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| Cavity Pair Strong Back Setup Procedure |
| **Document Number:** | CP-C75-ASSY-STBK | **Approval Date:** |  |
| **Revision Number:** | - | **Periodic Review Date:** |  |
| **Document Owner:** | C. Dreyfuss |  |  |

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# Purpose and Scope

The purpose of this procedure is to explain how to setup the C75/C50 Strong Back rail in the clean room for cavity pair assembly.

# References

[CP-C75-CPR-CLN-ION Ionized Nitrogen Cleaning Procedure](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-212167/CP-C75-CPR-CLN-ION-R1.pdf)

Jlab Drawing# [JL0092262 STRONGBACK TOOLING](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-212495/JL0092262---STRONGBACK%20TOOLING.pdf)

# Terms and Definitions

1. **SST--- Stainless Steel Table**
2. **UHV--- Ultra High Vacuum**

# Process Details

1. Grab a tall SST and put a cavity pair strong back rail onto it. The strong back rail should only have the end plates, four feet and twelve pillow blocks on it at this time. Take table with strong back on it to the chem room for cleaning.
2. Disassemble the pair beam tube and iris holding components from the strong back and send those to the chem room for cleaning.
3. After components and strong back rail are cleaned and in the pass thru use the Handi lift cart to transfer the strong-back fixture to the support pedestal. The strong back fixture has four large screws at one end and two large screws at the other end (convectron gauge end). Orient the strong back assembly properly on the support pedestal so the convectron gauge side is known. The strong back assembly should be centered on the support pedestal. Assemble the strong-back parts onto the rail as per drawing # [JL0092262 STRONGBACK TOOLING](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-212495/JL0092262---STRONGBACK%20TOOLING.pdf).
4. Loosen the end plate bolts and ensure both rails sit on the pedestal support points and do not rock. Tighten end plate bolts and recheck. Spray the entire assembly with ionized nitrogen. (This is for drying purpose only do not need particle counter for this.) The strong-back fixture is ready for cavity assembly.

# **Revision History**

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| Rev # | Revision or update: | Effective: |
| Release  | Initial Release  | 4/22/2020 |
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# **Approvals**

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