DCA315 Return End
Extra Kapton

TS-SSC 91-171
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Table 1 shows the inner diameter deviations from the nominal 3.948" for the return end clamps of DCA313, 314, and 315. Also shown are the number of additional 5 mil kapton layers added to DCA313 and 314 and the hydraulic pressures necessary to install them.

Position (inches from collar laminations)	DCA313 I-III	DCA313 II-IV	DCA314 I-III	DCA314 II-IV	DCA315 I-III	DCA315 II-IV
0.25	-5	-10	-3	-5	-4	-6
1.0	-10	-12	-4	-8	-6	-6
2.0	-7	-9	-3	-5	-3	-6
3.0	-5	-6	-4	-7	-4	-6
4.0	-4	-4	-2	0	-5	-5
5.0	-3	-2	+4	+2	-5	-6
6.0	-2	-1	+4	+4	-5	-6
Hydraulic Installation Pressure (kpsi)	6029		6300			
Extra Layers Added (5 mils each)	0		1			

Table 1. Deviations of the Collet Insulator Inner Diameters from Nominal Diameter 3.948"

The dimensions of this set are very similar to the DCA314 set in the coil straight section (.25, 1.0, 2.0" positions). DCA314 was installed with reasonable hydraulic pressure and showed deflections of the can outward between 3 and 7 mils in the straight section region. I therefore recommend installing this end clamp with a **single additional layer of 5 mil kapton** added to the inner surface of the G10 CR insulators.