

SRB CRITICAL ITEMS LIST

SUBSYSTEM: STRUCTURES AND MISCELLANEOUS ITEMS

ITEM NAME: Thermal Protection System - Aft Skirt, Aft Ring and External Actuator Support Structure

PART NO.: 10115-0001 (LH),  
10116-0001 (RH)

FM CODE: A01

ITEM CODE: 60-03-08

REVISION: Basic

CRITICALITY CATEGORY: 1

REACTION TIME: Seconds

NO. REQUIRED: 1

DATE: March 1, 2001

CRITICAL PHASES: Boost

SUPERCEDES: March 31, 1998

FMEA PAGE NO.: E-36

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SHEET 1 OF 8

APPROVED: S. Parvathaneni

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FAILURE MODE AND CAUSES: Loss of Aft Skirt, Aft Ring and/or external actuator support structure thermal protection caused by:

- O Degraded thermal or physical properties due to improper constituents, formulation, mixing application, cure or natural environments. (Degraded Properties)
- O Inadequate TPS thickness. (Inadequate Thickness)
- O Debonding due to improper application of substrate paint system, improper substrate preparation, adhesive failure or improper application of insulation topcoat. (Debonding)

FAILURE EFFECT SUMMARY: Loss of mission, vehicle and crew due to loss of flight control.

RATIONALE FOR RETENTION:

A. DESIGN

- O The Aft Skirt skin is insulated with various thicknesses of cork (0.125 inch to 0.75 inch) or .19 +0.08/-.00 and MCC-1 (Various thickness). External fasteners are insulated with ramped BTA, or K5NA/RT 455 (ALT.) ablator. The Aft Ring is insulated with 0.50/0.62 inch cork or 1.0/1.3 inch BTA or K5NA/RT 455 (ALT.). The External Actuator Supports are insulated with 0.25 inch cork and BTA or K5NA/RT 455 (ALT.). All cork is bonded with EC-2216 B/A Clear Amber adhesive. Closeout and repair are accomplished with BTA or K5NA/RT 455 (ALT.).

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- O Thermal protection requirements are presented in SE-019-068-2H, (SRB Thermal Design Data Book). Thermal insulation requirements were established by test and analysis.
- O Material properties were determined by development testing at the MSFC Modified Hot Gas Facility, AEDC and Ames wind tunnels. The range of thermal environments, acoustic and vibration, stress and pressure loads were obtained from applicable documentation and encompassed the maximum and minimum values. Design properties derived from these tests are reported in SE-019-068-2H.
- O Verification testing was performed per "SRB/TPS Verification Test Plan," NASA Letters EP44(79-54), EP44(79-79), EP44(79-120), EE11(S-80-34) and 10PLN-0061 using analytically determined TPS material thicknesses, maximum heat loads and rates for the applicable regions, and representative model configurations. Subsequent changes in TPS materials, thickness, configuration, etc. were verified on an individual basis using current environments and loads (e.g.: Addition of K5NA/RT 455 (ALT.) as alternate to cork on the Aft Ring was authorized by approval of ECP-1638; Addition of BTA as alternate material to K5NA/RT 455 (ALT.) was authorized by approval of ECP-2850F.) Subsequent changes in SRB environments were reviewed to verify that original verification parameters were not exceeded.

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- O Certification was performed per document SE-019-149-2H, (SRB/TPS Certification Plan.) Subsequent changes in TPS materials and/or thickness or configuration will be certified based on verification test results. Changes to certification requirements (environments and/or loads) are reviewed to verify that existing requirements are not exceeded.
- O The following Certificates of Qualification (COQs) are applicable to the TPS materials required:

Cork/EC-2216	-	USA SRBE COQ A-TPS-8109
Clear Amber Adhesive		
MCC-1	-	USA SRBE COQ A-TPS-8127
Zinc Primers	-	USA SRBE COQ A-TPS-8129
K5NA	-	USA SRBE COQ A-TPS-8108
BTA	-	USA SRBE COQ A-TPS-8120
Hypalon	-	USA SRBE COQ A-TPS-8106
Deft	-	USA SRBE COQ A-TPS-8125
RT 455	-	USA SRBE COQ A-TPS-8130
Hentzen	-	USA SRBE COQ A-TPS-8131

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- O The Aft Skirt, Aft Ring and External Actuator Support Structure insulation requirements are specified on USA SRBE drawings 10115-0028, 10116-0025 (Insulation Installation, Aft Skirt) or 10115-0030, 10116-0027 (Cork Insulation Installation, Aft Skirt ) and 10115-0008, 10116-0008 (TPS Closeout Installation, Aft Skirt).

Other documents controlling Aft Skirt insulation requirements include:

- O Cork/EC-2216 Clear Amber Adhesive:

10753-0009 Cork, Insulation  
10753-0007 Adhesive Cork Bonding  
10PRC-0018 Insulation Application, Cork

O K5NA/RT 455 (ALT.):

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MSFC-SPEC-1918 Ablative Compound, Thermal  
MSFC-SPEC-1919 Ablative Compound, Thermal, Application and Cure of

O BTA:

10753-0032 BTA Insulation Formulation  
10PRC-0546 BTA Procedure for Troweled Application

O Insulation Topcoat:

10PRC-0013 Paint, Chlorosulfonated Polyethylene 09463  
10PRC-0028 TPS Topcoat, Application of

O Substrate Protective Finish:

10A00527 Sealing of Fasteners Subject to Seawater Exposure on the SRB, excluding the SRM.  
10PRC-0442 Protective Finish Application for Aluminum and Steel Alloys

O MCC-1:

- o 10753-0064 Marshall Convergent Coating, Sprayable
- o 10PRC-0637 Procedure for Insulation Application

O Remove all TPS after every flight

B. TESTING

Testing to verify the acceptability of the insulation application is accomplished in accordance with the following:

O Cork application is verified per 10REQ-0021, para. 4.1.4.

- o Cork/adhesive bonding verification is accomplished by fabricating one cork panel for each day of cork application operations. The panel is processed into four flatwise tensile specimens and one test panel for topcoat analysis. (Degraded Properties)

O MCC-1 acceptability is verified per 10REQ-0021, para., 4.1.1.2

- o Acceptability of MCC-1 constituents, formulation, mixing, cure and proper adherence to substrate is verified by density testing and flatwise tensile tests. (Degraded Properties, Debonding)
- o Thickness measurements (Eddy Current) are taken on flight hardware at 9 to 15 inch intervals over the area of application. (Inadequate Thickness)

O BTA acceptability is verified per 10REQ-0021, para. 4.1.2

- o To verify acceptability of BTA constituents, formulation, mixing, application and cure, three tensile specimens and two density coupons are prepared and tested from at least one batch mixed, for each day of BTA processing. Hardness is measured on the density coupons and on the flight hardware. (Degraded Properties)

O K5NA/RT 455 (ALT.) acceptability is verified per OMRSD File V, Vol. I, requirement no. B09GEN.010, 10REQ-0021 para. 4.1.3 and MSFC-SPEC-1918/MSFC-SPEC-1919.

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- o To verify acceptability of K5NA/RT 455 (ALT.) constituents, formulation, mixing, application and cure for each lot of K5NA/RT 455 (ALT.) submitted for acceptance, vendor performs tests such as tensile, hardness, specific gravity and thermogravimetric analysis (TGA). (Degraded Properties)

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- o To verify acceptability of K5NA/RT 455 (ALT.) constituents, formulation, mixing application and cure for production hardware, three tensile specimens are prepared and tested from at least one batch mixed, for each day of K5NA/RT 455 (ALT.) processing. Hardness is verified for each batch and on the hardware. (Degraded Properties).

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C. INSPECTION

O Cork insulation acceptability is verified per 10REQ-0021, para. 4.1.4 including the following:

- o Preparation of surfaces to be insulated: verify that the surface is abraded, clean and dry before insulation application is made. (Debonding)
  - o Proper formulation and mixing of adhesive (EC-2216 B/A): verify formulation and mixing of amber adhesive accelerator (Part A) to adhesive base (Part B). (Degraded Properties)
  - o Cork thickness: verify cork thickness is in compliance with drawing requirements. (Inadequate Thickness)
  - o Integrity of bonded cork: inspect bonded cork for integrity of cured bond lines, and absence of wrinkles, cracks and blisters. (Debonding)
  - o Verify process control acceptance of cork bonding by Flatwise tensile strength tests. (Debonding)
- O MCC-1 acceptability is verified per 10REQ-0021, para., 4.1.1.2, including the following:
- o Verify surfaces to be insulated are clean and dry before insulation application. (Debonding)
  - o Verify flow rate parameters are within acceptable range for resin, catalyst, glass eccosphere and K54 concentration. (Degraded Properties, Debonding)
  - o Verify process parameters are within acceptable range for air pressure, temperature, stand-off distance and humidity. (Degraded Properties, Debonding)
  - o Verify proper cure temperature and time cycle is followed. (Degraded Properties)
  - o Verify finish, thickness, and absence of voids. (Debonding, Inadequate Thickness)

- O K5NA/RT 455 (ALT.) acceptability is verified per 10REQ-0021, para. 4.1.3, including the following:
  - o Preparation of surfaces to be insulated: verify that the surface is abraded, clean and dry before insulation application is made. (Debonding) CN 042
  - o Verification of the formulation of each lot of K5NA/RT 455 (ALT.) insulation received. (Degraded Properties) CN 042
  - o Application of K5NA/RT 455 (ALT.): verify that K5NA/RT 455 (ALT.) is applied within the application life. (Degraded Properties) CN 042
  - o Completion of cure: verify hardness meets Durometer type D 15 minimum. (Degraded Properties) CN 042
  - o Thickness and integrity of application: verify K5NA/RT 455 (ALT.) applications for compliance with drawing requirements or that the K5NA/RT 455 (ALT.) thickness is equal to adjacent insulation thickness and has a smooth surface finish. (Inadequate Thickness) CN 042
  
- O BTA acceptability is verified per 10REQ-0021, para. 4.1.2., including the following:
  - o Preparation of surfaces to be insulated: verify that the surface is abraded, clean and dry before insulation application is made. (Debonding)
  - o Formulation of each mix of BTA insulation: verify formulation and mixing of basic ingredients. (Degraded Properties)
  - o Completion of cure: verify BTA material is cured and ready for subsequent operations based on three hardness tests. (Degraded Properties)
  - o Finishing and Inspection: Verify that the BTA after cure is free of defects such as unacceptable sags, voids, cracks and holes. (Degraded Properties)
  - o Thickness and integrity of application: Verify BTA applications for compliance with drawing requirements or that the BTA thickness is equal to adjacent insulation thickness and has a smooth surface finish. (Inadequate Thickness)

- O Topcoat (chlorosulfonated polyethylene paint) application acceptability is verified per 10REQ-0021, para. 4.1.5.
  - o Preparation of surfaces to be insulated: verify that the surface is abraded, clean and dry before insulation application is made. (Debonding)
  - o Formulation of each mix of topcoat material: verify chlorosulfonated polyethylene paint/activator mix ratio by weight. (Degraded Properties)
  - o Topcoat application integrity and thickness: verify dry tape test adhesion and topcoat thickness on test panel. Inspect completed topcoat application after final coat is complete for absence of overspray, blisters, sags, runs, cracking, peeling and discoloration. (Degraded Properties/Debonding)
- O On repainted structures, USA SRBE Quality performs surface inspections prior to application of conversion coating primer and topcoat; performs topcoat inspection and verifies adhesion tests. (Debonding)
- O Shelf life, formulation, mixing, surface preparation, application, cure and physical properties of K5NA/RT 455 (ALT.) are verified per OMRSD File V, Vol. 1, requirement number B09GEN.010. (Degraded Properties) CN 042
- O Perform TPS assessment walkdown inspection prior to rollout per OMRSD File V, Vol. 1, requirement number B09TP0.010.
  - o Visually assess the TPS (Cork, K5NA/RT 455 (ALT.), MCC-1, SLA-220, Glass Phenolic Laminate, etc.) to identify possible degradation or damage. (Degraded Properties) CN 042
- O Visual inspection verifies the integrity of TPS and/or TPS topcoat on aft skirt, aft ring and external actuator support structure per OMRSD File V, Vol. 1, requirement number B09TP0.010. (Degraded Properties/Debonding)
- O Perform a visual assessment of the Integrity of TPS and/or TPS topcoat on all applicable flight structures per 10REQ-0021, para., 4.1.7.1 prior to transfer to SPC.
  - o Visually assess the TPS (cork, K5NA/RT 455 (ALT.), MCC-1, etc.) to identify possible damage or degradation prior to delivery to SPC. (Degraded Properties) CN 042

Critical Processes/Inspections:

- O Cork application per 10PRC-0018
- O BTA application per 10PRC-0546
- O K5NA/RT 455 (ALT.) application per MSFC-SPEC-1919 CN 042
- O Insulation topcoat application per 10PRC-0028
- O Substrate protective finish per 10PRC-0442
- O MCC-1 application per 10PRC-0637

D. FAILURE HISTORY

- O Failure Histories may be obtained from the PRACA database.

E. OPERATIONAL USE

- O Not applicable to this failure mode.