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| Traveler Title | C100 Supply Beam Pipe Receiving Inspection | | | |
| Traveler Abstract | This traveler is to be used for incoming inspection of all C100 Supply Beam Pipe Weldment assemblies. | | | |
| Traveler ID | P1-INSP-SUBP | | | |
| 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 | J. Fischer | A. Reilly |  |
| Approval Signatures |  |  |  |  |
| Approval Dates |  |  |  |  |
| Approval Title | Author | 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. | | | |
| Top Assembly Drawing |  |  |  |  |
| [CRM-120-7061-2001](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-39736/CRM_120_7061_2001%5B1%5D.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>>  [[SUBPSN]] <<SUBPSN>>  [[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 finger prints or other defects.** | **[[Clean\_Eval]] <<COMMENT>>**  **[[Clean\_Photo]] <<FILEUPLOAD>>** |

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| **Step No** | **Instructions** | **Data Inputs** |
| **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-120-7061-2001](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-39736/CRM_120_7061_2001%5B1%5D.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: 5.465**  **Dimension #2: 4.940**  **Dimension #3: 10.75**  **Dimension #4: 2.88**  **Dimension #5: 7.69**  **Dimension #6: 8.0**  **Dimension #7: 7.13** | **[[Dim1]] <<FLOAT>>**  **[[Dim2]] <<FLOAT>>**  **[[Dim3]] <<FLOAT>>**  **[[Dim4]] <<FLOAT>>**  **[[Dim5]] <<FLOAT>>**  **[[Dim6]] <<FLOAT>>**  **[[Dim7]] <<FLOAT>>**  **[[Dim\_Comment]] <<COMMENT>>** |

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| **Step No** | **Instructions** | **Data Inputs** |
| **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** | **Beampipe meets all of above requirements, ready for use.** | [[BLBP\_Tech]] <<SRF>>  [[BLBP\_Tech]] <<TIMESTAMP>>  **[[HeComment]] <<COMMENT>>** |