Status of MPI Endplug Production

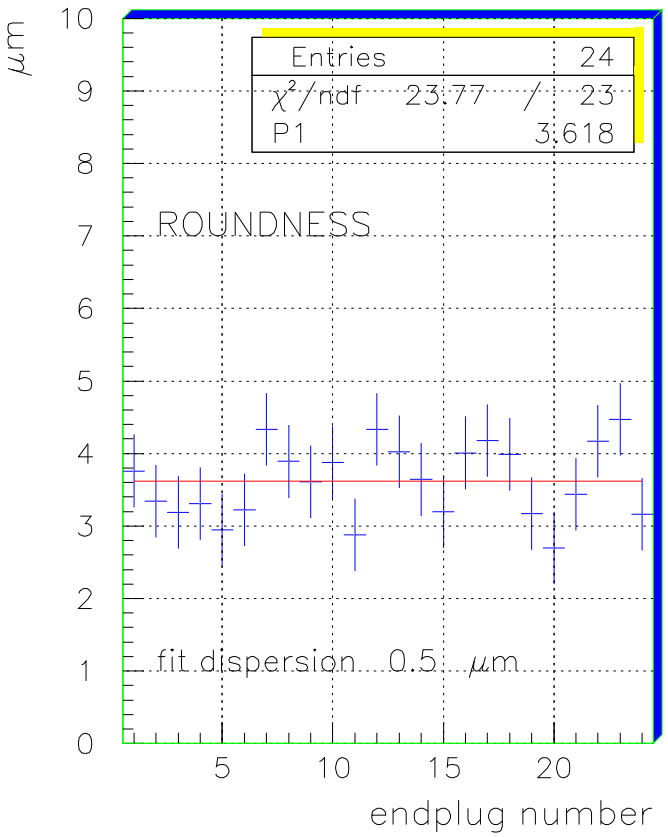
- **Preseries Production of 5000 Endplugs**
  - 1200 sent to Dubna for BOS drift tube production
  - 3400 sent to other institutes for module 0
  - Rest: extensive tests
  - Improvement of surface quality after first 5000
- **Quality Assurance**
  - Documentation of injection moulding process
  - QA/QC check lists for handling and storage in production
  - 1% of plugs cut after injection moulding
  - Metrology of 1% of plugs:
    - diameter,
    - roundness,
    - concentricity,
    - locator hole,
    - orthogonality,
    - O-ring groove width

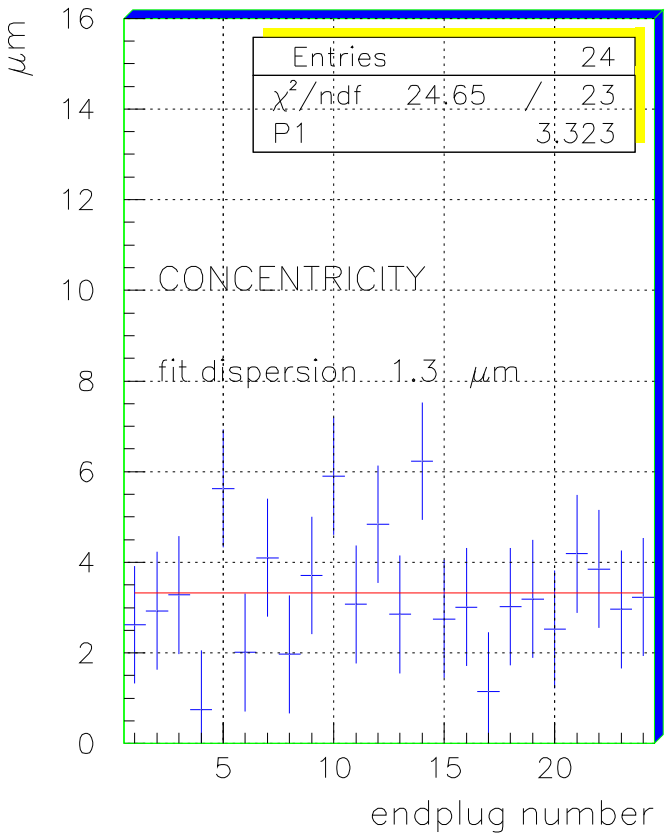
    within tolerances
  - Cleaning procedure and packing

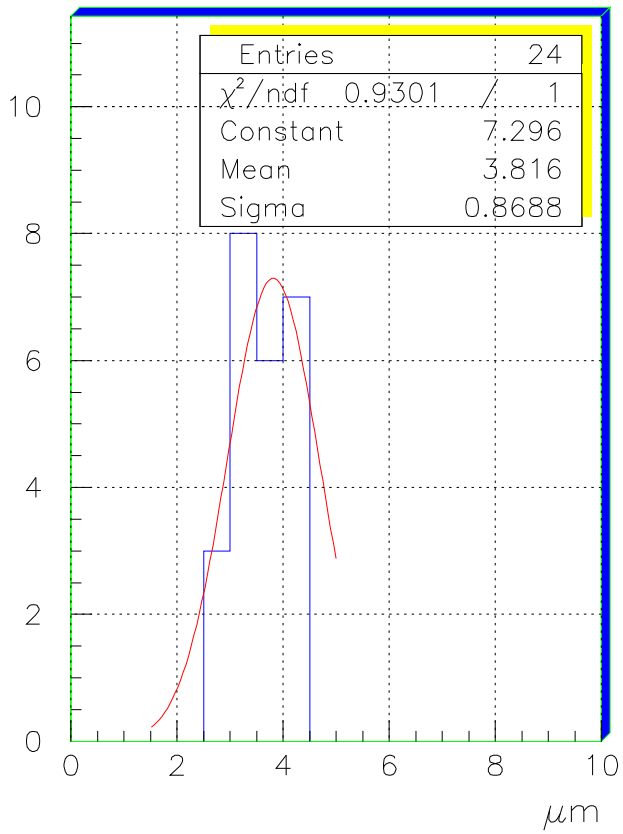
- **Cleaning and Tests**
  - **1200 plugs cleaned in ultrasonic bath with neutral detergent for 10 minutes: no visible cracks**
  - **200 plugs cleaned in ultrasonic bath with ethanol for 10 minutes: no visible cracks**
  - **40 plugs dipped in acetone: no visible cracks**

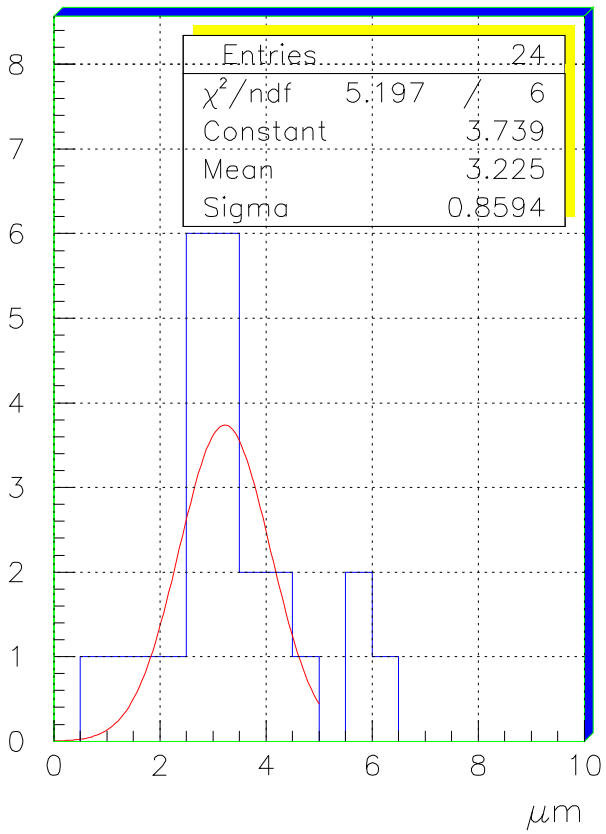
Metrology

Calibration at FAG









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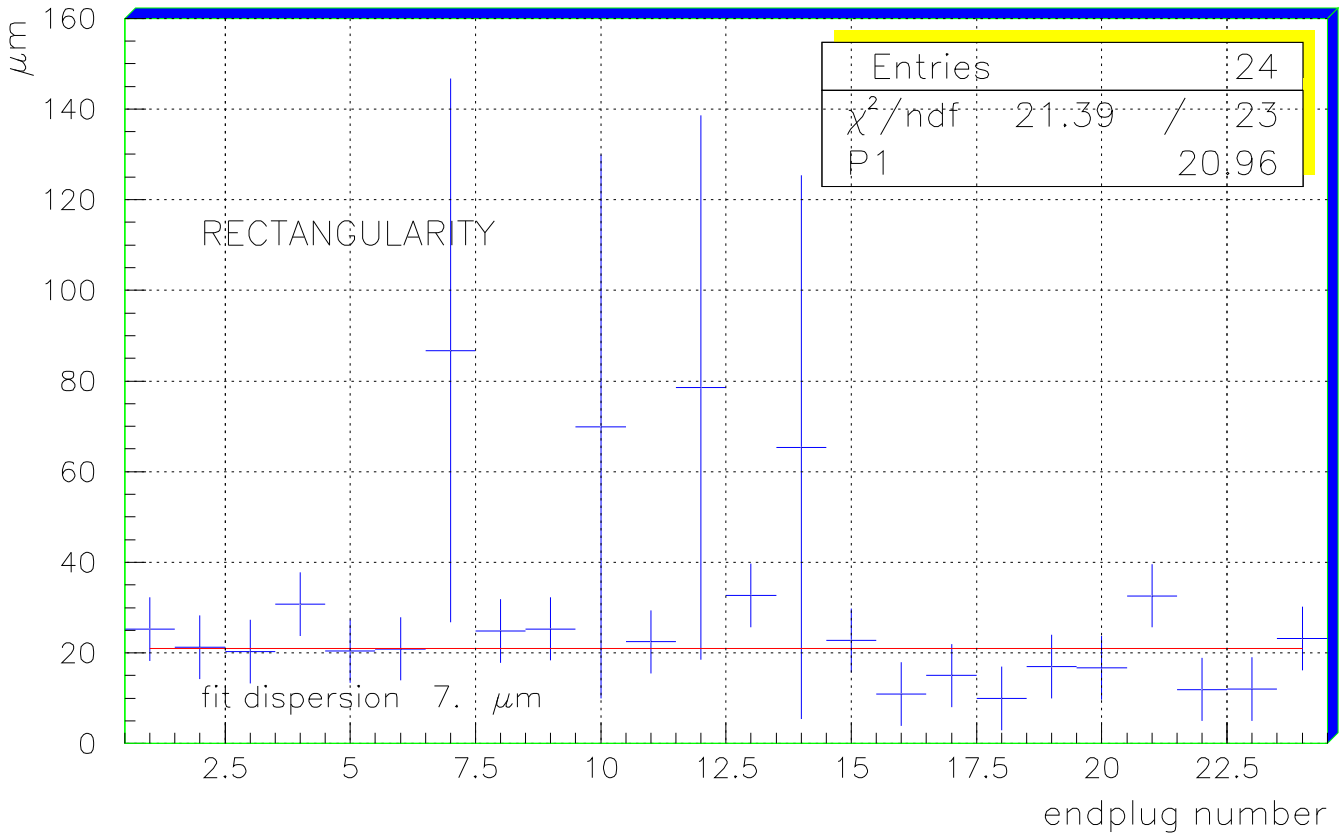
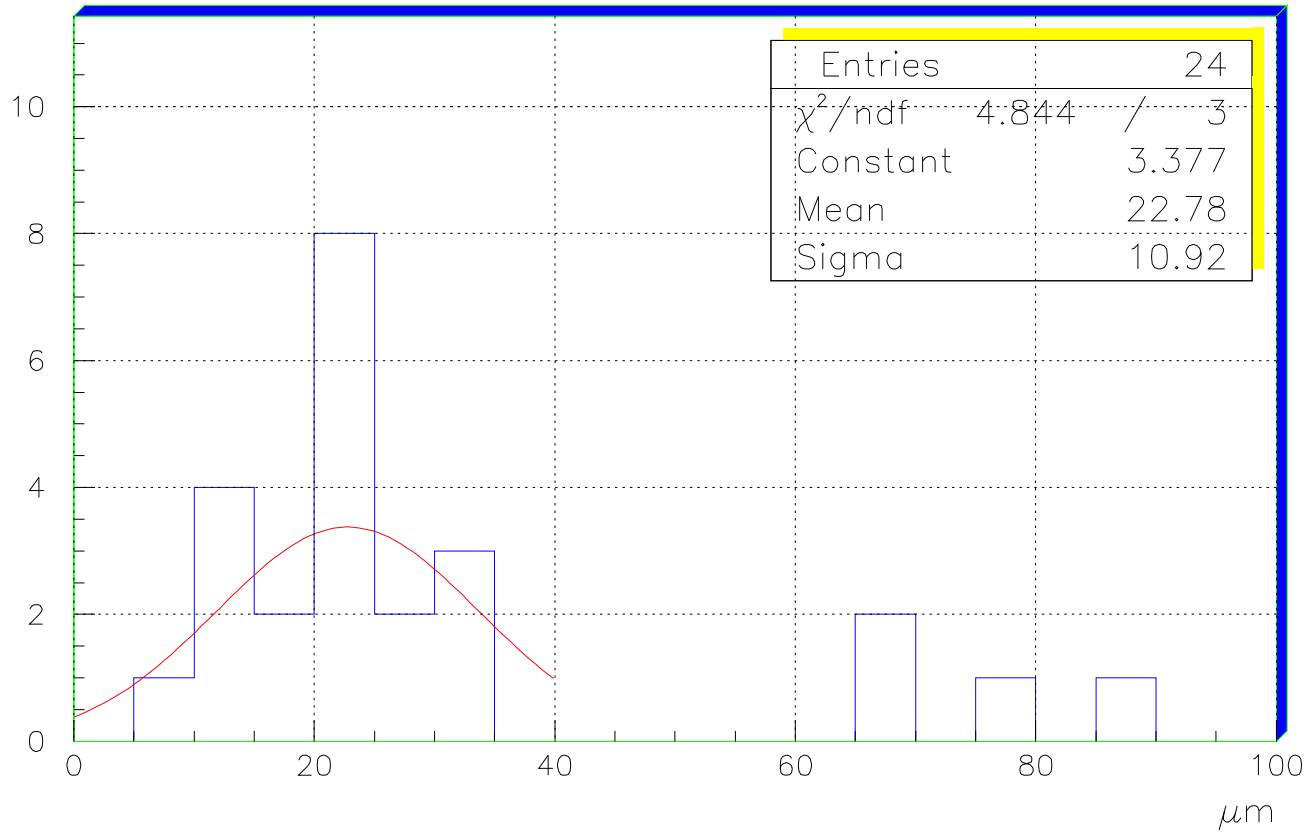
Metrology

Calibration at FAG





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