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| Traveler Title | SNS PPU Spaceframe Inspection Traveler | | | |
| Traveler Abstract | Traveler defines inspection process for the SNS PPU Spaceframe | | | |
| Traveler ID | SNSPPU-CST-INSP-SFR | | | |
| Traveler Revision | R1 | | | |
| Traveler Author | M. Marchlik | | | |
| Traveler Date | 16-Jun-20 | | | |
| NCR Informative Emails | Edaly,areilly | | | |
| NCR Dispositioners | marchlik,kwilson | | | |
| D3 Emails | Marchlik,kwilson | | | |
| Approval Names | M. Marchlik | K. M. Wilson | A. DeKerlegand | E.F. Daly |
| Approval Signatures |  |  |  |  |
| Approval Dates |  |  |  |  |
| Approval Title | Author | Reviewer | Reviewer | Project Manager |

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| --- | --- | --- | --- |
| 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. | | |
| 104210900-M8U-8200-A002 (SPACE FRAME ASSEMBLY-WELDMENT) | | 104210900-M8U-8200-A001 (SPACEFRAME ASSY) | CRM9005000-0016 (ROD END DETAIL) |
| CRM9005000-0011 (32.5 IN. AXIAL RESTRAINT ROD ASSY) | | CRM9005000-0019 (33.50 IN. AXIAL RESTRAINT ROD ASSY) |  |

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

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| Step No. | Instructions | Data Input |
| **General handling guidelines:** The spaceframe shall be handled according to standard cleaning and handling practices. | | |
| 1 | **Initial Inspection:** | |
| Technician Name  Date of Inspection  Serial Number of part | [[TechName]] <<SRF>>  [[InspectionDate]] <<TIMESTAMP>>  [[SFRSN]] << SFRSN>> |
| Is the assembly clean, free from dust, oil, finger prints or other contaminants? | [[PartCleanOk]] <<YESNO>> |
| Verify that the wheel assemblies are installed correctly and that the wheels are free to rotate by hand. | [[WheelsOk]]<<YESNO>> |
| Verify that the nitronic rods are all accounted for and are free from bends or gouges and that the ends are installed and are undamaged, especially the threads.  Verify the lengths of the rods to be:   * CRM9005000-0019: 33.50” +/- .03” * CRM9005000-0019: 32.50” +/- .03” | [[RodsOk]]<<YESNO>> |
| Verify that the welds appear to be of good quality, no cracking or pitting is present, and that a ¼” gap has been left in one side of the tube to support ring welds. | [[WeldsOk]]<<YESNO>> |
| Verify that the support rings are oriented correctly as shown in section view B-B and C-C of 104210900-M8U-8200-A002. | [[Orient1Ok]]<<YESNO>> |
| Verify that the 16 nitronic rod slots are present in the support tubes and are oriented correctly as shown in the top view of 104210900-M8U-8200-A002. | [[Orient2Ok]]<<YESNO>> |

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| Step No. | Instructions | | | Data Input | |
| 2 | **Dimensional Inspection:** | | | | |
| Dimensionally inspect the spaceframe assemblies with serial numbers ending in 001, 003 and 006. | | | [[DimcheckOk]] <<YESNO>>  [[DimcheckComment]] <<COMMENT>> | |
| **Drawing Number** | | **Description** | **Drawing Value** | **Measured Value** | **Within Tolerance** |
| 104210900-M8U-8200-A002 | | Location of the support ring’s ¾-10 and ½-13 tapped holes. | .03” true position to datum A and B:   * 30.30” * 28.94” * 57.96” * 79.52” * 108.54” * 137.47” * 167.78” | [[MeasHolelocate]] <<FLOAT>> <<YESNO>> | |
| 3 | **Storage:** | | | | |
| Store the spaceframes in a clean and dry location and keep them covered to limit the amount of dust and debris that can accumulate on them. | | | [[StorageTech]] <<SRF>>  [[StorageDate]] <<TIMESTAMP>> | |