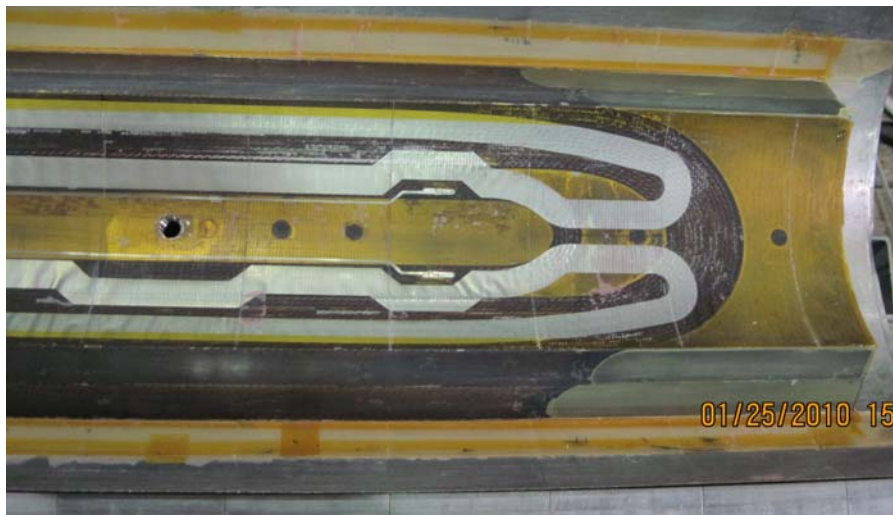
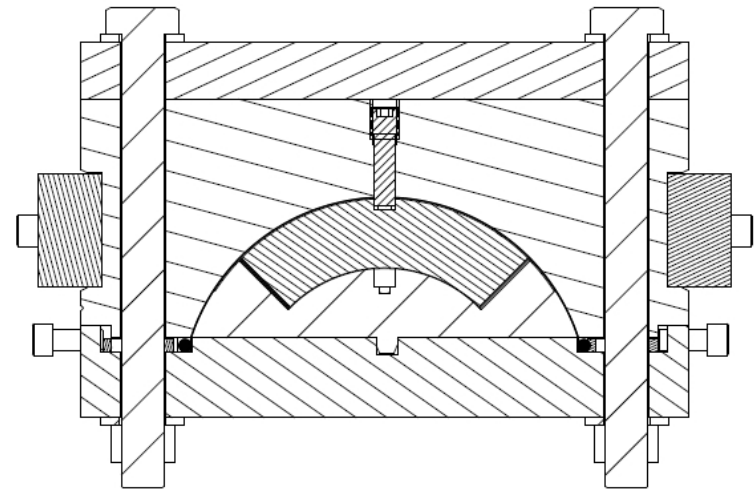


HQ Coil Fab at BNL

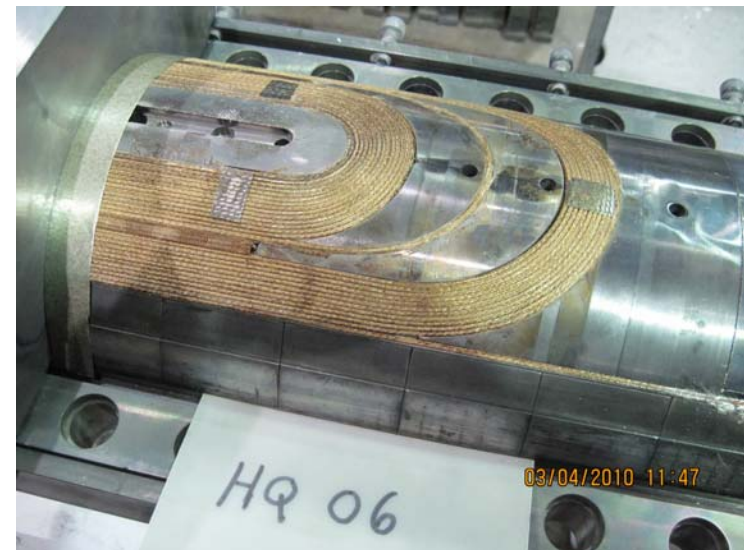
Jesse Schmalzle, BNL
04/27/10

HQ Coil Status

- Four coils reacted and impregnated:
 - HQ02 - Completed and shipped.
 - HQ04 - Completed and shipped.
 - HQ05 - Completed and shipped.
 - HQ06 - Impregnated, final prep underway.

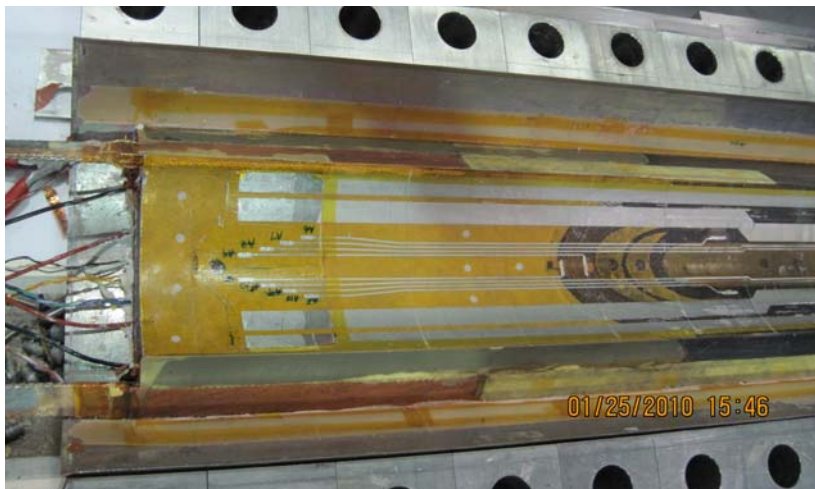


J. Schmalzle



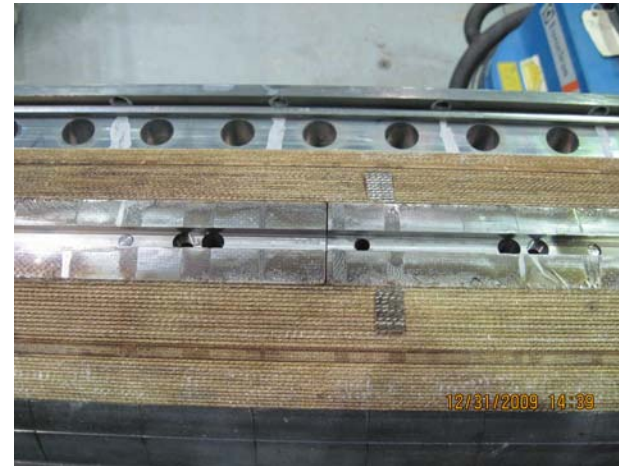
HQ Coil Fab at BNL - CM14 04/27/10

Misc photos



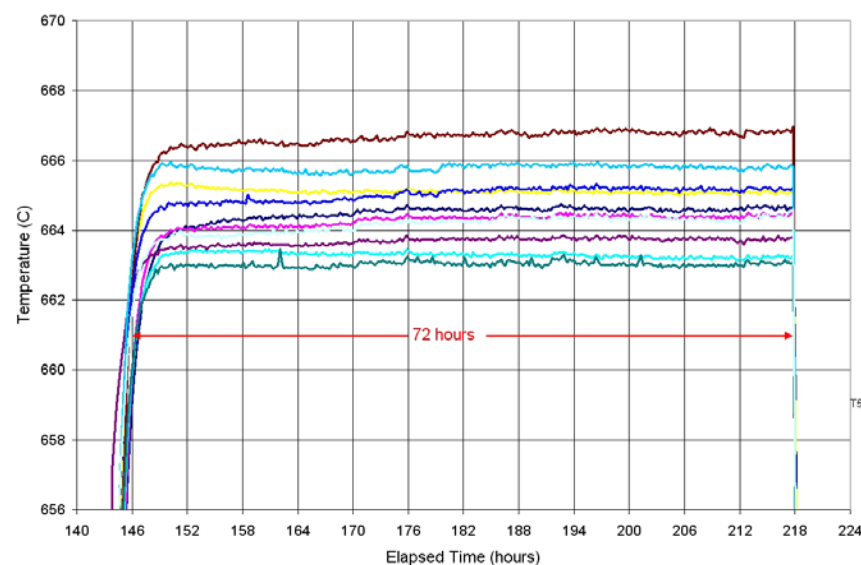
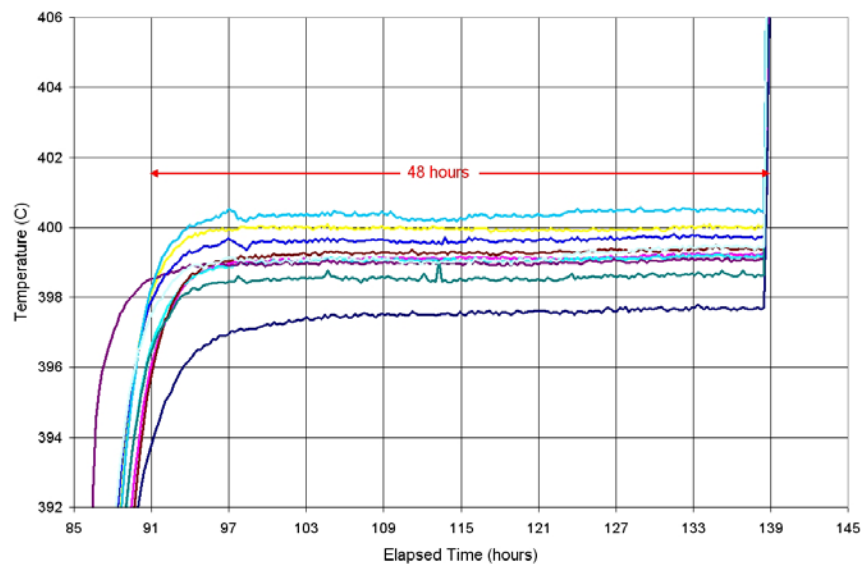
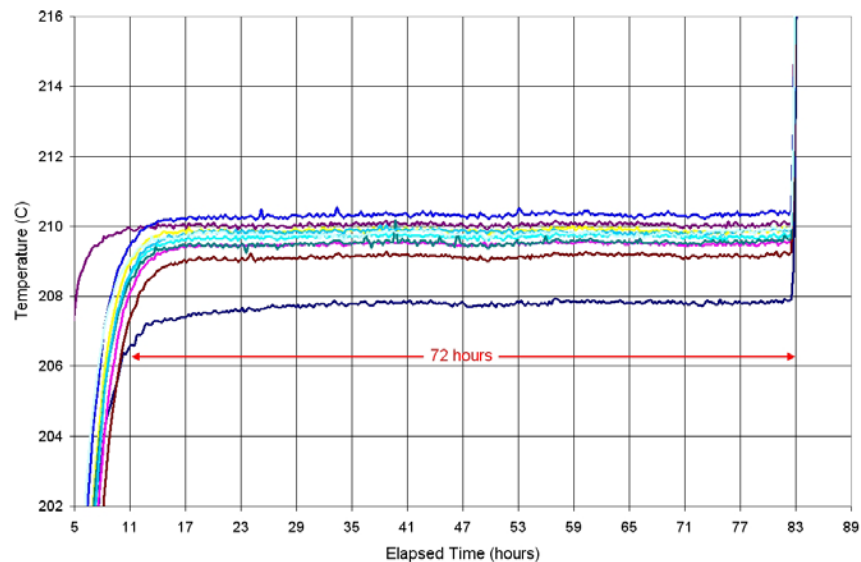
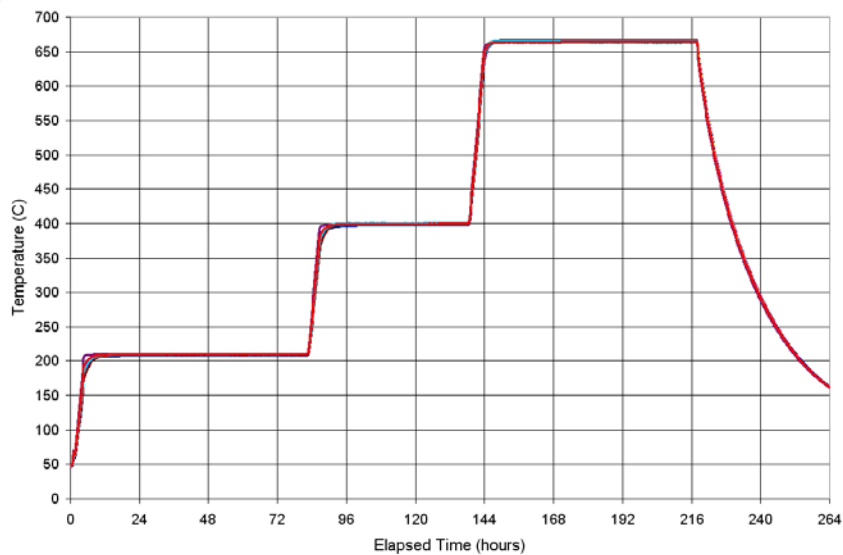
Anomalies / Discrepancies

- HQ05 - Gap between pole segments prevented installation of pin.
 - Gap remained after reaction.

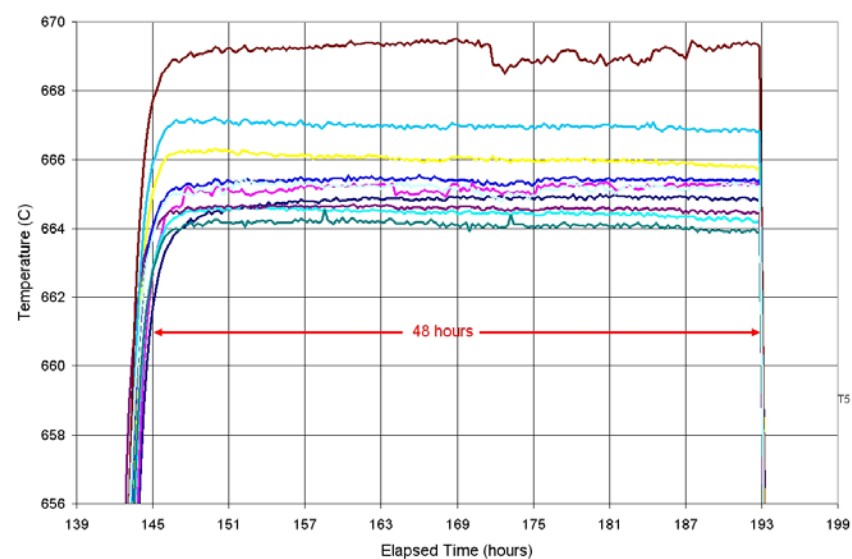
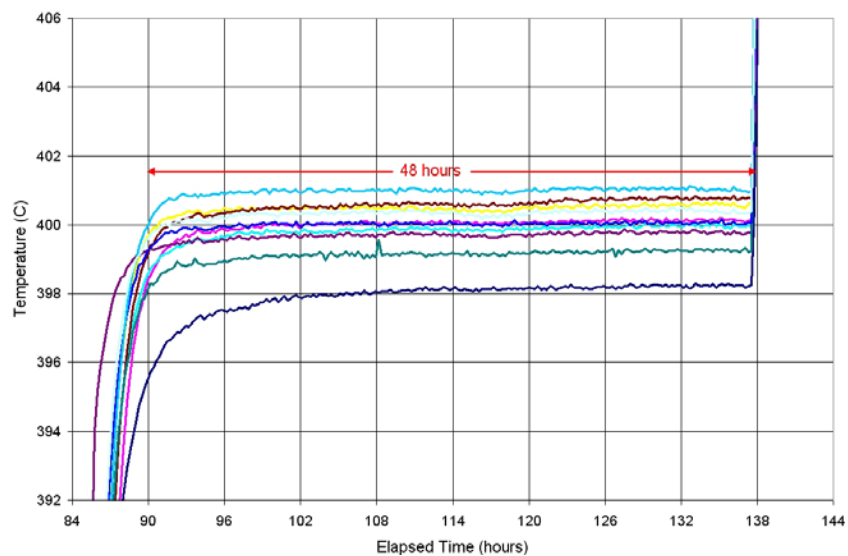
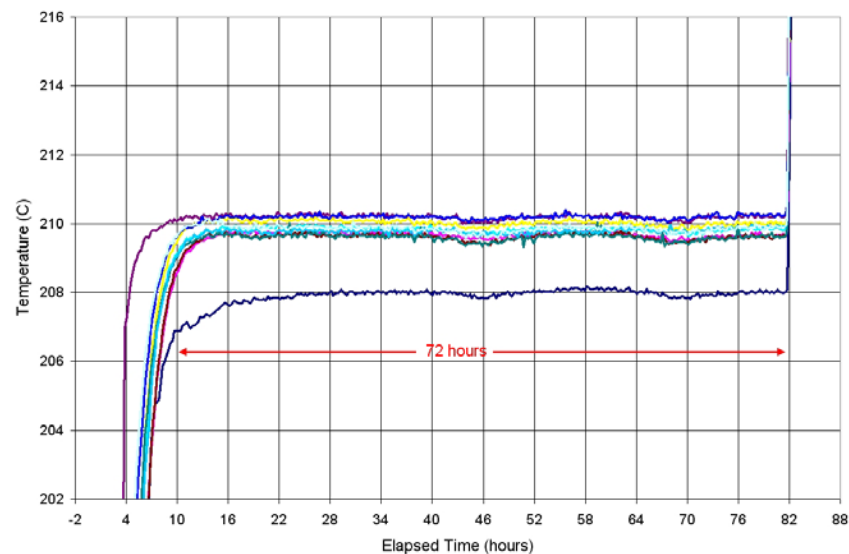
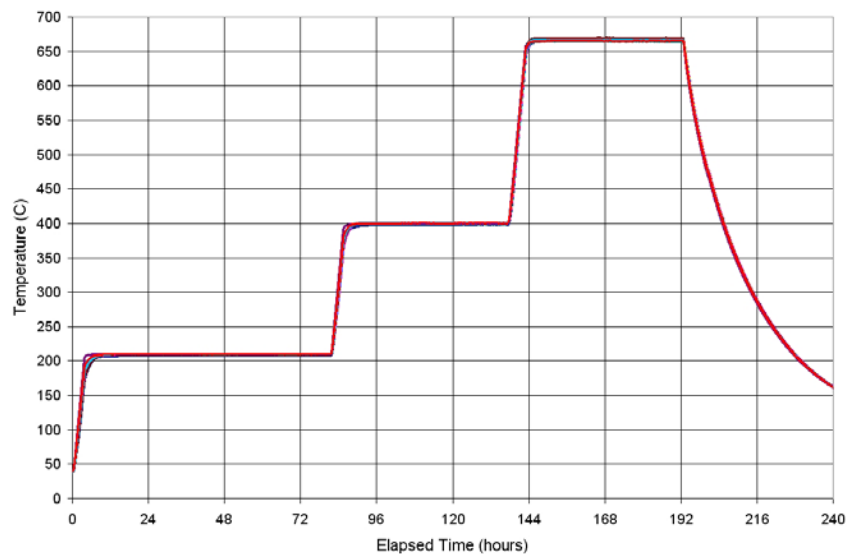


- HQ04 –short between coil and outer layer LE saddle.
- HQ06 – Missing V-Tap (B5), copper flag broken very near coil OD.

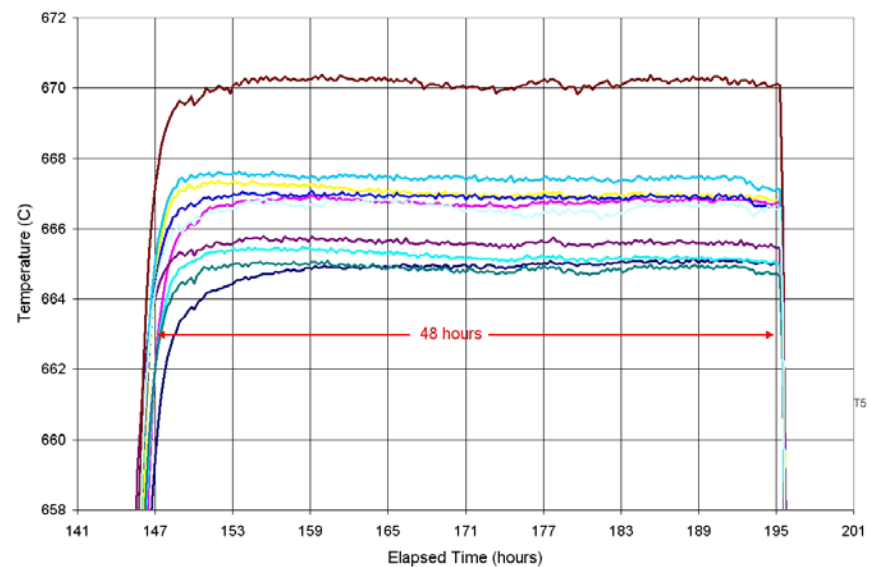
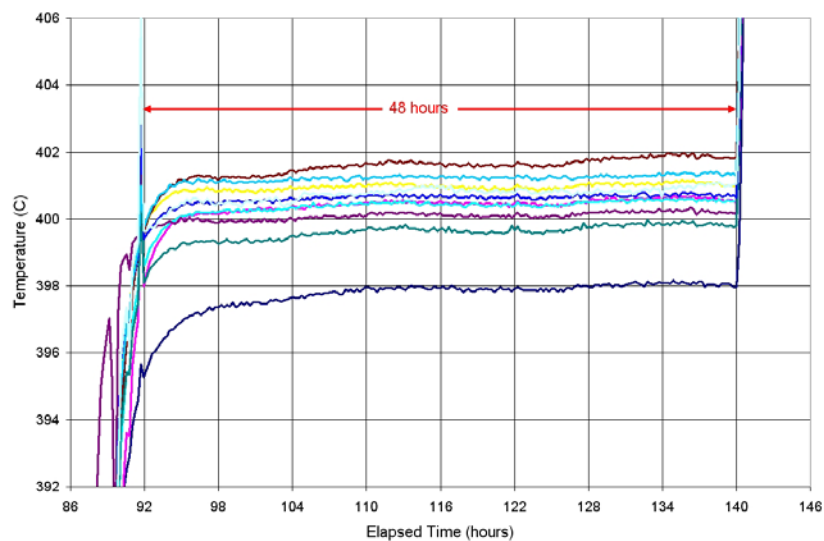
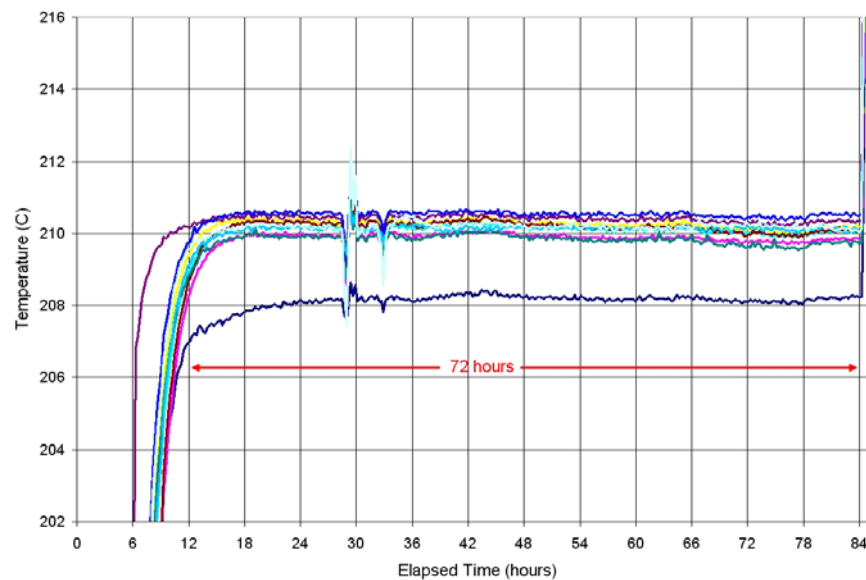
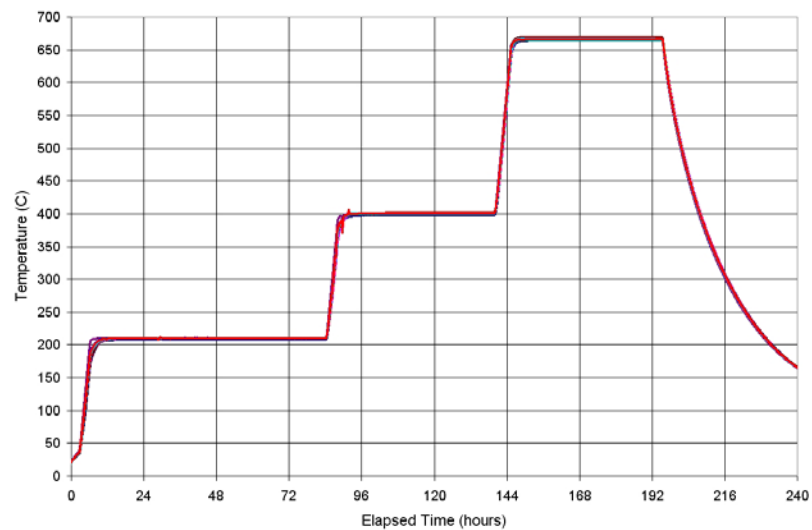
HQ02 - Reaction



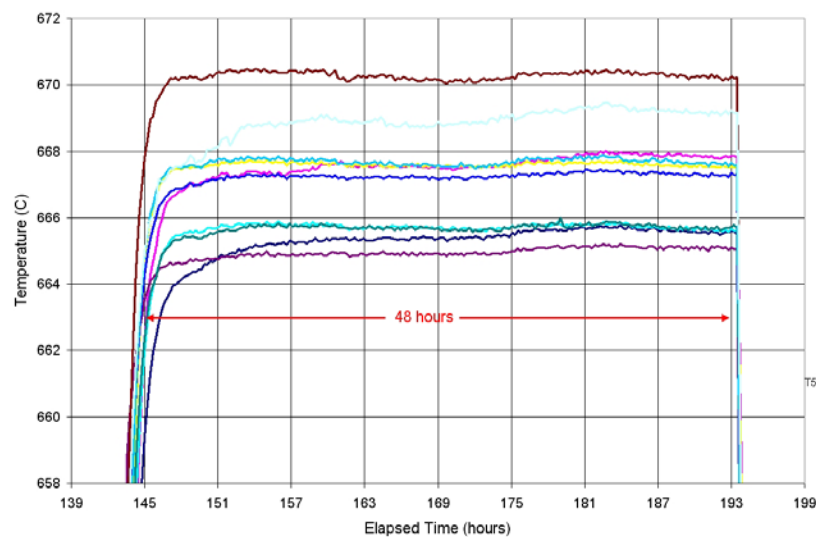
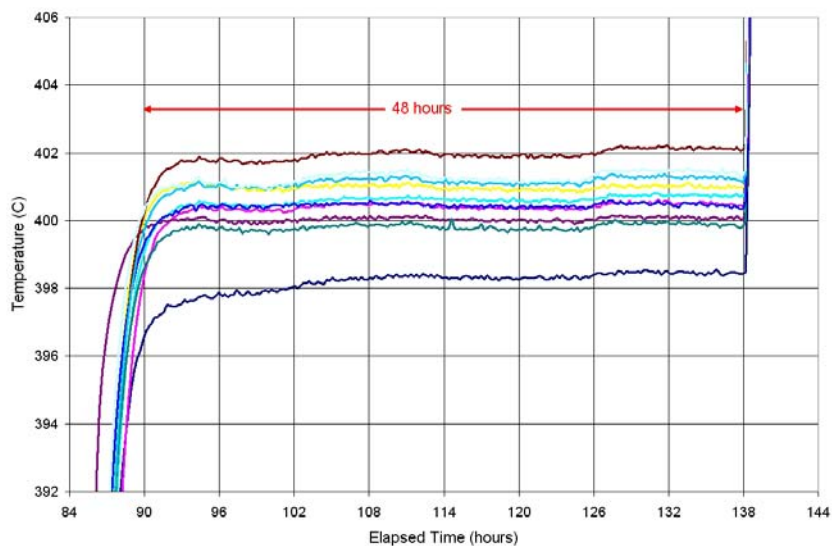
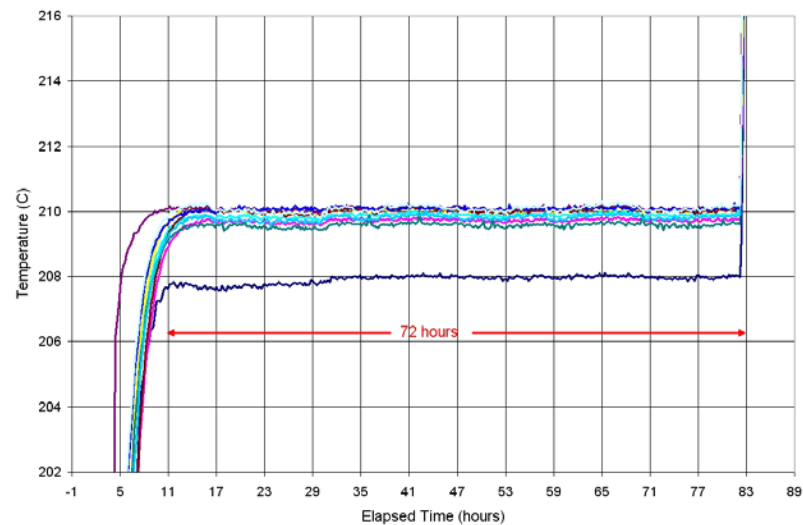
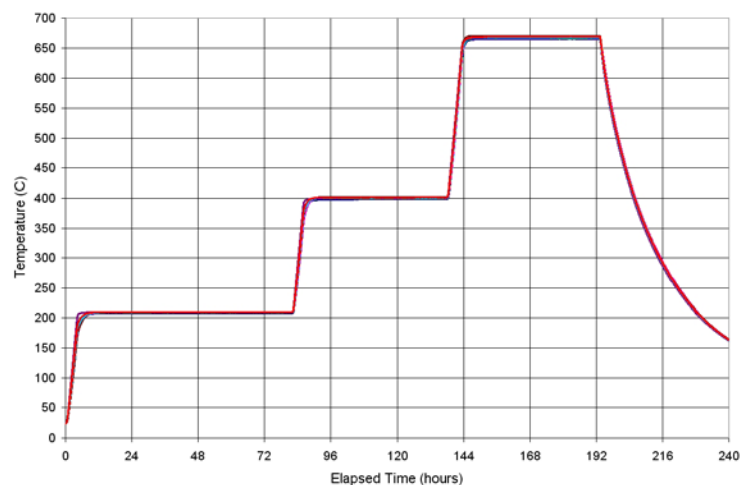
HQ04 - Reaction



HQ05 - Reaction

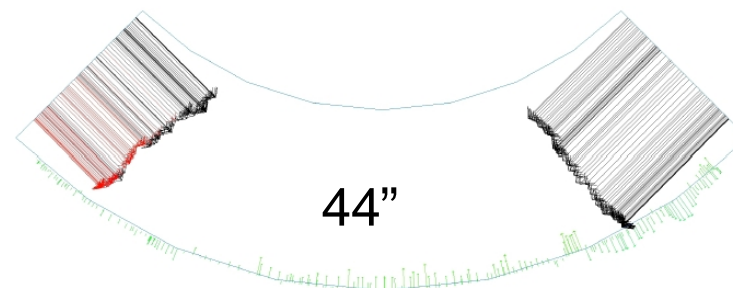
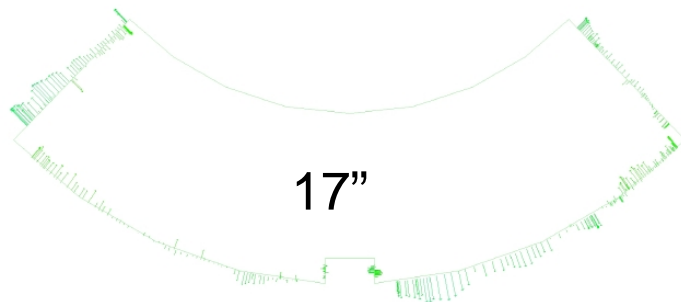
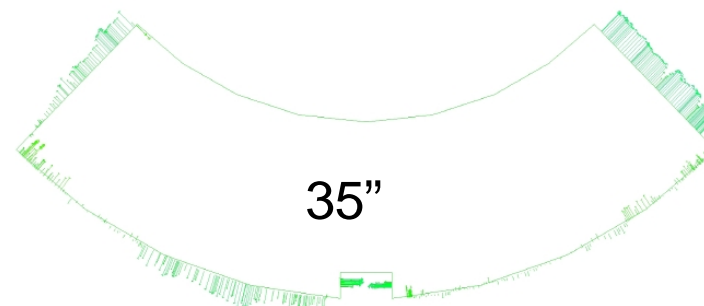
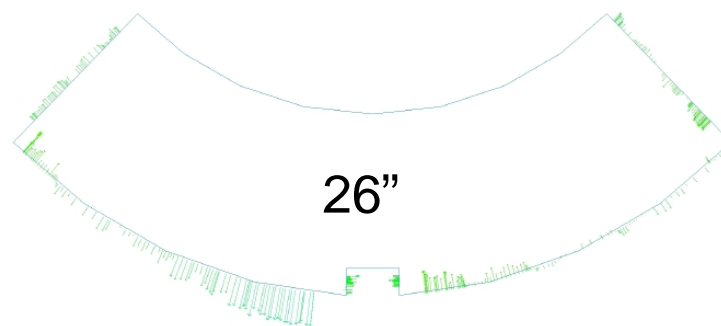
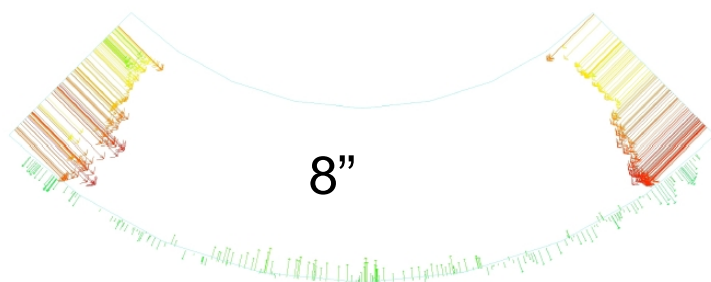


HQ06 - Reaction



HQ02 – Coil Size

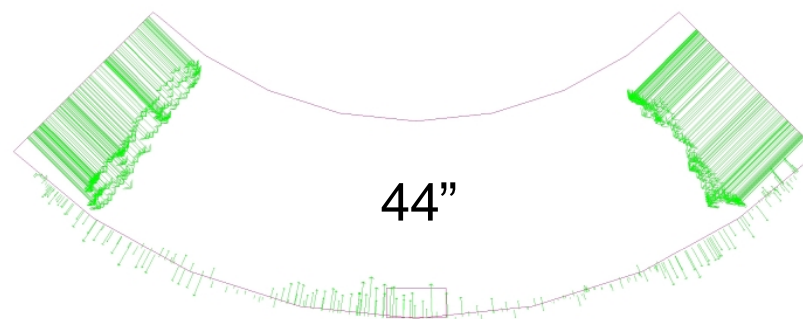
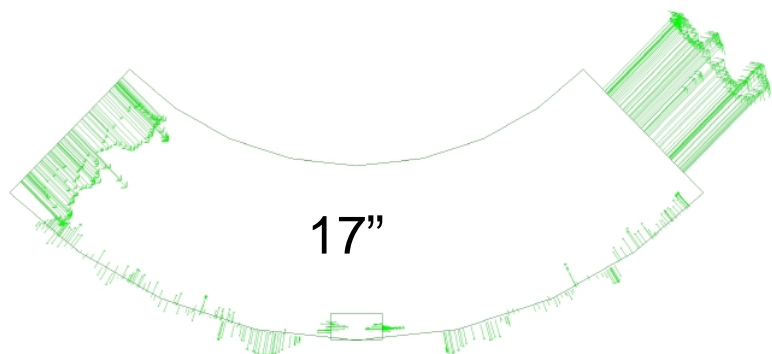
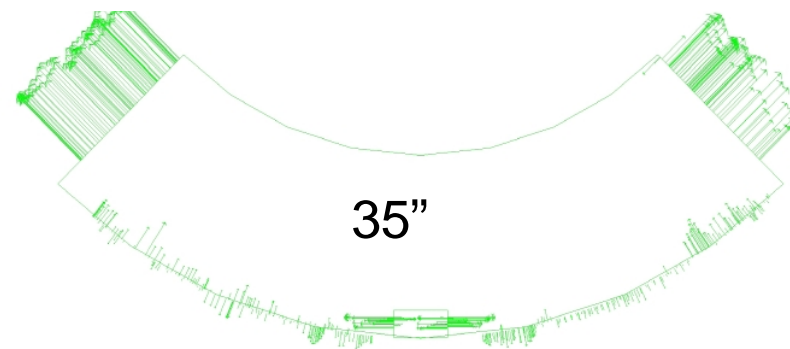
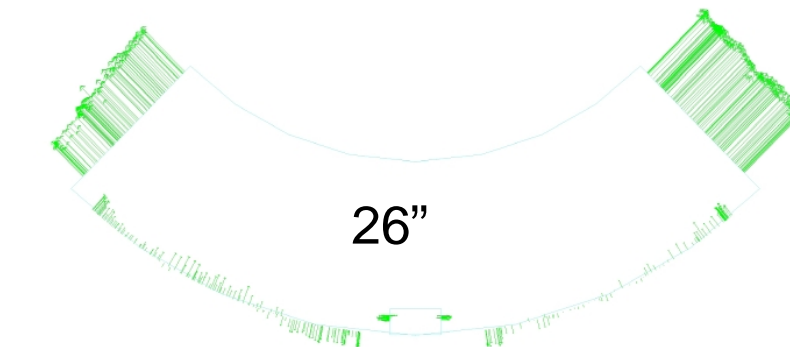
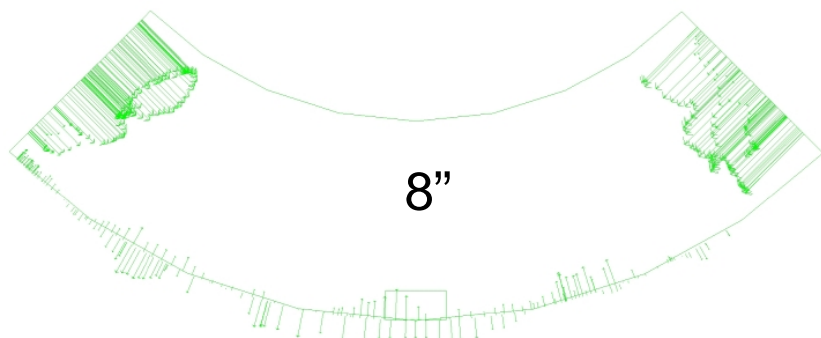
- Ends 2-8 mils small
- Center 1-2 mils large



- Fit to coil OD (OD plus keyway in center).

HQ04 – Coil Size

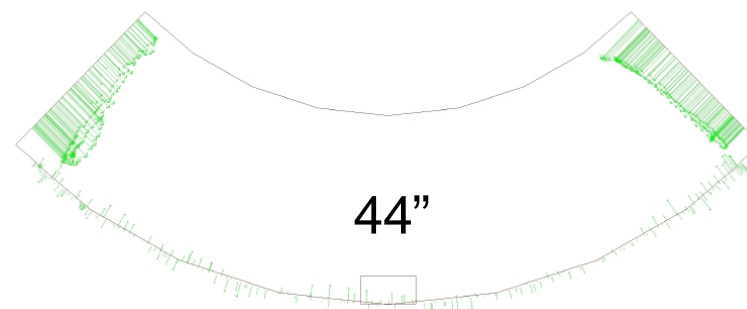
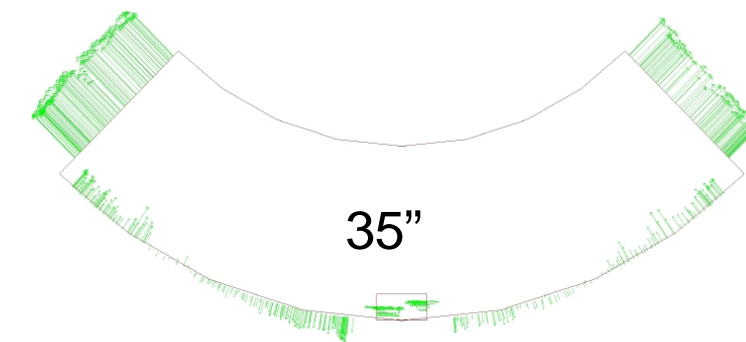
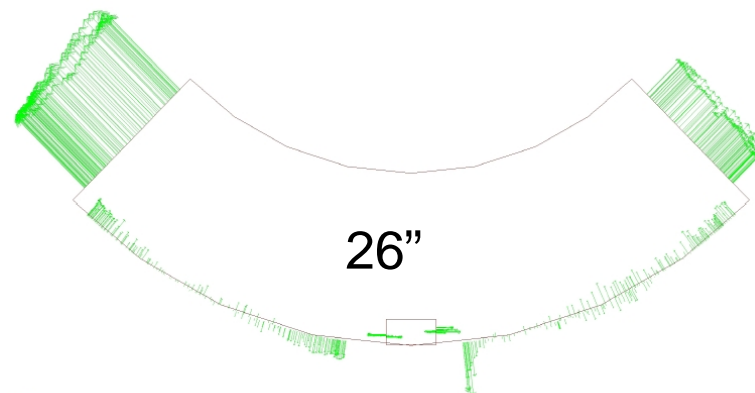
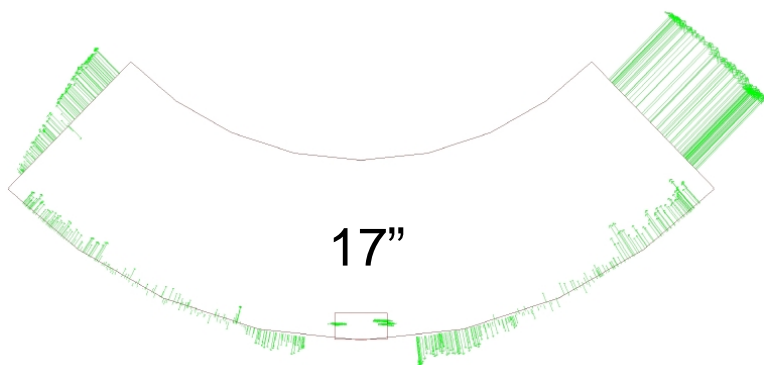
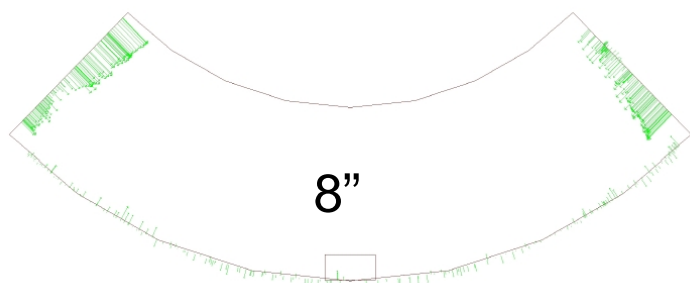
- Ends 2-7 mils small
- Center 2-7 mils large



- Fit to coil OD (OD plus keyway in center).

HQ05 – Coil Size

- Ends 1-4 mils small
- Center 2-8 mils large



- Fit to coil OD (OD plus keyway in center).

HQ Coil Fab – Elapsed Time

ID	Task Name	Duration	Start	Finish	r	1st Quarter				2nd Quarter			3rd Quarter			4th Quarter			1st Quarter			2nd Quar	
					Dec	Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	Dec	Jan	Feb	Mar	Apr	May	
1	HQ02	78 days	Mon 8/3/09	Fri 11/20/09																			
2	prep for reaction	12 days	Mon 8/3/09	Tue 8/18/09																			
3	reaction	10 days	Fri 8/21/09	Thu 9/3/09																			
4	OD prep for impreg	19 days	Tue 9/8/09	Fri 10/2/09																			
5	ID prep for impreg / hang	14 days	Mon 10/5/09	Thu 10/22/09																			
6	impregnation	6 days	Mon 10/26/09	Mon 11/2/09																			
7	final prep / wiring	13 days	Tue 11/3/09	Fri 11/20/09																			
8	HQ04	48	68 days	Tue 10/27/09	Thu 2/4/10																		
9	prep for reaction	8 days	Tue 10/27/09	Thu 11/5/09																			
10	reaction	7 days	Fri 11/6/09	Tue 11/17/09																			
11	OD prep for impreg	11 days	Wed 11/18/09	Fri 12/4/09																			
12	ID prep for impreg / hang	6 days	Mon 12/7/09	Mon 12/14/09																			
13	heater trouble	20 days	Tue 12/15/09	Wed 1/13/10																			
14	impregnation	6 days	Thu 1/14/10	Thu 1/21/10																			
15	final prep / wiring	10 days	Fri 1/22/10	Thu 2/4/10																			
16	HQ05	50	62 days	Fri 12/4/09	Thu 3/4/10																		
17	prep for reaction	4 days	Fri 12/4/09	Wed 12/9/09																			
18	reaction	12 days	Fri 12/11/09	Wed 12/30/09																			
19	OD prep for impreg	12 days	Thu 12/31/09	Fri 1/15/10																			
20	wait for impreg tool	9 days	Mon 1/18/10	Thu 1/28/10																			
21	ID prep for impreg / hang	5 days	Fri 1/29/10	Thu 2/4/10																			
22	impregnation	6 days	Fri 2/5/10	Fri 2/12/10																			
23	hold while work on 06	3 days	Fri 2/12/10	Wed 2/17/10																			
24	final prep / wiring	11 days	Thu 2/18/10	Thu 3/4/10																			
25	HQ06	53	64 days	Mon 2/8/10	Fri 5/7/10																		
26	prep for reaction	7 days	Mon 2/8/10	Wed 2/17/10																			
27	reaction	8 days	Thu 2/18/10	Mon 3/1/10																			
28	OD prep for impreg	12 days	Tue 3/2/10	Wed 3/17/10																			
29	wait for trace	5 days	Thu 3/18/10	Wed 3/24/10																			
30	ID prep for impreg / hang	10 days	Thu 3/25/10	Wed 4/7/10																			
31	impregnation	6 days	Thu 4/8/10	Thu 4/15/10																			
32	hold while work on LQ	6 days	Fri 4/16/10	Fri 4/23/10																			
33	final prep / wiring	10 days	Mon 4/26/10	Fri 5/7/10																			