

# pfRICH end ring prototyping updates

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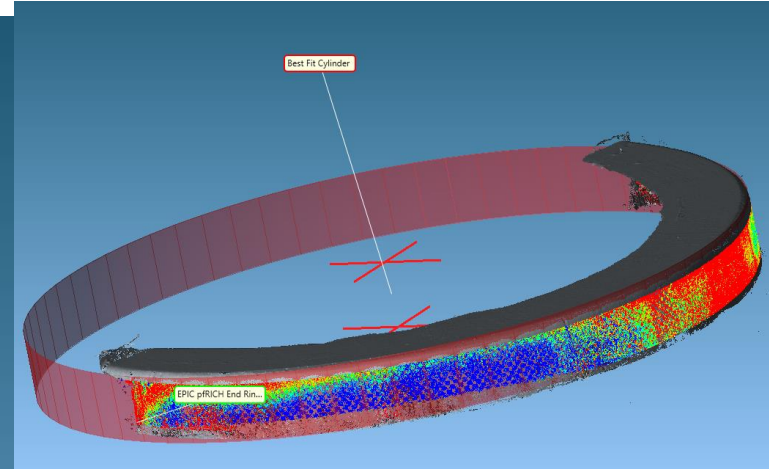
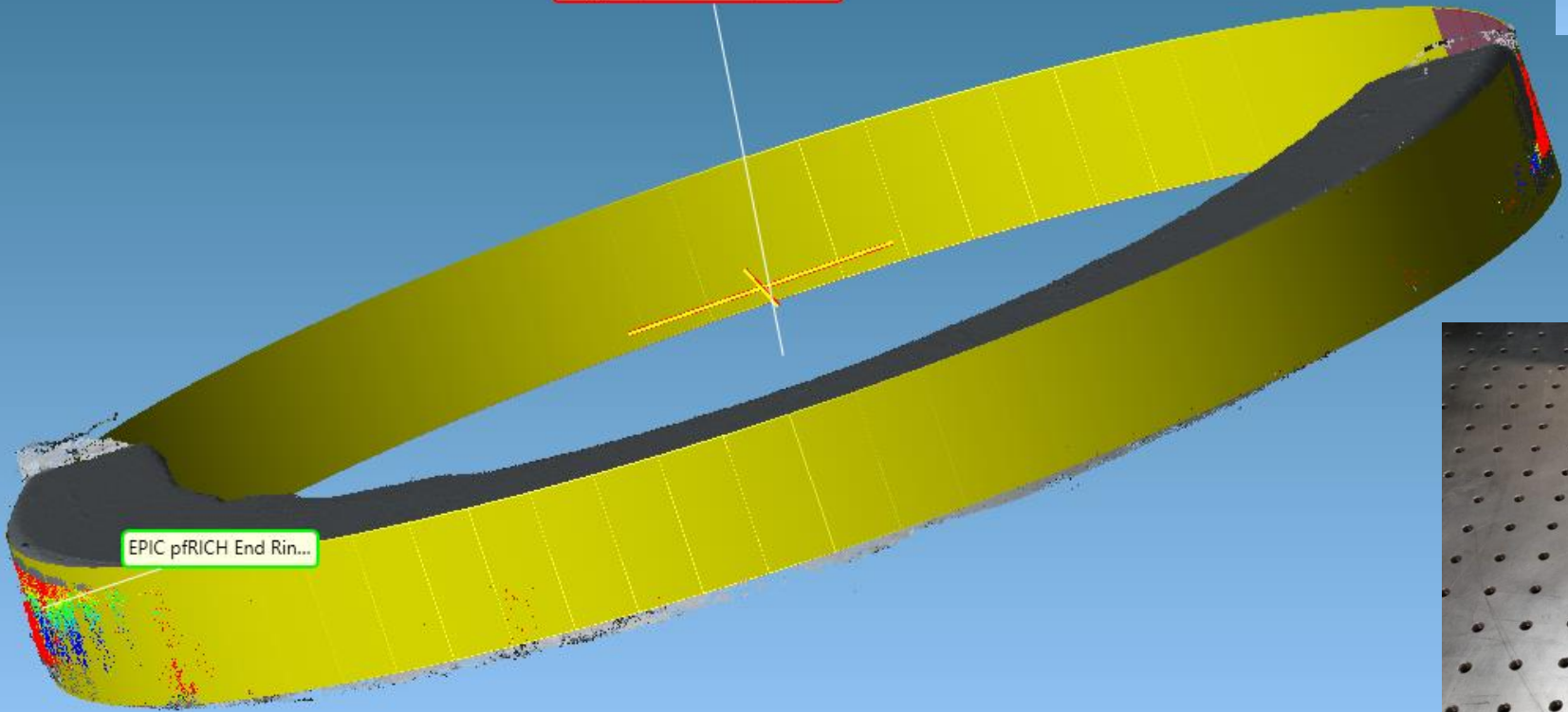
12 Feb 2024

- ◊ Concave mold is the way forward. The convex mold had spring-in leading to part clamping on to the mold and the part damaged while removing
- ◊ Next steps – machining inserts and groove features
- ◊ Mortise and Tenon joining mechanism machining



Target : 338 mm  
Achieved : 337.9 mm

Best Fit Cylinder		
	Actual	
Diameter	337.907mm	⚑
$\varnothing$	3.237mm	⚑



Date	End Ring	Sensor Plates	Mirror Substrate
20 Feb	End ring prototype with small radius		Concave or convex design ??
25 Feb	surface roughness, tool compensation for larger end ring - start		
10 Mar	tool compensation for larger end ring – end Tool machining start	1 <sup>st</sup> prototype for sensor plate T-assembly	takes about 3-4 weeks from CAD to final pieces – need final design to start this
15 Mar	Tool ready – metrology and QC/QA		
30 Mar	Layup of all 4 end ring quarters		
15 Apr	Machining & Assembly of 4 quarters		
20 Apr	Ship End Ring to SBU		
15 May		First Sensor Plate assembly	
25 May		Second Sensor Plate Assembly	