


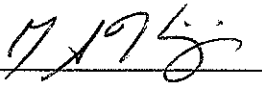
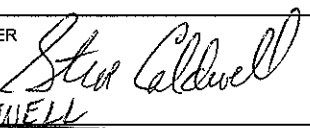


1. PROJECT CODE SA-AMS		2. JPIC CODE AMS		TASK PERFORMANCE SHEET NASA - LYNDON B. JOHNSON SPACE CENTER				
T Y P E	A	CONFIGURATION CHANGE <input checked="" type="checkbox"/>		4. TPS NO. 2A0720189		5. PAGE 1 OF 2		
	PERMANENT <input checked="" type="checkbox"/>		TEMPORARY <input type="checkbox"/>		6. MOD SHEET(S) NUMBER(S)		7. ORG. EA1	
	B		NONCONFIGURATION CHANGE <input type="checkbox"/>		8. SYSTEM AMS		9. NEED DATE 8/15/2007	
10. PART NAME Lower Payload / USS-02 Ass'y				11. PART NO./DRAWING NO. SEG39135726-302		12. SERIAL/LOT NO. N/A		
14. APPLICABLE DOCUMENTS CGS Silver Teflon Instration Process Document				15. CONTRACT NO./JOB NO. NNJ05HI05C		13. TIME/CYCLE/SHELF LIFE <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO		
18. SHORT TITLE OF TPS AMS-02 Unique Support Structure - Silver Teflon Tape Installation						17. ENG. EVAL. <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO		
19. ADP UPDATE <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO						16. HAZ. TEST <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO		
20. OPER SEQ. NO.		21. OPERATIONS (Print, Type, or Write Legibly)				VERIFICATION		
		 8-9-07				<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO		
		The purpose of this TPS is to give the Installation steps for the Silver Teflon Tape on the USS.				 8-28-07		
1.		<p>Open this TPS.</p> <p style="text-align: center;">WARNING: Rotation of the USS is prohibited unless the Diagonal Struts are installed.</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>						
2.		<p>Install the Silver Teflon Tape per AMS-02 Task Sheet</p> <p style="text-align: center;">(ATS) <u>TCS-PR-CGS-001</u> Procedure start date <u>8-28-07</u></p> <p>ESCG Designated Verifier (DV) <u>Craig S. Clark</u>.</p> <p>Note: Contact AMS Thermal Engineering as required.</p> <p>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</p>						
24. ORIGINATOR John Heilic 			DATE 8.9.07		25. FINAL ACCEPTANCE STAMP AND DATE			
APPROVALS (Printed or Typed and Signed)								
26. PROJECT ENGINEER John Heilic 			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			

TASK PERFORMANCE SHEET
 CONTINUATION PAGE
 NASA - LYNDON B. JOHNSON SPACE CENTER

4. TPS NO.

2A0720189

6. MOD NO.

20. OPER
SEQ. NO.

21. OPERATIONS
(Print, Type, or Write Legibly)

VERIFICATION

22. TECH

23. QA/DV


normally require a Mandatory Inspection Point or (MIP). ESCG Designated Verifier shall insure compliance with NASA/JSC NT-CWI-001 work instruction.

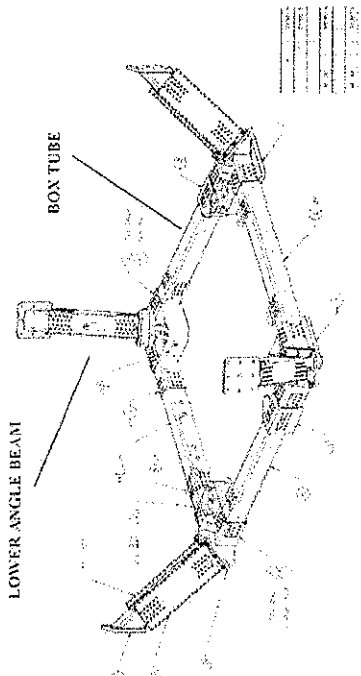
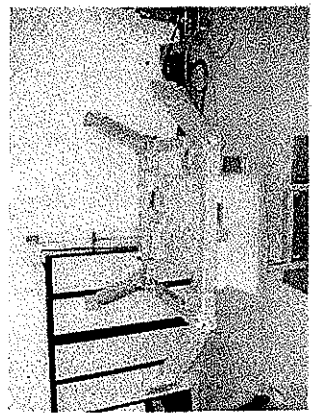
3. Indicate procedure end date for the Silver Teflon Tape Application, AMS-02 Task Sheet

(ATS) TCS-PR-CGS-001 Procedure end date 8-31-07

4. Close this TPS


CSC
8-31-07

 CARLO GAVAZZI SPACE SPA	<h1>AMS02 - TCS</h1>		N° Doc: TCS-RP-CGS-001 Doc N°: Ediz.: 1 Data: 05/09/2007 Issue: Date: Pagina 24 di of 34 Page Page
	USS TAPE APPLICATION REPORT		N° Doc: TCS-PR-CGS-001 Doc N°: Ediz.: 1 Data: 20/08/2007 Issue: Date: Pagina di of Page Page
			REPORT REFERENCE

UUT DATA:		Model	Item	C.I.	S/N
STEP n°	TAPE APPLICATION SEQUENCE	EXPECTED VALUE	MEASURED VALUE	REMARKS	
1	Lower USS tape application PRELIMINARY OPERATIONS Identify the surfaces of the LUSS where the tape is to be applied according to the following scheme: - 4 lower angle beams (all the sides at the maximum extent) - Box tubes (all the sides but the detector brackets)	Parts to be covered identified	Parts identified.	The Lower USS to Upper USS joints are NOT to be covered. The center body box joints are NOT to be covered. Holes and areas which were alodined for bounding purposes (see AD[2]) are NOT to be covered. Final tape configuration on Lower USS:	
1.1					

DATE: 30/08/07	TEST CONDUCTOR: <i>[Signature]</i>	QA: <i>[Signature]</i>	CUSTOMER:
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 CARLO GAVAZZI SPACE SpA	<h1>AMS02 - TCS</h1>		N° Doc: TCS-PR-CGS-001 Doc N°: Ediz.: 1 Issue: Date: 20/08/2007 Pagina 25 di 34	N° Doc: TCS-RP-CGS-001 Doc N°: Ediz.: Issue: Date: 05/09/2007 Pagina 25 di 34
	USS TAPE APPLICATION REPORT		REPORT REFERENCE	

UUT DATA: Model Item C.I. S/I/N
STEP n° TAPE APPLICATION SEQUENCE

STEP n°	TAPE APPLICATION SEQUENCE	EXPECTED VALUE	MEASURED VALUE	REMARKS
2	Lower USS tape application - Lower angle beams			
2.1	Clean the 4 surfaces sides of Lower angle beams of the LUSS where the tape is to be applied with Isopropyl Alcohol.	Clean performed OK	Surfaces clean OK	
2.2	Cut the VDM, G4019, CVLY, Teflon tape 2" into stripes (not longer than 15" or 38.1cm) according to the surface side to be covered (in order to keep the tape area less than 31 square inch =200cm ²). LEAVE the orange protective cover on the tape. Record the stripes length (for weight considerations).			TAPE Part number : 146415-002 (G401905) Lay-up (5 mils thick) : Teflon/AG/Inc/966 adhesive Perforated
2.3	if the surface where the tape is to be applied is equipped with holes and areas which have been alodined for bonding purposes (see AD[2]), adjust the tape with the suitable tools (LEAVE the orange protective cover on the tape). For edge holes leave the complete row on the part uncovered. For the centred holes leave a squared area 1" x 1" uncovered. For the areas which have been alodined for bonding purposes (see AD[2]), adjust the tape over the part accordingly.	Strip perforated.	OK	See Tab. 8-1 for weight considerations Do not adapt the tape to the LUSS riveted surfaces. The riveted parts are NOT to be covered by the tape.
2.4	Once the tape stripe is ready, remove gradually the liner "rolling" the tape down on the surface. Apply finger pressure to the tape in the direction parallel to the stripe length and perpendicularly from the center to the external edges in a manner that will squeeze out any air bubble.	Strip applied.	OK	
2.5	In case additional tape is needed to cover the same angle beam side, do NOT overlap with the previous tape stripe.	No overlap of strips.	OK	
2.6	Repeat steps from 2.2 to 2.5 until all the four sides of the angle beam are covered.	All the sides of the angle beam #1 are covered.	OK	See Fig. 7-5, angle beam final configuration.

DATE: 30/08/07	TEST CONDUCTOR: <i>Non Comandante</i>	QA: <i>[Signature]</i>	CUSTOMER:
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	USS TAPE APPLICATION REPORT		PROCEDURE REFERENCE	

UUT DATA:	Model	Item	C.I.	S/N
STEP n°	TAPE APPLICATION SEQUENCE			

STEP n°	Model	Item	C.I.	S/N	EXPECTED VALUE	MEASURED VALUE	REMARKS
2.7		Repeat steps from 2.1 to 2.6 for Lower angle beam #2.			OK		
2.8		Repeat steps from 2.1 to 2.6 for Lower angle beam #3			OK		
2.9		Repeat steps from 2.1 to 2.6 for Lower angle beam #4			OK		
3		Lower USS tape application - Box tubes					
3.1		Clean the 4 surfaces sides of Box tube of the LUSS where the tape is to be applied with Isopropyl Alcohol			Clean performed	Surfaces clean	
3.2		Cut the VDM, G4019, CVLY, Teflon tape 2" into stripes (not longer than 15" or 38,1cm) according to the surface side to be covered (in order to keep the tape area less than 31 square inch =200cm2). LEAVE the orange protective cover on the tape. Record the stripes length (for weight considerations).			OK	OK	TAPE Part number : 146415-002 (G401905) Lay-up (5 mils thick) : Teflon/AG/Inc/966 adhesive Perforated
3.3		If the surface where the tape is to be applied is equipped with holes and areas which have been alodined for bonding purposes (see AD[2]), adjust the tape with the suitable tools.(LEAVE the orange protective cover on the tape). For edge holes leave the complete row on the part uncovered. For the centred holes leave a squared area 1" x 1" uncovered. For the areas which have been alodined for bonding purposes (see AD[2]), adjust the tape over the part accordingly.			Strip perforated ready for application.	OK	See Tab. 8-1 for weight considerations

DATE: 31/08/07	TEST CONDUCTOR / <i>[Signature]</i>	QA	CUSTOMER
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	USS TAPE APPLICATION REPORT		PROCEDURE REFERENCE			

UUT DATA:	Model	C.I.		S/N
STEP n°	TAPE APPLICATION SEQUENCE	EXPECTED VALUE	MEASURED VALUE	REMARKS

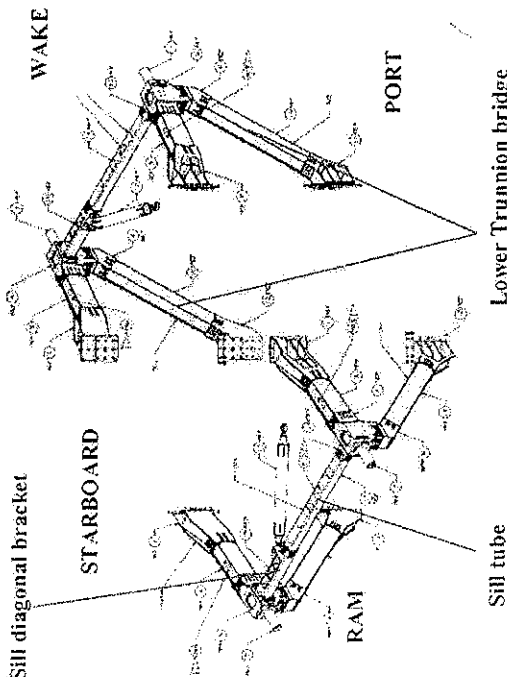
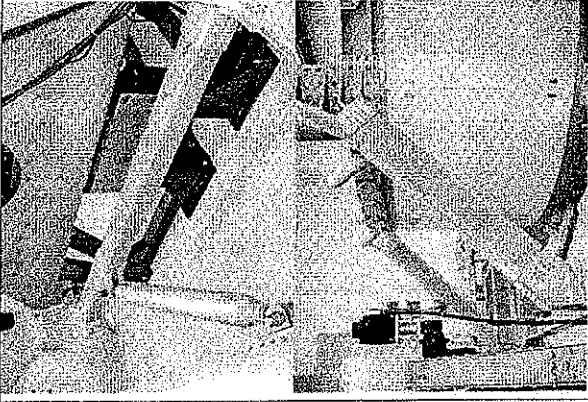
STEP n°	TAPE APPLICATION SEQUENCE	EXPECTED VALUE	MEASURED VALUE	REMARKS
3.4	Once the tape stripe is ready, remove gradually the liner "rolling" the tape down on the surface. Apply finger pressure to the tape in the direction parallel to the stripe length and perpendicularly from the center to the external edges in a manner that will squeeze out any air bubble.	Strip applied.	OK	
3.5	In case additional tape is needed to cover the same box tube side, do NOT overlap with the previous tape stripe.	No overlap of strips.	OK	
3.6	Repeat steps from 3.2 to 3.5 until all the four sides of the box tube are covered.	All the sides of the box tube #1 are covered	OK	See Fig. 7-8 and Fig. 7-10, box tubes final configuration.
3.7	Repeat steps from 3.1 to 3.6 for Box tube #2.	All the sides of the box tube #2 are covered	OK	
3.8	Repeat steps from 3.1 to 3.6 for Box tube #3	All the sides of the box tube #3 are covered	OK	
3.9	Repeat steps from 3.1 to 3.6 for Box tube #4	All the sides of the box tube #4 are covered	OK	
4	Upper USS tape application PRELIMINARY OPERATIONS			
4.1	Identify the parts of the Upper USS, where the tape is to be applied according to the following scheme: - 2 lower trunnion bridge beams at WAKE side. All the four sides of the Lower Trunnion bridge beam - Port side - are completely covered by tape. All the four sides of the Lower Trunnion bridge beam - Starboard side (CAB side) , are completely covered by tape, but the beam side pointing to Starboard	Parts to be covered identified	Parts identified	Final tape configuration on Upper USS:

DATE: 31/08/07	TEST CONDUCTOR: <i>[Signature]</i>	QA	CUSTOMER
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		PROCEDIRE REFERENCE		

UUT DATA :	Model	Item	C.I.	S/I/N
STEP n°	TAPE APPLICATION SEQUENCE		EXPECTED VALUE	MEASURED VALUE
			REMARKS	

	<p>direction.</p> <ul style="list-style-type: none"> Sill diagonal bracket – RAM side. All four sides of the bracket , are completely covered. Sill tube – RAM side. All four sides of the bracket , are completely covered. 		
			
			

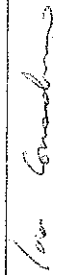
DATE: 28/08/07	TEST CONDUCTOR: <i>Carlo Gavazzi</i>	QA: <i>GA</i>	CUSTOMER
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	USS TAPE APPLICATION REPORT		PROCEDURE REFERENCE	

UUT DATA:	Model	Item	C.I.	S/N
STEP n°	TAPE APPLICATION SEQUENCE		EXPECTED VALUE	MEASURED VALUE
			REMARKS	

STEP n°	TAPE APPLICATION SEQUENCE	EXPECTED VALUE	MEASURED VALUE	REMARKS
5	Upper USS tape application – Lower trunnion bridge beams – WAKE side			
5.1	Clean the 4 surfaces sides of the Lower trunnion bridge beam – PORT side where the tape is to be applied with Isopropyl Alcohol.	Clean performed.	Surfaces clean	
5.2	Cut the VDM, G4019, CVLY, Teflon tape 2" into stripes (not longer than 15" or 38,1cm) according to the surface side to be covered (in order to keep the tape area less than 31 square inch ≈200cm ²). LEAVE the orange protective cover on the tape. Record the stripes length (for weight considerations).	OK	OK	TAPE Part number : 146415-002 (G401905) Lay-up (5 mills thick) : Teflon/AG/Inc/966 adhesive Perforated
5.3	If the surface where the tape is to be applied is equipped with holes and areas which have been alodined for bonding purposes (see AD[2]), adjust the tape with the suitable tools (LEAVE the orange protective cover on the tape). For edge holes leave the complete row on the part uncovered. For the centred holes leave a squared area 1" x 1" uncovered. For the areas which have been alodined for bonding purposes (see AD[2]), adjust the tape over the part accordingly.	Strip perforated ready for application.	OK	See Tab. 8-1 for weight considerations
5.4	Once the tape stripe is ready, remove gradually the liner "rolling" the tape down on the surface. Apply finger pressure to the tape in the direction parallel to the stripe length and perpendicularly from the center to the external edges in a manner that will squeeze out any air bubble.	Strip applied.	OK	
5.5	In case additional tape is needed to cover the same side of the beam, do NOT overlap with the previous tape stripe.	No overlap of strips.	OK	
5.6	Repeat steps from 5.2 to 5.5 until all the four sides of the beam are covered.	All the sides of the trunnion	OK	See Fig. 7-14, PORT Trunnion bridge final configuration.

DATE: 23/08/07	TEST CONDUCTOR: 	QA	CUSTOMER
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	USS TAPE APPLICATION REPORT		PROCEDURE REFERENCE	

UUT DATA: Model Item S/N
TAPE APPLICATION SEQUENCE

STEP n°	MEASURED VALUE	EXPECTED VALUE	REMARKS
5.7	Surfaces clean	bridge - PORT side- are covered Clean performed	
5.8	OK	OK	TAPE Part number : 146415-002 (G401905) Lay-up (5 mils thick) : Teflon/AG/Ino/966 adhesive Perforated
5.9	OK	Strip perforated ready for application.	See Tab. 8-1 for weight considerations
5.10	OK	Strip applied.	
5.11	OK	No overlap of strips.	
5.12	OK	All the three strips.	

DATE: 23/08/07	TEST CONDUCTOR: <i>[Signature]</i>	QA: <i>[Signature]</i>	See Fig. 7-15, STBD Trunnion bridge CUSTOMER
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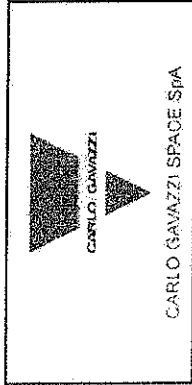
 CARLO GAVAZZI SPACE SpA	<h1>AMS02 - TCS</h1>		N° Doc: TCS-PR-CGS-001 Doc N°: Ediz.: 1 Issue: Date: 20/08/2007 Pagina di 31 Page of 34	N° Doc: TCS-RP-CGS-001 Doc N°: Ediz.: Issue: Date: 05/09/2007 Pagina di Page of
	USS TAPE APPLICATION REPORT		PROCEDURE REFERENCE	

UUT DATA :	Model	Item	C.I.	S/N
STEP n°	TAPE APPLICATION SEQUENCE		EXPECTED VALUE	MEASURED VALUE
			REMARKS	

STEP n°	Model	Item	C.I.	S/N	EXPECTED VALUE	MEASURED VALUE	REMARKS
6					sides of the Trunnion bridge - STARBOARD side- are covered		final configuration.
6.1		Upper USS tape application – Sill tube and diagonal bracket – RAM side			Clean all the 4 surfaces sides of the Sill tube – RAM side where the tape is to be applied with Isopropyl Alcohol	Surfaces clean	
6.2					Cut the VDM, G4019, CVLY, Teflon tape 2" into stripes (not longer than 15" or 38,1cm) according to the surface side to be covered (in order to keep the tape area less than 31 square inch =200cm2). LEAVE the orange protective cover on the tape. Record the stripes length (for weight considerations).	OK	TAPE Part number : 146415-002 (G401905) Lay-up (5 mils thick) : Teflon/AG/Inc/966 adhesive Perforated
6.3					If the surface where the tape is to be applied is equipped with holes and areas which have been alodined for bonding purposes (see AD[2]), adjust the tape with the suitable tools (LEAVE the orange protective cover on the tape). For edge holes leave the complete row on the part uncovered. For the centred holes leave a squared area 1" x 1" uncovered. For the areas which have been alodined for bonding purposes (see AD[2]), adjust the tape over the part accordingly.	Strip perforated ready for application.	See Tab. 8-1 for weight considerations
6.4					Once the tape stripe is ready, remove gradually the liner "rolling" the tape down on the surface. Apply finger pressure to the tape in the direction parallel to the stripe length and perpendicularly from the center to the external edges in a	Strip applied.	OK

DATE: 23/08/07	TEST CONDUCTOR: <i>Carlo Gavazzi</i>	QA: <i>GA</i>	CUSTOMER:
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AMS02 - TCS

USS TAPE APPLICATION REPORT

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 Issue: Date: **20/08/2007**
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UIJT DATA :		C.I.		S/N		
STEP n°	Model	Item	TAPE APPLICATION SEQUENCE	EXPECTED VALUE	MEASURED VALUE	REMARKS

6.5			manner that will squeeze out any air bubble.				
6.6			In case additional tape is needed to cover the same side of the part, do NOT overlap with the previous tape stripe. Repeat steps from 6.2 to 6.5 until all four sides of the tube are covered.	No overlap of strips. OK	OK		
6.7			Clean all the 4 surfaces sides of the Sill diagonal bracket - RAM side - where the tape is to be applied with Isopropyl Alcohol.	All the four sides of the sill tube - RAM side- are covered Clean performed. OK	OK	See Fig. 7-19, Sill Tube final configuration.	
6.8			Cut the VDM, G4019, CVLY , Teflon tape 2" into stripes (not longer than 15 " or 38,1cm) according to the surface side to be covered (in order to keep the tape area less than 31 square inch =200cm2). LEAVE the orange protective cover on the tape. Record the stripes length (for weight considerations).	OK	OK	TAPE Part number : 146415-002 (G401905) Lay-up (5 mils thick) : Teflon/AG/Inc/966 adhesive Perforated	
6.9			If the surface where the tape is to be applied is equipped with holes and areas which have been alodined for bonding purposes (see AD[2]), adjust the tape with the suitable tools (LEAVE the orange protective cover on the tape). For edge holes leave the complete row on the part uncovered. For the centred holes leave a squared area 1" x 1" uncovered. For the areas which have been alodined for bonding purposes (see AD[2]), adjust the tape over the part accordingly.	Strip perforated ready for application. OK	OK	See Tab. 8-1 for weight considerations	
6.10			Once the tape stripe is ready, remove gradually the liner "rolling" the tape down on the surface. Apply finger pressure to the tape in the direction parallel to the	Strip applied. OK	OK		
DATE: 30/08/07		TEST CONDUCTOR	QA				CUSTOMER

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UUT DATA :	Model	Item	C.I.	S/N
STEP n°	TAPE APPLICATION SEQUENCE		EXPECTED VALUE	MEASURED VALUE

STEP n°	Model	Item	C.I.	S/N	REMARKS
6.11		stripe length and perpendicularly from the center to the external edges in a manner that will squeeze out any air bubble.			
6.12		In case additional tape is needed to cover the same side of the bracket, do NOT overlap with the previous tape stripe. Repeat steps from 6.8 to 6.11 until all four sides of the bracket are covered.	No overlap of strips. All the four sides of the sill bracket - RAM side- are covered	OK OK	See Fig. 7-13, Sill diagonal bracket final configuration.

DATE: 30/08/07	TEST CONDUCTOR: <i>Anna Consonni</i>	QA	CUSTOMER
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ANNEX 1



SPECIALTY MATERIALS CERTIFICATE OF CONFORMANCE

MASSACHUSETTS INSTITUTE

CUSTOMER NAME OF TECHNOLOGY SHELDALH LINE ITEM NO(s): 1
CUSTOMER P.O. # 4500890979 QTY: 8
SALES ORDER 1434430 U/M ROLLS
CAGE CODE 07955

MATERIAL DESCRIPTION: C.V.L.Y.; TEF: 5.0 MIL; AG/INC; 988; PERF: 2"; 108" ROLL

Sheldahl Item No. 149413-002
Sheldahl Spec No. G401905

This is to certify that materials furnished against this purchase order are in conformance with specifications required by subject order, also with material, manufacturing, and test specifications as determined by Sheldahl. Some physical values (i.e., density, thickness, tensile strength, etc.) may be based on our vendor's published values. It is noted that the materials shipped under this purchase order may be patented under a United States Patent or may have been made on an apparatus which may be patented under a United States Patent. Details are available from the Marketing Department, Sheldahl, Northfield Minnesota 55057.

This product shall meet specified values for a minimum of 12 months after date of shipment when stored in its original unopened container at 50 - 80°F.

TEST DATA

CHARACTERISTIC	Absorbance	Emittance	Metal Adhesion	Adhesive Strength		Certification Date/DM	Warranty Expiration Date
TEST METHOD	Q-189	Q-341	Q-84	ASTM-D-1000			
IP 421682	0.07	0.84	NO REMOVAL	63 OZ/IN OF WIDTH	2 ROLLS	June 12, 2007	June 25, 2008
IP 421683	0.07	0.84	NO REMOVAL	57 OZ/IN OF WIDTH	2 ROLLS	June 12, 2007	June 25, 2008
IP 421684	0.06	0.84	NO REMOVAL	67 OZ/IN OF WIDTH	2 ROLLS	June 12, 2007	June 25, 2008
MFG. LOT NO. (IP #)							

1150 Sheldahl Road
Northfield, MN 55057
507/663-8000

Pat Schroeder-George
Pat Schroeder-George - QC

Date 6/25/2007

