LCLS
Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory
Stanford Linear Accelerator Center

Procedure Number: L1440202-00039
Revision: 0
Issue Date: 09/20/2007

LCLS Extruded Vacuum Chamber Traveler

VENDOR: Hi-Tech DATE: 12/28/07

SERIAL #: 45 PART NAME: LCLS vacuum chamber machined extrusion

DRAWING #: L1440202-200010 P.O. #: 8A-01238

1. Receive and visually inspect machined extrusion 12/28/07 MTE
2. Verify machined extrusion is serialized per section 2.3.3.1 of ESD 1.4-118 MTE 12/28/07
3. Clean chamber per section 2.6 of ESD 1.4-106 KTK 1/9/08
4. Mount machined extrusion to support structure MTE 1/10/08
5. Inspect per section 3.2 of ESD 1.4-118 MTE 1/10/08
6. GTAW flanges to chamber per section 2.4 of ESD 1.4-118 MTE 1/11/08 *
7. Post-weld leak check per section 3.4 of ESD 1.4-118 KTK+RLO 1/12/08
8. Vacuum bakeout chamber per section 3.3 of ESD 1.4-118 KTK+RLO 1/18/08
9. Leak check and RGA chamber per sections 3.4 and 3.5 of ESD 1.4-118 KTK+RLO 1/18/08
10. Prepare for shipment per section 2.9 of ESD 1.4-106 MTE 1/31/08
11. Photograph MTE 1/31/08
12. Crate chamber per section 2.9 of ESD 1.4-106 MTE 1/31/08
13. Ship to LCLS MTE 1/31/08

* SMALL WELD BEAD @ CORNER ON END B. NOT IN APERTURE. ACCEPT AS IS. MTE

RECHECK FLANGE ⊥ AFTER BAKEOUT. OK MTE