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| Traveler Title | Outer Tube Assembly |
| Traveler Abstract | Outlines the assembly of the RFD Outer Tube |
| Traveler ID | AUP-ASSY-DAMP-TBASSY |
| Traveler Revision  | R2 |
| Traveler Author | Matthew Weaks |
| Traveler Date | 7-Apr-20 |
| NCR Informative Emails | Weaksmc |
| NCR Dispositioners | Huque,scott |
| D3 Emails | Huque,scott,weaksmc |
| Approval Names | Matthew Weaks | John Fischer | Naeem Huque |  |
| 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. |
| [CERN EDMS No. 1389321](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-211739/EDMS%20-%201389321%20Cleaning_stainless_steel_rev1%281%29.pdf) | [CERN EDMS No. 1389669](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-211730/EDMS%201389669%20-%20Engineering_specification_dressed_cavities.v2.5%281%29.pdf) | [JL0088268\_CMM](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-227669/JL0088268_-_OUTER%20TUBE%20ASSY_CMM.pdf) |  |  |
| [JL0088268](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-212515/JL0088268_-_OUTER%20TUBE%20ASSY.pdf) | [JL0086009](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-212520/JL0086009_-_HOMS%20H%20EXTERNAL%20PIPE.pdf) | [JL0088598](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-212521/JL0088598_-_OUTLET%20TUBE.pdf) |  |  |

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| Revision Note |  |
| R1 | Initial release of this Traveler. |
| R2 | Added serial numbers. Added drawing in Step 5 |

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| Step No. | Instructions | Data Input |
| 1 | Serial Number of Parts | [[TBASSYSN]] <<TBASSYSN>>[[OTUBESN]] <<OTUBESN>>[[EXPIPESN]] <<EXPIPESN>> |
| CHEMISTRY |
| 1a | Degrease JL0086009 as per CP-STP-CAV-CHEM-ACIDUpload any relevant photos and/or comments. | [[DG1Tech]] <<SRF>>[[DG1Time]] <<TIMESTAMP>>[[DG1Comm]] <<COMMENT>>[[DG1File]] <<FILEUPLOAD>> |
|  | Degrease JL0088598 as per CP-STP-CAV-CHEM-ACIDUpload any relevant photos and/or comments. | [[DG2Tech]] <<SRF>>[[DG2Time]] <<TIMESTAMP>>[[DG2Comm]] <<COMMENT>>[[DG2File]] <<FILEUPLOAD>> |
| WELDING |
| 2 | TIG Weld the assembly together as per drawing JL0088268 following ASME BPVC Section IX as described in CERN EDMS No. 1389669 – Section 11.4.6.Upload relevant WPS and WPQR along with any photos and/or comments. | [[WeldTech]] <<SRF>>[[WeldTime]] <<TIMESTAMP>>[[WeldComm]] <<COMMENT>>[[WeldFile]] <<FILEUPLOAD>> |

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| Step No. | Instructions | Data Input |
| INSPECTION |
| 2a | Visually inspect the weld following EN ISO 13919-2 Level B as described in CERN EDMS No. 1389669 Section 5.2.4.3.Upload Inspection Report. | [[Ins1Tech]] <<SRF>>[[Ins1Comm]] <<COMMENT>>[[Ins1File]] <<FILEUPLOAD>> |
| 2b | Inspect the assembly radiographically following EN ISO 13919-2 Level B as described in CERN EDMS 1389669 – Section 5.2.4.55.Upload Inspection Report | [[Ins2Tech]] <<SRF>>[[Ins2Time]] <<TIMESTAMP>>[[Ins2Comm]] <<COMMENT>>[[Ins2File]] <<FILEUPLOAD>> |
| TESTING |
| 3 | Leak check the assembly following EN 13185 as described in CERN EDMS No. 1389669 – Section 4.3.5Upload leak check chart. | [[LCTech]] <<SRF>>[[LCTime]] <<TIMESTAMP>>[[LCComm]] <<COMMENT>>[[LCFile]] <<FILEUPLOAD>> |
| 4 | Pressure test the assembly following EN 13445-5:2014 as described in CERN EDMS No. 1389669 – Section 11.5.8Upload any relevant photos and/or comments. | [[PTTech]] <<SRF>>[[PTTime]] <<TIMESTAMP>>[[PTComm]] <<COMMENT>>[[PTFile]] <<FILEUPLOAD>> |

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| Step No. | Instructions | Data Input |
| INSPECTION |
| 5 | Verify dimensions marked on JL0088268\_CMM.Upload inspection report | [[Ins3Tech]] <<SRF>>[[Ins3Time]] <<TIMESTAMP>>[[Ins3Comm]] <<COMMENT>>[[Ins3File]] <<FILEUPLOAD>> |
| CHEMISTRY |
| 6 | Degrease the assembly as per CERN EDMS No. 1389321Upload any relevant photos and/or comments. | [[DG3Tech]] <<SRF>>[[DG3Time]] <<TIMESTAMP>>[[DG3Comm]] <<COMMENT>>[[DG3File]] <<FILEUPLOAD>> |