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| Traveler Title | P1 Return Beam Pipe Receiving Inspection |
| Traveler Abstract | This traveler is to be used for incoming inspection of all C100 Return Beam Pipe Weldment assemblies. |
| Traveler ID | P1-INSP-RTBP |
| Traveler Revision  | R1 |
| Traveler Author | C. Wilcox |
| Traveler Date | 15-Dec-2010 |
| NCR Informative Emails | Areilly |
| NCR Dispositioners | Fischer,wilcox |
| D3 Emails | Areilly,fischer,wilcox |
| Approval Names | C. Wilcox | C. Wilcox | C. Wilcox | C. Wilcox |
| Approval Signatures |  |  |  |  |
| Approval Dates |  |  |  |  |
| Approval Title | Author | Author | Author | Author |

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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. |
| Top Assembly Drawing |  |  |  |  |
| [CRM-120-7060-2002](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-39565/CRM_120_7060_2002.pdf) |  |  |  |  |

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

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| Step No. | Instructions | Data Input |
| 1 | Inspect the shipping container for external damage. | [[INSPTech]] <<SRF>>[[INSPStart\_Time]] <<TIMESTAMP>>[[RTBPSN]] <<RTBPSN>>[[External\_Damage]] <<YESNO>>[[External\_Inspection\_Comment]] <<COMMENT>>[[External\_Photo]] <<FILEUPLOAD>> |
| 2 | Check hands to ensure gloves are installed. | [[Gloves\_Installed]] <<CHECKBOX>> |
| 3 | 1. Open container.
2. Ensure Beam Pipe Assembly is properly packaged.
3. Inspect for damage.
 | [[Internal\_Damage]] <<YESNO>>[[Internal\_Inspection\_Comment]] <<COMMENT>>[[Internal\_Photo]] <<FILEUPLOAD>> |
| 4 | **Remove the beam pipe assembly from the packaging and stage on a pre-cleaned surface. Verify that the unit is clean and doesn't have fingerprints or other defects.** | **[[Clean\_Eval]] <<COMMENT>>****[[Clean\_Photo]] <<FILEUPLOAD>>** |

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| Step No. | Instructions | Data Input |
| 5 | **Review the top level assembly drawing.** **Inspect the assembly & verify that each of the items on the BOM are in fact part of the weldment.**[CRM-120-7060-2002](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-39565/CRM_120_7060_2002.pdf) | **[[BOM\_Correct]] <<CHECKBOX>>****[[BOM\_Comment]] <<COMMENT>>** |
| 6 | **Verify that the dimensions specified on the drawing match the beam pipe assembly.****Create an NCR for any dimensions that deviate by greater than 0.15 in****Take note that dimension #2 can be influenced by deflection of the bellows. Bellows should be in a relaxed state for measurement.****Dimension #1: 3.31****Dimension #2: 4.940****Dimension #3: 8.00****Dimension #4: 2.74** | **[[Dim1]] <<FLOAT>>****[[Dim2]] <<FLOAT>>****[[Dim3]] <<FLOAT>>****[[Dim4]] <<FLOAT>>****[[Dim\_Comment]] <<COMMENT>>** |

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| Step No. | Instructions | Data Input |
| 7 | **Perform an He leak check on the assembly.****Be sure to provide mechanical support to prevent crushing of the bellows.****Attach the data file.** | **[[He\_Tech]] <<SRF>>****[[He\_Start]] <<TIMESTAMP>>****[[He\_Serial\_Number]] <<FLOAT>>****[[He\_Comment]] <<COMMENT>>****[[He\_Data]] <<FILEUPLOAD>>** |
| 8 | **Beam pipe meets all of above requirements, ready for use.** | [[RTBP\_Tech]] <<SRF>>[[RTBP\_DateTime]] <<TIMESTAMP>>**[[HeComment]] <<COMMENT>>** |