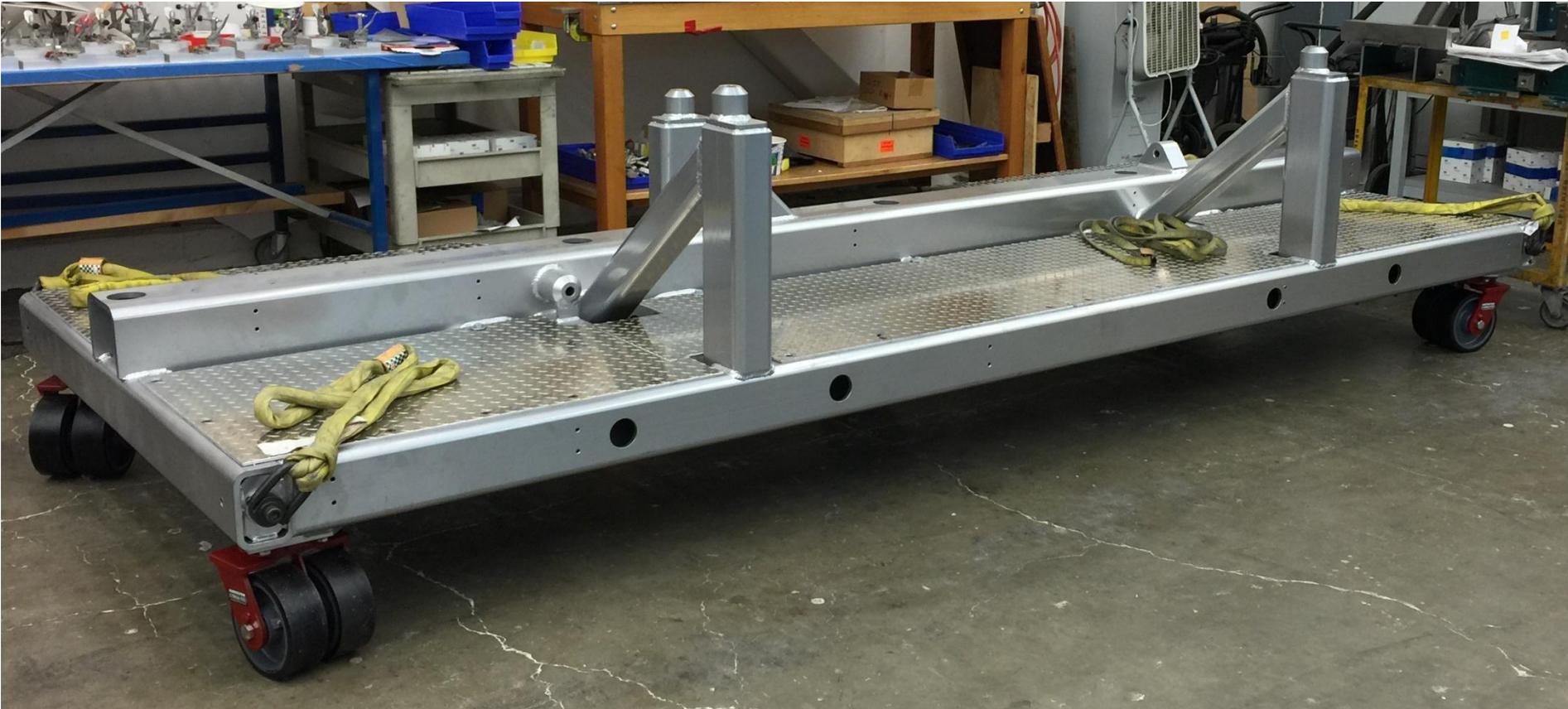
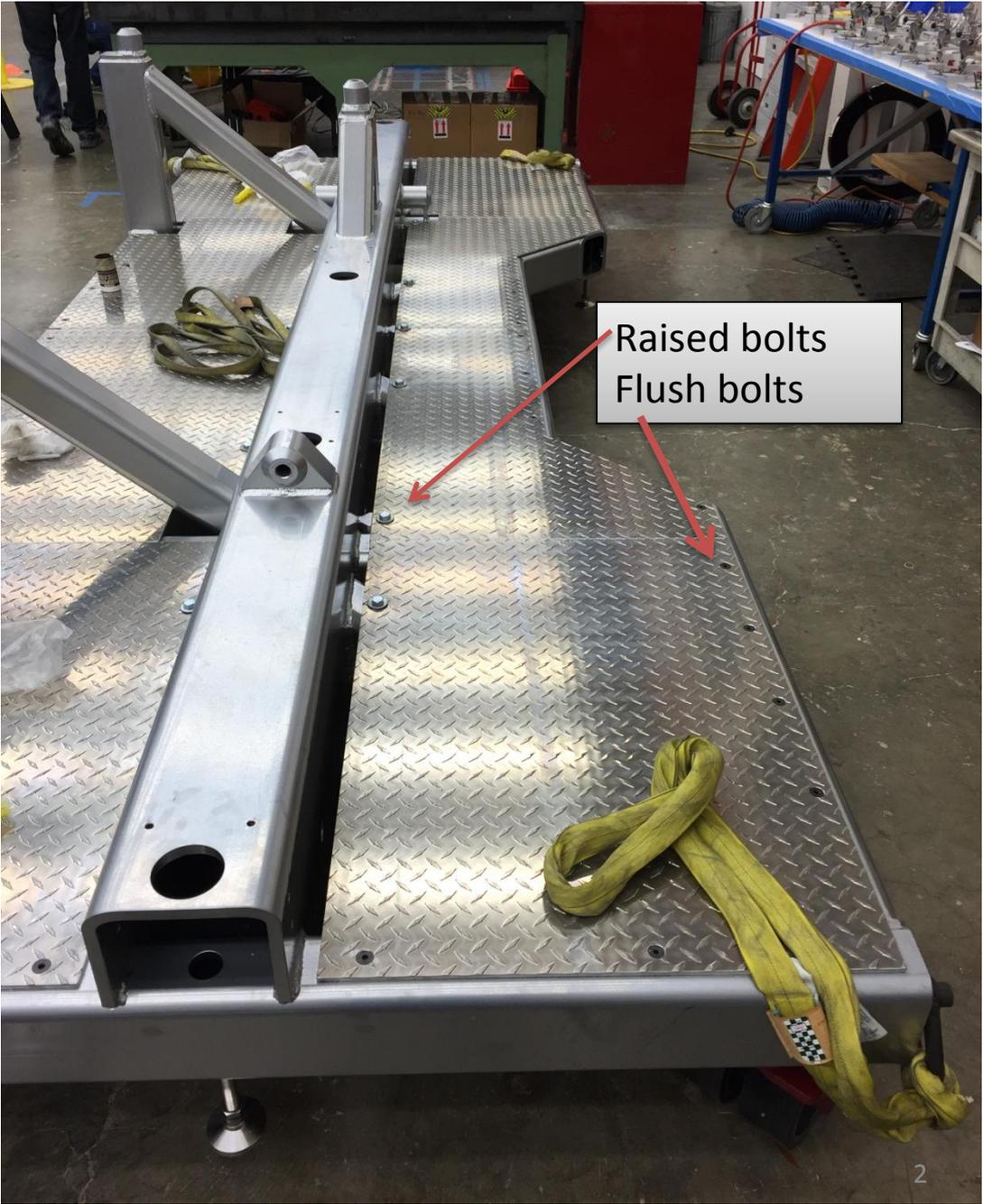


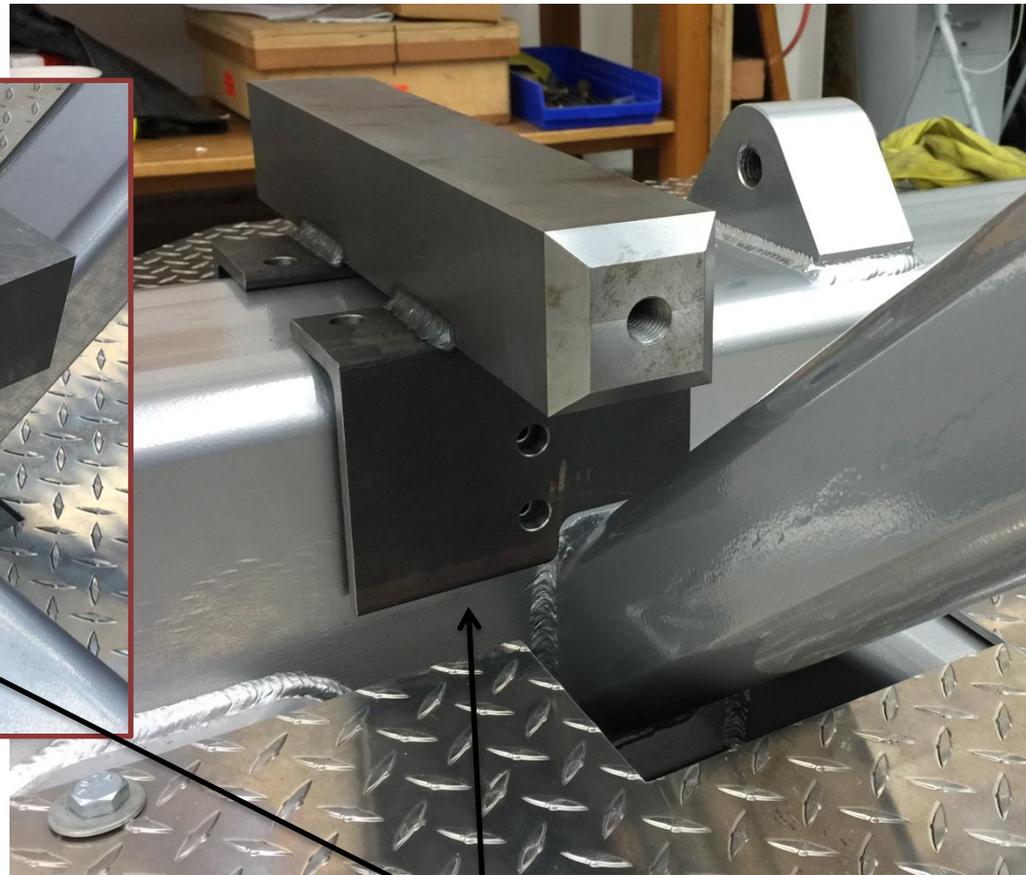
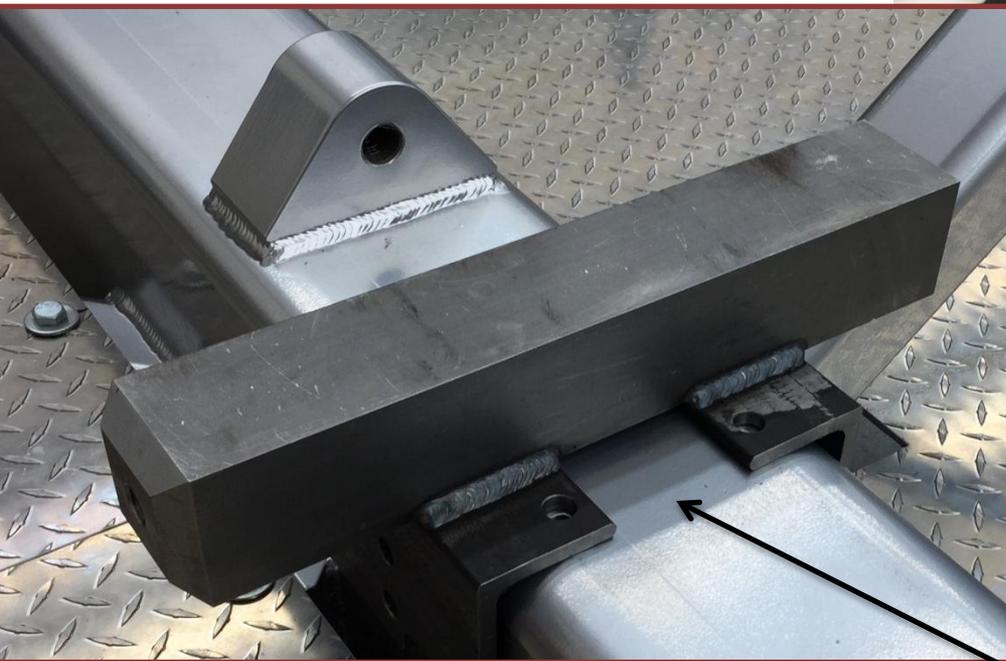
May 28, 2015 PXIE RFQ Fabrication Update



Support Frame is complete



Raised bolts
Flush bolts



A temporary strut support (unpainted) placed on the frame for a fit check.

Leveling feet

Part Fabrication Update

Water fitting for the Pi-mode rods and cooling channels are complete

Support Frame - complete

Temporary tuners - 2-3 weeks

Square to round vacuum port transition and blank-off plates - 2-3 weeks

Sensing loop plugs – in process

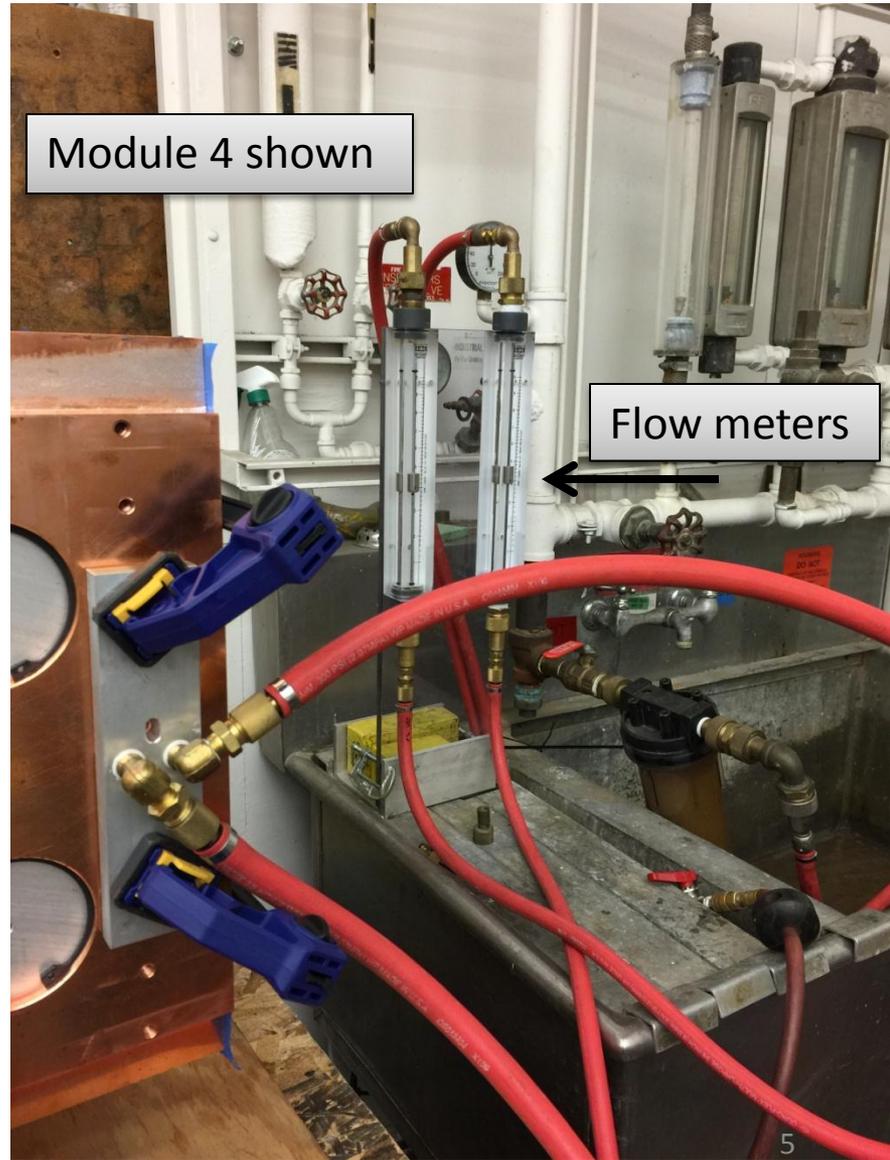
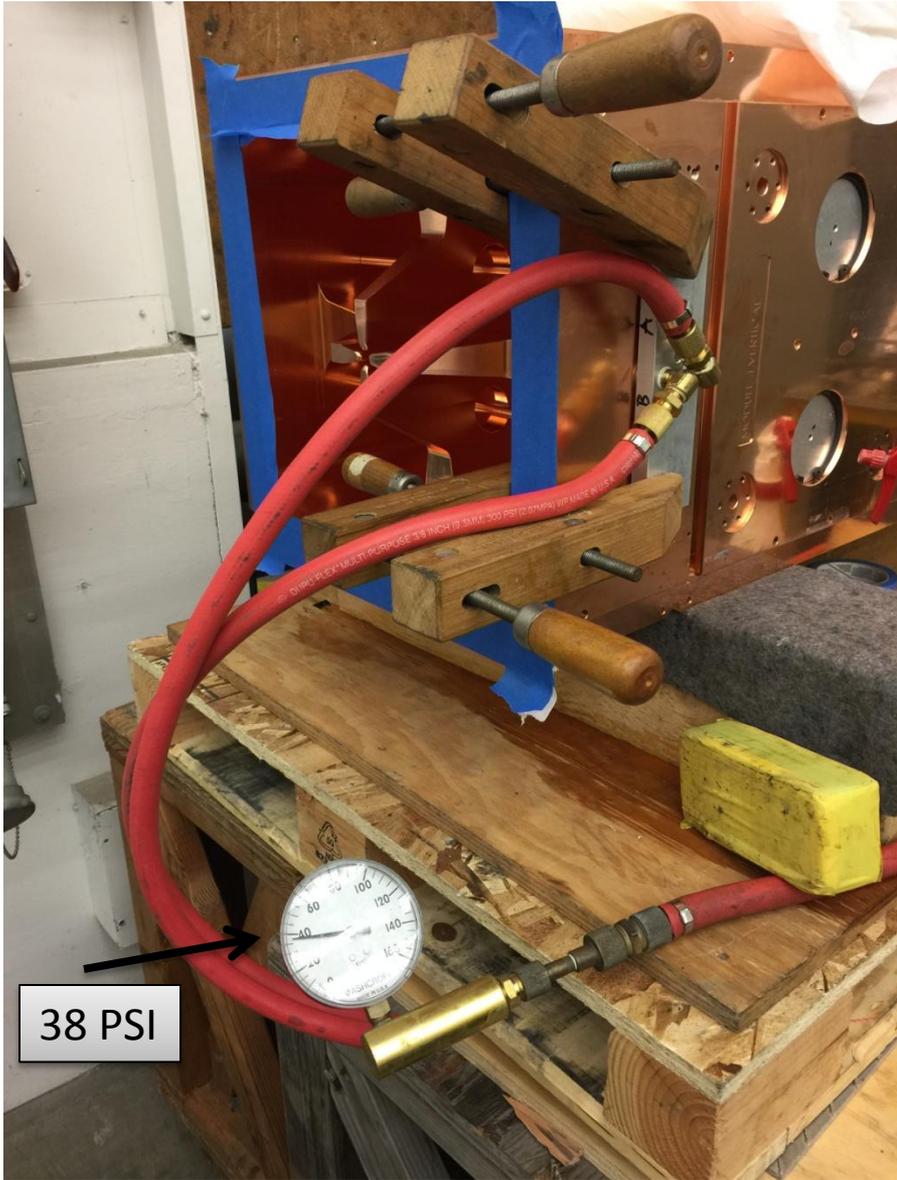
FNAL end plates final machining - not started

Shipping frame - not started

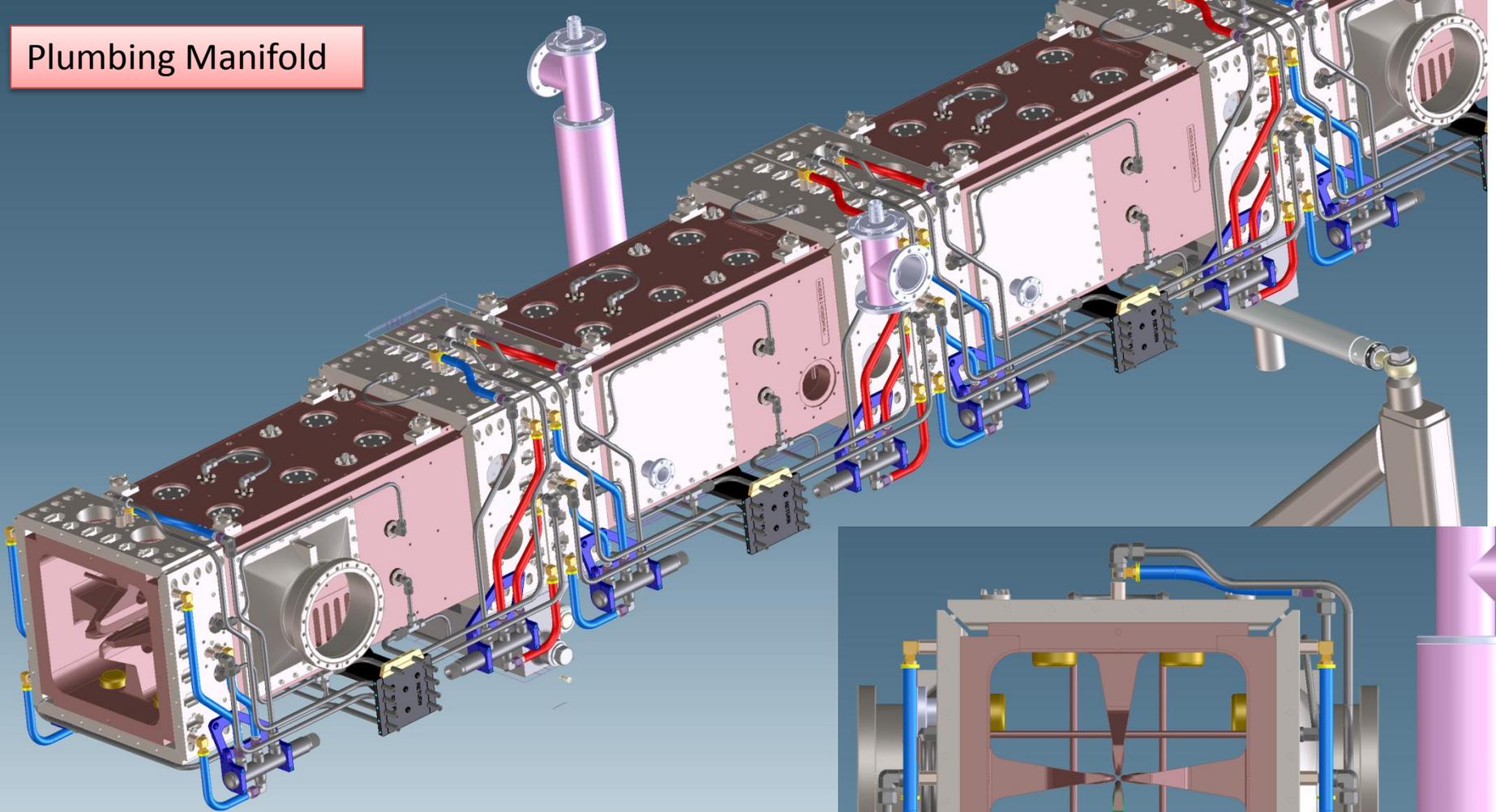


Final cooling passage flow check

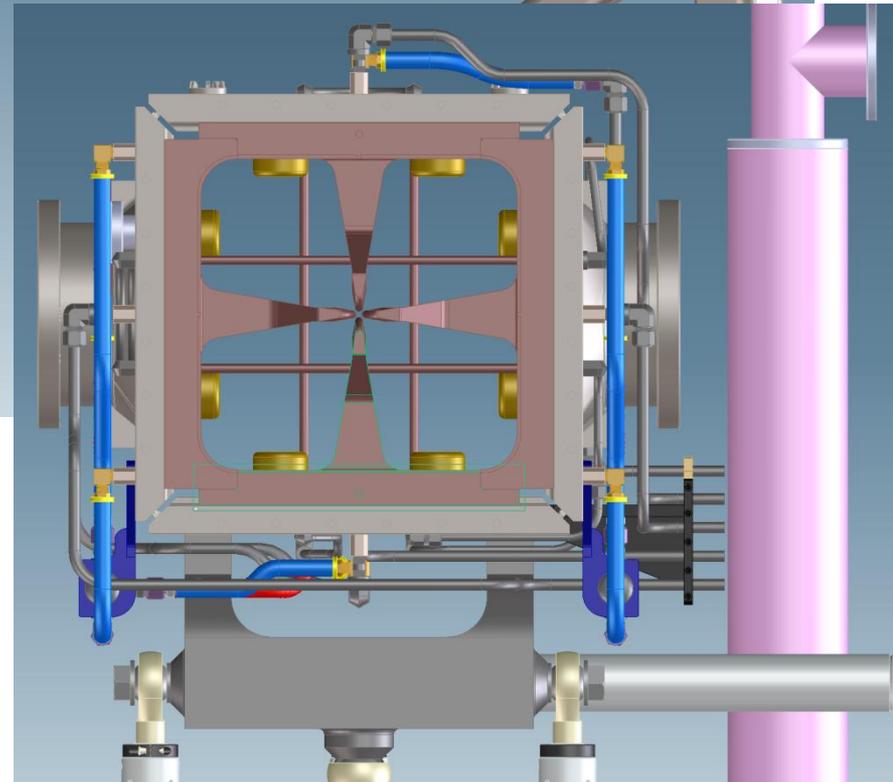
All modules have been final flow checked.



Plumbing Manifold



A plumbing manifold design has been created by Joe Wallig. It was discussed by LBNL last week and is being tweaked this week.



Internal Schedule Spreadsheet

	A	B	C	D	E
1	PXIE RFQ Assembly Tasks	Date Begin	Date Finished	Resource(s) Needed	
2	Helium leak check the cooling passages of all modules	5/18/2015	5/22/2015	1-2 Technicians	Done 
3	Use existing flow check hardware				
4	Pressure/flow check the cooling passages of all modules	5/21/2015	5/25/2015	1-2 Technicians	Done 
5	Use existing flow check hardware				
6	Take pressure drop reading on one module				
7	Final cleaning	5/21/2015	5/28/2015	Chris Redding	
8	Add the threaded inserts for tooling ball mounts	5/22/2015	5/28/2015	1-2 Technicians	Starting 
9	CMM all modules and transfer dimensions to tooling balls	5/22/2015	5/28/2015	Bob Connors	Starting 
10	Prepare temporary struts	5/18/2015	5/25/2015	1-2 Technicians	
11	Attach all joint plates	5/22/2015	5/29/2015	1-2 Technicians	
12	Bolt joint plates to RFQ				
13	Bolt plate corners				
14	Take one module and measure pressure drop through a single manifold			Joe Wallig	
15	Prepare support frame	5/18/2015	5/25/2015	Tim & Roman	Done 
16	Position in assembly shop				
17	Install floor anchors				
18	Prepare the rigging/hoist equipment for mounting the Modules	5/25/2015	5/29/2015	1-2 Technicians	
19	Assemble the full length RFQ on the support frame (Eng. Note 10924)	6/1/2015	6/12/2015	2-3 Technicians	
20	Install temporary tuners for bead pull				
21	Install sensing loops				
22	Install endwalls for bead pull				
23	Full length bead pull	6/15/2015	6/19/2015	LBNL & FNAL Phy. & Eng.	
24	Full length vacuum test	6/26/2015	6/30/2015	1-2 Technicians	
25	Install fixed slug tuners				
26	Install RF coupler/vacuum port blank offs				
27	Install end blank offs				
28	Install plumbing manifolds	6/30/2015	7/6/2015	1-2 Technicians	
29					