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| Traveler Title | LCLS-II HE 50 K Clamp Assembly Kit Inspection Traveler |
| Traveler Abstract | This traveler covers the necessary steps to perform incoming inspection and acceptance of the LCLS-II HE 50 K clamp assembly kit at JLab. This item is a Fermilab procurement and drop-shipped to JLab. |
| Traveler ID | L2HE-INSP-CLMP50K |
| Traveler Revision  | R1 |
| Traveler Author | Seetha-Lakshmi Lalitha |
| Traveler Date | 2-Jun-21 |
| NCR Informative Emails | kwilson,hogan |
| NCR Dispositioners | lalitha,king |
| D3 Emails | lalitha,king,fischer |
| Approval Names | Seetha-Lakshmi Lalitha | Larry King | John Fischer | John Hogan |
| Approval Signatures |  |  |  |  |
| Approval Dates |  |  |  |  |
| Approval Title | Author, SOTR | 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. |
|  | [F10046443-Rev F.pdf](file:///X%3A%5CFacilities%5CSRF%20Institute%5C01%20-%20SRF%20Projects%5C01%20-%20Open%5C1.21.01.XXX%20LCLS-II%20HE%20Project%20-%20High%20Energy%20%28Preble%5EHogan%29%5C05%20-%20Preliminary%20Drawings%20%28L2HE%29%5CF10046443-Rev%20F.pdf) | [F10045240-Rev C.pdf](file:///X%3A%5CFacilities%5CSRF%20Institute%5C01%20-%20SRF%20Projects%5C01%20-%20Open%5C1.21.01.XXX%20LCLS-II%20HE%20Project%20-%20High%20Energy%20%28Preble%5EHogan%29%5C05%20-%20Preliminary%20Drawings%20%28L2HE%29%5CF10045240-RevC.pdf) |  |  |
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| Revision Note |  |
| R1 | The initial release of this Traveler. |

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| **Notes**1. *The 50 K clamp assembly drawing - F10046443-RevF.pdf.*
2. *Wear nitrile gloves while handling the components.*
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| **Figure 1: Front view of the 50 K Clamp Assembly (3D CAD model number: F10046443-Rev F).**  |
| **Step No.** | **Instructions** | **Data Input** |
|  | *Note: See Figure 1 and Table 1 of this document and attached CAD drawings for the details.* |
|  | **Serialization of the 50 K clamp assembly** |  |
|  | * 1. Preparer name.
 | [[Ser\_Preparer\_Name\_SRF]] <<SRF>> |
|  | * 1. Assign serial number for 50 K clamp assembly.

*Note: The labeling format is F10046443FSN where the last two digits indicate the serial number starting from 01.* | [[CLMP50KSN]] <<CLMP50KSN>> |
|  | * 1. Mark the serial number on the outer side of the 5 K clamping plate (label 4 in Figure 1), and the 5 K strap clamping plate (label 6 in Figure 1).
 | [[Mark\_CLMP50KSN]] <<YESNO>> |
|  | * 1. Add comments, if any.
 | [[Ser\_Comment]] <<COMMENT>> |
|  | * 1. Date of completion.
 | [[Ser\_Comp\_Date]] <<TIMESTAMP>> |
|  | **EBOM inspection** |   |
|  | * 1. Inspector name and date.
 | [[EBOMI\_Inspector\_Name\_SRF]] <<SRF>>[[EBOMI\_Date]] <<TIMESTAMP>> |
|  | * 1. Are all components listed in Table.1 present?
 | [[EBOMI\_Tally]] <<YESNO>>[[EBOMI\_Comment]] <<COMMENT>> |
|  | * 1. If the answer is NO to step #2.2, then generate NCR.
 |  |
|  | * 1. Date of completion of EBOM inspection.
 | [[EBOMI\_Comp\_Date]] <<TIMESTAMP>> |
|  | **Visual inspection** |  |
|  | * 1. Inspector name and date.
 | [[VI\_Inspector\_Name\_SRF]] <<SRF>>[[VI\_Date]] <<TIMESTAMP>> |
|  | * 1. Are all components free of dirt, grease, oil, or chip?
 | [[VI\_Pass\_1]] <<YESNO>>[[VI\_Pass\_1\_Comment]] <<COMMENT>> |
|  | * 1. Are all parts free of sharp edges, corners, and burrs?
 | [[VI\_Pass\_2]] <<YESNO>>[[VI\_Pass\_2\_Comment]] <<COMMENT>> |
|  | * 1. Check for the signs of damage on weldments. Refer to the drawings for the 5 K clamping strip weldment (drawing no: F10045240-Rev C) for details.
 | [[VI\_Pass\_3]] <<YESNO>>[[VI\_Pass\_3\_Comment]] <<COMMENT>> |
|  | * 1. If the answer is NO to steps #3.2 and/or #3.3 and/or #3.4, then generate NCR.
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|  | * 1. Date of completion of visual inspection.
 | [[VI\_Comp\_Date]] <<TIMESTAMP>> |
|  | Re-pack the 50 K clamp assembly kit. Send to inventory area until use. | [[Repack\_Inspector\_Name\_SRF]] <<SRF>>[[Repack\_Comp\_Date]] <<TIMESTAMP>> |
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