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| Traveler Title | L2HE BLA Disassembly and Inspection |
| Traveler Abstract | Covers inspection steps for BLA production |
| Traveler ID | L2HE-CM-INSP-BLA |
| 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 |
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| **General handling guidelines: The BLA bellows are fragile and susceptible to denting if dropped or struck. Great care shall be taken to prevent damage during handling. Both end flanges contain sealing surfaces. Care shall be taken to avoid scratching/gouging these surfaces and protective covers shall be installed over these surfaces at all possible times.** |
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|  | Initial Inspection |  |
| 1 | In CMM room, using the proper BLA tooling, disassemble ceramic absorber from housing. Keep hardware separate. New hardware will be issued for clean room assembly. C-channels will be anodized and G-10 retainers will be replaced by stainless steel retainer. ***Magnetic field check***Perform BLA magnetic field test. If permeability is below the threshold specifications (0.5 mGauss) record YES. If higher, document in the comment box and generate **NCR**. ***Flanges***Visually check integrity of the BLA flanges (sealing surfaces, knife edges). If everything is okay record YES. If damage is present, document with relevant photos, comments and generate **NCR**.***Bellows***Inspect integrity of both small and large bellows. If everything is okay record YES. If damage is present, document with relevant photos, specify whether it’s large or small bellows, comments and generate **NCR**.***Copper plating***Inspect the quality of copper plating. If everything is okay record YES. If damage is present, document with relevant photos, specify location, comments and generate **NCR**.***Ceramic brazing***Visually check integrity of the BLA copper-stub brazing. If everything is okay record YES. Count the number of not brazed pins (normally found around the edges). If damage present, or the number of **non-brazed pins is GREATER THAN 20** document with relevant photos, comments and generate **NCR**.When visual inspection is complete, move the parts to Chem-room for cleaning. Leave the housing and absorber disassembled. | [[BLAVisADate]] <<TIMESTAMP>>[[VisInspector]] <<SRF>>[[BLAPerm]] <<YESNO>[[BLAFlanges]] <<YESNO>>[[BLABellows]] <<YESNO>>[[BLACopperBL]] <<YESNO>>[[BLACopperStub]] <<YESNO>>[[NoBrazePins]] <<INTEGER>>[[Visual\_Comm]] <<COMMENT>> [[Visual\_pics]] <<FILEUPLOAD>> |