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| Traveler Title | P1 Seven Cell Helium Tanked Cavity Transfer to Test Stand and Evacution and Leak Check |
| Traveler Abstract | This traveler verifies proper transfer of P1 Seven Cell Helium Tanked cavities to test stands for evacuation and leak check in preparation for VTA testing. |
| Traveler ID | P1-CLNRM-CAV-TSTD |
| Traveler Revision  | R1 |
| Traveler Author | C. Dreyfuss |
| Traveler Date | 7-Sep-20 |
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| NCR Dispositioners | D. Forehand, K. Davis, T. Ganey |
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| Approval Names | C. Dreyfuss | D. Forehand | T. Ganey |  |
| 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. |
|  | P100 Slow pumping ProcedureCP-JLAB-CAV-ASSEM-VAA-TSSPP |  |  |  |
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| Revision Note |  |
| R1 | Initial release of this Traveler. |

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| Stepp | Instructions | Data Input |
| 1 | At this point the cavity is fully assembled and torqued and ready to hang in test stand for pump-down and leak check. * Hang cavity and cage in the test stand with the back tech.
* Ensure cavity test stand is bled up and nitrogen is shut off on the test stand so N2 is not purging into the test stand while attaching cavity to test stand.
* Record cavity and test stand serial number.
* Re-torque all flanges before moving to the next step.
* Remove 2 ¾ blank from the down pipe of the test stand and wipe the lip of the bellows on the down pipe with an alcohol soaked wipe.
* Remove the temporary blank off the pump out port of the cavity.
* Using clean vacuum practices, install a new 2 ¾ copper gasket onto the cavity pump flange out and install the bellows from the test stand onto the cavity pump out port in one fluid motion( use two personnel or the two spring clamps you just removed to hold the bellows flange in place while installing fasteners).
* Install two bolts and nuts and snug down. Ensure the copper 2 ¾ gasket is correctly in place. Install the rest of the bolts and evenly tighten down the flange.
 | [[CAVSN]] <<CAVSN>>[[TestStand]] <<VTATSSN>>[[Technician]] <<SRFCVP>>[[Technician]] <<SRFCVP>>[[Comment1]] <<COMMENT>> |
| 2 | Pump Down of Cavity and Leak Test.* Follow the slow pump down procedure P100 Slow pumping Procedure to evacuate the cavity.
* Record the day/time of the pump down start.
* After cavity has reached 1.4E-06Mbar start the RGA filament.
* After cavity is at 2.0E-07Mbar start the elctron multiplier, and after you can see the calibrated leak rate you can leak test cavity.
* Leak check all joints on the cavity with the RGA system attached to the test stand.
* There shall be no detectable leak on any joints. If cavity is leaking inform the supervisor for further instruction.
* After the leak check set up RGA for an analog scan looking at mass 2 thru 100.
* Upload Analog scan and Meta file.

Cavity is ready to be moved to VSA for sensor attachment, and VTA test. | [[PumpdownStartTime]] <<TIMESTAMP>>[[CavityAnlogScan]] <<FILEUPLOAD>>[[CavityMETA]] <<FILEUPLOAD>>[[Technician]] <<SRFCVP>>[[LeakTight]] <<YESNO>>[[Comment3]] <<COMMENT>>[[FieldName]] <<YESNO>> |