Dear Andrea,

1) What about the cleaning process of the bakelite when you receive
them? How is done and with which chemical products?
We clean whole surface using IPA by hand.

2) the glue drying is done in normal air or at specific conditions?
During gluing, gaps remains with all gas pipes open but with no air flushing. Temperature in the lab is maintained with in 20 ~ 23 C.

Cheers, Kyongsei
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From: Andrea Gelmi
Sent: 11 January 2019 18:06
To: Kyong Sei Lee; kslee@kodel.korea.ac.kr
Cc: Nikolaos Zaganidis; Ian Crotty; kakakaminho@korea.ac.kr; Youngmin Jo
Subject: Re: gaps production

Dear Kyong Sei,

Thanks a lot for the very useful informations.

1) What about the cleaning process of the bakelite when you receive
them? How is done and with which chemical products?

2) the glue drying is done in normal air or at specific conditions?

thanks, cheers

andrea

Il 11/01/19 16:32, Kyong Sei Lee ha scritto:
> Dear Andrea,
>
> 1) The gaps oiling configuration is the one represented in a schematic way attached?
> Exactly yes.
>
> 2) How do you check when the gaps if full of oil?
> The oil level seen in the top oil line and also the height of the oil tank.
>
> 3) Do you apply any filters to re-use th oil coming out after the oiling?
> Yes. The filter is attached in the bottom of the oil distributer box. The filter module unit is cleaned regularly.
>
> 4) How long it takes the oiling process?
> 3 hours for oil and 4 days for drying (rel H = 35% @ T=30 C)
>
> 5) How long it pass between oiling and drying?
> The procedure for the previous RE4 is
> - 3 hour oiling (up and down)
> - waiting a hour for draining
> - 96 hours drying
>
> The drying was done right after oiling. for RE4. But, the new process with double-coating will become more complicated.
> - Air circulation for 1 hours to air-flushing (~ 100 liter/h) epoxy out gas
> - 3 hour oiling (up and down)
> - waiting a hours for draining
> - 12 hours air drying
> - 3 hour oiling (up and down)
> - waiting a hours for draining
> - 96 hours drying
>
> 6) oiling and drying is done in parallel for the gaps that you produce at the same time?
> Yes they should be
>
> 7) what is the spacers material?
> Polycarbonate
>
> 8) how long do you wait between the spacers glueing and the oiling procedure?
> One or two days for the last glued gaps. But anyway we are going to do one-hour air-flushing to remove epoxy outgas before oiling.
>
> 9) did you applied the same procedure for the old endcaps prodcutions (2005 and RE4) and for the iRPCs?
> Yes.
>
> Cheers, Kyongsei
> \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_
> From: Andrea Gelmi
> Sent: 11 January 2019 15:25
> To: Kyong Sei Lee; kslee@kodel.korea.ac.kr
> Cc: Nikolaos Zaganidis; Ian Crotty
> Subject: gaps production
>
> Dear Kyong Sei,
>
>
> We have some questions about gaps production details, which will be very
> useful for the chemical analysis:
>
>
> 1) The gaps oiling configuration is the one represented in a schematic
> way attached?
>
> 2) How do you check when the gaps if full of oil?
>
> 3) Do you apply any filters to re-use th oil coming out after the oiling?
>
> 4) How long it takes the oiling process?
>
> 5) How long it pass between oiling and drying?
>
> 6) oiling and drying is done in parallel for the gaps that you produce
> at the same time?
>
>
> 7) what is the spacers material?
>
> 8) how long do you wait between the spacers glueing and the oiling
> procedure?
>
>
> 9) did you applied the same procedure for the old endcaps prodcutions
> (2005 and RE4) and for the iRPCs?
>
>
> Sorry for the many questions. If you have any documentation would be
> very useful as well.
>
> Thanks a lot,
>
> cheers, andrea
>
>
>
>
>