22.02.00
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EST production at LPI
(January – February 2000)

- In mid-January LPI group has restored the production of the EST boards at the new stage corresponding to the changed hole sizes. New templates for cutting procedure have been ordered and built.

- The increased production rate – 10 board/day was achieved, due to use of additional rubber mats in the glue press.

- Produced EST boards (at the moment corresponding to 18.02)

Front EST boards - 146
Rear EST boards - 129

Total - 275

- Fully tested EST boards (at the moment corresponding to 18.02)

Front EST boards - 58
Rear EST boards - 77

- The wastage during this new production period is rather small.

Among 275 EST boards produced
1 board was rejected during production
2 boards were rejected during HV testing

Electrostatic stability of DuPont kapton is very good.

- Delivered EST boards:

  1 front module (with spares) ---> Dubna
  1 rear module (with spares) ---> Protvino

  EST boards, which will constitute another 3 rear modules and 2 front modules, are in the final state of production.

- Along with preparation templates for the new stage of EST production the special bath was built at LPI, which could be filled in with LN2 and used for carrying out the full size cold test of the EST boards. Main goal was:
  to CHECK EST board SHRINKAGE with respect to Cu-plate.

- The results of several tests:

Material	Relative shrinkage (round holes ---> wide end of EST)
Old (Russian) kapton (kept at humidity 35%)	3 mm
DuPont kapton (kept at humidity 35%)	2.5 mm
DuPont kapton (after vacuum pumping for 36 hours.)	2 mm