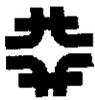


DFLX - 40



0. Cover Sheet for Check Out Form

Power leads being tested: 7500 A DFLX 20 7500 A DFLX 40

| Task # | Responsible | Task | Received Date,time | Performed Date,time |
|--------|--------------|---|--------------------|---------------------|
| 1 | Inspection | Unpack the leads | | 031803 031803 |
| 2 | Inspection | IB4 mech. & Tolerances | | 031803 |
| 3 | Mechanical | Move the leads to MTF | 2/22/05 1100 | |
| 4 | Electrical | Initial electrical check out | | 032103 022305 |
| 4a | Mechanical | Preliminary leak check | | 022305 |
| 5 | Mechanical | Installation of the current leads | | 030105 |
| 6 | Mechanical | Pressure test | | 030205 |
| 7 | Mechanical | Leak check | | 030305 |
| 7a | Mechanical | Top plate insertion into the dewar | | 030405 |
| 8 | M. Tartaglia | Configuration of the DAQ system | | |
| 9 | Electrical | Room temp. electrical test | | 030705 |
| 10 | Mechanical | Installation of the top plate | | |
| 10.1 | Electrical | Room temp. GHe hipot | | 030805 |
| 12 | Mechanical | Cool down | | 031605 |
| 13 | Electrical | Electrical & instrumentation test | | |
| 14 | Mechanical | Connect the leads to the Power Supply & configure | | 030805 |
| 15 | Electrical | Electrical & instrumentation test | | 031505 |
| 16 | M. Thompson | Cold test of the power lead | | 030805 |
| 17 | Mechanical | Perform a Thermal cycle | | |
| 18 | M. Thompson | Cold test of the power lead | | |
| 19 | Mechanical | Warm up | | 031105 |
| 20 | Electrical | Electrical & instrumentation test | | 031605 |
| 21 | Mechanical | Remove the top plate | | 031405 |
| 22 | Mechanical | Remove the leads from the top plate | | 031405 |
| 23 | Mechanical | Pack and move the leads | | 031705 |



FERMILAB
Technical
Division

7500A HTS Power leads for the LHC DFBX

Doc. No.
 Rev. No.
 Date: January 6, 2003
 Page 1 of 1
 Author: Sandor Feher

1. Unpacking Check Out Form

Performed by SUDHIR GHANTA (name typed) [Signature] (signature)
 Date & time 7/28/03 9:30 AM

Note: Save the shipping container for storing and moving the leads around TD and after the test is complete to ship them to the DFBX manufacturer.

1.1 Container Identification: 7500 A DFLX 39 7500 A DFLX 40
 (Leads serial numbers are on one side of the container)

1.2 Note condition of shipping container
 No damage Slight damage Massive damage

1.3 Examine condition of g-load indicators

a. Each side of the box are Shock Watch-s are installed
 Not tripped Tripped (red) Remark: _____
 Not tripped Tripped (red) Remark: _____

b. Each leads have a Shock Watch installed onto their body
 Not tripped Tripped (red) Remark: _____
 Not tripped Tripped (red) Remark: _____

c. Each leads have another "10G DROP" devices installed on the flag of the leads
 Not tripped Tripped (Black) Remark: _____
 Not tripped Tripped (Black) Remark: _____

1.4 Container content:

a. Power leads: 7500 A DFLX 39 ; 7500 A DFLX 40
 b. Travel document for each lead in an envelope
 c. In a plastic box:

1. One clamp: Item No. C105-12-401; Description NW16/10 Clamping ring ST/STEEL PK1
2. One valve made by "precision Cryogenic System" MISSING
3. One O-ring seal with brass insert MISSING

4. UN IDENTIFIED PARTS.

PART NAME : 7.5 KA CURRENT LEAD ASSY (LBNL01)
 REV NUMBER :
 SER NUMBER :
 STATS COUNT : 1

7500 A DFLX 39

| MM | DIM CYL -A-DIA= LOCATION OF CYLINDER CYL -A- | | | | | | |
|----|--|-------|-------|--------|-------|--------|--|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL | |
| D | 99.000 | 0.200 | 0.200 | 99.022 | 0.022 | 0.000 | |

| MM | DIM -A= ROUNDNESS OF CYLINDER CYL -A- | | | | | | |
|----|---------------------------------------|-------|-------|-------|-------|--------|--|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL | |
| M | 0.000 | 0.200 | 0.000 | 0.154 | 0.154 | 0.000 | |

| MM | DIM -B= FLATNESS OF PLANE PLN -B- | | | | | | |
|----|-----------------------------------|-------|-------|-------|-------|--------|--|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL | |
| M | 0.000 | 0.050 | 0.000 | 0.011 | 0.011 | 0.000 | |

| MM | DIM PERP1= PERPEND OF PLANE PLN -B- TO CYLINDER CYL -A- EXTEND=0.000 | | | | | | |
|----|--|-------|-------|-------|-------|--------|--|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL | |
| M | 0.000 | 0.400 | 0.000 | 0.207 | 0.207 | 0.000 | |

| MM | DIM PERP2= PERPEND OF PLANE LRG FLANGE TO CYLINDER CYL -A- EXTEND=560.000 | | | | | | |
|----|---|-------|-------|-------|-------|--------|--|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL | |
| M | 0.000 | 0.400 | 0.000 | 0.436 | 0.436 | 0.036 | |

| MM | DIM -C- DIA= LOCATION OF CYLINDER -C- | | | | | | |
|----|---------------------------------------|-------|-------|--------|--------|--------|--|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL | |
| D | 80.000 | 0.200 | 0.200 | 79.953 | -0.047 | 0.000 | |

| MM | DIM CONCEN2=CONCENTRICITY FROM CYLINDER -C- TO CYLINDER CYL -A- | | | | | | |
|----|---|-------|-------|-------|-------|--------|--|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL | |
| M | 0.000 | 1.000 | 0.000 | 2.004 | 2.004 | 1.004 | |

| MM | DIM RND2= ROUNDNESS OF CYLINDER -C- | | | | | | |
|----|-------------------------------------|-------|-------|-------|-------|--------|--|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL | |
| M | 0.000 | 0.200 | 0.000 | 0.073 | 0.073 | 0.000 | |

| MM | DIM DIST1= 2D DISTANCE FROM PLANE PLN -B- TO PLANE LRG FLANGE PAR TO YAXIS | | | | | | |
|----|--|-------|-------|---------|-------|--------|--|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL | |
| M | 561.000 | 1.000 | 1.000 | 562.260 | 1.260 | 0.260 | |

| MM | DIM LOC5= TRUE POSITION OF CIRCLE CIR2 | | | | | | |
|----|--|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| X | 0.000 | | | | 0.000 | 0.000 | |
| Z | 123.571 | | | | 123.931 | 0.360 | |
| DF | 18.000 | 0.200 | 0.200 | | 17.989 | -0.011 | 0.000 |
| TP | RFS | 0.130 | | 0.000 | | 0.719 | 0.589 |

| MM | DIM LOC10= TRUE POSITION OF CIRCLE CIR3 | | | | | | |
|----|---|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| X | -78.890 | | | | -79.020 | -0.131 | |
| Z | 95.047 | | | | 95.610 | 0.563 | |
| DF | 18.000 | 0.200 | 0.200 | | 17.987 | -0.013 | 0.000 |
| TP | RFS | 0.130 | | 0.000 | | 1.156 | 1.026 |

| MM | DIM LOC11= TRUE POSITION OF CIRCLE CIR4 | | | | | | |
|----|---|-------|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| X | 78.890 | | | | 78.871 | -0.019 | |
| Z | 95.047 | | | | 95.229 | 0.182 | |
| DF | 18.000 | 0.200 | 0.200 | | 17.989 | -0.011 | 0.000 |
| TP | RFS | 0.130 | | 0.000 | | 0.367 | 0.237 |

| MM | DIM LOC12= TRUE POSITION OF CIRCLE CIR5 | | | | | | |
|----|---|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| X | 78.890 | | | | 78.419 | -0.471 | |
| Z | -95.047 | | | | -94.839 | 0.208 | |
| DF | 18.000 | 0.200 | 0.200 | | 17.988 | -0.012 | 0.000 |
| TP | RFS | 0.130 | | 0.000 | | 1.029 | 0.899 |

| MM | DIM 18.00 DIA HOLE= TRUE POSITION OF CIRCLE CIR6 | | | | | | |
|----|--|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| X | -78.890 | | | | -79.474 | -0.584 | |
| Z | -95.047 | | | | -94.441 | 0.606 | |
| DF | 18.000 | 0.200 | 0.200 | | 17.949 | -0.051 | 0.000 |
| TP | RFS | 0.130 | | 0.000 | | 1.682 | 1.552 |

| MM | DIM 8.433 DIA HOLE #1= TRUE POSITION OF CIRCLE SH1 | | | | | | |
|----|--|-------|-------|-------|----------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.530 | -0.020 | |
| PA | -153.000 | | | | -153.466 | -0.466 | |
| DF | 8.433 | 0.200 | 0.000 | 0.178 | 8.611 | 0.178 | 0.000 |
| TP | MMC | 0.080 | | 0.178 | | 1.475 | 1.216 |

| MM | DIM 8.433 DIA HOLE #2= TRUE POSITION OF CIRCLE SH2 | | | | | | |
|----|--|-------|-------|-------|----------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.693 | 0.143 | |
| PA | -171.000 | | | | -171.421 | -0.421 | |
| DF | 8.443 | 0.200 | 0.000 | 0.148 | 8.591 | 0.148 | 0.000 |
| TP | MMC | 0.080 | | 0.148 | | 1.361 | 1.133 |

| MM | DIM 8.433 DIA HOLE #3= TRUE POSITION OF CIRCLE SH3 | | | | | | |
|----|--|-------|-------|-------|----------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.385 | -0.165 | |
| PA | -135.000 | | | | -135.483 | -0.483 | |
| DF | 8.433 | 0.200 | 0.000 | 0.151 | 8.584 | 0.151 | 0.000 |
| TP | MMC | 0.080 | | 0.151 | | 1.562 | 1.331 |

| MM | DIM 8.433 DIA HOLE #4= TRUE POSITION OF CIRCLE SH4 | | | | | | |
|----|--|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.854 | 0.304 | |
| PA | 171.000 | | | | 170.622 | -0.378 | |
| DF | 8.433 | 0.200 | 0.000 | 0.139 | 8.572 | 0.139 | 0.000 |
| TP | MMC | 0.080 | | 0.139 | | 1.342 | 1.123 |

| MM | DIM 8.433 DIA HOLE #5= TRUE POSITION OF CIRCLE SH5 | | | | | | |
|----|--|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.934 | 0.384 | |
| PA | 153.000 | | | | 152.699 | -0.301 | |
| DF | 8.433 | 0.200 | 0.000 | 0.125 | 8.558 | 0.125 | 0.000 |
| TP | MMC | 0.080 | | 0.125 | | 1.225 | 1.021 |

| MM | DIM 8.433 DIA HOLE #6= TRUE POSITION OF CIRCLE SH6 | | | | | | |
|----|--|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.954 | 0.404 | |
| PA | 135.000 | | | | 134.767 | -0.233 | |
| DF | 8.433 | 0.200 | 0.000 | 0.131 | 8.564 | 0.131 | 0.000 |
| TP | MMC | 0.080 | | 0.131 | | 1.093 | 0.882 |

| MM | DIM 8.433 DIA HOLE #7= TRUE POSITION OF CIRCLE SH7 | | | | | | |
|----|--|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 91.008 | 0.458 | |
| PA | 117.000 | | | | 116.849 | -0.151 | |
| DF | 8.433 | 0.200 | 0.000 | 0.132 | 8.565 | 0.132 | 0.000 |
| TP | MMC | 0.080 | | 0.132 | | 1.032 | 0.821 |

| MM DIM 8.433 DIA HOLE #8= TRUE POSITION OF CIRCLE SH8 | | | | | | | |
|---|---------|-------|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.968 | 0.418 | |
| PA | 99.000 | | | | 98.959 | -0.041 | |
| DF | 8.433 | 0.200 | 0.000 | 0.131 | 8.564 | 0.131 | 0.000 |
| TP | MMC | 0.080 | | 0.131 | | 0.846 | 0.635 |

| MM DIM 8.433 DIA HOLE #9= TRUE POSITION OF CIRCLE SH9 | | | | | | | |
|---|---------|-------|-------|-------|--------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.866 | 0.316 | |
| PA | 81.000 | | | | 81.024 | 0.024 | |
| DF | 8.433 | 0.200 | 0.000 | 0.143 | 8.576 | 0.143 | 0.000 |
| TP | MMC | 0.080 | | 0.143 | | 0.636 | 0.413 |

| MM DIM 8.433 DIA HOLE #10= TRUE POSITION OF CIRCLE SH10 | | | | | | | |
|---|---------|-------|-------|-------|--------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.797 | 0.247 | |
| PA | 63.000 | | | | 63.101 | 0.101 | |
| DF | 8.433 | 0.200 | 0.000 | 0.125 | 8.558 | 0.125 | 0.000 |
| TP | MMC | 0.080 | | 0.125 | | 0.587 | 0.382 |

| MM DIM 8.433 DIA HOLE #11= TRUE POSITION OF CIRCLE SH11 | | | | | | | |
|---|---------|-------|-------|-------|--------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.611 | 0.061 | |
| PA | 45.000 | | | | 45.149 | 0.149 | |
| DF | 8.433 | 0.200 | 0.000 | 0.143 | 8.576 | 0.143 | 0.000 |
| TP | MMC | 0.080 | | 0.143 | | 0.488 | 0.265 |

| MM DIM 8.433 DIA HOLE #12= TRUE POSITION OF CIRCLE SH12 | | | | | | | |
|---|---------|-------|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.488 | -0.062 | |
| PA | 27.000 | | | | 27.145 | 0.145 | |
| DF | 8.433 | 0.200 | 0.000 | 0.136 | 8.569 | 0.136 | 0.000 |
| TP | MMC | 0.080 | | 0.136 | | 0.475 | 0.259 |

| MM DIM 8.433 DIA HOLE #13= TRUE POSITION OF CIRCLE SH13 | | | | | | | |
|---|---------|-------|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.427 | -0.123 | |
| PA | 9.000 | | | | 9.167 | 0.167 | |
| DF | 8.433 | 0.200 | 0.000 | | 8.571 | 0.138 | 0.000 |
| TP | RFS | 0.080 | | 0.000 | | 0.583 | 0.503 |

| MM DIM 8.433 DIA HOLE #14= TRUE POSITION OF CIRCLE SH14 | | | | | | | |
|---|---------|-------|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.255 | -0.295 | |
| PA | -9.000 | | | | -8.898 | 0.102 | |
| DF | 8.433 | 0.200 | 0.000 | 0.168 | 8.601 | 0.168 | 0.000 |
| TP | MMC | 0.080 | | 0.168 | | 0.672 | 0.424 |

| MM DIM 8.433 DIA HOLE #15= TRUE POSITION OF CIRCLE SH15 | | | | | | | |
|---|---------|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.147 | -0.403 | |
| PA | -27.000 | | | | -26.964 | 0.036 | |
| DF | 8.433 | 0.200 | 0.000 | 0.151 | 8.584 | 0.151 | 0.000 |
| TP | MMC | 0.080 | | 0.151 | | 0.815 | 0.584 |

| MM DIM 1450= 2D DISTANCE FROM LINE FRT END TO LINE LIN2 PAR TO YAXIS | | | | | | |
|--|----------|-------|-------|----------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 1450.000 | 0.400 | 0.400 | 1452.252 | 2.252 | 1.852 |

| MM DIM 130.0DIA= LOCATION OF CIRCLE OD1 | | | | | | |
|---|---------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| D | 130.000 | 0.200 | 0.200 | 129.903 | -0.097 | 0.000 |

| MM | DIM 502 COOLING HOLE= 2D DISTANCE FROM CIRCLE ID15 TO PLANE LRG FLANGE PAR TO YAXIS | | | | | |
|----|---|-------|-------|---------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 502.000 | 0.400 | 0.400 | 503.068 | 1.068 | 0.668 |

| MM | DIM X LOC OF COOLING HOLE= LOCATION OF CIRCLE ID15 | | | | | |
|----|--|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| X | 0.000 | 1.800 | 1.800 | -1.278 | -1.278 | 0.000 |

| DEG | DIM WARM TERMINAL= 3D ANGLE (TRUE) FROM PLANE PLN2 TO ZAXIS | | | | | |
|-----|---|-------|-------|-------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| A | 0.000 | 0.100 | 0.100 | 0.395 | 0.395 | 0.295 |

| MM | DIM X LOC OF WARM TERM= LOCATION OF PLANE MID PLN | | | | | |
|----|---|-------|-------|-------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| X | 0.000 | 0.100 | 0.100 | 0.614 | 0.614 | 0.514 |

| MM | DIM POLAR ANGLE OF COOLING HOLE= LOCATION OF CIRCLE ID15 | | | | | |
|----|--|-------|-------|--------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| PA | 90.000 | 2.000 | 2.000 | 91.427 | 1.427 | 0.000 |

| MM | DIM 442.5= 2D DISTANCE FROM LINE FRT END TO PLANE PLN -B- PAR TO YAXIS | | | | | |
|----|--|-------|-------|---------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 442.500 | 1.500 | 1.500 | 444.545 | 2.045 | 0.545 |

PART NAME : 7.5 KA CURRENT LEAD ASSY (LBNL01)
 REV NUMBER :
 SER NUMBER :
 STATS COUNT : 1

7500A DFLX 40

| MM DIM CYL -A-DIA= LOCATION OF CYLINDER CYL -A- | | | | | | |
|---|---------|-------|-------|--------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| D | 99.000 | 0.200 | 0.200 | 99.049 | 0.049 | 0.000 |

| MM DIM -A= ROUNDNESS OF CYLINDER CYL -A- | | | | | | |
|--|---------|-------|-------|-------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 0.000 | 0.200 | 0.000 | 0.147 | 0.147 | 0.000 |

| MM DIM -B= FLATNESS OF PLANE PLN -B- | | | | | | |
|--------------------------------------|---------|-------|-------|-------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 0.000 | 0.050 | 0.000 | 0.004 | 0.004 | 0.000 |

| MM DIM PERP1= PERPEND OF PLANE PLN -B- TO CYLINDER CYL -A- EXTEND=0.000 | | | | | | |
|---|---------|-------|-------|-------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 0.000 | 0.400 | 0.000 | 0.650 | 0.650 | 0.250 |

| MM DIM PERP2= PERPEND OF PLANE LRG FLANGE TO CYLINDER CYL -A- EXTEND=560.000 | | | | | | |
|--|---------|-------|-------|-------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 0.000 | 0.400 | 0.000 | 0.241 | 0.241 | 0.000 |

| MM DIM -C- DIA= LOCATION OF CYLINDER -C- | | | | | | |
|--|---------|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| D | 80.000 | 0.200 | 0.200 | 79.960 | -0.040 | 0.000 |

| MM DIM CONCEN2=CONCENTRICITY FROM CYLINDER -C- TO CYLINDER CYL -A- | | | | | | |
|--|---------|-------|-------|-------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 0.000 | 1.000 | 0.000 | 3.138 | 3.138 | 2.138 |

| MM DIM RND2= ROUNDNESS OF CYLINDER -C- | | | | | | |
|--|---------|-------|-------|-------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 0.000 | 0.200 | 0.000 | 0.059 | 0.059 | 0.000 |

| MM DIM DIST1= 2D DISTANCE FROM PLANE PLN -B- TO PLANE LRG FLANGE PAR TO YAXIS | | | | | | |
|---|---------|-------|-------|---------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 561.000 | 1.000 | 1.000 | 561.456 | 0.456 | 0.000 |

| MM DIM LOC5= TRUE POSITION OF CIRCLE CIR2 | | | | | | | |
|---|---------|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| X | 0.000 | | | | 0.000 | 0.000 | |
| Z | 123.571 | | | | 123.495 | -0.076 | |
| DF | 18.000 | 0.200 | 0.200 | | 17.975 | -0.025 | 0.000 |
| TP | RFS | 0.130 | | 0.000 | | 0.152 | 0.022 |

| MM DIM LOC10= TRUE POSITION OF CIRCLE CIR3 | | | | | | | |
|--|---------|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| X | -78.890 | | | | -78.917 | -0.028 | |
| Z | 95.047 | | | | 94.893 | -0.154 | |
| DF | 18.000 | 0.200 | 0.200 | | 17.974 | -0.026 | 0.000 |
| TP | RFS | 0.130 | | 0.000 | | 0.313 | 0.183 |

| MM DIM LOC11= TRUE POSITION OF CIRCLE CIR4 | | | | | | | |
|--|---------|-------|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| X | 78.890 | | | | 78.982 | 0.091 | |
| Z | 95.047 | | | | 95.094 | 0.047 | |
| DF | 18.000 | 0.200 | 0.200 | | 17.976 | -0.024 | 0.000 |
| TP | RFS | 0.130 | | 0.000 | | 0.205 | 0.075 |

| MM DIM LOC12= TRUE POSITION OF CIRCLE CIR5 | | | | | | | |
|--|---------|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| X | 78.890 | | | | 79.207 | 0.317 | |
| Z | -95.047 | | | | -95.026 | 0.021 | |
| DF | 18.000 | 0.200 | 0.200 | | 17.958 | -0.042 | 0.000 |
| TP | RFS | 0.130 | | 0.000 | | 0.635 | 0.505 |

| MM DIM 18.00 DIA HOLE= TRUE POSITION OF CIRCLE CIR6 | | | | | | | |
|---|---------|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| X | -78.890 | | | | -78.679 | 0.211 | |
| Z | -95.047 | | | | -95.207 | -0.160 | |
| DF | 18.000 | 0.200 | 0.200 | | 17.957 | -0.043 | 0.000 |
| TP | RFS | 0.130 | | 0.000 | | 0.529 | 0.399 |

| MM DIM 8.433 DIA HOLE #1= TRUE POSITION OF CIRCLE SH1 | | | | | | | |
|---|----------|-------|-------|-------|----------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.400 | -0.150 | |
| PA | -153.000 | | | | -152.905 | 0.095 | |
| DF | 8.433 | 0.200 | 0.000 | 0.198 | 8.631 | 0.198 | 0.000 |
| TP | MMC | 0.080 | | 0.198 | | 0.425 | 0.147 |

| MM DIM 8.433 DIA HOLE #2= TRUE POSITION OF CIRCLE SH2 | | | | | | | |
|---|----------|-------|-------|-------|----------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.342 | -0.208 | |
| PA | -171.000 | | | | -170.875 | 0.125 | |
| DF | 8.443 | 0.200 | 0.000 | 0.168 | 8.611 | 0.168 | 0.000 |
| TP | MMC | 0.080 | | 0.168 | | 0.572 | 0.324 |

| MM DIM 8.433 DIA HOLE #3= TRUE POSITION OF CIRCLE SH3 | | | | | | | |
|---|----------|-------|-------|-------|----------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.477 | -0.073 | |
| PA | -135.000 | | | | -134.904 | 0.096 | |
| DF | 8.433 | 0.200 | 0.000 | 0.200 | 8.635 | 0.202 | 0.002 |
| TP | MMC | 0.080 | | 0.200 | | 0.337 | 0.057 |

| MM DIM 8.433 DIA HOLE #4= TRUE POSITION OF CIRCLE SH4 | | | | | | | |
|---|---------|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.408 | -0.142 | |
| PA | 171.000 | | | | 171.113 | 0.113 | |
| DF | 8.433 | 0.200 | 0.000 | 0.186 | 8.619 | 0.186 | 0.000 |
| TP | MMC | 0.080 | | 0.186 | | 0.455 | 0.189 |

| MM DIM 8.433 DIA HOLE #5= TRUE POSITION OF CIRCLE SH5 | | | | | | | |
|---|---------|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.380 | -0.170 | |
| PA | 153.000 | | | | 153.078 | 0.078 | |
| DF | 8.433 | 0.200 | 0.000 | 0.175 | 8.608 | 0.175 | 0.000 |
| TP | MMC | 0.080 | | 0.175 | | 0.421 | 0.166 |

| MM DIM 8.433 DIA HOLE #6= TRUE POSITION OF CIRCLE SH6 | | | | | | | |
|---|---------|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.392 | -0.158 | |
| PA | 135.000 | | | | 135.030 | 0.030 | |
| DF | 8.433 | 0.200 | 0.000 | 0.173 | 8.606 | 0.173 | 0.000 |
| TP | MMC | 0.080 | | 0.173 | | 0.331 | 0.078 |

| MM DIM 8.433 DIA HOLE #7= TRUE POSITION OF CIRCLE SH7 | | | | | | | |
|---|---------|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.417 | -0.133 | |
| PA | 117.000 | | | | 117.012 | 0.012 | |
| DF | 8.433 | 0.200 | 0.000 | 0.175 | 8.608 | 0.175 | 0.000 |
| TP | MMC | 0.080 | | 0.175 | | 0.268 | 0.013 |

| MM | DIM 8.433 DIA HOLE #8= TRUE POSITION OF CIRCLE SH8 | | | | | | |
|----|--|-------|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.483 | -0.067 | |
| PA | 99.000 | | | | 98.991 | -0.009 | |
| DF | 8.433 | 0.200 | 0.000 | 0.188 | 8.621 | 0.188 | 0.000 |
| TP | MMC | 0.080 | | 0.188 | | 0.138 | 0.000 |

| MM | DIM 8.433 DIA HOLE #9= TRUE POSITION OF CIRCLE SH9 | | | | | | |
|----|--|-------|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.516 | -0.034 | |
| PA | 81.000 | | | | 80.966 | -0.034 | |
| DF | 8.433 | 0.200 | 0.000 | 0.195 | 8.628 | 0.195 | 0.000 |
| TP | MMC | 0.080 | | 0.195 | | 0.127 | 0.000 |

| MM | DIM 8.433 DIA HOLE #10= TRUE POSITION OF CIRCLE SH10 | | | | | | |
|----|--|-------|-------|-------|--------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.563 | 0.013 | |
| PA | 63.000 | | | | 63.007 | 0.007 | |
| DF | 8.433 | 0.200 | 0.000 | 0.192 | 8.625 | 0.192 | 0.000 |
| TP | MMC | 0.080 | | 0.192 | | 0.035 | 0.000 |

| MM | DIM 8.433 DIA HOLE #11= TRUE POSITION OF CIRCLE SH11 | | | | | | |
|----|--|-------|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.635 | 0.085 | |
| PA | 45.000 | | | | 44.966 | -0.034 | |
| DF | 8.433 | 0.200 | 0.000 | 0.200 | 8.642 | 0.209 | 0.009 |
| TP | MMC | 0.080 | | 0.200 | | 0.201 | 0.000 |

| MM | DIM 8.433 DIA HOLE #12= TRUE POSITION OF CIRCLE SH12 | | | | | | |
|----|--|-------|-------|-------|--------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.627 | 0.077 | |
| PA | 27.000 | | | | 27.031 | 0.031 | |
| DF | 8.433 | 0.200 | 0.000 | 0.200 | 8.637 | 0.204 | 0.004 |
| TP | MMC | 0.080 | | 0.200 | | 0.183 | 0.000 |

| MM | DIM 8.433 DIA HOLE #13= TRUE POSITION OF CIRCLE SH13 | | | | | | |
|----|--|-------|-------|-------|--------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.626 | 0.076 | |
| PA | 9.000 | | | | 9.032 | 0.032 | |
| DF | 8.433 | 0.200 | 0.000 | | 8.643 | 0.210 | 0.010 |
| TP | RFS | 0.080 | | 0.000 | | 0.182 | 0.102 |

| MM | DIM 8.433 DIA HOLE #14= TRUE POSITION OF CIRCLE SH14 | | | | | | |
|----|--|-------|-------|-------|--------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.631 | 0.081 | |
| PA | -9.000 | | | | -8.920 | 0.080 | |
| DF | 8.433 | 0.200 | 0.000 | 0.199 | 8.632 | 0.199 | 0.000 |
| TP | MMC | 0.080 | | 0.199 | | 0.300 | 0.021 |

| MM | DIM 8.433 DIA HOLE #15= TRUE POSITION OF CIRCLE SH15 | | | | | | |
|----|--|-------|-------|-------|---------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.616 | 0.066 | |
| PA | -27.000 | | | | -26.898 | 0.102 | |
| DF | 8.433 | 0.200 | 0.000 | 0.186 | 8.619 | 0.186 | 0.000 |
| TP | MMC | 0.080 | | 0.186 | | 0.348 | 0.081 |

| MM | DIM 1450= 2D DISTANCE FROM LINE FRT END TO LINE LIN2 PAR TO YAXIS | | | | | |
|----|---|-------|-------|----------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 1450.000 | 0.400 | 0.400 | 1452.877 | 2.877 | 2.477 |

| MM | DIM 130.0DIA= LOCATION OF CIRCLE OD1 | | | | | |
|----|--------------------------------------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| D | 130.000 | 0.200 | 0.200 | 129.922 | -0.078 | 0.000 |

| MM | DIM 502 COOLING HOLE= 2D DISTANCE FROM CIRCLE ID15 TO PLANE LRG FLANGE PAR TO YAXIS | | | | | |
|----|---|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 502.000 | 0.400 | 0.400 | 501.262 | -0.738 | 0.338 |

| MM | DIM X LOC OF COOLING HOLE= LOCATION OF CIRCLE ID15 | | | | | |
|----|--|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| X | 0.000 | 1.800 | 1.800 | -0.800 | -0.800 | 0.000 |

| DEG | DIM WARM TERMINAL= 3D ANGLE (TRUE) FROM PLANE PLN2 TO ZAXIS | | | | | |
|-----|---|-------|-------|-------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| A | 0.000 | 0.100 | 0.100 | 0.036 | 0.036 | 0.000 |

| MM | DIM X LOC OF WARM TERM= LOCATION OF PLANE MID PLN | | | | | |
|----|---|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| X | 0.000 | 0.100 | 0.100 | -0.038 | -0.038 | 0.000 |

| MM | DIM POLAR ANGLE OF COOLING HOLE= LOCATION OF CIRCLE ID15 | | | | | |
|----|--|-------|-------|--------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| PA | 90.000 | 2.000 | 2.000 | 90.902 | 0.902 | 0.000 |

| MM | DIM 442.5= 2D DISTANCE FROM LINE FRT END TO PLANE PLN -B- PAR TO YAXIS | | | | | |
|----|--|-------|-------|---------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 442.500 | 1.500 | 1.500 | 444.673 | 2.173 | 0.673 |

PART NAME : 7.5 KA CURRENT LEAD ASSY (LBNL01)
 REV NUMBER :
 SER NUMBER :
 STATS COUNT : 1

DFLX 40

| MM | DIM CYL -A-DIA= LOCATION OF CYLINDER CYL -A- | | | | | |
|----|--|-------|-------|--------|-------|--------|
| | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| D | 99.000 | 0.200 | 0.200 | 99.071 | 0.071 | 0.000 |

| MM | DIM -A= ROUNDNESS OF CYLINDER CYL -A- | | | | | |
|----|---------------------------------------|-------|-------|-------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 0.000 | 0.200 | 0.000 | 0.134 | 0.134 | 0.000 |

| MM | DIM -B= FLATNESS OF PLANE PLN -B- | | | | | |
|----|-----------------------------------|-------|-------|-------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 0.000 | 0.050 | 0.000 | 0.001 | 0.001 | 0.000 |

| MM | DIM PERP1= PERPEND OF PLANE PLN -B- TO CYLINDER CYL -A- EXTEND=0.000 | | | | | |
|----|--|-------|-------|-------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 0.000 | 0.400 | 0.000 | 0.641 | 0.641 | 0.241 |

| MM | DIM PERP2= PERPEND OF PLANE LRG FLANGE TO CYLINDER CYL -A- EXTEND=560.000 | | | | | |
|----|---|-------|-------|-------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 0.000 | 0.400 | 0.000 | 0.244 | 0.244 | 0.000 |

| MM | DIM -C- DIA= LOCATION OF CYLINDER -C- | | | | | |
|----|---------------------------------------|-------|-------|--------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| D | 80.000 | 0.200 | 0.200 | 80.153 | 0.153 | 0.000 |

| MM | DIM CONCEN2=CONCENTRICITY FROM CYLINDER -C- TO CYLINDER CYL -A- | | | | | |
|----|---|-------|-------|-------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 0.000 | 1.000 | 0.000 | 3.400 | 3.400 | 2.400 |

| MM | DIM RND2= ROUNDNESS OF CYLINDER -C- | | | | | |
|----|-------------------------------------|-------|-------|-------|-------|--------|
| | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| | 0.000 | 0.200 | 0.000 | 0.064 | 0.064 | 0.000 |

| MM | DIM DIST1= 2D DISTANCE FROM PLANE PLN -B- TO PLANE LRG FLANGE PAR TO YAXIS | | | | | |
|----|--|-------|-------|---------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 561.000 | 1.000 | 1.000 | 561.476 | 0.476 | 0.000 |

5 HOLES IN LARGE FLANGE

| MM | DIM LOC5= TRUE POSITION OF CIRCLE CIR2 | | | | | | |
|----|--|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| X | 0.000 | | | | 0.000 | 0.000 | |
| Z | 123.571 | | | | 123.509 | -0.062 | |
| DF | 18.000 | 0.200 | 0.200 | | 17.971 | -0.029 | 0.000 |
| TP | RFS | 0.130 | | 0.000 | | 0.123 | 0.000 |

| MM | DIM LOC10= TRUE POSITION OF CIRCLE CIR3 | | | | | | |
|----|---|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| X | -78.890 | | | | -78.901 | -0.012 | |
| Z | 95.047 | | | | 94.856 | -0.191 | |
| DF | 18.000 | 0.200 | 0.200 | | 17.973 | -0.027 | 0.000 |
| TP | RFS | 0.130 | | 0.000 | | 0.382 | 0.252 |

| MM | DIM LOC11= TRUE POSITION OF CIRCLE CIR4 | | | | | | |
|----|---|-------|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| X | 78.890 | | | | 78.997 | 0.107 | |
| Z | 95.047 | | | | 95.162 | 0.115 | |
| DF | 18.000 | 0.200 | 0.200 | | 17.976 | -0.024 | 0.000 |
| TP | RFS | 0.130 | | 0.000 | | 0.314 | 0.184 |

| MM | DIM LOC12= TRUE POSITION OF CIRCLE CIR5 | | | | | | |
|----|---|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| X | 78.890 | | | | 79.340 | 0.450 | |
| Z | -95.047 | | | | -94.957 | 0.090 | |
| DF | 18.000 | 0.200 | 0.200 | | 17.935 | -0.065 | 0.000 |
| TP | RFS | 0.130 | | 0.000 | | 0.918 | 0.788 |

| MM | DIM 18.00 DIA HOLE= TRUE POSITION OF CIRCLE CIR6 | | | | | | |
|----|--|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| X | -78.890 | | | | -78.542 | 0.348 | |
| Z | -95.047 | | | | -95.228 | -0.181 | |
| F | 18.000 | 0.200 | 0.200 | | 17.953 | -0.047 | 0.000 |
| P | RFS | 0.130 | | 0.000 | | 0.785 | 0.655 |

POSITION OF 16X 8.41 DIA HOLES IN LARGE FLANGE

| MM | DIM 8.433 DIA HOLE #1= TRUE POSITION OF CIRCLE SH1 | | | | | | |
|----|--|-------|-------|-------|----------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.325 | -0.225 | |
| PA | -153.000 | | | | -152.865 | 0.135 | |
| DF | 8.433 | 0.200 | 0.000 | 0.191 | 8.624 | 0.191 | 0.000 |
| TP | MMC | 0.080 | | 0.191 | | 0.621 | 0.349 |

| MM | DIM 8.433 DIA HOLE #2= TRUE POSITION OF CIRCLE SH2 | | | | | | |
|----|--|-------|-------|-------|----------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.272 | -0.278 | |
| PA | -171.000 | | | | -170.848 | 0.152 | |
| DF | 8.443 | 0.200 | 0.000 | 0.158 | 8.601 | 0.158 | 0.000 |
| TP | MMC | 0.080 | | 0.158 | | 0.735 | 0.497 |

| MM | DIM 8.433 DIA HOLE #3= TRUE POSITION OF CIRCLE SH3 | | | | | | |
|----|--|-------|-------|-------|----------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.403 | -0.147 | |
| PA | -135.000 | | | | -134.848 | 0.152 | |
| DF | 8.433 | 0.200 | 0.000 | 0.196 | 8.629 | 0.196 | 0.000 |
| TP | MMC | 0.080 | | 0.196 | | 0.564 | 0.288 |

| MM | DIM 8.433 DIA HOLE #4= TRUE POSITION OF CIRCLE SH4 | | | | | | |
|----|--|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.352 | -0.198 | |
| PA | 171.000 | | | | 171.122 | 0.122 | |
| DF | 8.433 | 0.200 | 0.000 | 0.171 | 8.604 | 0.171 | 0.000 |
| P | MMC | 0.080 | | 0.171 | | 0.552 | 0.301 |

| MM | DIM 8.433 DIA HOLE #5= TRUE POSITION OF CIRCLE SH5 | | | | | | |
|----|--|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.336 | -0.214 | |
| PA | 153.000 | | | | 153.078 | 0.078 | |
| DF | 8.433 | 0.200 | 0.000 | 0.163 | 8.596 | 0.163 | 0.000 |
| TP | MMC | 0.080 | | 0.163 | | 0.493 | 0.250 |

| MM | DIM 8.433 DIA HOLE #6= TRUE POSITION OF CIRCLE SH6 | | | | | | |
|----|--|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.366 | -0.184 | |
| PA | 135.000 | | | | 135.019 | 0.019 | |
| DF | 8.433 | 0.200 | 0.000 | 0.154 | 8.587 | 0.154 | 0.000 |
| TP | MMC | 0.080 | | 0.154 | | 0.373 | 0.139 |

| MM | DIM 8.433 DIA HOLE #7= TRUE POSITION OF CIRCLE SH7 | | | | | | |
|----|--|-------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.418 | -0.132 | |
| PA | 117.000 | | | | 116.998 | -0.002 | |
| DF | 8.433 | 0.200 | 0.000 | 0.154 | 8.587 | 0.154 | 0.000 |
| TP | MMC | 0.080 | | 0.154 | | 0.264 | 0.030 |

| MM | DIM 8.433 DIA HOLE #8= TRUE POSITION OF CIRCLE SH8 | | | | | | |
|----|--|-------|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.505 | -0.045 | |
| PA | 99.000 | | | | 98.978 | -0.022 | |
| DF | 8.433 | 0.200 | 0.000 | 0.166 | 8.599 | 0.166 | 0.000 |
| TP | MMC | 0.080 | | 0.166 | | 0.114 | 0.000 |

| MM | DIM 8.433 DIA HOLE #9= TRUE POSITION OF CIRCLE SH9 | | | | | | |
|----|--|-------|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.559 | 0.009 | |
| PA | 81.000 | | | | 80.958 | -0.042 | |
| DF | 8.433 | 0.200 | 0.000 | 0.176 | 8.609 | 0.176 | 0.000 |
| TP | MMC | 0.080 | | 0.176 | | 0.134 | 0.000 |

| MM DIM 8.433 DIA HOLE #10= TRUE POSITION OF CIRCLE SH10 | | | | | | | |
|---|---------|-------|-------|-------|--------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.627 | 0.077 | |
| PA | 63.000 | | | | 63.013 | 0.013 | |
| DF | 8.433 | 0.200 | 0.000 | 0.175 | 8.608 | 0.175 | 0.000 |
| P | MMC | 0.080 | | 0.175 | | 0.159 | 0.000 |

| MM DIM 8.433 DIA HOLE #11= TRUE POSITION OF CIRCLE SH11 | | | | | | | |
|---|---------|-------|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.709 | 0.159 | |
| PA | 45.000 | | | | 44.982 | -0.018 | |
| DF | 8.433 | 0.200 | 0.000 | 0.200 | 8.637 | 0.204 | 0.004 |
| TP | MMC | 0.080 | | 0.200 | | 0.323 | 0.043 |

| MM DIM 8.433 DIA HOLE #12= TRUE POSITION OF CIRCLE SH12 | | | | | | | |
|---|---------|-------|-------|-------|--------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.705 | 0.155 | |
| PA | 27.000 | | | | 27.063 | 0.063 | |
| DF | 8.433 | 0.200 | 0.000 | 0.197 | 8.630 | 0.197 | 0.000 |
| TP | MMC | 0.080 | | 0.197 | | 0.369 | 0.092 |

| MM DIM 8.433 DIA HOLE #13= TRUE POSITION OF CIRCLE SH13 | | | | | | | |
|---|---------|-------|-------|-------|--------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.703 | 0.153 | |
| PA | 9.000 | | | | 9.077 | 0.077 | |
| DF | 8.433 | 0.200 | 0.000 | | 8.641 | 0.208 | 0.008 |
| TP | RFS | 0.080 | | 0.000 | | 0.390 | 0.310 |

| MM DIM 8.433 DIA HOLE #14= TRUE POSITION OF CIRCLE SH14 | | | | | | | |
|---|---------|-------|-------|-------|--------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.699 | 0.149 | |
| PA | -9.000 | | | | -8.861 | 0.139 | |
| DF | 8.433 | 0.200 | 0.000 | 0.186 | 8.619 | 0.186 | 0.000 |
| TP | MMC | 0.080 | | 0.186 | | 0.531 | 0.265 |

| MM DIM 8.433 DIA HOLE #15= TRUE POSITION OF CIRCLE SH15 | | | | | | | |
|---|---------|-------|-------|-------|---------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | BONUS | MEAS | DEV | OUTTOL |
| PR | 90.550 | | | | 90.675 | 0.125 | |
| PA | -27.000 | | | | -26.821 | 0.179 | |
| DF | 8.433 | 0.200 | 0.000 | 0.179 | 8.612 | 0.179 | 0.000 |
| TP | MMC | 0.080 | | 0.179 | | 0.618 | 0.359 |

| MM DIM 1450= 2D DISTANCE FROM LINE FRT END TO LINE LIN2 PAR TO YAXIS | | | | | | |
|--|----------|-------|-------|----------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 1450.000 | 0.400 | 0.400 | 1452.654 | 2.654 | 2.254 |

| MM DIM 130.0DIA= LOCATION OF CIRCLE OD1 | | | | | | |
|---|---------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| D | 130.000 | 0.200 | 0.200 | 129.926 | -0.074 | 0.000 |

| MM DIM 502 COOLING HOLE= 2D DISTANCE FROM CIRCLE ID15 TO PLANE LRG FLANGE PAR TO YAXIS | | | | | | |
|--|---------|-------|-------|---------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 502.000 | 0.400 | 0.400 | 501.649 | -0.351 | 0.000 |

| MM DIM X LOC OF COOLING HOLE= LOCATION OF CIRCLE ID15 | | | | | | |
|---|---------|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| X | 0.000 | 1.800 | 1.800 | -1.950 | -1.950 | 0.150 |

| DEG DIM WARM TERMINAL= 3D ANGLE (TRUE) FROM PLANE PLN2 TO ZAXIS | | | | | | |
|---|---------|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| A | 0.000 | 0.100 | 0.100 | -0.155 | -0.155 | 0.055 |

| MM DIM X LOC OF WARM TERM= LOCATION OF PLANE MID PLN | | | | | | |
|--|---------|-------|-------|--------|--------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| X | 0.000 | 0.100 | 0.100 | -0.672 | -0.672 | 0.572 |

| MM | DIM POLAR ANGLE OF COOLING HOLE= LOCATION OF CIRCLE ID15 | | | | | |
|----|--|-------|-------|--------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| PA | 90.000 | 2.000 | 2.000 | 92.128 | 2.128 | 0.128 |

| MM | DIM 444.5= 2D DISTANCE FROM LINE FRT END TO PLANE PLN -B- PAR TO YAXIS | | | | | |
|----|--|-------|-------|---------|-------|--------|
| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
| M | 444.500 | 1.500 | 1.500 | 444.711 | 0.211 | 0.000 |



FERMILAB
Technical
Division

7500A HTS Power leads for the LHC DFBX

Doc. No.
Rev. No.
Date: January 6, 2003
Page 1 of 1
Author: Sandor Feher

3. Form for moving power leads

Power leads need to be moved from ~~134~~ to MTF are:
7500 DFLX 25 & 7500 DFLX 40

Approved by Sandor Feher
(name typed) (signature)

Date & time 02.22.05

The request should go through Marsha Schmidt who is responsible keeping track of whereabouts of the power leads.

Requested by ROGER RABEHL Roger Rabehl
(name typed) (signature)

Date & time FEB 18, 2005 1200

Delivered by PAUL MAYER Paul A. Mayer
(name typed) (signature)

Date & time 2-22-05 11:00 am

Received by ROGER RABEHL Roger Rabehl
(name typed) (signature)

Date & time 2-22-05 1100

The next person _____ responsible to perform Checkout form #5 (5. Installation of the current leads into the top plate) has been

Notified by _____
(name typed) (signature)

Date & time _____

This form should be copied and each copy should be placed into the folders of both of the power leads



4. Initial Electrical Checkout

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Note: Save the shipping container for storing and moving the leads around TD and after the test is complete to ship them to the DFBX manufacturer.

Performed by Dan Eddy (name typed) Dan Eddy (signature)

Date & time 7/31/03 PAIR 39:40

Power Lead 7500 A DFLX 39

When checkout is complete, make sure you place this document in the Traveler Binder

3.1 Voltage segment and drop measurement.

Apply 5 Amps between the copper flag and the LTS cable.

Record the applied current 5 A

Use HP3458 DVM, set it to 40 line cycle integration time.

Measure the voltages between the following pins:

Voltage tap Connector 1 (Primary) (Fisher DEE104A06)

Pin 1 - pin 2 (80uv) 83 V Pin 2 - pin 3 (225uv) 235 V

Pin 1 - pin 3 (300uv) 331 V Pin 3 - pin 4 (240uv) 257 V

Pin 1 - pin 4 (530uv) 598 V Pin 4 - pin 5 (float) FLOAT V

Pin 1 - pin 5 (float) FLOAT V Pin 5 - pin 6 (float) FLOAT V

Pin 1 - pin 6 (float) FLOAT V

Voltage tap Connector 2 (Redundant) (Fisher DEE104A06)

Pin 1 - pin 2 (80uv) 81 V Pin 2 - pin 3 (225uv) 243 V

Pin 1 - pin 3 (300uv) 324 V Pin 3 - pin 4 (240uv) 261 V

Pin 1 - pin 4 (530uv) 591 V Pin 4 - pin 5 (float) FLOAT V

Pin 1 - pin 5 (float) FLOAT V Pin 5 - pin 6 (float) FLOAT V

Pin 1 - pin 6 (float) FLOAT V

3.2 Verify that between pin 5 and the coiled wire at the bottom of the lead has continuity:

Connector 1 (Primary) Pin 5 and end of the wire continuity is OK not OK

Comments _____

Connector 2 (Redundant) Pin 5 and end of the wire continuity is OK not OK

Comments _____

3.2.1 Using a small piece of fiberglass tape, mark the Primary and Redundant wires

3.3 Temperature sensor resistance measurements.

3.3.1 Two wire measurement on connector 3 (Fisher DEE104Z086):

Resistance between Pin 1 and pin 2 1.09 Ω

Resistance between Pin 1 and pin 3 109.81 Ω

Resistance between Pin 1 and pin 4 109.80 Ω

Resistance between Pin 2 and pin 3 109.81 Ω



4. Initial Electrical Checkout

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Resistance between Pin 2 and pin 4 $\frac{109.81}{\Omega}$
 Resistance between Pin 3 and pin 4 $\frac{1.10}{\Omega}$
 Pins 1-4 resistance to lead $\infty \Omega$ Pins 1-4 resistance to flange $\infty \Omega$

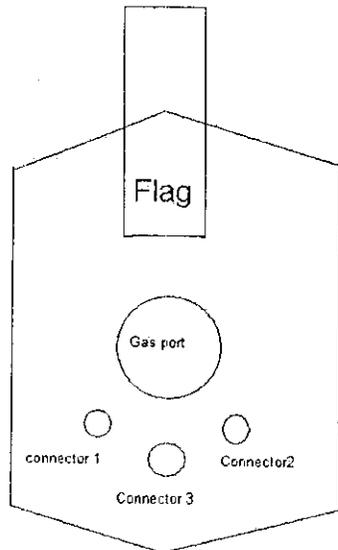
Resistance between Pin 5 and pin 6 $\frac{1.09}{\Omega}$
 Resistance between Pin 5 and pin 7 $\frac{109.79}{\Omega}$
 Resistance between Pin 5 and pin 8 $\frac{109.79}{\Omega}$
 Resistance between Pin 6 and pin 7 $\frac{109.84}{\Omega}$
 Resistance between Pin 6 and pin 8 $\frac{109.82}{\Omega}$
 Resistance between Pin 7 and pin 8 $\frac{1.11}{\Omega}$
 Pins 5-8 resistance to lead $\infty \Omega$ Pins 5-8 resistance to flange $\infty \Omega$

Resistance between Pin 9 and pin 10 $\frac{1.00}{\Omega}$
 Resistance between Pin 9 and pin 11 $\frac{109.70}{\Omega}$
 Resistance between Pin 9 and pin 12 $\frac{109.67}{\Omega}$
 Resistance between Pin 10 and pin 11 $\frac{109.74}{\Omega}$
 Resistance between Pin 10 and pin 12 $\frac{109.72}{\Omega}$
 Resistance between Pin 11 and pin 12 $\frac{1.04}{\Omega}$

Pins 9-12 resistance to lead $\infty \Omega$ Pins 9-12 resistance to flange $\infty \Omega$

3.3.2 Using HP3458 DVM measure temperature sensor resistance with the four wire measurement technique:

Resistance of T1 $\frac{108.71}{\Omega}$ (I+ at pin 1, I- at pin 2, U+ at pin 3, U- at pin 4)
 Resistance of T2 $\frac{108.70}{\Omega}$ (I+ at pin 5, I- at pin 6, U+ at pin 7, U- at pin 8)
 Resistance of T3 $\frac{108.68}{\Omega}$ (I+ at pin 9, I- at pin 10, U+ at pin 11, U- at pin 12)



Looking from the top of the lead down where the LTS cable is located.
 Connector 2= Redundant and Connector 1= Primary



4. Initial Electrical Checkout

40

Note: Save the shipping container for storing and moving the leads around TD and after the test is complete to ship them to the DFBX manufacturer.

Performed by DAN EDDY (name typed) *Dan Eddy* (signature)

Date & time 7/31/03 PAIR 39540

Power Lead 7500 A DFLX 40

When checkout is complete, make sure you place this document in the Traveler Binder

3.1 Voltage segment and drop measurement.

Apply 5 Amps between the copper flag and the LTS cable.

Record the applied current 5 A

Use HP3458 DVM, set it to 40 line cycle integration time.

Measure the voltages between the following pins:

Voltage tap Connector 1 (Primary) (Fisher DEE104A06)

| | |
|--------------------------------------|--------------------------------------|
| Pin 1 - pin 2 (80uv) <u>87</u> V | Pin 2 - pin 3 (225uv) <u>251</u> V |
| Pin 1 - pin 3 (300uv) <u>340</u> V | Pin 3 - pin 4 (240uv) <u>265</u> V |
| Pin 1 - pin 4 (530uv) <u>611</u> V | Pin 4 - pin 5 (float) <u>FLOAT</u> V |
| Pin 1 - pin 5 (float) <u>FLOAT</u> V | Pin 5 - pin 6 (float) <u>FLOAT</u> V |
| Pin 1 - pin 6 (float) <u>FLOAT</u> V | |

Voltage tap Connector 2 (Redundant) (Fisher DEE104A06)

| | |
|--------------------------------------|--------------------------------------|
| Pin 1 - pin 2 (80uv) <u>84</u> V | Pin 2 - pin 3 (225uv) <u>248</u> V |
| Pin 1 - pin 3 (300uv) <u>335</u> V | Pin 3 - pin 4 (240uv) <u>254</u> V |
| Pin 1 - pin 4 (530uv) <u>596</u> V | Pin 4 - pin 5 (float) <u>FLOAT</u> V |
| Pin 1 - pin 5 (float) <u>FLOAT</u> V | Pin 5 - pin 6 (float) <u>FLOAT</u> V |
| Pin 1 - pin 6 (float) <u>FLOAT</u> V | |

3.2 Verify that between pin 5 and the coiled wire at the bottom of the lead has continuity:

Connector 1 (Primary) Pin 5 and end of the wire continuity is OK not OK

Comments _____

Connector 2 (Redundant) Pin 5 and end of the wire continuity is OK not OK

Comments _____

3.2.1 Using a small piece of fiberglass tape, mark the Primary and Redundant wires

3.3 Temperature sensor resistance measurements.

3.3.1 Two wire measurement on connector 3 (Fisher DEE104Z086):

| | | |
|------------------------------------|---------------|---|
| Resistance between Pin 1 and pin 2 | <u>1.07</u> | Ω |
| Resistance between Pin 1 and pin 3 | <u>109.80</u> | Ω |
| Resistance between Pin 1 and pin 4 | <u>109.80</u> | Ω |
| Resistance between Pin 2 and pin 3 | <u>109.81</u> | Ω |



40

4. Initial Electrical Checkout

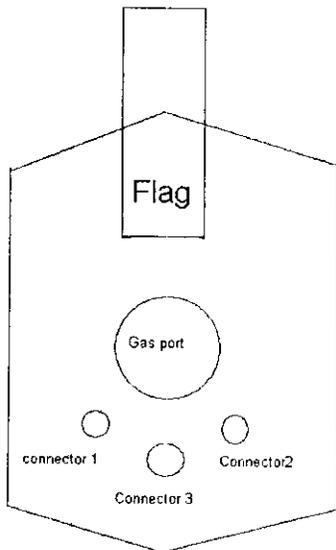
Resistance between Pin 2 and pin 4 109.81 Ω
 Resistance between Pin 3 and pin 4 1.10 Ω
 Pins 1-4 resistance to lead ∞ Ω Pins 1-4 resistance to flange ∞ Ω

Resistance between Pin 5 and pin 6 1.08 Ω
 Resistance between Pin 5 and pin 7 109.83 Ω
 Resistance between Pin 5 and pin 8 109.81 Ω
 Resistance between Pin 6 and pin 7 109.86 Ω
 Resistance between Pin 6 and pin 8 109.84 Ω
 Resistance between Pin 7 and pin 8 1.13 Ω
 Pins 5-8 resistance to lead ∞ Ω Pins 5-8 resistance to flange ∞ Ω

Resistance between Pin 9 and pin 10 1.01 Ω
 Resistance between Pin 9 and pin 11 109.73 Ω
 Resistance between Pin 9 and pin 12 109.71 Ω
 Resistance between Pin 10 and pin 11 109.76 Ω
 Resistance between Pin 10 and pin 12 109.76 Ω
 Resistance between Pin 11 and pin 12 1.02 Ω
 Pins 9-12 resistance to lead ∞ Ω Pins 9-12 resistance to flange ∞ Ω

3.3.2 Using HP3458 DVM measure temperature sensor resistance with the four wire measurement technique:

Resistance of T1 108.72 Ω (I+ at pin 1, I- at pin 2, U+ at pin 3, U- at pin 4)
 Resistance of T2 108.72 Ω (I+ at pin 5, I- at pin 6, U+ at pin 7, U- at pin 8)
 Resistance of T3 108.73 Ω (I+ at pin 9, I- at pin 10, U+ at pin 11, U- at pin 12)



Looking from the top of the lead down where the LTS cable is located.
 Connector 2= Redundant and Connector 1= Primary



Post U.K. Repair

4. Initial Electrical Checkout

Note: Save the shipping container for storing and moving the leads around TD and after the test is complete to ship them to the DFBX manufacturer.

Performed by Dan Eddy
(name typed) (signature)

Date & time 02/23/2005

Power Lead 7500 A DFLX 40

When checkout is complete, make sure you place this document in the Traveler Binder

3.1 Voltage segment and drop measurement.

Apply 5 Amps between the copper flag and the LTS cable.

Record the applied current 5 A

Use HP3458 DVM, set it to 40 line cycle integration time.

Measure the voltages between the following pins:

Voltage tap Connector 1 (Primary) (Fisher DEE104A06)

| | |
|--------------------------------------|--------------------------------------|
| Pin 1 - pin 2 (80uv) <u>83.4</u> V | Pin 2 - pin 3 (225uv) <u>245.4</u> V |
| Pin 1 - pin 3 (300uv) <u>330.4</u> V | Pin 3 - pin 4 (240uv) <u>260.4</u> V |
| Pin 1 - pin 4 (530uv) <u>594.4</u> V | Pin 4 - pin 5 (float) <u>FLOAT</u> V |
| Pin 1 - pin 5 (float) <u>FLOAT</u> V | Pin 5 - pin 6 (float) <u>FLOAT</u> V |
| Pin 1 - pin 6 (float) <u>FLOAT</u> V | |

Voltage tap Connector 2 (Redundant) (Fisher DEE104A06)

| | |
|--------------------------------------|--------------------------------------|
| Pin 1 - pin 2 (80uv) <u>84.4</u> V | Pin 2 - pin 3 (225uv) <u>249.4</u> V |
| Pin 1 - pin 3 (300uv) <u>334.4</u> V | Pin 3 - pin 4 (240uv) <u>253.4</u> V |
| Pin 1 - pin 4 (530uv) <u>590.4</u> V | Pin 4 - pin 5 (float) <u>FLOAT</u> V |
| Pin 1 - pin 5 (float) <u>FLOAT</u> V | Pin 5 - pin 6 (float) <u>FLOAT</u> V |
| Pin 1 - pin 6 (float) <u>FLOAT</u> V | |

3.2 Verify that between pin 5 and the coiled wire at the bottom of the lead has continuity:

Connector 1 (Primary) Pin 5 and end of the wire continuity is OK not OK

Comments _____

Connector 2 (Redundant) Pin 5 and end of the wire continuity is OK not OK

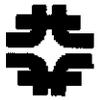
Comments _____

3.2.1 Using a small piece of fiberglass tape, mark the Primary and Redundant wires

3.3 Temperature sensor resistance measurements.

3.3.1 Two wire measurement on connector 3 (Fisher DEE104Z086):

| | | |
|------------------------------------|---------------|---|
| Resistance between Pin 1 and pin 2 | <u>1.04</u> | Ω |
| Resistance between Pin 1 and pin 3 | <u>109.66</u> | Ω |
| Resistance between Pin 1 and pin 4 | <u>109.67</u> | Ω |
| Resistance between Pin 2 and pin 3 | <u>109.63</u> | Ω |



4. Initial Electrical Checkout

Resistance between Pin 2 and pin 4 109.64 Ω
 Resistance between Pin 3 and pin 4 1.09 Ω
 Pins 1-4 resistance to lead ∞ Ω Pins 1-4 resistance to flange ∞ Ω

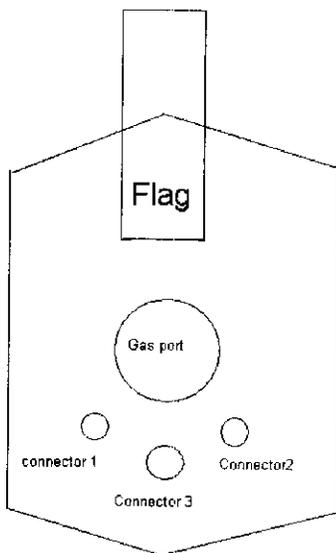
Resistance between Pin 5 and pin 6 1.02 Ω
 Resistance between Pin 5 and pin 7 109.65 Ω
 Resistance between Pin 5 and pin 8 109.67 Ω
 Resistance between Pin 6 and pin 7 109.64 Ω
 Resistance between Pin 6 and pin 8 109.65 Ω
 Resistance between Pin 7 and pin 8 1.06 Ω
 Pins 5-8 resistance to lead ∞ Ω Pins 5-8 resistance to flange ∞ Ω

Resistance between Pin 9 and pin 10 .94 Ω
 Resistance between Pin 9 and pin 11 109.52 Ω
 Resistance between Pin 9 and pin 12 109.53 Ω
 Resistance between Pin 10 and pin 11 109.54 Ω
 Resistance between Pin 10 and pin 12 109.55 Ω
 Resistance between Pin 11 and pin 12 1.00 Ω

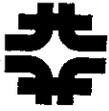
Pins 9-12 resistance to lead ∞ Ω Pins 9-12 resistance to flange ∞ Ω

3.3.2 Using HP3458 DVM measure temperature sensor resistance with the four wire measurement technique:

Resistance of T1 108.61 Ω (I+ at pin 1, I- at pin 3, U+ at pin 2, U- at pin 4)
 Resistance of T2 108.62 Ω (I+ at pin 5, I- at pin 7, U+ at pin 6, U- at pin 8)
 Resistance of T3 108.58 Ω (I+ at pin 9, I- at pin 11, U+ at pin 10, U- at pin 12)



Looking from the top of the lead down where the LTS cable is located.
Connector 2= Redundant and Connector 1= Primary



FERMILAB
Technical Division
Development & Test

**7500 A HTS Power Leads for the
LHC DFBX:
4a. Preliminary Leak Check
Procedure**

Doc. No.
Rev. 1 (RJR)
Rev. Date: August 18, 2003
Page 1 of 2



**FERMILAB
Technical Division**

**7500 A HTS Power Leads for the LHC DFBX:
4a. Preliminary Leak Check Procedure**

Lead Number: 40

Signed

P.E. Hues

Date 02.23.05



**7500 A HTS Power Leads for the
LHC DFBX:
4a. Preliminary Leak Check
Procedure**

1. Preparation for Leak Checking

- 1.1 Attach the lifting/insertion tool to the lead flag as shown in Figure 1.1 and remove the lead from the shipping container.

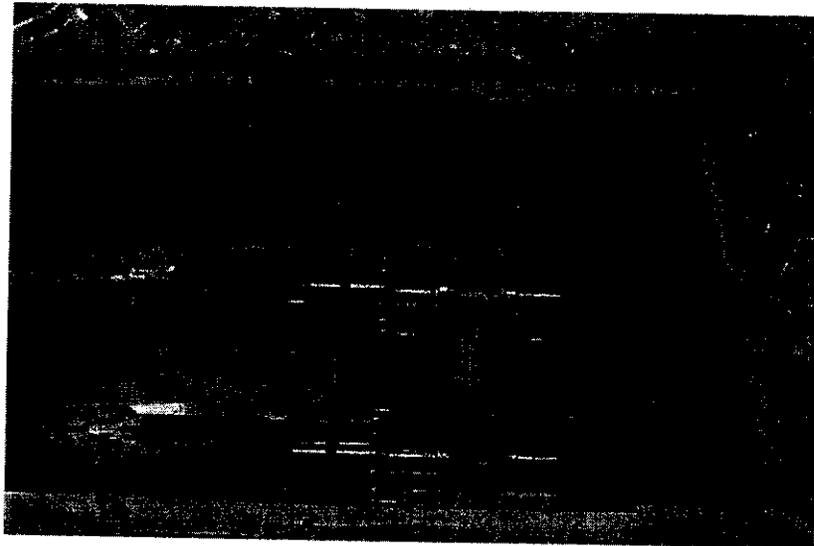


Figure 1.1 The lifting/insertion tool bolted to a power lead in preparation for removing it from the shipping container.

- 1.2 Remove the plastic plug from the 4-20 K gas inlet on the lead body.
1.3 Put the power lead on the steel table, with the power lead lower flange resting in a V-block.
1.4 Hose clamp a rubber gasket and PVC clamshells around the lead to cover and seal the 4-20 K inlet.
1.5 Attach an adapter to the top of the power lead so that a leak detector can be connected.
1.6 Wrap the voltage tap wires around the bottom of the lead and secure them with tape.

2. Leak Check-Lead Number 40

- 2.1 Pump out the power lead with the leak detector.
2.2 Record the baseline reading from the leak detector.

Baseline: 74.1×10^{-15} (1.9×10^{-8} atm cc Sec⁻¹)

- 2.3 Spray all joints with He and watch for a signal from the leak detector
2.4 Record the maximum leak detector reading.

Maximum reading: 73.8×10^{-15} (1.9×10^{-8} atm cc Sec⁻¹)



FERMILAB
Technical
Division

**7500 A HTS Power Leads for the
LHC DFBX:
5. Installation of the Current
Leads**

Doc. No.
Rev. 7 (RJR)
Rev. Date: October 17, 2003
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FERMILAB
Technical Division

**Stand 3 LHC-HTS Lead Testing:
5. Installation of the Current Leads**

Lead Pair

Negative Lead: 20

Positive Lead: 40

Signed

C. E. Hess Jr.

Date

03.01.05



1. Mechanical Integration of Current Leads in Test Facility

- 1.1 Using wedges, tilt the insert by 10° so that the power leads will be vertical when installed.
- 1.2 Clean sealing surfaces inside the chimneys with acetone and/or alcohol wipe.
- 1.3 Position the upper insulator in each chimney according to Figure 1.3.
- 1.4 Position the PEEK seal in each chimney according to Figure 1.3.
- 1.5 Position the lower insulator in each chimney according to Figure 1.3.

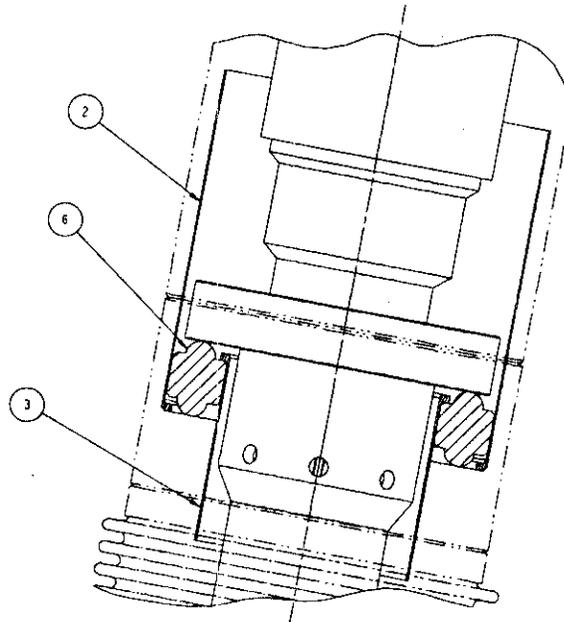


Figure 1.3 2 – Upper Insulator, 3 – Lower Insulator, 6 – PEEK Seal

- 1.6 Attach the lifting/insertion tool to the lead flag as shown in Figure 1.6 and lift the lead from the steel table where the preliminary leak check was performed.

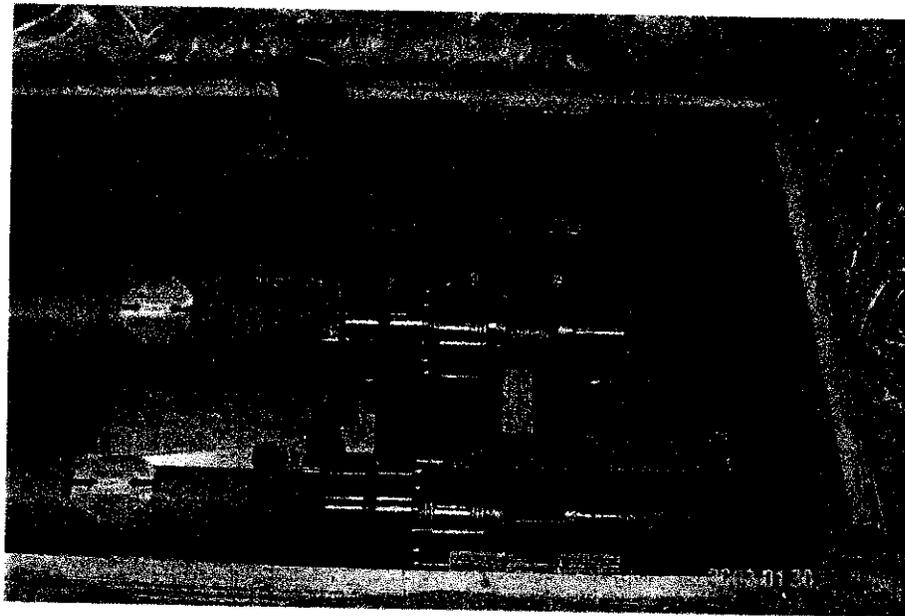
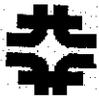


Figure 1.6 The lifting/insertion tool bolted to a power lead.

- 1.7 Remove the rubber gasket and PVC clamshells from the 4-20 K gas inlet on the lead body.
- 1.8 Remove the protective covers from the lower and upper flanges.
- 1.9 With alcohol, clean the lower flange and the upper flange knife edge and sealing surface.
- 1.10 Prepare to install the power lead baffle by removing the short threaded rods to open the baffle.
- 1.11 Install the baffle on the lead with the pointed tips of the threaded rods pointing toward the bottom of the lead. An installed baffle is shown in Figure 1.11.

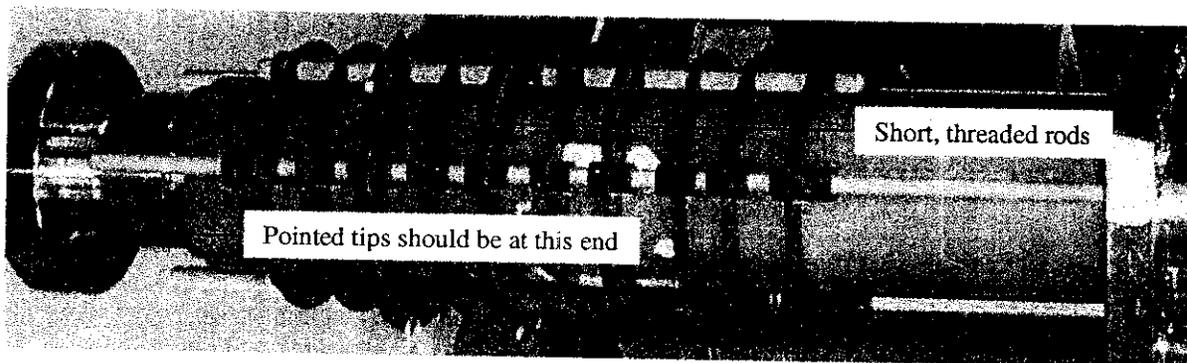


Figure 1.11 A baffle installed on a power lead.

- 1.12 Clamp the end support around the lower flange so that the handles will rest on the backs of the C-channels clamped to the steel table.
- 1.13 Set the lead between the C-channels on the steel table.
- 1.14 Clean the top plate Conflat flange knife edge and copper gasket. Install the gasket on the top plate Conflat flange.



- 1.15 Align the top plate rotatable Conflat flange to the orientation shown on Figure 1.15, where the leak check grooves on the flange align with the middle tensioning studs.

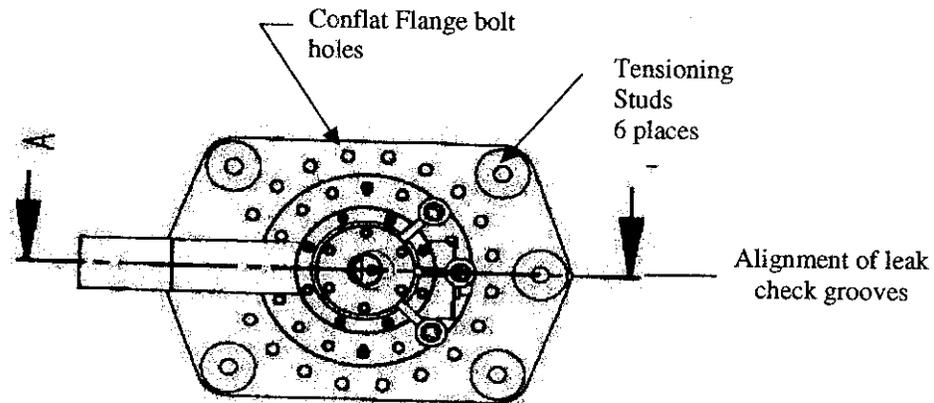


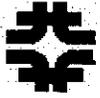
Figure 1.15 The 20-hole Conflat bolt pattern is bisected by center tensioning studs.

- 1.16 Back down the nuts on the tensioning studs.
1.17 Swing the lifting/insertion tool 180 degrees as shown in Figure 1.17 in preparation for lifting the power lead into the vertical position.



Figure 1.17 The lifting/insertion tool in position to lift the power lead into a vertical position.

- 1.18 Strapping the overhead crane to the lifting/insertion tool and manually guiding the lower end support, lift the lead and position it vertically while not allowing any loading on the bottom end of the lead.



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Division

7500 A HTS Power Leads for the LHC DFBX: 5. Installation of the Current Leads

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- 1.19 Remove the lower end support.
- 1.20 Tie a weighted string to the LTS bus to help guide it through the chimney during installation.
- 1.21 Install the lead in the chimney per Figure 1.21a until the lower sealing flange bottoms out. The flag should be toward the bayonet connections on the insert. The negative lead is installed on the left hand side, and the positive lead is installed on the right hand side as shown in Figure 1.21b.

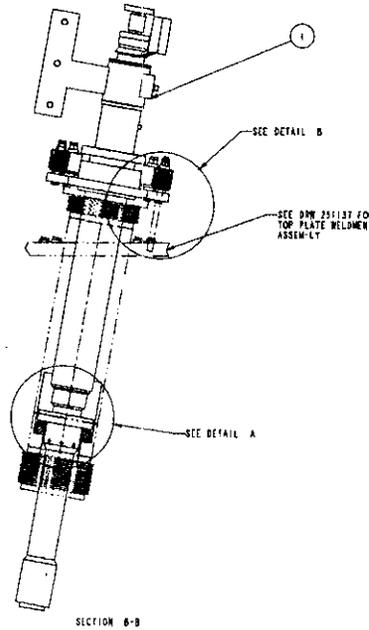
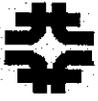


Figure 1.21a HTS Lead in Test Chimney. Note: CERN chimneys do not have bellows.

Negative Lead DFLX 20 Positive Lead DFLX 40



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**7500 A HTS Power Leads for the
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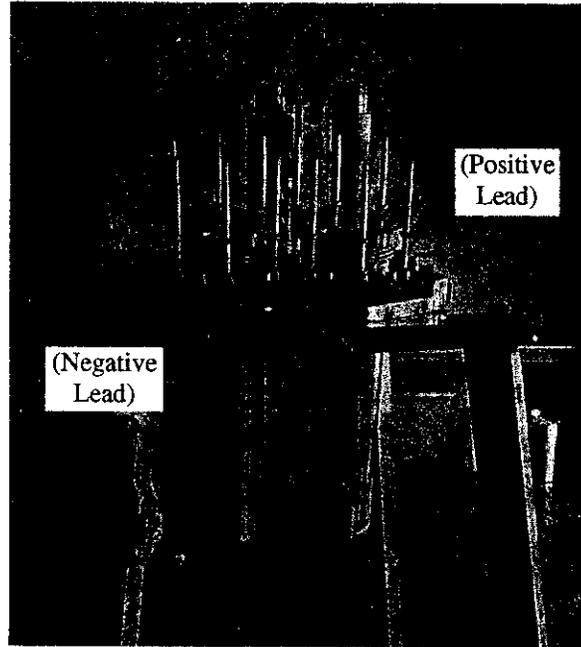


Figure 1.21b Locations of the negative and positive leads.

1.22 Raise the nuts on the tensioning studs to hold the lead in place, as shown in Figure 1.22.

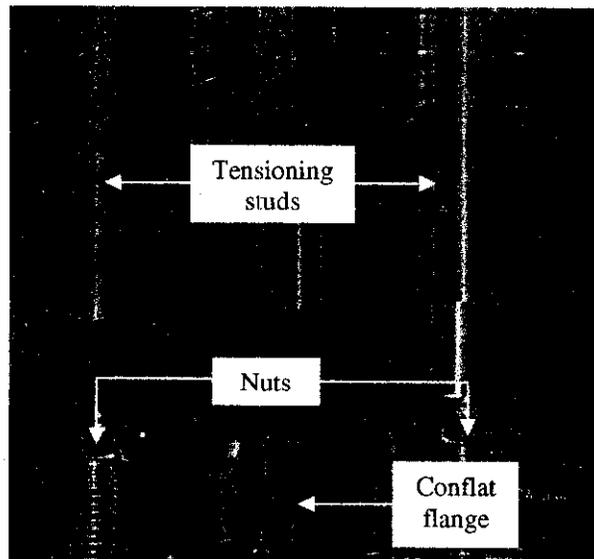
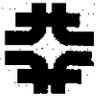


Figure 1.22 The positions of the tensioning studs, nuts, and top plate Conflat flange as the 20 Conflat bolts are tightened.

Negative Lead DFLX 20 Positive Lead DFLX 40



- 1.23 Center the lower end of the lead in the chimney using the centering shim blocks. The Teflon inner centering shim blocks are labeled with an 'I' and go between the power lead and the lower insulator. The Teflon outer centering shim blocks are labeled with an 'O' and go between the lower insulator and the chimney. The installed Teflon centering shim blocks are shown in Figure 1.23.

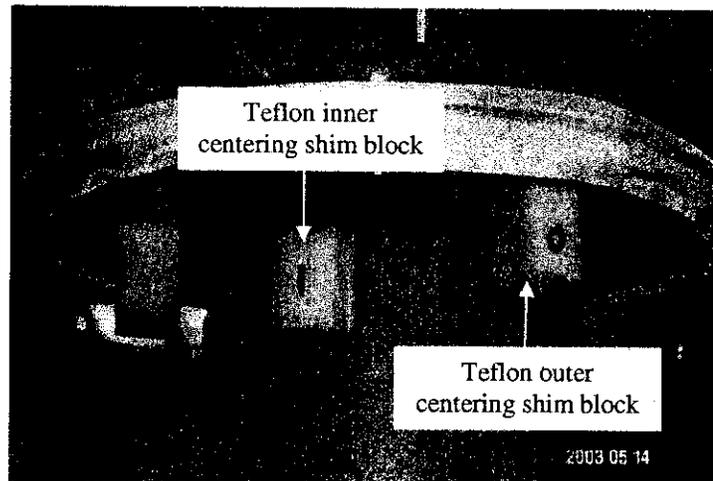


Figure 1.23 The installed Teflon centering shim blocks.

- 1.24 On the power lead flange, number the Conflat bolt holes 1 through 20 as indicated by Figure 1.24.
- 1.25 If there is a gap between the top plate Conflat flange and the Pirelli flange, pull the bellows up to close the gap using bolts 1 through 4.
- 1.26 Use a 5/16 12-point socket to tighten the 20 Conflat bolts. The tightening must be made gradually in 1/4 turn increments to a final torque of 15 ft-lbf (180 in-lbf). The tightening sequence is given by Fig. 1.24.



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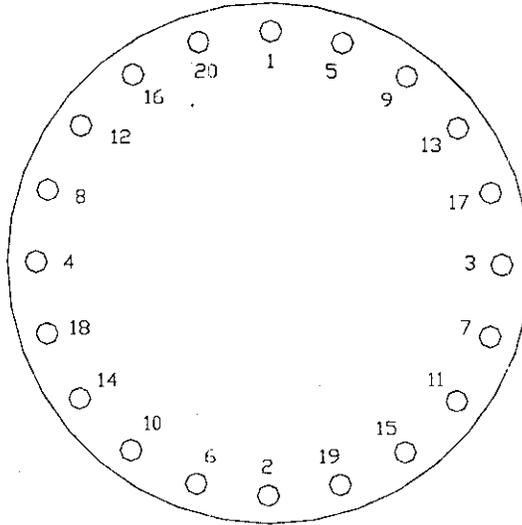


Figure 1.24 Tightening sequence for the 20 Conflat bolts.

- 1.27 Unbolt the lifting/insertion tool from the installed power lead.
- 1.28 Install Belleville Washer Assemblies on each tensioning stud per Figures 1.28a and 1.28b. A spherical washer must be placed below the Belleville washer holder on each stud. In the figures: Items 11 (10 each) are Belleville Washers, arranged as shown; Items 6 (2 each) are flat washers; Items 4 and 5 are the Belleville Washer Holder; Item 10 are Spherical Washers for above and below the washer holder; Item 9 is a loading nut; and Item 8 is a jam nut.



7500 A HTS Power Leads for the LHC DFBX: 5. Installation of the Current Leads

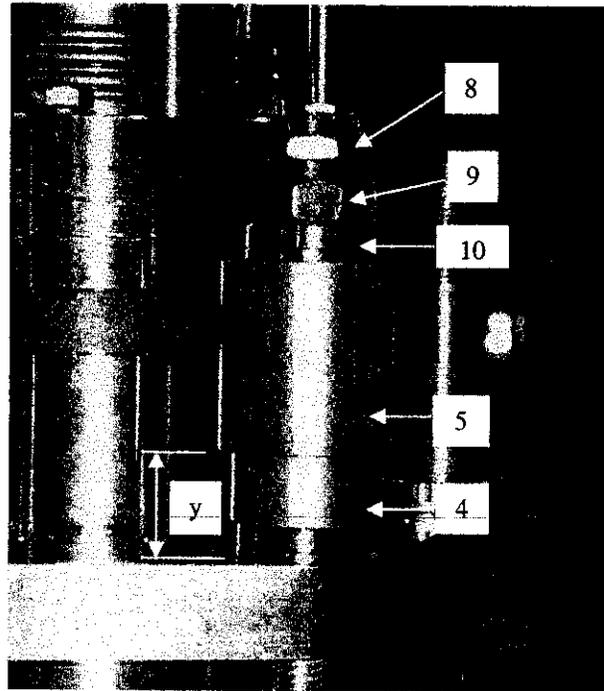


Figure 1.28a An installed Belleville Washer Assembly.

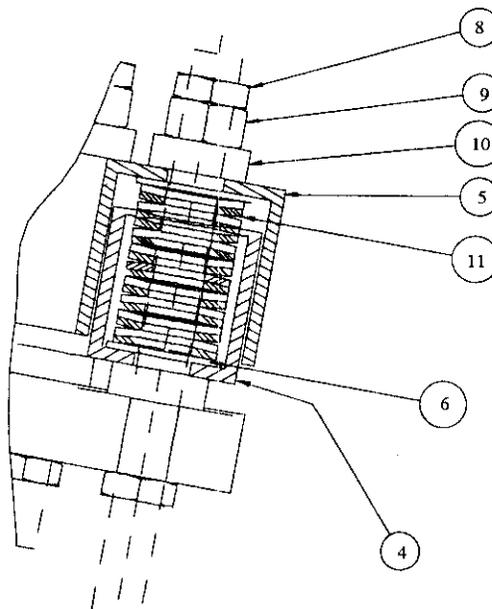


Figure 1.28b An installed Belleville Washer Assembly.

1.29 Tighten the 6 Belleville Washer Assemblies to apply load to the PEEK seal.
1.29.1 Washers for Lead DFLX 40

Negative Lead DFLX 20 Positive Lead DFLX 40



**7500 A HTS Power Leads for the
LHC DFBX:
5. Installation of the Current
Leads**

1.29.1.1 Ensure that the tensioning rod nuts used in 1.22 have a gap of about 5 mm below the lead flange.

1.29.1.2 Tighten the 6 loading nuts finger-tight. With adjustable parallels, measure and record the gap "y" indicated in Figure 1.28a between Item 5 and the current lead top flange at the 6 locations specified in Figure 1.29.1.5. Units are mm.

A 24.47 B 24.29 C 24.14 D 23.87 E 24.35 F 23.96

1.29.1.3 For each of the six studs: remove the adjustable parallel, adjust it for 1.8 mm of compression, and return the adjustable parallel into position under the Belleville washer holder. Record the adjusted heights of the adjustable parallels. Units are mm.

A 22.67 B 22.49 C 22.34 D 22.07 E 22.55 F 22.16

1.29.1.4 Using the sequence A through F in Figure 1.29.1.5, tighten the loading nuts 1/4 turn until the total compression is 1.8 mm at each of the six locations. As each loading nut is tightened 1/4 turn, check off the appropriate line.

A ✓ B ✓ C ✓ D ✓ E ✓ F ✓

A ✓ B ✓ C ✓ D ✓ E ✓ F ✓

A ✓ B ✓ C ✓ D ✓ E ✓ F ✓

A ✓ B ✓ C ✓ D ✓ E ✓ F ✓

A ✓ B ✓ C ✓ D ✓ E ✓ F ✓

A ✓ B ✓ C ✓ D ✓ E ✓ F ✓

A ✓ B ✓ C ✓ D ✓ E ✓ F ✓

A _____ B _____ C _____ D _____ E _____ F _____

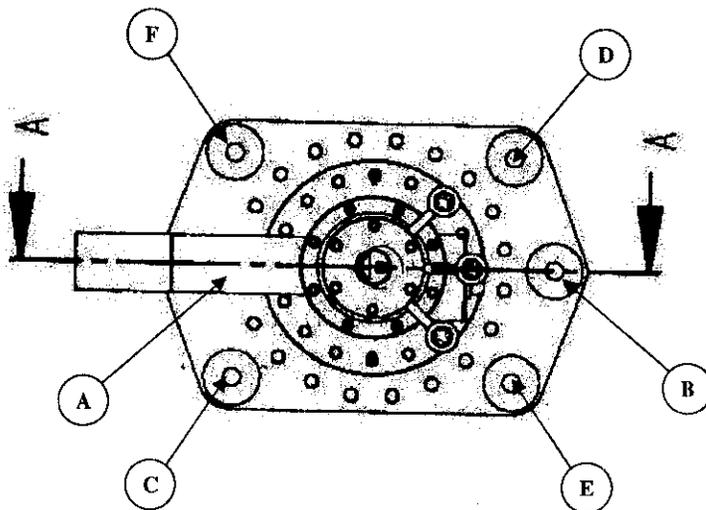


Figure 1.29.1.5 The specified sequence for tightening the Belleville Washer Assemblies.

1.29.1.5 Remove the adjustable parallels from under each Belleville washer assembly, then replace them and measure the final gaps 'y' in Figure 1.28a. Units are mm.

A 22.66 B 22.48 C 22.35 D 22.13 E 22.55 F 22.08

1.29.1.6 Remove the Teflon centering shim blocks from the installed power lead.

1.29.2 Washers for Lead DFLX 20

1.29.2.1 Ensure that the nuts used in 1.22 have a gap of about 5 mm below the lead flange.

1.29.2.2 Tighten the 6 loading nuts finger-tight. With adjustable parallels, measure and record the gap "y" indicated in Figure 1.28a between Item 5 and the current lead top flange at the 6 locations specified in Figure 1.29.1.5. Units are mm.

A 24.14 B 24.17 C 23.90 D 23.89 E 24.30 F 23.80

1.29.2.3 For each of the six studs: remove the adjustable parallel, adjust it for 1.8 mm of compression, and return the adjustable parallel into position under the Belleville washer holder. Record the adjusted heights of the adjustable parallels. Units are mm.

A 22.34 B 22.57 C 22.10 D 22.09 E 22.50 F 22.00

1.29.2.4 Using the sequence A through F in Figure 1.29.1.5, tighten the loading nuts ¼ turn until the total compression is 1.8 mm at each of the six locations. As each of the loading nuts is turned ¼ turns, check off the appropriate line.

A B C D E F



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5. Installation of the Current
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A B C D E F
 A B C D E F
 A B C D E F
 A B C D E F
 A B C D E F
 A _____ B _____ C _____ D _____ E _____ F _____
 A _____ B _____ C _____ D _____ E _____ F _____
 A _____ B _____ C _____ D _____ E _____ F _____

1.29.2.5 Record the final measured gaps 'y' in Figure 1.28a. Units are mm.

A 22.39 B 22.34 C 22.09 D 22.08 E 22.46 F 21.99

1.29.2.6 Remove the Teflon centering shim blocks from the installed power lead.

1.30 On both power leads, tighten down the jam nuts to secure the loading nuts on the installed Belleville Washer Assemblies.

1.31 Tighten the nuts on the underside of the current lead top plate against the plate to provide stability during transportation.

2. Pressure Test

2.1 Follow the procedure specified in the document entitled, "7500 A HTS Power Leads for the LHC DFBX: 6. Pressure Test Procedure."

3. Leak Check

3.1 Follow the procedure specified in the document entitled, "7500 A HTS Power Leads for the LHC DFBX: 7. Leak Check Procedure."

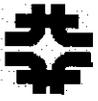
4. Electrical Integration of Current Leads in Test Facility

4.1 Attach the G-10 clamshell clamp at the bottoms of the power leads, and install the clamp support.

4.2 Clean the LTS pigtails with alcohol.

4.3 Make connection to LTS pigtails. The joint is a mechanical connection with a stainless steel clamp block (supplied by LBNL) and indium foil between the cables to ensure good electrical contact. Torque each of the clamp block fasteners to **10 ft-lbf**. Figure 4.3a shows a rendition of

Negative Lead DFLX 20 Positive Lead DFLX 40



the installed power leads. Figure 4.3b shows the G-10 clamshell clamp, the clamp support, and the mechanical clamp.

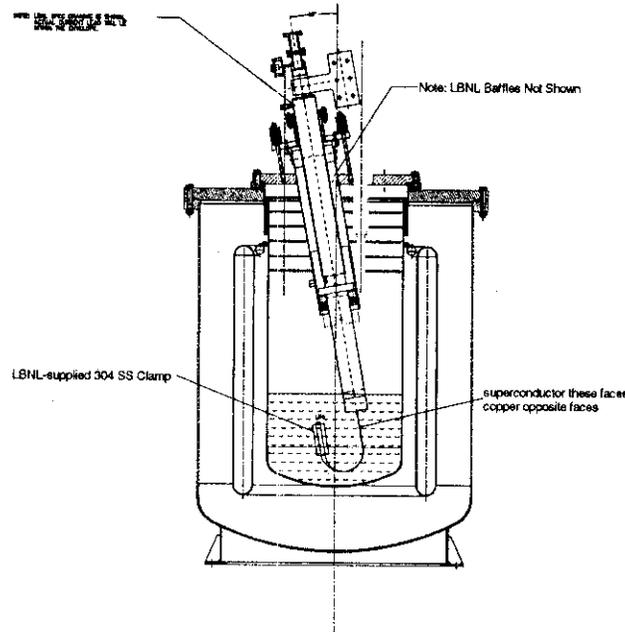


Figure 4.3a Side View of Lead in Cryostat with the LTS cables connected.

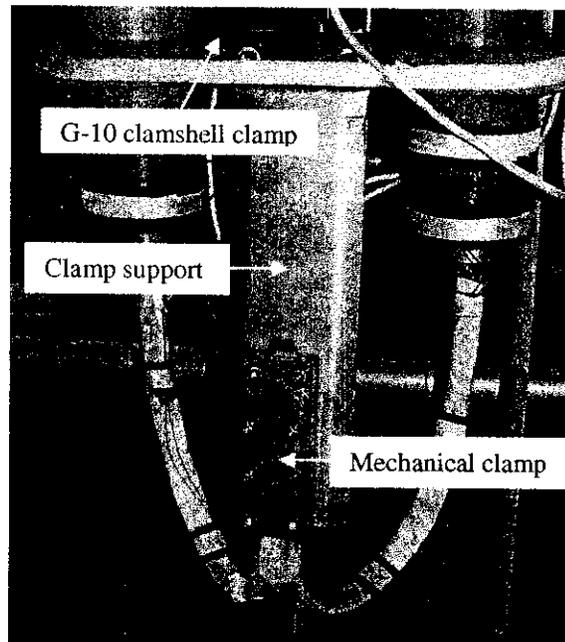


Figure 4.3b Electrical integration of the LTS sections.



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5. Installation of the Current
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- 4.4 Clamp a piece of bus wire and a small amount of indium to the LTS cable. Solder the two V5 voltage tap wires to the bus wire. Wind excess voltage tap wire around the bottom of the lead, securing it with Kapton and glass tape.
- 4.5 Insulate the superconducting cable with Kapton and glass tape.
- 4.6 Install He space temperature sensors and LHe liquid level probes.
- 4.7 Install the bottom fill tube.
- 4.8 Bolt the heaters to each power lead. Use grease at the interface to improve the thermal contact between the heater and power lead.
- 4.9 Measure and record dimensions required for the insert map.



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**7500 A HTS Power Leads for the
LHC DFBX:
6. Pressure Test Procedure**

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**7500 A HTS Power Leads for the LHC DFBX:
6. Pressure Test Procedure**

Lead Pair

Negative Lead: 20

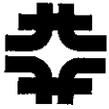
Positive Lead: 40

Signed

C. E. New J

Date

03.02.05



**7500 A HTS Power Leads for the
LHC DFBX:
6. Pressure Test Procedure**

1. Preparation for Pressurization

- 1.1 Install the bayonet plug into the 4-20 K supply bayonet on the top plate. Tie it down.
- 1.2 On the 4-20 K female bayonet vacuum jacket, cap off one of the 1/4 inch compression fittings. Connect the test gauge and associated tubing to the second 1/4 inch compression fitting.
- 1.3 Install Conflat blankoffs on the vents of the installed power leads.
- 1.4 Put the cover cans over each lead vent and tie them down.
- 1.5 Connect a nitrogen bottle to the pressure test tubing.

2. Pressurization

- 2.1 Pressurize the 4-20 K circuit to 65 psia (50 psig) and record the initial pressure from the test gauge.

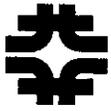
Initial pressure: 65.6 psia 13:40

- 2.2 Wait five minutes and record the final pressure from the test gauge.

Final pressure: 65.6 psia 13:46

3. Release of Pressure

- 3.1 Isolate the nitrogen bottle.
- 3.2 Release the pressure by opening the hand valve on the pressure test tubing.
- 3.3 Disconnect the pressure test tubing from the top plate/insert.



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**7500 A HTS Power Leads for the
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7. Leak Check Procedure**

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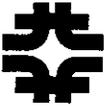
**7500 A HTS Power Leads for the LHC DFBX:
7. Leak Check Procedure**

Lead Pair

Negative Lead: 20

Positive Lead: 40

Signed *C.E. Hesse Jr* Date 03.03.05



**7500 A HTS Power Leads for the
LHC DFBX:
7. Leak Check Procedure**

1. Preparation for Leak Checking

- 1.1 Cap/plug the two 1/4 inch compression fittings on the 4-20 K female bayonet vacuum jacket.
- 1.2 Remove the Conflat blankoff from one of the lead vents and install the modified Conflat with a vacuum pumpout.
- 1.3 Attach a leak detector to the vacuum pumpout installed on the top of one of the power leads.

2. Leak Check

- 2.1 Pump out the 4-20 K circuit with the leak detector.
- 2.2 Record the baseline reading from the leak detector.

Baseline: $61.8_D \times 10_S (1.54e-7 \text{ atm cc sec}^{-1})$ *

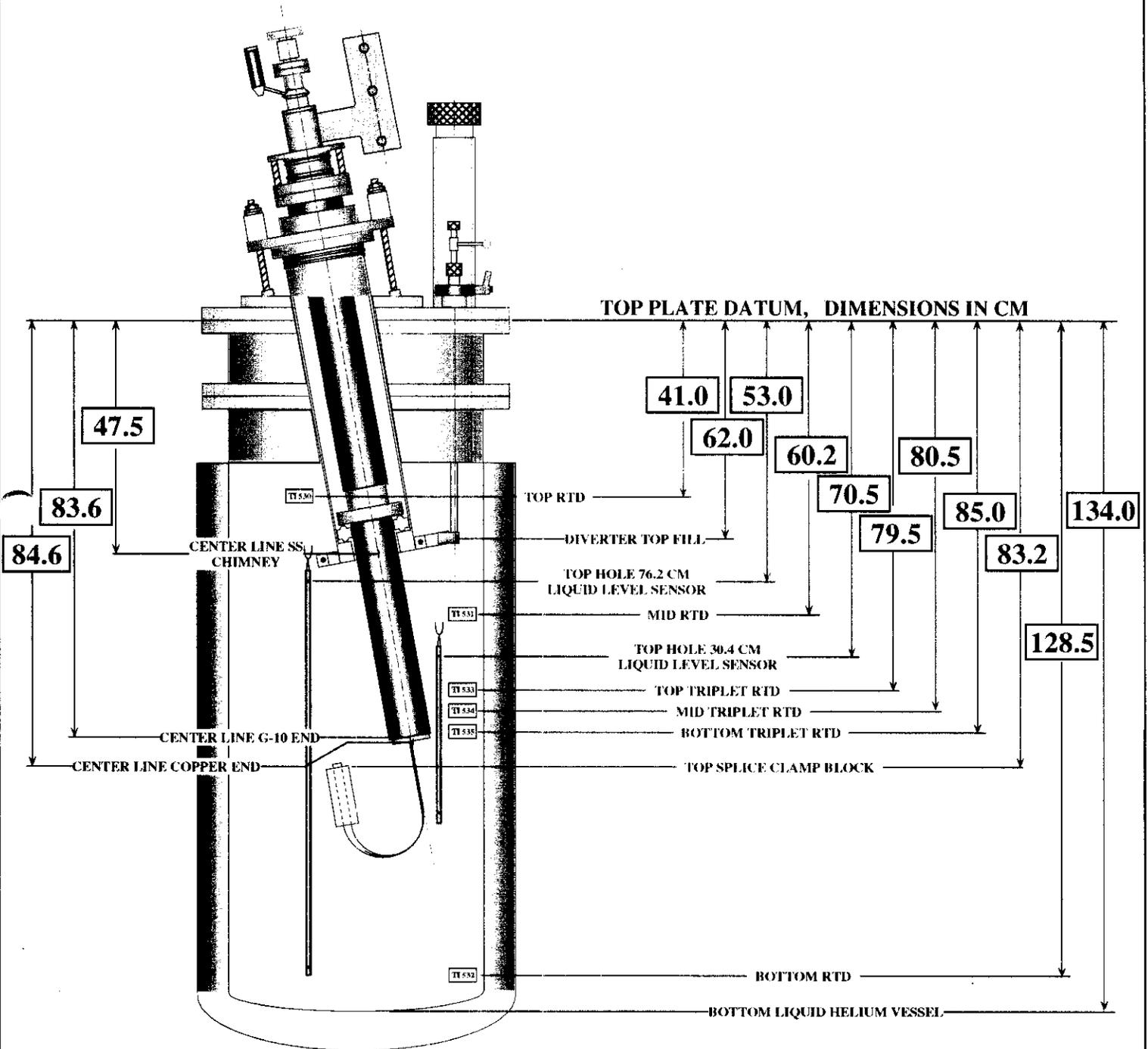
- 2.3 Spray all joints with He and watch for a signal from the leak detector
- 2.4 Record the maximum leak detector reading.

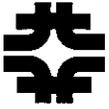
Maximum reading: $61.6_D \times 10_S (1.54e-7 \text{ atm cc sec}^{-1})$ *

Note: Both PEEK seals leak to saturation. The above numbers reflect all other joints.

LHC HTS POWER LEAD TESTING @ TEST STAND 3

PAIR - DFLX- 20 (-) & DFLX- 40 (+)

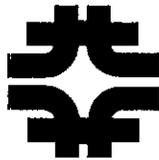




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**7500 A HTS Power Leads for the
LHC DFBX:
7a. Top Plate Insertion into the
Dewar**

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Rev. Date: Sept. 3, 2003
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**7500 A HTS Power Leads for the LHC DFBX:
7a. Top Plate Insertion into the Dewar**

Lead Pair

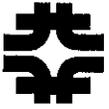
Negative Lead: 20

Positive Lead: 4c

Signed

Date

03.04.05



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**7500 A HTS Power Leads for the
LHC DFBX:
7a. Top Plate Insertion into the
Dewar**

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1. Grease and install an o-ring on the top flange of the dewar extension.
2. Remove the 10 degree blocks from under the top plate.
3. Lift the top plate and insert from the roll-around cart and set them onto the dewar extension. The leads must be on the south side of the test dewar.
4. Install a power lead vent, stack on each power lead, keeping in mind the orientation of the vent line.
5. Verify that the heaters are bolted to the power leads.

Negative Lead DFLX 20 Positive Lead DFLX 40



9. Room Temperature Electrical Checkout

Note: Save the shipping container for storing and moving the leads around TD and after the test is complete to ship them to the DFBX manufacturer.

Performed by Dan Watson (Name typed) (Signature)

Date & time 3/7/05

Pos. Power Lead 7500 A DFLX 40 and Neg. Power Lead 7500 A DFLX 20

When checkout is complete, make sure you place the original and a copy of this document in the Traveler Binder.

1.0 Before beginning checkout, be sure that the following is done:

- Make sure all of the 4-pin circular Hypertronic connectors inside dewar have been connected and taped up with fiberglass tape.
- Cool down and check pos and neg lead heaters. ~1ohm
- Install positive and negative lead heaters.
- Be sure to apply thermal compound on the back of heaters before attaching to leads.
- Attach primary and redundant labels to the fisher connector assembly on each lead

Primary = Left Redundant=Right

2.0 Voltage drop measurement for Vtap & flag cables.

- 2.1 Connect Kepco power supply cable to the LHC power leads. This is the gray two-conductor cable (black to negative lead and clear to positive lead).
- 2.2 Connect before and After Flags ring terminals to both leads.
- 2.3 Configure the Kepco distribution box on the Stand 4 platform to power the LHC power leads (jumper should be in the Checkout power/Stand-3 Power leads position).
- 2.4 Turn on Kepco power supply and set the output for 10 amps. (5v on HP meter=10 amps)
- 2.5 Connect stand 3 trim current cable to shunt current monitor above the Kepco power supply.
- 2.6 Log into cryo computer (left computer at Stand 3). Password is: ScMagsRU

NOTE: Be sure that Mike T has rebooted the system and scans are active or values will not show

DFLX _____ DFLX _____



9. Room Temperature Electrical
Checkout

avench-Doctor

- 2.7 Bring up a terminal and type the following to bring up the numerical display
ssh mdtf34
The password is: ScMagsRU (can also rlogin mdtf24)
You should be in the directory mdtf34: home/mdtf34/cryo
Type the command: numdisp -n mtfvx27&
(numeric display on mtfuz27 shows up)
Click on chooser
Click the File button on numeric display.
Then choose Load setup
Enlarge window
In **directories**, double click: home/mdtf34/cryo/Setups and then
home/mdtf34/cryo/Setups/Stand3
After you are in the Stand3 directory, under **Files**: double click
LHC02_Dvm_CheckoutVariables.numdisp_setup
This will bring up a preset display with the trim current and all Stand 3 RTD's
You won't need to check the RTD's until later in checkout.
Record the applied current(trim) 9.94 A (Should be approx. 10A)
- 2.8 Connect both primary and redundant Vtap cables to positive and negative leads.
- 2.9 Remove the four primary and redundant Vtap cables from the back of the Vtap distribution box (these cables are located on the right side).
- 2.10 Using the dual 8-pin breakout box, connect the cables as per the following instructions:
- 2.11 Use HP3457 DVM, set it to 40-line cycle integration time.

Positive Lead (single cable test)
Voltage tap Connector 1 (**Primary**)

| | |
|---|--|
| Pin 1 - pin 2 (160uv) <u>163uv</u> V | Pin 2 - pin 3 (450uv) <u>475uv</u> V |
| Pin 1 - pin 3 (610uv) <u>637uv</u> V | Pin 3 - pin 4 (480uv) <u>504uv</u> V |
| Pin 1 - pin 4 (1.1mv) <u>1.143mv</u> V | Pin 4 - pin 5 (3.5mv) <u>3.598mv</u> V |
| Pin 1 - pin 5 (4.7mv) <u>4.743mv</u> V | Pin 5 - pin 6 (float) <u>---</u> V |
| Pin 1 - pin 6 (float) <u>---</u> V | Pin 6 - pin 7 (float) <u>---</u> V |
| → Pin 1 - pin 7 (-20uv) <u>-229uv</u> V | Pin 7 - pin 8 (0v) <u>-238uv</u> V ← |
| → Pin 1 - pin 8 (-20uv) <u>-464uv</u> V | |

Voltage tap Connector 2 (**Redundant**)

| | |
|--|--|
| Pin 1 - pin 2 (160uv) <u>163uv</u> V | Pin 2 - pin 3 (450uv) <u>478uv</u> V |
| Pin 1 - pin 3 (610uv) <u>642uv</u> V | Pin 3 - pin 4 (480uv) <u>499uv</u> V |
| Pin 1 - pin 4 (1.1mv) <u>1.144mv</u> V | Pin 4 - pin 5 (3.5mv) <u>3.596mv</u> V |
| Pin 1 - pin 5 (4.7mv) <u>4.743mv</u> V | Pin 5 - pin 6 (float) <u>---</u> V |
| Pin 1 - pin 6 (float) <u>---</u> V | |



9. Room Temperature Electrical
Checkout

Negative Lead (single cable test)

Voltage tap Connector 1 (Primary)

Pin 1 - pin 2 (-160uv) -165.4 V Pin 2 - pin 3 (-450uv) -479 V
 Pin 1 - pin 3 (-600uv) -642 V Pin 3 - pin 4 (-480uv) -496 V
 Pin 1 - pin 4 (-1.1mv) -1.135 mV Pin 4 - pin 5 (-3.5mv) -3.63 mV
 Pin 1 - pin 5 (-4.7mv) -4.763 mV Pin 5 - pin 6 (float) 4.589 mV
 Pin 1 - pin 6 (float) -174 V Pin 6 - pin 7 (float) 479 V
 Pin 1 - pin 7 (+20uv) 307 V Pin 7 - pin 8 (0v) -143.4 V
 Pin 1 - pin 8 (+20uv) 166 V

Voltage tap Connector 2 (Redundant)

Pin 1 - pin 2 (-160uv) -166 V Pin 2 - pin 3 (-450uv) -10 V
 Pin 1 - pin 3 (-600uv) -174 V Pin 3 - pin 4 (-480uv) -470 V
 Pin 1 - pin 4 (-1.1mv) -1.45 mV Pin 4 - pin 5 (-3.5mv) 2.8 V
 Pin 1 - pin 5 (-4.7mv) float V Pin 5 - pin 6 (float) float V
 Pin 1 - pin 6 (float) float V

Connection 1 (Primary) (dual cable test)

Positive Lead Pin 1 - Negative Lead pin 5 (3.7mv) 3.2 mV
 Positive Lead Pin 1 - Negative Lead pin 4 (7.3mv) 6.9 mV
 Positive Lead Pin 1 - Negative Lead pin 3 (7.7mv) 7.3 mV
 Positive Lead Pin 1 - Negative Lead pin 2 (8.2mv) 7.8 mV
 Positive Lead Pin 1 - Negative Lead pin 1 (8.3mv) 8.0 mV

Connection 2 (Redundant) (dual cable test)

Positive Lead Pin 1 - Negative Lead pin 5 (3.7mv) 3.2 mV
 Positive Lead Pin 1 - Negative Lead pin 4 (7.3mv) 6.8 mV
 Positive Lead Pin 1 - Negative Lead pin 3 (7.7mv) 7.3 mV
 Positive Lead Pin 1 - Negative Lead pin 2 (8.2mv) 7.8 mV
 Positive Lead Pin 1 - Negative Lead pin 1 (8.3mv) 8.0 mV

2.12 When finished taking voltage measurements reconnect the Vtap cables on back of the Vtap Distribution box.

3.1 Check QC Signals through the Cryo Computer.

3.2 Setup Kepco for +/- 10Amps. Set function generator for square wave. You should see current go from +10A to -10A. Frequency should be set at .01 (approx. 100 seconds).



**9. Room Temperature Electrical
Checkout**

3.3 Bring up a new terminal and type the command: numdisp -n mtfvz la
(numeric display on mtfvz la shows up)
Click on chooser
Click the File button on numeric display.
Then choose Load setup
Enlarge window
In **directories**, double click: home/mdtf34/cryo/Setups and then
home/mdtf34/cryo/Setups/Stand3
Then double click: LHC02_FVT_VOLTAGES.numdisp_setup
Select the Print Button on the numeric display on mtfvz la window and staple the

3.4 Printout to the back of this checkout form.

Check QC POS and NEG Vtaps to the below

FVT NEGVOLTAGES

H3_VoTapNegCu_V1V2M_1 (-160uv) -----
H3_VoTapNegHtsBotV3V4M_1 (-480uv) -----
H3_VoTapNegHtsLtsV2V5M_1 (-4.45mv) -----
H3_VoTapNegHts_V2V4M_1 (-950uv) -----
H3_VoTapNegLts_V4V5M_1 (-3.5mV) -----

FVT POSVOLTAGES

H3_VoTapPosCu_V1V2M_1 (160uv) -----
H3_VoTapPosHtsBotV3V4M_1 (480uv) -----
H3_VoTapPosHtsLtsV2V5M_1 (4.45mv) -----
H3_VoTapPosHts_V2V4M_1 (950uv) -----
H3_VoTapPosLts_V4V5M_1 (3.5mV) -----

3.5 Return Kepco to +10Amps.

4.0 Voltage Drop measurements for QC & QD Cables

4.1 Connect QC POS LEAD & QC NEG LEAD Connectors on Stand 4 platform Quench Management Vtap Box to the breakout box.
4.2 Use a 3457 DVM to check the voltages on specified pins.

QC POS LEAD (+VTAP QC RR STN3 DBOX +VTAP QC STN4 QMBOX)

Pin 1 - pin 2 (160uv) 162u V (V1-V2)
Pin 3 - pin 4 (950uv) 972u V (V2-V4)
Pin 5 - pin 6 (480uv) 501u V (V3-V4)
Pin 7 - pin 8 (3.5mv) 3.591m V (V4-V5) mV

DFLX _____ DFLX _____



**9. Room Temperature Electrical
Checkout**

QC NEG LEAD

Pin 1 - pin 2 (-160uv) $\underline{-163 \mu V}$ (V1-V2)
 Pin 3 - pin 4 (-950uv) $\underline{-964 \mu V}$ (V2-V4)
 Pin 5 - pin 6 (-480uv) $\underline{-490 \mu V}$ (V3-V4)
 Pin 7 - pin 8 (-3.5mv) $\underline{-3.624 mV}$ (V4-V5) *MILLI*

Restore QC cables

4.3 Connect QD POS LEAD & QD NEG LEAD Connectors on Stand 4 platform Quench Management Vtap Box to the breakout box.

4.4 Use a 3457 DVM to check the voltages on specified pins.

QD POS LEAD (+VTAP QD RR STN3 DBOX +VTAP QD STN4 QMBOX)

Pin 1 - pin 2 (4.61mv) $\underline{4.957 mV}$ (flag-V5) *MILLI*
 Pin 3 - pin 4 (4.45mv) $\underline{4.564 mV}$ (V2-V5) *MILLI*
 Pin 5 - pin 6 (float) $\underline{\quad\quad\quad V}$ (shorted)
 Pin 7 - pin 8 (3.5mv) $\underline{3.591 mV}$ (V4-V5) *MILLI*

QD NEG LEAD

Pin 1 - pin 2 (-4.61mv) $\underline{-5.067 mV}$ (flag-V5) *MILLI*
 Pin 3 - pin 4 (-4.45mv) $\underline{-4.588 mV}$ (V2-V5) *MILLI*
 Pin 5 - pin 6 (float) $\underline{\quad\quad\quad V}$ (shorted)
 Pin 7 - pin 8 (-3.5mv) $\underline{-3.624 mV}$ (V4-V5) *MILLI*

Restore QD cables

4.5 When voltage measurements are complete, turn off kepc power supply and disconnect kepc power cable on positive and negative LHC power leads. Disconnect the before and After Flags.

5.0 RTD resistance measurements.

5.1 Using the special RTD test cable (cable should be located in the bottom of the rack for Stand 3), use the standard blue breakout box (box should be in the breakout box cabinet), connect it to each LEADS RTD connectors. This is the connector between the primary and redundant Vtap connectors. Each RTD connector connect to 3 sets of RTDs. The LHC lead RTD's are

5.2 511-3, 512-3, 509-3A, 509-3B, 510-3A, and 510-3B.

5.3 Using a hand-held meter, perform a two-wire measurement on connector #3 of Positive Lead



9. Room Temperature Electrical
Checkout

Resistance between Pin 1 and pin 2 (.800) 1.89 Ω
 Resistance between Pin 1 and pin 3 (109) 110.6 Ω
 Resistance between Pin 1 and pin 4 (109) 110.6 Ω
 Resistance between Pin 2 and pin 3 (109) 110.3 Ω
 Resistance between Pin 2 and pin 4 (109) 110.3 Ω
 Resistance between Pin 3 and pin 4 (.800) 2.23 Ω

Pins 1-4 resistance to lead (infinite) ✓ Ω
 Pins 1-4 resistance to ground (infinite) ✓ Ω

Resistance between Pin 5 and pin 6 (.800) 1.84 Ω
 Resistance between Pin 5 and pin 7 (109) 110.5 Ω
 Resistance between Pin 5 and pin 8 (109) 110.6 Ω
 Resistance between Pin 6 and pin 7 (109) 110.3 Ω
 Resistance between Pin 6 and pin 8 (109) 110.3 Ω
 Resistance between Pin 7 and pin 8 (.800) 2.09 Ω

Pins 5-8 resistance to lead (infinite) ✓ Ω
 Pins 5-8 resistance to ground (infinite) ✓ Ω

Resistance between Pin 9 and pin 10 (.800) 1.7 Ω
 Resistance between Pin 9 and pin 11 (109) 110.4 Ω
 Resistance between Pin 9 and pin 12 (109) 110.6 Ω
 Resistance between Pin 10 and pin 11 (109) 116.7 Ω
 Resistance between Pin 10 and pin 12 (109) 110.24 Ω
 Resistance between Pin 11 and pin 12 (.800) 1.69 Ω

Pins 9-12 resistance to lead (infinite) ✓ Ω
 Pins 9-12 resistance to ground (infinite) ✓ Ω

5.4 Using HP3458 DVM measure temperature sensor resistance with the four wire measurement technique:

Resistance of T1 108.6 Ω (108.5) (I+ at pin 1, U+ at pin 2, I- at pin 3, U- at pin 4)
 Resistance of T2 108.6 Ω (108.5) (I+ at pin 5, U+ at pin 6, I- at pin 7, U- at pin 8)
 Resistance of T3 108.6 Ω (108.5) (I+ at pin 9, U+ at pin 10, I- at pin 11, U- at pin 12)



9. Room Temperature Electrical
Checkout

5.5 Two wire measurement on connector 3 of Negative Lead (Fisher DEE104Z086):

Resistance between Pin 1 and pin 2 (.800) 2.5 Ω
 Resistance between Pin 1 and pin 3 (109) 110.5 Ω
 Resistance between Pin 1 and pin 4 (109) 110.6 Ω
 Resistance between Pin 2 and pin 3 (109) 110.4 Ω
 Resistance between Pin 2 and pin 4 (109) 110.4 Ω
 Resistance between Pin 3 and pin 4 (.800) 1.6 Ω

Pins 1-4 resistance to lead (infinite) ✓ Ω
 Pins 1-4 resistance to ground (infinite) ✓ Ω

Resistance between Pin 5 and pin 6 (.800) 1.95 Ω
 Resistance between Pin 5 and pin 7 (109) 110.5 Ω
 Resistance between Pin 5 and pin 8 (109) 110.6 Ω
 Resistance between Pin 6 and pin 7 (109) 110.4 Ω
 Resistance between Pin 6 and pin 8 (109) 110.4 Ω
 Resistance between Pin 7 and pin 8 (.800) 1.6 Ω

Pins 5-8 resistance to lead (infinite) ✓ Ω
 Pins 5-8 resistance to ground (infinite) ✓ Ω

Resistance between Pin 9 and pin 10 (.800) 6.78 Ω
 Resistance between Pin 9 and pin 11 (109) 110.5 Ω
 Resistance between Pin 9 and pin 12 (109) 110.7 Ω
 Resistance between Pin 10 and pin 11 (109) 110.3 Ω
 Resistance between Pin 10 and pin 12 (109) 110.4 Ω
 Resistance between Pin 11 and pin 12 (.800) 1.6 Ω

Pins 9-12 resistance to lead (infinite) ✓ Ω
 Pins 9-12 resistance to ground (infinite) ✓ Ω

5.6 Using HP3458 DVM measure temperature sensor resistance with the four wire measurement technique:

Resistance of T1 108.7 Ω (108.5) (I+ at pin 1, U+ at pin 2, I- at pin 3, U- at pin 4)
 Resistance of T2 108.7 Ω (108.5) (I+ at pin 5, U+ at pin 6, I- at pin 7, U- at pin 8)
 Resistance of T3 108.7 Ω (108.5) (I+ at pin 9, U+ at pin 10, I- at pin 11, U- at pin 12)



9. Room Temperature Electrical
Checkout

5.7 Check remaining RTDs

*Display Data - n
mit FVX 26*

Connect the following cables

- Connect four-pin N2 shield
594-3
- Connect four-pin outlet HE for each lead
513-3, 514-3
- Connect cables for three 19-pin top plate connectors
dewar 0, dewar 1, dewar inlet HE te/II

All Stand 3 RTD's can be read out on the numeric display that was opened earlier in the checkout. Be sure that Mike T has rebooted the system and scans are active. Check that all Temps for the RTDs read approximately 295K on all channels below.

- 507-3A ✓, 507-3B ✓, 509-3A ✓, 509-3B ✓, 510-3A ✓, 510-3B ✓, 511-3 ✓, 512-3 ✓, 513-3 ✓, 514-3 ✓, 515-3 ✓, 516-3 ✓, 526-3 ✓, 530-3 ✓, 531-3 ✓, 532-3 ✓, 533-3 ✓, 534-3 ✓, 535-3 ✓, 594-3 ✓

5.8 TE 507-3B doesn't always read the correct temp; the display will have 507-3B's resistance. It should read approx. 60 Ω.

To exit click Exit.

5.9 Check all three liquid levels probes (12", 30", and 36").

The 12" liquid level is connected to pins 9-12 of "dewar inlet HE te/II" cable.

Connect 4-pin cable on top plate for 30" probe.

Disconnect J1 at the back of each liquid level meter and do a 4-wire resistance measurement on each probe.

Using a breakout box measure the resistance of each probe on J1:

- 1. pin 1 (red) to pin 8 (blue) should be approx. 5 Ω
- 2. pin 8 (blue) to pin 6 (yellow) should be approx. (13.75 X active length of probe) 165 Ω for 12" and 412.5 Ω for 30"
- 3. pin 6 (yellow) to pin 7 (black) should be something less than 5 Ω
- 4. pin 1 (red) to pin 7 (black) should approximately equal resistance from #2 + #1

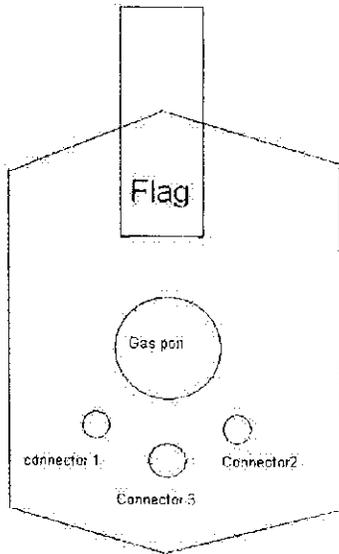
5.10 Do a 4-Wire resistance measurement:

12" Dewar 163.8 30" Dewar 403.2 30" Phase sep. 403.8

| | 12" Dewar | 30" Dewar | 30" Phase sep |
|----------------------------|--------------|--------------|---------------|
| 1. 1 (red) to 8 (blue) | <u>2.3</u> | <u>7.4</u> | <u>6.8</u> |
| 2. 8 (blue) to 6 (yellow) | <u>166.5</u> | <u>405.2</u> | <u>409.01</u> |
| 3. 6 (yellow) to 7 (black) | <u>3</u> | <u>1.8</u> | <u>1.8</u> |
| 4. 1 (red) to 7 (black) | <u>171.5</u> | <u>410.6</u> | <u>411.99</u> |



9. Room Temperature Electrical Checkout



Looking from the top of the lead down
where the LTS cable is located.

**Connector 2= Redundant, Connector 1=
Primary and Connector 3= RTD.**

NOTE: After checkout is complete, be sure to set up kepcos with function generator for +/- 10 amps and then turn off. Cryo techs will turn on when they begin cool down.

Set up function generator for square wave. You should see current go from +10A to -10A. Frequency should be set at .01 (approx. 100 seconds).

NUMDISP PRINTOUT

=====

Last update request - Mon, Mar 07, 2005 09:23:50 AM

Request frequency - 5.00 sec.

FvtCurrents

| | | | | | |
|-----------------------|---------|---|----|---------|-------------|
| H3_CuHolPentBuNegM_1 | 3.66211 | A | OK | 3/07/05 | 09:23:51.15 |
| H3_CuIdotPentBuNegM_1 | 3.20435 | A | OK | 3/07/05 | 09:23:51.15 |
| H3_CuShuPentTrimPSM_1 | 8.09541 | A | OK | 3/07/05 | 09:23:51.15 |

FvtAqdVoltages

| | | | | | |
|-----------------------|-------------|---|----|---------|-------------|
| H3_VoAqdGnd_RefM_1 | 0.00946045 | V | OK | 3/07/05 | 09:23:51.15 |
| H3_VoAqdHtsLts_LtsM_1 | -0.981598 | V | OK | 3/07/05 | 09:23:51.15 |
| H3_VoAqdLeads_IM_1 | -0.0497437 | V | OK | 3/07/05 | 09:23:51.15 |
| H3_VoAqdLts_GndM_1 | 0.00305176 | V | OK | 3/07/05 | 09:23:51.15 |
| H3_VoAqdLts_IdotM_1 | -0.00823975 | V | OK | 3/07/05 | 09:23:51.15 |

FvtNegVoltages

| | | | | | |
|--------------------------|-------------|---|----|---------|-------------|
| H3_VoTapNegCu_V1V2M_1 | 0.000313138 | V | OK | 3/07/05 | 09:23:51.15 |
| H3_VoTapNegHtsLtsV2V5M_1 | 0.00469717 | V | OK | 3/07/05 | 09:23:51.15 |
| H3_VoTapNegHts_V2V4M_1 | 0.000977374 | V | OK | 3/07/05 | 09:23:51.15 |
| H3_VoTapNegLts_V4V5M_1 | 0.0035697 | V | OK | 3/07/05 | 09:23:51.15 |

FvtPosVoltages

| | | | | | |
|--------------------------|-------------|---|----|---------|-------------|
| H3_VoTapPosCu_V1V2M_1 | 0.000129666 | V | OK | 3/07/05 | 09:23:51.15 |
| H3_VoTapPosHtsLtsV2V5M_1 | -0.00428764 | V | OK | 3/07/05 | 09:23:51.15 |
| H3_VoTapPosHts_V2V4M_1 | -0.00101717 | V | OK | 3/07/05 | 09:23:51.15 |
| H3_VoTapPosLts_V4V5M_1 | -0.00347 | V | OK | 3/07/05 | 09:23:51.15 |

NUMDISC PRINTOUT

=====

Last update request - Mon, Mar 07, 2005 09:21:03 AM
 Request frequency - 5.00 sec.

FvtCurrents

| | | | | | |
|-----------------------|----------|---|----|---------|-------------|
| H3_CuHolPentBuNegM_1 | 3.66211 | A | OK | 3/07/05 | 09:21:04.14 |
| H3_CuIdotPentBuNegM_1 | 3.20435 | A | OK | 3/07/05 | 09:21:04.14 |
| H3_CuShuPentTrimPSM_1 | -4.09239 | A | OK | 3/07/05 | 09:21:04.14 |

FvtAqdVoltages

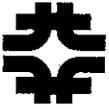
| | | | | | |
|-----------------------|--------------|---|----|---------|-------------|
| H3_VoAqdGnd_RefM_1 | 0.00961304 | V | OK | 3/07/05 | 09:21:04.14 |
| H3_VoAqdHtsLts_LtsM_1 | 1.01776 | V | OK | 3/07/05 | 09:21:04.14 |
| H3_VoAqdLeads_IM_1 | 0.0515747 | V | OK | 3/07/05 | 09:21:04.14 |
| H3_VoAqdLts_GndM_1 | 0.0106812 | V | OK | 3/07/05 | 09:21:04.14 |
| H3_VoAqdLts_IdotM_1 | -0.000610352 | V | OK | 3/07/05 | 09:21:04.14 |

FvtNegVoltages

| | | | | | |
|--------------------------|--------------|---|----|---------|-------------|
| H3_VoTapNegCu_V1V2M_1 | -3.05501e-05 | V | OK | 3/07/05 | 09:21:04.14 |
| H3_VoTapNegHtsLtsV2V5M_1 | -0.00442825 | V | OK | 3/07/05 | 09:21:04.14 |
| H3_VoTapNegHts_V2V4M_1 | -0.000916288 | V | OK | 3/07/05 | 09:21:04.14 |
| H3_VoTapNegLts_V4V5M_1 | -0.00363405 | V | OK | 3/07/05 | 09:21:04.14 |

FvtPosVoltages

| | | | | | |
|--------------------------|-------------|---|----|---------|-------------|
| H3_VoTapPosCu_V1V2M_1 | 0.000450017 | V | OK | 3/07/05 | 09:21:04.14 |
| H3_VoTapPosHtsLtsV2V5M_1 | 0.0048 | V | OK | 3/07/05 | 09:21:04.14 |
| H3_VoTapPosHts_V2V4M_1 | 0.0009319 | V | OK | 3/07/05 | 09:21:04.14 |
| H3_VoTapPosLts_V4V5M_1 | 0.00366924 | V | OK | 3/07/05 | 09:21:04.14 |



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Development & Test

**7500 A HTS Power Leads for the
LHC DFBX:
10. Installation of the Top Plate**

Doc. No.
Rev. 4 (RJR)
Rev. Date: Sept. 3, 2003
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FERMILAB
Technical Division

**7500 A HTS Power Leads for the LHC DFBX:
10. Installation of the Top Plate**

Lead Pair

Negative Lead: 20

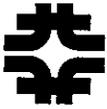
Positive Lead: 40

Signed

C.E. Ho J

Date

03.07.05



**7500 A HTS Power Leads for the
LHC DFBX:
10. Installation of the Top Plate**

1. Install all bolts to fasten the top plate to the dewar extension.
2. Loosen the tensioning rod nuts on the undersides of the lead plates at least 0.5 mm below the lead plate.
3. Install the transfer lines for maintaining the test dewar liquid level.
4. Install the transfer lines supplying the 4-20 K circuit.
5. Install the test dewar flexible vent line.
6. Connect the vent lines (thermally insulated, non-conductive hoses) to the power lead vent stacks.
7. Connect the lines labeled "+ LD PDT L" and "- LD PDT L" to the positive and negative lead vent stacks, respectively. These lines connect to the low side of the differential pressure transducers.
8. Connect the lines labeled "+ LD PDT H" and "- LD PDT H" at the 4-20 K female bayonet vacuum jacket. These lines connect to the high side of the differential pressure transducers.
9. Connect the power leads' warm gas supply line to the 4-20 K transfer line.
10. Connect one end of the bypass line at the phase separator and the other end at the vent piping.



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**7500 A HTS Power Leads for the
LHC DFBX:
12. Cooldown Checklist**

Doc. No.
Rev. 1 (RJR)
Rev. Date: May 12, 2003
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**FERMILAB
Technical Division**

**7500 A HTS Power Leads for the LHC DFBX:
12. Cooldown Checklist**

Lead Pair

Negative Lead: #20

Positive Lead: #40

Signed

Mary Gillman

Date 03/08/05



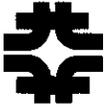
**7500 A HTS Power Leads for the
LHC DFBX:
12. Cooldown Checklist**

7
7
7

1. ± 5 A applied to the current leads during cooldown.
2. DAQ system is operational (temperature sensor readouts in the test dewar helium space are updating).
3. Test dewar and power leads cooled down as per the cooldown procedure "7500 A HTS Power Leads for the LHC DFBX: 12a. Cryogenic Operating Procedure".

Manly 07/08/05 @ 2000

NEED LEAD #'s
Fill valve?



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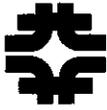
**7500 A HTS Power Leads for the
LHC DFBX:
12a. Cryogenic Operating
Procedure**

Doc. No.
Rev. 10 (RJR)
Rev. Date: January 16, 2004
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**7500 A HTS Power Leads for the LHC DFBX:
12a. Cryogenic Operating Procedure**



**7500 A HTS Power Leads for the
LHC DFBX:
12a. Cryogenic Operating
Procedure**

I. Pre-test

1. Check all insulating vacuums (dewar, transfer lines, etc.). Make a note of them in the LHC-HTS Lead Test logbook.

II. Purge before cool-down

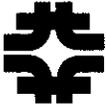
1. Close all system valves.
2. Supply GHe to the test dewar via regulator PRV549-3 and rotameter FI549-3, and vent through diverter valve HV524-3 set to the bottom fill position. Open level control valve LCV547-3 through the FIX32 system. This will push the air out of the test dewar and replace it with GHe. Maintain flow for at least 5 minutes.
3. Close level control valve LCV547-3.
4. Purge the test dewar vent lines by opening rotameter FI519-3 and then valves HV519-3 and HV520-3 in turn for 1 minute each.
5. Purge the test dewar cooldown vent by opening valve HV517-3 for 1 minute.
6. Prepare to purge the lead flow paths by turning on the two Edwards vacuum pumps.
7. Establish a flow path through the negative lead by opening rotameters FI513-3 and FI515-3 and opening the mass flow controller FC509-3 100%.
8. Establish a flow path through the positive lead by opening rotameters FI514-3 and FI516-3 and opening the mass flow controller FC510-3 100%.
9. Supply GHe to the leads via regulator PRV504-3, rotameters FI504-3 and FI505-3, and valve HV502-3.
10. Flow GHe for 1 minute.
11. Close HV502-3, turn off the two Edwards vacuum pumps, and close mass flow controllers FC509-3 and FC510-3.

III. Initial LN2 cool down

1. Enable the LN2 supply solenoid automatic control loop to begin cooling the dewar shield via TY594-3.

IV. Helium cooldown of the dewar.

1. Complete the cooldown checklist ("12. Cooldown Checklist").
2. Turn on the AC line switch on the back of the enclosure on the side of the instrumentation rack. This switch provides power to all of the heater controllers.
3. Enable the lead flag heaters, the 4-20 K transfer line heater, and the phase separator heater by flipping on the switches to the right of the instrumentation rack front.
4. Open the test dewar cooldown vent HV517-3.
5. Attach a pressurizing line to the portable LHe dewar supplying the test dewar, and supply pressure via regulator PRV502-3, rotameter FI502-3, and valve HV522-3. The portable dewar pressure can be read out on gauge PI522-3. Maintain 80 inH₂O of transfer differential as measured by PDI522-3.
6. Sting the portable dewar with the test dewar fill transfer line.
7. Place a permanent magnet on the flexible transfer line to open the built-in check valve.
8. Supply liquid helium (LHe) to the test dewar with the diverter valve HV524-3 in the bottom fill position.
9. Put level control valve LCV547-3 into Automatic mode with a 6 in. setpoint.
10. Make sure the lead flow bypass valve HV513-3 and HV514-3 are closed.



**7500 A HTS Power Leads for the
LHC DFBX:
12a. Cryogenic Operating
Procedure**

11. Sting the second portable dewar with the lead flow transfer line.
12. Attach the second pressurizing line to the portable LHe dewar supplying the leads. At the gauge panel, open valve HV523-3, pressurizing rotameter FI504-3, and vent rotameter FI505-3. Adjust regulator PRV504-3 to pressurize the portable dewar to 8 psig. The portable dewar pressure can be read out on gauge PI523-3.
13. Place a permanent magnet on the flexible transfer line to open the built-in check valve.
14. With the Edwards vacuum pumps on, put both mass flow controllers FC509-3 and FC510-3 into Automatic mode with 50 K setpoints.
15. Briefly open bypass valve HV507-3 to help purge out the phase separator, then close down on bypass valve HV507-3 until it is ¼ turn open. Set the phase separator heater control loop LIC526-3 to Automatic mode with a 12 in. setpoint.

VII. LHe fill

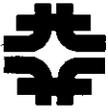
1. Keep the lead temperature control loops TIC509-3 and TIC510-3 in Automatic mode with 50 K setpoints.
2. Keep the test dewar liquid level control loop LIC547-3 in Automatic mode with a 6 in. setpoint. The maximum reading on the liquid level gage is 12 in. Avoid overfilling.
3. Keep the phase separator liquid level control loop LIC526-3 in Automatic mode with a 12 in. setpoint.

VIII. 4.2 K operation

1. Keep lead mass flow control loops TIC509-3 and TIC510-3 in Automatic mode with 50 K setpoints.
2. Diverter valve HV524-3 can be switched into the top fill position.
3. During power tests, use LCV547-3 and its PID loop LIC547-3 to maintain liquid level in the test dewar at 6 in.
4. Use the heater control loop TIC507-3 in Automatic mode with a 20 K setpoint to control the GHe temperature being supplied to the leads.
5. Use temperature control loops TIC509-3 and TIC510-3 in Automatic mode to control the lead HTS warm terminal temperatures. These control loops accomplish this by varying the mass flow rates through the leads.

IX. Warm up from 4.5 K to 275 K

1. Shut off LN2 shield flow by switching the LN2 supply solenoid TY594-3 to Manual mode and closing it in FIX32.
2. Isolate the LN2 source by closing the hand valve on the 240 l dewar.
3. Stop transfer from the LHe dewars by closing pressurization valves HV522-3 and HV523-3 on the gauge panels.
4. Blow down the portable dewars and remove the stingers. Leave the portable dewar 1 psig reliefs active overnight (don't isolate them).
5. Remove the magnet from the flexible transfer line supplying the power leads.
6. Shut down the Edwards vacuum pumps, and close the mass flow controllers FC509-3 and FC510-3 by setting them to 0% in Manual mode in FIX32.
7. Put heater control loops TIC507-3 and LIC526-3 to 0% in Manual mode in FIX32.
8. Switch the liquid level control loop LIC547-3 to Manual mode and close LCV547-3 in FIX32.



**7500 A HTS Power Leads for the
LHC DFBX:
12a. Cryogenic Operating
Procedure**

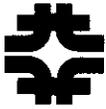
9. Remove the flexible transfer line supplying the test dewar, and place a G-10 tube on the end of the U-tube.
10. Supply warm gas to the test dewar via regulator PRV549-3 and rotameter FI549-3 at the gauge panel.
11. Switch the test dewar diverter valve HV524-3 to the bottom fill position.
12. Open LCV547-3 in FIX32 to push the liquid out of the test dewar and back through the transfer line. Close cooldown vent HV517-3 at the test dewar and dewar vents HV519-3 and HV520-3 at the gauge panel.
13. Supply warm helium gas to the power leads via regulator PRV504-3, rotameter FI504-3, and valve HV502-3 at the gauge panel.
14. Establish flow through the leads by opening lead bypass valves HV513-3 and HV514-3 at the test dewar.
15. After all of the LHe has been blown out of the test dewar, push one more cylinder of GHe through the system. The system can then be switched to a GN2 warmup, with the GN2 being supplied by the plant.
16. Stop the GHe lead flow by closing HV502-3 on the gauge panel.
17. Open cooldown vent HV517-3 at the test dewar.
18. Remove the G-10 tube from the test dewar fill U-tube and attach a nitrogen line.
19. GN2 supplies to the lead flow transfer line and the test dewar transfer line are located south of the Stand 6 subcooler.

X. Warm up from 275 K to 300 K

1. Remove the flexible transfer line supplying the lead flow, and cap off the phase separator port.
2. Remove the hard transfer line supplying the test dewar and connect the nitrogen line with a Hot Watt heater at the test dewar toop plate.
3. Attach a thermocouple to the Hot Watt heater and control the power so that the thermocouple temperature gets no higher than 50 C.

XI. Overnight condition

1. Shut off the LN2 shield flow by switching the LN2 supply solenoid TY594-3 to Disable.
2. Turn off the pressurizing circuit to the portable LHe dewar supplying the test dewar by closing HV522-3.
3. Turn off the pressurizing circuit to the portable LHe dewar supplying the power leads by closing HV523-3.
4. Close level control valve LCV547-3.
5. Remove the stingers from the portable LHe supply dewars.
6. Remove the permanent magnets from the other end of the flexible transfer lines and place them on the transfer line Unistrut support.
7. Shut off the two Edwards vacuum pumps.
8. Switch the lead temperature control loops TIC509-3 and TIC510-3 to Manual mode, and close the mass flow controllers FC509-3 and FC510-3.
9. Switch the heater control loop TIC507-3 into Manual mode and set the output to 0%.
10. Switch the phase separator liquid level control loop LIC526-3 into Manual mode and set the output to 0%.



**7500 A HTS Power Leads for the
LHC DFBX:
12a. Cryogenic Operating
Procedure**

11. Open test dewar auxiliary vent valve HV520-3 to allow check valve FCV520-3 to maintain a 1 psi backpressure on the test dewar.
12. Close test dewar vent valve HV519-3.
13. Close cooldown vent valve HV517-3.

XI. Resumption of LN2 and LHe filling after an overnight pause

1. Open the LN2 dewar supply valve and switch the LN2 supply solenoid TY594-3 to Enable.
2. Open cooldown vent valve HV517-3.
3. Close test dewar auxiliary vent valve HV520-3.
4. Insert the stingers into the LHe supply dewars, and put the small permanent magnets on the bayonets at the other end of the flexible transfer lines to hold open the check valves.
5. Turn on the pressurizing circuit to the portable LHe dewar supplying the test dewar by opening HV522-3.
6. Turn on the pressurizing circuit to the portable LHe dewar supplying the power leads by opening HV523-3.
7. Set diverter valve HV524-3 to bottom fill position.
8. Set level control valve LCV547-3 to Automatic with a 6 in. setpoint to begin refilling the test dewar.
9. Turn on the two Edwards vacuum pumps.
10. Set the lead mass flow control loops TIC509-3 and TIC510-3 in Automatic mode with a 50 K setpoint.
11. Set the phase separator liquid level control loop LIC526-3 in Automatic mode with a 12 in setpoint.
12. Verify that the phase separator bypass valve HV507-3 is open $\frac{1}{4}$ turn.

XII Securing the test stand

1. Turn off the Hot-Watt heater that is warming the GN2 entering the test dewar.
2. After allowing the heater to cool for a few minutes, turn off the GN2 supply to the test dewar.
3. Turn off the GN2 supply to the power leads.
4. Close test dewar vent valve HV519-3.



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13. Cold Temp Hi-pot In HE Environment

Note: Save the shipping container for storing and moving the leads around TD and after the test is complete to ship them to the DFBX manufacturer.

Performed by Fred Lewis (Name typed) [Signature] (Signature)

Date & time 3/16/03

Pos. Power Lead 7500 A DFLX 20 and Neg. Power Lead 7500 A DFLX 40

This hi-pot should be performed after dewar has been filled with liquid helium. Notify the Cryo Operator before you disconnect cables. When checkout is complete, make sure you place the original and a copy of this document in the Traveler Binders.

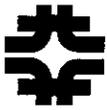
1.1 Short all of the temperature sensors together using the special RTD high pot cable. High pot each set of temperature sensor to 300v with respect to the Lead (ground).

Record breakdown voltage (if any) _____ V.
Record current .054 A

1.2 Hi-pot the leads in a cold (4.5K) He environment to 1500V (1.3 Bar) using a Droege HV power supply. Connect the positive clip to one lead and the negative clip to ground. Also, short all of the temperature sensors together using the special RTD high pot cable. Connect the ring terminal from each connector to the flag of each lead. **Be sure to disconnect the redundant voltage taps on both leads and the power connections from Kepco power supply.**

Record breakdown voltage (if any) _____ V.
Record current .064 A.
Record approximate temp. _____ K. (Record Temp of TI532-3)
Record approximate test dewar pressure _____ PSIA.

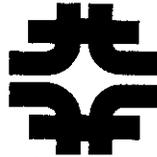
NOTE: Reconnect Vtaps and RTDs when finished.



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**7500 A HTS Power Leads for the
LHC DFBX:
14. Connect the Leads to the
Power Supply & Configure**

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**7500 A HTS Power Leads for the LHC DFBX:
14. Connect the Leads to the Power Supply &
Configure**

Lead Pair

Negative Lead: DFLX 20

Positive Lead: DFLX 40

Signed Roger Rabehl Date 3/8/05



**7500 A HTS Power Leads for the
LHC DFBX:
14. Connect the Leads to the
Power Supply & Configure**

1. Bus Connection Changes – VMTF End

- 1.1 Visually verify completion of electrical connection of the green flex leads to the Stand 4 hard bus in the trench.
- 1.2 Visually verify completion of LCW connections between the green flex leads and the Stand 4 hard bus in the trench.
- N/A 1.3 Visually verify completion of electrical connection of the 1000 MCM flexible leads and Main Injector dipoles.
- 1.4 Visually verify all exposed bus has been wrapped with rubber insulation for personnel safety.

2. Bus Connection Changes – Stand 4 Platform

- 2.1 Visually verify that the Stand 3 hard bus has been mated with the Stand 4 flexible bus on the Stand 4 platform and that the polarity is correct.

3. Bus Connection Changes – Stand 3 Test Dewar

- 3.1 Visually verify the flex leads and chill blocks have been bolted to the power lead flags with Penetrox E conductive grease applied to the cooling block-lead flag joint.
- 3.3 Visually verify that voltage taps VFF-A and VFF-B have been connected at the negative and positive flex lead flags, respectively, and voltage taps VLF-A and VLF-B have been connected at the negative and positive power lead flags, respectively. These taps will allow the combined voltage drop across the flex lead/chill block joint and chill block/power lead joint to be measured.
- 3.4 Visually verify Kapton-wrapped platinum temperature sensors TE515-3 and TE516-3 have been attached to the positive and negative lead flags, respectively, using glass tape.
- 3.5 Visually verify the power lead flags have been wrapped with rubber insulation for personnel safety.
- 3.6 Visually verify the plexiglass enclosure has been installed around the power leads for personnel safety.



**7500 A HTS Power Leads for the
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14. Connect the Leads to the
Power Supply & Configure**

3. Power Supply System Configuration

- 3.1 On the FIX32 HMTF Power Interlock screen, switch the selector switch to the Stand 3 position.
- 3.2 Switch warning lights at the VMTF pit and at the Stand 4 platform to the "Stand 3" position.
- 3.3 Adjust the power supply time constant by setting the resistance to 500 $\mu\Omega$.
- 3.4 Adjust the power supply time constant by setting the inductance to 0.05 mH.
- 3.5 Adjust the dump resistance to 30 m Ω .
- 3.6 Place the VMTF ground switch in the "off" position.
- 3.7 Place the Stand 4 ground switch in the "on" position.
- 3.8 Place the Stand 3/VMTF ground switch on the ETS panel in the Stand 3 (up) position and press the Master Reset.
- 3.9 Remove the power control cable, which contains QLM, PLC, etc. signals, from the VMTF "j" plug and insert into the Stand 4 "j" plug.
- N/A 3.10 Switch LCW control box switch to Main Injector Magnets In position to enable flow switches in PLC interlock logic.

4. LCW System Verification

- N/A 4.1 Record the flow indicator readings for LCW flow to the 1000 MCM flexible leads and the Main Injector dipoles.

1000 MCM Flexible lead flow FI2239 (IB1 south wall): gpm (12 gpm nominal)
 Main Injector dipole 1 flow FI2278: gpm (5 gpm nominal)
 Main Injector dipole 2 flow FI2279: gpm (5 gpm nominal)
 Main Injector dipole combined flow FI2236: gpm (10 gpm nominal)

- 4.2 Record the flow indicator readings for LCW flow to the 750 MCM green flexible leads.

Positive flex lead flow FI2230: 11 gpm (12 gpm nominal, 11 gpm actual)
 Negative flex lead flow FI2231: 9 gpm (12 gpm nominal, 9 gpm actual)

Negative lead DFLX 20 Positive lead DFLX 40



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✓ 4.3 Record the flow indicator readings for LCW flow to Stand 3.

10 ft negative flex lead on the Stand 4 platform FI553-3: 4.9 gpm (4 gpm nominal)

10 ft positive flex lead on the Stand 4 platform FI554-3: 5.1 gpm (4 gpm nominal)

Copper bus flow FI556-3: 15 gpm (12 gpm nominal)

6 ft flex leads at the Stand 3 test dewar FI558-3: 3.5 gpm (4 gpm nominal)

Negative lead DFLX 20 Positive lead DFLX 40



15. OD circuit checkout

Performed by Fred Lewis (name typed) [Signature] (signature)

Date & time 4/21/03

Power Lead 7500 A DFLX ~~40~~ **40**

When checkout is complete, make sure you place this document in the Traveler Binders

Print-out Threshold setup spreadsheet.

1.1 Connect the HTS LEAD V-TAP Breakout Box to 6 pin Primary V-TAP cable for Lead #1 and Lead #2.

1.2 Connect the HTS LEAD V-TAP Breakout Box to 8 pin Lead test cable for Lead #1 and Lead #2. These red cables are located in the back of Stand 3 Relay-Rack.

1.3 Connect the HTS LEAD V-TAP Breakout Box to special flag cable. Use the Before Flag for Lead #1 and Lead #2.

1.4 Connect the duel breakout box to both of the 8 pin Lead test cables on the Stand-4

1.5 Use a voltage source to inject a signal into the appropriate pins as per Threshold Setup spreadsheet and set the threshold. Repeat for other lead test cable.

1.6 Make a copy of the Threshold setup spreadsheet and place it in Traveler for both leads along with a copy of this form.

1.7 The quench management cables for stand 3 will always remain connected to the QM box. These cables include quench characterization for the positive and negative lead and quench detection for the positive and negative lead. There are six cables that need to be connected from stand 4. These include FVTLD1, FVTLD2, FVT+LEAD, FVT-LEAD, FVT WC 1/2C M1, and FVT WC 1/2C M2. These cables should be plugged into the corresponding connectors on QM box.



16. Cold test of the power leads

Performed by ROGER RABEHL Roger Rabehl
(name typed) (signature)
Date & time MARCH 8, 2005 0900
(+) (-)
Power Lead 7500 A DFLX 40 & 7500 A DFLX 20

✓ 16.0 Set the DAQ system ScribeLeads and ScribeFix32 Data Logging Intervals to capture data every 5 seconds.

16.1. Establish cryogenic parameters for normal high current operating conditions.

Set the liquid level at 6in location using the 1 foot LL probe
Set the copper section inlet cooling gas temperature to 15-20K range
Set the LHe vapor cooling control loop in automatic mode to keep the upper HTS terminal temperature at 45 K for 1/2 hour

Neg. lead flow rate 0.182 g/s Pos. lead flow rate 0.141 g/s

Neg. lead diff. pressure 0 mbar Pos. lead diff. pressure 0 mbar

Set the upper HTS temperature to 50 K and keep it there for 1/2 hour

Neg. lead flow rate 0.164 g/s Pos. lead flow rate 0.132 g/s

Neg. lead diff. pressure 0 mbar Pos. lead diff. pressure 0 mbar

Frost observed on leads? (Y/N) N

✓ 16.1.1 Set software quench detection thresholds by executing:
/usr/vmtf/sh/lhchts_setquenchthreshold_run.sh

16.2 Stair step profile test.

Turn on the Power Supply. Set HTS terminal temperature to 50K and apply current profile 1 (/usr/vmtf/sh/hmtf3_run_prf.sh)

Monitor voltages and make sure that the data is recorded.

Run data analysis tool on the obtained data file to determine joint resistances.

7500 A DFLX (-) R(joint between V2 & V3) = 38.3 nΩ
R(joint between V3 & V4) = 3.3 nΩ

7500 A DFLX (+) R(joint between V2 & V3) = 41.7 nΩ
R(joint between V3 & V4) = 2.0 nΩ

16.3 Coolant loss test.

Apply 7500 A and

a) Close the coolant flow for 7500 A DFLX (-)

Wait until QD detects the quench and record

T1 = 80K; T2 = 271; V12 = 91mV; V23 = 0.65mV; V34 = 1.00mV;

T1 is the HTS warm terminal temp., TI509-3 (neg. lead) or TI510-3 (pos. lead).

T2 is the upper copper temp., TI511-3 (neg. lead) or TI512-3 (pos. lead).



16. Cold test of the power leads

- b) Re-establish operating conditions
- c) Close the coolant flow for 7500 A DFLX (+)

Wait until QD detects the quench and record

$$T1 = 79 K ; T2 = 289 K ; V12 = 95 mV ; V23 = 1 mV ; V34 = 0.3 mV ;$$

16.4a Set the upper HTS terminal temperature to 50K and apply current profile 2.

Neg. lead flow rate 0.507 g/sec Pos. lead flow rate 0.441 g/sec

Neg. lead diff. pressure 0.6 mbar Pos. lead diff. pressure 2.6 mbar

16.4b Set HTS terminal temp to 45K and apply current profile 2.

Neg. lead flow rate 0.534 g/s Pos. lead flow rate 0.464 g/s

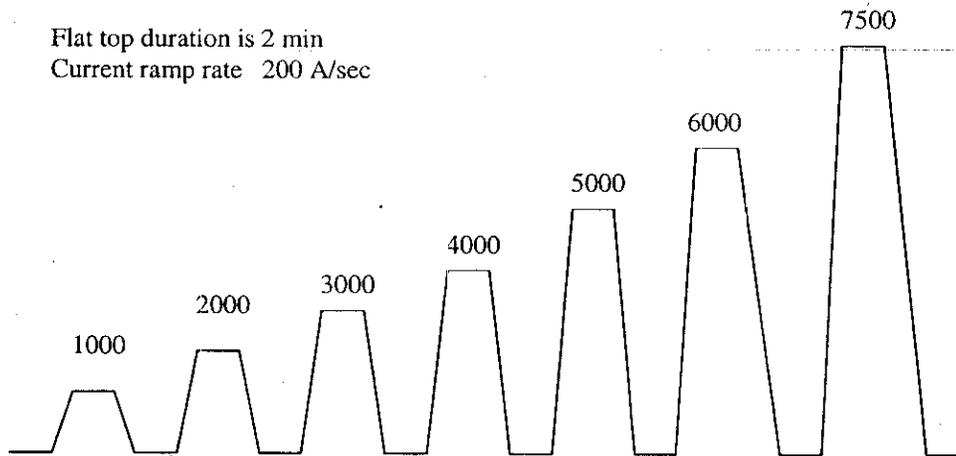
Neg. lead diff. pressure 0.55 mbar Pos. lead diff. pressure 2.3 mbar

16.5 When test is completed, set the ScribeLeads and ScribeFix32 Data Logging Intervals to 300 seconds.

Note: If any irregularity occur call Sandor.

Profile 1:

Flat top duration is 2 min
Current ramp rate 200 A/sec

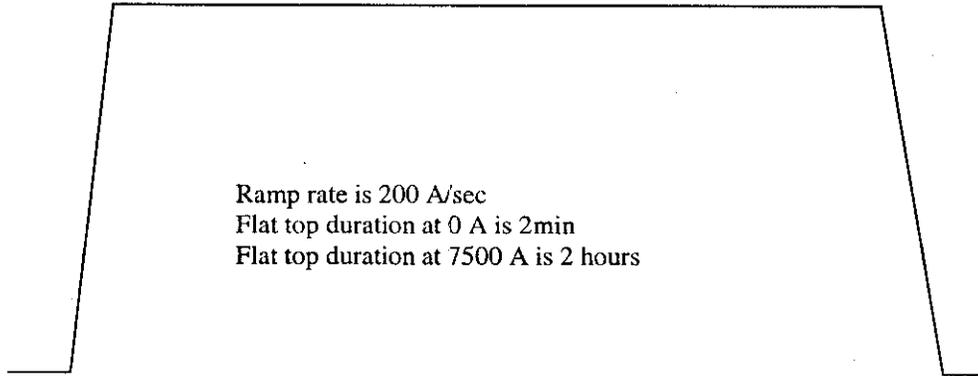




16. Cold test of the power leads

Profile 2:

7500 A





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20. Warm Temp Hi-pot In Gasous He Environment

Note: Save the shipping container for storing and moving the leads around TD and after the test is complete to ship them to the DFBX manufacturer.

Performed by Fred Lewis (Name typed) [Signature] (Signature)

Date & time 3/16/05

Pos. Power Lead 7500 A DFLX 20 and Neg. Power Lead 7500 A DFLX 40

This hi-pot should be performed after dewar has been filled with gaseous helium after the second test cycle has been completed and the dewar is at room temperature. When checkout is complete, make sure you place the original and a copy of this document in the Traveler Binders.

1.1 Short all of the temperature sensors together using the special RTD high pot cable. High pot each set of temperature sensor to 300v with respect to the Lead (ground).

Record breakdown voltage (if any) _____ V.
Record current .074 A

1.2 Hi-pot the leads in a cold (4.5K) He environment to 1500V (1.3 Bar) using a Droege HV power supply. Connect the positive clip to one lead and the negative clip to ground. Also, short all of the temperature sensors together using the special RTD high pot cable. Connect the ring terminal from each connector to the flag of each lead. **Be sure to disconnect the redundant voltage taps on both leads and the power connections from Kepco power supply.**

Record breakdown voltage (if any) _____ V.
Record current .084 A.
Record approximate temp. _____ K. (Record Temp of TI532-3)
Record approximate test dewar pressure _____ PSIA.

**NOTE: Reconnect Vtaps and RTDs when finished.
Turn OFF Main Power Switch to Hoffman Enclosure on
Side of END RACK!!!!**



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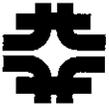
**7500 A HTS Power Leads for the
LHC DFBX:
21. Removal of the Top Plate
from the Dewar**

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**7500 A HTS Power Leads for the LHC DFBX:
21. Removal of the Top Plate from the Dewar**



**7500 A HTS Power Leads for the
LHC DFBX:
21. Removal of the Top Plate
from the Dewar**

1. Electrical Disconnections

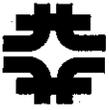
- 1.1 Put the power system into LOTO.
- 1.2 Remove the plexiglass shield around the power leads.
- 1.3 Remove the Kapton-wrapped platinum temperature sensors TE515-3 and TE516-3 from the positive and negative lead flags, respectively.
- 1.4 Remove voltage taps VF-A and VF-B from the negative and positive flex lead flags, respectively.
- 1.5 Disconnect the flex leads and chill blocks from the power lead flags.

2. Piping Disconnections

- 2.1 Disconnect the GN2 warmup supply line from the 4-20 K supply line.
- 2.2 Disconnect the GN2 warmup supply line from the top plate.
- 2.3 Remove the Hot Watt if it was used to during the warmup.
- 2.4 Disconnect the lines labeled "+ LD PDT +" and "- LD PDT +" from the 4-20 K female bayonet vacuum jacket. The lines connect to the high side of the differential pressure transducers.
- 2.5 Disconnect the lines labeled "+ LD PDT -" and "- LD PDT -" from the positive and negative lead vent stacks, respectively. These lines connect to the low side of the differential pressure transducers.
- 2.6 Disconnect the vent lines (thermally insulated, non-conductive hoses) to the power lead vent stacks.
- 2.7 Remove the power lead vent stack from each power lead.
- 2.8 Remove the test dewar flexible vent line.
- 2.9 Remove the transfer lines supplying the 4-20 K circuit.

3. Top Plate and Insert Removal

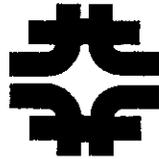
- 3.1 Remove all bolts fastening the top plate to the dewar extension.
- 3.2 Lift the top plate and insert from the test dewar and set them onto the roll-around cart.
- 3.3 Tighten the nuts on the underside of the current lead top plate against the plate to provide stability during transportation.



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**7500 A HTS Power Leads for the
LHC DFBX:
22. Removal of the Current
Leads**

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**Stand 3 LHC-HTS Lead Testing:
22. Removal of the Current Leads**



**7500 A HTS Power Leads for the
LHC DFBX:
22. Removal of the Current
Leads**

1. Electrical Disconnection of Current Leads from Test Facility

- 1.1 Unbolt the heater from each power lead flag.
- 1.2 Remove the bottom fill tube.
- 1.3 Remove the He space temperature sensors and the liquid level probes.
- 1.4 Remove the Kapton and glass tape insulating the low temperature superconducting cable.
- 1.5 Unclamp the V5 voltage tap wires from the LTS cable.
- 1.6 Unwind the excess voltage tap wire from around the bottom of each power lead and gather it into a coil. Secure it with tape and let it hang from the end of the power lead.
- 1.7 Separate the joined LTS cables by opening the mechanical clamp. Recover as much indium as possible.
- 1.8 Remove the mechanical clamp, the clamp support, and the G-10 clamshell clamp.

2. Mechanical Removal of Current Leads from Test Facility

- 2.1 Using wedges, tilt the insert by 10° so that the power leads are vertical.
- 2.2 Remove the jam nuts from the tensioning studs.
- 2.3 Remove the loading nuts and Belleville washer assemblies from the tensioning studs. Put each Belleville washer assembly/loading nut/jam nut group on a threaded rod for storage.
- 2.4 Use a 5/16 12-point socket to loosen and remove the 20 Conflat bolts connecting the lead plate to the insert top plate.
- 2.5 Attach the lifting/insertion tool to the lead flag and carefully lift the lead from the top plate.
- 2.6 With the lead supported by the crane at a reasonable working height, remove the power lead baffle.
- 2.7 Remove the Conflat copper gasket from the knife edge on the underside of the lead plate.
- 2.8 Clamp the end support around the lead lower flange so that the handles can rest on the backs of C-channels when the lead is put on a steel table.
- 2.9 Place the lead on the C-channels, using the end support to prevent any loading on the lower part of the lead.
- 2.10 Recover as much indium as possible from the power lead LTS cables.
- 2.11 Remove the upper insulator, PEEK seal, and lower insulator from each chimney.
- 2.12 Put each upper insulator, PEEK seal, and lower insulator in LN2. This will drive off the absorbed helium and will greatly improve the system background during the leak check of the next pair of leads to be tested.



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**7500 A HTS Power Leads for the
LHC DFBX:
23. Pack and Ship the Leads**

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**Stand 3 LHC-HTS Lead Testing:
23. Pack and Ship the Leads**

Lead Pair

Negative Lead: 20

Positive Lead: 40

Signed

C. E. Hess

Date

03.17.05



1. Pack the Leads

- 1.1 With the lead on the steel table, swing the insertion/lifting tool 180° so that the lead can be picked up and remain horizontal as shown in Figure 1.1.

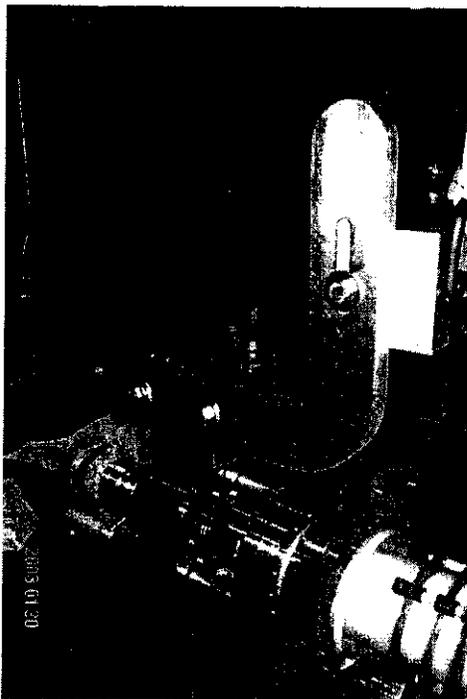
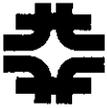


Figure 1.1 Orientation of the insertion/lifting tool to allow the power lead to be held horizontally.

- 1.2 Lift the power lead off of the steel table.
- 1.3 While supporting the lead from the crane, remove the end support clamped around the lower flange of the power lead.
- 1.4 Complete the lead preparation checklist:
- a) Install the protective covers for the lead top plate knife edge sealing surface and for the lower flange sealing surface on each lead. Secure them with tape.
 - b) Insert a protective plastic cap into the 4-20 K gas port for each lead.
 - c) Reattach the g-force indicators that were attached to the leads when they arrived.
 - d) Wrap the ceramic insulator at the top of each lead in bubble wrap.
 - e) Place a cap on the Conflat flange at the top of each lead.



- f) Wrap the power lead vacuum pumpout in aluminum foil.
- g) Secure the power lead bus and voltage tap wires to the power lead lower G-10 section with tape.
- h) Set each lead in the shipping crate and remove the insertion/lifting tool.

1.5 Complete the packing checklist:

- a) Reinstall the wooden supports in the crate to hold the lead in place during shipping.
- b) Make two photocopies of all documents in the lead travelers, and place the power lead travelers in the shipping crate. One copy of the documents is for Sandor, the second copy is for Marsha Schmidt.
- c) Verify the following items are in the shipping crate:
 - i) Two flag heaters
 - ii) Two flag heater connectors
 - iii) Vacuum pumpout actuator
 - iv) NW16 clamp
 - v) NW16 o-ring

1.6 Close the shipping crate

2. Ship the Leads

2.1 Complete the shipping checklist:

- a) Call Marsha Schmidt (X-4377) to request that the power leads be shipped to storage.