STANFORD LINEAR ACCELERATOR CENTER

SPECIFICATION

STANFORD SYNCHROTRON RADIATION LABORATORY

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Author(s): Jack Tanabe, Nanyang Li		Date: Nov. 9, 1999

First Line: SPEAR3
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Title: Sextupole Magnetic Measurements

Sextupole

Magnetic Measurements

Specification

六极铁

磁场测量

生产说明书

Approved: SPEAR3 System Manager
Richard Boyce

Date:

Approved: SLAC Magnet Group Leader
Domenico Dell'Orco

Date:

Approved: IHEP Administrative Representative
Yanling Jiang

Date:

Approved: IHEP Technical Representative
Huamin Qu

Date:

Update / 修 改

Main coil and skew quadrupole coil was 33 and 36 turns and is 32 and 37 turns, respectively. Magnet design, operation and testing currents are changed correspondingly. PS-444-400-23R0 is invalid. / 主线圈和斜四极线圈分别由33和36匝改为32和37匝。磁铁设计、运行和测量电流相应修改。说明书PS-444-400-23R0版不再有效。

1. GENERAL / 概述

The sextupole magnetic measurement effort is divided among IHEP and SLAC. This document specifies the measurements required at IHEP and describes the complementary measurements that will be performed at SLAC. This document is presented in both English and Chinese text; in case of differences, the English version shall be used.

六极铁的磁测由高能所和SLA共同承担。本说明概括了高能所需进行的磁测项目以及SLAC的辅助测量。本说明有中、英文两种文字，如有不同，以英文为准。

1.1 Scope of the Specification / 说明书范围

This specification describes the minimum requirements for the magnetic measurement for the SPEAR3 prototype and production sextupole magnets. These measurements include measurement of the skew quadrupole field, supplied by trim windings, in addition to the fundamental sextupole measurement. The measurements require a rotating compensated integral coil (thereafter call rotating coil) measurement to determine the quality of the integrated field. This specification outlines the good field region, minimum line integral field quality in this region and the tolerance for the location of the magnet axis. Required prototype and production magnet conditioning and measurement procedures are described.

本说明书解释了SPEAR3六极铁样机和生产铁最基本的磁测要求。这些要求除了包括基础六极场的测量外，还包括校正线圈所产生的斜四极场的测量。积分场的质量采用补偿积分旋测线圈(以下简称为旋测线圈）测量。本说明书对好场区，好场区内线积分场质量最低要求以及磁中心精度要求都做了说明。同时也阐述了样机和生产铁标准化循环和测量步骤。

1.1.2 Reference Document / 参考文件

Engineering Note M321	Sextupole Magnet Design Summary
工程说明书M321	六极铁工程设计总括

1.2 Scope of Work / 工作范围

IHEP shall design and fabricate rotating coils for sextupole measurements. This coil will also be capable of measuring the integrated multipole distribution for the magnet when the skew quadrupole coils are excited. IHEP shall measure the integrated multipole error spectrum and verify the field quality of the prototype magnet and submit the results to SLAC for approval prior to manufacturing the production quantities of sextupole magnets. IHEP shall measure the multipole field integral distribution and determine the offset of the magnetic center from the rotational center of the measurement coil for all production sextupole magnets.

高能所应设计和制造六极铁测量用的旋测线圈，这一线圈应同时能够用来测量斜四极线圈激磁产生的场的多极分量的积分分布。高能所应实施测量样机的多级分量积分误差值，分析样机的场质量，在批量铁正式开工前将测量结果交SLAC，由SLAC审核批准生产铁的正式投产—高能所应测量所有生产六极铁场的多级分量积分分布，确定磁中心相对于旋测线圈中心的偏离。

1.2.1 Field Integral Measurement Tooling / 场积分测量工具

IHEP shall design and fabricate two (2) sets of rotating coils. One coil shall be delivered to SLAC and the second shall be retained at IHEP. IHEP shall assemble a magnetic measurement system using the rotating coil to collect the raw output and reduce the measurement data. IHEP may use existing equipment if appropriate. If not already available, IHEP shall specify and purchase any device(s) necessary to carry out the required measurements. The second set of rotating coil delivered to SLAC will subsequently be used to verify prototype and production measurements on selected magnets. The coil shall be configured so that uncompensated as well as compensated measurements can be made.

高能所应设计和制造两（2）个旋测线圈。一个线圈发SLAC，一个线圈留高能所使用。高能所应建立与其匹配的相应测量系统，取数和处理数据。高能所可使用现有的适用设备。如无现成合用设备，高能所应采购所有测量所需物品。发至SLAC的线圈将用于复测样机和抽测生产磁铁。线圈的结构应可在补偿和非补偿两种模式间切换。

1.2.1.1 Measurement System and Procedure Tolerance / 测量系统自身和工作精度

The rotating coil shall be fabricated so that its axis is collinear with the housing axis within 0.100 mm. Measurements shall be made to identify the offset of the rotating coil axis with respect to the housing within 0.025mm. Installation of the rotating coil housing in the magnet shall be repeatable within 0.025 mm.

旋测线圈的制造应能保证其旋转中心与外筒的偏心度小于0.100毫米。偏心度的测量误差应在0.025毫米内。旋测线圈外筒 在磁铁内的重复 定位精度应小于0.025毫米。

1.2.1.2 Data Correction / 数据修正

Means for correcting or compensating for the “drift” due to small DC voltages during the measurements shall be developed and described by IHEP. If adequate power supply stability cannot be maintained during measurements, means to correct for any power supply variation during the measurements shall be developed by IHEP.

由于测量产生的是微直流电压信号，故其会出现“漂移”现象，高能所应在系统中加入修正或补偿“漂移”的手段。对于电源不稳定造成的数据偏差，高能所也应有相应的修正措施。

2. REQUIREMENTS / 场质量要求

2.1 Tolerance of the Field Integral Distribution / 场线积分分布误差

The field quality requirements for prototype and production magnets are defined in terms of multipole errors evaluated at the good field radius. . The integrated allowed and non-allowed multipole error field normalized to the integrated sextupole field at 32 mm radius shall be less than 4.4×10^{-3} and 1.2×10^{-3} at the sextupole operating current, respectively. Measurements shall also be made at the sextupole design current to determine if there are any changes in the field quality. When the skew quadrupole field is excited at design

currents, the multipole error normalized to the skew quadrupole field at 32 mm radius shall be less than $4x10^{-1}$.

样机和生产铁的场—质量以好场区范围内多级分量误差值为衡量标准。在主线圈为磁铁运行激磁电流值时，32毫米半径处场的系统和随机多级分量积分值与六极分量之比应分别不大于$4.4x10^{-3}$和$1.2X10^{-3}$。按磁铁设计电流激磁时的场的质量也应进行测量，以确认场的质量是否会有变化。斜四极场在设计电流激磁时，多极误差相对于斜四极场之比在32毫米半径处应小于$4x10^{-1}$。

2.1.1 Sextupole Currents / 六极铁电流

The sextupoles are divided among two groups, 21S and 25S. They are designed for higher excitation in order to provide for possible future upgrade. The operating and design currents for 21S and 25S sextupoles are:

六极铁分为两组，分别为21S和25S。考虑到—来加速器可能的升级，它们的设计电流都高于运行电流。21S和25六极铁的运行和设计电流如下表：

Sextupole Type **磁铁名**	**Operating Currents** 运行电流	**Design Currents** 设计电流
21S	154 Amps	170 Amps
25S	193 Amps	212 Amps

2.1.2 Skew Quadrupole Design Currents / 斜四极场设计电流

The skew quadrupole design currents for 21S and 25S are:

21S和25S六极铁的斜四极场的设计电流分别为：

Sextupol Type	**21S**	**25S**
Design Currents	29.2 Amps	24.6 Amps

2.1.3 Sextupole Polarities / 六极铁极性

The power connection for all magnets should be connected using the appropriate magnet polarities prior to conditioning and exciting for measurements. The polarities of sextupoles among 2 groups are:

磁铁标准化—环和通电测量之前，电源的连接要符合被测铁的极性要求。两组六极铁的极性如下：

Sextupole Type 磁铁名	**21S**	**25S**
Focussing 聚焦铁数量	37	
Defocussing 散焦铁数量	9	30

2.1.4 Magnet Polarity of Skew Quadrupole Field / 斜四极场的极性

Since the skew quadrupole field is a trim field and the required polarity depends on the lattice performance, the polarity of the magnet when excited to produce skew

quadrupole field has not been determined. When making skew quadrupole measurements, an arbitrary power supply polarity may be chosen. However, the prototype magnet and all production magnets should be measured using the same polarity.

由于斜四极场是校正场，其极性是根据磁铁的拉梯斯排列决一的，目前各斜四极场的极性尚难确定。故在测量斜四极场时，电源连接方式可随意选择。不过样机和批量铁的测量所采用的极性应一致 。

2.2 Magnet Axis / 磁中心

The measured offset of magnetic center of all production sextupole magnets shall be within a radius of 0.1mm.

所有生产六极铁所测磁中心偏离值都应不超出0. 1毫米半径范围。

3. MEASUREMENTS / 测量

3.1 Supporting Documentation / 支持文件

3.1.1 Field Uniformity / 场均匀性一件

Supporting documentation for the field uniformity measurements shall include details of the measurement coil engineering design, including the positions of the various coil bundles and the number of turns in each bundle. The computed quadrupole and sextupole absolute sensitivity (using theoretical dimensions) and the relative sensitivities to the error multipoles in the compensated configuration shall be tabulated. Means for correcting the "drift" and any power supply variation during the measurements shall be described. Sketches shall be included which describe the orientation of the coil drive axis, identify the coordinate axes of the measurements with respect to the magnet features (i.e. the location of the power busses) and the rotation direction of the measurement coil.

场均匀性测量的支持文件应包括测量线圈物理和机械设计的详细说明，其中包括线圈各扎的位置和每扎的匝数。四 、六极分量的计算绝对敏感度（用线圈的理论尺寸）和反抵模式时多级分量的相对敏感度应列表说明。测量中所采用的修正"漂移"和电源不稳定造成的数据偏差的手段。 同时还应附有示意图，说明线圈转轴的方位，所取的相对于磁铁某一部件（如电源母板）建立的测量坐标轴以及测量线圈的旋转方向。

3.1.1.2 Rotating Coil Positioning / 旋测线圈的定位说明

The measurement coil housing shall be indexed to the top two poles of sextupole on the same 1/3 core assembly using a pair of sleeves located at repeatable longitudinal positions at each end of the magnet. A second pair of sleeves shall be fabricated and delivered to SLAC. The offset of the rotating coil axis using the two pairs of sleeves shall be measured. The offset and the longitudinal position of each sleeve information shall be sent to SLAC.

测量线圈的外筒应通过放置在磁铁前后两端重复位置的一对半瓦片座靠在六极铁上部位于同一个三分之一铁芯的两个极头上。高能所应生产两套瓦片，其中

一套作为旋测线圈的附件发SLAC使用。高能所应测量旋测线圈使用两套瓦片的定位偏差度，偏差度数据和瓦片在磁铁内的纵向位置都应提供给SLAC。

3.2 Field Uniformity and Magnetic Center Measurements / 场均匀性和磁中心测量

Each magnet shall be conditioned prior to the measurements. The magnets need not be reconditioned before measurements at each current level. Uncompensated mode of the rotating coil shall be used to measure the quadrupole and sextupole components of the magnet field. The result of real and skew components of the quadrupole field shall be used to compute the offset of the magnetic center of the tested magnet from the rotational center of the measurement coil. Compensated mode of the rotating coil shall be used to measure the multipole errors.

测量之前磁铁应做标准化循环。磁铁在各场平测量前，不需再做标准化循环。旋测线圈的非反抵模式用来测量磁铁的六、四极场；所得四极场的正、斜极矩用来计算被测铁相对于旋测线圈旋转中心的偏离；反抵模式用来测量多极分量误差。

3.2.1 Sextupole Measurement Currents / 六极场测量电流

Uncompensated and compensated measurements shall be made at sextupole currents at:

反抵和非反抵测量模式六极场的测量电流如下：

Group	**21S**	**25S**
Main Coil (Amps)	115, 134, 154 and 170	145, 176, 193 and 212

3.2.2 Skew Quadrupole Measurement Currents / 斜四极场测量电流

Uncompensated measurements shall be made at skew quadrupole excitations at:

非反抵测量模式斜四极场的测量电流如下：

Group	**21S**	**25S**
Skew Quadrupole Coil (Amps)	30	25

3.2.3 Conditioning Cycle / 标准化循环

Prior to measurements, each magnet shall be conditioned by raising its current to 110% of its design current three times and returning to zero. The current rate of rise and return to zero shall be approximately linear (avoid step functions) and shall take no less than 10 seconds per cycle. The maximum conditioning currents shall be:

每块磁铁测量前，须经标准化循环。其激磁电流应升至设计电流的110％而後回零，如此反复三次。电流的提升和回零应相对呈直线（避免阶梯作用），各循环周期不应低于10秒。标准化循环最大电流见下表：

Group	**21S**	**25S**
Max. Current (Amps)	187	233

3.2.4 Measurement Results / 测量结果

The raw uncompensated and compensated integrator output before performing Fourier analysis shall be stored in magnetic media and kept at IHEP. The raw data shall include identifying information (magnet serial number, date, time, ambient temperature and operator).

在做傅利叶分析之前积分器输出的原始非反抵和反抵数据应有高能所磁盘存档。原始数据应包括鉴别资料（磁铁身份号，日期，时间，环境温度和测量人员姓名）。

3.2.5 Tabulated Results / 表格数据

The tabulated results for each measurement shall include, at minimum, the following.

每项测量的表格数据一少应包括以下数据：

3.2.5.1 Identifying Information / 鉴别资料

Magnet Identification Number, Date, Time, Ambient Temperature and Operator.

磁铁身份号，日期，时间，环境温度和测量人员姓名。

3.2.5.2 Results of Uncompensated measurements / 非反抵测量数据

Measurement current, drift counts quadrupole and sextupole integrator counts, integrated fields (using computed coil sensitivities), their absolute phases with respect to coil horizontal axis at start of rotation. X, Y and magnitude of the offset of magnetic axis from the coil axis.

测量电流，漂移计数，四、六极分量积分器计数，场积分（使用线圈敏感度计算值），它们相对于线圈初始水平位置的绝对相角，磁中心相对于线圈轴的X，Y位移值。

3.2.5.3 Results of Compensated measurements / 反抵测量数据

Measurement current, drift counts, sextupole bucking ratio, normalizing radius, integrator counts, computed multipole normalized to the fundamental sextupole and phases relative to the sextupole zero phase on the positive magnet x-axis for all multipole error terms from n=4 to n=21.

测量电流，漂移计数，六极反抵比，归一化半径，积分器计数，多极分量相对于基础六极分量的计算比值，和所有n=4至n=21极分量相对正接铁X轴六极分量0相位的相角。

4. PROTOTYPE MAGNET / 样机

The chamfer shape has been optimized at SLAC using a three dimensional magnet code. This chamfer is specified in the core assembly drawing. It is expected that the performance of the prototype of a 21S magnet will reproduce the results from the code and iteration of the chamfer shape will not be needed.

SLAC用三维程序计算出了六极铁的端部削斜几何尺寸。铁芯图纸中给出的即是这一计算图形。预计样机铁--21S六极铁的场形将与三维算出的结果相吻合而不必再做削斜实验。

4.1 Prototype Chamfer Design Acceptance / 样机端部削斜设计确认

The measurement described in Section 3.2 of this specification shall be performed on the prototype. The results of the prototype measurements shall be analyzed at IHEP and forwarded to SLAC for approval. Chamfer machining of the production magnets shall not proceed until SLAC acceptance of the prototype performance has been obtained.

样机完成后，应按本说明3. 2款的要求进行测量。高能所应对样机测量数据进行分析，将结果呈SLAC审核。生产铁的削斜在SLAC确认设计无误之前不可进行。

4.2 Alternate Chamfer Shape / 削斜替换方案

If, for any reason, the initial SLAC suggested chamfer results in systematic error multipoles that fail to satisfy the field quality requirements for the sextupoles, SLAC shall provide an alternate chamfer shape that can be machined on the same prototype. This chamfer shape will remove more material than the initial prototype chamfer shape. Chamfer machining of the production magnets shall not proceed until SLAC has accepted the final prototype performance.

万一SLAC建议采用的端部削斜方案没能满足六极铁高阶系统误差的要求，SLAC将提供另一可在同一样机上继续往深里加工的削斜方案。在SLAC最後确定削斜方案之前，生产铁不可开始加工端部削斜。

5. PRODUCTION MAGNETS / 生产铁

Acceptance of the chamfer shape is based on the performance of 21S prototype magnet. It is expected that this same chamfer will result in acceptable performance for 25S magnet. However, there may be some small differences in the performance of the 25S magnets. Because of this, measurements of the first article of 25S sextupole should be made by IHEP prior to machining the chamfers on the remaining production magnets of this length.

根据21S样机铁测量结果所确定的端部削斜设计将用于25S六极铁，预计场的质量应能满足要求。不过25S铁的表现可能会有些许的不同，因此，高能所只有在对第一块25S生产铁测量后，方可开始该种铁批量削斜生产。

5.1 Production Magnet Acceptance / 生产铁验收

To promptly correct any fabrication or assembly problems, magnetic measurements of sextupole magnets shall proceed as soon as a production magnet has been assembled. The backlog of assembled but unmeasured magnets shall be no more than five (5) magnets. Satisfaction of the requirements shall be indicated on the magnet assembly traveler by a dated signature of the magnetic measurement engineer in charge and referenced to the identification number for each magnet.

为了尽快发现可能的制造或装配问题，每块六极铁的测量应在总装完成后立即进行。完工待测铁的库存量不应超过5块。磁测合格的铁，应在该磁铁总装跟踪卡上注明，并由磁测执行人签名和日期。

5.1.1 Corrections / 返工

In case the field quality or magnetic axis measurements for any magnet does not satisfy the requirements outlined in sections 2.1 and 2.2, IHEP shall perform a careful mechanical inspection of the core to determine whether the chamfer satisfied mechanical tolerances and/or the core stacking factor and assembly tolerance satisfied requirements outlined in the core assembly specification. The corrections shall be made and the magnetic measurements shall be repeated. This procedure shall be repeated until the magnet satisfies the requirements. All corrections made on the magnet shall be noted in the magnet assembly traveler that accompanies each magnet.

如果任何一块磁铁的场的质量获重复精度不符合本说明书款2.1和2.2的要求，高能所应对铁芯的机械质量进行认真复查，看削斜尺寸是否符合公差要求，或者是否达到了要求的叠装系数和总装精度。在实施相应的改进措施后，需对该铁进行复测。如仍未达到要求，需再修、再测，直至合格。所有返修过程都应在该铁的跟踪卡上做记录。

5.1.2 Rejections / 报废

If corrections described in section 5.1.1 do not result in magnets which satisfy the quality and/or magnetic axis location requirements, SLAC shall be notified promptly, and plans and procedures for necessary correction of production procedures shall be mutually negotiated between technical personnel at IHEP and SLAC. Problems which are not easily corrected may require rejection of the magnet in question or some of its components and/or temporary suspension of a portion of the production effort until satisfactory corrective plans are developed.

如果5.1.1款所述返工不能使铁达到场质量或磁中心精度要求，应立即通知SLAC，高能所和SLAC的技术代表需立即磋商，共同找出解决问题的方法。如该铁实在无法修补，应予整体或部分报废；或暂时搁置一旁，直至找出补救方法。

5.2 Data Achiving, Storage and Transfer / ━∈━、留存和转交

All measurement results shall be filed in hardcopy and on magnetic media and archived at IHEP in duplicate. One set of measurements on hardcopy and an electronic copy of measurements on magnetic media shall be shipped to SLAC along with delivered magnets. More frequent data transfer is encouraged.

所有测量数据应有文本拷贝和磁盘拷贝两种文本，在高能所复制存档。一套两种文本的复制件应随磁铁的发运交SLAC。如果磁测数据能不按批量━先于磁铁发货交递则更为理想。

6. SLAC Measurements / SLAC测量项目

6.1 Field Quality / 场质量

SLAC shall measure and verify the field quality of approximately 20% of the production magnets delivered from SLAC using the IHEP supplied rotating coil.

用高能所提供的旋测线圈，SLAC对大约20％的生产铁抽检场质量。

6.2 Transfer Function / 传递函数测量

The integrated sextupole field transfer function shall be measured at SLAC.

SLAC应测量积分六极场传递函数。

6.3 Magnet to Magnet Transfer Function Reproducibility / 铁间传递函数一致性

Magnet to magnet sextupole field transfer function reproducibility measurements shall be performed at SSRL.

SLAC实施铁间六极场传递函数一致性测量。

6.4 Fiducial Locations / 定标位置

SLAC shall measure the location of the fiducial balls using the mechanical axis of the sextupole as the datum. If there are significant differences among the magnetic center offsets of production sextupoles, the fiducial coordinates shall be adjusted.

利用六极铁的机械中心为基准，测量准直测量球靶的位置。如果生产六极铁磁中心的离散度太大，每块铁的准直坐标都应予以调整。