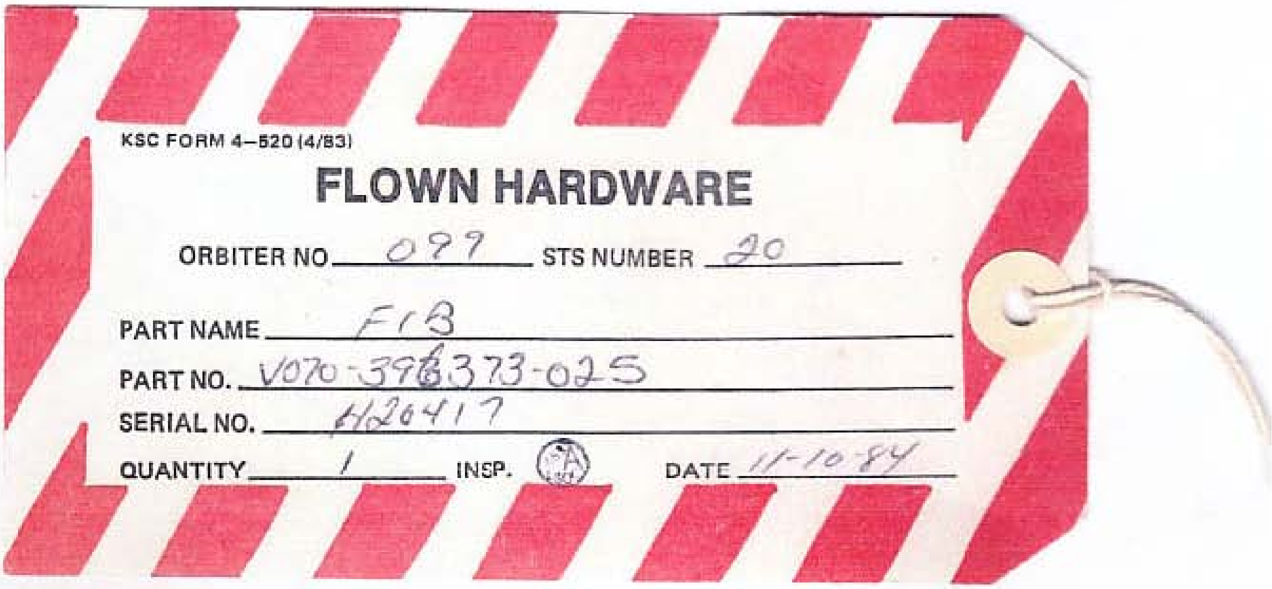


KSC FORM 4–520 (4/83)

FLOWN HARDWARE

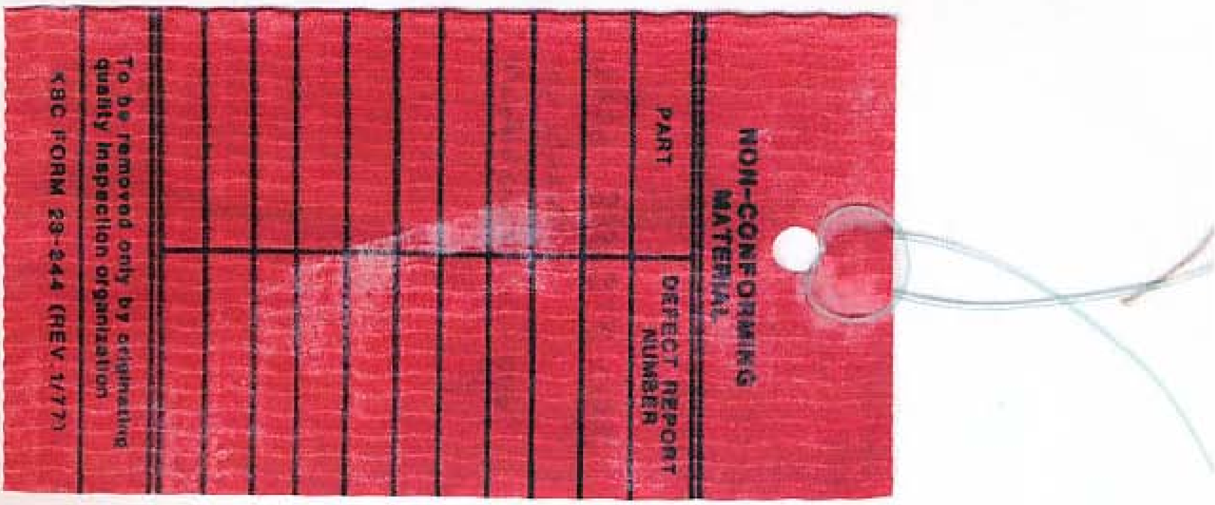
ORBITER NO 099 STS NUMBER 20

PART NAME FIB

PART NO. V070-396373-025

SERIAL NO. H20417

QUANTITY 1 INSP. DATE 11-10-84



NON-CONFORMING MATERIAL

PART	DEFECT REPORT NUMBER

To be removed only by originating quality inspection organization

KSC FORM 23-244 (REV 1/77)

NASA
National Aeronautics and Space Administration
Department of the Air Force
United States of America
Kennedy Space Center/Vandenberg Air Force Base

(ORBITER TPS)

☒ **PROBLEM REPORT** PV6R03347

☐ **DISCREPANCY REPORT**

2. DETECTED DURING ~~TPS-008 Bond~~ Visual
3. WORK AREA OPF-1
4. END ITEM CONTROL NUMBER TLP01-9-07-0144
5. WORK UNIT CODE
6. PART NAME AFRSI
7. PART NO. V070-396373-025
8. SER. NO. H20417
10. FSCM/VENDOR 03953
11. NHA/PN FF
12. STS #/EF 20/99
13. REPORTED BY (NAME/ORG/STAMP) D. Penn LSOC 194

16. ITEM
17. PROBLEM DESCRIPTION

☐ HRSI 9/22 ☐ LRSI ☐ FRSI ☐ RCC GAP FILLER: ☐ PILLOW ☐ AMES ☐ DESIGN ☐ MINI-Q ☒ OTHER AFRSI

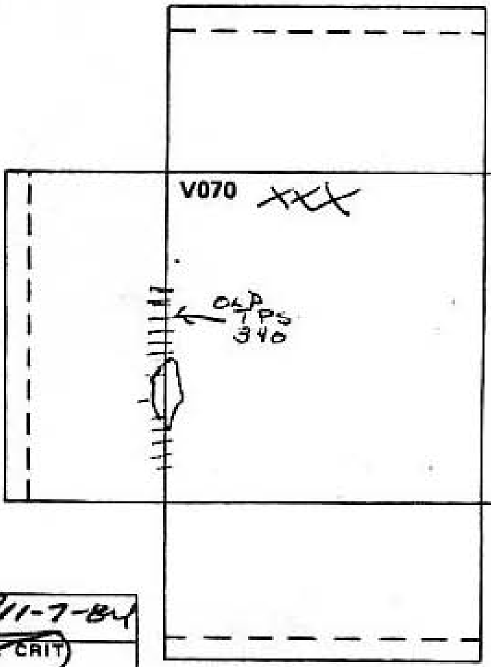
LOCATION ____ INCHES FROM OML ____ TILE THICKNESS ____

CHIP/GOUGE ____ L_x ____ W_x ____ D

INSTALLED ☐ YES ☐ NO

☐ CARRIER PANEL: INSTALLED ☐ YES ☐ NO

1 Blanket is Torn 1.5 along edge with Batting exposed (old TPS 340)



CAUSE: Blanket Removal
17A. QA SUPV./DATE 11-7-84
18. CRIT. SKILLS ☒ YES ☐ NO
20. CONSTRAINTS ☒ YES ☐ NO TO: V5013
21. CRIT

29. ITEM
30. DISPOSITION
31. TECH
CONT QA

1 SEE PG 2 FOR DISPO.

33. FINAL ACCEP
DATE

ATTACHMENTS (STAMPS) 11/9/84 1A 1B 1C 1D 1E 1F 1G 1H 1I

23. WEIGHT REQ. ☐ YES ☑ NO
24. RETEST REQ. ☐ YES ☑ NO
25. HAZARDOUS OP ☐ YES ☑ NO
26. MR REQ. ☐ YES ☑ NO
36. RELATED REPORTS
19. E O REQ. ☐ YES ☑ NO
34. DATA CODE
37. RC ACTION REQ'D. ☐ YES ☑ NO
38. RC CONSTRAINT (SIGNATURE DATE) TO:
39. RC CLOSURE (Signature) DATE
40. TPS DATA

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KSC FORM 2-151A (REV. 1/82)

ORIGINAL

P-501 B
PAGE 1 OF 2
OMI V9024 VOL 5 REV C
ISSUED BY Bracman

PROCESS CONTROL RECORD

REPLACEMENT OF FLEXIBLE
INSULATION BLANKETS

Process 501

WAD NO. [illegible]
FIB NO. 96[illegible]
DATE 11-10-8

	PROC.	SEQ	CRITICAL SKILLS:	TECH	DV	CONTRA QA
	501	001	FIB Part No. 396373-025 OCN H20417	T	11/10/84	
	501	003	Remove FIB	T	11/10/84 DV	
	501	004	Remove Gross RTV Residue from Substrate	T	11/10/84	
P	501	005 006 007	Clean and Inspect Cavity Record Substrate ______ Record Proc # ______	T		Q
	501	008	Rework Screed Per Proc. 213 ☐N.R.______	T		Q
	501	009	ID Removed Blanket as Scrap and Route to Logistics	T		Q
	501	010	Fabricate Mylar Templates Indicate Method: ☐1 ☐2 ☐3 (Proc. 102)	T		Q
	501	011	Obtain Replacement Blanket Record PMR #______ ☐N.R.______		DV	
	501	012	Prepare Structure	T		Q
			☐Heatsink (Proc. 211) ☐N.R.______ ☐Screed (Proc. 212) ☐N.R.______			
			☐N.R.______ ☐Spot Bond Wiring (Proc. 217)			
			☐Koropon (Proc. 210) ☐N.R.______ Date______ Time______ Date______ Time______	T		Q
	210	006	Verify 24 Hour Cure Complete Date______ Time______ ☐N.R.______	T		Q
	501	013	Determine Pressure Method	T		Q
			☐ Positive Pressure Obtain Pressure Pad			
			☐ Vacuum Pressure Verify Vacuum Hold/Seal Requirements			
	501	014	Determine Location/Layout	T		Q
	501	015	Install Filler Bar Per Proc.502 ☐N.R.______	T		Q
			Install Sub Insulation Per Proc. 503 ☐SIP ☐FRSI ☐ NOMEX Ramp ☐N.R.______	T		Q
	501	016	Prefit Blanket PN______ OCN______ Document No-Fit WAD #______	T		Q
	501	017	Check Tooling Set-Up ☐N.R.______	T		Q
	501	018	Prepare Coupons/Test Panels	T		Q
	501	019	Prepare Surface. Record Proc. #______	T		Q
			Solvent Wipe Sub-Insulation/Transfer Coat Date______ Time______	T		Q

Kennedy Space Center/Vandenberg Air Force Base

☐ **DISCREPANCY REPORT**

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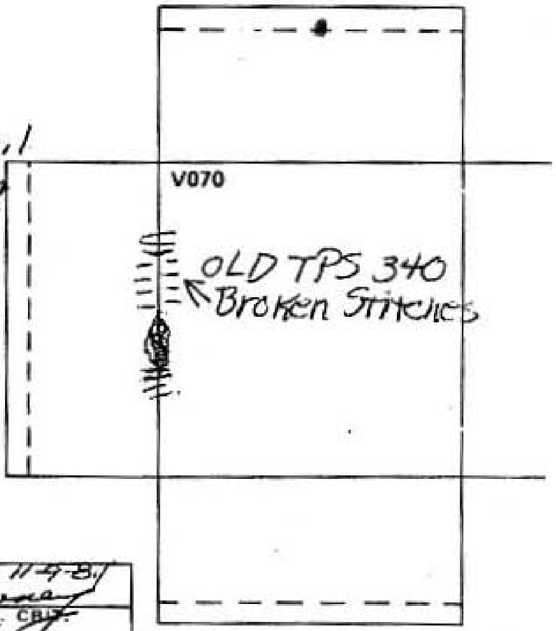
2. DETECTED DURING: TLP01-9-07-0144
3. WORK AREA: OPF1
4. END ITEM CONTROL NUMBER: TLP01-9-07-0144
5. WORK UNIT CODE:
6. PART NAME: AFRSI
7. PART NO. V070 396373-025
8. SER. NO. H20417
10. FSCM/VENDOR: 03953 RI
11. NHA/PN: FF
12. STS #/EFF. 20/099
13. REPORTED BY (NAME/ORG/STAMP): Schmitz, LSOC, 197

16. ITEM

17. PROBLEM DESCRIPTION
☐ HRSI 9/22 ☐ LRSI ☐ FRSI ☐ RCC GAP FILLER: ☐ PILLOW ☐ AMES ☐ DESIGN ☐ MINI-Q ☑ OTHER AFRSI
LOCATION ______ INCHES FROM OML ______ TILE THICKNESS ______
CHIP/GOUGE ______ L x ______ W x ______ D
INSTALLED ☑ YES ☐ NO
☐ CARRIER PANEL: INSTALLED ☐ YES ☐ NO

2. Area reported torn in pg. 1 was coated w. elastimer; stitches are broken, & repair is on an edge which should not have pressure applied.
(REF. V9040 Process 341-033 which req's pressure application)



CAUSE: GRN
17A. QA SUPV/DATE: 11-9-84
18. CRIT. SKILLS ☑ YES PGK ☐ NO
20. CONSTRAINTS ☐ YES ☐ NO TO: V5019
21. CRIT. 3

29. ITEM	30. DISPOSITION	31. TECH	CONTR QA
3.	VOID DISPO. PG. 2.		Q
			11-10-84
4.	REPLACE FCB 396373-025 PER OMI V9024 PROC. 501.		QA
5.	CLOSE THIS PR.		QA
	LSOC SUP: C R Kuyer 11-9-84		
	LSOC QA: 11/10/84		
	PS01 LSOC 11-10-84		

33. FINAL ACCEP
DATE

ATTACHMENTS (STAMPS) 1A 1B 1C 1D 1E 1F 1G 1H 1I

23. WEIGHT REQ. ☐ YES ☑ NO
24. RETEST REQ. ☐ YES ☑ NO
25. HAZARDOUS OP ☐ YES ☑ NO
26. MR REQ. ☐ YES ☑ NO
36. RELATED REPORTS
19. E O REQ. ☐ YES ☑ NO
34. DATA CODE
37. RC ACTION REQ'D. ☐ YES ☑ NO
38. RC CONSTRAINT (SIGNATURE DATE) TO:
39. RC CLOSURE (Signature) DATE
40. TPS DATA

KSC FORM 2-151A (REV. 1/82)

ORIGINAL

NASA USAF
Kennedy Space Center/Vandenberg Air Force Base

PR PV6L05550
DR
☐ CAAR

2 OF

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2. DETECTED DURING	3. RESERVED	4. END ITEM CONTROL NO. PLBD-3-04-0061	

5. ITEM		6. TECH	7. CONTR QA	8. GOVT QA
1.	ORDER REPLACEMENT BLANKET # 377516-063.			
	RECORD PMR NO: ______			
2.	I.D. REMOVED BLANKET AS "SCRAP". (REMOVED	233		
	FOR TPS PLBD-3-04-003.) ROUTE SCRAP	3/8/85		
	BLANKET TO LOGISTICS.			
3.	RESUBMIT TO TPS ENG. FOR FURTHER DISPOSITION/			
	INSTALLATION INSTRUCTIONS.			
	LSOC SYS: C K ~~3-8-85~~			
	LSOC QE: 3-8-85			

9. CLOSURE

KSC FORM 2-155 (REV. 3/82)

ORIGINAL