|  |  |
| --- | --- |
| Traveler Title | L2HE BLA Chemistry and Oven Processing |
| Traveler Abstract | Covers steps for BLA cleaning |
| Traveler ID | L2HE-CHEM-BLA-DEGR |
| Traveler Revision  | R1 |
| Traveler Author | A. Grabowski |
| Traveler Date | 9-Jul-24 |
| NCR Informative Emails | D.Forehand |
| NCR Dispositioners | A. Grabowski, G. Cheng |
| D3 Emails | D.Forehand, A. Grabowski, G. Cheng |
| Approval Names | A.Grabowski | D. Forehand | M. Bevins |  |
| Approval Signatures |  |  |  |  |
| Approval Dates |  |  |  |  |
| Approval Title | Author/SOTR | Reviewer | 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. |
| L2HE-CST-BLAVV | [CP-L2HE-CLNRM-BLA-ASSY](file:///C%3A%5CUsers%5Cadamg%5CDownloads%5CCP-L2PRD-%20BLA-assy) | [M:\asd\asddata\CavityProduction\LCLS2 L2PRD Project Folder\LCLS2 L2PRD BLA Pic2](file:///M%3A%5Casd%5Casddata%5CCavityProduction%5CLCLS2%20L2PRD%20Project%20Folder%5CLCLS2%20L2PRD%20BLA%20Pic2) |  |  |
|  |  |  |  |  |

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

|  |  |  |
| --- | --- | --- |
| Step No. | Instructions | Data Input |
| 1 | ***Cleaning***Record date of cleaning and technician name.Clean both housing and absorber per L2HE Copper plated bellows cleaning procedure. After cleaning, dry the parts under laminar flow. When they are dry, close them in the cleanroom bags and send housings to Elnik furnace and ceramics to Big Blue furnace for baking.If any damage or anomaly is found, upload pictures and provide comments. | [[AbsCleaningDate]] <<TIMESTAMP>>[[CleaningOperators1]] <<SRF>>[[Cleaning\_pics]] <<FILEUPLOAD>>[[Cleaning\_comment]] <<COMMENT>> |
|  | ***Ceramic absorber Bake***Record technician name, date of the bake operation. Effective bake time for ***ceramic absorber***: 6 hours at 600 C, if RGA scan does not pass spec then continue bake for up to 12 hours.Upload RGA file taken during bake if applicable.Provide comments if any. If any issues during high temperature bake, generate **NCR**. | [[AbsBakeDate]] <<TIMESTAMP>>[[AnsBakeOperators]] <<SRF>>[[AbsRGA]]<<FILEUPLOAD>>[[CommAbsBake]] <<COMMENT>> **NCR.**[[HP1]] {{Grabowski}} <<HOLDPOINT>> |
|  | ***Housing bake***Effective bake time for ***housing***: 6 hours at 300 C, if RGA scan does not pass spec then continue bake for up to 12 hours.Record name, date and upload RGA file if applicable. Provide final bake time required and comments, if any. If any issues during high temperature bake, generate **NCR**. | [[HousingBakeDate]] <<TIMESTAMP>>[[HousingBakeOperators]] <<SRF>>[[HousingRGA]]<<FILEUPLOAD>>[[CommHousingBake]] <<COMMENT>> **NCR.**[[HP1]] {{Grabowski}} <<HOLDPOINT>> |
|  | ***After baking*****Bag and N2 purge ceramic absorber immediately** when removed from oven, then move ceramic and housing to chem room.At chem room, place bagged ceramic absorber in clean room pass-thru. **Do not re-clean Absorber.**Clean housing following L2HE post-bake copper plated bellows cleaning procedure. Dry and place in the clean room pass-thru.**Communicate with clean room staff to move the parts into the nitrogen cabinet as soon as possible.** | [[PassthruDate\_absorber]] <<TIMESTAMP>>[[PassthruDate\_housing]] <<TIMESTAMP>> |