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| Traveler Title | Field Probe Port Fabrication Traveler |
| Traveler Abstract | Outlines the inspection and fabrication steps for the Field Probe Port Assembly for the EIC 197MHz Crab Cavity after returning from ultrasonic inspection. |
| Traveler ID | EIC197-FAB-FPP-ASSYF |
| Traveler Revision  | R1 |
| Traveler Author | J. COX |
| Traveler Date | 9-Jul-24 |
| NCR Informative Emails | AREILLY,GEORGED,GROSE,KDAVIS |
| NCR Dispositioners | BLUMER,BUTTLES,HUQUE |
| D3 Emails | AREILLY,GEORGED,GROSE,KDAVIS,BLUMER,BUTTLES,HUQUE |
| Approval Names | J. COX | G. GROSE | J. BUTTLES | N. HUQUE |
| 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. |
| [JL0119121](https://misportal.jlab.org/jlabDocs/documents/175657/download) | [JL0150085](https://misportal.jlab.org/jlabDocs/documents/185430/download) | [JL0139908](https://misportal.jlab.org/jlabDocs/documents/175651/download) | [JL0140270](https://misportal.jlab.org/jlabDocs/documents/175650/download) | [11141-S-0033](https://misportal.jlab.org/jlabDocs/documents/70285/download) |
| [FieldProbePortFabricationPlan](https://jeffersonlab.sharepoint.com/%3Ap%3A/r/sites/EICPartnerProject-TJNAF/Accelerator/RF%20Systems/Cryomodules/197%20MHz%20DVC/Cavity%20Fabrication%20Files/Fabrication%20Plans/Field%20Probe%20Port%20Fabrication%20Plan.pptx?d=wedf4dd387d8e4bb3a8cca928b31fb420&csf=1&web=1&e=LkQEgk) This is in sharepoint, move to DS | [EIC-BPS-JL0140270](https://misportal.jlab.org/jlabDocs/documents/201698/download) | [JL0119121-Step1InspectDim](https://jeffersonlab.sharepoint.com/%3Ab%3A/r/sites/EICPartnerProject-TJNAF/Accelerator/RF%20Systems/Cryomodules/197%20MHz%20DVC/Cavity%20Fabrication%20Files/Images/Traveler%20Inspection%20Dimensions/JL0119121-Step1InspectDim.pdf?csf=1&web=1&e=D8HvjT) This is in sharepoint, move to DS, it is a drawing? | [JL0150085-Step1InspectDim](https://jeffersonlab.sharepoint.com/%3Ab%3A/r/sites/EICPartnerProject-TJNAF/Accelerator/RF%20Systems/Cryomodules/197%20MHz%20DVC/Cavity%20Fabrication%20Files/Images/Traveler%20Inspection%20Dimensions/JL0150085-Step1InspectDim.pdf?csf=1&web=1&e=8jOnuQ) This is in sharepoint, move to DS, it is a drawing? | [JL0139908-Step1InspectDim](https://jeffersonlab.sharepoint.com/%3Ab%3A/r/sites/EICPartnerProject-TJNAF/Accelerator/RF%20Systems/Cryomodules/197%20MHz%20DVC/Cavity%20Fabrication%20Files/Images/Traveler%20Inspection%20Dimensions/JL0139908-Step1InspectDim.pdf?csf=1&web=1&e=6LUYpn) This is in sharepoint, move to DS, it is a drawing? |
| [JL0140270-Step5InspectDim](https://jeffersonlab.sharepoint.com/%3Ab%3A/r/sites/EICPartnerProject-TJNAF/Accelerator/RF%20Systems/Cryomodules/197%20MHz%20DVC/Cavity%20Fabrication%20Files/Images/Traveler%20Inspection%20Dimensions/JL0140270-Step5InspectDim.pdf?csf=1&web=1&e=DUlKDC) This is in sharepoint, move to DS, it is a drawing? | [JL0140270-Step11InspectDim](https://jeffersonlab.sharepoint.com/%3Ab%3A/r/sites/EICPartnerProject-TJNAF/Accelerator/RF%20Systems/Cryomodules/197%20MHz%20DVC/Cavity%20Fabrication%20Files/Images/Traveler%20Inspection%20Dimensions/JL0140270-Step11InspectDim.pdf?csf=1&web=1&e=HMC8E2) This is in sharepoint, move to DS, it is a drawing? |  |  |  |

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

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| Step No. | Instructions | Data Input |
| PART IDENTIFICATION |
| 0 | Enter Serial Number of Finished Part (WHO STARTS THIS TRAVELER?)

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| **STEPS** | **WORK CENTER AREAS** | **ACTIONS** |
| 1 | MACHSHOP | Machine to final dimensions  |
| 2 | CMA | Leak Check |
| 3 | INSP | Final dimenionsal checks |
| 4 | INV | Engrave and return to INV |

 | [[FPCPSN]] <<SN>>[[FPCPNote]]{{FPCP is a new component name: FPC Port Assembly}} <<NOTE>> |

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| **Step No** | **Instructions** | **Data Inputs** |
| MACHINING |
| 1 | Machine knife edge and final dimensions.Include job number. | [[MachTech2]] <<SRF>>[[MachTime2]] <<TIMESTAMP>>[[MachJobNumber2]] <<INTEGER>>[[MachComm2]] <<COMMENT>> |

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| Step No. | Instructions | Data Input |
| LEAK CHECK |
| 2 | Leak check the assembly in accordance with 11141-S-0033[11141-S-0033](https://misportal.jlab.org/jlabDocs/documents/70285/download) Vendor Standard Helium Leak Check ProcedureUse a copper gasket to validate complianceUpload any relevant images/comments | [[VacTech2]] <<SRF>>[[VacTime2]] <<TIMESTAMP>>[[VacPass2]] <<YESNO>>[[VacComm2]] <<COMMENT>>[[VacFile2]] <<FILEUPLOAD>> |

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| **Step No** | **Instructions** | **Data Inputs** |
| **DIMENSIONAL INSPECTION** |
| 3 | **Verify dimensions in red on JL0140270** [JL0140270](https://misportal.jlab.org/jlabDocs/documents/175650/download)**Take knife edge profile on FormTracer****Upload inspection report****See** [JL0140270-Step11InspectDim](https://jeffersonlab.sharepoint.com/%3Ab%3A/r/sites/EICPartnerProject-TJNAF/Accelerator/RF%20Systems/Cryomodules/197%20MHz%20DVC/Cavity%20Fabrication%20Files/Images/Traveler%20Inspection%20Dimensions/JL0140270-Step11InspectDim.pdf?csf=1&web=1&e=HMC8E2) | [[InsTech5]] <<SRF>>[[InsTime5]] <<TIMESTAMP>>[[InsPass]] <<YESNO>>[[InsComm5]] <<COMMENT>>[[InsFile5]] <<FILEUPLOAD>> |

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| Step No. | Instructions | Data Input |
| LOGISTICS |
| 4 | **Engrave serial number onto flange (WHO ENGRAVES?)****Upload pictures of finished assembly** | [[FPPASN3]] <<SN>>[[LogTime]] <<TIMESTAMP>>[[LogFile]] <<FILEUPLOAD>> |
| 5 | **Inventory assembly (DOES THIS PART RETURN TO INVENTORY TO BE STORED?)** | [[LogTech]] <<SRF>>[[LogComm]] <<COMMENT>> |