

PROBLEMS CONTRIBUTING TO SCHEDULE REVISIONS

INSULATION

STRUCTURAL REWORK REQUIREMENTS INDICATED BY 'T'
TEST PROGRAM

ASSEMBLY WELDING OFFSET PROBLEM

ENGINEERING CHANGES

MATERIAL REVIEW ACTIONS

SLIDE 14. PROBLEMS CONTRIBUTING TO SCHEDULE REVISIONS

and one of Tedlar that comprise this blanket that has to be bonded onto the stage. We use a resin glue that we bake on in an oven at about 350°. We first have to put it on the quarter panels. These are major segments of the tank. Then we weld these quarter panels into a ring, and we weld the rings into the complete stage. Then we have to go back and put strips in to close out over the welds, and this requires more bonding. Originally, we had this material subcontracted out to a number of suppliers—Eldon Plastics, for one. We didn't exercise sufficient in-process control over these suppliers and, as a result, we got some material that was below standards. We put this material on the stage. During tanking, we purge with helium gas under pressure to insulate the hydrogen from the outside ambient air; and under this pressure, about four pounds per square inch, we found the insulation failing. It would just rip, pieces would break off or a hole would appear. We would have to repair it and pump it up again and some more would break off. And we went on fighting this insulation repair for months and months. Finally we pulled all