Work Package: Cooler

SPIRE-SBT-REP-001353

2. Subsystem Progress This Month - CQM units : cooler hearts cleaned – now under cleanliness and contamination control. Mounting of thermometers and heaters to follow - Heat switches : qualification of titanium/copper brasing done (new subcontractor) – procedure established. Assembly of heat switches to follow - Heat switches support : New geometry qualified on samples (ease one of the EB weld). In addition 2 TIGs on miniature sorption pump replaced by EB welds (also qualified on samples). New parts have been machined and EB welded (switch support): now ready for brasing. - Structures : surface treatment on titanium along with subcontractor identified. Structures to be treated by OAS (0xydation Anodique Sulfurique) in the course of September. - Kevlar characterisation campaign : continue. Unexpected creep (?) detected during multiple cycles between room T and LN2 is under investigation. - Solution for the electrical isolation identified – to be implemented in the design. New parts to be manufactured. 3. Problem Areas Remedial Action Peculiar behaviour of Kevlar Under investigation 4. Engineering Activities Tensiometer & electrical isolation 5. Design Changes Status 6. PA/QA Activities Completed General QA management. Status 7. Subsystem Management Issues None 8. Actions Requiring Immediate Attention Status None Completed	Manufacturing of new large test cryostat done ("standard" test cryostat implemented. STM units available (vibration tests performed). 2. Subsystem Progress This Month - CQM units : cooler hearts cleaned – now under cleanliness and corr and heaters to follow - Heat switches : qualification of titanium/copper brasing done (new in Assembly of heat switches to follow	at available). Product Assurance plan
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