

CRITICAL ITEMS LIST

ASSY NOMENCLATURE: OXYGEN REGULATOR
 ASSY P/N: F241-3708-1

SYSTEM: CREW ESCAPE SYSTEM

SUBSYSTEM: HELMET RETENTION ASSEMBLY

REVISION:

PAGE 52 OF 60

FMEA		NAME, QTY & DRAWING REF DESIGNATION	CRITY	FAILURE MODE AND CAUSE	FAILURE EFFECT ON END ITEM	RATIONALE FOR ACCEPTANCE
REF	REV					
4.3.1		OXYGEN REGULATOR (1), SKD13101506-3D1	1/1	4.3.1 Mode: Fails open Cause: • defective material • contamination • defective diaphragm	Excessive consumption of EOS 10-minute supply	1. DESIGN FEATURES TO MINIMIZE FAILURE MODE a. The regulator is in use by the Air Force. b. The cover and body are cast aluminum c. The diaphragm and packings are silicone elastomer. d. Internal parts are stainless steel and phosphor bronze. e. A screen filter is installed on the inlet port to prevent contamination of the regulator. 2. TEST OR ANALYSIS TO DETECT FAILURE MODE a. <u>Acceptance Testing</u> . (1) Leakage test at 2 inches of H ₂ O at 120 psig, leakage allowed (0.9 - 1.65 inches H ₂ O). (2) Flow test: 0 slpm at 55 psig; 90 slpm at 55 psig; 0 slpm at 90 psig; and 90 slpm at 90 psig (3) Flow test at altitude: 0 alpm (40,000 feet) at 50 psig; 90 alpm (40,000 feet) at 50 psig; 0 alpm (43,000 feet) at 50 psig; 90 alpm (43,000 feet) at 50 psig; 0 alpm (40,000 feet) at 90 psig; 90 alpm (40,000 feet) at 90 psig; 0 alpm (43,000 feet) at 90 psig; and 90 alpm (43,000 feet) at 90 psig b. <u>Certification Test</u> (1) High altitude chamber test, Brooks Air Force Base (a) Manned testing series 1. Gradual ascent/descent to 39,000 feet. 2. Denitrogenation verification for function as an extravehicular activity prebreathing device

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 ATTACHMENT -
 Page 109 of 111

PREPARED BY: R. L. ALLISON

SUPERSEDING DATE

APPROVED BY: J. D. SCHLOSSER

DATE:

REF: 1001

CRITICAL ITEMS LIST

ASSY NOMENCLATURE: OXYGEN REGULATOR

SYSTEM: CREW ESCAPE SYSTEM

REVISION:

ASSY P/N: F261-1700-1

SUBSYSTEM: HELMET RETENTION ASSEMBLY

PAGE 53 OF 60

FMEA		NAME, QTY & DRAWING REF DESIGNATION	CRITY	FAILURE MODE AND CAUSE	FAILURE EFFECT OR FAILURE CONDITION	RATIONALE FOR ACCEPTANCE
REF	REV					
4.3.1		OXYGEN REGULATOR (1), SKD13101506-301	(1)	<p>4.3.1 Mode: Fails open</p> <p>Cause:</p> <ul style="list-style-type: none"> • defective material • contamination • defective diaphragm 	Excessive consumption of EOS 10-minute supply	<p>c. <u>Turnaround Test</u>. (In accordance with PIA 23037)</p> <p>(1) Leak test at 120 psig (leakage allowable 0.9 - 1.65 in H₂O)</p> <p>(2) Regulator positive pressure test: at 55 psig, 0 lpm, at 55 psig, 135 lpm, pressure should be equal to or greater than 0.1 in H₂O; at 110 psig, 135 lpm, pressure should be equal to or greater than 0.1 in H₂O; at 110 psig, 0 lpm, pressure should be (0.9 - 1.65 in H₂O); at 140 ± psig, 45 lpm, pressure should be equal to or greater than 0.0 in H₂O; at 140 ± 20 psig, 0 lpm, pressure should be (0.9 - 1.65 in H₂O).</p> <p>3. INSPECTION</p> <p>a. Visual inspection of parts for defects.</p> <p>b. One hundred percent visual inspection during assembly of regulator.</p> <p>c. Verify regulator operates within leakage specifications</p> <p>d. Verify regulator operates within positive pressure test specifications.</p> <p>e. Verify parts and regulator are cleaned to level 300 in accordance with JSCM 5322.</p> <p><u>Turnaround Inspection</u>. (In accordance with PIA 23037)</p> <p>a. Visual inspection of parts for defects.</p> <p>b. One hundred percent visual inspection during assembly of regulator</p> <p>c. Verify regulator operates within leakage specifications</p>

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SUPERSEDING DATE:

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DATE:

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 ATTACHMENT - 11
 PAGE 110 OF 117

CRITICAL ITEMS LIST

ASSY NOMENCLATURE: OXYGEN REGULATOR

SYSTEM: CREW ESCAPE SYSTEM

REVISION:

ASSY P/N: F247-1700-1

SUBSYSTEM: HELMET RETENTION ASSEMBLY

PAGE 54 OF 60

P/N/A		NAME, QTY & DRAWING REF DESIGNATION	QTY	FAILURE MODE AND CAUSE	FAILURE EFFECT ON END ITEM	RATIONALE FOR ACCEPTANCE
REF	REV					
4.3.1		OXYGEN REGULATOR (1), SKD13101506-301	1/1	<p>4.3.1 Mode: Fails open</p> <p>Cause:</p> <ul style="list-style-type: none"> • defective material • contamination • defective diaphragm 	Excessive consumption of EOS 10-minute supply	<p>d. Verify regulator operates within positive pressure test specifications.</p> <p>e. Verify parts and regulator are cleaned to level 300 in accordance with JSCM 5322.</p> <p>4. FAILURE HISTORY</p> <p>None. This regulator is used by the Air Force in high altitude suits for high performance aircraft and Dryden Flight Research Center.</p> <p>5. OPERATIONAL USE</p> <p>a. Operational Effect of Failure - Possible loss of crewmember</p> <p>b. Crew Action - None</p> <p>c. Crew Training - Not applicable.</p> <p>d. Mission Constraints - None. Mission would be terminated prior to emergency use of this equipment.</p> <p>e. In Flight Checkout - None. Crew could not repair or replace a defective regulator.</p>

PREPARED BY: R. L. ALBISON

SUPERSEDING DATE

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DATE

CEE/HRR-B

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 ATTACHMENT - II
 PAGE 111 OF 117