

Traveler Title	SNS-PPU Cavity Tuner Assembly Inspection Traveler			
Traveler Abstract	Outlines the inspection steps for tuner assemblies received from the vendor			
Traveler ID	SNSPPU-CM-INSP-TUNC			
Traveler Revision	R1			
Traveler Author	N. Huque			
Traveler Date	17-Mar-20			
NCR Informative Emails	edaly			
NCR Dispositioners	Huque,fischer			
D3 Emails	Huque,fischer			
Approval Names	N. Huque	M. Wiseman	A. DeKerlegand	E. Daly
Approval Signatures				
Approval Dates				
Approval Title	Author	Reviewer	Reviewer	Project Manager

References	List and Hyperlink all documents related to this traveler. This includes, but is not limited to: safety (THAs, SOPs, etc), drawings, procedures and facility related documents.		
	104111400-M8U-8200-A001	SNS-PPU Cavity Tuner Assembly Spares	
	104211400-M8U-8200-A001 SOW	CMM – 104211400-M8U-8200-A050	JL0093052
	CMM – 104211400-M8U-8200-A035	CMM – 104211400-M8U-8200-A002	

Revision Note	
R1	Initial release of this Traveler.

Step No.	Instructions	Data Input
1	Technician Name	[[TechName]] <<SRF>>
	Date of Inspection	[[InspTime]] <<TIMESTAMP>>
	Serial Number of part	[[TUNCSN]] <<TUNCSN>>
	Are all parts in the BOM of 104122400-M8U-8200-A001 included in the package?	[[BOMYesNo]] <<YESNO>> [[BOMComm]] <<COMMENT>> [[BOMFile]] <<FILEUPLOAD>>
	Are all the spare parts listed in SNS-PPU Cavity Tuner Assembly Spares included in the package?	[[SprYesNo]] <<YESNO>> [[SprComm]] <<COMMENT>> [[SprFile]] <<FILEUPLOAD>>
	Check for damage to Tuner Frame body. Check for any obvious signs of weld spatter on body. Upload photos if damage found	[[DamPhoto]] <<FILEUPLOAD>> [[DamComm]] <<COMMENT>>
	Check for any excessive amounts of grease or other residue on the components which may warrant additional cleaning. Upload photos of any issues.	[[CleanPhoto]] <<FILEUPLOAD>> [[CleanComm]] <<COMMENT>>
	Do Items 2 and 4 move freely in relation to Item 1 (on 104122400-M8U-8200-A001) with no resistance or binding in the bearings?	[[MovYesNo]] <<YESNO>> [[MovComm]] <<COMMENT>> [[MovFile]] <<FILEUPLOAD>>
	Fit the main tuner body on to the Tuner Inspection Gauge Assy (JL0093052). Does the assembly go on without requiring excessive lateral force on the supports (Item 9 on 104122400-M8U-8200-A001)?	[[FitYesNo]] <<YESNO>> [[FitComm]] <<COMMENT>> [[FitFile]] <<FILEUPLOAD>>

Step No.	Instructions	Data Input		
2	Extended Inspection (to be performed on one unit per lot)			
	Will this unit undergo extended inspection?	[[ExtendYN]] <<YESNO>>		
	Disassemble the tuner to measure the following components: 104211400-M8U-8200-A050 – FRAME 104211400-M8U-8200-A035 – SECONDARY LEVER-ACTUATOR 104211400-M8U-8200-A002 – PRIMARY LEVER	[[InspTechName]] <<USERNAME>> [[ExtInspTime]] <<TIMESTAMP>>		
	Dimensional Inspection			
	Dimension Location	Nominal	Tolerance	
	CMM – 104211400-M8U-8200-A050			
	E6	15.63	+/- 0.010	[[Dim1_050]] <<FLOAT>> [[Dim1_050]] <<COMMENT>>
	E5	2.87	+/- 0.010	[[Dim2_050]] <<FLOAT>> [[Dim2_050]] <<COMMENT>>
	D4	5.990	+/- 0.005	[[Dim3_050]] <<FLOAT>> [[Dim3_050]] <<COMMENT>>
	C6	12.664	+/- 0.005	[[Dim4_050]] <<FLOAT>> [[Dim4_050]] <<COMMENT>>
	B4	0.591	+/- 0.005	[[Dim5_050]] <<FLOAT>> [[Dim5_050]] <<COMMENT>>
	B5	0.59	+/- 0.010	[[Dim6_050]] <<FLOAT>> [[Dim6_050]] <<COMMENT>>
	Dimension Location	Nominal	Tolerance	
	CMM – 104211400-M8U-8200-A035			
	D7	5.83	+/- 0.010	[[Dim1_035]] <<FLOAT>> [[Dim1_035]] <<COMMENT>>
	D6	2.25	+/- 0.010	[[Dim2_035]] <<FLOAT>> [[Dim2_035]] <<COMMENT>>
	D4	6.81	+/- 0.010	[[Dim3_035]] <<FLOAT>> [[Dim3_035]] <<COMMENT>>

	B5	1.260	+/- 0.005	[[Dim4_035]] <<FLOAT>> [[Dim4_035]] <<COMMENT>>
	Dimension Location	Nominal	Tolerance	
	CMM – 104211400-M8U-8200-A002			
	F5	1.73	+/- 0.010	[[Dim1_002]] <<FLOAT>> [[Dim1_002]] <<COMMENT>>
	D5	0.59	+/- 0.010	[[Dim2_002]] <<FLOAT>> [[Dim2_002]] <<COMMENT>>
	D6	16.06	+/- 0.010	[[Dim3_002]] <<FLOAT>> [[Dim3_002]] <<COMMENT>>