|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| Traveler Title | AUP H-HOM Damper Assembly | | | |
| Traveler Abstract | Outlines the final assembly of the HHOM Damper Assembly | | | |
| Traveler ID | AUP-ASSY-DAMP-FASSY | | | |
| Traveler Revision | R2 | | | |
| Traveler Author | Matthew Weaks | | | |
| Traveler Date | 4-Aug-21 | | | |
| NCR Informative Emails | fischer | | | |
| NCR Dispositioners | Huque | | | |
| D3 Emails | Huque | | | |
| Approval Names | Matthew Weaks | John Fischer | Naeem Huque |  |
| Approval Signatures |  |  |  |  |
| Approval Dates |  |  |  |  |
| Approval Title | Author | 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. | | | |
| [CERN EDMS No. 1389669](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-211730/EDMS%201389669%20-%20Engineering_specification_dressed_cavities.v2.5(1).pdf) | [CP-STP-CAV-CHEM-ACID](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-211742/CP-STP-CAV-CHEM-ACID-R1.pdf) | [JL0086007\_CMM](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-227670/JL0086007_-_AUP%20RFD%20HOM%20DAMPER_CMM.pdf) | [CP-STP-CAV-CHEM-DEGR](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-211743/CP-STP-CAV-CHEM-DEGR-R3.pdf) |  |
| [JL0086009](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-246135/JL0086009_-_HOMS%20H%20EXTERNAL%20PIPE.pdf) | [JL0088598](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-246134/JL0088598_-_OUTLET%20TUBE.pdf) | [JL0088602](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-212517/JL0088602_-_INNER%20CAN%20ASSY.pdf) | [JL0086007](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-246136/JL0086007_A_AUP%20RFD%20HOM%20DAMPER.pdf) |  |

|  |  |
| --- | --- |
| Revision Note |  |
| R1 | Initial release of this Traveler. |
| R2 | Changed drawings and weld sequence. Removed steps. Added work center lead as reviewer |

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| 1 | Serial Number of JL0086007  Serial Number of JL0088602  Serial Number of JL0086009  Serial Number of JL0088598 | [[FASSYSN]] <<FASSYSN>>  [[INCANSN]] <<INCANSN>>  [[EXPIPESN]] <<EXPIPESN>>  [[OTUBESN]] <<OTUBESN>> |
| CHEMISTRY | | |
| 2a | Degrease JL0088602 as per CP-STP-CAV-CHEM-DEGR  Upload any relevant photos and/or comments. | [[DG1Tech]] <<SRF>>  [[DG1Time]] <<TIMESTAMP>>  [[DG1Comm]] <<COMMENT>>  [[DG1File]] <<FILEUPLOAD>> |
| 2b | Degrease JL0086007 as per CP-STP-CAV-CHEM-DEGR  Upload any relevant photos and/or comments. | [[DG2Tech]] <<SRF>>  [[DG2Time]] <<TIMESTAMP>>  [[DG2Comm]] <<COMMENT>>  [[DG2File]] <<FILEUPLOAD>> |
| 2c | Degrease JL0088598 as per CP-STP-CAV-CHEM-DEGR  Upload any relevant photos and/or comments. | [[DG3Tech]] <<SRF>>  [[DG3Time]] <<TIMESTAMP>>  [[DG3Comm]] <<COMMENT>>  [[DG3File]] <<FILEUPLOAD>> |
| WELDING | | |
| 3 | TIG Weld the assembly as per drawing JL0086007 following ASME BPVC Section IX as described in CERN EDMS No. 1389669 – Section 11.4.6 | [[WeldTech]] <<SRF>>  [[WeldTime]] <<TIMESTAMP>>  [[WeldComm]] <<COMMENT>>  [[WeldFile]] <<FILEUPLOAD>> |

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| INSPECTION | | |
| 4 | 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>>  [[Ins1Time]] <<TIMESTAMP>>  [[Ins1Comm]] <<COMMENT>>  [[Ins1File]] <<FILEUPLOAD>> |
| TESTING | | |
| 5a | Leak check the **Stainless Steel Jacket** following EN 13185 as per CERN EDMS No. 1389669 – Section 4.3.5.  Upload any relevant photos and/or comments. | [[LC1Tech]] <<SRF>>  [[LC1Time]] <<TIMESTAMP>>  [[LC1Comm]] <<COMMENT>>  [[LC1File]] <<FILEUPLOAD>> |
| 5b | Pressure test the **Stainless Steel Jacket** following EN 13445-5:2014 as per CERN EDMS No. 1389669 – Section 11.5.8 (38 psig)  Upload any relevant photos and/or comments. | [[PT1Tech]] <<SRF>>  [[PT1Time]] <<TIMESTAMP>>  [[PT1Comm]] <<COMMENT>>  [[PT1File]] <<FILEUPLOAD>> |

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| TESTING | | |
| 6a | Pressure test the **Niobium Space** following EN 13445-5:2014 as per CERN EDMS No. 1389669 – Section 4.3.5 (38 psig)  Upload any relevant photos and/or comments. | [[PT2Tech]] <<SRF>>  [[PT2Time]] <<TIMESTAMP>>  [[PT2Comm]] <<COMMENT>>  [[PT2File]] <<FILEUPLOAD>> |
| 6b | Leak check the **Niobium Space** following EN 13158 as per CERN EDMS 1389669 – Section 4.3.5  Upload any relevant photos and/or comments | [[LC2Tech]] <<SRF>>  [[LC2Time]] <<TIMESTAMP>>  [[LC2Comm]] <<COMMENT>>  [[LC2File]] <<FILEUPLOAD>> |
| INSPECTION | | |
| 7 | Verify dimensions marked on drawing JL0086007\_CMM  Upload inspection report. | [[Ins2Tech]] <<SRF>>  [[Ins2Time]] <<TIMESTAMP>>  [[Ins2Comm]] <<COMMENT>>  [[Ins2File]] <<FILEUPLOAD>> |