

STANFORD UNIVERSITY
W.W. HANSEN EXPERIMENTAL PHYSICS LABORATORY
GRAVITY PROBE B, RELATIVITY GYROSCOPE EXPERIMENT
STANFORD, CALIFORNIA 94305-4085

**REPLACING SEALING PLATE IN 2.5” VALVES
GPB ENGINEERING PROCEDURE**

P0717

July 19, 2000

PREPARED _____
A. Halevy , GMA Engineer Date

APPROVED _____
G. Asher, GMA REE Date

APPROVED _____
D. Ross, Quality Assurance Date

APPROVED _____
B. Muhlfelder, Hardware Manager Date



TABLE OF CONTENTS

TABLE OF CONTENTS 3

1. GENERAL DESCRIPTION 4

2. TEST INFORMATION..... 4

2.2 Cleanliness..... 4

2.4 Personnel, QA, and Documentation..... 4

2.5 Red-line Authority 5

3. DOCUMENTS AND EQUIPMENT 6

3.1 Applicable Documents..... 6

3.2 Test Equipment 6

4. CHANGING SEALING PLATE 6

6. PROCEDURE COMPLETION 7

7 DATA BASE ENTRY 7

1. GENERAL DESCRIPTION

This procedure describes the replacement of sealing plates in **flight** vatterfly valves V1, V2, V3, V4 and V5 (Howden drawing #3179) in order to have a vulcanized sealing other than the O ring type sealing.

2. TEST INFORMATION

- Proper care should be taken in handling components, and their cleanliness must be preserved.
- Temperature: Room temperature
- Humidity: not critical

2.2 Cleanliness

2.2.1 Normal lab environment when components are double bagged.

2.2.2 Class 1000 Clean Room, on laminar flow working table.

2.3 ESD precautions

2.3.1 None required.

ONR representative, and QA to be notified 24 hours prior to beginning this procedure

2.4 Personnel, QA, and Documentation

2.4.1 Personnel Integration and Test Director

The Integration and Test Director (ITD) shall be Aaron Halevy or an alternate that he shall designate. The ITD has overall responsibility for the implementation of this procedure and shall sign off the completed procedure and relevant sections within it. The GMA REE shall also sign off the completed “As-Built” procedure.

Integration Engineers and other personnel. All engineers and technicians participating in this procedure shall work under the direction of the ITD who shall determine personnel that are qualified to participate in this procedure. Participants in this procedure are to be C. Warren and A. Halevy.

The test shall be conducted on a formal basis to approved and released procedures. The QA program office shall be notified of the start of this procedure. A Quality Assurance Representative, designated by D. Ross shall be present during the procedure (if deemed

necessary) and shall review any discrepancies noted and approve their disposition. Upon completion of this procedure, the QA Manager, D. Ross or her designate, shall certify their concurrence that the effort was performed and accomplished in accordance with the prescribed instructions by signing and dating in the designated place(s) in this document. Discrepancies will be recorded in a D-log or as a DR per Quality Plan P0108. If a re-test of any or all of the hardware is necessary, the ITD will determine the appropriate changes in the procedure, with the QA Manager's approval.

2.5 Red-line Authority

Authority to red-line (make minor changes during execution) this procedure is given solely to the ITD or his designate, or the GMA Manager, and shall be approved by QA. Additionally, approval by the Hardware Manager shall be required, if in the judgment of the ITD or QA Representative, experiment functionality may be affected.

To conveniently record data directly into the procedure thus generating the "as-built" document, the procedure will be handled, if possible, in a paperless fashion until completed. A Laptop computer containing an electronic version of this procedure will be operated by the ITD or QA Representative and data shall be recorded by typing directly into the electronic file. Alternatively, an "As-Built" may be created after-the-fact from hand written notes in the approved procedure.

Following completion of the procedure and the creation of an edited electronic copy, a hard copy of the "As-Built" procedure shall be printed and *signed off by all the designated parties*. It shall then be filed, including an electronic copy into the data base.

The electronic editing of this document shall be as follows:

Data will be inserted into the document using normal font, i.e. non-bold, non-italic

- "Signatures" shall be designated by **BLACK CAPITAL BOLD LETTERS**.
- "Redlines" shall be in **RED BOLD ITALICS** to make them distinguishable in computer and on the hard copy printout.
- If available, digital pictures shall be inserted into the document where appropriate.

3. DOCUMENTS AND EQUIPMENT

3.1 Applicable Documents

Howden drawing #3179

3.2 Test Equipment

Equipment	Model and Serial Number	Calibration
scriber		
Set of fine pliers		
tweezers		
Control box		

4. CHANGING SEALING PLATE

Started on: _____

- 4.1 Notify QA & ONR 2 hours prior to start of operation.
- 4.2 Open the valve to fully open position. Adjust the clearance between bushing (13) and (18) to approx. 0.1 mm by adjusting item (9) and (46). Make sure to tighten item (9) and (46) properly.
- 4.3 Document cycling of each valve in valve's cycle log and on the table below.

Valve #1: Cycles	
Valve #2: Cycles	
Valve #3: Cycles	
Valve #4: Cycles	
Valve #5: Cycles	

- 4.4
- 4.5 Fine scribe the exposed bushing area (13) to mark it's position.
- 4.6 Remove one circlip (33) from pin (15), and take away pin (15) with the other circlip.
- 4.7 Remove bushings (14).

- 4.8 Slide bushing 13 out of the stem.
- 4.9 Use clean adhesive tape to protect the fork of the plate holder from scratching the sealing area.
- 4.10 Rotate the sealing plate 180 degrees from it's original position, open 4 nuts (45), remove the sealing plate be careful not to loose the 4 washers (47) beneath the plate.
- 4.11 Place the original sealing plate (not with the O ring), do not forget the 4 washers (47) between the plate (7) and the plate holder. Center the sealing plate by eye, and tighten nuts (45).
- 4.12 Bring the sealing plate to its original position, slide bushing 13 to its location use the scribe for the right positioning.
- 4.13 Bring the sealing plate to the open position, make sure that the cam is also in the open position.
- 4.14 Slide bushings (14), using your finger to stop their falling from the other side.
- 4.15 Insert pin (15) with one circlip (33).
- 4.16 Secure the assembly by locking the other circlip (33).
- 4.17 Check again the 0.1 mm gap.
- 4.18 Final centering the valve sealing plate. The plate shouldn't touch the valve body during opening and closing. It is most important that the plate does not touch the body on the side opposite the bellow. It is less critical if the plate should touch the body on the side of the bellow in the open position. During opening of the valve there should be a clearance of 0.2-0.3 mm between the plate seal and the valve body on the side opposite to the bellow, you can change the position of the valve plate after loosening the 4 nuts (45) and by carefully moving the plate with. Tighten the 4 nuts properly.
- 4.19 Stake the nuts, according to P0499.

6. PROCEDURE COMPLETION

7 DATA BASE ENTRY

The following data shall be entered into the GP-B Data base:

- Name, number and revision of this procedure
- Date of successful completion of procedure.

- Part numbers and serial numbers of Vatterfly valve and their components