



The Fabrication and Measurements of the Dual Aperture Quadrupole for CEPC

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Outline

- Dual Aperture Quadrupole(DAQ) parameters and first prototype
- Preliminary field measurement results
- Optimization design
- Prototype modification and field measurement results
- Summary

DAQ parameters and first prototype

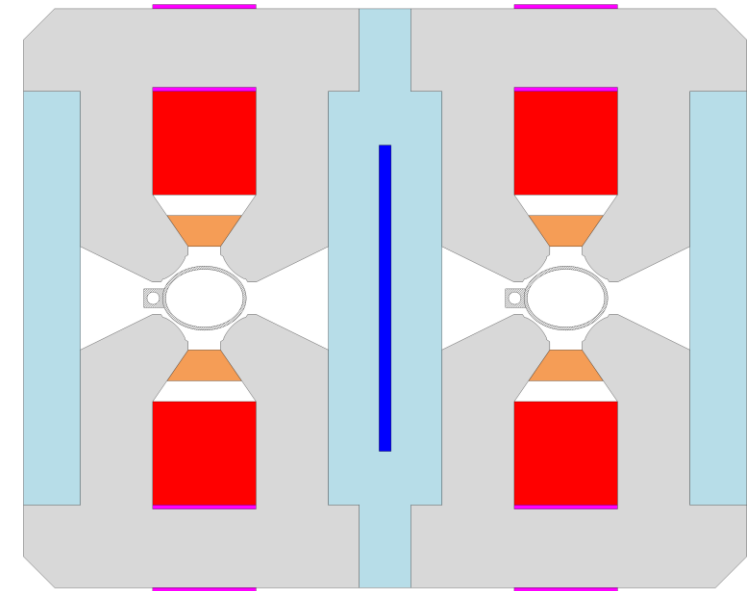
■ Basic parameters of DAQ(dual aperture quadrupole)

- Apertures: 76mm
- Beam separation: 350mm
- Gradient range: 3.2T/m@45.5GeV~12.8T/m@182.5GeV
- Trim coil: $\pm 1.5\%$ gradient tapering
- Field quality: 5×10^{-4} @Rref=12.2mm

■ First F/D prototype features

- DT4 compensation sheet
- Trim coils located on the yoke, far from the midplane.
- Hollow water cooled aluminum conductor.
- Large leakage field at the outside and middle of the magnet.
- Strong dipole field at the end.
- With lead blocks for radiation shielding

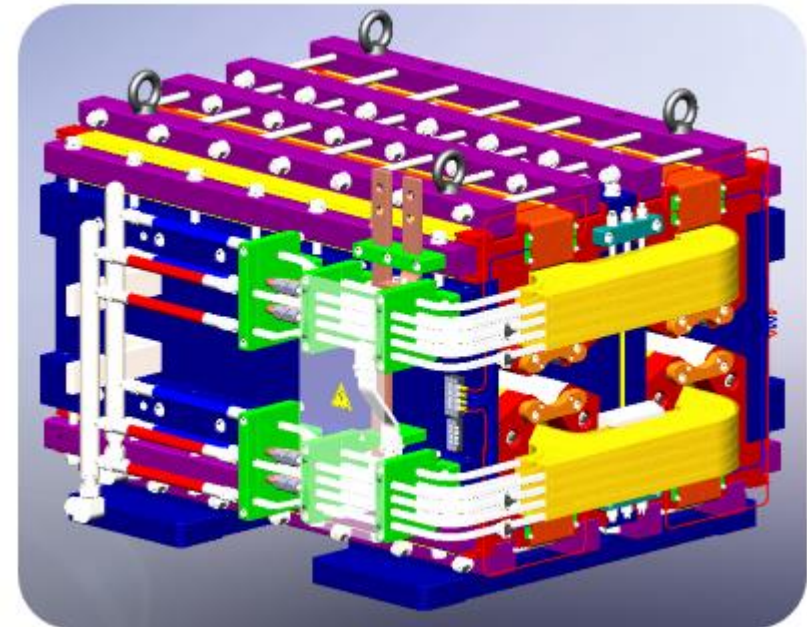
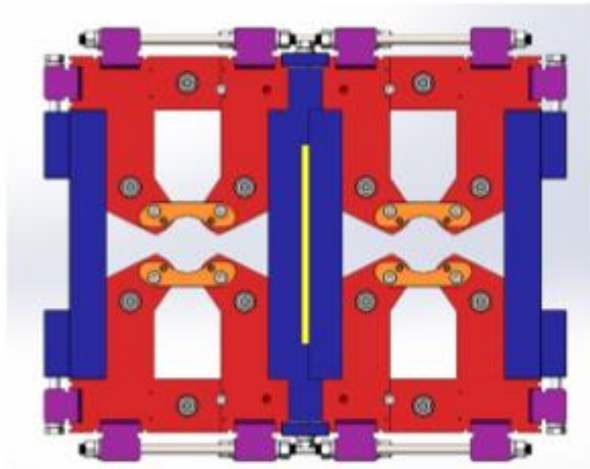
CDR,2018



First F/D design

DAQ parameters and first prototype

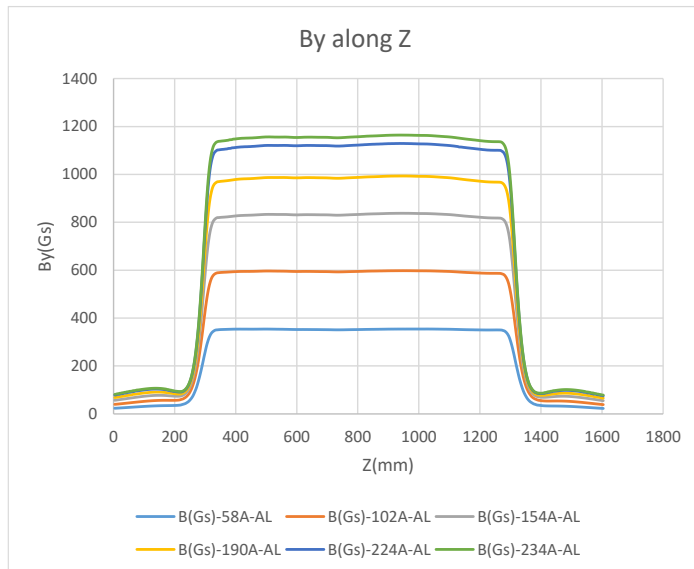
- The first prototype is a laminated one with DT4 compensate sheet in the middle.
- Complex mechanical structure:
 - The iron is divided into many blocks.
 - The poles are slender.
 - Difficult to control the tolerance.



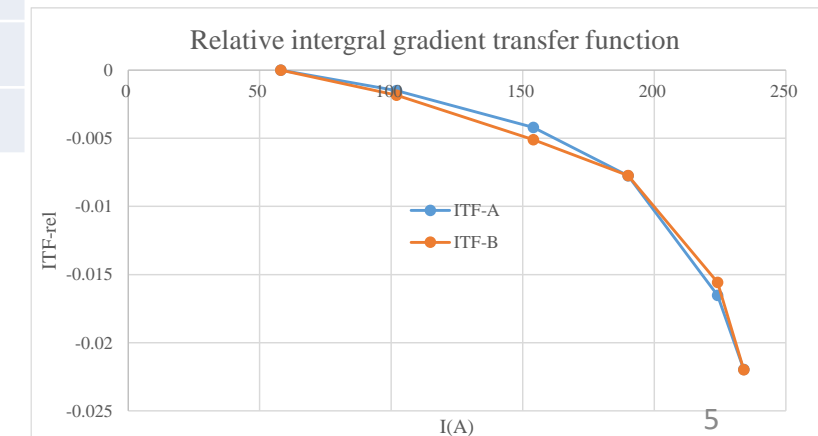
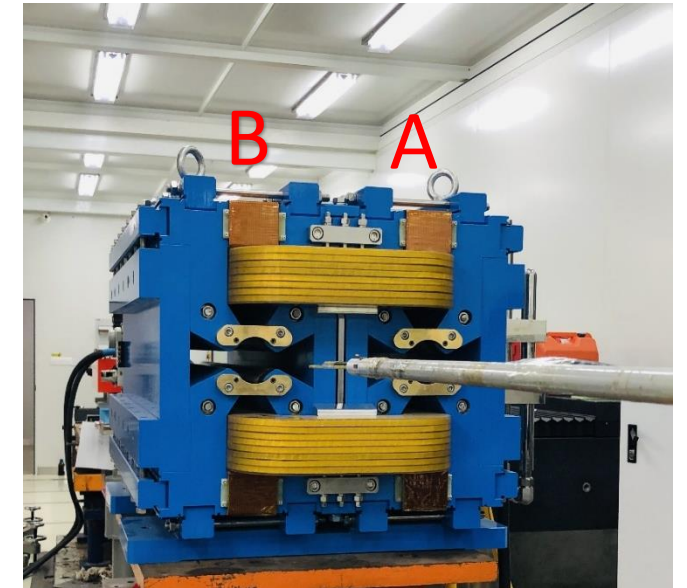
DAQ parameters and first prototype

- The first 1m long prototype was fabricated and tested by Hall.

- Large edge field;
- GL difference in two apertures: less than 0.5% (except 80GeV)
- X0 center shift with energy;



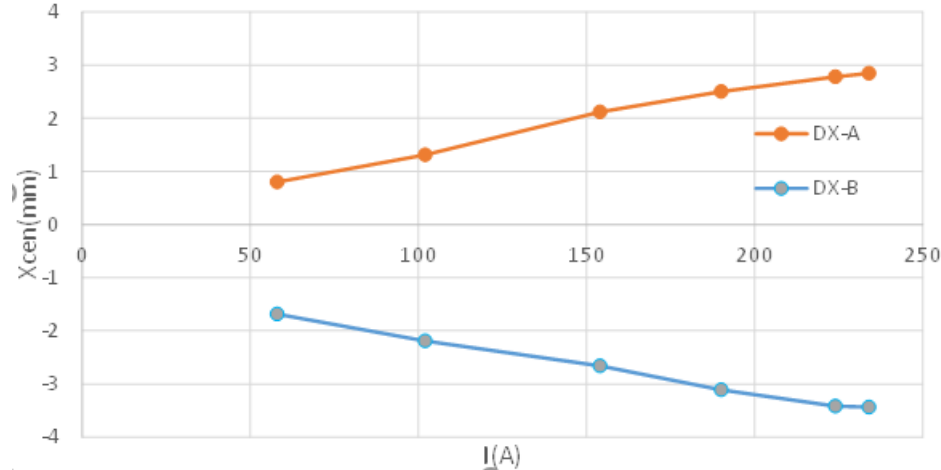
E(GeV)	I(A)	GL(T)-A	GL(T)-B	GL_A/GL_B-1
45	57.99	-3.36	3.35	0.40%
80	101.99	-5.91	5.88	0.59%
120	153.98	-8.89	8.85	0.49%
148	189.98	-10.93	10.89	0.40%
175	223.99	-12.77	12.73	0.30%
182.5	233.99	-13.27	13.21	0.40%



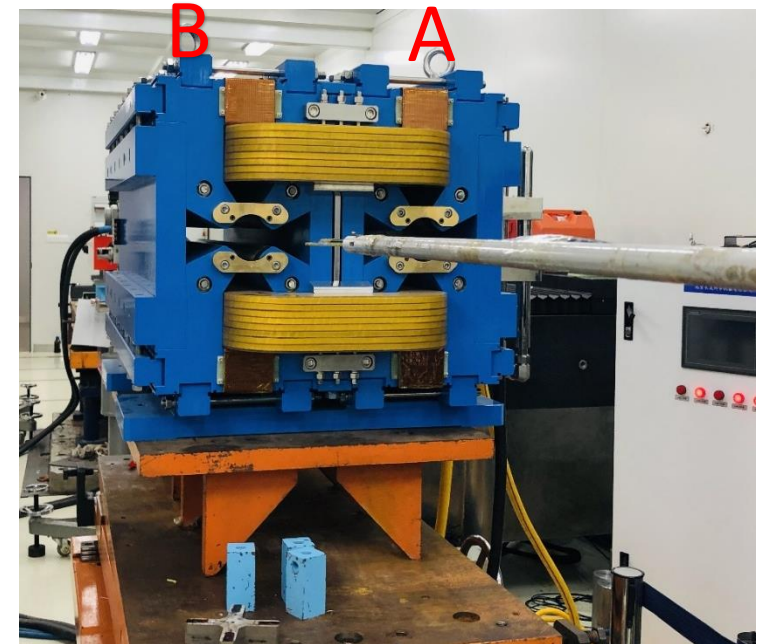
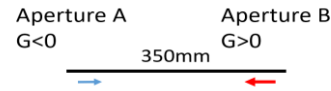
DAQ parameters and first prototype

■ Problems with the first design

- One DT4 sheet only can only work at one situation.
- The DAQ magnet should work at four different energy cases and with trim coils.
- The harmonics of b1 and b3 vary large at different field levels and with trim coils.



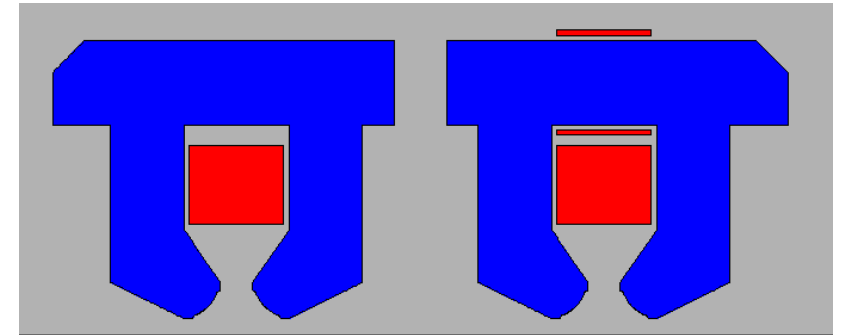
X0 shift with energy



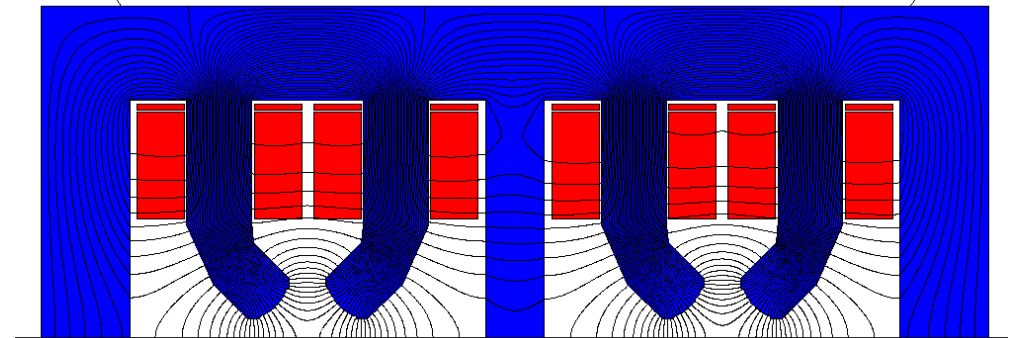
Prototype on the hall measurement bench

Alternative design schemes

- Two separate irons with common coils
 - Mechanical depart;
 - No X center shift with energy shift
 - Large and constant b_1 and b_3 , and can compensate by iron shim;
 - Trim coils on the yoke, far away from the midplane.
- Parallel iron with 8 main coils
 - Large power supply
 - Nearly no cross talk effect between two apertures.



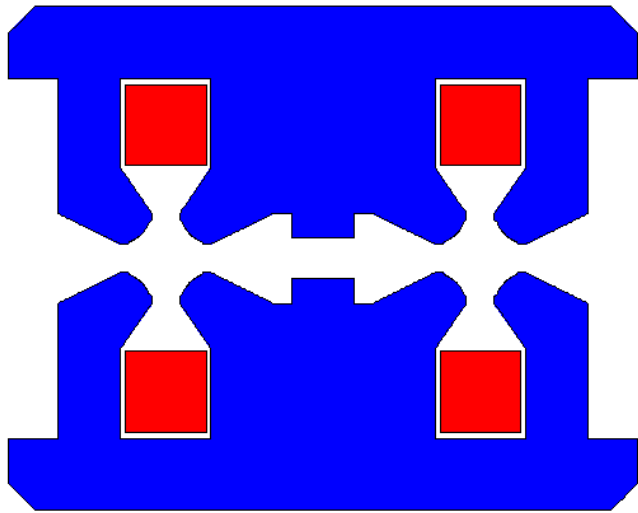
Separate irons, no DT4 compensation sheet
2020 CEPC DAY



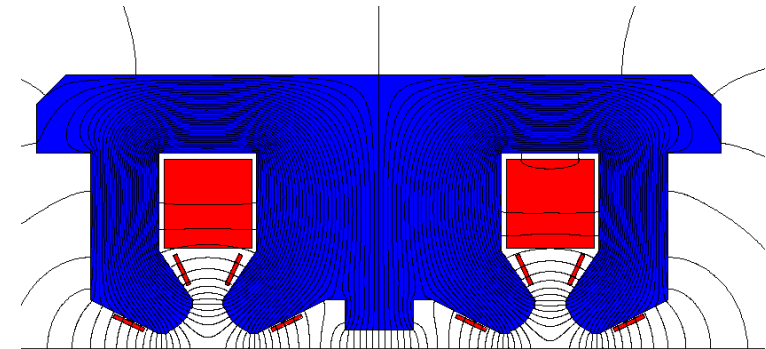
8 main coils, F/F design
2021 IAS

Optimization of the design

- With center shim, make the flux distribution symmetrical in a single aperture.
 - @120GeV: b1 and b3 reduced a lot.
 - No obvious shift at different energies.
 - Trim coils on the poles.
 - Strong cross talk between the two apertures.



E=120GeV	origin		center shim	
n	Bn/B2-L	Bn/B2-R	Bn/B2-L	Bn/B2-R
1	1557.30	-1557.27	-13.51	13.53
2	10000	10000	10000	10000
3	126.14	-126.18	-1.11	1.06
4	0.52	0.52	0.51	0.53
5	1.70	-1.71	-0.02	0.01
6	-0.04	-0.03	-0.04	-0.03
B1(T)	-0.01622	-0.0162197	0.00014	0.00014
B2(T)	-0.1041546	0.1041547	-0.10411	0.10411
B3(T)	-1.31E-03	-0.0013143	0.00001	0.00001
G(T/m)	-8.537	8.537	-8.534	8.534
S(T/m2)	-17.654	-17.660	0.155	0.149

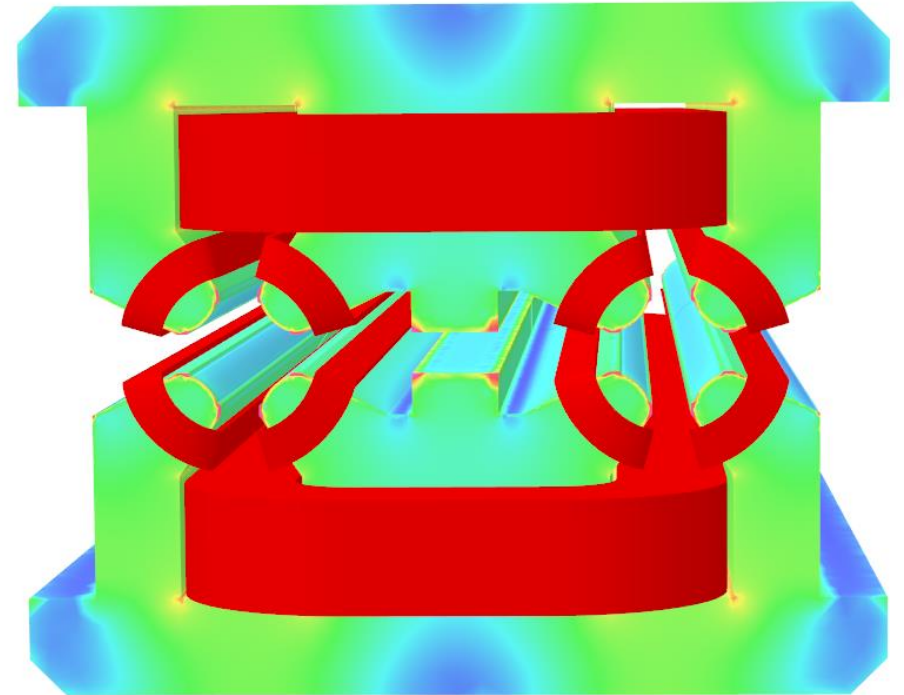


Optimization of the design

■ With trim coils in 3D simulation

➤ Little b_1 & b_3 variations in the energy range

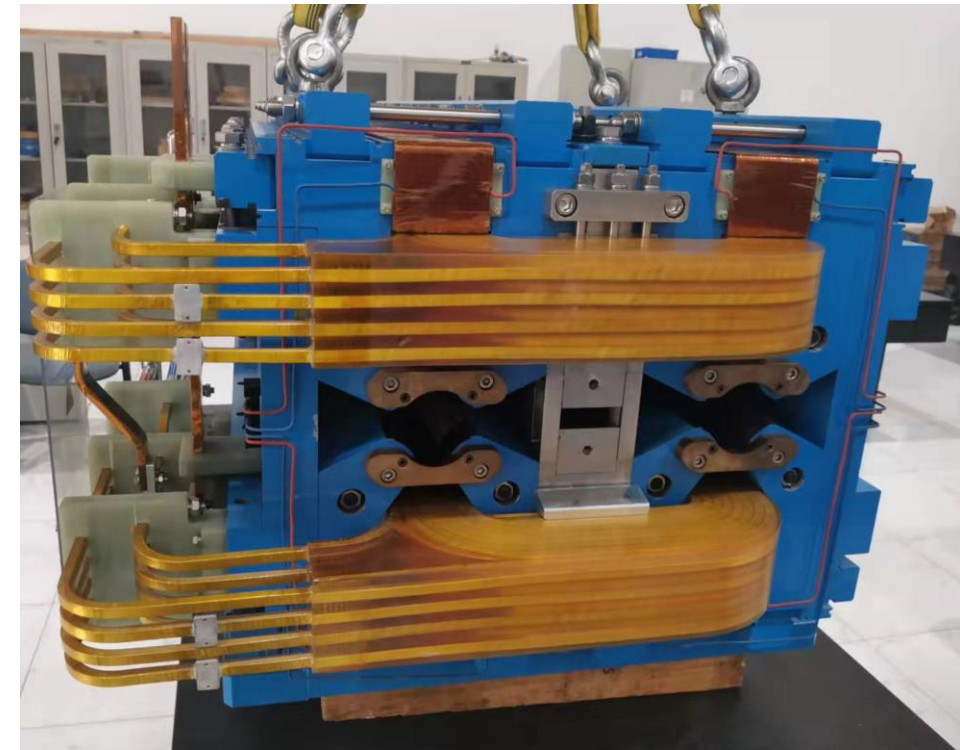
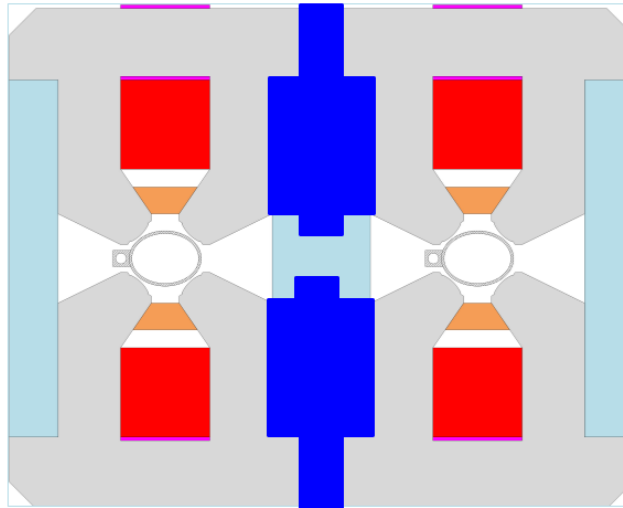
Trimcoil	45GeV		120GeV		182.5GeV		change
	AP_L	AP_R	AP_L	AP_R	AP_L	AP_R	
G(T/m)	-3.18	3.28	-8.39	8.64	-12.68	13.05	
b_3	9.63	-9.53	9.64	-9.72	10.52	-11.58	-2.05
b_4	0.53	0.41	0.54	0.42	0.56	0.43	
b_5	0.11	-0.12	0.11	-0.12	0.12	-0.14	
b_6	-0.34	-0.31	-0.35	-0.31	-0.36	-0.33	
$x_0(\text{mm})$	0.2937	-0.2834	0.2936	-0.2807	0.2841	-0.2560	0.0274
Beam sep		-0.5770		-0.5743		-0.5401	0.0369



DAQ simulation shows that the F/D scheme can meet the requirement.

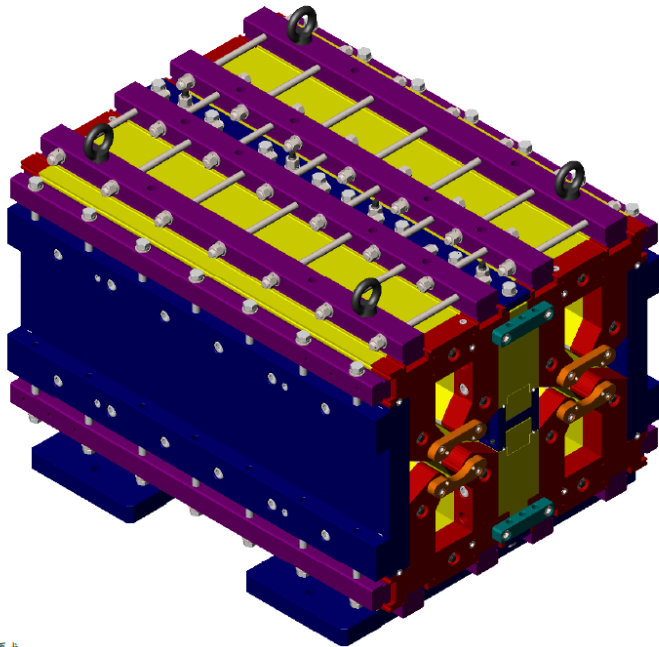
Modified DAQ-1m prototype

- 1m long prototype modification
 - DT4 iron in the middle instead the sheet and stainless steel.

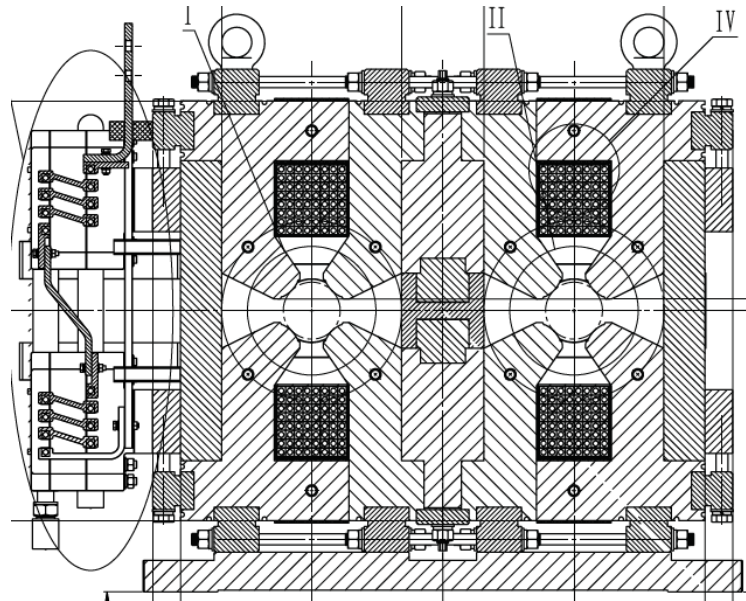


Prototype modification and field measurement results

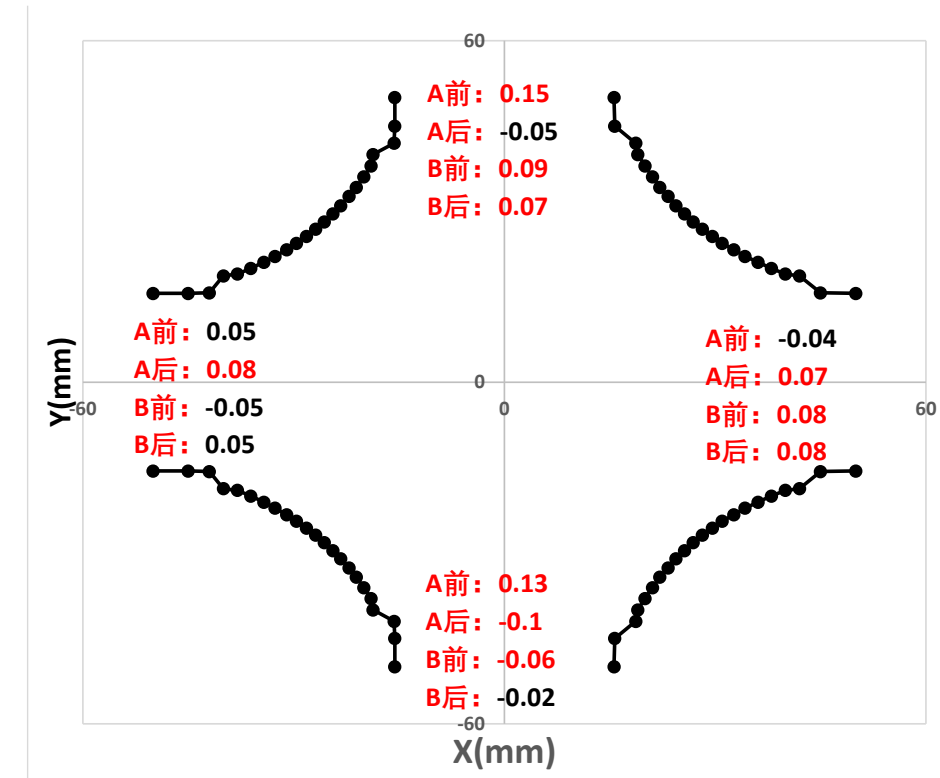
- Magnet assembly errors (tolerance: $\pm 0.05\text{mm}$)
 - Complex structure: laminated, with trim coils and shared main coils
 - Large magnet blocks, long iron length, slender poles.
 - The final assembly is out of tolerance.



Iron model



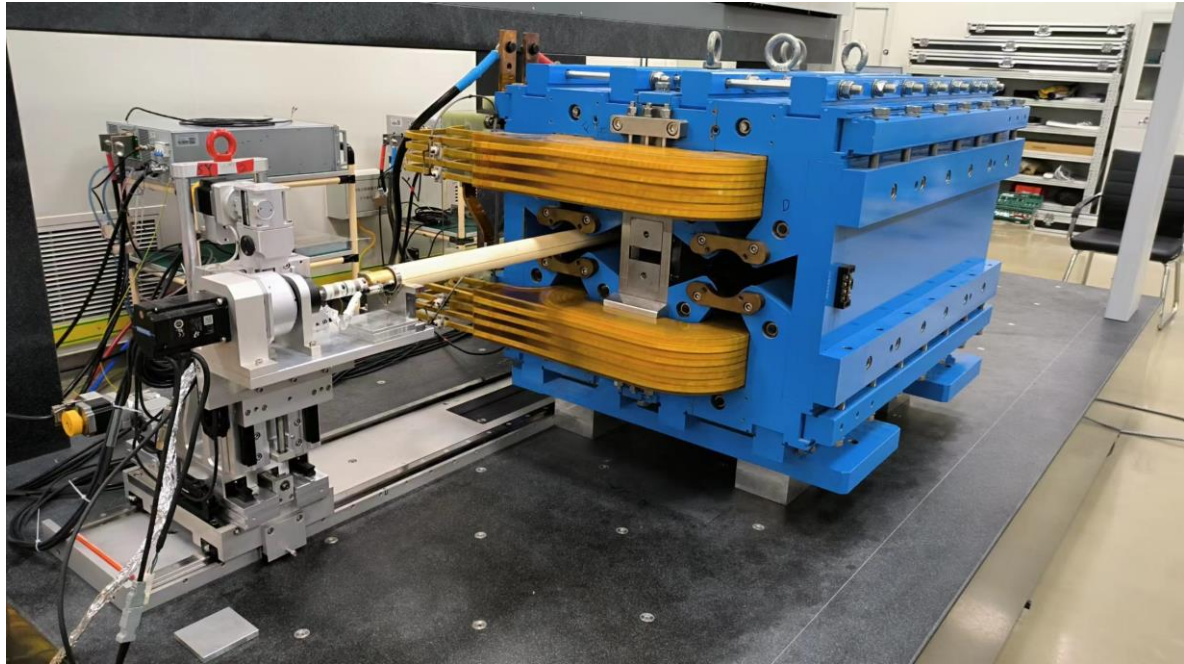
Cross section of DAQ



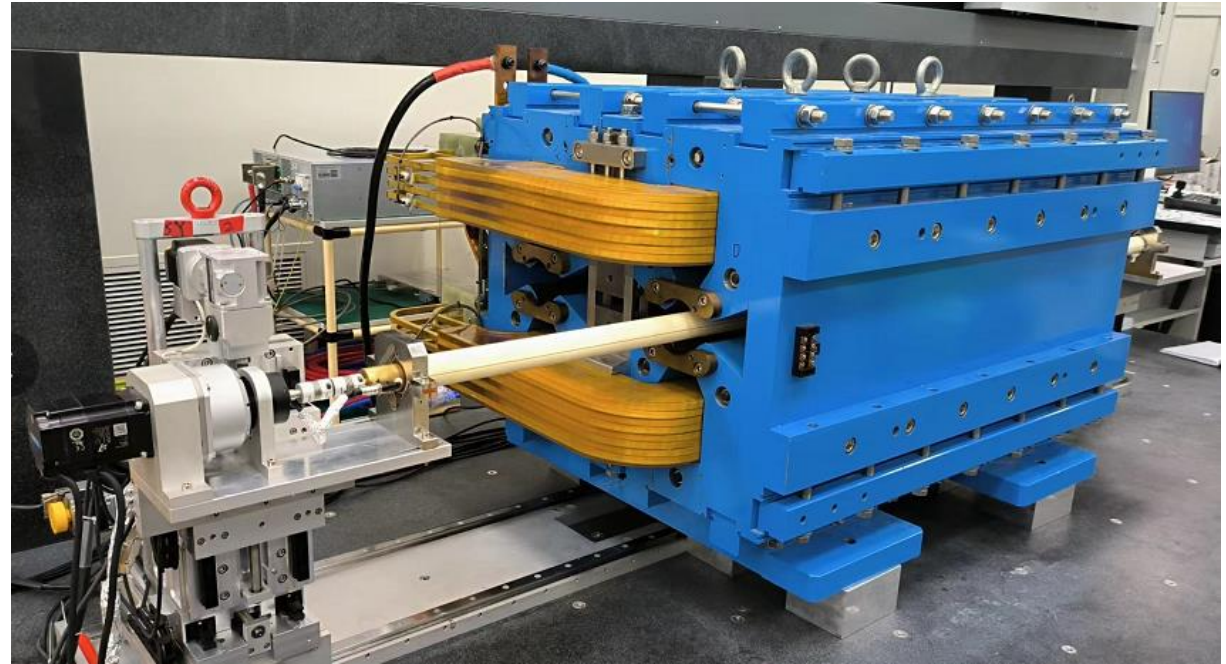
Gap between poles

Prototype modification and field measurement results

- Field measurements with rotating coil measurement system
 - Aperture A: F polarity
 - Aperture B: D polarity



Aperture A



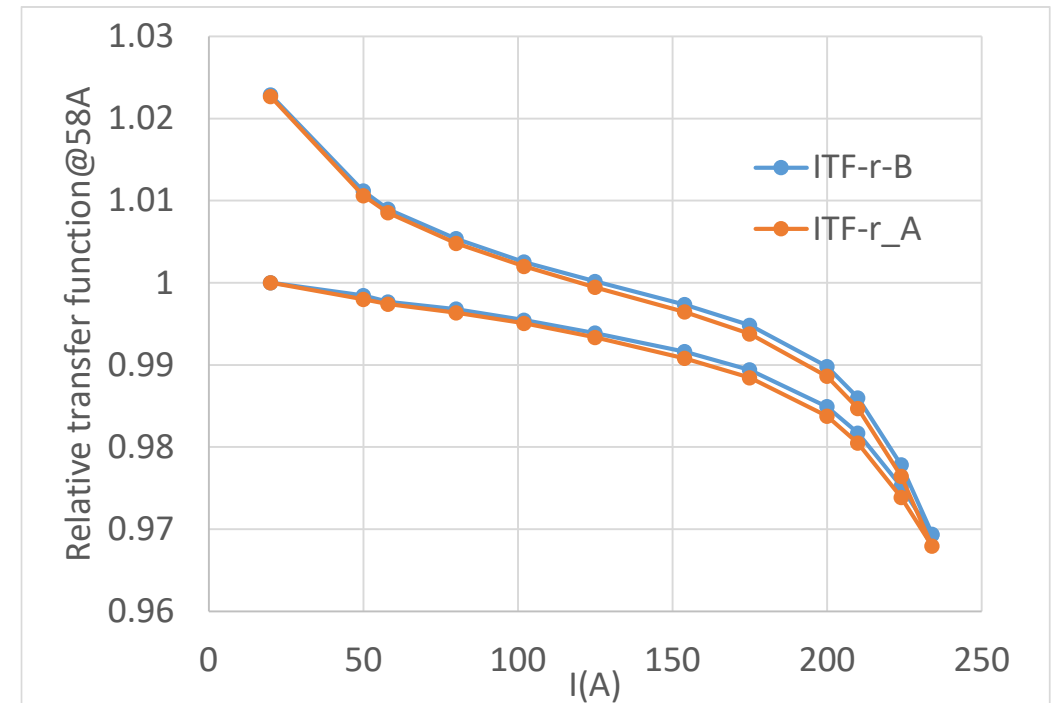
Aperture B

Prototype modification and field measurement results

■ RCS results—Integral transfer function

- GL difference in two apertures : <0.2%
- Similar transfer function in two apertures.
- The efficiency is about 97.8%, not saturated.

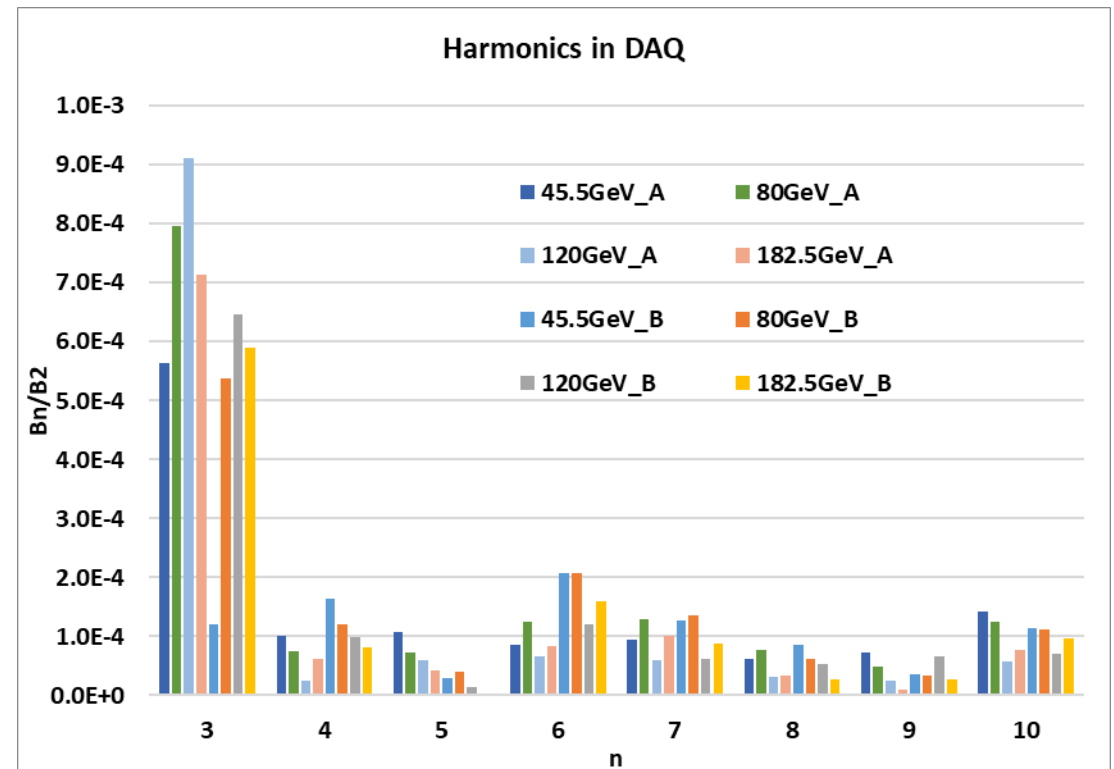
E(GeV)	Ireal(A)	PHI2_A	PHI2_B	BL_A/BL_B-1
45.5	57.99286	0.02407	0.024025	0.19%
80	101.9951	0.042234	0.042161	0.17%
120	153.9915	0.063491	0.063409	0.13%
182.5	233.9919	0.094249	0.094182	0.07%



Prototype modification and field measurement results

■ Harmonics:

- Higher harmonics: less than 3 units, except sextupole component.
- Possible reasons:
 - Large mechanical assemble errors;
 - Iron deformation;
 - Cross talk effect is not compensated completely.
- Possible solutions:
 - Adjust the compensate blocks.
 - Magic finger to adjust the field.

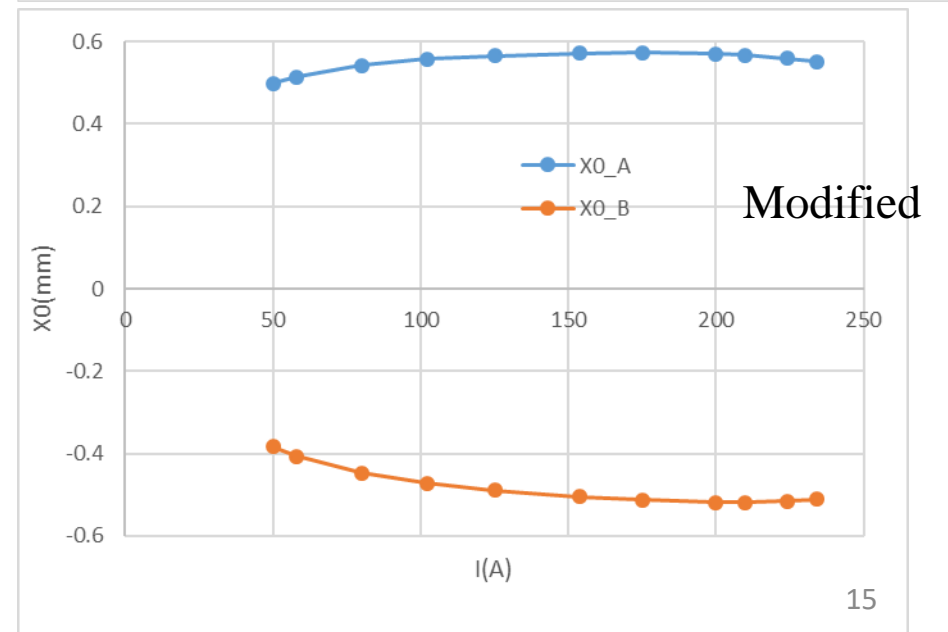
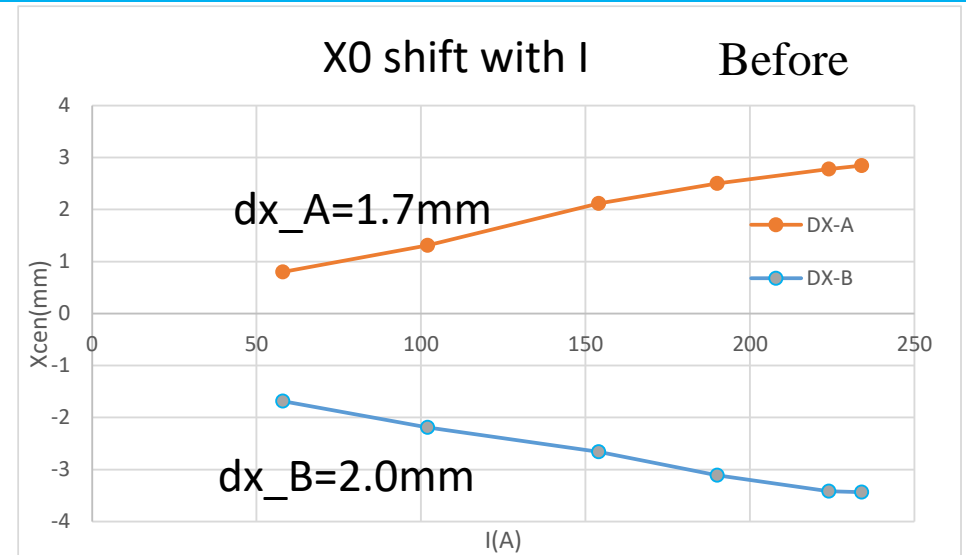


Prototype modification and field measurement results

■ Shift of magnetic center with energy

- X0_A varies 0.056mm, X0_B varies 0.105mm
- Possible reason: incomplete compensation; iron properties different.
- Y0_A varies 0.04mm
- Possible reason: Busbars' location.

E(GeV)	Ireal(A)	X0_A(mm)	Y0_A(mm)	X0_B(mm)	Y0_B(mm)
45.5	57.99286	0.514	0.174	-0.406	-0.078
80	101.9951	0.557	0.166	-0.472	-0.074
120	153.9915	0.571	0.157	-0.505	-0.069
182.5	233.9919	0.551	0.133	-0.511	-0.072
	max-min	0.056	0.040	0.105	0.009



Summary

- First prototype is a laminated one and composed by many blocks, whose strength and stiffness is weak. The design will be reviewed later, especially the mechanical design.
- After iron modification with center shim, X_0 shifts is reduced by an order, which is agreed with the simulation results.
- New trim coils will add on the poles to taper the gradient in the two apertures.
- Further modification
 - Adjust the gap height of the center shim, to compensate the cross talk effect.
 - Add trim coils or use the correctors to adjust the x_0 shift at different energies.



Thank you very much!