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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/%28SOW%29-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>> |