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| Traveler Title | LCLS-II HE HOM Feedthru Receiving Inspection |
| Traveler Abstract | LCLS-II HE HOM feedthru receiving inspection traveler, this is for the wrk center QA. |
| Traveler ID | L2HE-CAV-INSP-HMFT-S1 |
| Traveler Revision  | R1 |
| Traveler Author | HyeKyoung Park |
| Traveler Date | 26-Mar-2020 |
| NCR Emails | hkpark |
| Approval Names | HyeKyoung Park | George DeKerlegand | Katherine Wilson |  |
| Approval Signatures |  |  |  |  |
| Approval Dates |  |  |  |  |
| Approval Title | Author | Work Center 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. |
|  | Drawing GMM-9433A |  |  |  |
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| Revision Note |  |
| R1 | Initial release of this Traveler. |
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| Step No. | Instructions | Data Input |
|  | **HOM feedthru is an ultra high vacuum component. Wear talc free latex or Nitrile gloves at all times when handling this component**. |  |
|  | **CMM Room Inspections** |  |
| 1 | Visual inspection [CMM Room]* Select a serial number from the drop down menu and mark the number on the flange.
* Enter inspector name and date.
* Is part clean, free from dust, oil, finger prints, or brazing residue?
* Gasket sealing surface: smooth, free from burrs or nicks?
* Sapphire: free from cracks? Is there excess of braze material on the surface of sapphire?
* Surface of probe: free from scratches or stain?

The part passed the visual inspection?If the part does not pass visual inspection, provide a short description, take pictures and upload the file.  | [[HMFTSN]] <<HMFTSN>>[[Insp\_NAME\_SRF]] <<SRF>>[[Insp\_Date]] <<TIMESTAMP>>[[Vis\_Pass]] <<YESNO>>[[Vis\_Comment]] <<COMMENT>>[[Vis\_Pics]] <<FILEUPLOAD>> |
| 2 | Connector and pin checks [CMM Room]* Check thread fit with a standard N type connector.
* Check the pin’s braze integrity with a tweezer. There should be no rotation or axial movement but lateral flexibility is acceptable.
* Use the gauge and check the connector pin position.

Provide comments if any abnormality is observed. | [[Thread\_fit\_pass]] <<YESNO>>[[Pin\_braze\_pass]] <<YESNO>>[[Pin\_Pos\_pass]] <<YESNO>>[[Conn\_pin\_comment]] <<COMMENT>> |
| 3 | Dimensional checks [CMM Room] |  |
|  | **Description** | **Specified Dimensions: unit in mm (Min/Max)** |  |
|  | Flange seal surface to probe tip | 29.51/29.61 | [[Dim\_seal\_to\_tip]] <<FLOAT>> |
|  | Flange seal depth | 0.9/1.0 | [[Dim\_seal\_depth]] <<FLOAT>> |
|  | Probe tip diameter | 7.3/8.3 | [[Dim\_probe\_dia]] <<FLOAT>> |
|  | Probe perpendicularity (measured in degree) | 1.0 deg max | [[Dim\_perpendicularity]] <<FLOAT>> |
|  | Pin depth | 4.05/4.95 | [[Dim\_pin\_depth]] <<FLOAT>> |

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| Step No. | Instructions | Data Input |
|  | **QC Review** |  |
| 4 | This final inspection is visual and the purpose is to make sure there is no damage during cold cycle and leak check. Inspect for bent or broken connect pin and probe.Enter name and date of the final inspection.Review the cold cycle and leak check travelers.If all NCRs are closed and the feedthrough passes the final inspection, select YES for production relaease. Otherwise generate NCR. Deliver the feedthrough to the storage area.  | [[Final\_Insp\_Name]] <<SRF>>[[Final\_Insp\_Date]] <<TIMESTAMP>> [[Production\_realease]] <<YESNO>> |