
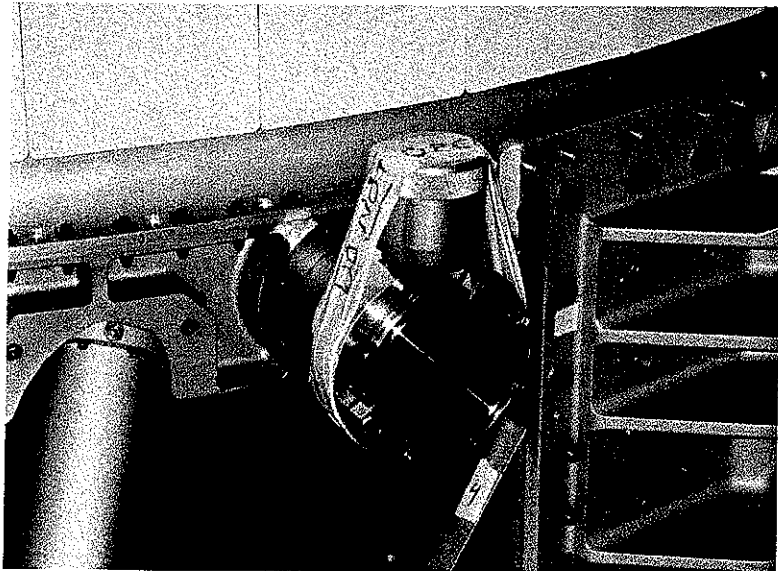






~ESCG~

1. PROJECT CODE		2. JPIC CODE		TASK PERFORMANCE SHEET			
SA-AMS		AMS		NASA - LYNDON B. JOHNSON SPACE CENTER			
T Y P E	A	CONFIGURATION CHANGE		<input checked="" type="checkbox"/>	4. TPS NO. <u>2A0720 226</u>		5. PAGE 1 OF 5
	PERMANENT		<input type="checkbox"/>	TEMPORARY	<input checked="" type="checkbox"/>	6. MOD SHEET(S) NUMBER(S)	7. ORG.
	B		NONCONFIGURATION CHANGE		<input type="checkbox"/>	N/A	EA
10. PART NAME				11. PART NO./DRAWING NO.		12. SERIAL/LOT NO.	13. TIME/CYCLE/SHELF LIFE
STA Vacuum Case Assembly				SEG39135774-301		1001	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
14. APPLICABLE DOCUMENTS				15. CONTRACT NO./JOB NO.		16. HAZ. TEST	17. ENG. EVAL.
N/A				NNJ05HI05C		<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
18. SHORT TITLE OF TPS						19. ADP UPDATE	
STA VC Pump Down and Re-Pressurization at CERN						<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO	
20. OPER SEQ. NO.		21. OPERATIONS (Print, Type, or Write Legibly)				VERIFICATION	
		 <u>9-21-07</u>				22. TECH	
1.		Open this TPS.					
2.		Remove the NW100 blanking plate and claws/bolts. Bag and tag them for later use.				TM 9/25/07	
							
3.		Wipe clean the mating surface on the gate valve with IPA.				TM 9/25/07	
24. ORIGINATOR			DATE		25. FINAL ACCEPTANCE STAMP AND DATE		
Phil Mott 			21-SEP-07		 11-8-07		
APPROVALS (Printed or Typed and Signed)							
26. PROJECT ENGINEER			DATE		27. QUALITY ENGINEER		DATE
Phil Mott 			21-SEP-07		Steve Caldwell 		9-21-07
28.			N/A		29.		N/A
30.			N/A		31.		N/A
					<div style="border: 1px solid black; padding: 5px; display: inline-block;"> ORIGINAL Retain in Bldg. <u>10</u> Rm. <u>114</u> QARC </div>		N/A

TASK PERFORMANCE SHEET
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2A0720 226

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VERIFICATION

22. TECH

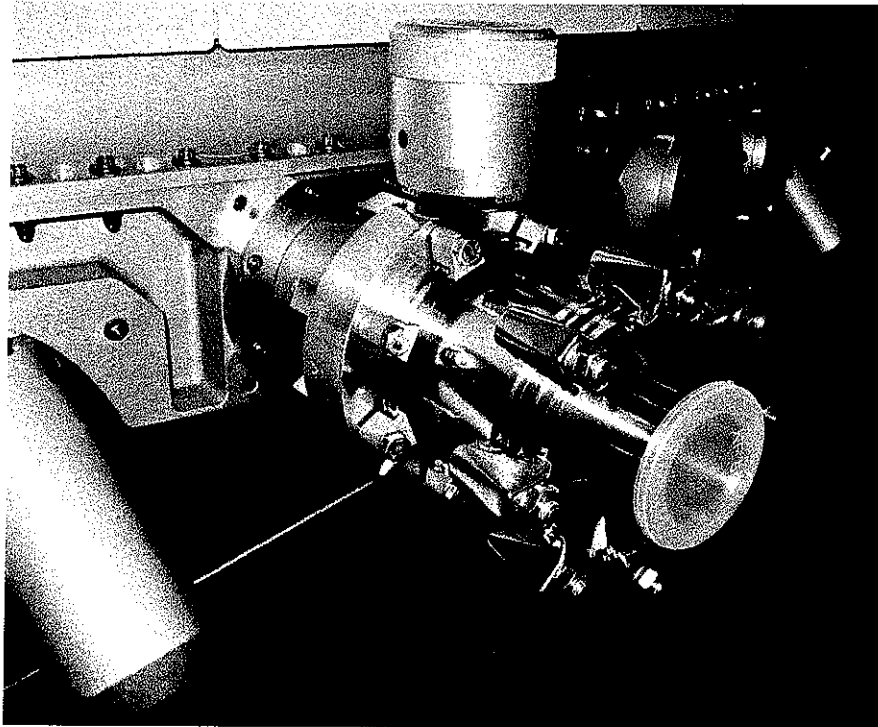
23. QA/DV

4.

Attach the following hardware as shown as shown . Wipe clean the mating surfaces and centering rings with isopropyl alcohol prior to assembly. Once all fasteners have been installed, tighten fasteners in a clockwise pattern. Continue to tighten fasteners until they can be tightened without the adjacent fastener coming loose.

- ISO F NW100 Nipple
- ISO F NW100 Centering Ring
- 8 single claw clamp fasteners with bolt M8 x 35mm for ISO F NW100
- ISO F NW100 to ISO KF NW50 Adapter
- ISO F NW100 Centering Ring
- 8 double claw clamp fasteners with insert M8 x 35mm for ISO F NW100

TM
9/25/07



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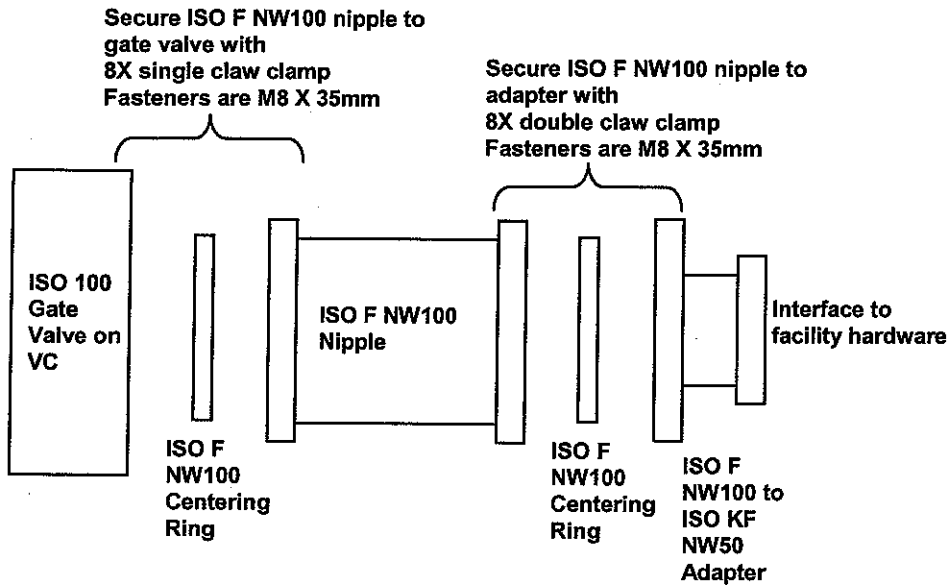
20. OPER
SEQ. NO.

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

VERIFICATION

22. TECH

23. QA/DV



5. Attach facility hardware and pumps with any extra required adaptors or fittings. Pumps should be on a UPS, or have integral safety devices, in case power is lost to prevent oil from backing up into the VC.

JM
9/25/07

6. Turn on roughing pump. Leave the gate valve on the VC closed. Record date and time pump was started.

JM
9/25/07

9/25/07 14:14

7. Slowly open the gate valve on the VC.

JM
9/25/07

8. Let pump run until the vacuum level reaches the 10-2 mbar range.

JM
9/25/07

9. Just prior to closing the gate valve on the VC, record the vacuum level and whether the gage is before or after the pump.

JM
9/25/07

9/26/07 15:15 83 mbar BEFORE

10. Close the gate valve on the VC. Record date and time valve was closed.

JM
9/26/07

9/26/07 15:15 83 mbar

11. Turn off the roughing pump and remove the facility hardware and pumps.

JM
9/26/07

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6. MOD NO. N/A

20. OPER
SEQ. NO.

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

VERIFICATION
22. TECH 23. QA/DV

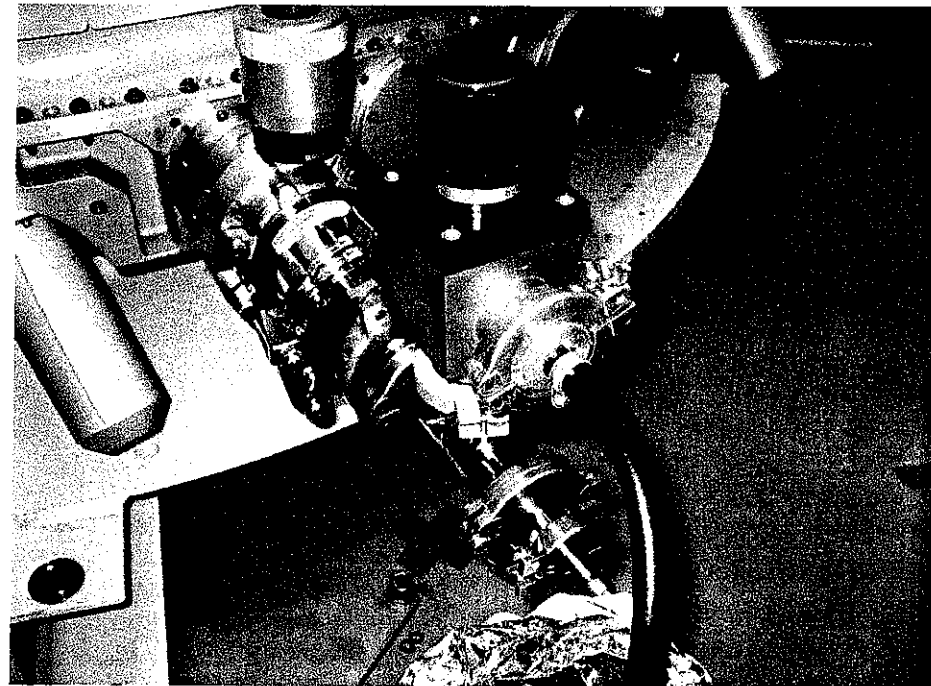
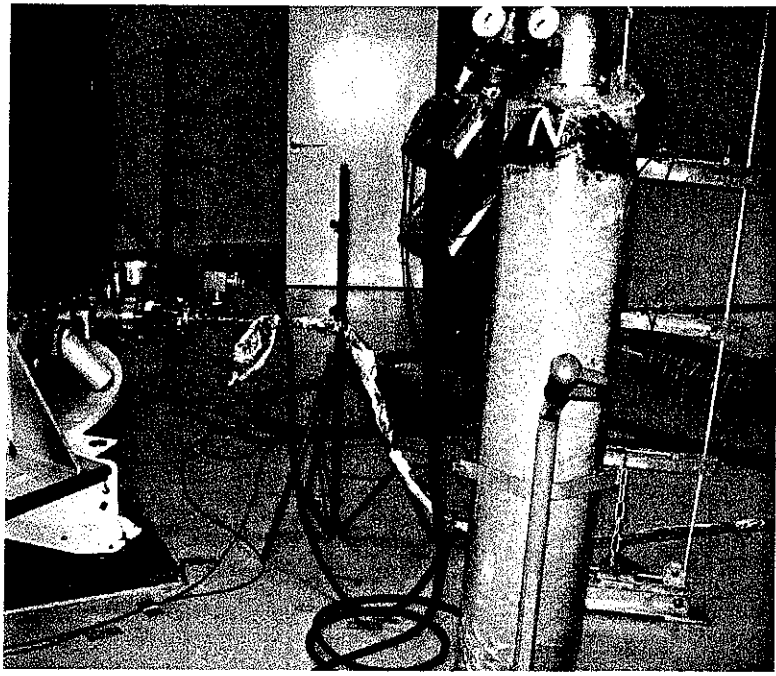
12. Perform VC measurements as determined by the AMS Group.

JM
9/26/07

Re-pressurization of the VC

13. Attach an NW50 nipple plate to the end of the stack up with a swing clamp (Supplied by CERN). See the pictures below for a similar setup.

JM
9/26/07



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SEQ. NO.21. OPERATIONS
(Print, Type, or Write Legibly)

VERIFICATION

22. TECH

23. QADV

- | | | | |
|-----|---|---------------|--|
| 14. | Attach a hose from the nipple to a regulator on a standard bottle of dry nitrogen. The regulator shall have a gage both upstream and downstream of the regulator. | TM
9/26/07 | |
| 15. | With the gate valve closed, crack open the nitrogen bottle. | TM
9/26/07 | |
| 16. | Slowly open the gate valve. | TM
9/26/07 | |
| 17. | Slowly open the nitrogen bottle to increase the flow. Re-pressurization shall take about 2 hours. | TM
9/26/07 | |
| 18. | Monitor the pressure gage on the bottle. The STA VC requires almost a full bottle of nitrogen. | TM
9/26/07 | |
| 19. | When the gage reads approximately 1 atm (1 bar), close the gate valve and the nitrogen bottle. | TM
9/26/07 | |
| 20. | Remove the NW50 nipple plate and swing clamp. | TM
9/26/07 | |
| 21. | Crack open the gate valve to equalize the pressure. Once pressure has equalized, close the gate valve. | TM
9/26/07 | |
| 22. | Remove the following vacuum hardware from the VC gate valve and return to their original shipping boxes. <ul style="list-style-type: none"> • ISO F NW100 Nipple • ISO F NW100 Centering Ring • 8 single claw clamp fasteners with bolt M8 x 35mm for ISO F NW100 • ISO F NW100 to ISO KF NW50 Adapter • ISO F NW100 Centering Ring • 8 double claw clamp fasteners with insert M8 x 35mm for ISO F NW100 | TM
9/26/07 | |
| 23. | Replace the NW100 blanking plate and claws/bolts that were removed in step 2. Wipe clean the mating surfaces and centering rings with isopropyl alcohol prior to assembly. Once all fasteners have been installed, torque fasteners in a clockwise pattern. Continue to torque fasteners until they can be tightened without the adjacent fastener coming loose. | TM
9/26/07 | |
| 24. | Close this TPS. | | |



11-8-07