

SSME EA/CIL
REDUNDANCY SCREEN

Component Group: Ducts and Lines
CIL Item: K318-01
Part Number: RS007118
Component: HPOTP Turbine Primary Seal Drain Manifold
FMEA Item: K318
Failure Mode: Fails to contain hot gas.

Prepared: D. Early
Approved: T. Nguyen
Approval Date: 7/25/00
Change #: 1
Directive #: CCBD ME3-01-5638

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Phase	Failure / Effect Description	Criticality Hazard Reference
SMC 4.1	Hot-gas leakage into aft compartment. Aft compartment overpressurization. Possible fire or detonation. Loss of vehicle. Redundancy Screens: SINGLE POINT FAILURE: N/A	1 ME-D3S,A,M,C

SSME FMEA/CIL
DESIGN

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Design / Document Reference

FAILURE CAUSE: A: Parent material failure or weld failure.

THE MANIFOLD ASSEMBLY (1) IS FABRICATED USING INCONEL 625 TUBE AND BAR. INCONEL 625 WAS SELECTED FOR ITS WELDABILITY, FORMABILITY, RESISTANCE TO STRESS CORROSION CRACKING, AND CORROSION RESISTANCE (2). INCONEL 625 POSSESSES THE REQUIRED STRENGTH WITHOUT REQUIRING HEAT TREAT. INCONEL 625 IS NOT SIGNIFICANTLY EFFECTED BY HYDROGEN IN THIS ENVIRONMENT (2). FLANGE SECTIONS INCORPORATE RADIUS JOINTS TO REDUCE STRESS CONCENTRATIONS. OFFSET LIMIT REQUIREMENTS ARE ESTABLISHED TO REDUCE STRESS CONCENTRATIONS AND IMPROVE WELD GEOMETRY. TUBING STOCK IS DRAWN TO MAINTAIN SURFACE REGULARITY. INSTALLATION IS CONTROLLED FOR ANGULARITY AND OFFSET PER SPECIFICATION REQUIREMENTS (3). MINIMUM FACTORS OF SAFETY FOR THE MANIFOLD MEET CEI REQUIREMENTS (4). HIGH AND LOW CYCLE FATIGUE LIFE MEET CEI REQUIREMENTS (5). THE MANIFOLD ASSEMBLY HAS COMPLETED PRESSURE CYCLING AND ULTIMATE PRESSURE DVS TESTING (6). THE MANIFOLD ASSEMBLY PARENT MATERIAL WAS CLEARED FOR FRACTURE MECHANICS/NDE FLAW GROWTH, SINCE THEY ARE NOT FRACTURE CRITICAL PARTS (7). TABLE K318 LISTS ALL THE FMEA/CIL WELDS AND IDENTIFIES THOSE WELDS IN WHICH THE CRITICAL INITIAL FLAW SIZE IS NOT DETECTABLE, AND THOSE WELDS IN WHICH THE ROOT SIDE IS NOT ACCESSIBLE FOR INSPECTION. THESE WELDS HAVE BEEN ASSESSED AS ACCEPTABLE FOR FLIGHT (8).

(1) RS007118; (2) RSS-8582; (3) RA1102-006; (4) RSS-8546, CP320R0003B; (5) RL00532, CP320R0003B; (6) SSME-81-1046; (7) NASA TASK 117; (8) RSS-8756

**SSME FM CIL
INSPECTION AND TEST**

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Failure Causes	Significant Characteristics	Inspection(s) / Test(s)	Document Reference
A	LINE		RS007118
	FLANGE		RS007136
	FLANGE		RS007387
	MATERIAL INTEGRITY	MATERIAL INTEGRITY IS VERIFIED PER DRAWING REQUIREMENTS.	RS007118 RS007136 RS007387
		DETAILS ARE PENETRANT INSPECTED PER SPECIFICATION REQUIREMENTS.	RA0115-116
	WELD INTEGRITY	ALL WELDS ARE INSPECTED TO DRAWING AND SPECIFICATION REQUIREMENTS PER WELD CLASS. INSPECTIONS INCLUDE: VISUAL, DIMENSIONAL, PENETRANT, RADIOGRAPHIC, ULTRASONIC, AND FILLER MATERIAL, AS APPLICABLE.	RL10011 RA0607-094 RA0115-116 RA0115-006 RA1115-001 RA0115-127
ASSEMBLY INTEGRITY	THE ASSEMBLY IS PROOF PRESSURE TESTED PER DRAWING REQUIREMENTS.	RS007118	
FLIGHT FLOW TESTING	THE EXTERNAL SURFACE IS VISUALLY INSPECTED PRIOR TO EACH LAUNCH.		OMRSD V41BU0.030
	A HELIUM SIGNATURE LEAK TEST IS PERFORMED PRIOR TO EACH LAUNCH. (LAST TEST)		OMRSD S00000.950

Failure History: Comprehensive failure history data is maintained in the Problem Reporting database (PRAMS/PRACA)
 Reference: NASA letter SA21/88/308 and Rocketdyne letter 88RC09761.

Operational Use: Not Applicable.

SSME FMEA/CIL
WELD JOINTS

Component Group: Ducts and Lines
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Component	Basic Part Number	Weld Number	Weld Type	Class	Root Side Not Access	Critical Initial Flaw Size Not Detectable		Comments
						HCF	LCF	
MANIFOLD	RS007118	5,8	GTAW	I		X	X	
