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| Traveler Title | Receiving Inspection of LCLS-II HE Cryomodule Assembly, JT Valve Tube Kit (JTVTK) |
| Traveler Abstract | This traveler is for inspection of LCLS-II HE Cryomodule Assembly, JT Valve Tube Kit |
| Traveler ID | L2HE-INSP-JTVTK |
| Traveler Revision  | R1 |
| Traveler Author | Justin Kent |
| Traveler Date | 8/17/2021 |
| NCR Informative Emails | Jtkent,fischer,kwilson,hogan |
| NCR Dispositioners |  |
| D3 Emails |  |
| Approval Names | Justin Kent | Anne McEwen | John Hogan |  |
| 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. |
| Kit, JT Valve Tube |  |  |  |  |
| [F10074319](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-246594/F10074319.pdf) |  |  |  |  |

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

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| **Step No.** | **Instructions** | **Data Input** |
| 1 | Enter serial number of Kit, JT Valve Tube (JTVTK)being inspected | [[JTVTKSN]] <<JTVTKSN>> |
| 2 | **Check Vendor Documents**Vendor documents are attached to receiving traveler L2PRD-CM-RECV-JTVTK. Per drawing F10074319 note 4, the following shall be submitted by the vendor: Material certifications.Welding documentsIn process inspectionsMake a comment if any documents are missing. | [[Check\_Docs\_Tech]] <<SRF>>[[Check\_Docs\_Date]] <<TIMESTAMP>>[[JTVTK\_Docs\_Complete]] <<YESNO>>[[Docs\_Notes]] <<COMMENT>> |

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| **Step No.** | **Instructions** | **Data Input** |
| 3 | **Visual Inspection**Enter inspection technical name and inspection date.Remove packaging materials. Check the parts for apparent damages and geometry conformance with F10074319 views. If any parts have damages:1. Describe damages in comment field.
2. Take pictures of the damages and attach files.

For this entire traveler, if any of the inspection items in this traveler are not as they should be, please generate a NCR, based on the inspector’s judgment. **NOTE: For all inspection steps, if more drawings are needed that are not provided, please contact the SOTR.**  | [[JTVTK\_Visual\_INSP\_Tech]] <<SRF>>[[JTVTK\_Visual\_INSP\_Date]] <<TIMESTAMP>>[[Damage\_Pics]] <<FILEUPLOAD>>[[Comment\_AsReceived\_JTVTK]] <<COMMENT>> |

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| **Step No** | **Instructions** | **Data Inputs** |
| 4 | **Weld Inspection**Enter inspector name and inspection date.A certified weld examiner/inspector is required to inspect all welds to make sure that:* Welds are good; i.e. welds on parts should be smooth and flush, with no crevices, cracks or protrusions, weld oxidation shall have been brushed off. Verify weld sizes and patterns meeting specification in drawings. Make notes of any nonconformances.
* There should be no unusual discoloration to the base material, especially around the welds.
* Upload pictures of failed areas or areas of concern.

If a weld inspection report is prepared, please upload the report. | [[WeldInspector]] <<SRF>>[[WeldInspDate]] <<TIMESTAMP>>[[WeldsOk]] <<YESNO>>[[ColorationOk]] <<YESNO>>[[WeldsComments]] <<COMMENT>>[[WeldSurfPics]] <<FILEUPLOAD>>[[Weld\_Insp\_Rpt]] <<FILEUPLOAD>> |