

# CDC Donut Acceptance Checks

GlueX-doc: 1553

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**General Procedures:** All donuts are checked in the construction preparation area. No special handling is needed during this part of the procedure. The check is an overall yes/no on the donut with the ability to fix problems encountered during checking. The same procedure applies to both the aluminum and the plastic donuts.

**Training Procedure:** New personnel will be shown the posters describing the procedure and asked to carry out the steps under supervision. All work occurs in the prep room and no written documentation of training is maintained.

**Caution:** None

## Checking Aluminum Donuts

Check the outer diameter of the donut. It should be between 0.609 and 0.611 inches.

If it is out of range, reject the part.



**0.609 to 0.611 inches**



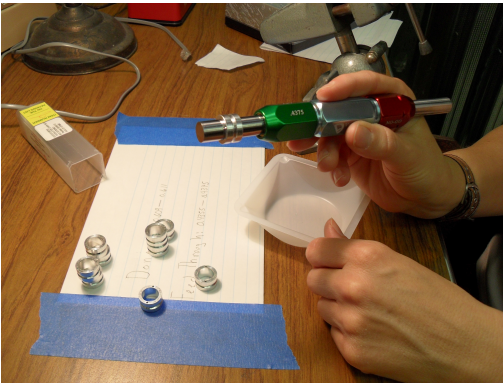
## Checking Aluminum Donuts

Check the inside hole with the go-no-go gauge. If the green end goes in, it is ok.

If the green end does not go in, then ream  
Out the hole with the hand reamer.

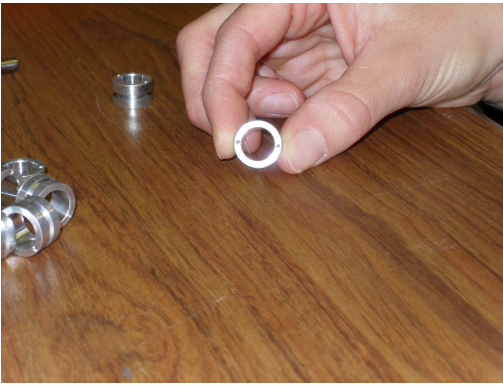
If the fit with the green felt loose, check  
The size of the hole with the red no-go  
Gauge. It should not fit.

If the no-go fits, reject the part



## Checking Aluminum Donuts

Check the size of the glue ports.



The needle should slide in and out easily. If it does, the ports are ok.

If it does not fit, the ports need to be reamed out. If the reamer does not fit, the ports need to be drilled out.





Parts are bagged in lots of 400 and then sent into the clean room for ultrasound cleaning.

The following activities take place in the clean room and are carried out under standard clean room procedure.

400 donuts at a time can be cleaned in the ultrasound unit. Once the unit is up to temperature, the donuts are put in and cleaned for 30 minutes.

Donuts are removed, rinsed in tap water, then in distilled water.

Donuts are air dried using filtered air.

Donuts are packed in clean clear bags with a desiccant packet and then stored in the clean room until ready to use.