



Status of Plate Production in Dubna-Torino



Presented by Amedeo on June 12 2002 – [Update 4 Sept. 2002](#)

- Production in Dubna proceeds within expected rate (8 surfaces/day) working 8-17 on average. [Same rate - normal working hrs](#)
- 2 days stop, due to table moving fault. We wrote instruction to solve the problem and JINR personnel could fix the problem and continue production (one parameter of driver 2 was wrong, and gave phase error, this was probably due to wrong reading of the external encoder position. Didn't happen since then).
- Expedition of 12 boxes + new head to Dubna on 1st July. Installation of new head in Dubna (Nino, Roberto, Vladimir, Amedeo, Mimmo) on 15-27 July. [Done](#)
- Cutting proceeding at slow rate (8 plates/day) due to major work on head assembly. [Now fast – half of total cut](#)
- New head: all parts completed, being assembled in Torino. [Done](#)



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Sez. di Torino



Aluminum Plates for DT Production - Material flow

| Box Type | Dubna Code | N. Plates | N. Chambers | N.Surfaces | Place | Manufactured | Sent on | N.Plates | N.Chambers |
|----------------|------------|-----------|-------------|------------|--------|--------------|------------|----------|------------|
| MB1-Torino/1 | | 30 | 2 | 48 | Aachen | ☺ | 6/6/2001 | | |
| MB1-Torino/2 | | 30 | 2 | 48 | Aachen | ☺ | 6/6/2001 | | |
| MB1-Torino/3 | 1 | 30 | 2 | 48 | Aachen | ☺ | 6/6/2001 | | |
| MB1-Dubna/1 | 2 | 30 | 2 | 48 | Aachen | ☺ | 29/8/2001 | | |
| MB1-23-01-02 | 3 | 34 | 2 | 54 | Aachen | ☺ | 26/2/2002 | | |
| MB1-4-3-02/1 | 4 | 45 | 3 | 96 | Aachen | ☺ | 26/4/2002 | | |
| MB1-4-3-02/2 | 5 | 45 | 3 | 96 | Aachen | ☺ | 15/5/2002 | | |
| MB1-1-05-02/1 | 6 | 45 | 3 | 96 | Dubna | ☺ | 13/5/02 | | |
| MB1-1-05-02/2 | 7 | 45 | 3 | 96 | Dubna | ☺ | 13/5/02 | 334 | 22 |
| MB1-8-7-02/1 | | 45 | 3 | 96 | Dubna | | 1/6/2002 | | |
| MB1-8-7-02/2 | | 45 | 3 | 96 | Dubna | | 1/6/2002 | | |
| MB1-16-9-02/1 | | 45 | 3 | 96 | Torino | | 16/9/02 | | |
| MB1-16-9-02/2 | | 45 | 3 | 96 | Torino | | 16/9/02 | | |
| MB1-16-9-02/3 | | 45 | 3 | 96 | Torino | | 16/9/02 | | |
| MB2-Torino/1 | | 30 | 2 | 48 | Madrid | ☺ | 15/3/2001 | | |
| MB2-Torino/2 | | 30 | 2 | 48 | Madrid | ☺ | 15/4/2001 | | |
| MB2-Torino/3 | | 30 | 2 | 48 | Madrid | ☺ | 15/5/2001 | | |
| MB2-Torino/4 | | 30 | 2 | 48 | Madrid | ☺ | 15/5/2001 | | |
| MB2-Torino/5 | | 30 | 2 | 36 | Madrid | ☺ | 15/12/2001 | | |
| MB2-Dubna/1 | 3 | 30 | 2 | 60 | Madrid | ☺ | 15/1/2002 | | |
| MB2-23-01-02/1 | 4 | 30 | 2 | 48 | Madrid | ☺ | 23/1/2002 | | |
| MB2-23-01-02/2 | 5 | 30 | 2 | 48 | Madrid | ☺ | 23/1/2002 | | |
| MB2-4-3-02/1 | 6 | 30 | 2 | 48 | Madrid | ☺ | 25/4/2002 | | |
| MB2-4-3-02/2 | 7 | 30 | 2 | 48 | Madrid | ☺ | 25/4/2002 | | |
| MB2-1-5-02/1 | 8 | 34 | 2 | 52 | Madrid | ☺ | 1/7/2002 | | |
| MB2-1-5-02/2 | 10 | 30 | 2 | 48 | Madrid | ☺ | 1/7/2002 | | |
| MB2-1-5-02/3 | 9 | 34 | 2 | 52 | Madrid | ☺ | 1/7/2002 | | |
| MB2-1-5-02/4 | 11 | 30 | 2 | 48 | Madrid | ☺ | 1/7/2002 | 428 | 28 |

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| Box Type | Dubna Code | N. Plates | N. Chambers | N.Surfaces | Place | Manufactured | Sent on | N.Plates | N.Chambers |
|---------------|------------|-----------|-------------|------------|---------|--------------|-----------|----------|------------|
| MB2-8-7-02/1 | | 30 | 2 | 48 | Dubna | | 1/6/2002 | | |
| MB2-8-7-02/2 | | 30 | 2 | 48 | Dubna | | 1/6/2002 | | |
| MB2-8-7-02/3 | | 30 | 2 | 48 | Dubna | | 1/6/2002 | | |
| MB2-8-7-02/4 | | 30 | 2 | 48 | Dubna | | 1/6/2002 | | |
| MB2-8-7-02/5 | | 30 | 2 | 48 | Dubna | | 1/6/2002 | | |
| MB2-8-7-02/6 | | 30 | 2 | 48 | Dubna | | 1/6/2002 | | |
| MB2-16-9-02/1 | | 30 | 2 | 48 | Torino | | 16/9/02 | | |
| MB2-16-9-02/2 | | 30 | 2 | 48 | Torino | | 16/9/02 | | |
| MB3-Torino/1 | | 15 | 1 | 24 | Legnaro | ☛ | 30/3/2001 | | |
| MB3-Torino/2 | | 45 | 3 | 72 | Legnaro | ☛ | 30/4/2001 | | |
| MB3-Torino/3 | | 30 | 2 | 48 | Legnaro | ☛ | 30/6/2001 | | |
| MB3-Dubna/1 | 2 | 30 | 2 | 48 | Legnaro | ☛ | 18/2/2002 | | |
| MB3-Dubna/2 | 3 | 30 | 2 | 48 | Legnaro | ☛ | 18/2/2002 | | |
| MB3-23-01-02 | 4 | 32 | 2 | 50 | Legnaro | ☛ | 25/4/2002 | | |
| MB3-4-3-02/1 | 5 | 45 | 3 | 96 | Legnaro | ☛ | 25/4/2002 | | |
| MB3-4-3-02/2 | 6 | 45 | 3 | 96 | Legnaro | ☛ | 1/7/2002 | 272 | 18 |
| MB3-1-05-02/1 | | 45 | 3 | 96 | Dubna | | 13/5/02 | | |
| MB3-1-05-02/2 | | 45 | 3 | 96 | Dubna | | 13/5/02 | | |
| MB3-8-7-02/1 | | 45 | 3 | 96 | Dubna | | 1/6/2002 | | |
| MB3-8-7-02/2 | | 45 | 3 | 96 | Dubna | | 1/6/2002 | | |
| MB3-16-9-02/1 | | 45 | 3 | 96 | Torino | | 16/9/02 | | |
| MB3-16-9-02/2 | | 45 | 3 | 96 | Torino | | 16/9/02 | | |
| MB3-16-9-02/3 | | 45 | 3 | 96 | Torino | | 16/9/02 | | |
| | | 1814 | 120 | | | | | 1034 | 68 |

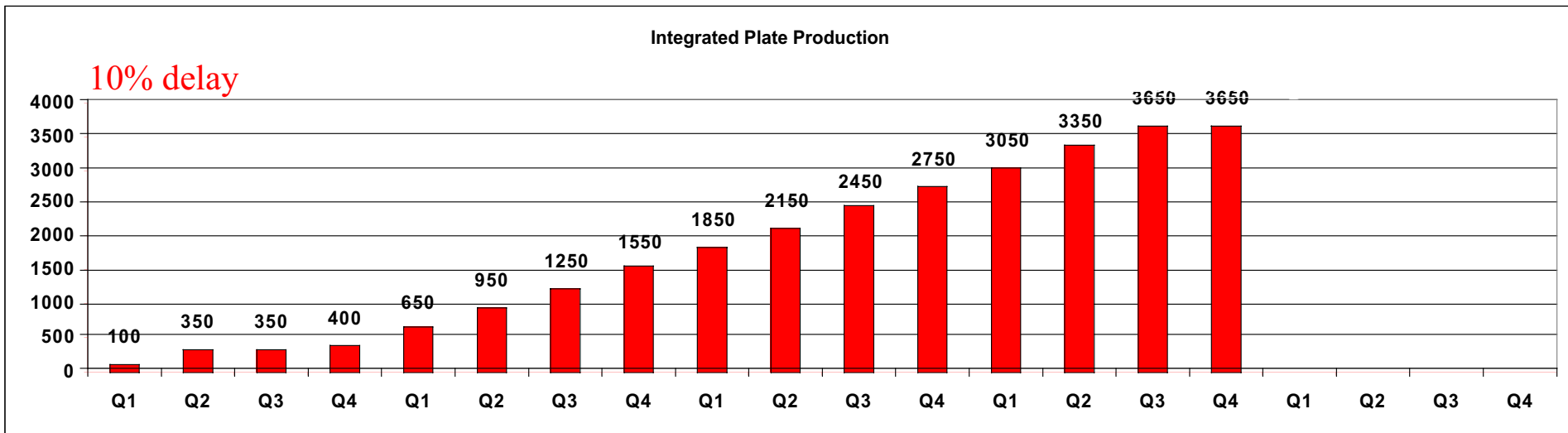
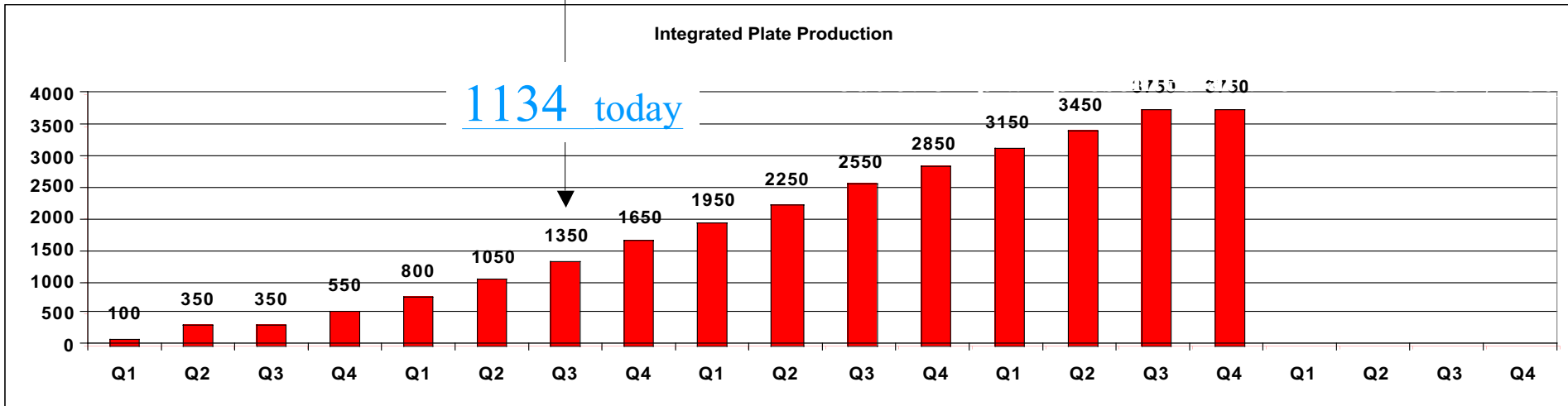
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Status of MB4 Production Preparation

Sez. di Torino



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Today: Q3 2002 1134 → Dubna finishes work in 21 months from today



Status of Plate Production in Dubna-Torino



Next delivery from Torino:

12 boxes (6MB2, 3MB1, 3MB3) on 1 July will leave Torino to Dubna.

16 boxes (4MB2, 3MB1, 3MB3 + ...) and tapes will leave Torino to Dubna
~ 1 month; Dubna well stocked

Next deliveries from Dubna:

1st July: 1 box (plates for 3MB3) + 4 boxes (plates for 8 MB2 + missing outer plates) will leave JINR to CERN-Legnaro-Madrid.

Next delivery to Aachen (1 box, 3 chambers) on 15 July.

On schedule. Done

Next delivery to Aachen (2 box, 6 chambers) next week 1 box with new head

Next delivery to Padova (2 box, 6 chambers) mid October

Next deliveries from Pechiney:

Dates unknown, ~ 20tons produced but damaged on one surface with a deep scratch from Sthal. Pechiney proposes to make a *ponçage* and redo chemical conversion. A sample sent and accepted by us, we are waiting for a reply. Delivered good plates Jul. 17 (239 big, 98 MB4)



Status of MB4 Production Preparation



- 2nd iron cast table will be delivered in Sette Comuni on 17th June.

Delivered and aligned

- Work area enlargement approved by director, installation starts at the beginning of July. Time estimated for completion of infrastructure work (crane extension, air conditioning system upgrade, final cleaning) 2 months.

Begin work end July, expected to be finished by end September

- Plotters: driver cabinets cabled and ready. Only missing part are the beam supports. Mimmo, back from China for MB4 support commissioning, will finish the drawings in July. Parts will be manufactured in September. [BUT](#)

Mimmo: designed details for MB4 supports insertion done in July but was not planned; presently working on gas system (first 2 weeks of Sept.) → NOT working on MB4. Outlook: will have start contract w/ integration on Nov. 1st and work on beam supports until end of Sept.

Will start working on I-beams tool drawings in Oct.

- All other parts have been delivered. Plotter beams ready to be sent to CINEL for milling.

Done in July.

- Glueing machine under test to check functionality for 15mt long pipes and possibility of glue dispenser splitting. One driver lost during set-up, replacement ordered.

- Tooling: I-beam tooling to be designed starting from September. [See above](#)



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■ MB4 HV and FE frame cabling: 2 electronics will start to work with us after 8th July, they will go to Legnaro on 16 July to learn how to start SL frame cabling work. Frames already in Torino ready to be machined.

Done

Frame cabling will start beginning of September.

Preparing area, tools.

Silvia collecting docs etc., waiting for material (3 profiles) from CINEL, Madrid (1, end of September);

Electronics will go to Padova, collect cables, connectors etc., more training. Start work in Torino.

Schedule: within the present schedule we are expected to provide a first SL by the end of the year. Two months delay in production preparation due to integration work on HV cable length and MB4 support commissioning test in Beijing (Mimmo) -> probably no MB4 SL before the end of the year.

CONFIRMED



Status of MB4 Production Preparation

Sez. di Torino



Test stand status - Vincenzo Monaco

DAQ

Hardware (VME modules+TDC+CPU) - *ok*
Software (acquisition+run control) - *done*
final cabling and L.V. - *to be done*
4 TDC available - 1 SL or 1/2 chamber)

Support for chamber and scintillators - in progress

Trigger - in progress

8 scintillatori 100*10*1 cm**3 - *ok*
4 scintillatori 200*20*1 - *assembling*
NIM logic - *in progress*

Analysis software - in progress

noise with scaler
Online monitor and offline analysis (noise, occupancy, efficiency, meantimer, distribuzioni drift time, ...)

H.V.

mainframe - *ok*
moduli - *waiting*
cabling, distribution box - *to be done*

Gas distribution system - to be done