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| Traveler Title | L2HE BLA Assembly |
| Traveler Abstract | Covers steps for BLA processing including incoming inspection, cleaning, assembly and leak checks |
| Traveler ID | L2HE-CLNRM-BLA-ASSY |
| 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 |   |

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

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| Step No. | Instructions | Data Input |
| 1 | ***Clean room assembly***Record assembly date and clean room operator(s) name.Before assembly, inspect units. If any damage or anomaly not noted in earlier steps of this traveler, generate **NCR**. BLA and hardware preparation: spray with dry filtered N2 gas in front of a particulate counter until particle count is zero. | [[CleanRoomDate]] <<TIMESTAMP>>[[AssyOperators1]] <<SRF>>[[AssyOperators2]] <<SRF>> |
| Ensure VAT right angle valve is leak checked. (If VAT right angle valve is not leak checked, contact supervisor). Enter serial number of vacuum valve (4 digit, usually start with 8) used in this assembly.Assemble BLA with right angle valve, ceramic absorber and beamline blanks per the assembly procedure, linked above.* **Spray out the inside of the BLA after each flange installation.**
 | [[AV15SN]] <<AV15SN>>[[VV\_leak]] <<YESNO>> |
| Final vacuum leak check and mass spectrum checkPerform vacuum leak check and select leak check result.After leak check, change RGA setting to histogram scan and change the amu range up to 100 and wait till the scan is stabilized.Record total pressure from pressure gage, **not** from RGA software. | [[Final\_LeakCheck\_pass]] <<YESNO>> |
| Record sum of each pressure peaks of amu from 45 up to 100. If this sum is more than 1/1000 of total pressure, write and NCR and the unit must be re-processed. Upload RGA file of the histogram scan. | [[Total\_pressure]] <<FLOAT>> mbar[[HistogramScan]]<<FILEUPLOAD>> |
| **Slow Bleed up**When the unit meets the mass spectrum requirement, bleed the unit using cavity slow-bleed system. | [[Sum\_45to100]] <<FLOAT>> mbar |
| BaggingAfter bleeding up, double bag the unit filled with nitrogen and record time. Communicate with other work centers for storage options. Leave the bagged unit in clean room N2 cabinet until ready for shipping.Record clean room exit date. | [[BLABagDate]] <<TIMESTAMP>> |
| When the unit exits clean room, proper information (status change and etc) will be recorded in Pansophy inventory system.  | [[Cleanroom\_exit\_date]] <<TIMESTAMP>> |
| 2 | Final review and production releaseIs the unit released for production?Provide comment on this unit if any. | Stop[[Reviewer]] <<SRF>>[[Prod\_release]] <<YESNO>>[[Final\_comment]] <<COMMENT>> |