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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 |
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| 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 NameDate of InspectionSerial Number of part | [[TechName]] <<SRF>>[[InspectionDate]] <<TIMESTAMP>>[[VVSN]] << VVSN>> |
| 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>> |