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| Traveler Title | LCLS-II-HE BPM Housing Inspection Traveler | | | |
| Traveler Abstract | Traveler defines the inspection process for the LCLS-II-HE BPM Housing | | | |
| Traveler ID | L2HE-INSP-BPMH | | | |
| Traveler Revision | R1 | | | |
| Traveler Author | Michelle Oast | | | |
| Traveler Date | 23-Mar-22 | | | |
| NCR Informative Emails | Weinmann,kwilson,Hogan | | | |
| NCR Dispositioners | Weinmann,kwilson | | | |
| D3 Emails | Weinmann,kwilson,Hogan,mdickey | | | |
| Approval Names | Michelle Oast | Katherine Wilson | 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. | | | |
| [Cold BPM Assembly](file:///M:\LCLS2-HE\FNAL%20DRAWINGS\F10023160_G_DWG1.pdf) | [BPM Housing](file:///M:\LCLS2-HE\FNAL%20DRAWINGS\F10030776_D_DWG1.pdf) |  |  |  |
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| Revision Note |  |
| R1 | Initial release of this Traveler. |

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| Step No. | Instructions | Data Input |
| General handling guidelines: Both end flanges contain sealing surfaces. Care shall be taken to avoid scratching/gouging these surfaces and protective covers shall be installed over these surfaces at all possible times. | | |
| 1 | Initial Inspection: | |
| Technician Name  Date of Inspection  Serial Number | [[TechName]] <<USERNAME>>  [[InspectionDate]] <<TIMESTAMP>>  [[SpoolSN]] <<SN>> |
| Is part clean, free from dust, oil, finger prints or other contaminants? | [[PartClean]] <<YESNO>> |
| Inspect the flanges’ sealing surfaces for scratches/gouges. | [[SealingSurfaceOK]] <<YESNO>> |
| Visually inspect the assembly for any pitting on internal and external surfaces. (Note shallow pitting in the comments, do not create NCR for shallow pitting.) | [[PlatingOK]] <<YESNO>> |
| Measure surface finish of seal groove of both flanges. Indicate "no" if roughness is equal to or higher than 0.8 um. | [[Flange1]] <<YESNO>>  [[Flange2]] <<YESNO>> |
| Comments:  • Upload photos of the BPM housing even if no discrepancies are found to show the "as received" state. At a minimum, photos should capture the condition of the BPM exterior, interior, and sealing surfaces.  • If discrepancies are found, upload photos of the discrepancy. | [[VisualInspComment]] <<COMMENT>> |
| 2 | Plating Inspection: |  |
| Comment on, but do not create NCRs for the following issues if found:  • Light spots  • Water marks  • Dark spots under 1/8" in diameter  • Small dents under 1/8" in diameter  • Darker shading than is typical of the overall copper plating  • Shallow pitting |  |
| Technician Name  Date of Inspection | [[TechName]] <<USERNAME>>  [[InspectionDate]] <<TIMESTAMP>> |
|  | Does copper plating cover the designated area shown in drawing F10030776? | [[PlatingCoverageOK]] <<YESNO>> |
| Is there pitting that goes through the plating? | [[Pitting]] <<YESNO>> |
| Is there flaking in the plating? | [[Flaking]] <<YESNO>> |
| Is there blistering of the plating? | [[Blistering]] <<YESNO>> |
| Are there dark spots over 1/8” in diameter in the plating? | [[DarkSpots]] <<YESNO>> |
| Are there areas over 1/8” in diameter missing plating? | [[BareSpots]] <<YESNO>> |
| Comments:  • Upload photos of the plating even if no discrepancies are found. Photos should at a minimum capture the plating areas, and seal surfaces where plating ends.  • If discrepancies are found, upload photos of the discrepancy. | [[PlateVisInspComment]] <<COMMENT>> |