

A.Staiano CERN 4 apr 2002

CMS-DT Field Strip Plates Manufacturing (Torino + Dubna)

Updates on:

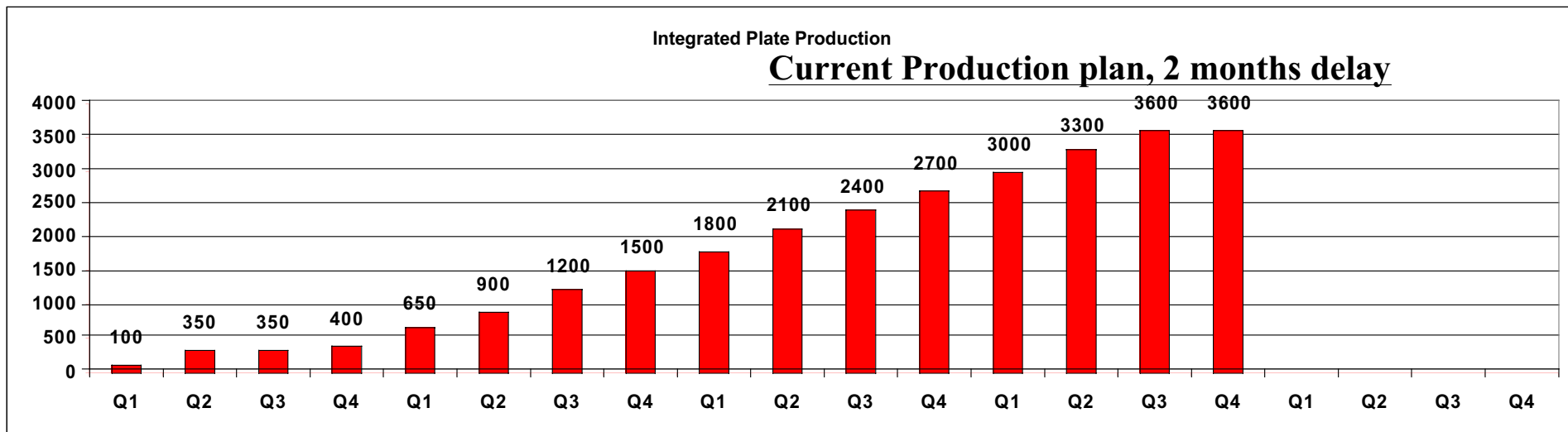
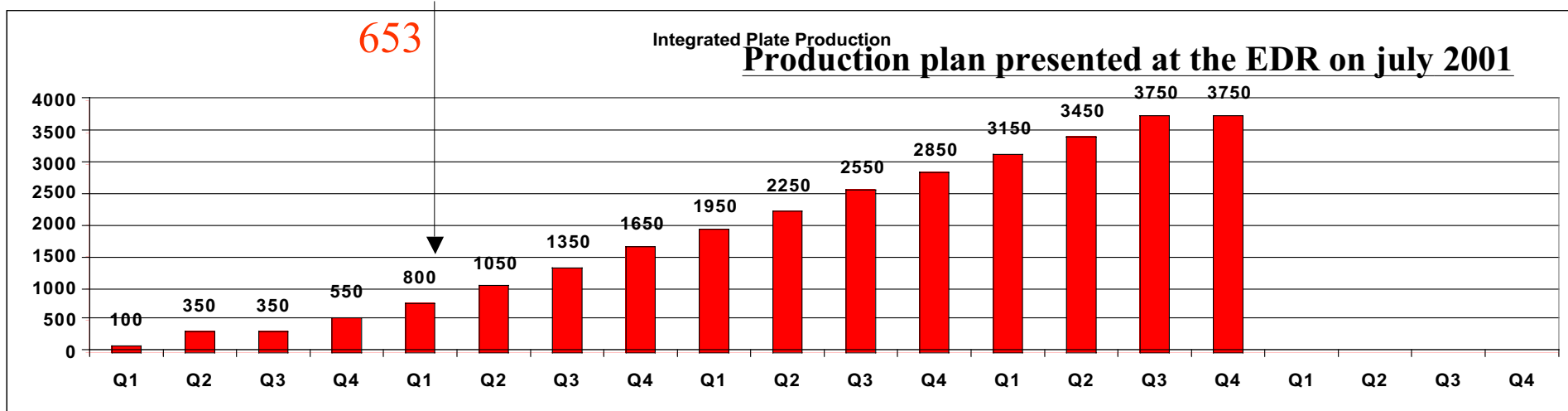
- Dubna Production
- Material Procurement

Dubna Production

Box Type	N. Plates	N. Chambers	N.Surfaces	Place	Manufactured	Delivered	N.Chambers manufactured
MB1-Torino/1	30	2	48	Aachen	☺	6/6/2001	
MB1-Torino/2	30	2	48	Aachen	☺	6/6/2001	
MB1-Torino/3	30	2	48	Aachen	☺	6/6/2001	
MB1-Dubna/1	30	2	48	Aachen	☺	8/29/2001	
MB1-23-01-02	34	2	54	Aachen	☺	2/26/2002	
MB1-4-3-02/1	45	3	96	Dubna	☺	3/4/2002	
MB1-4-3-02/2	45	3	96	Dubna		3/4/2002	
MB1_1-05-02/1	45	3	96	Torino			13
MB2-Torino/1	30	2	48	Madrid	☺	3/15/2001	
MB2-Torino/2	30	2	48	Madrid	☺	4/15/2001	
MB2-Torino/3	30	2	48	Madrid	☺	5/15/2001	
MB2-Torino/4	30	2	48	Madrid	☺	5/15/2001	
MB2-Torino/5	30	2	36	Madrid	☺	12/15/2001	
MB2-Dubna/1	30	2	60	Madrid	☺	10/15/2002	
MB2-23-01-02/1	30	2	48	Madrid	☺	1/23/2002	
MB2-23-01-02/2	30	2	48	Madrid	☺	1/23/2002	
MB2-4-3-02/1	30	2	48	Dubna	☺	3/4/2002	
MB2-4-3-02/2	30	2	48	Dubna		3/4/2002	
MB2-1-5-02/1	30	2	48	Torino		3/4/2002	
MB2-1-5-02/2	30	2	48	Torino		3/4/2002	18
MB3-Torino/1	15	1	24	Legnaro	☺	3/30/2001	
MB3-Torino/2	45	3	72	Legnaro	☺	5/30/2001	
MB3-Torino/3	30	2	48	Legnaro	☺	6/30/2001	
MB3-Dubna/1	30	2	48	Legnaro	☺	2/18/2002	
MB3-Dubna/2	30	2	48	Legnaro	☺	2/18/2002	
MB3-23-01-02	34	2	54	Dubna	☺	1/23/2002	
MB3-4-3-02/1	45	3	96	Dubna		3/4/2002	
MB3-4-3-02/2	45	3	96	Dubna		3/4/2002	
MB3_1-05-02/1	45	3	96	Torino			12

Status on 5-4-2002 17.2% of production after 1 year from production start in Torino
(5 months break for prod. line transportation) 653 plates produced, 39 chambers

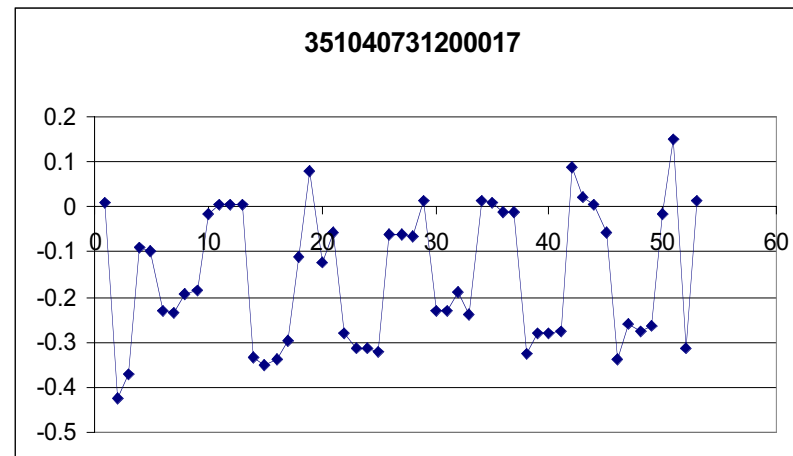
Dubna Production



Production plan presented at the EDR on July 2001. **653/800** plates produced with respect to the official schedule. The delay is mainly due to the installation time (2 months). Slope unchanged.

Dubna Production

- Production in Dubna ok, **peak production 8.6 plates/day** (5.5plates/day minimum rate to provide plates to 4 production sites producing 2 chambers/month), **average rate 4.6 plates/day** since production beginning (29 nov. 2001), **5.5 plates/day in the last month**. Customs related problems fully solved.
- Limitation rates:
 - metal particles in JINR lab. Cause frequent HV problems. Production sites should carefully monitor HV and give us feedback. Do strips get damaged after transportation? JINR people is studying these particles to identify the source and cure the problem.
 - present head working with strip deposition inefficiency of 10% and s-shape at strip limits. New head designed and presently being assembled in Torino. Installation in Dubna beginning of june.
- Strip position: systematic misplacement of **~-0.2mm** detected in Padova (to be cured with left/right spacers). Strip accuracy better than **0.1mm**.



Dubna Production

- Schedule: since last phone conference we changed the date of the last transportation from 17-6-02 to 24-6-02 due to new head installation time. Extra shifts foreseen in the period 17-6-02 to 14-7-02.

Chamber/ship													
LNL	4+spares	FEB 18	4/3	18/3	2/4	15/4							
	* 5					April 22	4/5	20/5	3/6	17/6	1/7		
	*** 3						Jun 24	15/7	29/7	12/8			
AA	2+spares	Feb 26	11/3	25/3									
	3				April 3	15/4	29/4	13/5					
	** 3						May 13	27/6	10/6	24/6			
	*** 3							Jun 24	8/7	22/7	5/8		
CIEM	4	March 4	18/3	2/4	15/4	29/4							
	* 2				April 22	6/5	20/5						
	** 2						May 13	3/6	17/6				
	*** 4							Jun 24	8/7	22/7	5/8	19/8	
total	35	7 trips Dubna-CERN-Production sites											

Pechiney Delivery

Delivery from Pechiney

Date	Delivery place	Order number	Box number	Weight (net)	3200	4150	5300	Cost (Euro)	Status
21/12/99	Torino	448610	527000	1916			35	12800.79	used
21/12/99	Torino	448610	527071	1916			35	12800.79	used
21/12/99	Torino	448503		2247	69			15012.21	used
14/11/2000	CERN-Torino	194083	534468	2190			40	14630.5	used
14/11/2000	CERN-Torino	194083	534469	1915			35	12801.69	used
14/11/2000	CERN-Torino	194083	534471	857		20		5725.62	replaced 18-12-01
14/11/2000	CERN	198573	574431	2629		66		18900.55	replaced 18-12-01
14/11/2000	CERN-Torino	194083	534470	2190			40	14631.39	used
14/11/2000	CERN	198393	574432	857		20		5725.62	replaced 18-12-01
14/11/2000	CERN-Torino	198393	574433	2196			40	14630.5	used
14/11/2000	CERN-Torino	198393	574434	2196			40	14630.5	used
14/11/2000	CERN-Torino	198393	574435	2196			40	14630.5	replaced 18-12-01
14/11/2000	CERN-Torino	198573	574427	2737			50	18285.9	replaced 18-12-01
14/11/2000	CERN-Torino	198573	574428	2737			50	18285.9	replaced 18-12-01
14/11/2000	CERN-Torino	198573	574429	2737			50	18285.9	replaced 18-12-01
14/11/2000	CERN-Torino	198573	574430	2737			50	18285.9	replaced 18-12-01
30/5/2001	Torino	211915	580927	2050			40	13593.27	
30/5/2001	Torino	211915	550928	595			12	4077.98	
18/12/01	Torino	211915	583660	2189			40		delivered
18/12/01	Torino	211915	584369	2185			40		delivered
18/12/01	Torino	211915	584372	1915			35		delivered
18/12/01	Torino	201484	583661	2326		55			delivered
18/12/01	Torino	201484	583662	1476		35			delivered
2/19/2002	CERN-Torino	206266	588106	2672			50		delivered
2/19/2002	CERN-Torino	206266	588107	2740			50		delivered
2/19/2002	CERN-Torino	206266	587633	2683			51		delivered
2/19/2002	CERN-Torino	206266	587634	2658			50		delivered
2/19/2002	CERN-Torino	206266	588065	2799			51		delivered
2/19/2002	CERN-Torino	206266	587635	2754		66			delivered
15/3/2002	CERN-Torino	215219/012	588373	2463			45		delivered
15/3/2002	CERN-Torino	215219/013	588375	2463			45		delivered
15/3/2002	CERN-Torino	215219/013	588376	2463			45		delivered
15/3/2002	CERN-Torino	215219/014	588374	2463			45		delivered
Total delivered						155	964		

50% of production delivered, quality ok.
 indicates plates still to be cut in Torino