

CRITICAL ITEMS LIST (CIL)

SYSTEM:	Propulsion/Mechanical	FUNCTIONAL CRIT:	1
SUBSYSTEM:	GH2 Pressurization	PHASE(S):	a, b, c
REV & DATE:	J, 12-19-97	HAZARD REF:	P.06, P.07, S.04, S.06
DCN & DATE:			
ANALYSTS:	J. Attar/H. Claybrook		

FAILURE MODE: Leakage

FAILURE EFFECT:

- a) Loss of mission and vehicle/crew due to fire/explosion.
- b) Loss of mission and vehicle/crew due to fire/explosion or LH2 tank structural failure.
Loss of mission due to premature engine shutdown caused by loss of NPSP.
- c) Loss of life due to ET impact outside designated footprint.

TIME TO EFFECT: Seconds

FAILURE CAUSE(S):

- A: Structural Failure of Hardline Component
- B: Flange Mating Surface Defects

REDUNDANCY SCREENS: Not Applicable

FUNCTIONAL DESCRIPTION: Transports GHe/GH2 during prelaunch and GH2 during ascent to maintain LH2 tank ullage pressure requirements.

<u>FMEA ITEM CODE(S)</u>	<u>PART NO.</u>	<u>PART NAME</u>	<u>QTY</u>	<u>EFFECTIVITY</u>
2.7.5.1	PD4800205-090	Mid Straight Line (Aft)	1	LWT-54 & Up

REMARKS:

CRITICAL ITEMS LIST (CIL)
CONTINUATION SHEET

SYSTEM: Propulsion/Mechanical
SUBSYSTEM: GH2 Pressurization
FMEA ITEM CODE(S): 2.7.5.1

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RATIONALE FOR RETENTION

DESIGN:

- A: The Mid Straight Line Assembly consists of fixed flanges and a straight tube section. The line assembly is totally fabricated from ARMCO 21-6-9 CRES and is an all welded configuration. Emphasis has been placed on joint geometry to enhance weld integrity. The line assembly has been designed to meet the required ultimate safety factors (1.4 for loads and 1.5 for pressure) and the required yield safety factors (1.1 for loads and 1.25 for pressure) (ET Stress Report 826-2188 and ET10-SR-0002, Arrowhead). The line assembly also meets the other operational and nonoperational requirements defined per PD4800205. Materials selected in accordance with MMC-ET-SE16 and controlled per MMMA Approved Vendor Product Assurance Plan assures repetitive conformance of composition, material compatibility and properties. Fusion welding specifications, processes, and quality controls are in accordance with MPS-MPA-103 (Arrowhead).
- C: Flange mating seal surface flatness, waviness and finish are specified on Engineering drawings to assure performance within the capability of the seal.

TEST:

The Mid Straight Line Assembly is qualified. Reference COQ MMC-ET-TM06-084.

Qualification: Testing of a similar line assembly (identical flange to tube weld configurations) included 2 proof loads/operating pressure and leakage (no bubbles helium at 300 psig) for acceptance, an electrical bonding (for impedance) test and 2 ultimate load tests (6,555 lb at 920 psig and 25,025 lbs respectively). There was no evidence of collapse, rupture or deformation (MMC-ET-RA09-95). The test criteria exceeded requirements for the aft straight line assembly. PD4800205-090 is qualified by analysis/similarity to PD4800205-059.

Acceptance:

Vendor - (Line Assembly):

- A: Perform proof loads/operating pressure test and leakage test (ATP 14205-390, Arrowhead).

MAF - (Line Assembly):

- B: Perform dual seal leakage rate test for flange joints per TM04k after installation (MMC-ET-TM04k).

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INSPECTION:

Vendor Inspection - Lockheed Martin Surveillance:

- A: Verify materials selection and verification controls (MMC-ET-SE16 and drawings 14205-79, 14205-63, 14205-91, Arrowhead).
- A: Inspect welding (MPS-MPO-103, Arrowhead).
- A: Penetrant inspect welding (MIL-I-6866, Type I, Method A, Group VI).
- A: Verify x-ray results (QCI-16-057, Arrowhead).
- B: Inspect mating surface flatness and finish and dimensions (drawing 14205-79 and 14205-63, Arrowhead).

Lockheed Martin Procurement Quality Representative:

- A, B: Witness proof loads/operating pressure and leakage tests (ATP 14205-390, Arrowhead).

MAF Quality Inspection:

- B: Inspect sealing surfaces for freedom of nicks, radial scratches or other imperfections (acceptance drawing 82620000001).
- B: Verify installation (drawing 80921021009).
- B: Witness seal flange leakage tests (MMC-ET-TM04k).

FAILURE HISTORY:

Current data on test failures, unexplained anomalies and other failures experienced during ground processing activity can be found in the PRACA data base.