80K shield, SI				
13	14	15	16	17 Installation Tunnel	18	19
		Insertion into vacuum vessel				
20	21	22 Cryomodule-C	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



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

Nov. 01, 2011



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	12 Denis/DESY
13	14	15	16	17 Installation QB cryomodule in tunnel	18	19
20	21 Pulling out of cold- mass, 80K/5K shield	22	23 勤労感謝の日	24 Disassembly of cold –mass (KEK)	25	26 Nakai/KEK Kako/KEK
27	28 Disassembly of Mag.-shield, Check of tuners Dismount of tuners (INFN/FNAL)	29	30			Rocco/INFN Angelo/INFN Yuriy/FNAL

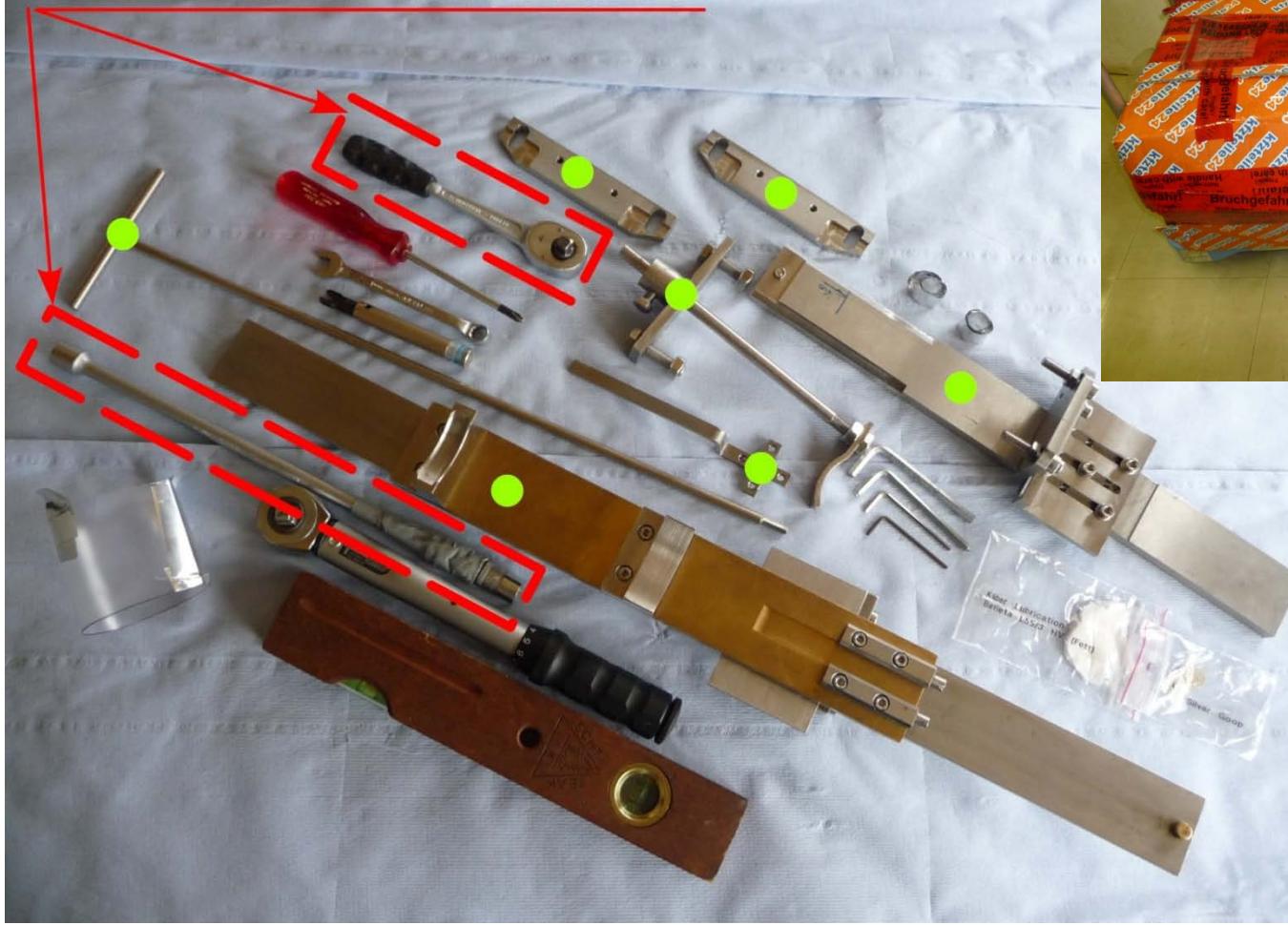
Disassembly plan of Cryomodule-C

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 Tug, Brian Marco, Mark /FNAL
18	19	20	21	22	23 天皇誕生日	24
25	26	27	28	29	30	31

Delivery of Coupler Disassembly Tools from DESY

metric screwdriver with extension M13



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

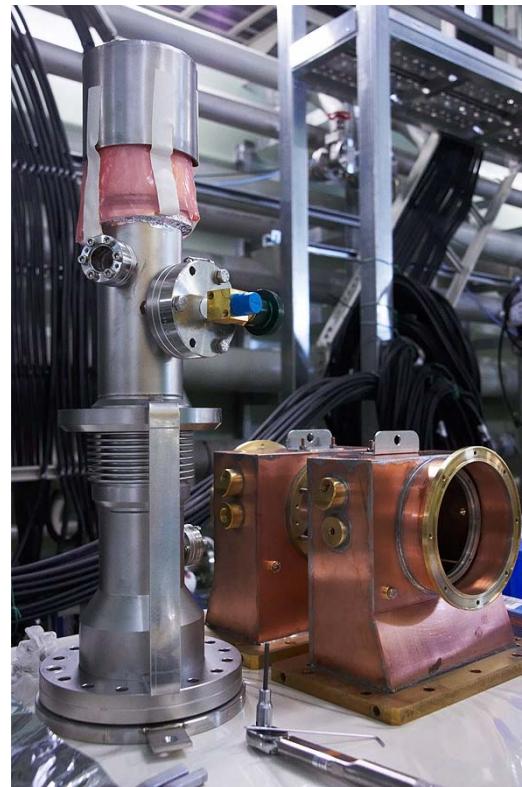


Jigs of Warm Couplers after dismounting



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



Spanner rods for
Blade tuner (FNAL)

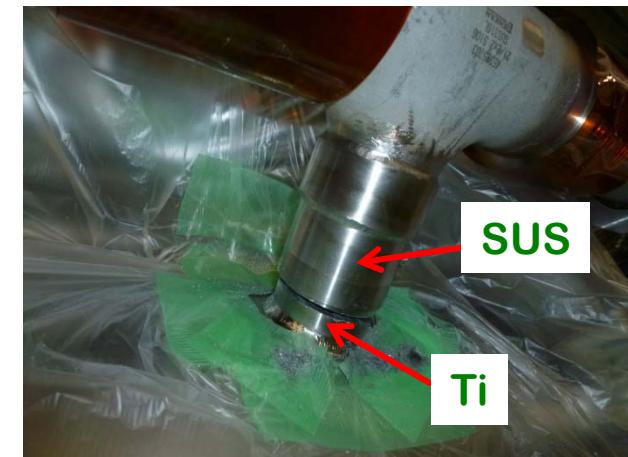
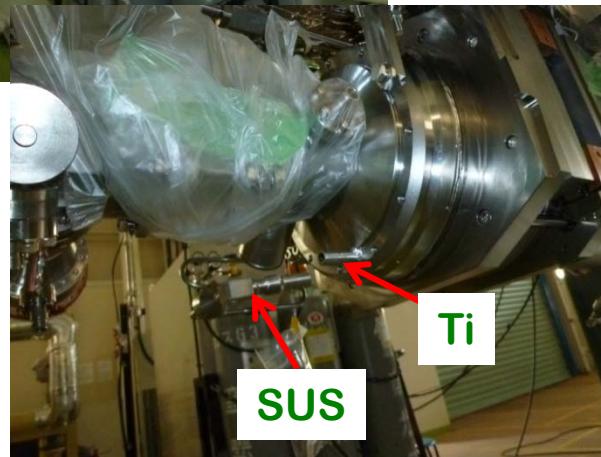
Arrival at
Oct. 27, 2011

Coupler support arms
for FNAL/DESY couplers



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

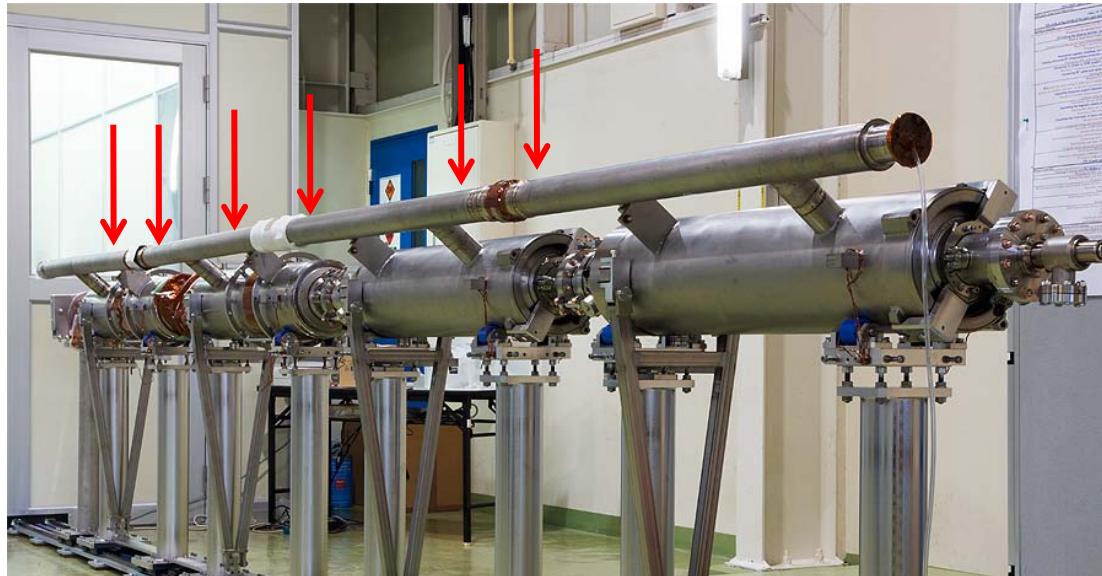


603SBCM

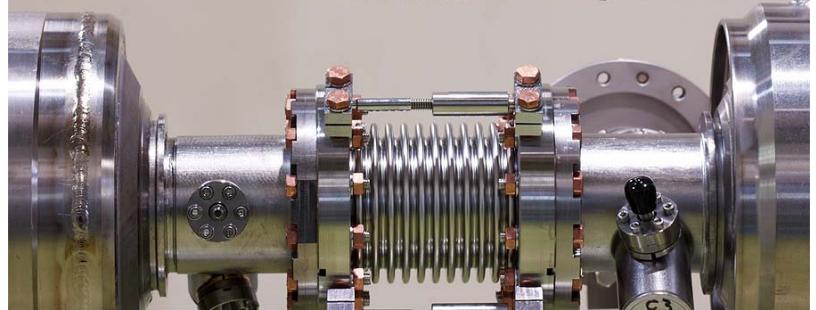
Information from DESY

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.