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TRAVELERS
Nov 16, 2020 11:00:05 AM

Traveler Search For: SNSPPU- (i.e. CAV-INSP)

Area: SNSPPU-CAV-ASSY-HELV-R2 -- SNSPPU Helium vessel welding
Edit / SNSPPU-CHEM-CAV-HPR-R1 -- SNS-PPU Traveler for Cavity High Pressure Rinse Processing
View SNSPPU-CLNRM-CAV-TSTD-R1 -- SNSPPU Cavity Transfer to Test Stand
SNSPPU

Select Traveler Page 0 NEXT LAST NEW

SerialNum: 0 Traveler ID: SNSPPU-INSP-HOBCB Rev: R1 Page:0 Traveler Seq Number: 0

Traveler Title	SNS PPU Cold Mass Assembly He Outlet Bellows and Con Bellows Inspection Traveler			
Traveler Abstract	Traveler prescribes JLab receiving inspection of the He Outlet Bellows and Con Bellows that are used on SNS PPU cryomodule cold mass assembly helium headers cryogenic circuit			
Traveler ID	SNSPPU-INSP-HOBCB			
Traveler Revision	R1			
Traveler Author	Gary Cheng			
Traveler Date	22-Oct-20			
NCR Informative Emails	Edaly, areilly			
NCR Dispositioners	Cheng, fischer			
D3 Emails	Cheng, fischer, edaly			
Approval Names	G. Cheng	M. Wiseman	G. DeKerlegand	E. Daly
Approval Signatures				
Approval Dates				
Approval Title	Author	Reviewer	Reviewer	Project Manager
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.			
104211500-M8U-8200-A017	104211500-M8U-8200-A026	SRF Serialization PR-P-007	11141S0034 Stainless Steel	
He Outlet Bellows	Con Bellows		Cleaning Procedure	
Revision Note				
R1	Initial release of this Traveler.			

Select Traveler Page 0 NEXT LAST NEW

Contact Us: [PansophyTeam](#)

A26 ??



TRAVELERS
Nov 16, 2020 11:01:12 AM

Traveler Search For: SNSPPU- (i.e. CAV-INSP)

Area: SNSPPU-CAV-ASSY-HELV-R2 -- SNSPPU Helium vessel welding
Edit / View: SNSPPU-CHEM-CAV-HPR-R1 -- SNS-PPU Traveler for Cavity High Pressure Rinse Processing
SNSPPU: SNSPPU-CLNRM-CAV-TSTD-R1 -- SNSPPU Cavity Transfer to Test Stand

Select Traveler Page 1

SerialNum: 0 Traveler ID: SNSPPU-INSP-HOBCB Rev: R1 Page:1 Traveler Seq Number: 0

Step No.	Instructions	Data Input
1	Enter inspector name and inspection date:	InspectorName -0- v InspectionDate NOW (ex format 18-Jun-2005 16:30)
2	The He Outlet Bellows and Con Bellows are kitted. Each kit consists of 2 ☐ He Outlet Bellows and 1 ☐ Con Bellows. There is also spare Con Bellows that are not kitted. Either a kit or a spare bellows is under inspection. Enter kit serial number (HOBCBSN): Or, spare Con Bellows serial number (HOBSN) Note: after inspection, parts shall resume kitted as they were.	HOBCBSN -0- v HOBSN -0- v
3	Visual Inspection ☐ Verify that the kit contents are complete, i.e. 2 ☐ He Outlet Bellows and 1 ☐ Con Bellows. ☐ Verify that the part geometry matches with corresponding drawing ☐ views. ☐ Confirm that S/Ns are engraved and meet SRF serialization format, use <u>SRF Serialization PR-P-007</u> as guide. ☐ Check the knife edges on He Outlet Bellows for shipping /handling damages ☐ Inspect the bellows cuffs and convolutions for cleanliness, perform wipe test (refer to 11141S0034) at the inspector ☐ judgement, structural integrity (kinks in metal). As long as the metal is not kinked, crimped, etc., bellows are okay. Avoid damaging the thin-walled bellows. Protect bellows with necessary covers or insulation after inspection. Generate NCR per the inspector ☐ judgement. Upload inspection pictures of failed areas or areas of concern.	VisualInspOk ☐ Yes ☐ No VisualInspComments Must submit traveler before attaching files.
4	Vendor docs check Enter inspector name and inspection date. Vendor documents are uploaded to SharePoint folder <u>CMASS He Outlet & Con Bellows</u> . The SOTR/SME is expected to review vendor documents and comment.	VendorDocReviewer -0- v VendorDocReviewDate NOW (ex format 18-Jun-2005 16:30)

VendorRptComment

Select Traveler ▼	VIEW all SAVE PDF	Page 1 ▼	FIRST	PREV	NEW
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Contact Us: [PansophyTeam](#)

From: Gary Cheng <cheng@jlab.org>

Sent: Monday, November 16, 2020 9:52 AM

To: E. Anne McEwen <mcewen@jlab.org>

Cc: Kirk Davis <kdavis@jlab.org>; Naeem Huque <huque@jlab.org>; Ed Daly <edaly@jlab.org>; srfinv@jlab.org; Katherine Wilson <kwilson@jlab.org>; SRF Pansophy (pansophy@jlab.org) <pansophy@jlab.org>

Subject: Re: SNS PPU He outlet & con bellows inspection

Hi Anne,

PPU management enforces kitting so if all procurement implemented kitting, ideally you would expect to see 7 kits of all things needed for assemblies. I know there are variations due to the fact that in the real world, not everything can be easily kitted due to the size for example. And some items may have spares that are not kitted.

The SNS PPU He outlet & con bellows (HOBCB) are kitted. My SOW & traveler both have kit definition. So there are 7 kits of HOBCB. And, I bought a couple spare bellows.

As to how many parts/kits to inspect, for the HOBCB, please inspect them all. They are made by Hyspan who delivered poor quality hoses to a subcontractor of us. Bellows takes time to repair/make, especially when the vendor is Hyspan.

Thanks,
Gary