|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| Traveler Title | Inspection for SNSPPU 8 pin Cryogenic Feedthrus | | | |
| Traveler Abstract | Traveler to provide the necessary steps to perform receiving inspection on 8 pin feedthrus. To include visual, electrical, cold shock, and leak check. | | | |
| Traveler ID | SNSPPU-CM-INSP-ELFT | | | |
| Traveler Revision | R1 | | | |
| Traveler Author | Peter Owen | | | |
| Traveler Date | 01-08-2020 | | | |
| NCR Emails | King, Fischer, Owen | | | |
| Approval Names | Peter Owen | John Fischer | Larry King | Ed Daly |
| Approval Date |  |  |  |  |
| 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. | | | |
| **CRM1207014-0001-** CAVITY STRING, OUTSIDE THE CLEANROOM | [JLAB SPEC 11141S0029 SMALL ITEMS LEAK CHECK](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-25381/JLAB_SPEC_11141S0029_Rev%20A.pdf) | [JLAB SPEC 11141S0101 CRYOGENIC INSTRUMENTATION FEEDTHRU 8 CONDUCTOR](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-34667/11141S0101%208PIN%20CRYO%20SPEC.docx) | Solid Sealing Technology Dwg. KT25618SL |  |
| Part # KT25618 |  |  |  |  |

|  |  |
| --- | --- |
| Revision Note |  |
| R1 | Initial release of this Traveler. |

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| 1 | Inventory received items. Part KT25618, includes 1 cryogenic 8 pin feedthru, 2 ceramic plug inserts, 1 ceramic spacer, 8 pins PN/KT25618 | [[InspectionTechnician]] <<SRF>>  [[Date]] <<TIMESTAMP>>  [[InventoryComplete]] <<YESNO>>  [[Comment]] <<COMMENT>> |
|  | | |
| 2 | Serialize feedthrus on o.d. of CF flange. Use part no, and sequential numbering. Do not duplicate.  i.e.- KT25618-01, KT25618-02, …. | [[InspectionTechnician2]] <<SRF>>  [[Date2]] <<TIMESTAMP>>  [[Comment2]] <<COMMENT>>  [[Feedthru Serial Number2]] <<ID>> |
| 3 | Visually inspect feedthru.  Is part clean, free from dust, oil, finger prints, or brazing residue  Pins straight on either end  Knife edge good  Carefully test fit ceramic plugs into either end  Note any non conformances. | [[Technician3]] <<SRF>>  [[Date3]] <<TIMESTAMP>>  [[Comment3]] <<COMMENT>> |
| 4 | Electrically check all pins to the feedthru case and pin continuity through ceramic, using DVM and fabbed harness. | [[ElectricalTechnician4]] <<SRF>>  [[Date4]] <<TIMESTAMP>>  [[Comment4]] <<COMMENT>> |
| 5 | Leak check feedthru to JLAB Specification 11141S0029 “Leak Check of Small Items”. Leak Rate not to exceed 1e-10 atm cc/sec of He. | [[LeakCheckTechnician5]] <<SRFCMP>>  [[Date5]] <<TIMESTAMP>>  [[LeakCheckGood5]] <<YESNO>>  [[Comment5]] <<COMMENT>> |
| 6 | Cold Shock the feedthru.  Perform in the VTA  Place the feedthru in a stainless steel basket suspended in test stand. Wire each feedthru to basket.  Cool down to 4K, mimicking the standard rate, ~ room temp to 4K in 1 hour.  Fill the dewer enough to cover the sample in LHe.  Warm to room temperature; repeat 2 additional times. Total of 3 cycles. | [[VTATechnician6]] <<SRF>>  [[Date6]] <<TIMESTAMP>>  [[Comment6]] <<COMMENT>> |
| 7 | Blow off, re-leak check feedthru to JLAB Specification 11141S0029 “Leak Check of Small Items”. Leak Rate not to exceed 1e-10 atm cc/sec of He. | [[LeakCheckTechnician7]] <<SRFCMP>>  [[Date7]] <<TIMESTAMP>>  [[LeakCheckGood7]] <<YESNO>>  [[UploadStripChart7]] <<FILEUPLOAD>>  [[Comment7]] <<COMMENT>> |