

2nd meeting of SRF subgroup in IDT/WG2

- ✓ New members of SRF subgroup
- ✓ Mission and schedule (again)
- ✓ Discussions
- ✓ Programs of SRF session in AWLC2020
- ✓ Others (if any)

Attendees: A. Yamamoto, A. Lankford, S. Michizono, H. Hayano, M. Ross, O. Napoly, D. Delikaris, N. C. Lasheras, B. List, S. Posen, R. Rimmer, R. Geng, M. Liepe, Kirk

<https://agenda.linearcollider.org/category/256/>

IDT-WG2 organization

Bi-weekly meeting: Sep.22, Oct. 6, ...

IDT WG2
Shin Michizono (Chair)
Benno List (Deputy)

Charges of Sub-groups

- Discuss the topics for
 - technical preparation (remaining topics) at Pre-lab
 - preparation for mass production at Pre-lab
 - possible schedule at Pre-lab
 - international sharing candidates of these activities
- Report to the IDT-WG2

All members belong to some sub-group(s).

SRF

Yasuchika Yamamoto	KEK
Dimitri Delikaris	CERN
Hitoshi Hayano	KEK
Olivier Napoly	CEA
Marc C. Ross	SLAC
Akira Yamamoto	KEK
Sam Posen	FNAL
Nuria Catalan	CERN
Robert Rimmer	JLAB
Rongli Geng	JLAB
M. Liepe	Cornell

newly added after 1st meeting

DR/BDS/Dump

Toshiyuki Okugi	KEK
Philip Burrows	U. Oxford
David L. Rubin	Cornell
Nikolay Solyak	FANL
Nobuhiro Terunuma	KEK
Kaoru Yokoya	KEK
Jenny List	DESY
Thomas Markiewicz	SLAC
Luis Garcia Tabares	CIEMAT

Sources

Kaoru Yokoya	KEK
Hitoshi Hayano	KEK
Masao Kuriki	U. Hiroshima
Benno List	DESY
Gudrid Moortgat-Pick	U. Hamburg
Joe Grames	JLAB

Technical preparation etc. will be discussed in bi-weekly sub-group meeting.

Civil engineering

Nobuhiro Terunuma	KEK
John Andrew Osborne	CERN
Tomoyuki Sanuki	U. Tohoku

2nd meeting of SRF subgroup in IDT/WG2

Mission of SRF subgroup in IDT/WG2

- ◆ List work items in ILC preparation period
 - ◆ Plug-compatibility of design to be re-confirmed/re-established
 - ◆ Mass production
 - ◆ Global CM transfer
 - ◆ Any other?
- ◆ List technical concerns (if any)
 - ◆ Although E-XFEL has been successfully constructed and operated (and LCLS-II also in progress), are there any concerns for ILC to be constructed in Japan?
 - ◆ High pressure gas (HPG) regulation to be globally handled
 - ◆ In Japan, IFMIF (@Rokkasho) requested CM construction to EU (satisfied with HPG regulation)
 - ◆ Contents specialized in Japan?
- ◆ List human resources/budget/schedule for each work item and in each region/lab.
 - ◆ Necessary to discuss how to share each work item for each region/lab.

Pre-Lab schedule (translated into table)

	Technical preparation period (Fiscal year)			
Items	1	2	3	4
Cost down R&D	→			
Cost estimation based on TDR	→			
Review		Internal	External	
Engineering design report	Writing →		Draft	Publish
Prototyping of critical items			→	
Preparation for mass-production line			→	
Global CM transfer	fabrication →	CM assembly/Cold test →	Global CM transfer/Cold test in Japan →	

We have to fit the SRF schedule to this overall schedule!

Schedule of SRF subgroup meeting in IDT/WG2

Meeting #	Date	Contents
1	29/Sep/2020	introduction, member list, schedule/work items in technical preparation, discussions
2	13/Oct/2020	New member, discussions on how many cavities/CMs to be produced, AWLC2020
	19~22/Oct/2020	AWLC2020 on virtual
3	27/Oct/2020	
4	10/Nov/2020	
5	24/Nov/2020	
6	8/Dec/2020	
7	22/Dec/2020	Draft of sharing work items in technical preparation period
?	12/Jan/2021?	
	Feb/2021	First draft of budget request in each region/lab., Submission to WG1/EB
		Preparation for MOU between/among laboratories
	Jun~Jul/2021	Submission of budget request to MEXT, in case of Japan

Technical preparation of SRF (only 4 years!)

- ❑ Mass production satisfied with the ILC spec.
 - ❑ 9-cell cavity production by cost effective method (to be discussed true number)
 - ❑ Production to be demonstrated during the Preparation Phase (Japan: 50 cavities, Others: 50 cavities)
 - ❑ RF performance, and success yield to be evaluated, under plug-compatible fabrication conditions
 - ❑ Surface treatment to be discussed (see next slide)
 - ❑ Ancillaries production (power coupler, tuner, HOM antenna, etc.)
 - ❑ Cryomodule (CM) production (Prototype, Type A, Type B)
- ❑ Global CM transfer
 - ❑ After surface (sea/marine) transportation, CM test to be done to confirm legal process in high-pressure code and RF performance in Japan (maybe in others)
 - ❑ After CM test, CM may return to home country

In case of Japan;

- ❑ Construction of hub-laboratory for mass production
- ❑ Demonstration of beam acceleration satisfied with ILC spec.

Any other items?

Remarks:

- Necessary cost should be considered **based on TDR**.
- Another important point is that new technology (fabrication/surface treatment) is **reliable**.

How many cavities are produced for mass production?

Discussion item

We can refer Volume 3 Part 1 in TDR.

At that time, **16** 9-cell cavities (out of > 50 cavities, **recognized as identical in fabrication and surface process**) were used to evaluate cavity performance.

In the preparation phase, **at least ~ 20 or much more cavities are necessary** to evaluate recent surface treatment method including fabrication method much advanced since TDR.

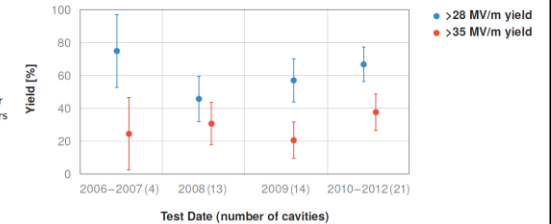
Not only surface treatment method but also what type of Nb material/fabrication method is used has to be discussed.

Table 2.6
Processing and handling of high-purity niobium cavities

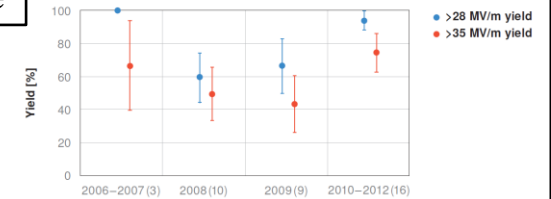
- Light BCP etching (10 μm)
- Heavy EP (100-120 μm)
- Post-heavy-EP cleaning
- Vacuum-furnace outgassing (800 °C for 2 h)
- RF tuning by no-touch bead-pull
- Light EP (25 μm)
- Post-light-EP cleaning
- First HPR 3 passes (~ 6 h)
- First clean room assembly
- Final HPR 3 passes (~ 6 h)
- Final clean-room assembly
- Leak checking
- In-situ baking at 120 °C for 48 h

Treatment method in TDR

Figure 2.19
Cavity yield for two gradient thresholds as a function of years, based on the global ILC cavity database updated as of October 2012 [67, 68]. Numbers in parentheses refer to cavity sample size. The cavities received standard treatment and were provided by established vendors.



History of cavity performance



When we evaluate success yield of cavity performance, each region/lab. has to select one method of fabrication and surface process. But, we don't need world-unified method of fabrication and surface process.

Helium tank/tuner are not necessary for this evaluation

# of cavities	Japan (/Asia)	Americas	E.U.
w/o helium tank/tuner	20	20	20
w/ helium tank/tuner			

How many cryomodules are produced for mass production?

ILC needs two types of cryomodules; Type A and Type B.

Any laboratory has never produced same types of CM as ILC.

High pressure gas regulation of Japan should be also satisfied for ILC.

As first step, each region produces **one prototype CM** (not necessary for conforming high pressure gas regulation).

Type B is preferred, as it includes systems of SC-Q magnet/cold BPM. Prototype CM is produced and tested in each region.

As second step, each region produces **at least one CM conforming high pressure gas regulation of Japan**.

That CM (Type B is preferred) is produced and tested in each region. If possible, Type A can be also produced.

As final step, each region carries out **global CM transfer to Japan**. CM produced in second step is available.

Discussion item

Table 3.1
Summary of key numbers for the SCRF Main Linacs for 500 GeV centre-of-mass-energy operation. Where parameters for positron and electron linacs differ, the electron parameters are given in parenthesis.

<i>Cavity (nine-cell TESLA elliptical shape)</i>		
Average accelerating gradient	31.5	MV/m
Quality factor Q_0	10^{10}	
Effective length	1.038	m
R/Q	1036	Ω
Accepted operational gradient spread	$\pm 20\%$	
<i>Cryomodule</i>		
Total slot length	12.652	m
Type A	9 cavities	
Type B	8 cavities	1 SC quad package
<i>ML unit (half FODO cell)</i>		
(Type A - Type B - Type A)	282 (285)	units
<i>Total component counts</i>		
Cryomodule Type A	564 (570)	
Cryomodule Type B	282 (285)	
Nine-cell cavities	7332 (7410)	
SC quadrupole package	282 (285)	
Total linac length – flat top.	11027 (11141)	m
Total linac length – mountain top.	11072 (11188)	m
Effective average accelerating gradient	21.3	MV/m
<i>RF requirements (for average gradient)</i>		
Beam current	5.8	mA
beam (peak) power per cavity	190	kW
Matched loaded Q (Q_L)	5.4×10^6	
Cavity fill time	924	μs
Beam pulse length	727	μs
Total RF pulse length	1650	μs
RF-beam power efficiency	44%	

# of cavities/couplers/CMs	Japan (/Asia)	Americas	E.U.
Cavity	16 + spare	16 + spare	16 + spare
Power coupler	16 + spare	16 + spare	16 + spare
Cryomodule	2	2	2

Work packages of SRF at ILC (it's too early!)

Item	Brief description
1.3 GHz Cavities	Order/fabrication, preparation , surface treatment, VT
Power couplers	Order/fabrication, preparation, assembly, high power test
HOM couplers	Order/fabrication, tuning
Frequency tuners incl. piezo	Order/fabrication,
Cavity string assembly	Overall works in clean room
Cryomodules	Order/fabrication, assembly incl. waveguide system (preparation by HLRF), cold test
Cold vacuum incl. HOM damper	Beamline connection of CM-to-CM, Pumping systems, Open/close gate valves
SC Q/D-magnet + BPM Systems	Order/fabrication, test
Alignment	Cavity-to-cavity, Cavity-to-CM, CM-to-CM
3.9 GHz Cavity System	For bunch compression in injector, Same type as E-XFEL/LCLS-II
650 MHz Cavity System	For damping ring, KEKB type?
Crab Cavity System	For head-on collision, Design not fixed, Discussion is necessary with BDS group
High Level RF System	Klystron, modulator, waveguide, dummy load, variable hybrid, phase shifter, circulator?
Low Level RF System	Construction of control systems incl. feed-forward/feed-back (closed-loop operation)
Cryogenics	For VT and module test, He/N ₂ line connection in tunnel
Global CM transfer	CM transfer to Japan by ship
High pressure gas regulation	To satisfy Japanese law
Installation	CM installed into accelerator tunnel
Machine protection (?)	Performance degradation, dark current, radiation security, etc.

Program of SRF session in AWLC2020

Date: 20~22/Oct

Conveners: Marc Wenskat (Univ. Hamburg), Sam Posen (FNAL), Kirk Yamamoto (KEK)

- Almost all slots are occupied (19/20), we are waiting for last piece
 - If no response, we will send the program to every presenter tomorrow
- Alternate host in zoom meeting is necessary?
 - Kirk has one account of zoom in KEK
 - Sam has one account in FNAL

Date	Slot #	#	Time	Presenter Date	Presenter time	Presenter	Affiliation	Talk time [min]	Presentation	Status	Preliminary title
20/Oct	1	1	7:00		16:00	Nick Walker	DESY	15	remote	confirmed	Operational Experience with the European XFEL
	2	2	7:15		9:15	M. Checchin	FNAL	15	remote	confirmed	LCLS-II HE
	3	3	7:30		9:30	G. Wu	FNAL	15	remote	confirmed	PIP-II
	4	4	7:45		10:45	R.-L. Geng	J-LAB	15	remote	confirmed	low surface field (LSF) 9-cell cavity, which has achieved 50 MV/m in some but not all cells
21/Oct	1	5	7:00		23:00	T. Dohmae	KEK	15	remote	confirmed	Current status report in KEK/CFF (early time expected)
	2	6	7:15		23:15	T. Saeki	KEK	15	remote	confirmed	Nb material: Nb disk directly sliced from forged ingot
	3	7	7:30		9:30	Y. Pischalnikov	FNAL	15	remote	confirmed	tuner review and some suggestion for improvement
	4	8	7:45		16:45	D. Kostin	DESY	15	remote	confirmed	Experience with the XFEL RF Couplers
	5	9	8:00		17:00	S. Berry	IRFU/CEA	15	remote	confirmed	CEA last development about cleaning robots in clean room
	6	10	8:15		17:15	M. Wenskat	Univ. Hamburg	15	remote	confirmed	optical inspections during cavity fabrication
	7	11	8:30		11:30	Kellen McGee	M.S.U.	15	remote	confirmed	on-going effort to maximize performance on 644MHz cavities for the possible FRIB upgrade
	8	12	8:45		11:45	Sang Hoon Kim	M.S.U.	15	remote	confirmed	Lesson learned from FRIB low-beta cryomodules and development of new medium-beta cavity and subsystems for FRIB energy upgrade
22/Oct	1	13	7:00		23:00	R. Katayama	KEK	15	remote	confirmed	High-Q/High-G R&D of SRF cavities by applying 2-step baking at KEK
	2	14	7:15		22:15	J. Zhai	IHEP	15	remote	confirmed	High Q high gradient cavity R&D in IHEP
	3	15	7:30		10:30	A. Palczewski	J-LAB	15	remote	confirmed	A novel approach to flux expulsion analysis without the need of a single cell cavity
	4	16	7:45		10:45	R. Porter	CORNELL	15	remote	confirmed	Nb3Sn
	5	17	8:00			?	?	15	remote	not confirmed	?
	6	18	8:15	23/Oct	0:15	A. Yamamoto	KEK	15	remote	confirmed	An R&D proposed for ILC ML-CM SCM sustainable under the dark-current energy absorption
	7	19	8:30		8:30	S. Gessner	SLAC	15	remote	confirmed	Advanced Accelerator Upgrade Paths for the ILC
	8	20	8:45	23/Oct	0:45	Kirk Yamamoto	KEK	15	remote	confirmed	Introduction of activity of IDT/WG2 SRF subgroup

Questions/Discussions/Comments (memorandum) @ 2nd meeting

Translation by Kirk

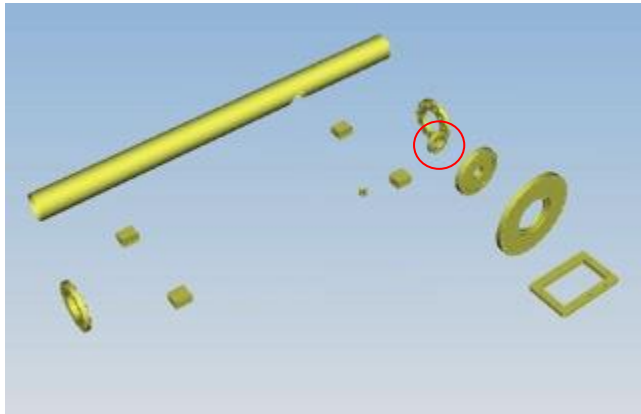
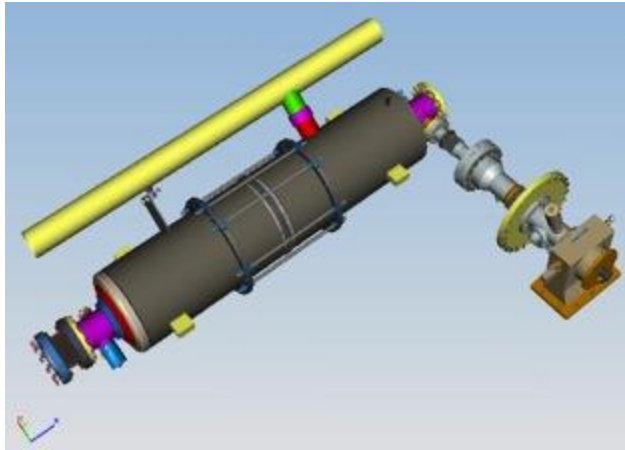
- CM production
 - Existing CM or New CM?
 - In Japan, before production, we have to discuss with KHK (authority of high pressure gas in Japan)
 - During production, inspection by KHK is necessary
- CM transfer
 - Shipping/High pressure gas regulation can be separated
 - Also rechecking cavity performance after shipping
- No cavity vendor in U.S., but same process as LCLS-II can be used
- How many cavities are produced? 20 at minimum. It depends on budget.
- Fabrication (incl. Nb material)/surface treatment to be discussed
- In TDR, second pass was available. How many times in surface treatment is available? It also depends on cost, and to be discussed.
 - Reliability
 - Cost-effectiveness
- Same method of fabrication and surface treatment as technical preparation period has to be used in construction of ILC
- Global CM transfer among Japan/U.S./EU to be discussed (Japan → U.S./EU?)
 - For fair international collaboration
- There are strict rules in high pressure gas regulation of Japan
 - It may take longer time to solve this
- How many prototypes do we need?
 - No prototype CM in LCLS-II → The construction started immediately (some of existing cavities are used)
 - Three prototype CMs in E-XFEL (PXFEL series)

References

- KEK homepage
 - <https://www2.kek.jp/ilc/en/>
- Technical Design Report
 - ?
- ILC Action Plan
 - <https://www.kek.jp/ja/newsroom/2016/01/06/1400/>
 - <https://www.kek.jp/ja/newsroom/2018/04/24/1200/>
- Recommendations on ILC Project Implementation
 - https://www.kek.jp/ja/newsroom/attic/20191001_%20ILC%20Project.pdf

Backup slides

Plug-compatible Conditions



Item	Variation	TDR Baseline
Cavity shape	TESLA / LL	TESLA
Length		Fixed
Beam pipe flange		Fixed
Suspension pitch		Fixed
Tuner	Blade/ Slide-Jack	Blade
Coupler flange (cold end)	40 or 60	40 mm
Coupler pitch		Fixed
He -in-line joint		Fixed

Plug-compatible interface established, in TDR, 2013

Accelerator activities at ILC Pre-lab phase

Technical preparations /performance & cost R&D [shared across regions]

- SRF performance R&D
- Positron source final design and verification
- Nanobeams (ATF3 and related): Interaction region: beam focus, control and Damping ring: fast kicker, feedback
- Beam dump: system design, beam window, cooling water circulation
- Other technical developments considered performance critical

Technical preparation

Final technical design and documentation [central project office in Japan with the help of regional project offices (satellites)]

- Engineering design and documentation, WBS
- Cost confirmation/estimates, tender and purchase preparation, transport planning, mass
- Site planning including environmental studies, CE, safety and infrastructure (see below for details)
- Review office
- Resource follow up and planning (including human resources)

Engineering Design Report (EDR)

Preparation and planning of deliverables [distributed across regions, liaising with regional project office and/or its satellites]

- Prototyping and qualification in local industries and laboratories, from SRF production lines to individual WBS items
- Local infrastructure development including preparation for the construction phase (including Hub.Lab)
- Financial follow up, planning and strategies for these activities

Mass-production

CE, local infrastructure and site [host country assisted by selected partners]

- Engineering design including cost confirmation/estimate
- Environmental impact assessment and land access
- Specification update of the underground areas including the experimental hall
- Specification update for the surface building for technical scientific and administrative needs

Civil engineering

Pre-lab schedule

1st year: TDR-based **estimate confirmation** work started by an international team centered on the Pre-lab.

2nd year: Estimate tabulation work, **internal review** in the latter half of the 2nd year. The review also reports on the progress of technical issues during the preparation period.

3rd year: Conducted an **external review** and completed scrutiny of costs and risks (this is the end of incorporating cost reduction R & D). Completion of **draft of engineering design report (EDR)**. **Prototyping** of critical items. Preparing **mass-production line**.

4th year: **EDR publishing (first half)**, report on progress on technical issues, preparation work for each large bid. **Prototyping** of critical items. Preparing **mass-production line**.

IDT WG2 timeline



Example (towards Pre-lab)

- 2022 April: Pre-Lab starts
- 2021 Dec.: IDT ends
- 2021 Feb.: First draft of budget request (each region/lab.)
- 2020 Dec.: Draft of sharing remaining technical preparation/pre-lab preparation (each region/lab.)
- 2020 Oct.: AWLC
- 2020 Oct.: Information sharing about **technical preparation and updating the list**
- 2020 Sep.: List of Pre-lab acc. activities/ **Human resources/ budget/** schedule

**2021, Submission of budget request in each region/lab,
(2021, early Summer: Submission of budget request to MEXT, in case of Japan)**

Materials for Pre-lab human resources, budget, technical preparation

- KEK ILC action plan (Jan. 2018, KEK)

https://www.kek.jp/en/newsroom/KEK-ILC_ActionPlan_Addendum-EN%20%281%29.pdf

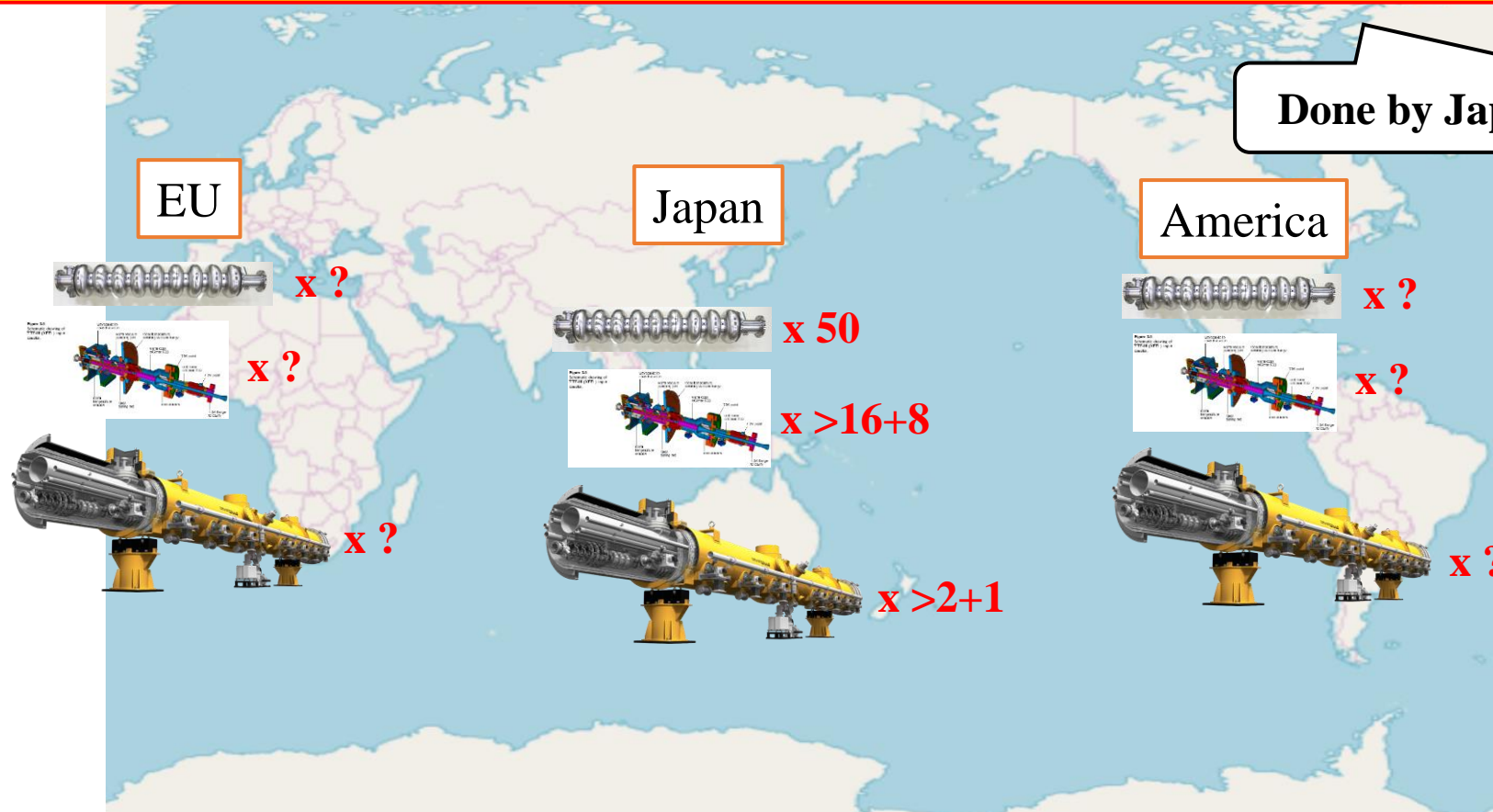
- “Recommendations on ILC Project Implementation” (Oct. 2019, KEK)

<https://www.kek.jp/en/newsroom/2019/10/02/1000/>

* Both materials are based on KEK estimate.

Mass production

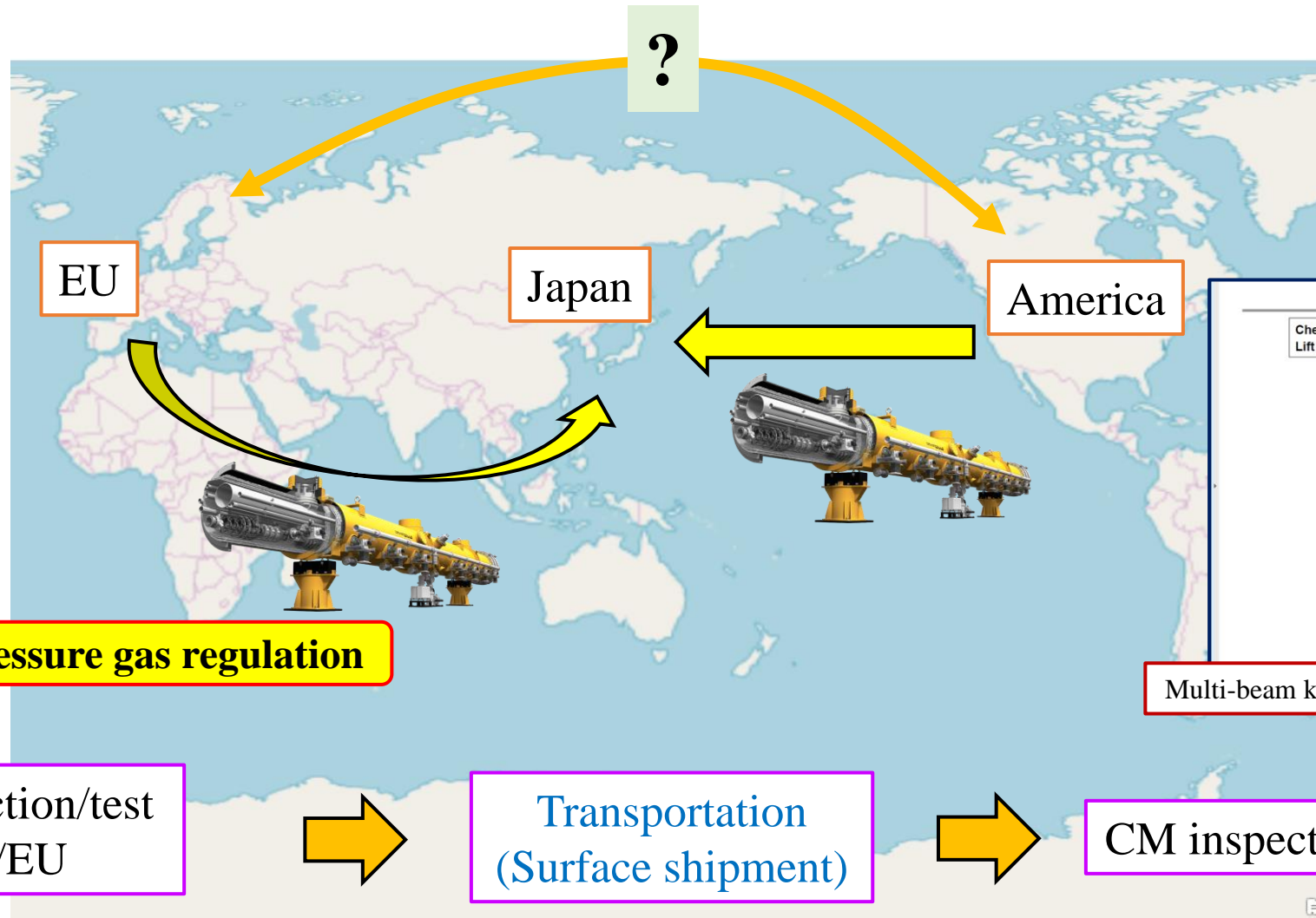
Before mass production starts, tuner design should be fixed!!



Done by Japan-U.S. collaboration

Which lab. is responsible for cavity, power coupler, tuner, CM, etc.?
How many cavities, couplers, CMs are produced?

Cryomodule transportation from overseas



Note: Returning the CMs to Europe/Americas for redundant confirmations, to be discussed.

In case of Japan (KEK)...

STF



Demonstration of beam acceleration satisfied with ILC spec.

Infrastructure upgrade for hub-lab. is mandatory!

COI



Mass production of CM

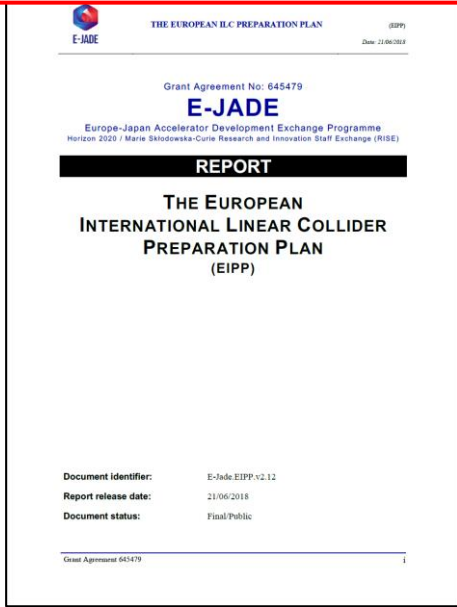
CFF



Mass production of cavity

Contribution from each lab. (case of E-JADE)

Kirk will make template table after discussion with Michizono-san and Akira Yamamoto-sensei. Please wait a minute!



Item/topic	Brief description	CERN	France C	Germany D	Time line
SCRF	Cavity fabrication including forming and EBW technology,	✓			2017-18
	Cavity surface process: High-Q & -G with N-infusion to be demonstrated with statics, using High-G cavities available (# > 10) and fundamental surface research		✓	✓	2017-18
	Power input-coupler: plug compatible coupler with new ceramic window requiring no-coating	✓			2017-19
	Tuner: Cost-effective tuner w/ lever-arm tuner design	✓	✓		2017-19
	Cavity-string assembly: clean robotic-work for QA/QC.		✓		2017-19
Cryogenics	Design study: optimum layout, emergency/failure mode analysis, He inventory, and cryogenics safety management.	✓			2017-18
HLLRF	Klystron: high-efficiency in both RF power and solenoid using HTS	✓			2017- (longer)
CFS	Civil engineering and layout optimization, including Tunnel Optimization Tool (TOT) development, and general safety management.	✓			2017-18
Beam dump	18 MW main beam dump: design study and R&D to seek for an optimum and reliable system including robotic work	✓			2017- (longer)
Positron source	Targetry simulation through undulator driven approach			✓	2017-19
Rad. safety	Radiation safety and control reflected to the tunnel/wall design	✓			2017 - (longer)

- SRF sub-groups need to make similar table for each region (Asia, America).
- Addition to these items, some new contents need to be added to the table.
 - CM transportation, automation, etc.
- And, budget, human resources...

Table 1: Current common studies between European institutions and Japan relevant for ILC.

KEK starts development of automation technique

	Germany DESY	France CEA Saclay	LAL	Italy INFN Milan	IFJ PAN	Poland WUT	NCBJ	Russia BINP	Spain CIEMAT
Linac									
Cryomodules	✓	✓		✓					
SCRF Cavities	✓			✓					
Power Couplers	✓		✓						
HOM Couplers							✓		
Frequency Tuners	✓								
Cold Vacuum	✓							✓	
Cavity String Assembly	✓	✓							
SC Magnets	✓				✓				✓
Infrastructure									
AMTF	✓				✓			✓	
Cryogenics	✓								
Sites & Buildings									
AMTF hall	✓								

	Germany DESY	France CEA	IPNO	Italy Elettra	INFN-LASA	Poland IFJ-PAN	Spain ESS Bilbao	Sweden ESS	Uppsala	UK STFC
RF systems				✓			✓	✓		
LLRF									✓	
Cryomodules		✓	✓							
SCRF Cavities		✓	✓		✓					✓
Power Couplers		✓	✓							
HOM couplers										
Frequency Tuners		✓	✓							
Cold Vacuum		✓	✓					✓		
Cavity String Assembly		✓	✓							
RF Tests (Cavities)	✓									✓
RF Tests (Cryomodules)		✓	✓			✓		✓	✓	

Table 2: Responsibility matrix for cryomodule production and testing for the European XFE

Table 3: Responsibility matrix for the cryomodule production and testing for the ESS.

Questions/Discussions/Comments (memorandum) @ 1st meeting

Translation by Kirk

- Surface treatment
 - Which surface treatment method (EP, HT) is selected in mass production?
 - Surface treatment method is flexible, rather, plug-compatible design of cavity package should be fixed
 - To investigate yield rate, same method should be used. One method in each region (Japan, US, EU)?
 - Always think about which method is used in mass production (performance, cost effective)
 - Choice as advanced technology should be left, even though new method does not work well at present
- Power coupler
 - Power coupler needs a lot of improvements for ILC
 - D. Kostin will present those issues and some suggestions in AWLC2020
- CM transportation
 - 13 CMs will be transferred from EU to US by plane in PIP-II (2023-2024?)
 - CM of ILC needs very large cage for marine transportation. After arrival at Japan, the cage may be sent back.
 - Cost of aerial transportation is much higher than marine
 - Cost of marine transportation is included into budget of each region
 - Design of cage and supporting jigs is necessary
 - “CM transportation” is not appropriate, then ”Global CM transfer” is better?
- Necessary to fix design of tuner/coupler until second year of technical preparation phase when technical review is done
- Additional membership (Michizono-san discussed with Andy and Steiner)
- Budget request of SRF including technical preparation
 - Budget request of subgroup → WG1 → each laboratory → Conclusion of MOU
 - Mass production and Global CM transfer should be summarized to one page for each until end of this year
 - Preparation for conclusion of MOU after Feb/2021
- Introduction of activity of SRF subgroup will be presented in AWLC2020
- Request to upload meeting slide on INDICO