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| Traveler Title | SNS PPU Vacuum Vessel Inspection Traveler | | | |
| Traveler Abstract | Traveler defines inspection process for the SNS PPU Vacuum Vessel | | | |
| Traveler ID | SNSPPU-CM-INSP-VV | | | |
| Traveler Revision | R1 | | | |
| Traveler Author | M. Marchlik | | | |
| Traveler Date | 10-Oct-20 | | | |
| NCR Informative Emails | Edaly,areilly | | | |
| NCR Dispositioners | Marchlik, Huque | | | |
| D3 Emails | Marchlik, Huque | | | |
| Approval Names | M. Marchlik | N. Huque | 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. | |
| 104210800-M8U-8200-A001 (VACUUM VESSEL ASSY) | | 104210800-M8U-8200-A002 (VACUUM VESSEL WELDMENT) |

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| Revision Note |  |
| R1 | Initial release of this Traveler. |

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| Step No. | Instructions | Data Input |
| **General handling guidelines:** The vacuum vessel shall be handled according to standard cleaning and handling practices. Keep all openings covered whenever feasible. | | |
| 1 | **Initial Inspection:** | |
| Technician Name  Date of Inspection  Serial Number of part | [[TechName]] <<SRF>>  [[InspectionDate]] <<TIMESTAMP>>  [[SFRSN]] << SFRSN>> |
| Are the Head Assemblies (item 2 of 104210800-M8U-8200-A001) attached securely? | [[HeadAssyOk]]<<YESNO>> |
| Is the assembly clean, free from dust, oil, finger prints or other contaminants? NW250 flange blank to allow access to the interior of the vessel | [[PartCleanOk]] <<YESNO>> |
| Are all openings blanked off? (The first and last vacuum vessels delivered will arrive with all of the openings blanked off with the flanges used for performing the pressure/leak tests. For the remaining, all ports will be blanked off with various flange types) | [[BlanksOk]]<<YESNO>> |
| Are the three Support Brackets, item#3, installed and undamaged? | [[BracketOk]]<<YESNO>> |
| Are the four Interface Panel Brackets, item #5, installed and undamaged? | [[PanelBracketOk]]<<YESNO>> |

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| Step No. | Instructions | | | Data Input | |
| 2 | **Dimensional Inspection:** | | | | |
| Dimensionally inspect the vacuum vessel assemblies with serial numbers ending in 002, 004 and 006. | | | [[DimcheckOk]] <<YESNO>>  [[DimcheckComment]] <<COMMENT>> | |
| **Drawing Number** | | **Description** | **Drawing Value** | **Measured Value** | **Within Tolerance** |
| 104210800-M8U-8200-A002 | | Location of the 24 lockdown pad center holes. | .03” true position to datums A, B and C:   * 17.11” * 47.42” * 76.35” * 105.37” * 126.94” * 155.96” * 184.89” * 215.20” | [[lockdownlocate]] <<FLOAT>> <<YESNO>> | |
| 104210800-M8U-8200-A002 | | Overall chamber length, end flange to end flange. | 232.31” +/- .03” | [[vessellength]] <<FLOAT>> <<YESNO>> | |
| 104210800-M8U-8200-A002 | | End flange clocking, 2 places. One of the end flange holes true position to the horizontal plane. | .03” | [[Flangeclock]] <<FLOAT>> <<YESNO>> | |
| 104210800-M8U-8200-A002 | | End flange perpendicularity to datum A, 2 places. | .060” | [[Flangeperp]] <<FLOAT>> <<YESNO>> | |
| 104210800-M8U-8200-A002 | | End can Mounting Pad locations. Edge of the mounting pads to the backsides of the end flanges. | REC:  1.500 +/- .030”  &  SEC:  1.050” +/- .030” | [[Padlocate]] <<FLOAT>> <<YESNO>> | |
| 104210800-M8U-8200-A002 | | Coupler flange height from chamber’s center axis, 4 places | 20.67” +/- .030” | [[FPCheight]] <<FLOAT>> <<YESNO>> | |
| 104210800-M8U-8200-A002 | | Coupler flange perpendicularity to datum C, 4 places. | .015” | [[FPCperp]] <<FLOAT>> <<YESNO>> | |
| 104210800-M8U-8200-A002 | | .060” tru position of the Coupler flange ID to datum A,B and C, 4 places. | 53.87”  15.80”  92.97”  15.80” | [[FPSposition]] <<FLOAT>> <<YESNO>> | |
| 104210800-M8U-8200-A002 | | Longitudinal position of the SEC flange, item #1, from the end flange. | 10.37” +/- .02” | [[SEClong]] <<FLOAT>> <<YESNO>> | |
| 104210800-M8U-8200-A002 | | Longitudinal position of the REC flange, item #2, from the end flange. | 11.03” +/- .02” | [[REClong]] <<FLOAT>> <<YESNO>> | |
| 104210800-M8U-8200-A002 | | .030” true position of the SEC flange, item #1, to datums A and C. | 14.71”  19.49” | [[SECpos]] <<FLOAT>> <<YESNO>> | |
| 104210800-M8U-8200-A002 | | .030” true position of the REC flange, item #2, to datums A and C. | 12.01”  19.85” | [[RECpos]] <<FLOAT>> <<YESNO>> | |
| 3 | **Storage:** | | | | |
| Close up all openings and store the vacuum vessel in a clean and dry location. | | | [[StorageTech]] <<SRF>>  [[StorageDate]] <<TIMESTAMP>> | |