

1. PROJECT CODE		2. JPIC CODE		TASK PERFORMANCE SHEET					
SA-AMS		AMS		NASA - LYNDON B. JOHNSON SPACE CENTER					
TYPE	A	CONFIGURATION CHANGE		<input checked="" type="checkbox"/>	4. TPS NO.		5. PAGE 1 OF 3		
		PERMANENT	<input checked="" type="checkbox"/>	TEMPORARY	<input type="checkbox"/>	6. MOD SHEET(S) NUMBER(S)	7. ORG	8. SYSTEM	9. NEED DATE
	B	NONCONFIGURATION CHANGE		<input type="checkbox"/>		EA	AMS-02	3/20/07	
10. PART NAME			11. PART NO./DRAWING NO.			12. SERIAL/LOT NO.	13. TIME/CYCLE/SHELF LIFE		
STA Vacuum Case Closeout Assembly			SEG39135774-701			N/A	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO		
14. APPLICABLE DOCUMENTS				15. CONTRACT NO./JOB NO.		16. HAZ TEST	17. ENG. EVAL.		
				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			
Gate Valve Relocation on STA Vacuum Case Assembly						<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO			
20. OPER SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legibly)						VERIFICATION		
							22. TECH	23. QADV	
1.	Open this TPS.							#	
2.	Remove the fasteners and washers (P/N NAS1351N3-16 & NAS1149E0363R) that attach the Pumping Port Adapter/Gate Valve (P/N SCD1800-01) at location 74.063 degrees and the Feedthru Port Cover (P/N SDG39135791-001) at location 214.688 degrees on the Lower Support Ring. Bag and tag the fasteners and washers respectively for each part.							3-20-07 #	
3.	Using clean, powder free, nitrile or vinyl gloves, remove the inner and outer o-rings (2-244 and 2-248 respectively) and set on a clean surface.							3-20-07	
4.	Clean the mating surfaces on the Lower Support Ring at the locations in step 2 and the mating surfaces on the removed hardware with IPA and lint free towels.							3-20-07	
5.	Using clean, powder free, nitrile or vinyl gloves, re-distribute the Dow Corning High Vacuum Grease that is currently on the o-rings removed in step 2, around the entire o-ring.							3-20-07	
6.	Re-install the o-rings into their respective grooves.							3-20-07	
7.	Install Pumping Port Adapter onto the Lower Support Ring with the test port facing up at the 214.688 degree location. Re-install the fasteners and washers removed in step 2 and record the running torque (2-18 in-lbs). Seat the fastener. Use the numbering pattern shown below.							3-20-07	
24. ORIGINATOR				DATE	25. FINAL ACCEPTANCE STAMP AND DATE				
Phil Mott									
APPROVALS (Printed or Typed and Signed)									
26. PROJECT ENGINEER				DATE	27. QUALITY ENGINEER		DATE		
Phil Mott					Steve Caldwell				
28.					29.				
30.					31.				

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4. TPS NO.

6. MOD NO.

20. OPER
SEQ. NO.

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

VERIFICATION

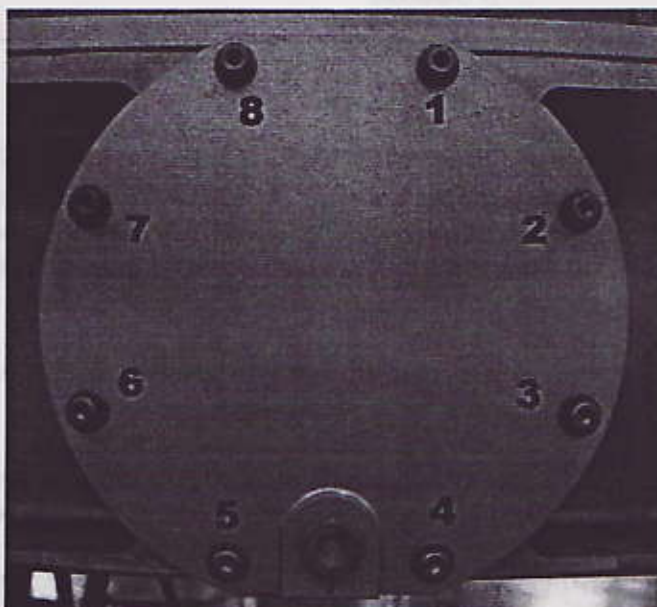
22. TECH

23. QADV

Torque Wrench Model: BELZER 120-m-30

Calibration Tag: 07/01-0280

Calibration Due Date: 7/30/07



Bolt 1 Ø

Bolt 5 Ø

Bolt 2 Ø

Bolt 6 Ø

Bolt 3 Ø

Bolt 7 Ø

Bolt 4 Ø

Bolt 8 Ø

8. Torque all fasteners to the final torque of 34-41 in-lbs plus the running torque and record below. Note: If the running torque is below minimum, continue with the remaining fasteners. This will be address on a DR if necessary.

Torque Wrench Model: BELZER 120-m-30

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3.20.07

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SEQ. NO.

21. OPERATIONS
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VERIFICATION

22. TECH

23. QADV

Bolt 1 <u>Ø 38.3</u>	Bolt 5 <u>Ø 38.1</u>
Bolt 2 <u>Ø 38.3</u>	Bolt 6 <u>Ø 38.2</u>
Bolt 3 <u>Ø 38.9</u>	Bolt 7 <u>Ø 38.8</u>
Bolt 4 <u>Ø 38.1</u>	Bolt 8 <u>Ø 38.3</u>

9. Install the Feedthru Port Cover (P/N SDG39135791-001) removed in step 2 onto the Lower Support Ring with the test port facing up at the 74.063 degree location. Re-install the fasteners and washers removed in step 2 and record the running torque (2-18 in-lbs). Seat the fastener. Use the numbering pattern shown in step 7.

Handwritten: 74.063

Torque Wrench Model: BELZER 120-M-30

Calibration Tag: 07/01-0280

Calibration Due Date: 7.30.07

Bolt 1 <u>Ø</u>	Bolt 5 <u>Ø</u>
Bolt 2 <u>Ø</u>	Bolt 6 <u>Ø</u>
Bolt 3 <u>Ø</u>	Bolt 7 <u>Ø</u>
Bolt 4 <u>Ø</u>	Bolt 8 <u>Ø</u>

10. Torque all fasteners to the final torque of 34-41 in-lbs plus the running torque and record below. Note: If the running torque is below minimum, continue with the remaining fasteners. This will be address on a DR if necessary.

Handwritten: 3.70.07

Torque Wrench Model: BELZER 120-M-30

Calibration Tag: 07/01-0280

Calibration Due Date: 7.30.07

Bolt 1 <u>36.8</u>	Bolt 5 <u>37.5</u>
Bolt 2 <u>36.5</u>	Bolt 6 <u>36.1</u>
Bolt 3 <u>36.7</u>	Bolt 7 <u>37.0</u>
Bolt 4 <u>37.9</u>	Bolt 8 <u>35.7</u>

11. Close this TPS.