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| Traveler Title | C100R Reinforced Pivot Arm Inspection Traveler |
| Traveler Abstract | This document is to be used to inspect the replacement cold tuner pivot arms. These pivot arms were upgraded to improve the microphonics of the structure inside the Cryomodule. |
| Traveler ID | C100R-INSP-RPAD |
| Traveler Revision  | R1 |
| Traveler Author | John Fischer |
| Traveler Date | 29-Oct-24 |
| NCR Informative Emails | areilly,fischer,weinmann |
| NCR Dispositioners | fischer,weinmann,jared |
| D3 Emails | areilly,fischer,jared,weinmann |
| Approval Names | John Fischer | Jared Martin | John Fischer | Michelle Weinmann |
| Approval Signatures |  |  |  |  |
| Approval Dates |  |  |  |  |
| Approval Title | Author | Reviewer | Work Center Lead | Project Representative |

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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.**All materials linked below and throughout this traveler are for reference only and should be verified for latest version at time of use.** |
| [C100 Reinforced Tuner Pivot Arm Dwg](https://misportal.jlab.org/jlabDocs/items/49768) |  |  |  |  |
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| Revision Note |  |
| R1 | Initial release of this Traveler. |

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| Step No. | InstructionsPerform inspections of the pivot arm as this document describes. Record results by identifying yes or no, to specified tolerances or features. | Data Input |
| 1 | View of datums and red circled numbered dimensions to be measured or fit tests to be performed.**VIEW 1** | [[InspectorV1]] <<SRF>>[[InspDateV1]] <<TIMESTAMP>>[[InspCommentV1]] <<COMMENT>>[[RPADSN]] <<RPADSN>>[[AttachPictures]] <<FILEUPLOAD>> |
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| # | Qnty | Dimension and Feature | Action |
| 1 | 1 | R 2.19 | CMM |
| 2 | 2 | 3.690 | CMM |
| 3 | 2 | D- .750, True position .002 to Datums A,B,C  | CMM |
| 4 | 2 | .064, .129, .127 | CMM |
| 5 | 1 | 3.950 | CMM |
| 6 | 1 | Planer to Datum C .002 | CMM |
| 7 | 1 | 7.000 | CMM |
| 8 | 2 | 2.69 | CMM |
| 9 | 2 | D- .195-.190 | CMM |
| 10 | 2 | 1.312 | CMM |
| 11 | 1 | 5.750 | CMM |
| 12 | 2 | #8-32 UNC | Hardware fit test |
| 13 | 2 | .688 | Hardware fit test |
| 14 | 4 | 1.281 | Hardware fit test |
| 15 | 2 | .906 | Hardware fit test |
| 16 | 4 | D- .377-.376 | Hardware fit test |
| 17 | 4 | D- .614-.595 | Hardware fit test |
| 18 | 4 | .312-18 UNC | Hardware fit test |
| 19 | 4 | .125 Thru | Visual |
| 20 | 4 | 1.250 | Caliper |

Label and Upload the CMM Data file | [[InspDataView1]] <<SRF>>[[DataView1Date]] <<TIMESTAMP>>[[DateView1Comment]] <<COMMENT>>[[UploadDataFileView1]] <<FILEUPLOAD>> [[View1N1]] <<YESNO>> [[View1N2]] <<YESNO>> [[View1N3]] <<YESNO>> [[View1N4]] <<YESNO>> [[View1N5]] <<YESNO>> [[View1N6]] <<YESNO>> [[View1N7]] <<YESNO>> [[View1N8]] <<YESNO>> [[View1N9]] <<YESNO>> [[View1N10]] <<YESNO>> [[View1N11]] <<YESNO>> [[View1N12]] <<YESNO>> [[View1N13]] <<YESNO>> [[View1N14]] <<YESNO>> [[View1N15]] <<YESNO>> [[View1N16]] <<YESNO>> [[View1N17]] <<YESNO>> [[View1N18]] <<YESNO>> [[View1N19]] <<YESNO>> [[View1N20]] <<YESNO>> |
| 4 | **VIEW 2** | [[InspectorV2]] <<SRF>>[[InspDateV2]] <<TIMESTAMP>>[[InspCommentV2]] <<COMMENT>> |
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| # | Qnty | Dimension and Feature | Action |
| 1 | 1 | 2.470 | CMM |
| 2 | 1 | 2.800 | CMM |
| 3 | 1 | 3.070 | CMM |
| 4 | 1 | 3.400 | CMM |
| 5 | 1 | 4.940 | CMM |
| 6 | 1 | 5.600 | CMM |
| 7 | 1 | 6.140 | CMM |
| 8 | 1 | 6.800 | CMM |
| 9 | 1 | Perpendicularity to C .002, Planer .002 | CMM |
| 10 | 1 | Perpendicularity to C .002, Planer .002 | CMM |

Label and Upload the CMM Data file | [[InspDataView2]] <<SRF>>[[DataView2Date]] <<TIMESTAMP>>[[DateView2Comment]] <<COMMENT>>[[UploadDataFileView2]] <<FILEUPLOAD>> [[View2N1]] <<YESNO>> [[View2N2]] <<YESNO>> [[View2N3]] <<YESNO>> [[View2N4]] <<YESNO>> [[View2N5]] <<YESNO>> [[View2N6]] <<YESNO>> [[View2N7]] <<YESNO>> [[View2N8]] <<YESNO>> [[View2N9]] <<YESNO>> [[View2N10]] <<YESNO>> |
| 6 | **VIEW 3** | [[InspectorV3]] <<SRF>>[[InspDateV3]] <<TIMESTAMP>>[[InspCommentV3]] <<COMMENT>> |
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| # | Qnty | Dimension and Feature | Action |
| 1 | 1 | 1.312 | CMM |
| 2 | 2 | 1.485 | CMM |
| 3 | 1 | 4.000 | CMM |
| 4 | 1 | .359 Spot Face .03 deep | CMM |

Label and Upload the CMM Data file | [[InspDataView3]] <<SRF>>[[DataView3Date]] <<TIMESTAMP>>[[DateView3Comment]] <<COMMENT>>[[UploadDataFileView3]] <<FILEUPLOAD>> [[View3N1]] <<YESNO>> [[View3N2]] <<YESNO>> [[View3N3]] <<YESNO>> [[View3N4]] <<YESNO>> |
| 8 | **VIEW 4** | [[InspectorV4]] <<SRF>>[[InspDateV4]] <<TIMESTAMP>>[[InspCommentV4]] <<COMMENT>> |
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| # | Qnty | Dimension and Feature | Action |
| 1 | 1 | 4.938 | CMM |
| 2 | 1 | 1.625 | CMM |
| 3 | 1 | 4.937 | CMM |
| 4 | 1 | 1.625 | CMM |
| 5 | 4 | .5000 | CMM |
| 6 | 4 | 1.000 | CMM |
| 7 | 1 | .750 | CMM |
| 8 | 1 | 1.374 | CMM |
| 9 | 1 | 1.374 | CMM |
| 10 | 1 | .750 | CMM |
| 11 | 4 | .312-18 UNC | Hardware fit test |

Label and Upload the CMM Data file | [[InspDataView4]] <<SRF>>[[DataView4Date]] <<TIMESTAMP>>[[DateView4Comment]] <<COMMENT>>[[UploadDataFileView4]] <<FILEUPLOAD>> [[View4N1]] <<YESNO>> [[View4N2]] <<YESNO>> [[View4N3]] <<YESNO>> [[View4N4]] <<YESNO>> [[View4N5]] <<YESNO>> [[View4N6]] <<YESNO>> [[View4N7]] <<YESNO>> [[View4N8]] <<YESNO>> [[View4N9]] <<YESNO>> [[View4N10]] <<YESNO>> [[View4N11]] <<YESNO>> |
| 10 | **VIEW 5** | [[InspectorV5]] <<SRF>>[[InspDateV5]] <<TIMESTAMP>>[[InspCommentV5]] <<COMMENT>> |
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| # | Qnty | Dimension and Feature | Action |
| 1 | 1 | .506 | Caliper |
| 2 | 1 | .333 | CMM |
| 3 | 1 | 37 Degrees | CMM |
| 4 | 1 | .333 | CMM |
| 5 | 4 | R .12 | Visual |

Label and Upload the CMM Data file | [[InspDataView5]] <<SRF>>[[DataView5Date]] <<TIMESTAMP>>[[DateView5Comment]] <<COMMENT>>[[UploadDataFileView5]] <<FILEUPLOAD>> [[View5N1]] <<YESNO>> [[View5N2]] <<YESNO>> [[View5N3]] <<YESNO>> [[View5N4]] <<YESNO>> [[View5N5]] <<YESNO>>[[PivotInspCompleteEmail]] {{fischer,jared,weinmann }} <<EMAIL>>[[PivotInspCompleteEmail]] {{PivotTRNotify}} <<EMAILSUBJ>> |
| 12 | Technical Representative or designee to review data and determine any actions to be taken. Findings remarks should be added to comment box. | [[TRReview]] <<SRF>>[[TRReviewDate]] <<TIMESTAMP>>[[TRReviewComment]] <<COMMENT>> |