|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| Traveler Title | End Group Beampipe Assembly Traveler | | | |
| Traveler Abstract | Outlines the inspection and fabrication steps for the End Group 1 Beampipe for the EIC 197Mhz Crab Cavity | | | |
| Traveler ID | EIC197-FAB-FPEGBP-ASSY | | | |
| Traveler Revision | R1 | | | |
| Traveler Author | J. Cox | | | |
| Traveler Date | 6-Sep-24 | | | |
| NCR Informative Emails | AREILLY,GEORGED,GROSE,KDAVIS | | | |
| NCR Dispositioners | BLUMER,BUTTLES,HUQUE | | | |
| D3 Emails | AREILLY,GEORGED,BUTTLES,GROSE,KDAVIS,BLUMER,HUQUE | | | |
| Approval Names | J. COX | G. GROSE | BUTTLES | N. HUQUE |
| Approval Signatures |  |  |  |  |
| Approval Dates |  |  |  |  |
| Approval Title | Author | Reviewer | Group Leader | 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. | | | |
| [JL0119538](https://misportal.jlab.org/jlabDocs/documents/177333/download) | [JL0149924](https://misportal.jlab.org/jlabDocs/documents/185354/download) | [JL0133803](https://misportal.jlab.org/jlabDocs/documents/177336/download) | [JL0136187](https://misportal.jlab.org/jlabDocs/documents/180708/download) | [EIC-BPS-JL0136187](https://misportal.jlab.org/jlabDocs/documents/205055/download) |
| [11141-S-0033](https://misportal.jlab.org/jlabDocs/documents/70285/download) | [EndGrpBeampipeFabricationPlan](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-289317/End%20Grp%20Beampipe%20Fabrication%20Plan.pptx) | [CP-AUP-CAV-CHEM-ACID](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-260914/CP-AUP-CAV-CHEM-ACID-R2(2).pdf) |  |  |

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

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| WORK CENTER | | |
| 0 | Enter Serial Number of Finished Part   |  |  |  | | --- | --- | --- | | **Steps** | **Work Center Areas** | **Actions** | | 1 | INSP | Initial Dimensional Inspection | | 2 | CHEM | BCP and DEGR | | 3-4 | FURN | Heat treat and Braze | | 5 | INSP | Verify perpendicularity | | 6 | MACHSHOP | Slug Removal | | 7 | CMA | Leak Check | | 8 | TR | Shipping and PR | | 9 | UT | Ultrasonic Inspection | | 10 | MACHSHOP | Machine transition and knife edge | | 11 | CMA | Leak Check | | 12 | INSP | Final Dimensional Inspection | | 13 | INV | Return to INV | | [[FPEGBPSN]] <<FPEGBPSN>>  [[New part SN dropdown]] <<NOTE>> |

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| DIMENSIONAL INSPECTION | | |
| 1 | Verify dimensions in red on [JL0119538](https://misportal.jlab.org/jlabDocs/documents/177333/download) (BEAMLINE FLANGE)  Diagram, schematic  Description automatically generated | [[BLFSN]] <<BLFSN>>  [[New part SN dropdown]] <<NOTE>>  [[InsTech]] <<SRF>>  [[InsTime]] <<TIMESTAMP>>  [[InsComm]] <<COMMENT>>  [[InsFile]] <<FILEUPLOAD>> |
| Verify dimensions in red on [JL0149924](https://misportal.jlab.org/jlabDocs/documents/185354/download) (6" FLANGE SLUG)  Shape, circle  Description automatically generated | [[InsTech2]] <<SRF>>  [[InsTime2]] <<TIMESTAMP>>  [[InsComm2]] <<COMMENT>>  [[InsFile2]] <<FILEUPLOAD>> |
| Verify dimensions in red on [JL0133803](https://misportal.jlab.org/jlabDocs/documents/177336/download) (BEAMPIPE)  Diagram  Description automatically generated | [[EBPSN]] <<EBPSN>>  [[New part SN dropdown]] <<NOTE>>  [[InsTech3]] <<SRF>>  [[InsTime3]] <<TIMESTAMP>>  [[InsComm3]] <<COMMENT>>  [[InsFile3]] <<FILEUPLOAD>> |

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| CHEMISTRY | | |
| 2a | Degrease [JL0119538](https://misportal.jlab.org/jlabDocs/documents/177333/download), [JL0149924](https://misportal.jlab.org/jlabDocs/documents/185354/download) and [JL0133803](https://misportal.jlab.org/jlabDocs/documents/177336/download)  According to [CP-AUP-CAV-CHEM-ACID](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-260914/CP-AUP-CAV-CHEM-ACID-R2(2).pdf) Acid Etching Proceedure  Upload any relevant photos and/or comments. | [[ChemTech]] <<SRFCVP>>  [[ChemTime]] <<TIMESTAMP>>  [[ChemComm]] <<COMMENT>>  [[ChemFile]] <<FILEUPLOAD>> |
| 2b | SS Etch [JL0119538](https://misportal.jlab.org/jlabDocs/documents/177333/download) and [JL0149924](https://misportal.jlab.org/jlabDocs/documents/185354/download) and  BCP to a depth of 15 microns [JL0133803](https://misportal.jlab.org/jlabDocs/documents/177336/download)  According to [CP-AUP-CAV-CHEM-ACID](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-260914/CP-AUP-CAV-CHEM-ACID-R2(2).pdf) Acid Etching Proceedure  Upload any relevant photos and/or comments. | [[ChemTech2]] <<SRFCVP>>  [[ChemTime2]] <<TIMESTAMP>>  [[ChemComm2]] <<COMMENT>>  [[ChemFile2]] <<FILEUPLOAD>> |

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| FURNACE | | |
| 3 | Heat Treat [JL0119538](https://misportal.jlab.org/jlabDocs/documents/177333/download) 2 hours at 950C  Heat Treat [JL0149924](https://misportal.jlab.org/jlabDocs/documents/185354/download) 2 hours at 950C  Upload relevant photos and/or comments | [[HeatTreatTech]] <<SRF>>  [[HeatTreatTime]] <<TIMESTAMP>>  [[HeatTreatComm]] <<COMMENT>>  [[HeatTreatFile]] <<FILEUPLOAD>> |
| 4 | Braze as per JLab [EIC-BPS-JL0136187](https://misportal.jlab.org/jlabDocs/documents/205055/download)  Enter serial number of brazement  Upload relevant photos and/or comments | [[BrazeTech]] <<SRF>>  [[BrazeTime]] <<TIMESTAMP>>  [[BrazeComm]] <<COMMENT>>  [[BrazeFile]] <<FILEUPLOAD>> |

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| DIMENSIONAL INSPECTION | | |
| 5 | Verify perpendicularity on [JL0136187](https://misportal.jlab.org/jlabDocs/documents/180708/download)  Upload Inspection report  Diagram  Description automatically generated | [[BrazeInsTech]] <<SRF>>  [[BrazeInsTime]] <<TIMESTAMP>>  [[BrazeInsComm]] <<COMMENT>>  [[BrazeInsFile]] <<FILEUPLOAD>>  [[BrazeInsMail]] {{BLUMER}} <<EMAIL>>  [[BrazeInsMail]] {{Pansophy: End Group 1 Beampipe Assy has finished preliminary inspection.}} <<EMAILSUBJ>> |

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| MACHINE SHOP | | |
| 6 | Remove slug and machine tube to final ID as per [JL0136187](https://misportal.jlab.org/jlabDocs/documents/180708/download)  Include job number | [[MachTech]] <<SRF>>  [[MachTime]] <<TIMESTAMP>>  [[MachJobNumber]] <<INTEGER>>  [[MachComm]] <<COMMENT>> |

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| LEAK CHECK | | |
| 7 | Leak check the assembly in accordance with [11141-S-0033](https://misportal.jlab.org/jlabDocs/documents/70285/download) Vendor Standard Helium Leak Check Procedure  Upload any relevant images/comments | [[BrazeVacTech]] <<SRF>>  [[BrazeVacTime]] <<TIMESTAMP>>  [[BrazeVacPass]] <<YESNO>>  [[BrazeVacComm]] <<COMMENT>>  [[BrazeVacFile]] <<FILEUPLOAD>>  [[BrazeVacMail]] {{BLUMER}} <<EMAIL>>  [[BrazeVacMail]] {{Pansophy: End Group 1 Beampipe Assy has finished preliminary leak check.}} <<EMAILSUBJ>> |

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| TECHNICAL REPRESENTATIVE | | |
| 8 | Enter SRF OPS Shipping form number and Purchase Requisition number for ultrasonic testing. | [[TechRep]] <<SRF>>  [[ShippingFormNumber]] <<INTEGER>>  [[PurchaseRequestNumber]] <<INTEGER>> |

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| ULTRASONIC INSPECTION | | |
| 9 | Ultrasonic inspection of the braze as per EN ISO 18279 Level B,  and no discontinuities over a length ≥20% of the nominal length of the joint.  Upload inspection report | [[UtTech]] <<SRF>>  [[UtTime]] <<TIMESTAMP>>  [[UtPass]] <<YESNO>>  [[UtComm]] <<COMMENT>>  [[UtFile]] <<FILEUPLOAD>> |

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| MACHINE SHOP | | |
| 10 | Machine Transition and Knife Edge as per [JL0136187](https://misportal.jlab.org/jlabDocs/documents/180708/download)  Include Job number | [[KnifeMachTech]] <<SRF>>  [[KnifeMachTime]] <<TIMESTAMP>>  [[KnifeMachJobNumber]] <<INTEGER>>  [[KnifeMachComm]] <<COMMENT>> |

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| LEAK CHECK | | |
| 11 | Leak check the assembly in accordance with [11141-S-0033](https://misportal.jlab.org/jlabDocs/documents/70285/download) Vendor Standard Helium Leak Check Procedure  Use a copper seal to validate knife edge  Upload any relevant images/comments | [[KnifeVacTech]] <<SRF>>  [[KnifeVacTime]] <<TIMESTAMP>>  [[KnifeVacPass]] <<YESNO>>  [[KnifeVacComm]] <<COMMENT>>  [[KnifeVacFile]] <<FILEUPLOAD>> |

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| DIMENSIONAL INSPECTION | | |
| 12 | **Verify all dimensions on** [JL0136187](https://misportal.jlab.org/jlabDocs/documents/180708/download)  **Take knife edge profile on FormTracer**  **Upload inspection report** | [[KnifeInsTech]] <<SRF>>  [[KnifeInsTime]] <<TIMESTAMP>>  [[KnifeInsPass]] <<YESNO>>  [[KnifeInsComm]] <<COMMENT>>  [[KnifeInsFile]] <<FILEUPLOAD>>  [[KnifeInsMail]] {{BLUMER}} <<EMAIL>>  [[KnifeInsMail]] {{Pansophy: End Group 1 Beampipe Assy has finished final inspection.}} <<EMAILSUBJ>> |

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| LOGISTICS | | |
| 13a | Upload pictures of finished assembly | [[FPEGBPSN2]] <<FPEGBPSN>>  [[LogTime]] <<TIMESTAMP>>  [[LogFile]] <<FILEUPLOAD>> |
| 13b | Return to inventory | [[LogTech]] <<SRF>>  [[LogComm]] <<COMMENT>> |