

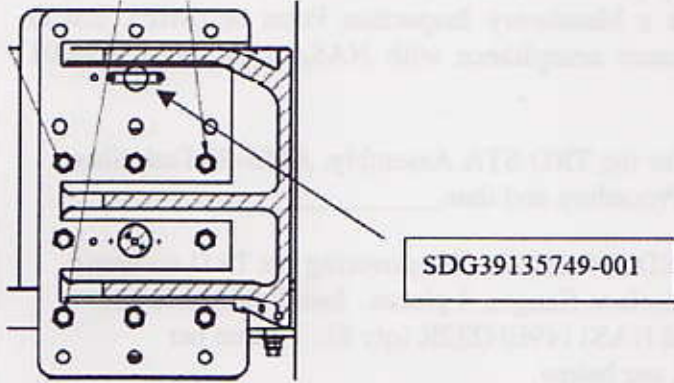
1. PROJECT CODE SA-AMS	2. JPIC CODE AMS	TASK PERFORMANCE SHEET NASA - LYNDON B. JOHNSON SPACE CENTER
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T Y P E	A	CONFIGURATION CHANGE <input checked="" type="checkbox"/>	4. TPS NO.	5. PAGE 1 OF 3
		PERMANENT <input type="checkbox"/> TEMPORARY <input checked="" type="checkbox"/>	6. MOD SHEET(S) NUMBER(S)	7. ORG. EA1
	B	NONCONFIGURATION CHANGE <input type="checkbox"/>	8. SYSTEM AMS	9. NEED DATE 3/19/2007

10. PART NAME TRD STA / Upper USS-02 Ass'y	11. PART NO./DRAWING NO. SEG39135726	12. SERIAL/LOT NO. N/A	13. TIME/CYCLE/SHELF LIFE <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
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14. APPLICABLE DOCUMENTS TRD STA Integration	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
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18. SHORT TITLE OF TPS TRD STA Installation into Upper USS in the PSS	19. ADP UPDATE <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
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20. OPER SEQ NO	21. OPERATIONS (Print, Type, or Write Legibly)	VERIFICATION	
		22. TECH	23. QA/DV
1.	<p>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>NOTE: This TPS will install the TRD STA onto the USS after the STA VC installation. The installation will be done per the TRD group ATS, Assembly Task Sheet or work procedure.</p>		<i>H</i> 3.21.07
2.	<p>Remove the bushing plates, SDG39135749-001; covering the TRD eccentric bushing holes in the Upper USS VC interface flanges, 4 places. Store the parts and fasteners for reuse later in this TPS.</p> <div style="text-align: center;">  </div>		<i>H</i> 3.21.07

24. ORIGINATOR John Heilig	DATE	25. FINAL ACCEPTANCE STAMP AND DATE
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APPROVALS (Printed or Typed and Signed)			
26. PROJECT ENGINEER John Heilig	DATE	27. QUALITY ENGINEER Steve Caldwell	DATE
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. QA/DV
3.	<p>Turn over below list of parts to TRD Project Engineer to perform TRD installation.</p> <p>1. BOLTS, HEX HEAD .500-20UNJF-3A X 2.235L NAS1958C24 qty 24 2. NUT, SELF LOCKING .500-20UNJF-3B NAS1291C8M qty 24 3. Washers NAS1587-8C qty 48 4. TRD Shim SDG39137805-801 SN 1001-1008 qty 4</p>		H 3.21.07
4.	<p>Install the TRD STA Assembly per AMS-02 Task Sheet (ATS) TRDSTA070226-1.</p> <p>Procedure start date <u>3.21.07</u>.</p> <p>ESCG Designated Verifier (DV) <u>Joh Heiler</u>.</p> <p>Note: Contact TRD STA Integration 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 procedure TRDSTA070226-1 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.</p>		
5.	<p>Indicate procedure end date for the TRD STA Assembly, AMS-02 Task Sheet (ATS) TRDSTA070226-1. Procedure end date _____.</p>		
6.	<p>Reinstall the bushing plates, SDG39135749-001; covering the TRD eccentric pins in the Upper USS VC interface flanges, 4 places. Install fasteners and washers, NAS1352N02-6 and NAS1149EN232R (qty 8). Torque per SEG39135726 notes 4 and 8, see below.</p> <p>Super Koropon Lott # <u>358445</u> Exp Date <u>7/1/07</u></p> <p>Braycote 601EF Lott # <u>86440</u> Exp Date <u>3/29/2026</u></p>		

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4. TPS NO.

6. MOD NO.

20. OPER
SEQ. NO.

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

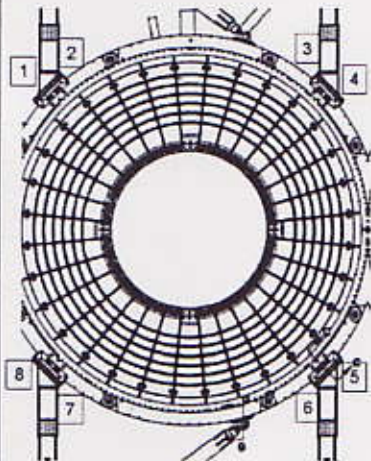
VERIFICATION

22. TECH

23. QA/DV

- 8. SEAL FASTENERS PER NASA/JSC PRC-4004 USING SUPER KOROPON, 515-700 (ITEM 53).
- 7. SEAL FAYING SURFACES WITH SUPER KOROPON 515-700 PER NASA/JSC PRC-4004 (ITEM 53).
- 6. INSTALL FASTENERS PER NASA/JSC PRC-9007. TORQUE FASTENERS TO 0-5 IN-LB UNTIL THE HEAD OF FASTENER SEATS AFTER LOCKING TORQUE. LOCKING TORQUE SHALL BE 90-800 IN-LB PER NASM25027. APPLY A THIN LAYER OF BRAYCOTE 601EF GREASE (ITEM 58) TO THE LOCKING ELEMENT PER NASA/JSC PRC-B002.
- 5. PLACE FASTENERS (ITEMS 40 & 41) HERE FOR -301 AND -302 ASSEMBLY.
- 4. INSTALL FASTENERS PER NASA/JSC PRC-9007. TORQUE FASTENERS PER TORQUE TABLE. ALL TORQUE VALUES ARE ABOVE LOCKING TORQUE/RUNNING TORQUE. APPLY A THIN LAYER OF BRAYCOTE 601EF GREASE (ITEM 58) TO THE LOCKING ELEMENT PER NASA/JSC PRC-B002.

7. Record the running torque and final torque per drawing SEG39135726, Item 37. Bolt numbers correspond to the below sketch.



Bolts #	Running Torque	Final Torque
1.	.3	3.3
2.	.3	3.4
3.	.3	3.4
4.	.3	2.3
5.	.3	2.3
6.	.3	3.3
7.	.3	3.4
8.	.3	2.3

Wrench PN SAME (Running)
 Note M# _____ Cal Due Date SOME

Wrench PN 317962 V (Final)
 Note M# 317962 V Cal Due Date 9/07 * 6 mo after certificate

NOTE: This closes this TPS. The USS is in the configuration required for shipping to IABG for static and modal testing.

8. Close this TPS