



Technical Coordinator's Report

Alexander Korzenev, JINR LHEP

SPD Collaboration Meeting Yerevan, 12 Nov 2025

Outline

- Experimental hall news
- Power structure of the detector
- Thermal analysis of magnet yoke
- Clean grounding for electronics
- Platforms
- Engineering communications and service pipelines
- Progress on MM cooling system
- Progress on ECal
- Progress on Straw tracker
- Progress on FARICH R&Ds
- Progress on ZDC
- Conclusion

SPD experimental hall in May 2025



A.Livanov

Hangar for assembly work (March 2025)





- Hangar is installed using the technology of a prefabricated building made of light steel thin-walled structures.
- Inside there is a partition with a passage dividing the hangar area in a 1:3 ratio.
- The lower part of the hangar is made of profiled metal sheet, the upper part is made of transparent profiled polycarbonate.
- Hangar will be used as a production and storage facility for the experiment.

A.Livanov

- The construction work in the SPD hall has not yet been completed
- We may only use two places in the hall for our needs: (1) container cabin and (2) hangar







Developing the power structure of the detector



N. Topilin	Chief designer
S.Sukhovarov	Leading designer
V.Shvetsov	Leading designer
S.Gerasimov	1st category design engineer
A.Shunko	1st category design engineer
K.Basharina	2nd category design engineer
I.Kruglova	2nd category design engineer
E.Dolbilina	3rd category design engineer

- Since the beginning of this year, Design Bureau № 2 of the LHEP has been actively involved in the development of the detector's power structure
- The main focus on developing of stage-1 subsystems:
 - Magnet yoke (Gerasimov, Kruglova, Dolbilina)
 - Platforms for electronics and auxiliary equipment (Shunko, Basharina)
 - ECal-endcap and ToF frames (Shvetsov)
 - Straw tracker (Sukhovarov, Basharina)
 - General power structure of the detector (Sukhovarov)
 - Pipe tracing of the water cooling system (Dolbilina)
- The work is coordinated with engineers from other groups

Details in N.Topilin's talk tomorrow

Developing the power structure of the yoke



The schedule has not changed yet, but delays are very likely

	20	24		2025				20	26		20	27	2028			
3D model development																
Preparation of design documentation																
Supplier search, tender, contract signing																
Production																
Shipment to Dubna																
Installation in SPD																

P.Dergachev (MISIS) M.Gorshenkov (MISIS)

Thermal state analysis of the magnet yoke (RS system)

- A simplified geometry of the RS detector was implemented with an approximate layout of FEE cards (without MDT itself)
- Heat dissipation of FEE cards (reading tubes)
 - $2.1W \times 10448 = 21.7 \text{ kW}$
- Heat dissipation of FEE cards (reading strips)
 - $3.1W \times 5944 = 18.3 \text{ kW}$
- It is assumed that convective heat transfer occurs only outside the barrel $h = 20 \text{ W/m}^2/\text{K}$
- The layout of the cooling tubes for the doors is currently under discussion







Transformer substation **L1** *L2 L3* N PE Transformer power supply GND (dirty) FEE cards **Structural GND** (dirty) *Instrument GND (clean?)* 8

- Clean ground is required for FEE
- Trigerless electronics: noise and interference from FEE increases the volume of data

Transformer substation L1 *L2 L3* N PE Transformer power supply GND (dirty) FEE cards **Structural GND** (dirty) Instrument GND (clean?)

- Clean ground is required for FEE
- Trigerless electronics: noise and interference from FEE increases the volume of data
- Presently all grounds (dirty and clean) are connected!
- Instrument ground has to be disconnected from dirty grounds

Transformer substation L1*L2 L3* N PE Transformer power supply GND (dirty) FEE cards **Structural GND** (dirty) Instrument GND (clean) 10

- Clean ground is required for FEE
- Trigerless electronics: noise and interference from FEE increases the volume of data
- Presently all grounds (dirty and clean) are connected!
- Instrument ground has to be disconnected from dirty grounds
- Removing jumpers between transformer & structural grounds. Isolate the detector from the rails

Transformer substation L1*L2 L3* N PE Transformer power supply GND (dirty) FEE cards **Structural GND** (dirty) ~100 m

- Clean ground is required for FEE
- Trigerless electronics: noise and interference from FEE increases the volume of data
- Presently all grounds (dirty and clean) are connected!
- Instrument ground has to be disconnected from dirty grounds
- Removing jumpers between transformer & structural grounds. Isolate the detector from the rails
- 2. Create a new ground

Instrument GND (clean?)

Development of platforms for various equipment



Equipment for the electronics platform

Cabinet or just racks





Different options for cabinet



Single or dual row layout





A.Shunko, K.Basharina

Development of the electronics platform









Engineering communications and service pipelines



Engineering communications and service pipelines



D.Dedovich, I.Zur (BSU)

Progress on MM cooling system



- Circulation of the coolant at a total pressure in the circuits less than atmospheric (so-called leakless mode)
 - There is no risk of water leakage onto critical detector systems, as atmospheric air acts as a sealing pressure
- Input MM parameters for calculation:
 - radiator pipe $\emptyset=3$ mm, manifold pipe $\emptyset=5$ mm, supplying pipeline $\emptyset=10$ mm
 - Heat power per FEE card $P_{heat} = 15 \text{ W}$
- Results of calculation (recommendation):
 - Coolant flow rate for 3 layers $q = 0.21 \text{ m}^3/\text{h}$
 - Speed of water in the radiator pipes is 2.9 m/s
 - Drop of pressure at each layer $\Delta p = 0.28$ atm
 - Water superheating $\Delta T = 0.19^{\circ}C$
- The results of MM cooling are absolutely satisfactory. It can be also applied to silicon VD detectors (4 times higher power)









Progress on ECal-endcap

O.Gavrishchuk (LHEP) +*LNP team*

- A new version of the endcap support for 928 modules (3712 cells each 40x40 mm²) was proposed by V.Shvetsov
- Frame consist of 4 parts (sectors) made of molded Aluminum
- There are no stretched steel ribbons in the frame. The modules just lie on top of each other
- ECal-endcap will be completely assembled externally and mounted in the frame as a whole.
- Total weight of one endcap is ~10 tons



Assembly of modules is ongoing in LHEP



- 200 modules (1000 cells) will be assembled in LHEP in 2025
- It is planned to assemble 500 modules in "Uniplast" in 2026
- Front-end electronics is being developed in LNP (N.Anfimov, I.Kreslo)

Progress on Straw-barrel



Production line and assembling hall

- Area ~200 m², clean room ~100 m²
- Production line length ~12 m
- Construction work in the hall has already been completed
- Commissioning works begins in May 2025
- All necessary materials and equipment have been purchased
- Straw production speed 1-2 m/min







- Octants are replaced by sextant modules due to better packing ratio and also because the radial ribs can be removed.
- The power frame will be formed by an outer cylinder and a set of straw tubes in the center, which will be replaced by carbon fiber tubes of the same diameter.
- The six modules will be assembled using the Lego principle to avoid areas without layers of oblique straw-tubes.
- A full-size mockup made of styrofoam will be assembled in May
- The detailed procedure for assembling the detector is still under discussion.



G.Kekelidze V.Kramorenko

Progress on Straw-endcap





- The prototype has passed numerous inspections: checking for tightness of the pipes (no gas leaks were detected), checking for electrical insulation (voltage 2.1 kV), etc.
- There are two types of boards developed by A.Solin BSU
 - an amplifying 16-channel AST-1
 - a high-voltage board
- The boards are installed on opposite sides of the straw tubes



Progress on Straw-endcap



Two versions of end-plug have been developed for straw: standard and light (for the central hole).

Production of frame elements for a full-size prototype camera at the "Artmash" company in Belarus (delivered to JINR in May)







Progress on FARICH R&Ds

Aerogel optimisation

Details in Alexander Kattsin's talk



- <u>3-layer aerogel</u> optimized for 6x6 mm² pixel size
- $L_{sc} \ge 60 \ mm$ for all aerogel tiles



- Samples were manufactured in 2024
- Plan to test with beams in 2025

MCP PMT development

Details in Alexander Barniakov's talk





A. Tishevsky

Progress on BBC



The optical cables prototype test





reduced prototype wheel (x2) (at the 1-st stage)

The grooving map is finalizing



FEE & Readout system:



- Tests of the new electronics showed reasonable results
- The upgraded version of FEE with FPGA KINTEX-7 based readout system are under development
- The cables prototype with clear fiber produced by Kuraray has been developed and tested

Plans:

- I. The R&D phase for optical and transmission connectors, as well as **methods of express sector checking** to be continued.
- II. The manufacture of **reduced BBC wheels** (128 tiles each) for SPD Phase 0 is planned to the mid of 2025.

ITEP: I.Alekseev +4 JINR: V.Poliakov, S.Shimanskiy, A.Tishevsky

Progress on the ZDC detector





- Configuration for the beginning of the NICA run: two detectors from both sides of IP
 - The 1st detector was installed in the cryostat of Y-chamber on April 2
 - The 2nd detector will be assembled by the end of month and installed in June
- The first stage ZDC detector: 6 layers of rectangular geometry + 1 veto layer
 - 37 mm thick layer = 30 mm copper radiator + 5 mm scintillator + 2 mm PCB
- Readout by CAEN FERS-5200 system:
 - DT5202 64-channel Citiroc units + DT5215 concentrator board
- Two barrels with homemade connectors for running wires through the cryostat are ready
 - Temporary solution for the beginning of datataking. It will have to be rebuild later



Magnet & detectors on Tuesday

	Status of magnet work at BINP	<i>Evgeniy Pyata</i> 09:30 - 09:50
10:00	Status of the SPD Solenoid Magnet Development	Sergey Pivovarov 09:50 - 10:10
	Status of the cryogenic system development	Юрий Беспалов 10:10 - 10:30
	Status of development of magnet yoke	Nikolay Topilin 10:30 - 10:50
11:00	Coffee break	10:50 - 11:10
	RS status report	Gennady Alexeev 11:10 - 11:30
	ECal status report	Dr Олег Гаврищук 🥝 11:30 - 11:50
12:00	Straw-barrel status report	<i>Төмур Еник</i> 11:50 - 12:10
	FEE for straw tracker	Vitaly Bautin 12:10 - 12:30
	Lunch	
13:00		

14:00	Aerogel Cherenkov Detector Studies for NICA SPD Experiment	Argine Hakobyan 14:00 - 14:20
	Readout electronics for the FARICH prototype (status and perspectives)	Ivan Kuyanov 14:20 - 14:40
	Recent progress of aerogel Cherenkov radiators production in Novosibirsk	Alexander Katcin 14:40 - 15:00
15:00	Status of R&Ds for the SPD project at the BINP	Alexander Barnyakov 15:00 - 15:20
	Coffee break	15:20 - 15:40
	Status of TOF development	<i>Валерий Чмиль</i> 15:40 - 16:00
16:00	Micomegas status report	<i>Дмитрий Дедович</i> 16:00 - 16:20
	BBC status report	Aleksey Tishevsky 16:20 - 16:40
	BBC at Phase-0	Иван Волков 16:40 - 17:00
17:00	Ongoing BBC detector activities in MEPhI	Andrei Durov 17:00 - 17:20

FEE and DAQ on Monday

14:00	Status of DAQ system	Dr Leonid Afanasyev
		14:00 - 14:20
	Status of L1 concentrator	Александр Бойков
		14:20 - 14:40
	Current status of TSS development. White Rabbit calibration automatization and modeli	ng of TSS network Daniil Kozyrev
		14:40 - 15:00
15:00	Current status of TSS development. TSS control protocol v.2. First test runs	Kirill Kotov
		15:00 - 15:20
	Coffee Break	
		15:20 - 15:40
	L2 concentrator firmware status	Andrei Berngardt
		15:40 - 16:00
16:00	RUNO ASIC for TOF	Dr Evgeny Usenko
		16:00 - 16:20
	Status of ASICs development for NICA-SPD track system	Alexandr Solin
		16:20 - 16:40

Dense agenda for the meeting!

Summary

- Strong involvement of Design Bureau № 2 of LHEP under the leadership of N.Topilin since the beginning of this year
- Significant progress in the overall power structure of the detector and platforms
- Discussion of issues of engineering communications and service pipelines has begun
- Progress in R&D of many detector subsystems
- According to present schedule we can have the 1-st stage detector by the end of this decade. *Clear planning required from corresponding groups*.

backup

Engineering communications and service pipelines



S.Sukhovarov

Progress on Straw-barrel



Range (muon) System Status

- Participation in developing the engineering Yoke design, especially in part concerning the impact of MDT detectors and electronics
- Organization/deployment of MDT test production equipment is in progress
- Execution of pre-production contract JINR-Minsk/Integral on amplifier chips (Ampl-8.53) is in progress
- Pre-production contract JINR-Minsk/Integral on preamplifier and discriminator chips (Ampl-8.11R-G5, Disc-8.17) is under discussion
- Tests on data transmission from digital FDM-192 module to L1 concentrator have been successfully performed using SerDes interface
- Main parameters of strip board (capacity and wave imperdace) were measured with Detector Layer Prototype (DLP)
- Preparations to the beam tests (Cherenkov counter at LINAC-200 and Range System Prototype at NUCLOTRON beam) are in progress

Schedule for Solenoid+Dewar production

	2024			2025 2026							20)27							
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SAT cryostat								<u> </u>											
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FAT coil winding								<u> </u>	<u> </u>										
Cold mass integration								'	1 '										

D.Nikiforov

LHe cryogenic system, cryocomplex, pipelines



* Commissioning is only possible with the magnetic yoke installed.

Range (muon) System project

Project leader	JINR: G.Alexeev									
Magnet yoke design and MDT detecting planes assembling and mounting into slots of the yoke	JINR: A.Samartsev, E.Boltushkin, S.Kakurin, S.Gerasimov									
Gas system (as part of DCS)	MSU: K.Korolev + 1									
Analog and digital electronics	JINR: N.Zhuravlev + 4 Minsk: M.Baturitsky + 3, A.Solin +1 MSU: A.Chepurnov, A.Nikolaev, A.Aynikeev + 3									
MDT detectors and strip boards production and assembling	JINR: V.Abazov, A.Piskun, S.Kutuzov, I.Prokhorov, Yu.Vertogradova									
Software and analysis	JINR: A. Verkheev, L. Vertogradov. MEPhI: A. Osterov.									

	2025				20	26			202	27			2028					
	l q 2025 II	q 2025 I	ll q 2025 IV	q 2026 Iq	2026 II q	2026 III q	2026 IV q	2027 lq	2027 II q	2027 III q	2027 IV q	2028 Iq	2028 IIq	2028 III q	2028 IV q 20	029 Iq 2	2029 II q	2029 III q
Month	2 3 4	5 6 7	8 9 10 1	1 12 1 2	3 4 5	6 7 8	9 10 11	12 1 2	3 4 5	678	9 10 11	12 1 2	3 4 5	678	9 10 11 12	1 2 3	4 5 6	7 8 9
Yoke production																		
Final engineering design																		
Detailed engineering design for external contract																		
Construction of the yoke																		
MDTs production																		
Preparation of the MDTs workshop																		
Purchase of materials for MDT mass production																		
R&D for strip readout																		
Purchase of materials for strip mass production																		
MDT mass production																		
Strip boards mass production																		
Assembly of detector planes																		
Mounting of detector planes into RS modules																		
Full RS comissioning																		
Analog FEE																		
Ampl-8.53/11R R&D																		
Dics-8.13 R&D																		
Ampl/Disc mass production																		
A_FEE cards proto development																		
A_FEE prototype cards tests with MDT detectors																		
Procurement of components																		
A_FEE mass production (+ testing/debugging)																		
Installation and debugging in RS/SPD																		
Commissioning																		
Digital FEE																		
Dig_FEE & L1 DAQ																		
R&D of final Dig_FEE																		
Firmware for Dig_FEE																		
Purchase of components for Dig_FEE mass production																		
Production & debugging																		
Dig_FEE test with DAQ L1																		
Installation of Dig_FEE modules to RS and debugging																		
Commissioning with SPD DAQ																		

Straw-barrel project

Project leaders	T.Enik (JINR), E.Kuznetsova (PNPI), Y.Mukhamejanov (JINR, INP).
Power frame and assembling procedure	JINR: K.Basharina, Y.Ershov, A.Salamatin, S.Sukhovarov.
Gas system	JINR: V.Perelygin, V.Karjavine, D.Kozlov.
Electronics	JINR: V.Bautin, M.Buryakov, N.Gorbunov, A.Golunov, V.Karjavine, S.Kochepasov, O.Minko, K.Salamatin BSU: A.Solin, A.Solin.
Tube production and assembling	JINR: Y.Kambar, S.Romakhov, A.Rymshina. INP: O.Kalikulov, N.Yerezhep, S.Shinbulatov, Sh.Utei, A.Baktoraz, S.Adilkhan
Software and analysis	JINR: R.Akhunzyanov, A.Chukanov, A.Lapkin, A.Mukhamejanova (JINR, INP), D.Myktybekov (JINR, INP), O.Samoylov, D.Baigarashev (JINR, INP), D.Kereibay (JINR, INP) PNPI: S.Bulanova, E.Mosolova, D.Sosnov, A.Zelenov.

	T.Enik, 30 oct 2024	2024			2025							2	202	6		2027						2028						2029		
		2024 Iq	2024 11 0	q 20)24 III q	2024 IV q	2025 I q	2025	5 II q	2025 III q	2025	IV q	2026 Iq	2026 11	2026	lli q	2026 IV q	2027 Iq	2027 II	q 20	27 III q	2027 IV q	2028 I q	2028 II q	202	28 III q	2028 IV q	2029 l q	20	029 II q
	Month	1 2	3 4	5 6	78	9 10 11	12 1 2	2 3 4	5 6	78	9 10	11 12	1 2	3 4	5 6 7	89	10 11	12 1 2	3 4	56	7 8 9	10 11	12 1 2	3 4 5	6	7 8	9 10 11	12 1	2 3	4 5 6
	prototyping - prototypes of individual elements																													
	prototyping - tracker octant prototype																													
	octant prototype testing																													
	prototyping of the tracker frame																													
	Production of the first traker frame																													
	Development of the straw mass production lines																													
	straw mass production																													
	quality control of the produced straws																													
	octant production																													
	octant quality control and final assembly																													
\rightarrow	tracker installation																													
	gas supply system R&D																													
	gas supply system prototyping																													
	gas system production, maintenance and testing																													
	readout electronics R&D																													
	readout electronics production, maintenance and testing																												_	
	LV and HV prototyping																													
	LV and HV production, maintenance and testing																													

G.Kekelidze V.Kramorenko

Progress on Straw-endcap

Small scale prototype, \emptyset =1 m

- The purpose of building the prototype with 80 tubes and aluminum frame is to test the assembly technology:
 - 1. stretching straws before gluing them to the frame
 - 2. keep straws in a humid environment before gluing
- Behaviours of the tubes will be studied throughout the year in order to choose the best technology

Full scale prototype, \emptyset =1.6 m

- Fiberglass frame of full size with mounted lodgements for tubes will be delivered by the end of this year
- Electronics, plugs, pins, films have been ordered and are being produced.



	2024	2025	2026	2027	2028	2029
	2024 III q 2024 IV q	2025 l q 2025 ll q 2025 ll q 2025 lV q	2026 l q 2026 ll q 2026 ll q 2026 ll q 2026 lV q	2027 l q 2027 ll q 2027 ll q 2027 ll q	2028 l q 2028 ll q 2028 ll q 2028 ll q 2028 lV q	2029 l q 2029 ll q
Month	7 8 9 10 11 12	1 2 3 4 5 6 7 8 9 10 11 12	2 1 2 3 4 5 6 7 8 9 10 11	12 1 2 3 4 5 6 7 8 9 10 11 1	1 2 3 4 5 6 7 8 9 10 11 12	1 2 3 4 5 6
End-plug production						
Pin production (12 000 pcs.)						
Purchase of polyimide film 40 kg						
Polyimide film processing						
Production of 2 1-meter prototypes (no FEE)						
Development of FFE for full-scale prototype						
Production of frame for full-scale prototype						
Изготовление строу 6000 x 2,5 м						
Production of full-scale prototype						
Update of technical documantation						
Production of the detector frames						
Development of technological tools						
Fabrication of technological tools						
Detector mass production						
Frame assembling			1 2 3 4 5	6 7 8 9 10 11	12 13 14 15 16	
Straw installation to the frame						
Straw cutting						
Installation of spacers to wires				그 사람 사람 관람 관계 없다. 것은 것은 것을 받아 같은 것은		
Installation of wires into detector						
Gluing of end plugs						
Connection to the gas system						
leak test						
Installation of FEE						
Soldering of chambers						
Fe-55 test of chambers						
Chambers full testing						
FEE development and production						
Assembling of chambers into blocks						

MicroMeGaS-based central tracker

Project leader	JINR: D.Dedovich
Micromegas detector production	JINR: A.Gongadze, I.Liashko, N.Koviazina
Micromegas PCB development	JINR: U.Kruchenak
Detector simulation	JINR: N.Koviazina
Software and analysis	JINR: D.Dedovich, N.Koviazina
FE electronic	JINR: A.Boikov, Svetlana Tereshchenko
ASIC sertification	TSU: S.Filimonov +3

First prototype of cylindrical MM chamber (early 2024)



	2	02	4				20	25)						20	26	6					2	202	27						20	028	8				20	29	9
	2024 III q	2024	4 IV q	2025	lq	2025 II	q	2025 III	q	2025 IV	q	2026 I q	1	2026	lq	2026 III	lq	2026	IV q	2027 Iq		2027 q	2	2027 III q	2	027 IV q	202	28 Iq	2028	8 II q	2028	lli q	2028	IV q	2029 10	1	2029	ll q
Month	78	9 10) 11 1	2 1	2 3	3 4	5 6	7	8 9	10	11 12	1	2 3	4	5 6	5 7	8 9	9 10	11 12	2 1	2 3	4	5 6	78	9	10 11	12	1 2	3 4	45	67	8	9 10	11 1	2 1	2 3	3 4	5 6
Realistic prototypes production&test																																						
Support structure development																																						
MM parameters finalization																																						
Cooling R&D																																						
M0 prototype production																																						
MM, cooling, support design finalization																																						
Cooling system component production																																						
Serial PCB production																																						
Serial DLC coating																																						
FE development & prototype test																																						
Pre-serial FE production& test																																						
FE serial production																																						
Modules production & test																																						
Assembling&test																																						

Beam-Beam-Counter (BBC) project

Project leader	V.Ladygin (JINR)	FEE, FPGA based TDC design and	MEPhI: P.Nekrasov, A.Melekesov					
Deputy	P.Teterin (MEPhI)	tests	JINR: A.Isupov, S.Reznikov, A.Tishevsky, I.Volkov					
	MEPhI: A Zakharov Ph Dubinin P Teterin	BBC interface to SPD DAQ	JINR: A.Isupov					
Manufacture, tests, assembling	JINR: Yu.Gurchin, A.Tishevsky, A.Livanov	Express off-line and data analysis	JINR: I.Volkov, K.Volkova MEPhI: E.Soldatov					
(Phase0)	JINR: A.Isupov, S.Reznikov, I.Volkov	Simulation	JINR: A.Terekhin, K.Volkova MEPhI: A.Durov, A.Levkov, E.Soldatov					

	2024	2025	2026
	2024 III q 2024 IV q 2025	l q 2025 ll q 2025 ll q 2025 lV q	2026 l q 2026 ll q 2026 lll q 2026 lV q
Month	7 8 9 10 11 12 1	2 3 4 5 6 7 8 9 10 11	12 1 2 3 4 5 6 7 8 9 10 11 12
Estimation of light loss at fiber bending			
Fabrication and testing of samples with different optical cement options			
Selection of final assembly components			
Fabrication of a three-layer base for the prototype			
Evaluation of rigidity and strength of the framework			
Development of 2 sector prototypes [2*7 tiles]			
Development of trigger counters for tests			
Calibrating the energy scale of DT5202			
Determining the optimum thresholds for DT5202			
Temperature dependence estimation and its consideration in tests			
Test of prototypes with cosmics		1 2	
Data analysis and interpretation of results			
Tests with SiPM Hamamatsu (1.3x1.3 mm^2)			
Development of the inner part of the detector			
Development of mapping			
Development of 2-rings detector prototype [2*(7*16) =224 tiles]			
Fabrication of frame for prototype			
Fabrication of a five-layer base for the prototype			
Implementation of composite bushings for fasteners, and milling			
Installing the base into the frame			
Design and manufacture of optical connector modules (WLS <-> transparent fiber)			
Design and manufacture of connectors (transparent fiber <-> SiPM)			
Design and manufacture of PCB for SiPMs			
Testing connectors and PCBs			
Prototype beam test			
Beam test data analysis			
Coordinating the output of the detector cables to the BBC control room			
Assembly of 2 rings of a full-scale detector			
Fabrication of frame (2 parts)			
Fabrication of a five-layer base for the detector			
Implementation of composite bushings for fasteners, and milling			
Installing the base into the frame			
Full test of chambers			
full-test data analysis			
Disassembling the detectors			
Transferring detectors to SPD			
Assembling the detectors			
Functional checks and tests			