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| --- | --- | --- | --- | --- |
| Traveler Title | Vertical HOM Damper | | | |
| Traveler Abstract | Outlines the final inspection and fabrication for the final assembly of the VHOM Damper for the RFD Cavity | | | |
| Traveler ID | AUP-ASSY-VHOM-VCASSY | | | |
| Traveler Revision | R1 | | | |
| Traveler Author | Naeem Huque | | | |
| Traveler Date | 25-Sep-21 | | | |
| NCR Informative Emails |  | | | |
| NCR Dispositioners | Huque,obrien | | | |
| D3 Emails | Huque | | | |
| Approval Names | Naeem Huque | Adam O’Brien | Naeem Huque |  |
| Approval Signatures |  |  |  |  |
| Approval Dates |  |  |  |  |
| Approval Title | Author | Work Center Lead | 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. | | | |
| [CP-AUP-CAV-CHEM-DEGR](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-212638/CP-AUP-CAV-CHEM-DEGR-R1.pdf) | [CP-AUP-CAV-CHEM-ACID](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-212637/CP-AUP-CAV-CHEM-ACID-R1.pdf) | [CERN EDMS No. 1389669](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-211730/EDMS%201389669%20-%20Engineering_specification_dressed_cavities.v2.5(1).pdf) | [JL0090121](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-212542/JL0090121_-_FEEDTHROUGH%2025ohm%20BRAZING%20ASSY.pdf) | [JL0089940](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-248298/JL0089940_A_V-HOM%20COUPLER%2025ohm.pdf) |
| [JL0118832](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-248297/JL0118832_-_V-HOM%20COUPLER%20SHIPPPING%20ARR.pdf) | [JL0101223](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-248299/JL0101223_-_PINCE%20FEEDTHROUGH.pdf) | [JL0090122](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-248296/JL0090122_A_V-HOM%20COUPLER%2025ohm%20HOOK.pdf) | [JL0089940\_CMM](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-227174/JL0089940_A_CMM.pdf) |  |

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

| Step No. | Instructions | Data Input |
| --- | --- | --- |
| 1 | Serial Number of Assembly.  Serial Number of JL0090121  Serial Numbet of JL0090122  Serial Number of JL0101223 | [[VCASSYSN]] <<VCASSYSN>>  [[BRZASSN]] <<BRZASSN>>  [[VH25HSN]]<<VH25HSN>>  [[FTPINSN]]<<FTPINSN>> |
| CHEMISTRY | | |
| 2a | Degrease/Etch JL0090121 as per JLab spec CP-AUP-CAV-CHEM-ACID  Upload any relevant photos and/or comments. | [[DG1Tech]] <<SRF>>  [[DG1Time]] <<TIMESTAMP>>  [[DG1Comm]] <<COMMENT>>  [[DG1File]] <<FILEUPLOAD>> |
| 2b | Degrease/Etch JL0101223as per JLab spec CP-AUP-CAV-CHEM-ACID  Upload any relevant photos and/or comments. | [[DG2Tech]] <<SRF>>  [[DG2Time]] <<TIMESTAMP>>  [[DG2Comm]] <<COMMENT>>  [[DG2File]] <<FILEUPLOAD>> |
| 2c | Degrease/Etch JL090122 as per JLab spec CP-AUP-CAV-CHEM-ACID  Upload any relevant photos and/or comments. | [[DG3Tech]] <<SRF>>  [[DG3Time]] <<TIMESTAMP>>  [[DG3Comm]] <<COMMENT>>  [[DG3File]] <<FILEUPLOAD>> |
|  | Hold to review inspection reports, travelers, NCRs, WPS, and WPQR to verify parts are ready for EBW. | [[HoldPoint1]] {{huque}} <<HOLDPOINT>> |
| ELECTRON BEAM WELD | | |
| 3a | EBW assembly as per drawing JL0089940  Upload relevant WPS and WPQR. | [[Weld1Tech]] <<SRF>>  [[Weld1Time]] <<TIMESTAMP>>  [[Weld1Comm]] <<COMMENT>>  [[Weld1File]] <<FILEUPLOAD>> |
| 3a | Visually inspect the welds following EN ISO 13919-2 Level B as defined in CERN EDMS No. 1389669 - Section 4.2.7  Upload inspection report. | [[Ins1Tech]] <<SRF>>  [[Ins1Time]] <<TIMESTAMP>>  [[Ins1Comm]] <<COMMENT>>  [[Ins1File]] <<FILEUPLOAD>> |
| LEAK CHECK AND THERMAL SHOCK | | |
| 4 | Leak check the assembly following EN 13185 as defined in CERN EDMS No. 1389669 - Section 4.5  Upload any relevant photos and/or comments. | [[LC1Tech]] <<SRF>>  [[LC1Time]] <<TIMESTAMP>>  [[LC1Comm]] <<COMMENT>>  [[LC1File]] <<FILEUPLOAD>> |
| RADIOGRAPHIC TESTING | | |
| 5 | Inspect the welds radiographically following EN ISO 13919-2 Level B as defined in CERN EDMS No. 1389669 - Section 4.2.7  Upload inspection report. | [[RT1Tech]] <<SRF>>  [[RT1Time]] <<TIMESTAMP>>  [[RT1Comm]] <<COMMENT>>  [[RT1File]] <<FILEUPLOAD>> |
| INSPECTION | | |
| 6 | Verify dimensions marked on drawing JL0089940\_CMM  Upload inspection report. | [[Ins2Tech]] <<SRF>>  [[Ins2Time]] <<TIMESTAMP>>  [[Ins2Comm]] <<COMMENT>>  [[Ins2File]] <<FILEUPLOAD>> |
| CHEMISTRY | | |
| 7 | Degrease/Etch the assembly as per JLab spec CP-STP-CAV-CHEM-DEGR and CP-STP-CAV-CHEM-ACID.  Upload any relevant photos and/or comments. | [[DG5Tech]] <<SRF>>  [[DG5Time]] <<TIMESTAMP>>  [[DG5Comm]] <<COMMENT>>  [[DG5File]] <<FILEUPLOAD>> |
| ASSEMBLY | | |
| 8 | Complete assembly as per drawing JL0118832.  Upload any relevant photos and/or omments. | [[AssyTech]] <<SRF>>  [[AssyTime]] <<TIMESTAMP>>  [[AssyComm]] <<COMMENT>>  [[AssyFile]] <<FILEUPLOAD>> |
| 9 | Close all travelers and NCRs. | [[TravCHK]] <<SRF>>  [[TravCHK]] <<TIMESTAMP>> |