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| Traveler Title | LCLS-II Rebuild Cavity String Weldment Upstream Bellows Inspection Traveler |
| Traveler Abstract | Traveler defines the inspection process for the LCLS-II Rebuild beam line Upstream Bellows |
| Traveler ID | L2RB-INSP-BLBU |
| Traveler Revision  | R1 |
| Traveler Author | M. Oast |
| Traveler Date | 23-Jul-25 |
| NCR Informative Emails | georged,mosby,areilly |
| NCR Dispositioners | weinmann,adamg,cheng |
| D3 Emails | weinmann,adamg |
| Approval Names | M.Oast | G. Dekerlegand | J. Buttles | A. Grabowski |
| Approval Signatures |  |  |  |  |
| Approval Dates |  |  |  |  |
| Approval Title | Author | Reviewer | Reviewer | 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. |
| [F10075494-D (WELDMENT BELLOWS-US END)](https://misportal.jlab.org/jlabDocs/documents/versions/212309/download) | [F10023439-B (FLANGE ROTATABLE)](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-241597/F10023439_B_DWG1.pdf) | [F10023440-B (FLANGE RING)](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-241598/F10023440_B_DWG1.pdf) | [F10075498 (BELLOWS SHORT-US END)](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-241594/F10075498___DWG1.pdf) | [F10075500-B (FLANGE NR-US END)](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-241596/F10075500_B_DWG1.pdf) |
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| Revision Note |  |
| R1 | Initial release of this Traveler. |

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| Step No. | Instructions | Data Input |
| **General handling guidelines:** The upstream 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 faces. Care shall be taken to avoid scratching/gouging this surface and a protective cover shall be installed over this face at all possible times. |
| 1 | **Initial Inspection:** |
| Technician NameDate of InspectionSerial Number of part | [[TechName]] <<SRF>>[[InspectionDate]] <<TIMESTAMP>>[[BLBUSN]] << BLBUSN>> |
| Is part clean, free from dust, oil, finger prints or other contaminants? | [[PartCleanOK]] <<YESNO>> |
| Visually inspect the bellows assembly convolutions for dings/dents/gouges. Create an NCR for any gouges. Create an NCR for any dents/dings that exceed 1/8". If a single ding or dent is under 1/8" do not create an NCR but leave a comment. For multiple dings or dents an NCR is required. | [[ConvolutionsOK]] <<YESNO>>[[ConvComment]] <<COMMENT>> |
| Visually inspect the assembly for any pitting. | [[Pitting]] <<YESNO>> |
| Are welds of good quality? (Smooth ID welds, no undercut, not cold welded/convex, no cracks, no inclusions, no protusions.)Check weld area for defects similar to the one pictured, if found create NCR. | [[WeldsOK]]<<YESNO>> |
| Inspect the flange's sealing surface for scratches/gouges. | [[SealingfaceOK]] <<YESNO>> |
| Thread in a M8 x 1.25 silicon bronze screw into the 6 tapped holes of the flange's circumference to verify pitch and ensure threads are undamaged. | [[TappedholesOK]] <<YESNO>> |
| Comments:* Upload photos of the bellows assembly even if no discrepancies are found.
* If discrepancies are found, upload photos of the discrepancy.
 | [[VisualInspComment]] <<COMMENT>>[[VisualInspPhoto]] <<FILEUPLOAD>> |
| 2 | **Storage:** |
| Each bellows assembly shall be re-packaged in its original protective packaging after inspection. | [[StorageTech]] <<SRF>>[[StorageDate]] <<TIMESTAMP>> |