Weekly Reporting SNS PPU

WBS P.02.03 Cryomodule Integration (JLab Scope)

June 2, 2023

**Issues:** None

**Accomplishments this week:**

Management:

* New requirements for after-hours work are emerging at JLab.  We are working to ensure that CM-06 cooldown is minimally impacted due to this potential change in operation.
* PPU activities are continuing with cryomodule assembly.
* Off-site work efforts continue in the procurement area on end cans.
* Presented PPU status at internal Planning and Coordination Meeting

Engineering & Design:

* Sustaining engineering activities are continuing in order to revise drawing packages based on feedback during the procurement phase with a focus on end can drawing packages.

Procurement:

* Supply End Cans (SECs):

|  |  |  |
| --- | --- | --- |
| S/N | Status | Estimated Delivery Date |
| 01 | Installed on CM-03 |  |
| 02 | Installed on CM-04 |  |
| 03 | Installed on CM-01 |  |
| 04 | Installed on CM-05 |  |
| 05 | Installed onto CM-06 |  |
| 06 | Delivered to JLab. Uncrated, inspections started. Phase 1 dimensional inspection done. Bridge tube angle is off by ~5 degrees. Welded onto PPU-07. The support block is machined, bridge tube bellows is largely skewed due to dimensional deviations on the SEC 06. |  |
| 07 | Installed on CM-02 |  |
| 08 | At the vendor. Album 2 cold mass/shield assembly work complete. Elbow/Flex Line welds complete. Currently working to complete flanged section of the bridging tube. Plan to be prepping for final testing next week. | Jun 15 |

* Return End Cans (RECs):

|  |  |  |
| --- | --- | --- |
| S/N | Status | Estimated Delivery Date |
| 01 | Installed on CM-03 |  |
| 02 | Installed on CM-01 |  |
| 03 | Installed on CM-05 |  |
| 04 | Installed on CM-02 |  |
| 05 | Delivered to JLab on 3/31. Inspection work complete. REC 5 is in position on CM-06. Bridge tube bellows has large deformation. A new support block has been welded onto PPU-06 cryomodule. |  |
| 06 | Installed on CM-04  |  |
| 07 | Delivered to JLab on 5/8. Uncrated on 5/10. Receiving inspection work has started and still ongoing. Initial alignment shows a modification to the bridge tube is needed. Currently the bridge tube is sectioned and will be re-welded. Another round of fitting/alignment will be performed after re-weld. |  |
| 08 | All interior structure is complete and wrapped in MLI. Album 2 (subassemblies) work completed. Vendor is working on completion of vacuum vessel heavy welding. Plan to transition to bridging tube work next week | June 22 |

Production:

* Cryomodule Status:
* CM-06: Installed in CMTF; Insulating vacuum leak checks on-going; On track for cooldown late next week.
* CM-07: REC positioned and aligned. Mitered elbow revised to achieve initial alignment.
* CM-08: Final steps in progress prior to installation into VV.

Project Management:

* Completed BCR 23-003 – CAM Change
* Issued Month End Manpower charts
* Held Progress Meeting
* Held Progress Analysis Meeting
* Updated CAM Notebook

Quality Assurance:

* Continue to monitor quality data for possible trends.
* Continuing to gather/review data deliverables for CM-06.

Project Photos: None