



SHUTTLE CRITICAL ITEMS LIST - ORBITER

attached  
# 50200P/6, 22

JBSYSTEM : ATMOSPHERIC REVIT. FMEA NO 06-1A -1205 -1 REV:10/26/87

AND BACK TO AMBIENT. THREE CYCLES MATED AND TWO CYCLES DEMATED AND CAPPED. 1000 CYCLE OPERATING LIFE TEST.

ACCEPTANCE TEST - EXAMINATION OF PRODUCT. PROOF TEST AT 1575 PSIG FOR THREE MINUTES CONNECTED AND DISCONNECTED, CAPPED AND UNCAPPED. OPERATION TEST - 5 CYCLES AT 0 PSIG AND AT 1050 PSIG. OVERTRAVEL TORQUE TEST. LEAKAGE TEST AT 12 PSIG AND 1050 PSIG -  $3.33 \times 10^{-3}$  SCCS MAX LEAKAGE - STANDARD TEST DISCONNECTED, AND WITH CAP INSTALLED (POPPET BLOCKED OPEN). CAP LEAK TESTED TO TOOLS OF MAXIMUM AND MINIMUM DIMENSION TO ASSURE A PROPER FIT TO ALL QD'S.

OMRSD - LEAK CHECK OF QD AFTER DEMATING AND PRIOR TO CAP INSTALLATION. VISUAL INSPECTION OF CAP INCLUDING O-RING SEAL PRIOR TO INSTALLATION.

C) INSPECTION

RECEIVING INSPECTION  
RAW MATERIAL VERIFIED.

CONTAMINATION CONTROL  
CORROSION PROTECTION PROVISIONS AND NDE VERIFIED BY INSPECTION.  
CONTAMINATION CONTROL VERIFIED BY INSPECTION.

ASSEMBLY/INSTALLATION  
PARTS PROTECTION, MANUFACTURING PROCESS, INSTALLATION AND ASSEMBLY VERIFIED BY INSPECTION. CRITICAL DIMENSIONS VERIFIED BY INSPECTION.

NONDESTRUCTIVE EVALUATION  
RADIOGRAPHIC INSPECTION VERIFIED.

CRITICAL PROCESSES  
WELDING CERTS AND HEAT TREAT VERIFIED BY INSPECTION.

TESTING  
ATP VERIFIED BY INSPECTION.

(D) FAILURE HISTORY  
NO FAILURES.

(E) OPERATIONAL USE  
NO CREW ACTION REQUIRED FOR FIRST FAILURE.