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| Traveler Title | Waveguide Sweeps | | | |
| Traveler Abstract | This traveler covers incoming inspection of the Waveguide Sweeps | | | |
| Traveler ID | P1-CMA-SWEEP-INSP | | | |
| Traveler Revision | R1 | | | |
| Traveler Author | John Fischer | | | |
| Traveler Date | 06-Aug-2020 | | | |
| NCR Informative Emails | edaly,macha,areilly | | | |
| NCR Dispositioners | fischer | | | |
| D3 Emails | edaly,macha,areilly,fischer | | | |
| Approval Names | J. Fischer | K. Macha | A. Reilly |  |
| Approval Signatures |  |  |  |  |
| Approval Dates |  |  |  |  |
| Approval Title | Author | 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. | | | |
| [Waveguide Sweep Drawings](https://jlabdoc.jlab.org/docushare/dsweb/View/Collection-12863) | [SOW-CRM-120-7000-S-1028-RevA](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-61853/(SOW)-CRM-120-7000-S-1022-RevA%5b1%5d.pdf) |  |  |  |
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| Revision Note |  |
| R1 | Initial release of this Traveler. |

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| Step No. | Instructions | Data Input |
| 1 | **This inspection applies to all first articles and 10% of production units, with a minimum of one per shipment.**  **Note**: Handle these components with care. Avoid scratches or other damage to the flange faces.  Enter serial number of the waveguide sweep being inspected: | [[SWPSN]] <<SWPSN>> |
| 2 | Inspect shipping container for signs of damage.  If the container is damaged:   1. Describe damage in comment field. 2. Take a picture of the damage and attach file(s). | [[ContainerTech]] <<SRF>>  [[ContainerDate]] <<TIMESTAMP>>  [[ContainerGoodCondition]] <<YESNO>>  [[ContainerComment]] <<COMMENT>>  [[ContainerFiles]] <<FILEUPLOAD>> |
| 3 | Scan and upload all documentation that arrives with the waveguide sweeps. (**Note**: if there is no time to scan and upload documents, it is also acceptable to keep paper copies in a file for future scanning and uploading.) | [[DocumentTech]] <<SRF>>  [[DocumentDate]] <<TIMESTAMP>>  [[DocumentComment]] <<COMMENT>>  [[DocumentFile]] <<FILEUPLOAD>> |

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| Step No. | Instructions | Data Input |
| 4 | Visual inspection of waveguide sweeps. For all items, make a note in the comment field for any damage. Use a boroscope and/or camera to take a picture of any damage (or questionable areas) and attach file(s).  Enter technician name:  Enter date: | [[VisualTech]] <<SRF>>  [[VisualDate]] <<TIMESTAMP>> |
| * Surface finish of part is good; i.e., all interior surfaces and flange faces should be smoothly finished with no gouges, scratches or burrs in material. Exterior surfaces should not exhibit significant damage (small scratches, etc., are ok.) | [[SurfaceFinishOk]] <<YESNO>>  [[FinishComment]] <<COMMENT>>  [[FinishFiles]] <<FILEUPLOAD>> |
| * There should be no foreign material (finger prints, excessive dust, oil traces, etc.) on interior surfaces or flange faces. | [[SurfacesOk]] <<YESNO>>  [[SurfaceComment]] <<COMMENT>>  [[SurfaceFiles]] <<FILEUPLOAD>> |
| * Please verify that the count and part numbers of included hardware matches the Bill of Materials. (Note: item 2, air side IR sensor, is not included.) | [[BOMTech]] <<SRF>>  [[BOMDate]] <<TIMESTAMP>>  [[BOM\_OK]] <<YESNO>>  [[BOMComment]] <<COMMENT>> |
| * Welds are good; i.e., welds on ID of part should be smooth and flush, with no crevices, cracks or protrusions | [[WeldsOk]] <<YESNO>>  [[WeldsComment]] <<COMMENT>>  [[WeldsFiles]] <<FILEUPLOAD>> |
| * There should be no unusual discoloration to the base material, especially around the welds. | [[ColorationOk]] <<YESNO>>  [[ColorationComment]] <<COMMENT>>  [[ColorationFiles]] <<FILEUPLOAD>> |
| * Examine the knife edges on the flanges carefully. There should be no damage at all (including burrs, scratches, nicks, or foreign material) to the knife edge. | [[KnifeEdgeOk]] <<YESNO>>  [[KnifeComment]] <<COMMENT>>  [[KnifeFiles]] <<FILEUPLOAD>> |

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| Step No. | Instructions | | | Data Input |
| 5 | Verify the dimensions shown below. | | | [[DimensionalTech]] <<SRF>>  [[DimensionalDate]] <<TIMESTAMP>>  [[DimensionalComment]] <<COMMENT>>  [[DimensionalFiles]] <<FILEUPLOAD>> |
| Dimension | Nominal | Tolerance |  |
| Inside bore width (Check in several places.) | 0.986 in | ± 0.005 in | [[InsideBoreWDimOk]] <<YESNO>> |
| Inside bore height (Check in several places.) | 5.292 in | ± 0.005 in | [[InsideBoreHDimOk]] <<YESNO>> |
| Using drawing [FAC-400-5656-1016-REV-A](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-61854/FAC4005656-1016-REV-A-%5b1%5d.pdf), verify the locations and diameters of the bolt holes in both flanges.  Describe any discrepancies in the comment field. |  | ± 0.005 in | [[BoltHoleDimOk]] <<YESNO>> |
| 6 | Clean waveguide per Cleaning Procedure for the HTB Warm Waveguides. | | | [[WGDCleanTech]] <<SRF>>  [[WGDCleanDate]] <<TIMESTAMP>>  [[WGDCleanComment]] <<COMMENT>>  [[WGDCleanFiles]] <<FILEUPLOAD>> |
| 7 | Perform a leak check per note 5 of [FAC-400-5656-1016-REV-A.](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-61854/FAC4005656-1016-REV-A-%5b1%5d.pdf) | | | [[LeakCheckTech]] <<SRF>>  [[LeakCheckDate]] <<TIMESTAMP>>  [[LeakCheckPassed]]<<YESNO>>  [[LeakCheckComment]] <<COMMENT>>  [[LeakCheckFiles]] <<FILEUPLOAD>> |
| 8 | Repackage items using nitrogen to backfill a double nylon bag containing the part and store in designated location. | | | [[RepackageTech]] <<SRF>>  [[RepackageDate]] <<TIMESTAMP>>  [[RepackageComment]] <<COMMENT>>  [[RepackageFiles]] <<FILEUPLOAD>> |