

Figure 4: measured BL error of bending magnets.

COD. On the other hand, the COD correction is easier at low energy from the point of view of the limited corrector strength. Therefore we decided to shuffle BMs in order to minimize the COD at 50 GeV energy.

The cod by  $\Delta BL / BL$  is written as,

$$x_{cod}(s) = \frac{\sqrt{\beta(s)}}{2 \sin \pi \nu} \sum_i \sqrt{\beta_i} \frac{(\Delta BL)_i}{B \rho} \cos(\pi \nu + |\psi(s) - \psi_i|) \quad (1)$$

where,  $\beta(s)$  and  $\psi(s)$  are beta function and betatron phase at position  $s$ ,  $\beta_i$  and  $\psi_i$  are beta function and betatron phase at the  $i$ th BM, respectively, and  $\nu$  is horizontal tune. Our position shuffling scheme of the BMs is as followed. One module in the arc section has 4 BMs and a horizontal phase advance of 270 deg. Therefore phase advance between the  $i$ th and  $(i+8)$ th BMs in the arc section is 540 deg. A pair with similar  $\Delta BL$  at 50 GeV energy is chosen and assigned at the  $i$ th and  $(i+8)$ th BM positions. Contribution to COD by this pair can be cancelled each other from Eq. (1).

The COD made by the  $\Delta BL$  deviation of all QMs was obtained from the SAD code. The (a) and (b) in Figure 5 show the CODs without shuffling along the whole ring. In this case, BMs are arranged in the ring in serial number order. The COD (b) for 50 GeV is larger than that (a) for 3 GeV, which is due to the difference of  $\Delta BL/BL$  spread for 50 GeV and 3 GeV energies. The maximum horizontal COD at 50 GeV is roughly 5 mm. As seen in Figure 5 (d), the COD is drastically reduced by the shuffling. The magnitude of COD (c) at 3 GeV is same as (a) without shuffling. This is due to no correlation

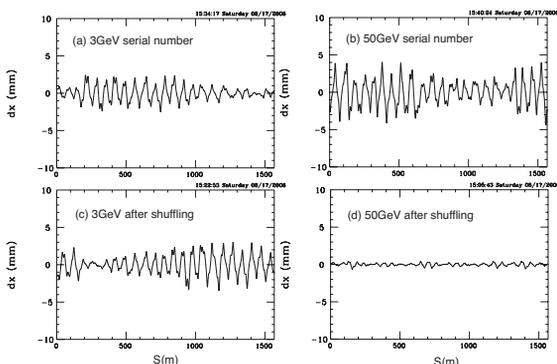


Figure 5: COD by  $\Delta BL/BL$  spread of the BMs.

between  $\Delta BL/BL$  distributions at 3 GeV and 50 GeV (see Figure 4).

### QM SHUFFLING

Figure 5 shows measured  $\Delta B'L/B'L$  distributions of the QFN family. The standard deviation  $\sigma$  of  $\Delta B'L/B'L$  for 100A and 1100A are 0.00027 and 0.00046, respectively. The electric currents of 100A and 1100A correspond to roughly 3 GeV and 40 GeV energies. The spread for 1100 A is larger than that of the 100A. We estimate that it is also caused by the field saturation. The magnets in other family show a similar tendency.

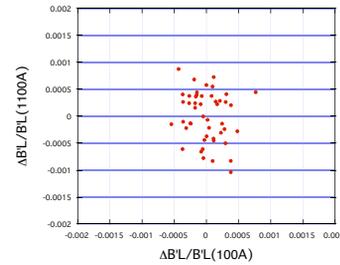


Figure 6: Measured  $\Delta B'L/B'L$  distribution for the QFN.

The deviation  $\Delta B'L/B'L$  of the quadrupole magnets makes a half integer stop band and causes  $\beta_x$  and  $\beta_y$  modulation. The horizontal and vertical stop band  $J_{Px}$  and  $J_{Py}$  are given by

$$J_{Px} = \frac{1}{2\pi} \sum_i \beta_{xi} \frac{(\Delta B'L)_i}{B \rho} \exp(-iP_x \phi_{xi}) \quad (2)$$

$$J_{Py} = \frac{1}{2\pi} \sum_i \beta_{yi} \frac{(\Delta B'L)_i}{B \rho} \exp(-iP_y \phi_{yi}) \quad (3)$$

where  $P_x$  and  $P_y$  are horizontal and vertical harmonic numbers,  $\phi_{xi}$  and  $\phi_{yi}$  are the horizontal and vertical position angles in the ring for the  $i$ th quadrupole magnet. A pair of magnets in the same family are placed so as to cancel  $J_{Px}$  for the QF family and  $J_{Py}$  for the QD family. For example, in case of the QFN, a pair with the same  $|\Delta B'L/B'L|$  and opposite sign are arranged at the  $i$ th and the  $(i+4)$ th positions with 540 deg horizontal phase advance. The shuffling was performed for the field data corresponding to 40-50 GeV, since the spread of  $\Delta B'L/B'L$  at the high field is larger that of the low field as shown in Figure 6.

Figure 7 shows the  $\beta$ -modulation  $\Delta\beta/\beta$  after the shuffling of all family, which were calculated by the SAD code. The calculated  $\beta$ -modulation is less than 1% and that for 40 GeV is slightly less than that for 3 GeV.

### SEXTUPOLE SHUFFLING

The deviation  $\Delta B''L/B''L$  of the sextupole magnets for the chromaticity correction excites the third order resonance. The related harmonics can be reduced by the position shuffling of the sextupole magnets. The slow extraction using the third integer resonance ( $3Q_x=67$ ) has

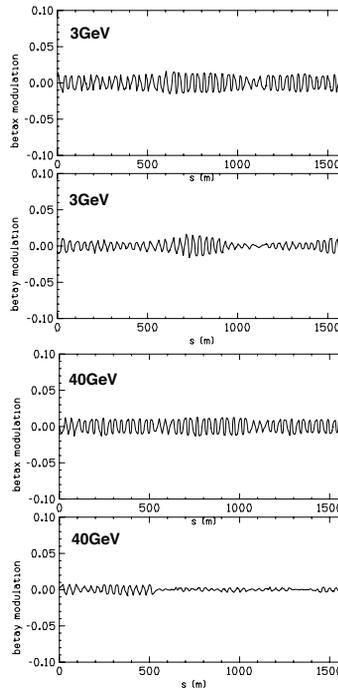


Figure 7: The  $\beta_x$  and  $\beta_y$  modulations after shuffling.

been adopted for the MR. The shuffling scheme was determined to minimize the 67th harmonics at the operation energy for the slow extraction. Figure 7 shows the measured  $\Delta B''L/B''L$  distribution for 50A and 200A, which roughly correspond to 3 and 30 GeV energies, respectively. This distribution shows the correlation between them. Similar tendency is seen also for the 400A. The standard deviation  $\sigma$  of  $\Delta B''L/B''L$  for 50A, 200A and 400A are 0.00096, 0.00075 and 0.00089, respectively.

Sextupole field measurements were divided into 3 batches with each 24 magnets. The 24 magnets in each batch were assigned in the same arc. These assigned magnets are classified into the SFA, SDA and SDB family.

Fourier amplitude  $\delta$  and the phase  $\xi$  of  $3Q_x=P_x$  is given by

$$\delta e^{i\xi} = \frac{\sqrt{2}}{24\pi} \sum_i \left[ \frac{B''L}{B\rho} \beta_x^{\frac{3}{2}} \right]_i \times e^{i\Phi_i} \quad (4)$$

$$\Phi_i = 2\pi[3\mu_x - (3Q_x - P_x) \frac{\theta_i}{C}] \quad (5)$$

where  $\mu_x$  is the ring tune,  $\theta_i$  is the angle of the  $i$ th magnet, and  $C$  is the circumference of the ring. A pair of magnets with the similar  $\Delta B''L/B''L$  in the classified family is placed so as to cancel  $\delta$  in Eq. (4) each other.

Table 1: Fourier amplitude $\delta$ of $3Q_x=67$ resonance.			
current (A)	50	200	400
$\delta$ (serial number order)	0.0019	0.0016	0.0033
$\delta$ (after shuffling)	0.0007	0.0003	0.0009

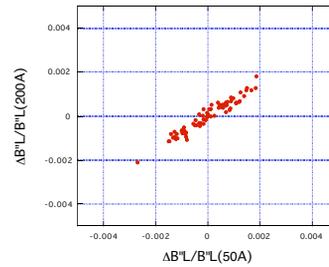


Figure 8: Measured field error distribution of sextupole magnets.

Table 1 is the comparison of the Fourier amplitude  $\delta$  obtained by the arrangement of the serial number and the position shuffling above mentioned. The amplitude  $\delta$  is reduced by the shuffling.

### CONCLUSIONS

Position shuffling for the bending, quadrupole and sextupole magnets has been performed from the results of field measurements and the installation of all magnets into the tunnel has started.

The COD caused by the deviation  $\Delta BL/BL$  of the BMs is reduced from 5 mm to 0.4 mm at a high energy by the shuffling.

The shuffling for the quadrupole magnets has been performed so as to reduce the half integer stop band each family. Resultant  $\beta$ -modulation is  $\sim 1\%$  at the nominal operating tune.

Sextupole shuffling reduces the amplitude of  $3Q_x=67$  resonance by several factor.

### ACKNOWLEDGMENT

The authors would like to thank S. Ohnuma for his helpful advice on the shuffling strategy.

### REFERENCES

- [1] Accelerator Group JAERI/KEK Joint Project Team, "Accelerator Technical Design Report for J-PARC", KEK Report 2002-13, March 2003.
- [2] K. Niki, K. Ishii, Y. Nemoto, E. Yanaoka and M. Muto, "Results of Field Measurements for J-PARC Main Ring Magnets", these proceedings.