

SHUTTLE CRITICAL ITEMS LIST - ORBITER NUMBER: 02-4B-007-X

SUBSYSTEM NAME: PAYLOAD BAY DOOR MECHANISMS

REVISION : 0 12/15/88 W

	PART NAME	PART NUMBER
	VENDOR NAME	VENDOR NUMBER
LRU :	PAYLOAD BAY DOOR C/L ACTUATOR	MC287-0040
	HOOVER ELECTRIC	15810
SRU :	TORQUE LIMITER	41415-2
	HOOVER ELECTRIC	15810

QUANTITY OF LIKE ITEMS: 4
4 CENTERLINE LATCH
ACTUATORS

DESCRIPTION/FUNCTION:

PROTECTS ACTUATOR MOTORS/GEARS AND LATCH LINKAGE BY SLIPPING WHEN LINKAGE IS STALLED OR JAMMED. PROTECTS LINKAGE UP TO 10 DEGREES FROM ON CENTER POSITION. ACTUATOR OUTPUT TORQUE IS LIMITED TO 4,000 - 6,500 INCH-LB. ONE TORQUE LIMITER IS INCLUDED IN GEAR TRAIN OF EACH ACTUATOR.

add bulkhead actuator MC287-0039, it is also in

the 02-4B-007-X series

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SUMMARY

SUBSYSTEM NAME: PAYLOAD BAY DOOR MECHANISMS
 LRU PAYLOAD BAY DOOR C/L ACTUATOR
 LRU PART #: MC287-0040
 ITEM NAME: TORQUE LIMITER

FMEA NUMBER	ABBREVIATED FAILURE MODE DESCRIPTION	CIL FLG	CRIT	RZD FLG
02-4B-007-01	SLIPS AT LESS THAN MINIMUM ALLOWABLE TORQUE*	X	1R2	
02-4B-007-02	STRUCTURAL FAILURE <i>Fails to slip at max allowable torque</i>	X	1R3	
02-4B-007-03	SLIPS AT LESS THAN MINIMUM ALLOWABLE TORQUE*	X	1R2	
02-4B-007-04	FAILS TO SLIP AT MAX ALLOWABLE TORQUE*	X	1R3	

SHUTTLE CRITICAL ITEMS LIST - ORBITER

SUBSYSTEM :ACTUATION MECH-PBD

FMEA NO 02-4B -007 -3

REV:03/08/88

ASSEMBLY :PBD LATCH ACTUATOR
P/N RI :MC287-0039
P/N VENDOR:15800 HOOVER ELECTRIC
QUANTITY :4
:4 BULKHEAD LATCH
ACTUATORS

VEHICLE	102	103	104
EFFECTIVITY:	X	X	X
PHASE(S):	PL	LO	OO X DO LS

CRIT. FUNC: 1R
CRIT. HDW: 2

REDUNDANCY SCREEN: A-FAIL B-FAIL C-PASS

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ITEM:

TORQUE LIMITER - BULKHEAD LATCHES

FUNCTION:

PROTECTS ACTUATOR MOTORS/GEARS AND LATCH LINKAGE BY SLIPPING WHEN LINKAGE IS STALLED OR JAMMED. ACTUATOR OUTPUT TORQUE IS LIMITED TO 14,200-19,880 INCH-LB. ONE TORQUE LIMITER IS INCLUDED IN GEAR TRAIN OF EACH ACTUATOR.

FAILURE MODE:

SLIPS AT LESS THAN MINIMUM ALLOWABLE TORQUE

CAUSE(S):

ADVERSE TOLERANCES/WEAR, CHANGE IN MATERIAL PROPERTIES, CONTAMINATION/ FOREIGN OBJECT/DEBRIS, DEFECTIVE PART/MATERIAL OR MANUFACTURING DEFECT, TEMPERATURE, LOSS OF SPRING FORCE

EFFECTS ON:

(A)SUBSYSTEM (B)INTERFACES (C)MISSION (D)CREW/VEHICLE

(A) LOSS OF CAPABILITY TO OPEN OR CLOSE A SET OF 4 LATCHES.

(B,C) LOSS OF MISSION IF PAYLOAD BAY DOORS CANNOT BE OPENED. ENTRY MAY PROCEED WITH ANY ONE OF FOUR BULKHEAD LATCH GANGS DISENGAGED, REF. JSC08934.

(D) POSSIBLE LOSS OF VEHICLE/CREW IF MORE THAN ONE GANG OF BULKHEAD LATCHES FAIL TO LATCH.

FAILS REDUNDANCY SCREEN "A" SINCE NO TURNAROUND TESTS ARE PERFORMED TO VERIFY THIS FAILURE AND FAILS SCREEN "B" SINCE THERE ARE NO MEANS OF VISUALLY DETECTING TORQUE SLIPPAGE IN FLIGHT.

SHUTTLE CRITICAL ITEMS LIST - ORBITER

SUBSYSTEM : ACTUATION MECH-PBD FMEA NO 02-4B -007 -3 REV:03/08/88

DISPOSITION & RATIONALE:

(A) DESIGN (B) TEST (C) INSPECTION (D) FAILURE HISTORY (E) OPERATIONAL USE

(A) DESIGN

SPRING LOADED BALL CLUTCH WITH ALUMINUM BRONZE AND STEEL CLUTCH DISKS. DESIGN OF ACTUATION SYSTEM PERMITS PARTIAL WORKAROUND OF THIS FAILURE MODE BY EXTRAVEHICULAR ACTIVITY (EVA) CREW IF PAYLOAD DOES NOT LIMIT ACCESS. NO WEAR IN NORMAL OPERATION OF ACTUATOR. TORQUE LIMITING ONLY REQUIRED IN JAMMED OR OVERLOAD CONDITION OF LINKAGE.

(B) TEST

QUALIFICATION TESTS: THE QUALIFICATION ACTUATOR IS CERTIFIED PER CR-29-287-0039-0001D. QUALIFICATION TESTS INCLUDE: HUMIDITY TESTS - (PER MIL-STD-810B METHOD 507 PROCEDURE IV, CYCLE ACTUATOR DURING SECOND AND FOURTH HUMIDITY CYCLE); QUALIFICATION ACCEPTANCE VIBRATION TEST (QAVT) - 20 TO 2,000 HZ RANGE WITH MAXIMUM OF 0.067 g²/HZ FOR 2 1/2 MINS/AXIS IN ACCORDANCE WITH SP-T-0023B; ELECTRICAL CIRCUITS - MONITORED FOR CONTINUITY DURING VIBRATION AND ACTUATOR CYCLED BEFORE AND AFTER VIBRATION TEST; FLIGHT VIBRATION TESTS - 20 TO 2,000 HZ RANGE WITH MAXIMUM OF 0.75 g²/HZ FOR 51 MINS/AXIS LEVEL "A" AND 0.2 g²/HZ FOR 27 MINS/AXIS-LEVEL "B"; THERMAL VACUUM TESTS - THERMALLY CYCLED 5 TIMES BETWEEN -167 DEG F AND +250 DEG F AT A VACUUM OF 1 X 10⁻⁶ TORR; ACTUATOR CYCLED AT EACH -100 DEG F AND +250 DEG F; THERMAL CYCLING TEST - CYCLED 5 TIMES BETWEEN -167 DEG F AND +330 DEG F WITH ACTUATOR CYCLED AT EACH -100 DEG F MINIMUM HEAT DISSIPATING MODE AND +250 DEG F AT MAXIMUM HEAT DISSIPATING MODE WITH AT LEAST 60 MINUTES DWELL AT EACH TEMPERATURE EXTREME.

QUAL TESTS ALSO INCLUDE: SHOCK TEST - BASIC DESIGN SHOCK PER MIL-STD-810B METHOD 516.1 PROCEDURE I AND TRANSIENT SHOCK AT 5-35 HZ +/-0.25 g PEAK; OPERATING LIFE TEST - ACTUATOR CYCLED 1500 TIMES AT ROOM TEMP, INCLUDES MOTOR #1 AND #2 CYCLED 250 TIME EACH INDIVIDUALLY WITHIN 60 SECONDS/STROKE AND 1,000 TIMES WITH BOTH MOTORS DRIVING TOGETHER WITHIN 30 SECONDS/STROKE; MECHANICAL STOP TEST - 100 TIMES WITH BOTH MOTORS INTO HARD STOP IN EACH DIRECTION AT NO LOADS. POWER CONSUMPTION TEST, IRREVERSIBILITY TEST FREEPLAY TESTS WERE CONDUCTED AS DEFINED IN THIS ACCEPTANCE TESTS. CERTIFICATION BY ANALYSIS/SIMILARITY - INCLUDED: FUNGUS, OZONE, ACCELERATION, TRANSPORTATION-PACKAGING, SAND/DUST, SALT SPRAY, LANDING SHOCK, AND EXPLOSIVE ATMOSPHERE. THE ACTUATORS WERE, SUBJECTED TO SYSTEM QUALIFICATION TESTS FOR FORWARD LATCH MECHANISM INSTALLATION V070-594160 (REF. CR-29-594160-001D) AND AFT LATCH MECHANISM INSTALLATION V070-594260 (REF. CR-29-594260-001E).

ACCEPTANCE TESTS: INCLUDES EXAMINATION OF PRODUCT (FOR WEIGHT, WORKMANSHIP, DIMENSIONS, CONSTRUCTION, CLEANLINESS, FINISH, IDENTIFICATION MARKING; TRACEABILITY, USE OF CERTIFIED MATERIALS AND PROCESSES); ACCEPTANCE VIBRATION TESTS (AVT) - 20 TO 2,000 HZ RANGE WITH MAXIMUM OF 0.04 g²/HZ FOR 30 SECONDS/AXIS IN ACCORDANCE WITH SP-T-0023 B; ELECTRICAL CIRCUITS - MONITORED FOR CONTINUITY DURING VIBRATION TESTS AND ACTUATOR CYCLED BEFORE AND AFTER VIBRATION TESTS; ACCEPTANCE THERMAL TEST (ATT) - THERMALLY CYCLED FROM +70 DEG F TO +310 DEG F TO +250 DEG F TO -147 DEG F TO -100 DEG F TO +310 DEG F TO +250 DEG F TO +70 DEG F WITH CONTINUITY MONITORED THROUGHOUT, THE ACTUATOR WAS CYCLED AT EACH +250 DEG F AND -100 DEG F.

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ACCEPTANCE TESTS ALSO INCLUDE: POWER CONSUMPTION TEST - SINGLE MOTOR STROKE WITHIN 60 SECONDS, DUAL MOTOR STROKE WITHIN 30 SECONDS; INSULATION RESISTANCE TEST AND INITIAL DIELECTRIC WITHSTANDING VOLTAGE TEST - PER MF0004-002; CYCLING TEST - SINGLE MOTOR, 20 CYCLES EACH AT 60 SEC/STROKE, DUAL MOTOR 80 CYCLES AT 30 SEC/STROKE; FREEPLAY TEST - MAXIMUM OF 0.1 DEGREES WITH 10 INCH-LB REVERSING TORQUE IN EACH DIRECTION; STALL/MAXIMUM TORQUE TEST - TORQUE LIMITER HOLDS AT 14,200 INCH-LB AND SLIPS ABOVE 19,880 INCH-LB; IRREVERSIBILITY TEST - ACTUATOR IS IRREVERSIBLE FROM LATCHING DIRECTION WITH 14,200 INCH-LB LOAD; AND TRAVEL LIMIT TESTS - ACTUATOR STOPPED BY LIMIT SWITCHES AND BY HARD STOPS WITH SWITCHES DEENERGIZED.

OMRSD: NONE. ACTUATOR CANNOT BE CHECKED FOR THIS FAILURE MODE DURING SYSTEM FUNCTIONAL CHECK. MAINTENANCE SAMPLING PERIODICALLY VERIFIES TORQUE LIMITER PERFORMANCE.

(C) INSPECTION

RECEIVING INSPECTION

CERTIFICATION OF COMPLIANCE, TEST COUPONS, PHYSICAL AND CHEMICAL RECORDS ARE VERIFIED BY INSPECTION. RECEIVING INSPECTION PERFORMS VISUAL AND DIMENSIONAL EXAMINATION OF ALL INCOMING PARTS. QUALITY CONTROL MAINTAINS SURVEILLANCE OF RAW MATERIAL, LIMITED LIFE MATERIALS, CHEMICAL AND METALLURGICAL TESTS AND REPORTS. SPRINGS ARE MANUFACTURED AND CHECKED BY HOOVER SUPPLIERS. CERTIFICATION IS ON FILE.

CONTAMINATION CONTROL

POLYETHYLENE SHEETING, USED TO BAG AND SEAL PARTS AFTER CLEANING, IS VERIFIED BY INSPECTION. A CLASS 100,000 CLEAN FACILITY IS USED FOR ASSEMBLY AND VERIFIED BY INSPECTION. ALL METAL PARTS ARE VERIFIED BY INSPECTION TO BE CLEANED. FINAL INSPECTION INCLUDES CHECKS FOR CONTAMINATION USING BORESCOPES, 5X AND 10X MAGNIFICATION DEVICES, AND FILTRATION METHODS.

ASSEMBLY/INSTALLATION

INSPECTION VERIFIES AND RECORDS DIMENSIONS OF ALL DETAIL PARTS.

NONDESTRUCTIVE EVALUATION

ALL DETAIL PARTS TO HOOVER DRAWINGS ARE MAGNETIC PARTICLE INSPECTED PER MIL-I-6868 OR FLUORESCENT PENETRANT INSPECTED PER MIL-I-6866, DEPENDING ON ALLOY, VERIFIED BY INSPECTION.

CRITICAL PROCESSES

HEAT TREATING IS VERIFIED BY INSPECTION.

TESTING

ACCEPTANCE TESTING IS VERIFIED BY INSPECTION.

HANDLING/PACKAGING

HANDLING AND PACKAGING REQUIREMENTS ARE VERIFIED BY INSPECTION.

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(D) FAILURE HISTORY

THERE HAVE BEEN NO ACCEPTANCE TEST, QUALIFICATION TEST, FIELD OR FLIGHT FAILURES ASSOCIATED WITH THIS FAILURE MODE.

(E) OPERATIONAL USE

LATCH TOOLS ARE AVAILABLE FOR EVA WORKAROUND EXCEPT IN THE CASE OF CERTAIN PAYLOADS WHICH LIMIT ACCESS. ABORT DECISION REQUIRED IF DOOR(S) CANNOT BE OPENED.