

SLAC Magnetic Measurement Plan and Traveler for the FACET Sextupole Magnet S1E#1 S202145T (style 1.625SX9.06)
Account Number to be charged: 9141206

This traveler covers the magnetic measurements plan for one of 2 identical water-cooled sextupoles, of engineering type 1.625SX9.06, called S1E#1, to be used as S202145T in sector 20 in FACET.

This new sextupole uses part of the steel core of a much longer sextupole that was made in 1986 at SLAC and previously ran in the SLC FF here at SLAC. Consequently it may have a very little residual radioactivity, the levels are marked on radiation tags and Jim Allan (ext 4064) can provide you further information on the type of radiation and what precautions you should take when handling these magnets.

This magnet weighs about 280 lb, and comes to you on a special channel support which sits on its final T1 mount; the whole assembly weighs 405 lb. It has yellow labels that indicate its beamline position in FACET (S202145T). It will run on its own power supply (hurrah).

1. Receiving Information:

Received by (MM initials)	SOA
Date received : (dd-mm-yyyy):	12-9-2010
Checked Magnet Number(S1E#1),Optics name(S202145T)	? ok by 15 Dec 2010
Magnet Engineer (Cherrill Spencer or her substitute) verifies that this magnet is ready to be magnetically measured.	Cherrill Spencer 8th Dec 2010
If sextupole does not have a barcode sticker then ask Magnet Engineer to add one and she will write the 6 digit barcode number here:	002724

Preparation:

2. Power and LCW Connections: Unipolar PS $\geq 50A$, 20 V required. Cosine-shaped ramp that mimics the ramps produced by an Ethernet-driven controller.

High pressure LCW system will be needed to cool this magnet in your measurement lab.

3. Magnet Orientation:

A beam direction arrow, should be visible on the top or side of the core, .Notice: This magnet has coil interconnects, power terminals and water fittings **downstream**. If there is no arrow, contact Cherrill Spencer, x3474.

Beam-direction arrow in place (initials):	SOA
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4. Magnet Alignment:

This magnet has sockets for 4 new tooling balls (TBs), they were recently fiducialized on the CMM in Bld 26 by Keith Caban and he has sent their fiducialization data to Mike Gaydosh who will give it to the Alignment crew.

Fiducialization of new TBs complete (Alignment Initials :) *BR*

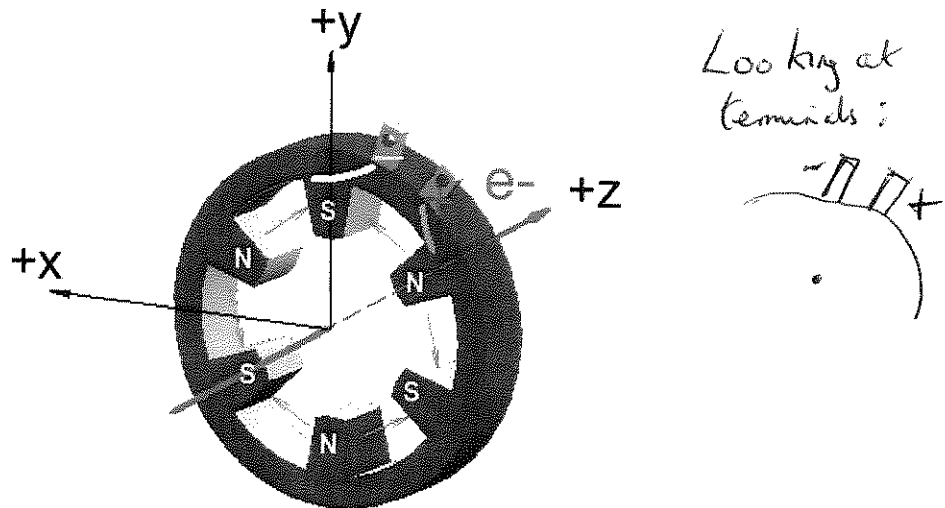
Alignment crew should do set up on measurement stand, and use the x,y,z axes of the whole magnet (as defined by TB measurements) such that the roll angle (angle of horizontal axis) is less than about 8.3 milliradian (or as small as possible), and pitch and yaw is also minimized. Fiducialization data on location of tooling balls with respect to geometric axis when poles are aligned perfectly horizontally should be saved.

Alignment completed, Roll Angle = 0.4 millirad (Alignment Initials :) *BR*

The rotating coil should have its windings oriented so that a 'zero' angle quoted for a pole is indeed zero relative to the horizontal axis defined by the alignment crew. (Angle of first south pole, and of higher multipoles is important). A stretched wire will be used before the rotating coil - see step 11.

5. Power leads and polarity:

The required polarity for S1E#1 is *focussing for electrons on the positive x side of the center*. This means the topmost pole (at 90 degrees to the horizontal) must be a SOUTH pole as shown in the figure below. This cartoon shows the power terminals upstream, in fact they will be downstream, so ignore the terminals in this cartoon.



Determine the electrical connection polarity (with supply outputting positive current) which produces the required magnetic field polarities. Place + and - labels on or near the main power flags for the required polarity.

Polarity established, power +/- labels applied *SRX*

6. Cooling Water Flow Check:

Each sextupole has 3 water circuits, there are 2 coils in series in a water circuit. There are 2 LCW input spiggots and 3 output spiggots. I will attach the top assembly drawing SA-235-019-60 so you can see which are LCW inputs and which outputs. There is no water manifold coming with the sextupole, please use your own manifold. Adjust the differential pressure across each water circuit (deltaP) to be about 150 psi.

Total water flow should be about 0.9 gpm. If you cannot adjust deltaP to 150 psi, first use 200 psi (or max), measure the flow, then make total flow 0.90 -0.0/ +0.2 gpm by adjusting the valve).

	Water flow [gpm]	Check
Maximum delta P _____	1.1 gpm	
Adjusted to produce 0.9:	0.9 or	

7. Thermocouple placement and Thermal Test: (thermal test to be done onS1E#1 only)

Place 5 thermocouples at these locations:

- any one of the coils – on the incoming LCW – on the outgoing LCW -elsewhere on bench for ambient temperature measurement – on the steel core near any pole tip.

Arrange for temperatures to be read at least once every 3 minutes for the following thermal test: After water flow has been checked on each circuit, run JUST the FIRST sextupole to 50 A for three hours, reading the thermocouples, magnet current and voltage.

Confirm total LCW flow is 0.90 -0.0 /+ 0.2 gpm	Flow is <u>1.1</u> gpm
Name of thermal test file and date of test	<u>rtdata.rul 12/9/2010</u>
URL of webpage where datafile stored	
Final LCW temp (in) – Final LCW temp (out)	= <u>0.13</u> °C

If the rise in the LCW temperature is more than 2 deg C, something is wrong; stop, call Cherrill Spencer at x3474 or substitute.

8. Initialization:

To be done only once, after successful completion of the water flow check and Thermal Test above. Use the cosine ramp with an equivalent linear rate of 5 A per second (NOTE I HAVE REDUCED THE STANDARDIZATION RAMP RATE FOR THESE SHORT SEXTUPOLES), minimum current of 5 A, maximum current of 50 A and pause time of 120 seconds at the minimum and maximum currents. Take the sextupole from 5 A to 50 A and back 7 times, ending up at 5 A

Initialization completed: date , MMG initials:	<u>12/9/2010 SDA</u>
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9. (a) Standardisation parameters and detail: (For use in measurements below)

Ramp type: cosine shape

Minimum standardisation current: 5 amps

Maximum standardisation current : 50 amps

Pause time at minimum or maximum standardization current: 30 seconds

Equivalent linear ramp rate for standardization process: 5 amps/second (increasing or decreasing) [note is 5 amps/second]

Start at 5 A and ramp up to 50 A and down to 5 A three times, finishing at 5 amps. A standardization procedure always involves FIVE up and down ramps; the up ramp followed by the down current ramp is called a *cycle*.

Setting to desired current (BDES) : ramp UP to BDES at 5 amps/second

All operating currents should be approached from below; except when I request a series of decreasing currents – these will be approached from a higher current. When moving from one current to another for the strength or harmonics measurements use 5 amps/second and wait at least 30 seconds after the operating current has been reached before making any magnetic measurements. Put basic standardization details in all datafile comments.

Confirm that magnet will ramp at 5 A/s (initials:)	SDA
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9 (b) Multiple standardization cycles to be carried out BEFORE any measurements are made. NEW instruction for the remaining FACET magnets.

To avoid the situation where the integrated strength at a fixed current continues to vary when the magnet is powered off and then on again and measured after a single standardization procedure, I ask you to carry out many standardization cycles on this style sextupole before any measurements are made on it. This will “train” the magnet into a state to produce a repeatable integrated strength when it is powered up in the beamline. Take the sextupole through 75 standardization cycles (equivalent to 15 standardization procedures)

Sextupole has undergone 15 standardization procedures	Date: 12/9/2010 Start time: 4:06
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10. Poletip Field Measurements

When it is convenient, maybe when the rotating coil is not in the sextupole’s aperture, please use a Hall probe to measure the poletip field at 34.2 amps (after a regular standardization procedure) . Please make a correction in the field value for the thickness of the Hall probe.

Current	Actual current	Poletip field :
34.2 A nominal	34.37	0.147T
Date and initials:	SDA	12/9/2010

11 (a) Stretched Wire Measurement to calibrate the rotating coil:

If a stretched wire is used to calibrate the rotating coil then record the datafile name and URL:

http://www-group.slac.stanford.edu/met/MagMeas/MAGDATA/FACET_Sector_20/S1E#1/ Coil Calibration/
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11 (b) Stretched Wire Measurement to Estimate Harmonics- please do this on S1E#1

Based on observations of the behavior of the rotating coil DC34qadd we need to make some stretched wire measurements to estimate the sizes of the multipoles, especially the 18-pole. Set up a stretched wire along the x=0, y=0 magnetic center of the sextupole’s aperture, have an Alignment Crew help set it up as well as they can.

Standardize and ramp up to 35 amps at 5 amps/second. Pause for 30 seconds before taking any data.

Measure integral B.dl at the following x positions (and y=0) with the stretched wire:
 -1.8,-1.5,-1.2,-0.9,-0.6,-0.3, 0.0, 0.3, 0.6, 0.9, 1.2, 1.5, 1.8 cm
 Go back across the aperture at the same x in reverse order and measure integral B.dl at 35 amps.
 Put all the data in the same data file.
 Tell the Magnet Engineer when this data is available and don't remove the stretched wire until the Magnet Engineer says it's OK to proceed.

Filename of Wire-Harmonics Measurement	wirevs x	.ru 2
Date of measurement, initials	12/10/2010	SDA

12. Rotating Coil Magnetic Measurements: $\int G'dl$ and harmonics at various currents.

Purpose of these measurements is to find the transfer functions (Current required to reach a certain integrated gradient-primed strength) especially for the desired integrated gradient-primed, and to check that the multipole harmonics do not exceed FACET requirements.

For S1E#1, the desired $\int G'dl$ is +1841.2738 kGauss/m (will need about 35 A)

Rotating Coil Designation (Name)	DC55
Rotating Coil Radius	0.16239

13. Integrated Strength Measurements:

Measure the integrated gradient' $\int G'dl$ at these currents:

5, 10, 15, 20, 25, 30, 35, 40, 45, 50 amps

Then back to 5 amps from 50 amps, measure the $\int G'dl$ at the same set of currents in reverse order. Remember to ramp at 5 amps/second and wait for 30 seconds after reaching the new current before starting a measurement.

Filename of Int. Strength Measurement	strdat	.ru 3
Date of measurement, initials	12/14/2010	SDA

14. Harmonics Measurements (with rotating coil, still do this, for comparison with stretched wire measurements in step 11(b)):

Measure the strength and angle of each multipole component at 35 amps.

(or at the operating current provided after analysis of integrated strength measurement).

Multipole values should be given as a percentage of the sextupole moment calculated at a 1cm radius, PLEASE. Also provide the magnetic center X and Y coordinates measured during the harmonics measurements at the above current.

Filename of Harmonics Measurement	hardat	.ru 3
Date of measurement, initials	12/14/2010	SDA

15. Polarity Reversal Test: THIS TEST WILL BE DONE ON S1E#1 to check the multiple standardizations in step 9(b) are sufficient to train this 1.625SX9.06 style sextupole. **REVERSE THE POLARITY OF S1E#1 and redo the integrated strength and harmonics measurements** (16, 17 below).

Swap the power cables on S1E#1 when you have done its nominal polarity data-taking and do TWO standardization procedure [10 cycles] in the new polarity and redo the measurements of integrated strength and harmonics, as indicated below *[when we have seen the stretched wire estimate of multipoles from step 9 (b) we will discuss whether the stretched wire needs to be used during the reversed polarity measurements or not]*.

The magnet engineer will do a comparison of the polynomials in the two polarities and decide if two standardizations are sufficient to maintain the behavior of the sextupole.

Then swap back to the original polarity and standardize TWICE and do the strength and harmonics measurements again (18,19 below) and the magnet engineer will do a comparison analysis and tell you of she needs any further measurements or if the same reversing polarity test has to be done on all 1.625SX9.06 sextupoles.

16. Reversed Polarity Integrated Strength Measurements:

Measure the integrated gradient' $\int G'dl$ at these currents:

5, 10, 15, 20, 25, 30, 35, 40, 45, 50 amps

Then back to 5 amps from 50 amps, measure the $\int G'dl$ at the same set of currents in reverse order. Remember to ramp at 5 amps/second and wait for 30 seconds after reaching the new current before starting a measurement.

Filename of Int. Strength Measurement	strdat .ru 4
Date of measurement, initials	12/15/2010 SDA

17. Reversed Polarity Harmonics Measurements:

Measure the strength and angle of each multipole component at 35 amps.

(or at operating current provided after analysis of integrated strength measurement).

Multipole values should be given as a percentage of the sextupole moment calculated at a 1cm radius. Also provide the magnetic center X and Y coordinates measured during the harmonics measurements at the above current.

Filename of Harmonics Measurement	hardat strdat .ru 4
Date of measurement, initials	12/15/2010 SDA

18. Original Polarity Integrated Strength Measurements:

Measure the integrated gradient' $\int G'dl$ at these currents:

5, 10, 15, 20, 25, 30, 35, 40, 45, 50 amps

Then back to 5 amps from 50 amps, measure the $\int G'dl$ at the same set of currents in reverse order. Remember to ramp at 5 amps/second and wait for 30 seconds after reaching the new current before starting a measurement

Filename of Int. Strength Measurement	strdat .ru 5
Date of measurement, initials	12/15/2010

19. Original Polarity Harmonics Measurement:

Measure the strength and angle of each multipole component at 35 amps.

(or at operating current provided after analysis of integrated strength measurement).

Multipole values should be given as a percentage of the sextupole moment calculated at a 1cm radius. Also provide the magnetic center X and Y coordinates measured during the harmonics measurements at the above current.

Filename of Harmonics Measurement	hardat .ru 5
Date of measurement, initials	12/15/2010

The magnet engineer will do a comparison of the polynomials in the two polarities and decide if the single standardization procedure is sufficient to maintain the behavior of the sextupole. Check with her/him before removal of S1E#1 from bench.

Magnet Engineer Approval obtained	Cherrill Spencer 16 Dec 2010
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20. Saving and Distributing the Magnetic measurement data

Please post all data at

http://www-group.slac.stanford.edu/met/MagMeas/MAGDATA/FACET_Sector_20/sextupole/S1E#1


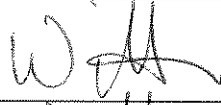
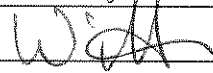
in a subdirectory with the magnet name.

Please inform Magnet Engineer (Cherrill Spencer at cherrill@slac.stanford.edu (ext 3474). and /or achim@SLAC.Stanford.EDU, wittmer@SLAC.Stanford.EDU of FACET) when the strength and harmonic measurement data are available for inspection and analysis, and for final approval .


21. This section is to be completed by FACET Magnet Engineer.

Data been inspected & analyzed by Magnet Engineer	Cherrill Spencer 16 Dec 2010
Based on Magnet Engineer analysis of data can confirm the pre-assigned beamline location (optics-deck name):	Optics beamline location: S1E#1 S202145T
Sextupole is released from Magnetics Group, signed and dated by FACET Magnet Engineer:	Cherrill Spencer 17 Dec 2010
Remove the LCW from the coils and take the magnet to the designated storage area. Signed & dated by MMG personnel:	Done on 17 Dec 2010

22. This section is to be completed by FACET Beam Physicist (Walter Wittmer).

Checked that integrated strength data is satisfactory and have generated the polynomial function for the controlling database to set the magnet. Nominal operating current is <u>35.2</u> amps. Checked that this is within the capability of the assigned power supply <u>max 38 A and Max std = 50 A</u>	Signature and date:  01/20/11
Checked that the multipole values at r=10mm are below the Physics Requirements tolerances (initial):	
Magnet accepted for FACET (signed):	
Date accepted (Month-Day-Year):	01/20/11

When this traveler is completed, attach it to the fabrication traveler of this magnet and send these hardcopies to the designated person in Kathleen Ratcliffe's group at MS 18 to be scanned into a pdf file. Then that electronic file will be stored in a place TBD and the hardcopies will be returned to sit with the magnet until it is installed in the beamline.

Two travelers for this magnet been scanned into a pdf file; by <u>Catherine Creech</u>	Name of pdf file <u>Magnet S1E#1 S202145T</u>
Two travelers been returned to sit with magnet in its "waiting for installation" place.	Signed & dated:  1.28.11

Further Tasks to be done on this magnet will be recorded on its Fabrication Traveler.

END OF FACET S1E#1 (S202145T) MAGNET MAGNETIC MEASUREMENT PLAN AND TRAVELER