|  |  |
| --- | --- |
| Traveler Title | CEBAF Cryomodule HOM Load (2015 C75 design) Flange Receiving Inspection |
| Traveler Abstract | This traveler details the steps required to dimensionally inspect a CEBAF HOM Load Flange (2015 design). |
| Traveler ID | C75-CPR-INSP-HMR |
| Traveler Revision  | R1 |
| Traveler Author | Aaron DeKerlegand |
| Traveler Date | 21-May-20 |
| NCR Informative Emails | Forehand, Macha, Ciovati, Scott |
| NCR Dispositioners | Forehand, Macha, Ciovati, Scott |
| D3 Emails | Forehand, Macha, Ciovait, Scott |
| Approval Names | A. DeKerlegand | S. Williams | K. Macha |  |
| Approval Signatures |  |  |  |  |
| Approval Dates |  |  |  |  |
| Approval Title | Author | 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. |
| HOM Absorber Flange | [JL0024623](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-162806/JL0024623_A_HOM%20ABSORBER%20FLANGE.pdf) |  |  |  |
|  |  |  |  |  |

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

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| 1 | ***RECEIVING INSPECTION.*** Assign a serial number to Hom Load by engraving serial number on the side of the flange and then selecting that number in the drop down box. | [[HOMLOADSN]] <<HOMLOADSN>>[[ENGRAVERTECH1]] <<USERNAME>> |
| 2 | Visually inspect the flange for scratches, pits, stains, damage or any other flaws within the indium seal path surface.Visual okay? Select yes or no. | [[VISUALTECH1]] <<USERNAME>>[[VISUALDATE1]] <<TIMESTAMP>>[[VISUALCOMMENT1]] <<COMMENT>>[[VisualOK]] <<YESNO>>[[AdditionalFiles1]] <<FILEUPLOAD>> |

|  |  |  |
| --- | --- | --- |
| 3 | Dimensional check. Dimensions are in Inch. Measure the surface finish with the Mitutoyo Profilometer. Carefully check four corners outside of the seal path to prevent any profilometer marks in or near seal. Then with CMM check the diameter and positions of holes. Also, check flatness of the indium sealing surface and flange thickness. | [[CMMTECH2]] <<USERNAME>>[[CMMDATE2]] <<TIMESTAMP>>[[CMMCOMMENTS2]] <<COMMENT>>[[AdditionalFiles2]] <<FILEUPLOAD>> |
| **Drawing Number** | **Description** | **Drawing Value**  | **Tolerance** | **Measured Value** | **Within Tolerance** |
| JL0024623 | Surface finish | 32 microinch  | Max 32 microinch | [[MeasValue1]] <<FLOAT>> | [[Tolerance1]] <<YESNO>> |
| JL0024623 | Surface finish | 32 microinch | Max 32 microinch | [[MeasValue2]] <<FLOAT>> | [[Tolerance2]] <<YESNO>> |
| JL0024623 | Surface finish | 32 microinch | Max 32 microinch | [[MeasValue3]] <<FLOAT>> | [[Tolerance3]] <<YESNO>> |
| JL0024623 | Surface finish | 32 microinch | Max 32 microinch | [[MeasValue4]] <<FLOAT>> | [[Tolerance4]] <<YESNO>> |
| JL0024623 | Flatness | .002 | Max .002 | [[MeasValue5]] <<FLOAT>> | [[Tolerance5]] <<YESNO>> |

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| 3 | CONTINUED step from previous page. Dimensional check. With the CMM check the diameter and positions of holes. Also, check the flange thickness.Dimensions are in INCH. | [[CMMTECH3]] <<USERNAME>>[[CMMDATE3]] <<TIMESTAMP>>[[CMMCOMMENTS3]] <<COMMENT>>[[AdditionalFiles3]] <<FILEUPLOAD>> |
| **Drawing Number** | **Description** | **Drawing Value**  | **Tolerance** | **Measured Value** | **Within Tolerance** |
| JL0024623 | Thickness | .750 | +/- .010 | [[MeasValue6]] <<FLOAT>> | [[Tolerance6]] <<YESNO>> |
| JL0024623 | Hole diameter (12x) | .270 Thru | +/- .010 | [[MeasValue7]] <<FLOAT>> | [[Tolerance7]] <<YESNO>> |
| JL0024623 | Hole position (4x) | 1.250 | +/- .010 | [[MeasValue8]] <<FLOAT>> | [[Tolerance8]] <<YESNO>> |
| JL0024623 | Hole position (4x) | 2.00 | +/- .010 | [[MeasValue9]] <<FLOAT>> | [[Tolerance9]] <<YESNO>> |
| JL0024623 | Hole position (4x) | 1.00 | +/- .010 | [[MeasValue10]] <<FLOAT>> | [[Tolerance10]] <<YESNO>> |