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| Traveler Title | L2HE BLA Disassembly and Inspection |
| Traveler Abstract | Covers inspection steps for BLA production |
| Traveler ID | L2HE- INSP-BLA |
| Traveler Revision  | R1 |
| Traveler Author | M.Oast |
| Traveler Date | 15-Nov-24 |
| NCR Informative Emails | forehand |
| NCR Dispositioners | adamg,cheng,weinmann |
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| Approval Signatures |  |  |  |  |
| Approval Dates |  |  |  |  |
| Approval Title | Author/SOTR | Reviewer | 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. |
| [F10080259 BLA Kit Assy](https://misportal.jlab.org/jlabDocs/documents/208067/download) | [F10026202 Seal End Flange](https://misportal.jlab.org/jlabDocs/documents/208071/download) | [F00457202 Flange Blank Off Cavity End](https://misportal.jlab.org/jlabDocs/documents/208073/download) | [SRF-MSPR-INSP-CPPL-R1](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-272279/SRF-MSPR-INSP-CPPL-R1.pdf) |  |
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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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| 1 | ***Initial Inspection***In CMM room, using the proper BLA tooling, disassemble ceramic absorber from housing. Keep hardware separate and deliver to inventory. New hardware will be issued for clean room assembly. C-channels will be anodized and G-10 bellows stiffeners will be replaced by stainless steel retainer. Keep G-10 stiffeners and deliver to inventory. | [[BLAVisADate]] <<TIMESTAMP>>[[VisInspector]] <<SRF>>[[BLASN]] <<BLASN>> |
| 2 | ***Magnetic hygiene check***Magnetic hygiene check of BLA parts shall be conducted in a region with relatively stable ambient field. Follow the following steps: 1. Turn on the magnetometer. Zero it if the magnetometer is equipped with a zero field chamber.
2. Anchor the magnetometer to a fixed base.
3. Take the reading of background field.
4. Move part to be on contact with the magnetometer, rotate the part to take the highest reading.
5. If the part’s highest reading subtract ambient field level is greater than 5 mG, the part is magnetic.
6. Parts that are magnetic shall be demagnetized. This can be done with a portable or DSC425-120 surface demagnetizer. Observe [JLab-PTW-2091 Demagnetizing small parts](https://urldefense.proofpoint.com/v2/url?u=https-3A__epas-2Drk95.prometheusgroup.app_Redirect.aspx-3Fitem-5Fnumber-3DJLab-2DPTW-2D2091&d=DwMFAw&c=CJqEzB1piLOyyvZjb8YUQw&r=HXSx-AF6JrbOPHtCDokxDA&m=YYHtRvogKVe3Otu94aWZ1sQBi22OLeW99dkvSkWuhxDVpoE9htptEAPSdvM9GYJ_&s=x7WMo5tEj-dqWDn71ETKxpGSsKkx86bFMgL0GUGuuYU&e=) for procedure and safety measures.
	1. To access the PTW in ePas, click the link above and press this button on the login page:
	2. Once signed in to ePas, reclick link to bring up the PTW.
7. Re-measure the demagnetized parts per steps 1-5.

If after repeated degmagnetizations some parts still cannot meet the requirement set in step 5, generate a **NCR** to describe which parts and the peak remanent field with photo evidence. | [[BLAMagHyg]] <<YESNO>>[[BLAMagHygNotes]] <<COMMENT>> |
| 3 | ***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**. | [[BLAFlanges]] <<YESNO>> |
| 4 | ***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**. | [[BLABellows]] <<YESNO>> |
| 5 | ***Copper plating***Inspect the quality of copper plating, using [SRF-MSPR-INSP-CPPL-R1](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-272279/SRF-MSPR-INSP-CPPL-R1.pdf) as a reference. If everything is okay record YES. If damage is present, document with relevant photos, specify location, comments and generate **NCR**. | [[BLACopperBL]] <<YESNO>> |
| 6 | ***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**. | [[BLACopperStub]] <<YESNO>>[[NoBrazePins]] <<INTEGER>> |
| 7 | Leave the housing and absorber disassembled. When visual inspection is complete, move the parts to Chemistry room for cleaning. | [[Visual\_Comm]] <<COMMENT>> [[Visual\_pics]] <<FILEUPLOAD>> |