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| Traveler Title | End Group 2 Assembly Traveler | | | |
| Traveler Abstract | Outlines the inspection and fabrication steps for the End Group 2 for the EIC 197Mhz Crab Cavity | | | |
| Traveler ID | EIC197-FAB-ENDG2-ASSY | | | |
| Traveler Revision | R1 | | | |
| Traveler Author | Eduard Drachuk | | | |
| Traveler Date | 22-Oct-24 | | | |
| NCR Informative Emails | AREILLY,GEORGED,O'BRIEN,KDAVIS | | | |
| NCR Dispositioners | DRACHUK,BUTTLES,HUQUE | | | |
| D3 Emails | AREILLY,GEORGED,BUTTLES, O'BRIEN,KDAVIS,DRACHUK,HUQUE | | | |
| Approval Names | E. DRACHUK | A. O'BRIEN | J. BUTTLES | N. HUQUE |
| Approval Signatures |  |  |  |  |
| Approval Dates |  |  |  |  |
| Approval Title | Author | Reviewer | Group Leader | 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. | | | |
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| Revision Note |  |
| R1 | Initial release of this Traveler. |

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| Step No. | Instructions | Data Input |
| PART IDENTIFICATION | | |
| 0 | Enter Serial Number of Finished Part   |  |  |  | | --- | --- | --- | | **STEPS** | **WORK CENTER AREAS** | **ACTIONS** | | 1 | MACHSHOP | Part Forming | | 2 | INSP | CMM | | 3 | CHEM | BCP | | 4 | EBW | EBW | | 5 | INSP | CMM | | 6 | CHEM | BCP | | 7 | EBW | EBW | | 8 | INSP | CMM | | 9 | CHEM | BCP | | 10 | EBW | EBW | | 11 | CHEM | BCP | | 12 | CMA | Leak Check | | 13 | CMA | Assemble | | 14 | INSP | CMM | | [[EG1SN]] <<SN>>  [[New part SN dropdown]] <<NOTE>> |
| FORMING | | |
| 1 | Form JL0129594 End Dish | [[FormingTech]] <<SRF>>  [[FormingTime]] <<TIMESTAMP>>  [[FormingComment]] <<COMMENT>> |
| DIMENSIONAL INSPECTION | | |
| 2 | Verify dimensions in red for JL0129594 End Dish | [[DISHSN]] <<SN>>  [[New part SN dropdown]] <<NOTE>>  [[InspectionTech1]] <<SRF>>  [[InspectionTime1]] <<TIMESTAMP>>  [[InspectionComment1]] <<COMMENT>>  [[InspectionUpload1]] <<FILEUPLOAD>> |
| CHEMISTRY | | |
| 3a | BCP JL0129594 End Dish to a depth of 15 microns  According to SRF-MSPR-CHEM-NB-ACID-R1 Acid Etching Proceedure | [[ChemistryTech1]] <<SRFCVP>>  [[ChemistryTime1]] <<TIMESTAMP>>  [[ChemistryComment1]] <<COMMENT>>  [[ChemistryUpload1]] <<FILEUPLOAD>> |
| 3b | BCP JL0143260 Boss (x2) to a depth of 15 microns  According to SRF-MSPR-CHEM-NB-ACID-R1 Acid Etching Proceedure | [[ChemistryTech2]] <<SRFCVP>>  [[ChemistryTime2]] <<TIMESTAMP>>  [[ChemistryComment2]] <<COMMENT>>  [[ChemistryUpload2]] <<FILEUPLOAD>> |
| 3c | BCP JL0135965 Boss (x2) to a depth of 15 microns  According to SRF-MSPR-CHEM-NB-ACID-R1 Acid Etching Proceedure | [[ChemistryTech3]] <<SRFCVP>>  [[ChemistryTime3]] <<TIMESTAMP>>  [[ChemistryComment3]] <<COMMENT>>  [[ChemistryUpload3]] <<FILEUPLOAD>> |
| 3d | BCP JL0134212 End Plate 2 to a depth of 15 microns  According to SRF-MSPR-CHEM-NB-ACID-R1 Acid Etching Proceedure | [[ChemistryTech5]] <<SRFCVP>>  [[ChemistryTime5]] <<TIMESTAMP>>  [[ChemistryComment5]] <<COMMENT>>  [[ChemistryUpload5]] <<FILEUPLOAD>> |
| 3e | BCP JL0136180 HHOW Waveguide Assembly to a depth of 15 microns  According to SRF-MSPR-CHEM-NB-ACID-R1 Acid Etching Proceedure | [[ChemistryTech6]] <<SRFCVP>>  [[ChemistryTime6]] <<TIMESTAMP>>  [[ChemistryComment6]] <<COMMENT>>  [[ChemistryUpload6]] <<FILEUPLOAD>> |
| 3f | BCP JL0136179 FPC Waveguide Assembly to a depth of 15 microns  According to SRF-MSPR-CHEM-NB-ACID-R1 Acid Etching Proceedure | [[ChemistryTech7]] <<SRFCVP>>  [[ChemistryTime7]] <<TIMESTAMP>>  [[ChemistryComment7]] <<COMMENT>>  [[ChemistryUpload7]] <<FILEUPLOAD>> |
| 3g | BCP JL0136181 FPC Beampipe Assembly to a depth of 15 microns  According to SRF-MSPR-CHEM-NB-ACID-R1 Acid Etching Proceedure | [[ChemistryTech8]] <<SRFCVP>>  [[ChemistryTime8]] <<TIMESTAMP>>  [[ChemistryComment8]] <<COMMENT>>  [[ChemistryUpload8]] <<FILEUPLOAD>> |
| 3h | BCP JL0143978 Nut (x4) to a depth of 15 microns  According to SRF-MSPR-CHEM-NB-ACID-R1 Acid Etching Proceedure | [[ChemistryTech9]] <<SRFCVP>>  [[ChemistryTime9]] <<TIMESTAMP>>  [[ChemistryComment9]] <<COMMENT>>  [[ChemistryUpload9]] <<FILEUPLOAD>> |
| EBW | | |
| 4a | Using fixture JL0147503, EBW JL0143260 Boss (x2) and JL0135965 Boss (x2) to JL0129594 End Dish | [[DISHSN]] <<SN>>  [[New part SN dropdown]] <<NOTE>>  [[BSOUTSN]] <<SN>>  [[New part SN dropdown]] <<NOTE>>  [[BSINSN]] <<SN>>  [[New part SN dropdown]] <<NOTE>>  [[EBWTech1]] <<SRF>>  [[EBWTime1]] <<TIMESTAMP>>  [[EBWComment1]] <<COMMENT>>  [[EBWFile1]] <<FILEUPLOAD>> |
| 4b | EBW JL0136180 HHOM Waveguide Assembly and JL0136179 FPC Waveguide Assembly to JL0134212 End Plate 2 | [[PLATE2SN]] <<SN>>  [[New part SN dropdown]] <<NOTE>>  [[???179]] <<SN>>  [[New part SN dropdown]] <<NOTE>>  [[???180]] <<SN>>  [[New part SN dropdown]] <<NOTE>>  [[EBWTech2]] <<SRF>>  [[EBWTime2]] <<TIMESTAMP>>  [[EBWComment2]] <<COMMENT>>  [[EBWFile2]] <<FILEUPLOAD>> |
| DIMENSIONAL INSPECTION | | |
| 5a | Verify dimensions in red for JL0129594 End Dish With Bosses | [[InspectionTech2]] <<SRF>>  [[InspectionTime2]] <<TIMESTAMP>>  [[InspectionComment2]] <<COMMENT>>  [[InspectionUpload2]] <<FILEUPLOAD>> |
| 5b | Verify dimensions in red for JL0134212 End Plate 2 With HHOM Waveguide And FPC Waveguide | [[InspectionTech3]] <<SRF>>  [[InspectionTime3]] <<TIMESTAMP>>  [[InspectionComment3]] <<COMMENT>>  [[InspectionUpload3]] <<FILEUPLOAD>> |
| CHEMISTRY | | |
| 6a | Optional BCP JL0129594 End Dish With Bosses to a depth of 15 microns  According to SRF-MSPR-CHEM-NB-ACID-R1 Acid Etching Proceedure | [[ChemistryTech10]] <<SRFCVP>>  [[ChemistryTime10]] <<TIMESTAMP>>  [[ChemistryComment10]] <<COMMENT>>  [[ChemistryUpload10]] <<FILEUPLOAD>> |
| 6b | BCP JL0134212 End Plate 2 With HHOM Waveguide And FPC Waveguide to a depth of 15 microns  According to SRF-MSPR-CHEM-NB-ACID-R1 Acid Etching Proceedure | [[ChemistryTech11]] <<SRFCVP>>  [[ChemistryTime11]] <<TIMESTAMP>>  [[ChemistryComment11]] <<COMMENT>>  [[ChemistryUpload11]] <<FILEUPLOAD>> |
| EBW | | |
| 7 | Using fixture JL0170550, EBW JL0136181 FPC Beampipe Assembly to JL0134212 End Plate 2 With HHOM Waveguide and FPC Waveguide to create part JL0136182 | [[???181]] <<SN>>  [[New part SN dropdown]] <<NOTE>>  [[EBWTech4]] <<SRF>>  [[EBWTime4]] <<TIMESTAMP>>  [[EBWComment4]] <<COMMENT>>  [[EBWFile4]] <<FILEUPLOAD>> |
| DIMENSIONAL INSPECTION | | |
| 8 | Verify dimensions in red for JL0136182 FPC End Plate Assembly | [[InspectionTech5]] <<SRF>>  [[InspectionTime5]] <<TIMESTAMP>>  [[InspectionComment5]] <<COMMENT>>  [[InspectionUpload5]] <<FILEUPLOAD>> |
| CHEMISTRY | | |
| 9 | BCP JL0136182 FPC End Plate Assembly to a depth of 15 microns  According to SRF-MSPR-CHEM-NB-ACID-R1 Acid Etching Proceedure | [[ChemistryTech13]] <<SRFCVP>>  [[ChemistryTime13]] <<TIMESTAMP>>  [[ChemistryComment13]] <<COMMENT>>  [[ChemistryUpload13]] <<FILEUPLOAD>> |
| EBW | | |
| 10 | Using fixture JL0146916, EBW JL0136182 to JL0136183 to create part JL0134243 | [[EBWTech6]] <<SRF>>  [[EBWTime6]] <<TIMESTAMP>>  [[EBWComment6]] <<COMMENT>>  [[EBWFile6]] <<FILEUPLOAD>> |
| CHEMISTRY | | |
| 11 | BCP JL0134243 to a depth of 15 microns  According to SRF-MSPR-CHEM-NB-ACID-R1 Acid Etching Proceedure | [[ChemistryTech15]] <<SRFCVP>>  [[ChemistryTime15]] <<TIMESTAMP>>  [[ChemistryComment15]] <<COMMENT>>  [[ChemistryUpload15]] <<FILEUPLOAD>> |
| LEAK CHECK | | |
| 12 | Leak check the assembly (JL0134243) in accordance with 11141-S-0033  Vendor Standard Helium Leak Check Procedure  Upload any relevant images/comments | [[LeakCheckTech]] <<SRF>>  [[LeakCheckTime]] <<TIMESTAMP>>  [[LeakCheckPass]] <<YESNO>>  [[LeakCheckComment]] <<COMMENT>>  [[LeakCheckUpload]] <<FILEUPLOAD>>  [[LeakCheckEmail]] {{DRACHUK}} <<EMAIL>>  [[LeakCheckEmail]] {{Pansophy: End Group 1 Passed The Leak Check}} <<EMAILSUBJ>> |
| ASSEMBLY | | |
| 13 | Assemble JL0145103 (x4) Rod with JL0143978 (x4) Nut to JL0134243 | [[AssemblyTech]] <<SRF>>  [[AssemblyTime]] <<TIMESTAMP>>  [[AssemblyComment]] <<COMMENT>>  [[AssemblyUpload]] <<FILEUPLOAD>> |
| DIMENSIONAL INSPECTION | | |
| 14 | Verify dimensions in red for JL0134243 | [[InspectionTech7]] <<SRF>>  [[InspectionTime7]] <<TIMESTAMP>>  [[InspectionComment7]] <<COMMENT>>  [[InspectionUpload7]] <<FILEUPLOAD>> |