Draft PPU Cryomodule Incoming inspection

Example Data

1. Perform a visual inspection for obvious damage of cryomodule on shipping frame

Text Box for Details

1. Transfer Cryomodule from shipping truck to transfer carts
2. Download data from shipping frame sensors

1E-6

1. Connect a controller and turn on the ion pump, record the Beamline vacuum (should be <1E-5 Torr)

0.1

1. Connect a CCG controller and check the Insulating Vacuum (should be less than 0.1 Torr)
2. Move Cryomodule into test cave and install on stands
3. Measure the cryomodule mechanical critical details, reference drawings 104210200-M8U-8200-A007, 104210200-M8U-8200-A001

|  |  |  |  |
| --- | --- | --- | --- |
| PPU Cryomodule Critical Dimensions (inches) | Drawing Value | Tolerance | Measured Value |
| Overall length end can to end can | 309.80 | +0.2,-0.5 |  |
| Beamline Length (subtract blank flanges 2X 0.73”) | 246.64 | ±0.050 |  |
| Shield supply to beamline center, (X direction) | 20.09 | ±0.100 |  |
| Primary supply to beamline center, (Z direction) | 12.77 | ±0.100 |  |
| Primary supply to shield supply(Z direction) | 12.00 | ±0.100 |  |
| Beamline center to shield supply height (Y direction) | 13.91 | ±0.125 |  |
| Beamline center to Primary supply height ( Y direction) | 13.91 | ±0.125 |  |
| 2K Primary outlet to beamline flange (X direction) | 1.80 | ±0.050 |  |
| 50K shield gas outlet to beamline flange (X direction) | 12.79 | ±0.100 |  |
| 2K Primary outlet to beamline center (Y direction) | 14.00 | ±0.050 |  |

Acceptance Criteria

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| Measured Value | Pass Criteria | NCR | D3 | Pass/ Fail |
| No damage during shipment | visual inspection no observables |  |  |  |
| Beamline Vacuum | < 1e-6 Torr |  |  |  |
| Insulating Vacuum | < 0.1 Torr |  |  |  |
| Overall Length end can to end can | 309.80” ± 0.2” |  |  |  |
| Beamline length  | 246.64 ± 0.05” |  |  |  |

Signature Box

Level 3 Manager Signature

Signature Box

Level 2 Manager Signature