

SHUTTLE CRITICAL ITEMS LIST - ORBITER

SUBSYSTEM : ACTIVE THERMAL CONTROL FMEA NO 06-3C -0301 -4 REV:08/29/80

ASSEMBLY : FREON THERMAL LOOP CRIT. FUNC: 11  
P/N RI : MC250-0001-0015 CRIT. HDW:  
P/N VENDOR: SV729780 VEHICLE 102 103 104  
QUANTITY : 1 EFFECTIVITY: X X X  
: ONE/VEHICLE PHASE(S): PL LO X CC X DO X LS

PREPARED BY:		REDUNDANCY SCREEN	A-PASS	B-PASS	C-PASS
DES	O. TRAMER	APPROVED BY:	APPROVED BY (NASA)		
REL	D. RISING	DES	SSM		
QE	W. SMITH	REL	REL		
		QE	QE		

ITEM:  
HEAT EXCHANGER, HYDRAULICS.

FUNCTION:  
PROVIDES HEATING OF HYDRAULIC FLUID DURING ON ORBIT PHASE.

FAILURE MODE:  
EXTERNAL LEAKAGE, FREON.

CAUSE(S):  
CORROSION, MECHANICAL SHOCK, VIBRATION.

EFFECT(S) ON:  
(A) SUBSYSTEM (B) INTERFACES (C) MISSION (D) CREW/VEHICLE  
(A, B) LOSS OF COOLANT FROM ONE FREON COOLANT LOOP FOR VEHICLE COOLING.  
(C) POSSIBLE LOSS OF MISSION. EARLY MISSION TERMINATION FOR FIRST FAILURE.  
(D) SECOND ASSOCIATED FAILURE (LOSS OF REDUNDANT FREON COOLANT LOOP) WILL CAUSE LOSS OF ALL VEHICLE COOLING AND MAY RESULT IN LOSS OF CREW/VEHICLE.

DISPOSITION & RATIONALE:  
(A) DESIGN (B) TEST (C) INSPECTION (D) FAILURE HISTORY (E) OPERATIONAL USE

(A) DESIGN  
THE HEAT EXCHANGER IS MADE FROM STAINLESS STEEL AND NICKEL BRONZE ALLOYS, WHICH ARE CORROSION RESISTANT AND COMPATIBLE WITH FREON 21 AND HYDRAULIC FLUID, AND CONTAINS NO MOVING PARTS SUBJECT TO WEAR. THE FLOW HEADERS ARE MACHINED FROM A SINGLE PIECE STAINLESS STEEL BAR. THE HEADERS ARE WELDED TO THE CORE, WHICH IS MADE OF 81 STACKED PLATE-FIN STAINLESS STEEL PARTING SHEETS (THICKNESS = 0.005 INCH). DESIGN PROOF PRESSURE IS 1.5 AND BURST PRESSURE IS 2.0 TIMES MAXIMUM OPERATING PRESSURE.

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(B) TEST

QUALIFICATION TEST - QUALIFICATION TESTED FOR 100 MISSION LIFE. THE HE EXCHANGER WAS SUBJECTED TO A PROOF/RUPTURE TEST FOR QUALIFICATION. DESIGN PROOF IS 575 PSIG AND UNIT DID NOT RUPTURE UNTILL 2440 PSIG (MAXIMUM HYDRAULICS OPERATING PRESSURE IS 75 PSIA). VIBRATION TESTED A 0.075 G<sup>2</sup>/HZ FOR 52 MIN/AXIS, SHOCK TESTED AT +/- 20 G EACH AXIS.

ACCEPTANCE TEST - CORE IS LEAK TESTED PRIOR TO INSTALLING THE HEADERS A AGAIN IN ATF OF ITEM.

CMRED - FCL'S ARE LEAK CHECKED PRIOR TO EACH FLIGHT. FLUID USE CONTROLLED TO SE-S-0073.

(C) INSPECTION

RECEIVING INSPECTION

RAW MATERIAL AND PURCHASED COMPONENTS REQUIREMENTS ARE VERIFIED BY <sup>2</sup> INSPECTION. PARTS PROTECTION IS VERIFIED BY INSPECTION.

CONTAMINATION CONTROL

SYSTEMS FLUID ANALYSES FOR CONTAMINATION ARE VERIFIED BY INSPECTION. CONTAMINATION CONTROL PLAN IS VERIFIED BY INSPECTION. CONTAMINATION CONTROL PROCESSES AND CLEAN AREAS ARE VERIFIED BY INSPECTION.

ASSEMBLY/INSTALLATION

MANUFACTURING, INSTALLATION, AND ASSEMBLY OPERATIONS ARE VERIFIED BY INSPECTION. SHEET METAL PARTS ARE INSPECTED AND VERIFIED BY INSPECTION SURFACE FINISHES VERIFIED BY INSPECTION. DIMENSIONS VERIFIED BY INSPECTION.

CRITICAL PROCESSES

WELDING IS VERIFIED BY INSPECTION. ALL WELDS ARE STRESS RELIEVED AFTER WELDING, VERIFIED BY INSPECTION. BRAZING IS VERIFIED BY INSPECTION.

NONDESTRUCTIVE EVALUATION

HEADER WELDS TO THE TUBES ARE PENETRANT AND X-RAY INSPECTED. OTHER WELDS (MOUNTING PADS AND HEADER WELDS TO THE CORES) ARE PENETRANT AND 10X MAGNIFICATION VISUALLY INSPECTED. BRAZES ARE VERIFIED BY PROOF AND LEAK TESTS.

TESTING

INSPECTION VERIFIES THAT RESULTS OF ACCEPTANCE TESTING AND FLOWRATES AR WITHIN SPECIFIED LIMITS.

HANDLING/PACKAGING

HANDLING AND PACKAGING REQUIREMENTS VERIFIED BY INSPECTION.

(D) FAILURE HISTORY

NO FAILURE HISTORY.

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(E) OPERATIONAL USE

ON-BOARD ALARM, FREON INLET PRESSURE, WILL PROVIDE INDICATION OF HARDWARE FAILURE. FREON PUMP WILL BE TURNED OFF AND LOSS OF ONE FREON LOOP POWERDOWN WILL BE PERFORMED. ENTRY AT NEXT PRIMARY LANDING SITE.