

Fermilab

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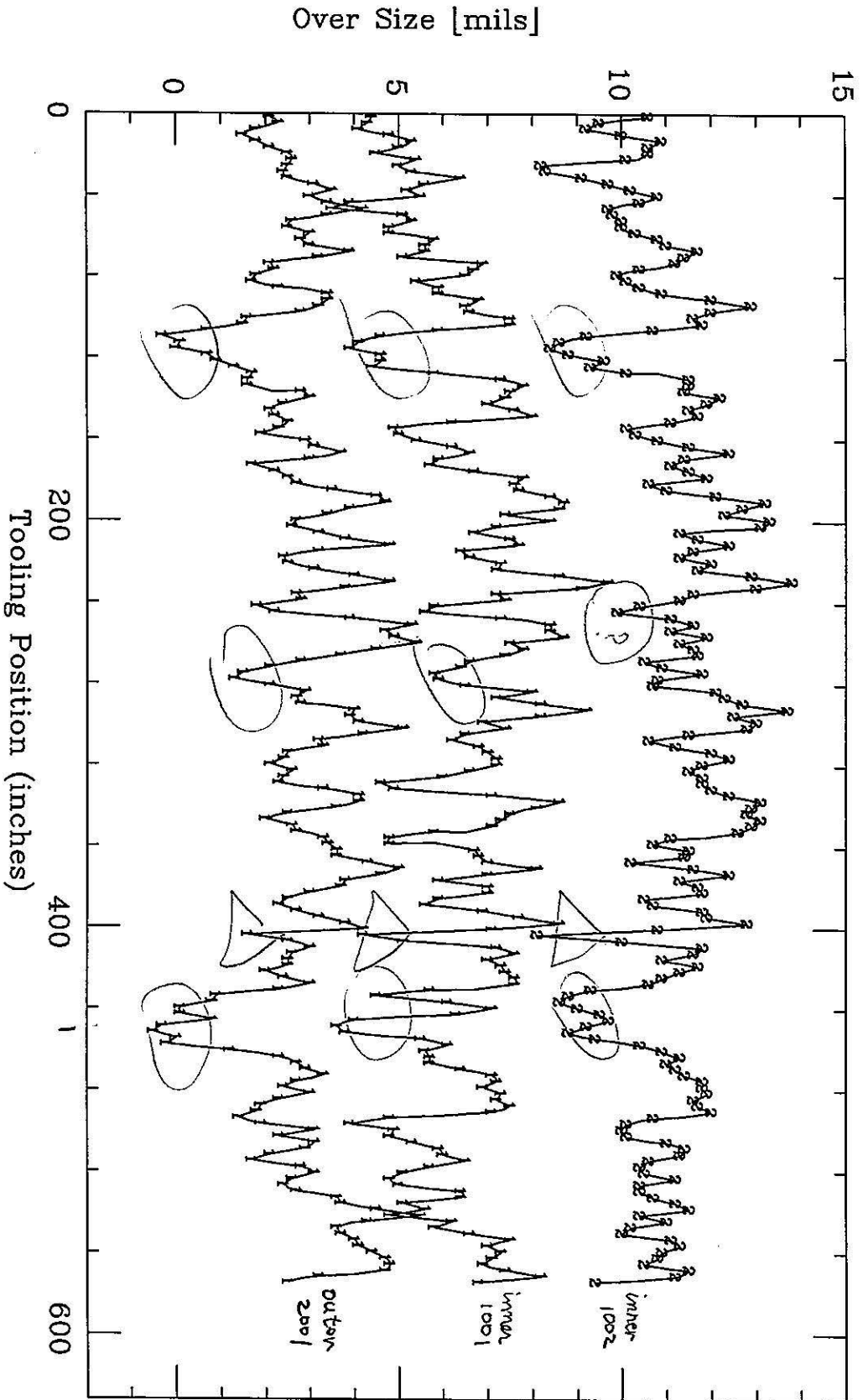
Subject: Coil Size Deviation of Long Dipole DCA^{3/0}~~320~~

The first series of 50 mm long dipole coils were wound and the size data became available¹. Attached are the data of inner coil 1001,1002 and outercoil 2001. Though the averaged size is about what we expected, these coils have large deviation in coil sizes. It should be noted that all tesse coils have the same deviation pattern. There are large bumps at 120", 280" and 445" from lead end ². and this is common for both inner and outer coils. It is very suspicious this is coming from the press instead of the tooling. At the position 400", there is an asymmetric structure in the I/III side of the both inner and outer coils. he curing press should be inspected carefully at these positions.

¹Dick's automatic sizing is now working and Terry has the transfer route to VAX.

²measured from the straight edge of the pole turn.

DCA310 Coils @ 12 ksi (I/III side)



DCA310 Coils @ 12 ksi (II/IV side)

