

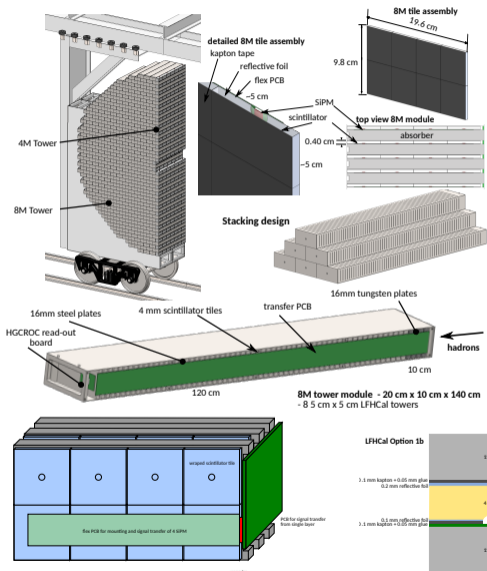
Longitudinally separated Forward HCal (LFHCal) Update

April 17, 2023

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LFHCal Buried SiPM design - New Default



- Same general design as LFHCal with SiPM on tile option and single wrapped tiles (5x5cm)
- Transfer of signals via small flex PCB to side of 8M module + long PCB to the end
- Signal summing of individual SiPMs at the end, same readout granularity at the end
- FEB boards removable similar, SiPMs not
- Simplified machining of absorber plates
- Upgrade option 1b+: Readout every SiPM by adding more HGCROCs & removing summing board, liquid cooling would be needed

Simulation progress:

- Integration in epic software is moving (PR's for eicrecon merged, dd4hep being discussed)
- Should be included in next simulation campaign with reasonable reconstruction & geometry

Mechanical design progress: (Elliott's presentation)

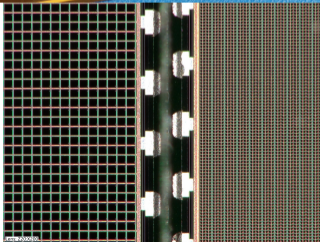
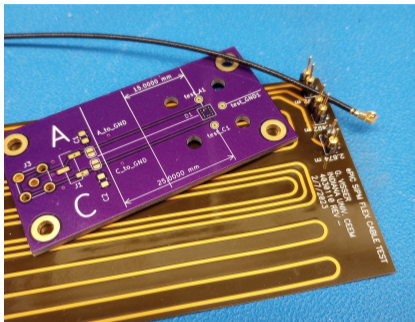
- 8M module design package (DRW) send to vendors for quotes on steel (incl. time estimates)
- 4M module design ready to also get quoted/ analyzed
- First stacking/deformation study
- First attempt at integrating the insert

Read-out & electronics design progress:

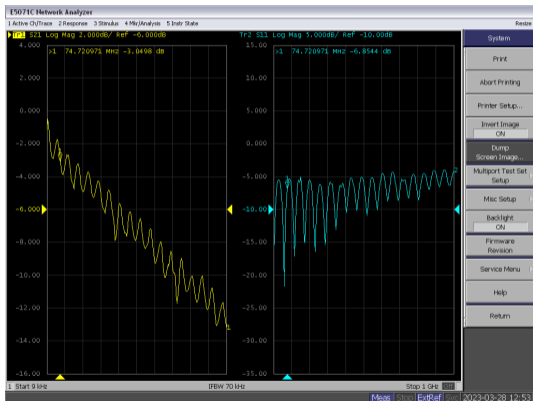
- First tests with flex PCB from Gerard
- Setting up read-out chain for HGCROC with version 3 prototype

Cost & Schedule:

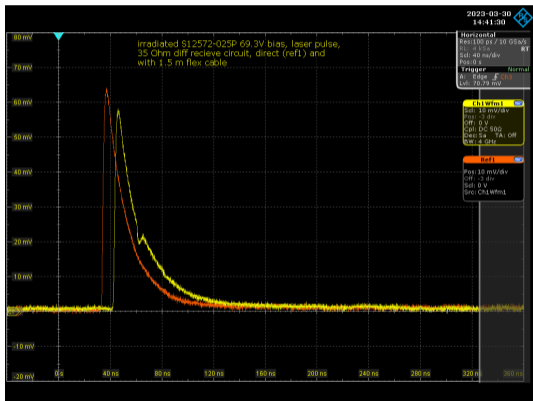
- Worked with Alex & Tyler on integrating updated and simplified costing and schedule into P6



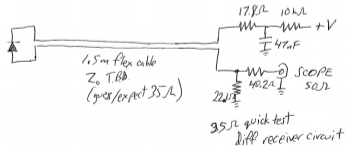
- Received first flex PCB prototype from Gerard (via BNL)
- Received 1.3mm diameter micro-coax samples from John Lajoie
- Received SiPM carrier PCBs
- Received CAEN DT5202 64ch CITIROC SiPM readout unit
- SiPMs at ORNL: Broadcom AFBR-S4K33 (15 μ m, 35 μ m, 47 μ m), AFBR-S4N33 (30 μ m)
 - ▶ Test PCBs produced and available



- Did a "quick and dirty" test with PCB on 2port VNA (not useful yet)
- Found a 4port VNA we are free to use eventually (will be very useful in the future)
- Received LFHCal eRD109 funds to produce more flex prototypes as needed
- Started looking into suitably thin connectors: Custom SAMTEC Z-Ray? Pogo pins?
- Can do full chain tests very soon with VNA, scope, CAEN, HGCROC...

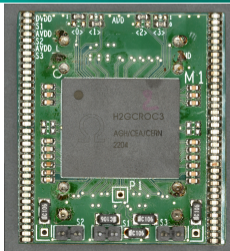


- Gerard has managed a full chain test
- Some reflection from impedance mismatch, but can be optimized, likely irrelevant in practice
- **The flex transfer works on a single channel!**
- More R&D needed for crosstalk, noise etc...



| | A | B | C | D | E | F |
|----|--------------|---------------|---------|----------|------------------------|---|
| 1 | Manufacturer | Type | Size | N pixels | Comment | |
| 2 | Hamamatsu | S13360-1325PE | 1.3x1.3 | 2668 | for SiPM-on-tile | |
| 3 | Hamamatsu | S14160-1315PS | 1.3x1.3 | 7284 | for SiPM-on-tile | |
| 4 | Hamamatsu | S13360-3025PE | 3.0x3.0 | 14400 | for fiber-based design | |
| 5 | Hamamatsu | S14160-1315PS | 3.0x3.0 | 39960 | for fiber-based design | |
| 6 | | | | | | |
| 7 | OnSemi | MicroC 10010 | 1.0x1.0 | 2880 | for SiPM-on-tile | |
| 8 | OnSemi | MicroC 30020 | 3.0x3.0 | 10998 | for fiber-based design | |
| 9 | OnSemi | MicroJ 30020 | 3.0x3.0 | 14410 | for fiber-based design | |
| 10 | | | | | | |

- Identified potential sensors for SiPM-on-tile option
- Project plans to request samples on behalf of EIC?



In ORNL we have now:

- 5 Carrier boards
- 2 working mezzanine boards with H2GCROC3
- KCU105 board from Xilinx (Ultrascale)
- I2C communication already tested and works

Plan for this week(s):

- Setup the PC with for the readout
- Firmware/software from the Omega group
 - ▶ With custom firmware we have an issue with the PLL lock so far
- Start testing the different signals/capabilities
- Update powering/ signal cable needs for costing

Mechanical:

- Do we have the force map for the expected magnetic forces on the LFHCal?
- Could we get the latest STL files of the beam pipe & pECal?

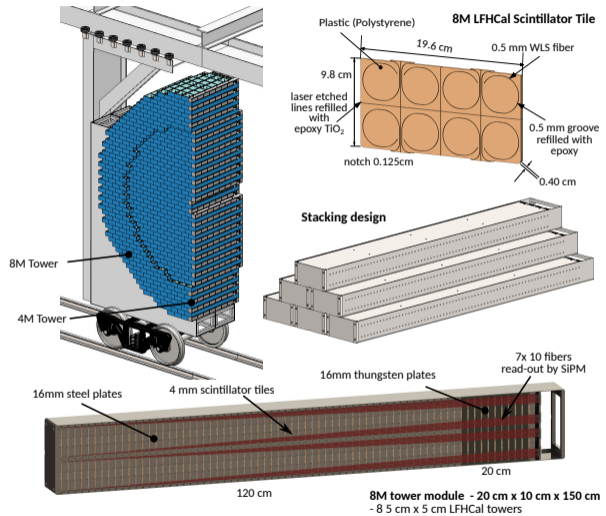
Finances:

- eRD109 - funding received for electronics
- eRD107 - account being setup up on ORNL side, PED still stuck on BNL side?
- Funding for injection molding FNAL on its way to being set up

Backup



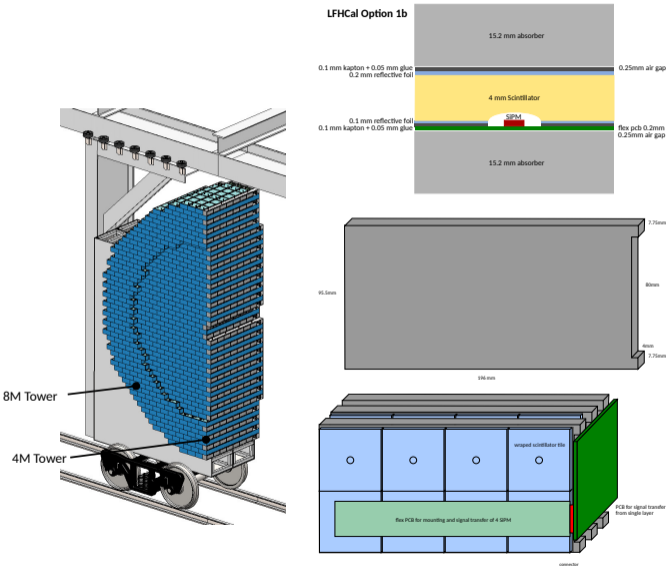
Option 1 (Default)



Concept:

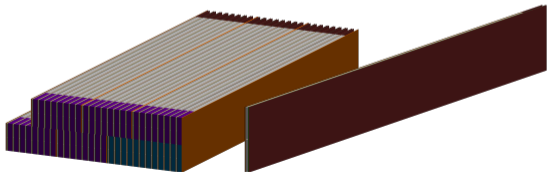
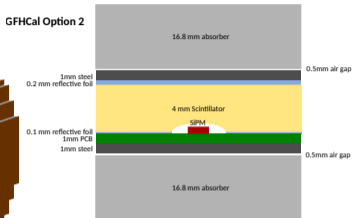
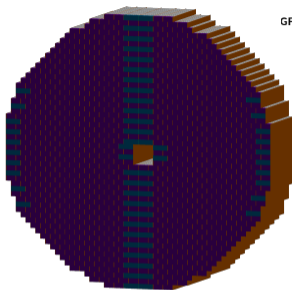
- PSD [link TDR] inspired inspired Fe/W-Scint calorimeter
4 layers of W (160 mm)-Sci plates (4mm) 61 layers of Steel (160 mm)-Sci plates (4mm) +
- Multiple towers combined in one module to reduce dead areas, increase granularity
- WLS fibers running into each tile, read out at the end
- Read-out:
 - ▶ 7 signals per tower (signals combined from 10 Sci-plates, 5 in tungsten section)
 - ▶ 63.3K channels read out
- Modules of different sizes (8M, 4M, 2M, 1M) to maximize coverage & assembly efficiency

Option 1b (Buried SiPM)



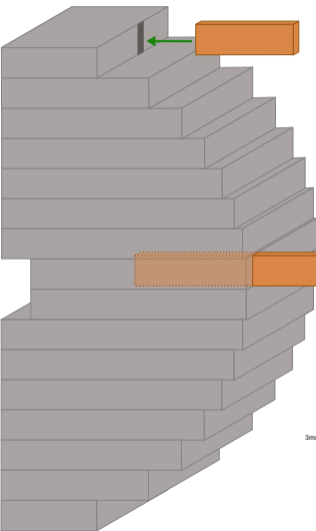
- Same general design as LFHCal option 1 replacing WLS fibers in each layer with SiPM on tile option and single wrapped tiles (5x5cm)
- Transfer of signals via small flex PCB to side of 8M module + long PCB to the end
- Signal summing of individual SiPMs at the end, same readout granularity at the end
- FEB boards removable similar to option 1, SiPMs not
- Simplified machining of absorber plates
- Upgrade option 1b+: Readout every SiPM by adding more HGCROCs & removing summing board, liquid cooling would be needed

Option 2 - GFHCaI



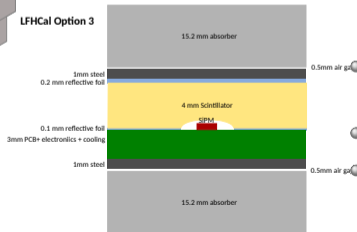
- Outer module dimensions + stacking stay largely the same replacing 4M with 12M modules
- Internal module design rotated by 90° absorber running in z direction
- Electronics + Scintillator tiles pulled out towards the back in cassettes
- SiPM on tile option with 5x5cm tiles
- Transfer of signals via long flex PCB to the end
- HGCROCs sitting in the back of HCal, cooling needed only in the back
- Signal summing of individual SiPMs at the end (2 tiles each) → increased granularity
- Simplified machining of absorber plates compared to option 1
- Upgrade option 2b+: Readout every SiPM by adding more HGCROCs & removing summing board, more liquid cooling would be needed

Option 3 - Full casset design



- Full redesign of everything
- Closest concept to HGCCal or CALICE AHCal SiPM on tile (5x5cm) & could incorporate insert with higher granularity
- Absorber structure of half detector (shell) + cradle build as a whole with slots on side for insertion of cassettes
- Cassettes ~ 30cm x 250cm in worst case (center) with all scintillators + readout electronics inside

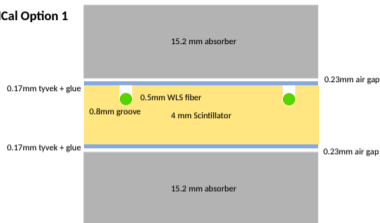
LFHCal Option 3



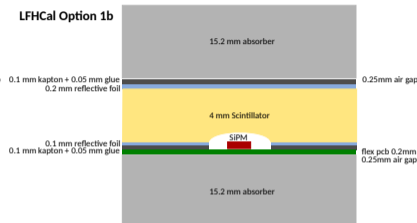
- HGCROCs would need to be integrated in layers
- Cooling absolutely necessary in layers
- Electronics + SiPM servicable no ganging trivially possible

Comparison layer thickness

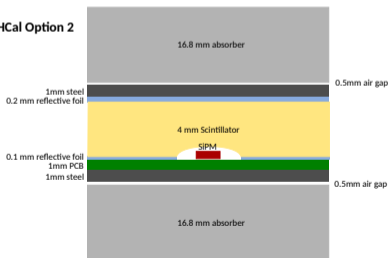
LFHCal Option 1



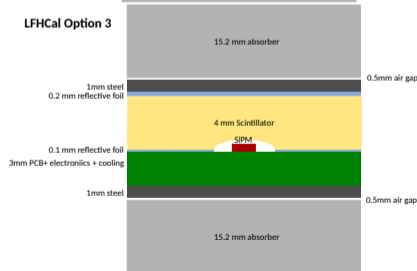
LFHCal Option 1b



GFHCal Option 2



LFHCal Option 3



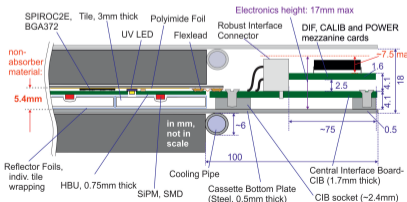
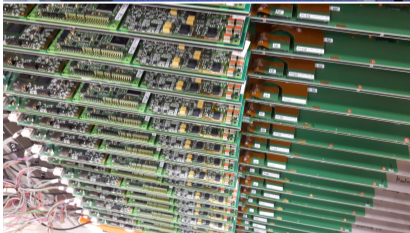
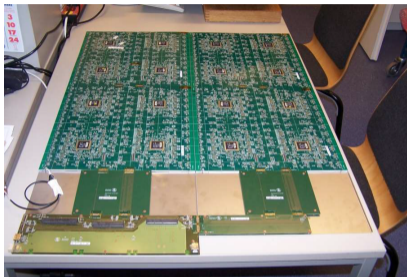
- Due to different needs, i.e. connections, cooling, readout out significant differences in sampling fraction
- Can't be fully adapted by changing layer thickness of steel/thungsten

Electronics comparison

| | Option 1 | Option 1b | Option 1b+ | Option 2 | Option 3 |
|--------------------|----------------------|----------------------------|----------------------------|----------------------------|----------------------------|
| Channel # | 63,280 | 63,280 | 601,160 | 253036 | 601,160 |
| SiPM \$ | 63,280; 3x3mm 506 | 601,160; 1.5x1.5mm 4210 | 601,160; 1.5x1.5mm 4210 | 506,072; 1.5x1.5mm 3550 | 601,160; 1.5x1.5mm 4210 |
| Summing board | No | Yes (10channel) | No | Yes (2channel) | No |
| # HGCROC (FEB) k\$ | ~1,100 22 | ~1,100 22 | ~10,450 210 | ~4,500 90 | ~10,450 210 |
| ECON-D (FEB) k\$ | | | 1,800 9 | 750 1.5 | 1,800 9 |
| FPGA (RDO) k\$ | 46 90 | 46 90 | 90 180 | 37 150 | 90 180 |
| PCB | 135 | 135 | 270 | 113 | 270 |
| Cooling | 0 | back | back | back/inner | inner |
| Cables, etc | ? | ? | ? | ? | ? |
| Total cost k\$ | 753 | 4457 | 4880 | 3829 | 4880 |

Main Questions option 1b & 2

- Can one drive & readout the SiPM over $> 1\text{m}$ using PCB or capton flex without applification?
- If not cooling might become necessary
- Do we wanna gang SiPMs
- Do we wanna go for injection molded tiles'?
- For option B, what does it to the physics?



CMS:

- In full cryo container, liquid Nitrogen
- No possibility to service HGCROCs or SiPMs ever

AHCal:

- Cassetts with fully integrated electronics ~ 6mm on inside, 3mm electronics
- Clearance around casset ~ 1 mm on both sides

Costing



Updated Cost Estimate - option 1

Example 8M module costs:

| Material procurement | Units | Unit Pricing |
|------------------------|-------|----------------|
| Absorber plates W | 4 | \$445 |
| Absorber plates Steel | 61 | \$60 |
| module support | 1 | \$320 |
| Scintillator plates | 65 | \$65 |
| tyvek + capton | 4.04 | \$0.4 |
| WLS fibers | 1360 | \$2 |
| 8M module cost: | 1091 | \$12770 |

| Assembly labor | hours | cost |
|---------------------------------|---------|-----------------|
| installing fiber mech. engineer | 17.5 h | \$2680.5 |
| tile wrapping PhD students | 7 h | \$140 |
| tower assembly mech. engineer | 0.083 h | \$12.8 |
| tower assembly PhD Student | 1.92 h | \$38.4 |
| tower assembly Undergrad | 11 h | \$220 |
| tower testing Postdoc | 1 h | \$71 |
| tower testing PhD Student | 4.5 | \$90 |
| 8M module cost: | 1091 | \$3252.7 |

| Electronics | Units | Unit Pricing |
|--------------------------------|-------|---------------|
| SiPMs | 56 | \$8 |
| SiPM mounting + summing boards | 1 | \$90 |
| HGCROC | 1 | \$20 |
| cable+HV/LV | 1 | ~\$822 |
| 8M module cost: | 1091 | \$1392 |

Additional costs:

- R&D cost: 393K
- Tooling: 200K
- Support Structure: 100K
- Installation: 382K
- FPGAs: 90K

Total costs:

- estimated for:
1091x8M module, 76x4M modules, 2x2M modules, 4x1M modules
- Module prices don't exactly scale as labor doesn't scale
- Cost adapted to most recent quotes for 8M steel, WLS, tungsten (not included before), scintillator with realistic design
- Labor hasn't been modified
- **total unescalated cost: \$20.7M**

Updated Cost Estimate - option 1b

Example 8M module costs:

| Material procurement | Units | Unit Pricing |
|------------------------------|-------|----------------|
| Absorber plates W | 4 | \$364 |
| Absorber plates Steel | 61 | \$45 |
| module support | 1 | \$320 |
| Scintillator tiles (wrapped) | 520 | \$7 |
| reflective wrap | 4.04 | \$50 |
| flexcables | 130 | \$2 |
| SiPMs | 520 | \$7 |
| 8M module cost: | 1091 | \$12003 |

| Assembly labor | hours | cost |
|-------------------------------|---------|----------------|
| tower assembly mech. engineer | 0.083 h | \$12.8 |
| tower assembly PhD Student | 2 h | \$40 |
| tower testing Postdoc | 1 h | \$71 |
| tower testing PhD Student | 4.5 | \$90 |
| 8M module cost: | 1091 | \$213.8 |

| Electronics | Units | Unit Pricing |
|------------------------|-------|---------------|
| FEB + summing boards | 1 | \$20 |
| HGCROC | 1 | \$20 |
| cable+HV/LV | 1 | ~\$822 |
| 8M module cost: | 1091 | \$1392 |

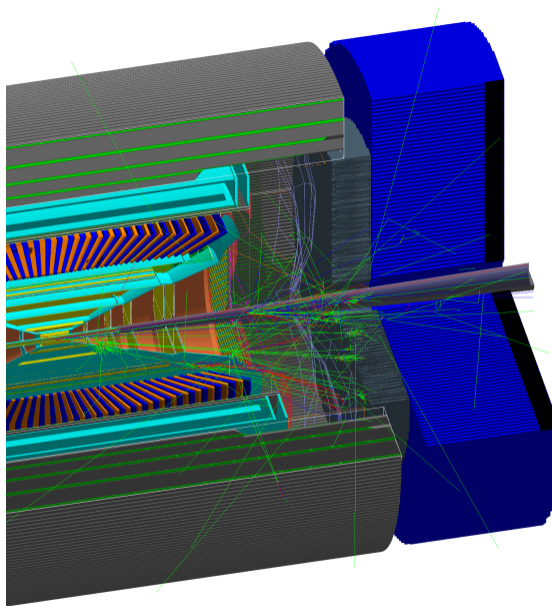
Additional costs:

- R&D cost: 393K
- Tooling: 200K
- Support Structure: 100K
- Installation: 382K
- FPGAs: 90K
- Robotic assembly: 460K

Total costs:

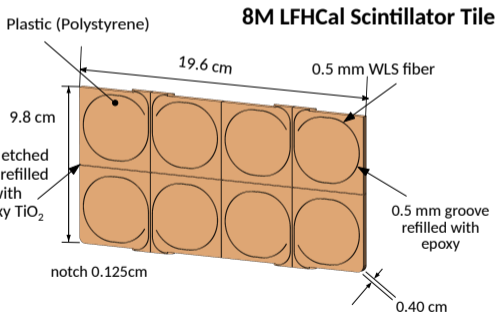
- estimated for same as std. option 1
- Assumed cost for absorber in option 1, 0.5 machining, scaled to 0.25
- not costed: long PCB on side, connectors layers & high density, testing of electric components and SiPMs, LEDs for each tiles
- **total unescalated cost: \$16.8M**

Thanks!

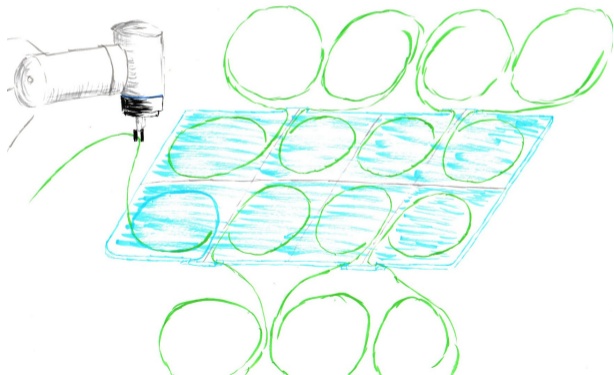
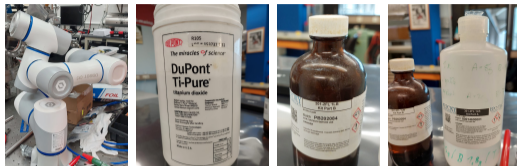


Current 8M Scintillator Plate Design

- Most scintillator plates produced as 1 unit of 100x200mm plates (8 single tower tiles)
- Separation of tiles edged into the plate (95%) through, refilled with Epoxy-TiO₂ mix
- Wrapped in Tyvek paper and Kapton tape or painted with TiO₂ rich paint

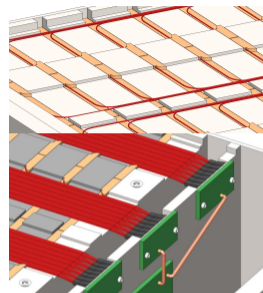
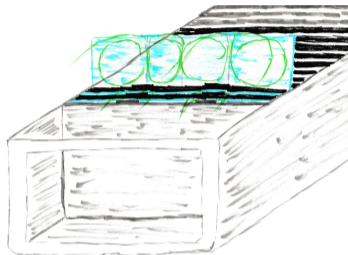
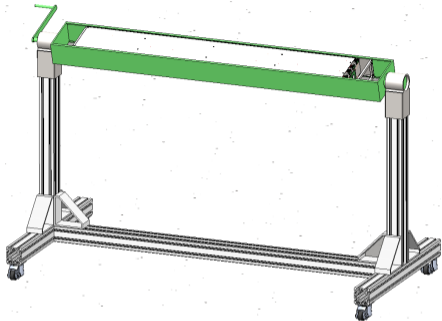


- Fiber thickness chosen for minimal light loss while bending (0.5mm)
→ other geometries for embedding under consideration (i.e. 1/4 circle)
- Originally costed from Uniplast as 1 unit of assembly + material
- Updated estimate including (material, fiber installation by engineer, wrapping by students, tooling)
→ new estimate driving by labor for fiber installation
- Exploring possible robot supported options for tile assembly

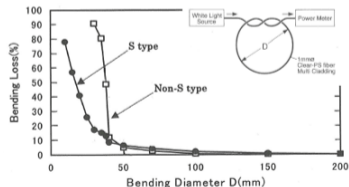


- ① Refilling of gaps with TiO_2 -Epoxy mix using collaborative robot
- ② Measuring fiber quality & cutting to desired length
- ③ Laying WLS-fibers in groove, fixating them using a few glue dots
- ④ Roll WLS-fibers up on try with tile
- ⑤ Might need additional coating with white paint
- ⑥ Stack trays & transport to 8M assembly site

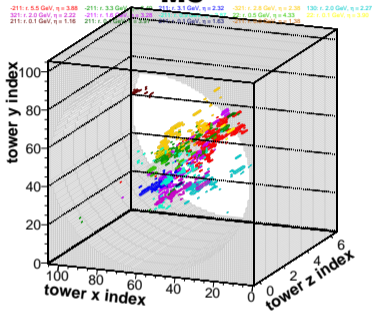
8M assembly detail



- a) Mount assembled steel/tungsten frame in pivot
- b) Slot scintillator tiles in frame from back to front
Fibers for bottom side slotted through, caught by tray on bottom
- c) After 10 tiles sort fibers 5/5 & place plastic strip as separator, tape on top
- d) Continue till top side finished & cut length of fibers to fit readout
- e) install cover plate
- f) Flip module in pivot, remove tray
- g) Sort fibers & assemble as on top

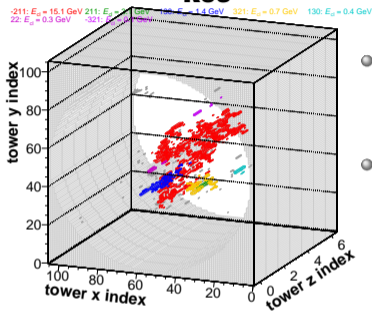


MC



LFHCal, Event 30
e-p: 18x 275 GeV, $Q^2 > 100$ GeV

Rec

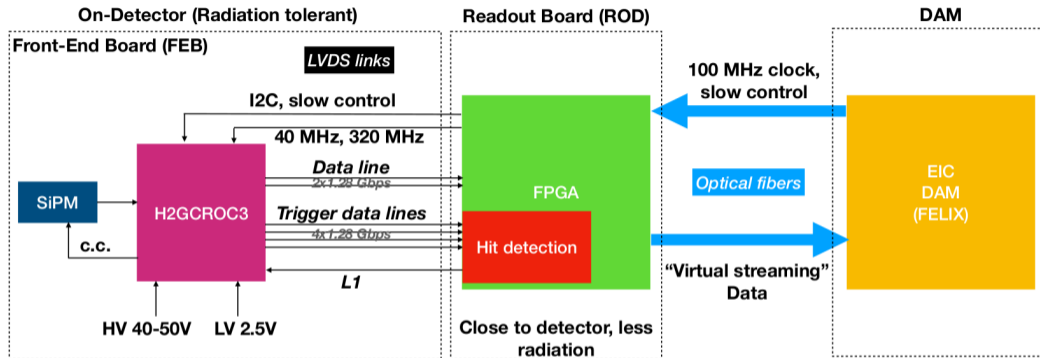


LFHCal, Event 30
e-p: 18x 275 GeV, $Q^2 > 100$ GeV

- High granularity needed to try to distinguish shower maxima close to beam pipe
- **HCal:**
read out in 7 layers longitudinally
desirable min measurable tower energy 3-5 MeV, max 20-30 GeV in single tower segment

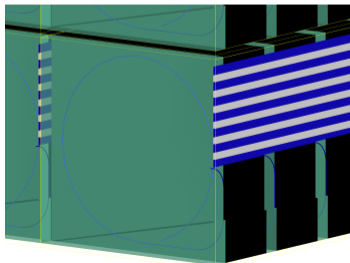
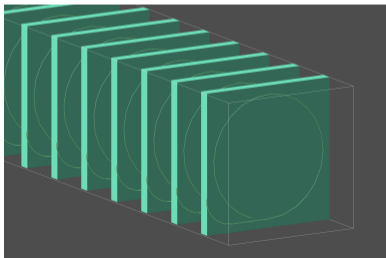
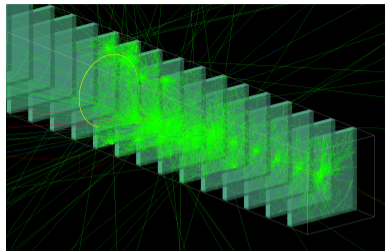
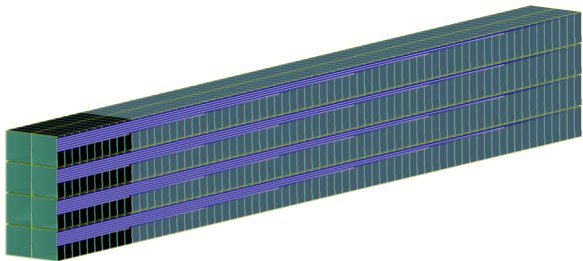
- LFHCal 1 SiPM per 10 fibers (7 per tower) -i.e Hamamatsu S13360-3025PE (14.4K pixels)
- HCal readout at end of module (max. 10cm)
- Small light collection prisms might be needed in front of SiPM
- Idea use each 1 H2GCROC3 (up to 70 channels) for readout of HCal (ideally common chip/board design with WSciFi-ECal & ALICE FoCal-H)

Current Read-out Concept



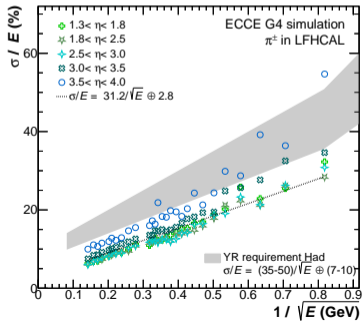
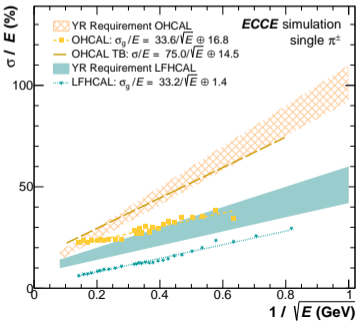
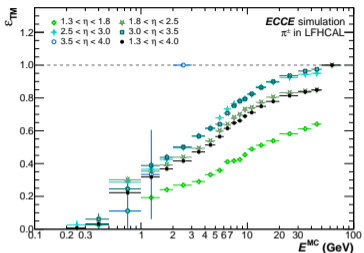
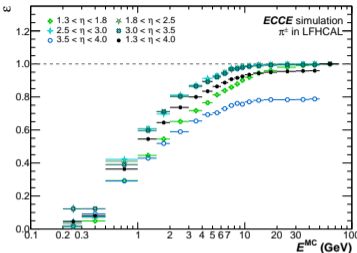
- The H2GCROC3 requires the L1 trigger for readout, with the maximum speed of 960 kHz
- The expected hit rate in one channel of LFHCal is up to 50 kHz:
 - ▶ With possible 4 sample readout we would reach a maximum of 200 kHz
 - ▶ "Virtual" streaming readout towards the EPIC DAQ system

GEANT Implementation Fun4All



- largely realistic implementation of geometry , refinements for module edges needed
- first light propagation studies, cross checks planned with test sub-tiles at ORNL (fiber routing)

LFHCAL Performance



- Cluster finding and track matching efficiencies good in center of LFHCAL, losses towards edges
- Performance overestimated with standard response implementation in GEANT4 (1.5x from other setups)
- Small η dependence for energy resolution
- Exploring possibility for high granularity insert with different composition & changing granularity of readout as function of R
- Studies to improve clusterization further using ML started

R&D activities & plans



1 Prototype tile production using machining & injection molding (04/23)

- ▶ Assembled prototype tiles using machined scintillator plates
- ▶ Assembled prototype tiles using injection molded scintillator tiles
- ▶ Documentation of procedures for manual assembly of tiles & WLS fibers

2 Reconstruction optimization (09/23)

- ▶ Write-up of optimization results from simulations

3 Sensor board development (07/23)

- ▶ First prototype of sensor board for Si-PM readout (together with eRD109)

4 Small test module assembly (07/23)

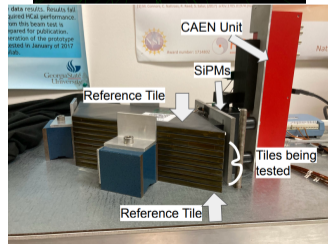
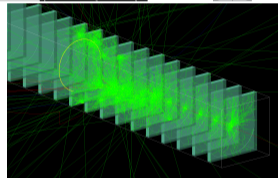
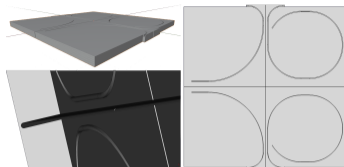
- ▶ First prototype of single segment of 8M module

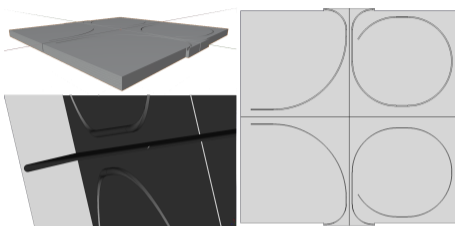
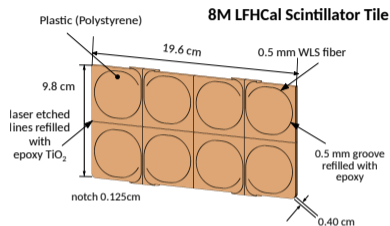
5 First automated scintillator tile assembly (08/23)

- ▶ Assembled prototype tiles
- ▶ Documentation and Evaluation of procedures for automated assembly of tiles & WLS fibers

6 Tile Characterization (08/23)

- ▶ Write-up of test bench & test beam measurement for all assembled tile-prototypes





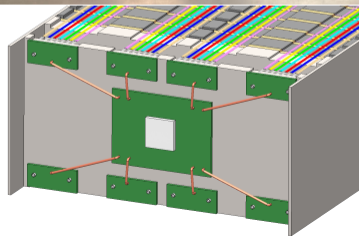
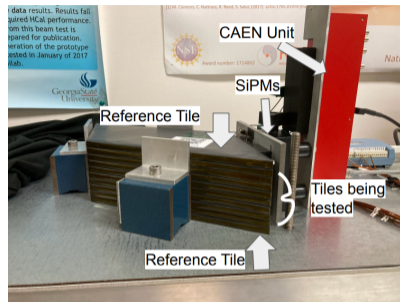
Prototype tile production using machining & injection molding

- Vendor replacement needed for Uniplast
 - a) Machining plastic scintillator plates (~ \$80/tile)
 - b) Injection molding tile (~ \$4 – 6/tile)
- Opportunity for significant cost reduction w/ injection molding
- Performance and mechanical stability tests needed in both cases

First automated scintillator tile assembly

- Tile assembly time & labor extensive w/ classical methods
- Exploring automated assembly using collaborative robots for:
 - ▶ Refilling sub-segmentation with TiO₂
 - ▶ Fiber laying and fixating in groves
 - ▶ Automatic measurements of WLS-fiber quality

- Characterization of assembled tiles according to:
 - ▶ Light yield
 - ▶ Cross-talk among different tiles
 - ▶ Response uniformity
 - ▶ Durability and mechanical stability
- Initial geometry optimization using TracePro simulations
- Usage of available test-stands at universities for tile characterization
- Possibility to test multiple scintillator materials/dopant concentration in particular for injection molding
- Development of a SiPM board and WLS fiber connector suitable for production module



- Successively-larger R&D prototype assembly
 - ① Scintillator tiles
 - ② Single segment of 8M module (20cm) including initial read-out design
 - ③ Full mechanical mock-up of 8M module
 - ④ Full 8M modules including initial read-out design
- Main measurements
 - ▶ Characterization of spatial distribution and uniformity of MIP response for different tile types
 - ▶ Saturation behavior of combined tile and SiPM readout system for single segment
 - ▶ Measuring the individual and combined response of tiles to EM-showers
 - ▶ Spatial and energy resolution of partial and full module LFHCAL module
 - ▶ Combined test-beam w/ pECal to characterize LFHCAL partial and full module response behind ECal
- Current Read-out electronics design based on CMS-SiPM-HGCROC (ASIC)
Final electronics R&D for EIC specific readout board within eRD109 based on same ASIC with possible small modifications

eRD107 Funding request

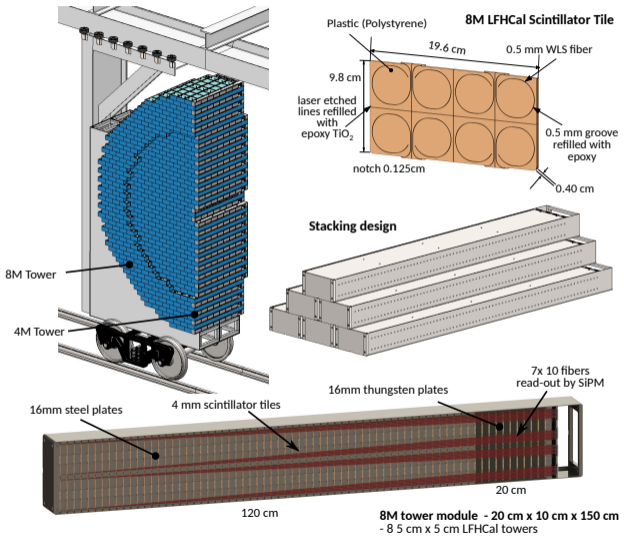
| activity | cost in FY23 k\$ | | | | | | | | | total cost in FY23 k\$ |
|------------------------|------------------|-------------|------------|------------|------------|------------|------------|------------|------------|---------------------------|
| | ORNL | FNAL | BNL | UTK | GSU | Yale | ISU | Valpo | UCR | |
| Machined Tiles | 11.7 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 11.7 |
| Injection Molded Tiles | 2.0 | 52.9 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 54.9 |
| Auto Tile Assembly | 20.0 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 20.0 |
| Tile Char. (Lab) | 16.0 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 16.0 |
| Sensor Board | 12.2 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 12.2 |
| LFHCAL Mechanics | 21.7 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 21.7 |
| Tile Char. (Beam) | 1.0 | 0 | 2.0 | 2.0 | 2.0 | 2.0 | 2.0 | 1.0 | 2.0 | 14.0 |
| Total | 84.6 | 52.9 | 2.0 | 2.0 | 2.0 | 2.0 | 2.0 | 1.0 | 2.0 | 150.5 |

| institute | cost in FY23 k\$ | | | | total cost in FY23 k\$ |
|--------------|------------------|-------------|-------------|-------------|---------------------------|
| | eng. and tech. | material | equipment | travel | |
| ORNL | 29.8 | 16.8 | 36.0 | 2.0 | 84.6 |
| FNAL | 52.9 | 0 | 0 | 0.0 | 52.9 |
| BNL | 0 | 0 | 0 | 2.0 | 2.0 |
| UTK | 0 | 0 | 0 | 2.0 | 2.0 |
| GSU | 0 | 0 | 0 | 2.0 | 2.0 |
| Yale | 0 | 0 | 0 | 2.0 | 2.0 |
| ISU | 0 | 0 | 0 | 2.0 | 2.0 |
| Valpo | 0 | 0 | 0 | 1.0 | 1.0 |
| UCR | 0 | 0 | 0 | 2.0 | 2.0 |
| Total | 82.7 | 16.8 | 36.0 | 15.0 | 150.5 |

- Largest fraction of funding for engineers and technicians
- Additional funds used for material, test equipment & travel for test beam campaigns
- Significant in-kind contribution from universities and laboratories for assembly, simulation and data analysis (~ 2140h)
- Parallel PED request for mechanical & electrical engineering support will be submitted to further final design of LFHCAL

| Task | Estimated cost in \$ per year | | |
|------------------------|-------------------------------|-------------|------------|
| | FY24 | FY25 | FY26 |
| mechanical engineering | 40K | 40K | 20K |
| electrical engineering | 30K | 30K | 20K |
| materials | 30K | 30K | 40K |
| test beam support | 10K | 10K | 10K |
| total | 110K | 110K | 90K |

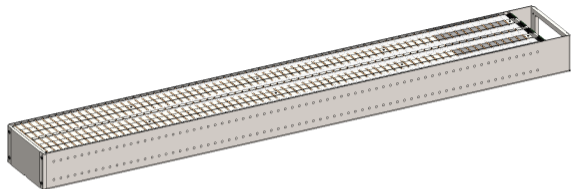
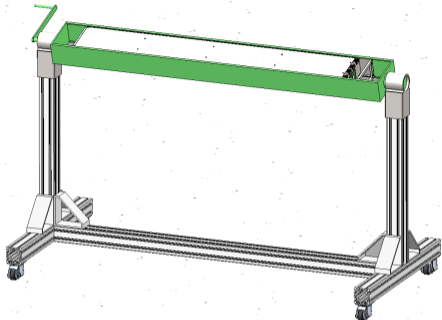
Calorimeter Details & PED request



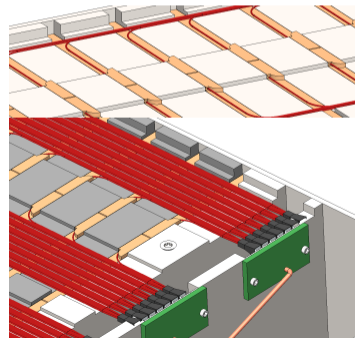
| parameter | LFHCal |
|-------------------------|-----------------------------|
| inner radius (envelope) | 17 cm |
| outer radius (envelope) | 270 cm |
| η acceptance | $1.2 < \eta < 3.5$ |
| tower information | |
| x, y ($R < / > 0.8$ m) | 5 cm |
| z (active depth) | 140 cm |
| z read-out | 10 cm |
| # scintillator plates | 70 (0.4 cm each) |
| # absorber sheets | 60 (1.6 cm steel) |
| weight | 10 (1.6 cm tungsten) |
| interaction lengths | ~ 30.6 kg |
| Molière radius R_M | $6.9 \lambda / \lambda_0$ |
| Sampling fraction f | 21.1 cm (π^\pm shower) |
| # towers (inner/outer) | 0.040 |
| # modules | 9040 |
| 8M | 1091 |
| 4M | 76 |
| 2M | 2 |
| 1M | 4 |
| # read-out channels | $7 \times 9,040 = 63,280$ |

| activity | cost in FY23 k\$ | | total cost in FY23 k\$ |
|---|------------------|-----------|------------------------|
| | ORNL | BNL | |
| Support structure design & integration with pECal | 75 | 0 | 75 |
| Rail/slide design | 0 | 50 | 50 |
| test production of module | 20 | 0 | 20 |
| tooling design + function test | 50 | 0 | 50 |
| Total | 145 | 50 | 195 |

8M assembly



- a) single tile assembly (fiber embedding, glueing, wrapping)
- b) tile testing
- c) assembly of module, alternating steel plate first kept in place by e-beam point welding then Scint-tile
- d) fiber channels layed out on front on back
- e) SiPM & read-out card installation
- f) tower testing
- g) close up module with cover plates

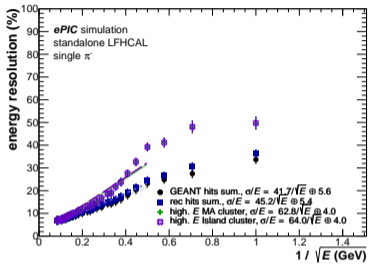
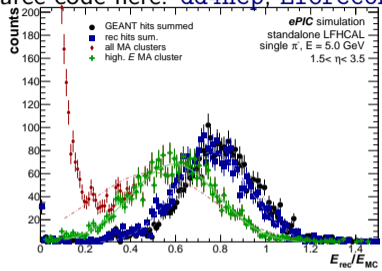
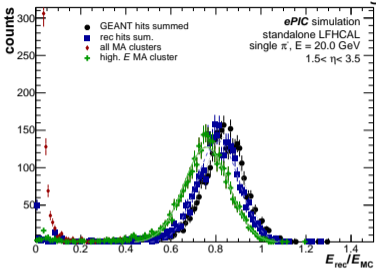


eRD107: Detailed cost table

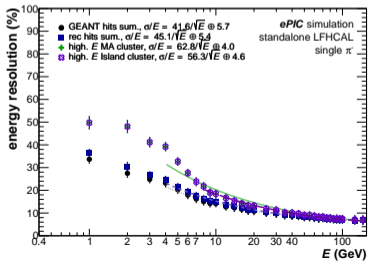
| Institute | Item | Cost per item in \$ | Number of items | Total cost in \$ | To be compl. by |
|---|--|---------------------|-----------------|------------------|-----------------|
| Machined Scintillator Tiles: | | | | | |
| ORNL | BC-408 plastic scintillator sheet | ~ 150 | 20 | 3K | Q1/2023 |
| ORNL | BCF-91A WLS fiber | 1500 | 1 | 1.5K | |
| ORNL | tile machining | 180/h | 40h | 7.2K | Q4/2022 |
| ORNL/UTK | tile assembly | | 40h | (in kind) 0K | Q4/2022 |
| Injection Molded Scintillator Tiles: | | | | | |
| FNAL | mold design + production | 50 000 | 1 | 50K | Q2/2023 |
| ORNL | travel | | | 2K | Q4/2022 |
| FNAL | raw material + dopant | | | (in kind) 0K | |
| FNAL | injection molder setup + operation | 180/h | 16h | 2.9K | Q1/2023 |
| ORNL/UTK | tile assembly | | 40h | (in kind) 0K | Q1/2023 |
| Automated Tile Assembly: | | | | | |
| ORNL | robotic arm | 20 000 | 1 | 20K | 2024 |
| ORNL | robot programming and evaluation | | 40h | (in kind) 0K | Q3/2023 |
| Tile Characterization (Lab Bench): | | | | | |
| ORNL/UTK | scintillator material characterization | | 20h | (in kind) 0K | Q3/2023 |
| ORNL | waveform sampling readout (8ch) | 16000 | 1 | 16K | Q2/2023 |
| GSU/Yale/UCR | tile lightyield testing | | 160h | (in kind) 0K | Q3/2023 |
| ISU/BNL | tile simulation | | 160h | (in kind) 0K | Q3/2023 |
| Sensor Board: | | | | | |
| ORNL | mechanical engineer | 180/h | 15h | 2.7K | Q1/2023 |
| ORNL | sensors: silicon photomultipliers | 30 | 300 | 9K | |
| ORNL | sensor board production, assembly | 50 | 10 | 0.5K | Q1/2023 |
| Reconstruction Optimization: | | | | | |
| UTK/Yale/BNL | simulations/digitization/reconstruction/analysis | | 640h | (in kind) 0K | 2025 |
| LFHCAL Mechanics: | | | | | |
| ORNL | mechanical engineer | 180/h | 105h | 18.9K | Q3/2023 |
| ORNL | absorber material + fasteners | 40 | 70 | 2.8K | |
| UTK/Yale | absorber machining | 100/h | 20h | (in kind) 0K | Q2/2023 |
| Tile Characterization (Test Beam): | | | | | |
| ORNL | assembly and shipping | | | 1K | |
| All | test beam travel | | | 13K | |
| ORNL/UTK | test beam preparation | | 80h | (in kind) 0K | Q2/2023 |
| ORNL | test beam | | 120h | (in kind) 0K | Q3/2023 |
| Yale | test beam | | 120h | (in kind) 0K | Q3/2023 |
| BNL | test beam | | 120h | (in kind) 0K | Q3/2023 |
| UTK | test beam | | 120h | (in kind) 0K | Q3/2023 |
| GSU | test beam | | 120h | (in kind) 0K | Q3/2023 |
| ISU | test beam | | 120h | (in kind) 0K | Q3/2023 |
| Valpo | test beam | | 120h | (in kind) 0K | Q3/2023 |
| UCR | test beam | | 120h | (in kind) 0K | Q3/2023 |
| Total | | | | 150.5K | |

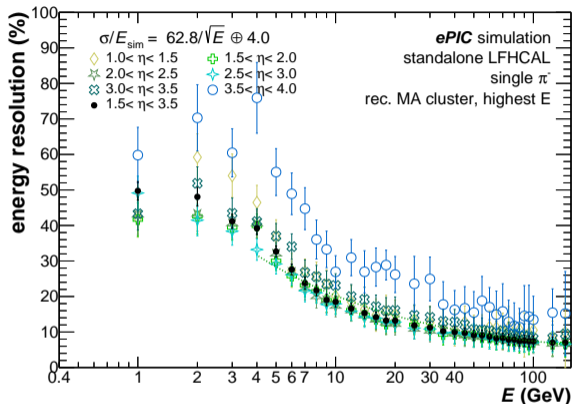
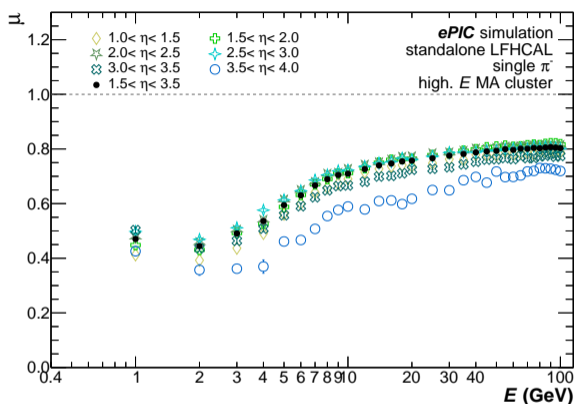
LFHCal simulations

source code here: [dd4hep](#), [EICrecon](#)



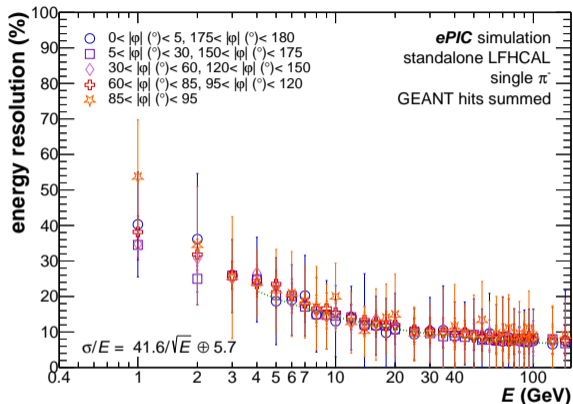
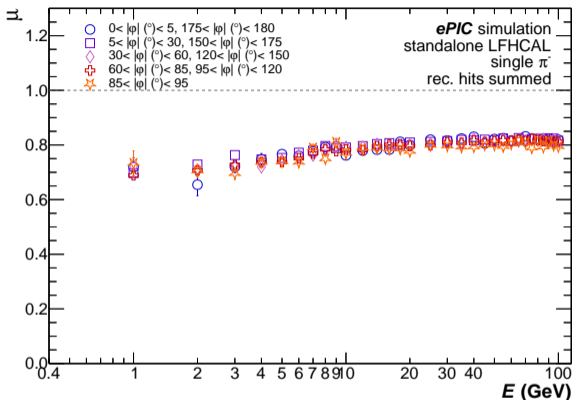
- Full implementation of hit chain (including basic noise simulation) & first version of clustering
- All simulations done with only HCal & single particle simulations
- Resolution calculated with time & energy cut offs
- Fitting restricted to > 4 GeV (as for CALICE data) resulting in more realistic $1/\sqrt{E}$ - term





- Current implementation without insert
- Mild eta dependence $1.5 < \eta < 3.0$
- Small leakage seen for $1.0 < \eta < 1.5$ & $3.0 < \eta < 3.5$, significant losses beyond $\eta = 3.5$

LFHCAL simulations vs phi

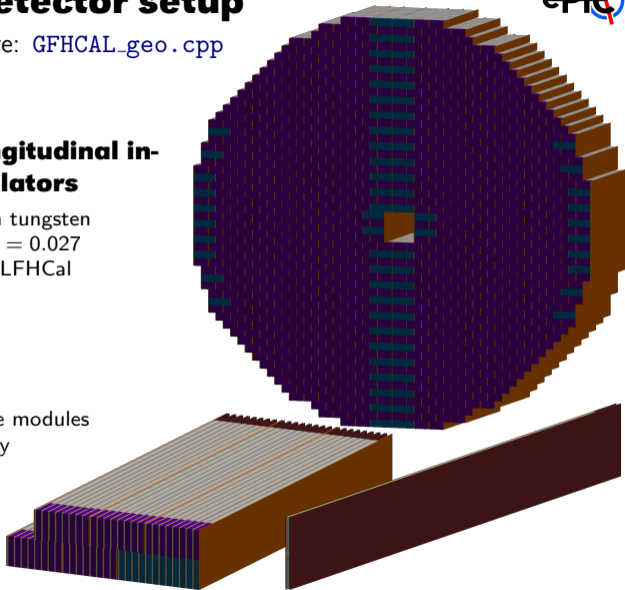


- Current implementation without insert
- No phi dependence

source code here: [GFHCAL_geo.cpp](#)

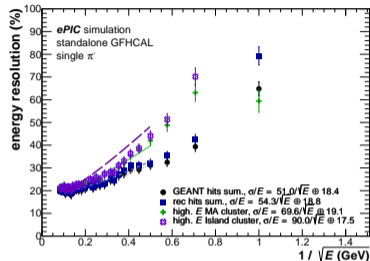
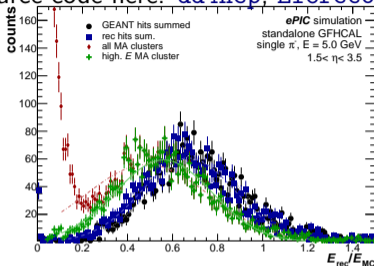
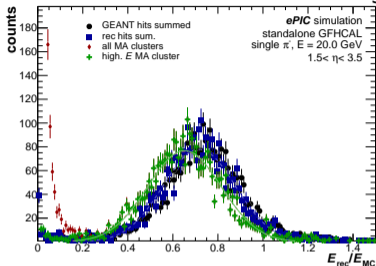
Alternative forward HCal design with longitudinal instead of transverse absorbers and scintillators

- Longitudinal absorber plates 120cm steel and 10cm tungsten
→ 16.8mm thickness, average sampling fraction: $f = 0.027$
→ additional version with more layers: $f = 0.036$ (LFHCAL $f = 0.033$)
- Longitudinal $0.4 \times 5 \times 10 \text{cm}^3$ Scintillator tiles
- Removable Scintillator+pcb mini frames
→ 1mm PCB space in current simulation
- Detector made of $20 \times 10 \text{cm}$ and $30 \times 10 \text{cm}$ front face modules
→ violet and cyan colors in right figure, respectively

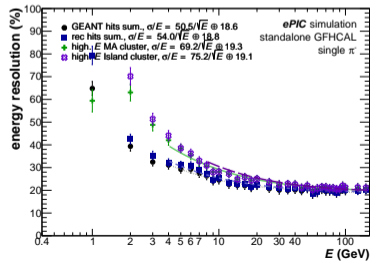


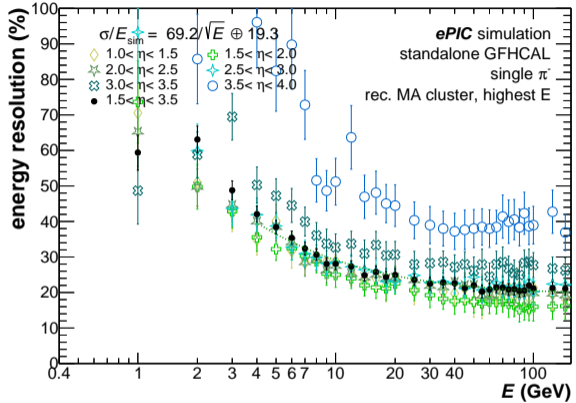
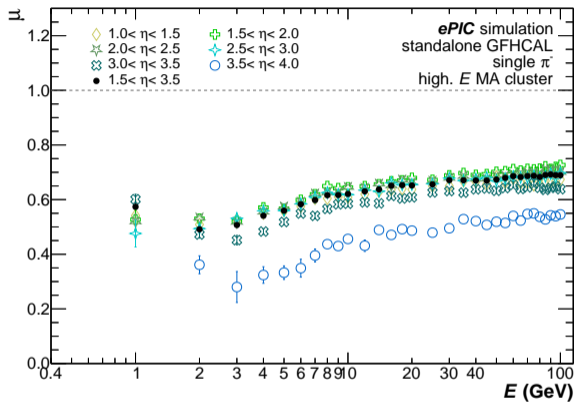
GFHCal simulations

source code here: [dd4hep](#), [EICrecon](#)



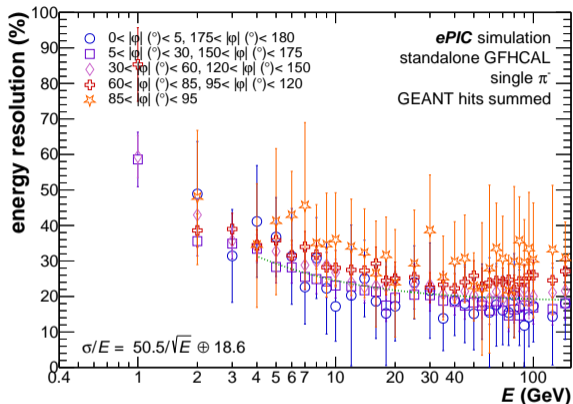
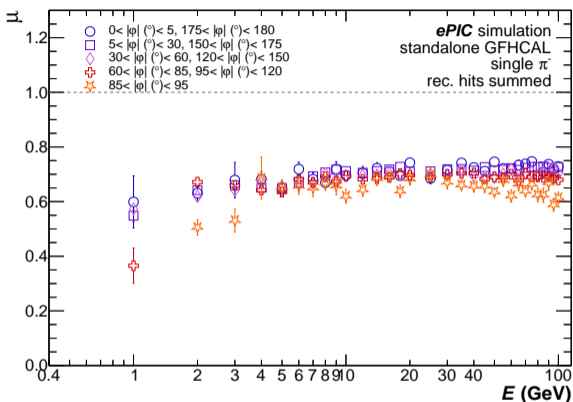
- Full implementation of hit chain (including basic noise simulation) & first version of clustering
- All simulations done with only HCal & single particle simulations
- Resolution calculated with time & energy cut offs
- Fitting restricted to > 4 GeV (as for CALICE data) resulting in more realistic $1/\sqrt{E}$ - term
- Significantly larger constant term than for LFHCal





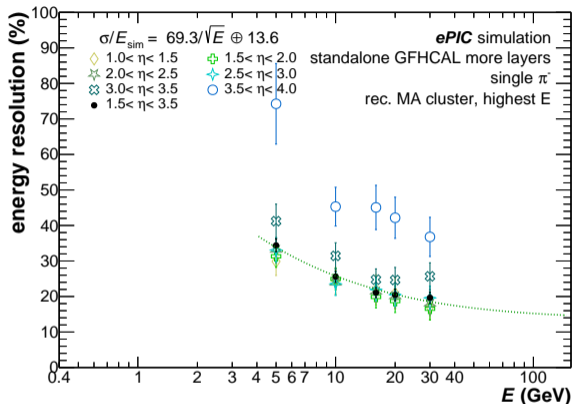
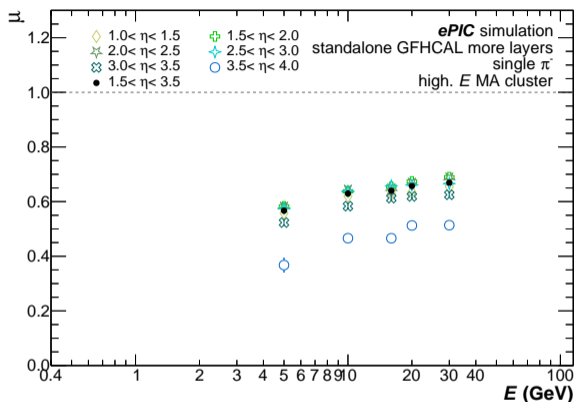
- Current implementation without insert
- Mild eta dependence $1.0 < \eta < 3.0$
- significant losses beyond $\eta = 3.0$, as expected

GFHCAL simulations vs phi



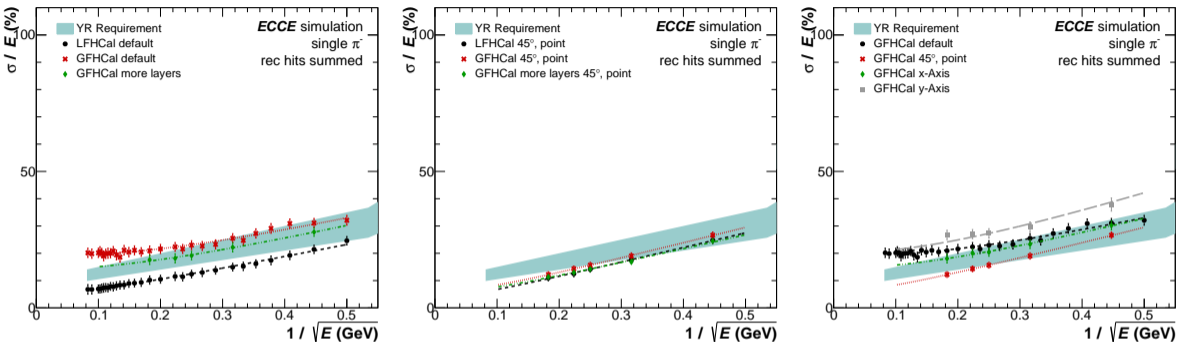
- Current implementation without insert
- Strong phi dependence, as expected (orange along y-axis, blue along x-axis)

GFHCAL simulations (m. layers) vs eta



- Current implementation without insert
- Mild eta dependence $1.0 < \eta < 3.0$
- significant losses beyond $\eta = 3.0$, as expected
- Improved constant term compared to default setup

Understanding the simulations (1)



- Left: Comparison of different detector setups full η/φ
- Middle: Comparison of different detector setups at 45° in center of detector very similar performance GFHCal more layers & LFHCal
- Right: Comparison of default GFHCal in different regions Significant losses along y-axis (channeling) and even along the x-axis Particle hitting center of detector similar performance as LFHCal