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| Traveler Title | SNS PPU ½-13 Lockdown Inspection Traveler |
| Traveler Abstract | Traveler defines inspection process for the SNS PPU spaceframe lockdown studs |
| Traveler ID | SNSPPU-CST-INSP-LDS12 |
| Traveler Revision | - |
| Traveler Author | Matt Marchlik |
| Traveler Date | 20-Aug-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-A251-Rev0 (1/2-13 LOCKDOWN STUD) |

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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>>[[LDS12SN]] << LDS12SN>> |
| 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 a ½-13 nut threads onto the stud easily. Do not use a stainless steel nut. | [[ThreadOk]]<<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 126 | [[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>> |
| 3 | **Storage:** |
| The lock downs shall be repackaged and sorted by part number | [[StorageTech]] <<SRF>>[[StorageDate]] <<TIMESTAMP>> |