
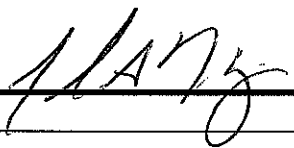
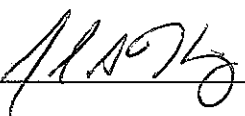
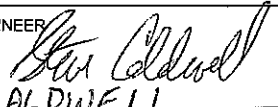


1. PROJECT CODE SA-AMS		2. JPIC CODE AMS		TASK PERFORMANCE SHEET NASA - LYNDON B. JOHNSON SPACE CENTER			
TYPE	3. A CONFIGURATION CHANGE <input checked="" type="checkbox"/>		4. TPS NO. 2A0720191		5. PAGE 1 OF 4		
	PERMANENT <input checked="" type="checkbox"/> TEMPORARY <input type="checkbox"/>		6. MOD SHEET(S) NUMBER(S)		7. ORG. EA1		8. SYSTEM AMS
	B NONCONFIGURATION CHANGE <input checked="" type="checkbox"/>						9. NEED DATE 8/15/2007
10. PART NAME Upper Payload / USS-02 Ass'y			11. PART NO./DRAWING NO. SEG39135726-302		12. SERIAL/LOT NO. N/A		13. TIME/CYCLE/SHELF LIFE <input checked="" type="checkbox"/> YES <input type="checkbox"/> NO
14. APPLICABLE DOCUMENTS SDU STA Main Radiator Removal Process			15. CONTRACT NO./JOB NO. NNJ05HI05C		16. HAZ. TEST <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO		17. ENG. EVAL. <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
18. SHORT TITLE OF TPS AMS-02 Unique Support Structure - STA Main Radiator Removal						19. ADP UPDATE <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO	
20. OPER SEQ. NO.		21. OPERATIONS (Print, Type, or Write Legibly)  8-9-07				VERIFICATION	
						22. TECH	
						23. QA/DV	
<p>The purpose of this TPS is to give the Removal steps of the Main Radiator STAs from the USS.</p> <p>NOTE: Dangerous lifting of STA radiators over the Flight USS is required. Proper CERN safety equipment and processes must be followed.</p>							
<p>1. Open this TPS.</p> <p>The Jacobs Project Engineer on site has the option to reorder steps in order to facilitate the logistics of moving around this large hardware.</p>							
<p>2. <u>USS Preparations</u>: The USS is in the cleanroom at CERN. It has been removed from the PSS and placed into the RAS. The RAS has inverted the USS following standard CERN procedures in preparations for the removal of the Main WAKE and RAM radiators. Follow AMS-CERN standard operating procedures for RAS rotation. JH 8-24-07</p>							
<p>3. Ensure CERN Personnel attach a warning tag to the RAS control box to prevent rotation of the RAS. All other operations of the RAS are acceptable. JH 8-24-07</p>							
<p>4. <u>Remove the two (2) Diagonal Strut Assemblies SEG39135741-301.</u> As per figure 1-1, remove cotter pins (55), nuts (42) and washers (44) from both ends JH 8-24-07</p>							
24. ORIGINATOR John Heilig 			DATE 8-9-07		25. FINAL ACCEPTANCE STAMP AND DATE		
APPROVALS (Printed or Typed and Signed)							
26. PROJECT ENGINEER John Heilig 			DATE 8-9-07		27. QUALITY ENGINEER  STEVE CALDWELL		DATE 8-9-07
28.			29.		ORIGINAL		
30.			31.		Return to Bldg. <u>10</u> Rm. <u>114</u> QARC		

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23. QA/DV

of each diagonal strut as shown in Figure 1-2. Bag and retain these parts for reuse. Take care to support the diagonal struts during removal of the pins (35) and washers (39) to prevent damage to the struts or USS.

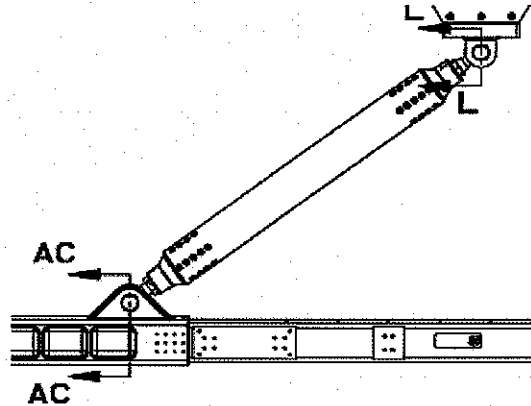


Figure 1-1

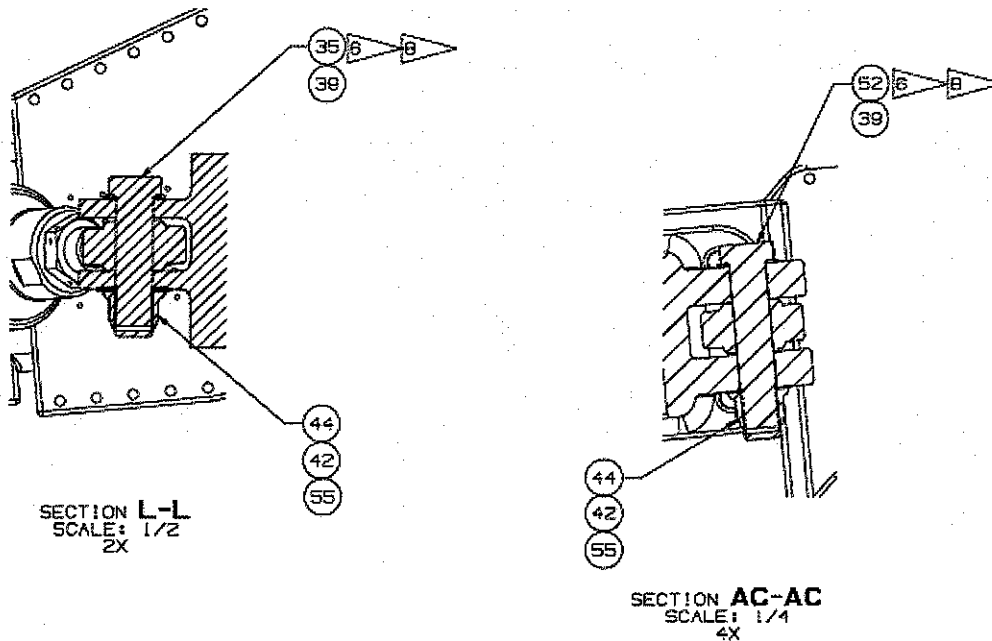


Figure 1-2

5. Storage Store the Diagonal Strut Assemblies, pins and fasteners for reuse later in this TPS. Store in a secure location.

JH
 8-24-07

WARNING: Rotation of the USS is prohibited until the Diagonal Struts are reinstalled. Tag the RAS to prevent rotation of the USS.

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VERIFICATION

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23. QA/DV

6. Remove the STA Main Radiators per AMS-02 Task Sheet (ATS)
SDA 080307-1 Procedure start date 8-24-07

ESCG Designated Verifier (DV) John Heiting

Note: Contact STA Main Radiator Engineering as required.

Note: ESCG Designated Verifiers (DV) shall witness and verify all torque applications, confirm the Running (or Run-in) and Final torques, and proper documentation of these torques relative to this procedure and any other sub-process relative to this task. Designated Verifier (DV) shall coordinate with ESCG quality personnel for any additional verification of steps that would normally require a Mandatory Inspection Point or (MIP). ESCG Designated Verifier shall insure compliance with NASA/JSC NT-CWI-001 work instruction.



7. Indicate procedure end date for the STA Main Radiator, AMS-02 Task Sheet (ATS) SDA 080307-1 Procedure end date 8-24-07

8. As shown in Figure 2-1, install the Diagonal Strut Assemblies to the STA VC by installing one (1) Washer, Flat P/N NAS1149E1632R, item 42; one (1) Washer, CSK, P/N NAS1587-16C, item 39; one (1) Nut, Self Locking, P/N NAS1805-16, item 44; and one (1) Pin, Clevis, VC, Diagonal Bracket P/N SDG39135744-003, item 35. Torque the nut 0 to 5 in-lbs (0 to .5 Nm) above locking torque after the nut bottoms out. Locking torque shall be 90 to 800 in-lbs (10.1 to 90.3 Nm). See Figure 2-2.

Braycote Grease

PN 601EF Lot# 86440 Exp. Date 03-15-2026

Torque Wrench

PN P3100 M# 213886 Cal Due Date 10/27/07

Nut	Locking Torque	Final Torque
1.	<u>3.1</u>	<u>3.6 Nm</u>
2.	<u>2.0</u>	<u>2.6 Nm</u>

See DR# 2A0730088



8-28-07

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MIP
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8-9-07

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22. TECH

23. QA/DV

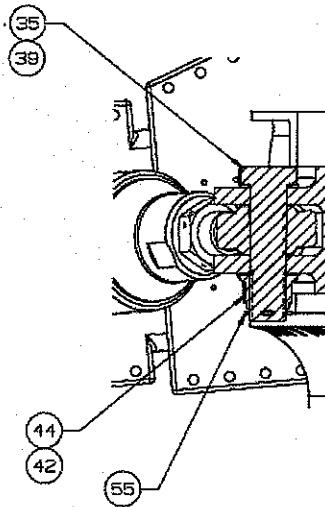


Figure 2-1

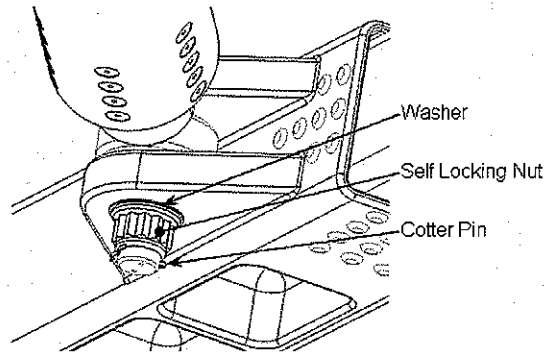


Figure 2-2

- 8-9-07 MIP 1
9. As shown in Figure 2-1, install other end of the Diagonal Strut Assemblies to the USS-02 by installing one (1) Washer, Flat P/N NAS1149E1632R, item 42; one (1) Washer, CSK, P/N NAS1587-16C, item 39; one (1) Nut, Self Locking, P/N NAS1805-16, item 44; and one (1) Pin, Clevis, USS-02, Diagonal Bracket P/N SDG39135744-002, item 52. Torque the nut 0 to 5 in-lbs (0 to .5 Nm) above locking torque after the nut bottoms out. Locking torque shall be 90 to 800 in-lbs (10.1 to 90.3 Nm). See Figure 2-2

Braycote Grease

PN 601EF Lot# 86440 Exp. Date 3.15.2026

Torque Wrench

PN P3100 M# 213886 Cal Due Date 10.23.07

Nut	Locking Torque	Final Torque	
1.	<u>5.5</u>	<u>6.0 Nm</u>	<u>See DR#</u>
2.	<u>4.9</u>	<u>5.4 Nm</u>	

10. Install the four (4) cotter pin, MS24665-306, item 55 in Figure 2-1 to all self locking nuts, item 44.

NOTE: Rotation of the RAS is now acceptable. Follow AMS-CERN standard operating procedures for RAS rotation

11. Close this TPS



J #
8-28-07