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| **Cavity Installation into Test Stand Procedure** |
| **Document Number:** | C100R-PR-CLNRM-CAV-TSTD | **Effective Date:** | 06 May 2024 |
| **Revision Number:** | R2 | **Periodic Review Date:** | 06 May 2026 |
| **Document Owner:** | Chris Dreyfuss | **Department Owner:** | SRF Operations |

# Purpose

The purpose of this document is to describe the steps necessary to install a caged and assembled C100 cavity into a test stand.

# Scope

This procedure applies to <enter text>.

This procedure does not apply to <enter text>.

# Terms and Definitions

The following terms have specific meanings within this procedure.

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| **Term** | **Definition** |
| Test Stand | Tooling that holds the cavity for insertion into VTA dewar to accommodate high power vertical testing |

# Roles and Responsibilities

The following roles have responsibilities described in this document.

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| --- | --- |
| **Role** | **Responsibility** |
| <Job Title> | <Very short summary of activities this job title performs in this procedure.> |
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# Procedure

NOTE: This procedure must be performed in the VAA.

The following must be completed before initiating this procedure:

* The cavity must be properly installed in its respective processing cage.
* The cavity must be fully assembled with pump out port properly blanked off.
* The cavity/ cage must be properly attached to the appropriate cavity manipulation cart (Back-Tek)
* An appropriate test stand must be loaded into one of the holes in the vertical attachment area of the clean room. The test stand shall be oriented in the VAA hole so the down-pipe is located on the right hand side while facing the test stand.
* The test stand must be at atmospheric pressure (1000 mbar), and the cavity isolation valve above the top plate is closed.

## Prepare to install cavity to test stand

Transport the cavity/manipulation cart to the vertical attachment room. At this time the cavity shall have the caps removed from the HV supply and return headers. The cavity shall then be rotated, with the back-tek, to check for water in the helium vessel. If water is found, ensure it is all drained out before installation onto test stand. A D3 shall be created, to document the presence of water, if any is found. The caged cavity will hang from four pins attached to the four post adapter on the test stand. Remove the cavity attachment pins from the four post adapter. Make sure cables and vacuum hoses are cleared from the area that the cavity will be hanging in.

## Install cavity to test stand

Align the cart with the test stand and raise the cavity until the cage almost engages the four post adapter on the test stand. If necessary adjust the tilt of the cage with the hand wheel at the base of the manipulation attachment to better align the cage with the test stand adapter. **Slowly** raise the cavity so that the cage engages the four post adapter and the attachment pins can be slid into place. Secure attachment pins.

## Prepare cavity and test stand for connection

Place an empty stainless tray on the lower shelf of an empty cart. Remove the fasteners and blank from the right angle valve and place it in the stainless tray. Remove all but two opposite fasteners from the blank on the end of the test stand bellows and place them in the stainless tray as well. The two remaining fasteners must remain tight. Clean inside the right angle valve as per the [ionized nitrogen parts cleaning procedure.](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-251185/SRF-MSPR-CLNRM-CST-ION-R1.pdf) Remove the blank from the end of the test stand bellows and place it in the stainless tray. Push the cart with the stainless tray away from the cavity.

## Prepare hardware and gasket for connection to test stand

Clean the handles and upper shelf of a clean room cart with an isopropyl soaked wiper. Clean the cart with ionized nitrogen. Place three clean wipers on the top shelf of the cart. Clean the required tools and place them on one of the wipers. Clean the 2.75” conflat hardware as per the [ionized nitrogen parts cleaning procedure](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-251185/SRF-MSPR-CLNRM-CST-ION-R1.pdf) and place on one of the wipers on the cart. Clean the 2.75” copper conflat gasket as per the [ionized nitrogen parts cleaning procedure](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-251185/SRF-MSPR-CLNRM-CST-ION-R1.pdf) and place it on the remaining wiper. Transport the cart to the test stand and position it within arm’s reach of the cavity to facilitate bellows connection.

## Connect cavity to test stand

Clean/replace outer gloves. Assemble test stand bellows and cleaned gasket to the right angle valve on the cavity.

**NOTE:** *Reduce particulates/contamination by attaching flanges with one motion while minimizing flange rotation/movement once together. Never position your body or clothing over an opening. Replace and clean new gloves if they are damaged prior to, or during an operation.*

Install and evenly tighten the cleaned fasteners. Open the right angle valve. The cavity is now ready for evacuation.

# Process Flow

<Related Process Outside this Procedure>

<Starting Condition>

<Step 2>

<Related Step 1>

<Step 4>

<Decision>

<Related Step 2>

<Related Step 4>

<Ending Condition>

<Step 1>

YES

NO

<Related Decision>

<Related Step 3>

YES

NO

<Step 3>

# References

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| --- | --- |
| **Document No.** | **Title** |
| SRF-01-ML-001 | SRF Quality Manual |
| SRF-MSPR-CLNRM-CST-ION | [Ionized nitrogen parts cleaning procedure.](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-251185/SRF-MSPR-CLNRM-CST-ION-R1.pdf) |
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# Release and Revision History

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| --- | --- | --- |
| **Rev #** | **Major Changes** | **Effective Date:** |
| 1 | Initial version | DD Mmm YYY |
| R2 | Added instructions to section 3.1 to ensure no water is present in the helium vessel prior to insertion in test stand. | 06 May 2024 |
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# Approvals

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