

ATTACH THIS FORM TO LCLS SYSTEMS AND COMPONENTS TO CONTROL THE SEQUENCE OF QUALITY ASSURANCE TASKS. RETURN THE COMPLETED TRAVELER TO THE LCLS QUALITY ASSURANCE COORDINATOR UPON COMPLETION.

System or Component Name: <i>LCLS Undulator Main Assembly</i>			
Part/Drawing Number: <i>L143-112000</i>		Revision:	Serial Number:
Manufacturer: <i>Metalex Manufacturing Inc</i>			Purchase Order Number:

Special Instructions:

<i>This form is to be completed upon shipment of First Article LCLS Undulator Main Assemblies to SLAC</i>
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Quality Assurance Tasks (attach continuation sheets if additional steps are required)

Seq No.	Task Description <i>*Inform the LCLS Technical Lead if a task cannot be completed or a requirement met</i>	Completed by/Date*	Requirement Met	Requirement Not Met*
1	<i>Place a copy the applicable list of drawings into the LCLS Undulator Main Assembly Quality Assurance Package</i>		<input type="checkbox"/>	<input type="checkbox"/>
2	<i>Place copy of final magnetic measurement results into the LCLS Undulator Main Assembly Quality Assurance Package</i>		<input type="checkbox"/>	<input type="checkbox"/>
3	<i>Place a copy of ANL Purchase Order 5A-10359 for the Undulator Main Assembly into the Undulator Main Assembly Binder</i>		<input type="checkbox"/>	<input type="checkbox"/>
4	<i>Place copy of the applicable revision of LCLS Statement of Work L-143-00066 (SLAC# SP-381-001-03) for the Main Assembly into the Undulator Main Assembly Binder</i>		<input type="checkbox"/>	<input type="checkbox"/>
5	<i>Place copies of the completed ANL-266 Acceptance Criteria Listing form E5-164018 for the Main Assembly into the LCLS Undulator Main Assembly Quality Assurance Package</i>		<input type="checkbox"/>	<input type="checkbox"/>
6	<i>Place a copy of Assembly Procedure L143-00076 into the LCLS Undulator Main Assembly Quality Assurance Package</i>		<input type="checkbox"/>	<input type="checkbox"/>
7	<i>Place a copy of the contractor's test reports for the Main Assembly into the LCLS Undulator Main Assembly Quality Assurance Package. Verify test reports meet requirements of sections 4.1.2 of the Statement of Work</i>		<input type="checkbox"/>	<input type="checkbox"/>
8	<i>If applicable, place copies of contractor's Red Flag Reports, ANL-311 Supplier Disposition Reports, LCLS Reports of Nonconformance for the Main Assembly into the LCLS Undulator Main Assembly Quality Assurance Package</i>		<input type="checkbox"/>	<input type="checkbox"/>
9	<i>Place a copy of ANL Purchase Order 5A-06990 for the Titanium Strongback into the LCLS Undulator Main Assembly Quality Assurance Package</i>		<input type="checkbox"/>	<input type="checkbox"/>
10	<i>Place a copy of the applicable revision of LCLS Statement of Work L-134-00030 (SLAC # SP-381-001-00) for the Titanium Strongback into the LCLS Undulator Main Assembly Quality Assurance Package</i>		<input type="checkbox"/>	<input type="checkbox"/>

LCLS Task Leader Pre-Approval: _____ Date: _____

LCLS QA Coordinator Pre-Approval: _____ Date: _____

Optional Approver Comments:

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Distribute completed traveler to: **Responsible Engineer, Task Leader, LCLS Quality Assurance Coordinator, Chief Engineer**

Other: R. Pope

Quality Assurance Tasks continued

Seq No.	Task Description	Completed by/Date*	Requirement Met	Requirement Not Met*
11	Place a copy of the completed ANL-266 Acceptance Criteria Listing form E5-020020 for the Titanium Strongback into the LCLS Undulator Main Assembly Quality Assurance Package		<input type="checkbox"/>	<input type="checkbox"/>
12	Place a copy of the material of certificate for the Titanium Strongback into the LCLS Undulator Main Assembly Quality Assurance Package. Verify material meets requirements of section 4.1.1 of the Statement of Work.		<input type="checkbox"/>	<input type="checkbox"/>
13	Place copies of the contractor's annealing certification and annealing data for the Titanium Strongback into the LCLS Undulator Main Assembly Quality Assurance Package. Verify that annealing meets requirements of section 4.1.2.3 of the Statement of Work.		<input type="checkbox"/>	<input type="checkbox"/>
14	Place copies of the contractor's vibratory stress relief data for the Titanium Strongback into the LCLS Undulator Main Assembly Quality Assurance Package.		<input type="checkbox"/>	<input type="checkbox"/>
15	Place a copy of the contractor's test reports for the Titanium Strongback into the LCLS Undulator Main Assembly Quality Assurance Package. Verify test reports meet requirements of sections 4.5.1, 4.5.2 of the Statement of Work.		<input type="checkbox"/>	<input type="checkbox"/>
16	If applicable, place copies of the contractor's Red Flag Reports, ANL-311 Supplier Disposition Reports, LCLS Reports of Nonconformance for the Titanium Strongback into the LCLS Undulator Main Assembly Quality Assurance Package		<input type="checkbox"/>	<input type="checkbox"/>
17	Place a copy of ANL Purchase Order 5A-05150 for the Magnet Poles into the LCLS Undulator Main Assembly Quality Assurance Package		<input type="checkbox"/>	<input type="checkbox"/>
18	Place copy of the applicable revision of LCLS Statement of Work L-143-00031 (SLAC #SP-381-001-01) for the Magnet Poles into the LCLS Undulator Main Assembly Quality Assurance Package		<input type="checkbox"/>	<input type="checkbox"/>
19	Place a copy of the completed ANL-266 Acceptance Criteria Listing form E5-026046 into the LCLS Undulator Main Assembly Quality Assurance Package		<input type="checkbox"/>	<input type="checkbox"/>
20	Place a copy of the material of certificate for the Magnet Poles into the LCLS Undulator Main Assembly Quality Assurance Package. Verify material meets requirements of section 4.1.1 of the Statement of Work.		<input type="checkbox"/>	<input type="checkbox"/>
21	Place copies of the contractor's annealing certification and annealing data for the Magnet Poles into the LCLS Undulator Main Assembly Quality Assurance Package. Verify that annealing meets requirements of section 4.1.2.2 of the Statement of Work.		<input type="checkbox"/>	<input type="checkbox"/>
22	Place a copy of the contractor's test reports for the Magnet Poles into the LCLS Undulator Main Assembly Quality Assurance Package. Verify test reports meet requirements of sections 4.5, 4.5.1, and 4.5.2 of the Statement of Work.		<input type="checkbox"/>	<input type="checkbox"/>
23	If applicable, place copies of the contractor's Red Flag Reports, ANL-311 Supplier Disposition Reports, LCLS Reports of Nonconformance for the Magnet Poles into the LCLS Undulator Main Assembly Quality Assurance Package		<input type="checkbox"/>	<input type="checkbox"/>
24	Place a copy of ANL Purchase Order 5A-06868 for the Magnets into the LCLS Undulator Main Assembly Quality Assurance Package		<input type="checkbox"/>	<input type="checkbox"/>
25	Place a copy of the applicable revision of LCLS Statement of Work L-143-00032 (SLAC # 381-001-02) for the Magnets into the LCLS Undulator Main Assembly Quality Assurance Package		<input type="checkbox"/>	<input type="checkbox"/>
26	Place a copy of the completed ANL-266 Acceptance Criteria Listing form E5-069069 into the LCLS Undulator Main Assembly Quality Assurance Package		<input type="checkbox"/>	<input type="checkbox"/>
27	Place a copy of the contractor's material stabilization certification into the LCLS Undulator Main Assembly Quality Assurance Package. Verify the material stabilization certification meets requirements of section 4.1.2.3 of the Statement of Work		<input type="checkbox"/>	<input type="checkbox"/>
28	Place a copy of the contractor's surface finish certification into the LCLS Undulator Main Assembly Quality Assurance Package. Verify the surface finish certification meets requirements of section 4.1.2.3 of the Statement of Work		<input type="checkbox"/>	<input type="checkbox"/>
29	Place a copy of the contractor's magnetic measurement data into the LCLS Undulator Main Assembly Quality Assurance Package. Verify the data meets requirements of sections 4.3.2 and 4.4.3 of Statement of Work.		<input type="checkbox"/>	<input type="checkbox"/>
30	Place copy of the contractor's physical measurement certification into the LCLS Undulator Main Assembly Quality Assurance Package. Verify the certification meets requirements of sections 4.3.1 and 4.3.3 of the Statement of Work		<input type="checkbox"/>	<input type="checkbox"/>

Quality Assurance Tasks continued

Seq No.	Task Description	Completed by/Date*	Requirement Met	Requirement Not Met*
31	<i>Place copy of contractor's slot assignment list into the LCLS Undulator Main Assembly Quality Assurance Package. Verify data meets requirements of sections 4.3.1 and 4.3.3 of Statement of Work L143-00032-Rev?</i>		<input type="checkbox"/>	<input type="checkbox"/>
32	<i>Place a copy of the results of ANL's magnetic verification testing on contractor's QA samples into the LCLS Undulator Main Assembly Quality Assurance Package.</i>		<input type="checkbox"/>	<input type="checkbox"/>
33	<i>Place a copy of the results of ANL's visual and dimensional inspection of contact QA samples into the LCLS Undulator Main Assembly Quality Assurance Package.</i>		<input type="checkbox"/>	<input type="checkbox"/>
34	<i>If applicable, place copies of contractor's Red Flag Reports, ANL-311 Supplier Disposition Reports, LCLS Reports of Nonconformance for the magnets into the LCLS Undulator Main Assembly Quality Assurance Package</i>		<input type="checkbox"/>	<input type="checkbox"/>
35	<i>Insert copy of the completed Checklist for Removing an LCLS Undulator Segment into the LCLS Undulator Main Assembly Quality Assurance Package</i>		<input type="checkbox"/>	<input type="checkbox"/>
36	<i>Insert copy of the completed Checklist for Moving an LCLS Undulator Segment into the LCLS Undulator Main Assembly Quality Assurance Package</i>		<input type="checkbox"/>	<input type="checkbox"/>
37	<i>Perform visual inspection for the presence of the correct serial number on the assembly</i>		<input type="checkbox"/>	<input type="checkbox"/>
38	<i>Perform visual inspection of the Main Assembly for completeness, workmanship, and presence of magnetic labeling prior to placing it in the shipping crate</i>		<input type="checkbox"/>	<input type="checkbox"/>
39	<i>Perform re-inspection of the Main Assembly after per sections 4.1.5.1, 4.1.5.2 of the Statement of Work following placement of the Main Assembly into the shipping crate</i>		<input type="checkbox"/>	<input type="checkbox"/>
40	<i>Reset shock monitoring devices and attach Shockwatch removal and return instructions prior to transport by ANL Rigging Department</i>		<input type="checkbox"/>	<input type="checkbox"/>
41	<i>Verify that an IATA Dangerous Goods Label(s) has been applied to the outside of the shipping container identifying the presence of a magnetic field</i>		<input type="checkbox"/>	<input type="checkbox"/>
42	<i>Verify the ANL Shipping Order has the correct shipping address</i>		<input type="checkbox"/>	<input type="checkbox"/>
43	<i>Place a copy of the ANL Shipping Order into the LCLS Undulator Main Assembly Quality Assurance Package</i>		<input type="checkbox"/>	<input type="checkbox"/>
44	<i>If applicable, create a LCLS Report of Nonconformance for any traveler requirement that wasn't met for disposition by the LCLS Project. Place a copy of the completed Report of Nonconformance into the LCLS Undulator Main Assembly Quality Assurance Package.</i>		<input type="checkbox"/>	<input type="checkbox"/>
45	<i>Place a copy of the completed Quality Assurance Traveler into the LCLS Undulator Main Assembly Quality Assurance Package</i>		<input type="checkbox"/>	<input type="checkbox"/>
46	<i>Make a copy of the LCLS Undulator Main Assembly Quality Assurance Package</i>		<input type="checkbox"/>	<input type="checkbox"/>
47	<i>Forward a copy of LCLS Undulator Main Assembly Quality Assurance Package and completed traveler to LCLS QA Coordinator Tom Barsz for entry into the ANL LCLS Records Database</i>		<input type="checkbox"/>	<input type="checkbox"/>
48	<i>Send original LCLS Undulator Main Assembly Quality Assurance Package R. Pope</i>			

