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| Traveler Title | SNS PPU Lockdown Inspection Traveler |
| Traveler Abstract | Traveler defines inspection process for the SNS PPU spaceframe lockdown studs |
| Traveler ID | SNSPPU-CST-INSP-LKDWN |
| Traveler Revision | - |
| Traveler Author | Matt Marchlik |
| Traveler Date | 12-May-20 |
| NCR Informative Emails | Marchlik, kwilson, edaly |
| NCR Dispositioners | marchlik, kwilson, edaly |
| D3 Emails |  |
| 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. |
| 104110000-M8U-8200-A252-Rev0 (3/4-10 LOCKDOWN STUD) | 104110000-M8U-8200-A251-Rev0 (1/2-13 LOCKDOWN STUD) |
| 104210800-M8U-8200-A030-Rev- (3/4-10 LOCKDOWN STUD W/ ½-13 HOLE) |

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

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| Step No. | Instructions | Data Input |
| **General handling guidelines:** The threads of the lockdowns should be protected against damage. They should be handled according to standard cleaning and handling practices. |
| 1 | **Initial Inspection:** |
| Technician NameDate of InspectionSerial Number of part | [[TechName]] <<SRF>>[[InspectionDate]] <<TIMESTAMP>>[[LKDWNSN]] << LKDWNSN>> |
| Is part clean, free from dust, oil or other contaminants? | [[PartCleanOk]] <<YESNO>> |
| Are the threads either silver plated or Dicronited? | [[PlatingOk]] <<YESNO>> |
| Verify that the male threads are free from damage and that either a ½-13 or ¾-10 nut threads onto the stud easily. | [[ThreadOk]]<<YESNO>> |
| Verify that a ½-13 silicon bronze screw threads easily into the hole of 104210800-M8U-8200-A030. | [[holeOk]]<<YESNO>> |
| Comments:Upload photos of any damage. | [[VisualInspComment]] <<COMMENT>>[[VisualInspPhoto]] <<FILEUPLOAD>> |
| 2 | **Dimensional Inspection:** |
| Dimensionally inspect the lockdowns against the reference drawings listed above. Record the serial numbers and calibration information for all measurement equipment used if applicable. Only a select number of lockdowns are to be dimensionally inspected:104110000-M8U-8200-A251SN: 001, 026, 052, 078, 104 and 126104110000-M8U-8200-A252SN: 001, 014 and 028104210800-M8U-8200-A030SN: 001, 007 and 014 | [[DimcheckOk]] <<YESNO>>[[DimcheckComment]] <<COMMENT>> |
| Calibration Info |
| [[Part\_CalName]] <<TEXT>>[[Part\_CalDate]] <<TIMESTAMP>>[[Part\_CalSN]] <<SN>> |
| **Drawing Number** | **Description** | **Drawing Value** | **Measured Value** | **Within Tolerance** |
| 104110000-M8U-8200-A251 | Length | 2.80 +/- .03” | [[Length]] <<FLOAT>> <<YESNO>> |
| Thread Length | 1.00 +/- .03 | [[TLength]] <<FLOAT>> <<YESNO>> |
| Shoulder diameter | .875 +/- .010” | [[Diameter]] <<FLOAT>> <<YESNO>> |
| 104110000-M8U-8200-A252 | Length | 3.00 +/- .03” | [[Length]] <<FLOAT>> <<YESNO>> |
| Thread Length | 1.10 +/- .03” | [[TLength]] <<FLOAT>> <<YESNO>> |
| Shoulder diameter | 1.25 +/- .010” | [[Diameter]] <<FLOAT>> <<YESNO>> |
| 104210800-M8U-8200-A030 | Length | 3.00 +/- .03” | [[Length]] <<FLOAT>> <<YESNO>> |
| Thread Length | 1.10 +/- .03” | [[TLength]] <<FLOAT>> <<YESNO>> |
| Shoulder diameter | 1.25 +/- .010” | [[Diameter]] <<FLOAT>> <<YESNO>> |
| 3 | **Storage:** |
| The tophats shall be repackaged and ensure the parts are sorted by part number | [[StorageTech]] <<SRF>>[[StorageDate]] <<TIMESTAMP>> |