GLAST Large Area Telescope:

Tracker Subsystem
WBS 4.1.4

Tracker Status Overview

Robert Johnson
Santa Cruz Institute for Particle Physics
University of California at Santa Cruz
Tracker Subsystem Manager

rjohnson@scipp.ucsc.edu
Outline

- CDR Design
- Engineering Model Status
  - EM Mechanical/Thermal Tower
  - Mini-Tracker Tower
- Flight Fabrication Status
  - SSD Receiving and Ladder Production
  - Tray Panel Production
  - ASICs and MCM Production
  - Tray Assembly
- Milestones
CDR Tracker Design

New Features:
- Copper thermal straps
- Greatly reinforced bottom tray
Bottom Tray Reinforcing

- Pins (Reinforce Butt-Joint)
- MCM Closeout Wall
- Structural Closeout Wall
- Bonded Butt-Joint
- Corner Reinforcement Bracket (Bonded)
- M55J/RS-3 Internal Frame
- C-C Outside Laminate
Engineering Model Tracker Module, upside down in the assembly fixture.

This photo was taken at G&A before installation of the readout cables and sidewalls.
Bottom-Tray Static Test

- Thermal/Mechanical Sidewalls (YS-90A)
- Tower Simulator with this sidewall removed
- Tray #2 (from prototype tower)
- Bottom Tray (SN 2)
Bottom-Tray Static Test

• Tests equivalent to the maximum loads from the random vibration levels were successful in the vertical and horizontal axes, including the xy direction (not shown).
• Testing this month will simulate the coupled-loads analysis maximum flexure loads.
EM Sidewalls

• Our first attempt at K13D sidewalls failed
  – Drawings lacking sufficient clarity and specifications
  – Resin loss at panel edges
  – Problems obtaining good or valid coupon test results
• A major program has been underway since then to correct these problems
  – New coupon tests at Plyform (photo)
  – Updated drawings and specifications with extensive review by composites experts
  – New prepreg orders and fabrication of new EM sidewalls by mid to late October.
Mini-Tracker Tower

3x, 3y SSD layers.

2\textsuperscript{nd} iteration MCM assembly with “flight” ASICs.

2\textsuperscript{nd} iteration flex-circuit cables with “flight” connectors.

4 of 5 trays are the same as in the 1\textsuperscript{st} Mini-Tracker, but with improved core grounding.
Encapsulation is being improved with a dam along the pitch adapter, which allows wire bonds to be covered in one application.

Pitch adapter attachment was not up to specs, making wire bonding to SSDs difficult; improvements are ongoing.
# Mini-Tracker Issues

## Time-Outs
- GTRC fails to send its data if a trigger-acknowledge signal from the TEM arrives 2, 3, or 4 clock cycles before the falling edge of the TOT.
- The problem can be avoided by disabling the TOT in the GTRC configuration register, but then we have no TOT information.
- Work is in progress to fix the design and fabricate new GTRCs, but schedule exigencies may not allow us to delay MCM fabrication until new wafers are ready, tested, and diced.

## Bias Bonds
- Ladders are normally connected to bias on both sides, but an incompatibility of the new MCMs and old bias circuits in the Mini-Tracker allowed edge ladders to be connected on only one side.
- This single wire bond failed on one edge ladder, resulting in a nonfunctional ladder.
- In flight production we will double these bonds, giving 4 per ladder, and all bonds will be encapsulated.
Example Cosmic Ray

GLAST LAT Project

September 15, 2003

Event #: 702 Event Tag: 0

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Total number of ship hits: 6

CAL Energy Scale in ADC counts

Example Cosmic Ray
Tracker Production Overview

Module Structure Components
SLAC: Ti parts, thermal straps, fasteners.
Italy (Plyform): Sidewalls

SSD Procurement, Testing
Japan, Italy (HPK)

SSD Ladder Assembly
Italy (G&A, Mipot)

Tracker Module Assembly and Test
Italy (Alenia Spazio)

Tray Assembly and Test
Italy (G&A)

Electronics Fabrication, burn-in, & Test
UCSC, SLAC (Teledyne)

Composite Panel, Converters, and Bias Circuits
Italy (Plyform): fabrication
SLAC: CC, bias circuits, thick W, Al cores

Readout Cables
UCSC, SLAC (Parlex)
SSDs and Ladder Assembly

- All SSDs have been manufactured at HPK.
- Enough SSDs have been procured and tested to fabricate the full flight instrument.
- Ladder assembly is in progress at both G&A and Mipot.
- Enough ladders have been assembled and tested to build a few towers.
Tray Panel Fabrication

- Machining of the Carbon-Carbon closeout material is just starting.
- Face sheets, cores, inserts, and tungsten are in hand.
- Bias circuits are out for quote.
- PRR actions are being closed.
ASICs & MCM Assembly

- GTFE and GTRC ASIC wafers have been fabricated, tested, lapped diced, and inspected. The yield is about 95%.
- Successful radiation testing completed, including SEE (INFN Padova)
- New GTRC wafers will probably be made, but preproduction of MCMs will start in a few weeks with existing chips.
- Tests of production details modified since the previous Mini-Tracker Tower MCM assembly are being tested at Teledyne this week.
- Preproduction printed wiring boards are being manufactured at DDI (we rejected the first iteration, but that problem was resolved).
- MCM test system is updated and nearly ready for flight production.
- MCM burn-in system is close to being ready for first tests at SLAC.
- Production Readiness Review (PRR) is still needed.
Tray Assembly

- Ladder attachment development is complete and works well.
- Some process details for MCM mounting, wire bonding, and encapsulation are being finalized with continuing testing at G&A.
- Preparations for a PRR are in progress (documentation).
Other Tasks...

- Flex circuit cables
  - Interface issues and exact length are being intensively worked at SLAC
- Tray testing with cosmic rays (4 stations in Italy)
  - Software scripts are being developed on the Mini-Tracker Tower
  - 4 EGSE systems, cables, and some special hardware still need to be procured or fabricated
- Tower assembly
  - Basic fixture worked well with the EM tower
  - Needs still some more development for safety and tower rotation
  - Documentation and PRR
- Tower functional testing
  - Software scripts are similar to those needed for tray testing
- Environmental testing
  - EM vibration plan is close to completion; need pretest review
  - Still need a lot of work on the thermal-vacuum plan; review
- Shipping
  - Prototype container is in hand; needs analysis, testing and review
Near-Term Milestones

- New EM sidewalls: end of October
- Completion of EM environmental testing: Christmas
- Completion of the MCM preproduction: end of November
- First flight-like trays: Christmas

- Additional engineering manpower recently added by SLAC to help ensure success as we move into flight production (all with extensive experience in space-flight programs):
  - Roger Williams    Test engineer
  - Nanda Menon      QA liaison between SLAC & Italy
  - David Rich       Tracker system engineering for flight manufacturing and test