PAYLOAD SAFETY AND MISSION SUCCESS CONFERENCE 2004

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FASTENER LOCKING REQUIREMENTS FOR JSC FLIGHT HARDWARE

REQUIREMENTS FOR SAFETY CRITICAL FASTENERS IN SPACEFLIGHT HARDWARE

- FASTENERS SHALL HAVE TWO SEPARATE VERIFIABLE LOCKING FEATURES. AT LEAST ONE FEATURE SHALL BE POSITIVE LOCKING AND VIBRATION RATED. JOINT PRELOAD MAY BE USED AS ONE OF THE FEATURES.

- JOINTS SUBJECT TO ROTATION SHALL USE AT LEAST ONE NON-FRICTION LOCKING DEVICE. (EX: COTTER PINS, LOCKWIRE)

- INSTALLATION PROCEDURES SHALL REQUIRE FUNCTIONAL VERIFICATION OF LOCKING FEATURE, SUCH AS MEASUREMENT OF RUNNING (SELF LOCKING) TORQUE

- PRELOAD AND RUNNING (SELF LOCKING) TORQUE SHALL BE SPECIFIED ON THE DRAWING.
REQUIREMENTS FOR SAFETY CRITICAL FASTENERS IN SPACEFLIGHT HARDWARE (CONTD.)

- EXAMPLES OF APPROVED FRICTION TYPE LOCKING METHODS ARE LOCKING HELICOILS, LOCKING KEE-INSERTS, SLIMSERTS (THIN WALLED INSERTS), LOCKNUTS, NUTPLATES, SELF LOCKING PATCHED SCREWS ETC. LOCKWASHERS ARE NOT APPROVED.

- EXAMPLE OF NON-FRICTION TYPE LOCKING DEVICE IS LOCKWIRE OR SAFETY WIRE.

- LOCKING COMPOUNDS (EX: VIBRATITE OR LOCTITE) SHALL NOT BE USED WITHOUT PRIOR APPROVAL FROM JSC STRUCTURAL ENGINEERING DIVISION.

- JSC 27301 REVISION D (MATERIALS CONTROL PLAN FOR JSC FLIGHT HARDWARE), SECTION 5.6.5.1 DOCUMENTS THESE REQUIREMENTS (ATTACHED). THESE REQUIREMENTS ARE APPLICABLE TO ALL JSC FLIGHT HARDWARE (GFE AND JSC FURNISHED PAYLOADS).
IMPLEMENTATION OF THE REQUIREMENTS

- JSC GOVERNMENT FURNISHED EQUIPMENT (GFE) AND JSC FURNISHED PAYLOADS FALL UNDER THE SCOPE OF THESE REQUIREMENTS

- ISS M&P TEAM IS CURRENTLY DRAFTING AN INTERPRETATION LETTER IN ADVANCE OF PROGRAM CHANGES TO SSP 30233, REVISION F (ISS M&P REQUIREMENTS DOCUMENT)

- THE PAYLOAD SAFETY REVIEW PANEL HAS DEVELOPED A POLICY LETTER TO IMPLEMENT THESE REQUIREMENTS, WHICH IS CURRENTLY UNDER REVIEW CYCLE
KEY DEFINITIONS

- SAFETY CRITICAL FASTENERS: DEFINED AS THOSE FASTENERS, FAILURE OF WHICH COULD POTENTIALLY RESULT IN A CRITICAL OR CATASTROPHIC HAZARD DUE TO JOINT SEPERATION OR RELEASE OF DEBRIS (THAT CAUSES CONTAMINATION, CREW INJURY, ELECTRICAL SHORT OR A FIRE PROPAGATION HAZARD). HAZARDOUS DEBRIS NEEDS TO BE DEFINED BY SAFETY ENGINEERING DISCIPLINE.

- SELF LOCKING (RUNNING) TORQUE: THE TORQUE REQUIRED TO OVERCOME KINETIC FRICTION OF THE MATING THREADS PLUS THE TORQUE REQUIRED TO OVERCOME THE LOCKING FEATURE WHEN 100 PERCENT OF THE LOCKING FEATURE IS ENGAGED AND THE FASTENER IS UNSEATED. CAN BE MEASURED IN A LOOSENING OR TIGHTENING DIRECTION.

- POSITIVE THREAD LOCKING DEVICE: MECHANICAL DEVICE USED TO PREVENT RELATIVE MOTION BETWEEN MALE AND FEMALE THREADS OF A FASTENED JOINT. POSITIVE thread locking is one that can be verified by visual inspection of non-friction locking devices or measurement of running torque for self locking devices.
LOCKING HELICOILS – DESIGN GUIDELINES

- THIS IS A PRECISION COIL OF DIAMOND SHAPED CRES 300 WIRES THAT FORMS BOTH EXTERNAL AND INTERNAL THREADS. COIL SLIGHTLY Oversized TO HAVE INTERFERENCE FIT IN TAPPED HOLE. SOME INSERTS ARE AVAILABLE WITH DEFORMED COIL WHICH HELPS PROVIDING SECONDARY LOCKING TO BOLTS AND SCREWS WITH A POSITIVE AND MEASURABLE SELF LOCKING (RUNNING) TORQUE.

- IT SHOULD BE ALWAYS VERIFIED THAT THE RUNNING TORQUE PROVIDED BY THE LOCKING FEATURE IS BETWEEN THE MAX. LOCKING TORQUE AND THE MINIMUM BREAKAWAY TORQUE SPECIFIED IN TABLE II OF NASM 8846. VERIFICATION NOTE IS STANDARD ON JSC DRAWINGS PER PRC 9007.

- NASM 8846 IS PROCUREMENT SPECIFICATION. AEROSPACE QUALIFIED PART NUMBER FOR LOCKING HELICOILS IS NASM 21209XX-XXL. THE “L” AT THE SUFFIX INDICATES DRY FILM LUBRICATED. RECOMMENDATION IS TO ALWAYS USE DRY FILM LUBRICANT TO AVOID BINDING.
LOCKING HELICOILS – DESIGN GUIDELINES (CONT'D.)

- RECOMMENDED TO USE CAUTION WHEN USING HELICOILS IN JOINTS THAT ARE PRE-LOAD CRITICAL. THESE ARE JOINTS THAT ARE SENSITIVE TO GAPPPING. HIGH PRE-LOAD SOMETIMES LEADS TO BINDING OF THREADS, IF IT IS NOT PROPERLY LUBRICATED.

- IT IS BETTER TO USE HELICOILS IN A BLIND HOLE RATHER THAN A THROUGH HOLE. IF USED IN THROUGH HOLE, IT IS ESSENTIAL TO INSPECT BACK SIDE OF HELICOIL AFTER EACH FASTENER INSTALLATION.

- IN VERY CORROSIVE ENVIRONMENT, CAUTION SHOULD BE USED WHEN USING HELICOILS. APPLICATION OF CORROSION PROTECTION SEALANT IS A TRICKY PROCESS IN HELICOILS. EXCESSIVE SEALANT GOES THROUGH COILS AND MAY AFFECT RUNNING TORQUE MEASUREMENT. TOO LESS SEALANT DOES NOT SERVE CORROSION PROTECTION FUNCTION.

- IT IS RELATIVELY EASIER TO REPLACE HELICOILS AND RE-INSTALL COMPARED TO KEY LOCKED INSERTS
LOCKING HELICOILS – DESIGN GUIDELINES (CONT'D.)

- HELICOILS WORKS BEST FOR RELATIVELY SMALL SIZE SCREWS (GUIDELINE FOR USE OF HELICOIL IS #10 AND SMALLER), WHICH ARE UNDER SMALL TENSION LOADS. FOR LARGER SIZE AND HEAVY DUTY TENSION BOLTS, USE OF KEE-INSERT IS RECOMMENDED.

- LENGTH OF HELICOIL SHOULD BE AT LEAST 1.5 D, WHERE THE "D" IS THE DIAMETER OF THE BOLT. LESS THAN 1.5D LENGTH MAY RESULT IN SHEARING OF THE THREADS AND BACK-OFF OF THE HELICOIL.

- RECOMMENDED TO USE HELICOILS IN ALUMINUM STRUCTURE. IT EXPANDS BETTER IN ALUMINUM AND HELD BY FRICTION. WE HAVE ENCOUNTERED PROBLEMS INSTALLING HELICOILS IN STEEL STRUCTURES. HELICOIL COMPANY RECOMMENDS A SPECIAL TiN COATED TAP FOR STEEL.

- INSTALLATION OF HELICOILS REQUIRES BREAKING THE TANGS. CAUTION SHOULD BE TAKEN SUCH THAT THE TANGS ARE NOT LEFT INSIDE THE HARDWARE. THIS MAY CREATE A SAFETY OR FUNCTIONALITY PROBLEM.
LOCKING HELICOILS—DESIGN GUIDELINES (CONT'D.)

- THERE IS NO FIXED CYCLE LIFE FOR HELICOILS. THE ONLY WAY TO DETERMINE IF A HELICOIL LOCKING FEATURE HAS WORN OUT IS BY MEASURING THE RUNNING TORQUE DURING EVERY SINGLE BOLT INSTALLATION AND VERIFYING THAT IT MEETS NASM 8846 REQUIREMENTS.
KEY LOCKED INSERTS AND THINWALLED INSERTS

• THESE ARE INSERTS WHICH HAVE A SELF LOCKING FEATURE SIMILAR TO THE HELICOILS TO PROVIDE POSITIVE LOCKING TO THE FASTENER. THE KEY LOCKED INSERTS HAVE AN ADDITIONAL FEATURE OF LOCKING KEYS (USUALLY FOUR) THAT LOCK THE INSERT INSIDE THE HOLE. RUNNING TORQUE VALUES ARE SPECIFIED IN MIL-I-45914, TABLE 1.

• BEST INSERT FOR HEAVY DUTY STRUCTURAL TENSION BOLTS. RECOMMENDED FOR FRACTURE CRITICAL BOLTS. HELICOILS ARE NOT RECOMMENDED FOR FRACTURE CRITICAL (SINGLE POINT FAILURE) BOLTS.

• SOLID INSERTS, SO APPLICATION OF CORROSION PROTECTION SEALANT IS NOT AS TRICKY AS HELICOILS. HENCE, USE IN SEVERE CORROSIVE ENVIRONMENTS IS NOT A PROBLEM, IF PROPER SEALANT IS APPLIED.

• TYPICAL EXAMPLE OF MIL. STANDARD KEY LOCKED INSERTS ARE MS 51830 THRU MS 51832.
KEY LOCKED INSERTS AND THINWALLED INSERTS

- THINWALLED INSERTS OR "SLIMsert" ARE SOLID INSERTS LIKE KEE-INSERTS, BUT WHICH DO NOT HAVE KEYS FOR LOCKING INTO THE TAPPED HOLE. INSTEAD, THEY HAVE A CYLINDRICAL SHOULDER ON THE TOP WHICH IS SWAGED INTO THE PARENT METAL WITH A TOOL. THIS SWAGING ACTION LOCKS THE INSERT INTO THE HOLE.

- AVAILABLE FROM ROSAN INCORPORATED, NEWPORT BEACH, CALIFORNIA. PROCUREMENT SPECIFICATION IS MIL-I-45932. RUNNING TORQUE VERIFICATION PER TABLE 1 OF SPEC. TYPICAL PART NO. IS M45932/1-9CL

- ADVANTAGES OVER KEY-LOCKED INSERTS ARE A) LIGHTER IN WEIGHT B) CAN BE USED IN JOINTS WHICH REQUIRE LESS EDGE DISTANCE. KEE-INSERTS REQUIRE HIGHER EDGE DISTANCE.

- AVAILABLE WITH SILVER PLATED FINISH WHICH ACTS AS A LUBRICANT AND PROVIDES MAXIMUM CYCLE LIFE. KEY LOCKED INSERTS ARE ONLY AVAILABLE WITH DRY FILM, WHICH IS NOT AS GOOD AS SILVER PLATING FOR CYCLE LIFE.
CORRECT METHOD FOR CALLING OUT INSTALLATION DIMENSIONS FOR SLIMSERT INSERTS ON DRAWINGS

MACHINING INFORMATION

FOR (PART NO. FOR MONUMENT INSTALLATION)

SLOTS  DIA. X DEEP

CRUCES  DIA. X DEEP

PARALLELS AT A CIRCLE 1/32" (0.0081") MIN.

TAP MIN PULL THRU

NOTES:

1. CORRECTLY BORED HOLES MUST AND MUST NOT BE IN THE PATH OF TOOL WAYS.

2. THE PULL IS TO BE CONSIDERED TO DETERMINE THE TOLERANCE OF INTERNAL HOLES.

3. PULLS MUST BE SHOWN ON THE DRAWINGS OF THE PARTS TO BE INSERTS FOR INSTALLATION.

INSTALLATION INFORMATION

A. THE INSERT IS INSERTED AND SUED IN ITS ENDS AND INSERTED UP TO A PROPER HEIGHT.

B. THE PARTS MUST BE PREPARED TO INSERT THE INSERTS IN THE PARTS.

C. ACHIEVED INSERTS MUST BE INSERTED UP TO A PROPER HEIGHT.

D. THE INSERT IS INSERTED UP TO A PROPER HEIGHT.

NOTES:

1. BE CAREFUL IN THE PARTS TO AVOID DISTORTION IN THE ORIENTATION OF THE PARTS.

2. ALL INSERTS ARE INTERCHANGEABLE WITH M45932/1 INSERTS.

SLIMSERTS
KEY LOCKED INSERTS AND THINWALLED INSERTS

- SILVER PLATING – BEST SURFACE FINISH FOR HIGH CYCLE LIFE OF INSERTS, NUTS ETC. HOWEVER, SILVER PLATING SHOULD NOT BE USED IN CONFIGURATIONS WHERE PLATING IS EXPOSED TO EVA EXTERNAL ENVIRONMENTS. DUE TO DEGRADATION BY AO/VUV RESULTS IN A LOOSE FRIABLE BLACK OXIDE AND RESULTANT CONTAMINATION.

- SLIMSETS ARE MORE SUITED FOR LIGHT WEIGHT STRUCTURES WHEREAS KEY LOCKED ONES FOR HEAVY DUTY STRUCTURES. FOR LIGHTWEIGHT STRUCTURES, SLIMSETS ARE PREFERRED OVER HELICOILS.
SELF LOCKING SCREWS AND BOLTS

- THESE ARE FASTENERS WHICH HAVE SELF LOCKING THREADS OR SELF LOCKING FEATURES BY MEANS OF A PLASTIC MATERIAL LOCKING ELEMENT CONTAINED IN THE SCREW. THE DESIGN OF THE LOCKING ELEMENT SHOULD MEET THE REQUIREMENTS OF MIL-DTL-18240F. THE DESIGN AND USAGE LIMITATIONS FOR SELF LOCKING EXTERNALLY THREADED FASTENERS ARE IDENTIFIED IN MILITARY SPECIFICATION MS 15981.

- EXAMPLES OF OFF THE SHELF SELF LOCKING SCREWS ARE THE FOLLOWING:
  (A) NAS 6703 THRU 6720
  (B) NAS 8100 THRU 8106
  (C) NAS 600 THRU 606
  (D) NAS 1189, NAS 1351
SELF LOCKING SCREWS AND BOLTS (CONT'D.)

- IN CASES WHERE FASTENERS WITH SELF LOCKING ELEMENTS ARE NOT READILY AVAILABLE, NASA-JSC STRUCTURAL ENGINEERING DIVISION RECOMMENDS THE USE OF THE FUSED MYLAR (POLYETYLENE TETRAPHTHALATE) PATCH. THIS TYPE OF PATCH HAS TEMPERATURE LIMITATIONS OF AROUND +400F. KEL-F, VESPEL PATCHES ARE OTHER OPTIONS WHICH HAVE WIDER OPERATING TEMPERATURE LIMITS, HOWEVER CYCLE LIFE AND DURABILITY OF THE PATCH IS LOWER THAN MYLAR. NYLON PATCH ALSO HAS LOWER CYCLE LIFE THAN MYLAR.

- MYLAR PATCH APPLICATION PROCESS: THE BOLT IS NORMALLY HEATED UP TO 500F TO 700F (DEPENDING ON BOLT MATERIAL), THE POLYESTER (MYLAR) IS THEN FUSED ON TO THE BOLT AND THEN IT IS QUENCHED.

- NASA-JSC HAS HAD GOOD EXPERIENCE WITH LONG LOK FASTENERS AND NYLOK CORPORATION FOR APPLYING PATCH ON EXISTING FASTENERS. ANY COMPANY LISTED UNDER THE QPL-18240 IS QUALIFIED TO PERFORM THE PATCH APPLICATION PROCESS
SELF LOCKING SCREWS AND BOLTS (CONT'D.)

- IN FRACTURE CRITICAL APPLICATIONS, PLASTIC PATCHES SHOULD NOT BE USED WITH HELICOILS. THIS IS DUE TO BINDING PROBLEMS THAT ARE ENCOUNTERED SOMETIMES WITH USING PATCHES ON HELICOILS. BINDING MAY BE REDUCED BY APPLYING GREASE, BUT THIS REDUCES THE RUNNING TORQUE AND LOCKING EFFICIENCY. ALSO, WHEN APPLYING GREASE, INSTALLATION TORQUE NEEDS TO BE REDUCED TO ACCOUNT FOR LOWER FRICTION FACTOR.

- PLASTIC PATCHES CAN BE SAFELY USED WITH SOLID INSERTS LIKE KEE-INSERTS AND SLIMINSERTS.

- DUE TO EXPERIENCE WITH INCONSISTENCIES IN QUALITY OF THE PATCHED SCREWS, WE RECOMMEND DOING BATCH TESTING ON THESE TYPE OF SCREWS TO MEASURE RUNNING TORQUE.

- WHEN SENDING SCREWS TO LONG-LOK CORP. FOR PATCH APPLICATION, IT IS RECOMMENDED TO SEND THEM A SPARE ENGINEERING UNIT OF THE HARDWARE INTO WHICH THE SCREW IS INSTALLED. THISENSURES PROPER QUALITY OF PATCH RESULTING IN ADEQUATE RUNNING TORQUE.
LOCKNUTS

- THESE ARE TYPES OF LOCKING ELEMENTS WHICH ACT ON THE PRINCIPLE OF BINDING THE NUT THREAD TO THE BOLT

- SILVER PLATED LOCKNUTS ARE COMMONLY USED IN SPACEFLIGHT HARDWARE FOR IMPROVED DURABILITY AND CYCLE LIFE. HOWEVER, IN EVA HARDWARE, SILVER PLATED LOCKNUTS SHOULD NOT BE USED DUE TO AO/VUV DEGRADATION PROBLEMS.

- DESIGN GUIDELINES AND USAGE LIMITATIONS ARE PROVIDED IN MIL. STANDARD MS 33588. EXAMPLES OF LOCKNUTS ARE: (A) NAS 1291 (B) MS21043 (C) MS21045 (D) MS21046. PROCUREMENT SPEC. IS NASM 25027

- NO MAJOR LIMITATIONS TO BE NOTED, EXCEPT CYCLE LIFE OF THE LOCKING FEATURE WHICH NEEDS TO BE MEASURED AND VERIFIED AGAINST SPEC. DURING EACH INSTALLATION. ALSO LOCKNUTS WITH SILVER PLATING OR ADEQUATE LUBRICATION SHOULD BE USED
LOCKING ADHESIVES – LOCTITE

- LOCTITE SHOULD NOT BE USED WITHOUT PRIOR APPROVAL FROM THE JSC STRUCTURAL ENGINEERING DIVISION ON A CASE BY CASE BASIS

- LOCTITE IS A SINGLE COMPONENT ANAEROBIC (CURSES IN ABSENCE OF AIR) THREADLOCKING MATERIAL. THE BASIC POLYMER TYPE IS DIMETHACRYLATE ESTER. LOCTITE CURES IN PLACE BETWEEN THE THREADS.

- LOCTITE IS QUALIFIED TO MIL-S-46163A. PREVAILING AND BREAKING TORQUE VALUES ARE AS SPECIFIED IN TABLE 3 OF THIS MILITARY SPECIFICATION (ATTACHED). HOWEVER, THESE VALUES ARE APPLICABLE FOR A 3/8 INCH. HEX. HEAD BOLT ONLY. BREAKING TORQUE VALUES ARE NOT AVAILABLE FOR ALL SIZES OF FASTENERS FROM THE SPECIFICATION. HENCE, THERE IS NO DIRECT WAY OF VERIFYING THAT LOCTITE WILL FUNCTION FOR ANY GIVEN FASTENER SIZE IN A PARTICULAR APPLICATION.
### TABLE III - Locking torque of unpolymerized sealing compounds

<table>
<thead>
<tr>
<th>Type and Grade</th>
<th>Locking torque a/, inch-pounds (newton-metres)</th>
<th>Steel Breakaway</th>
<th>Steel Prevail</th>
<th>Plated Breakaway</th>
<th>Plated Prevail</th>
</tr>
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<tbody>
<tr>
<td><strong>Type I</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Grade J</td>
<td>100-200 (11.3-22.6)</td>
<td>50-150 (5.65-16.9)</td>
<td>50-150 (5.65-11.3)</td>
<td>50-150 (5.65-16.9)</td>
<td></td>
</tr>
<tr>
<td>Grade K</td>
<td>200-300 (22.6-33.9)</td>
<td>250-350 (28.2-39.5)</td>
<td>50-100 (5.65-11.3)</td>
<td>200-300 (22.6-33.9)</td>
<td></td>
</tr>
<tr>
<td>Grade L</td>
<td>250-350 (28.2-39.5)</td>
<td>200-300 (22.6-33.9)</td>
<td>50-100 (5.65-11.3)</td>
<td>100-200 (11.3-22.6)</td>
<td></td>
</tr>
<tr>
<td><strong>Type II</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>Grade M</td>
<td>50-100 (5.65-11.3)</td>
<td>20-50 (2.26-5.65)</td>
<td>10-40 (1.13-4.52)</td>
<td>10-40 (1.13-4.52)</td>
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</tr>
<tr>
<td>Grade N</td>
<td>100-200 (11.3-22.6)</td>
<td>30-60 (3.39-6.78)</td>
<td>20-120 (2.26-13.6)</td>
<td>20-50 (2.26-5.65)</td>
<td></td>
</tr>
<tr>
<td>Grade O</td>
<td>150-250 (16.9-28.2)</td>
<td>50-150 (5.65-16.9)</td>
<td>50-150 (5.65-16.9)</td>
<td>50-150 (5.65-16.9)</td>
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</tr>
<tr>
<td><strong>Type III</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Grade P</td>
<td>20-100 (2.26-11.3)</td>
<td>20-100 (2.26-11.3)</td>
<td>20-100 (2.26-11.3)</td>
<td>10-50 (1.13-5.65)</td>
<td></td>
</tr>
<tr>
<td>Grade Q</td>
<td>20-100 (2.26-11.3)</td>
<td>100-200 (11.3-22.6)</td>
<td>20-100 (2.26-11.3)</td>
<td>20-100 (2.26-11.3)</td>
<td></td>
</tr>
<tr>
<td>Grade R</td>
<td>20-100 (2.26-11.3)</td>
<td>200-350 (22.6-39.5)</td>
<td>10-50 (1.13-5.65)</td>
<td>120-300 (13.6-33.9)</td>
<td></td>
</tr>
</tbody>
</table>

a/ 3/8-inch (9.525-mm) bolt (see 4.6.2.1.2)

MIL-S-46163 – TABLE 3
LOCKING ADHESIVES – LOCTITE

• THERE IS NO VIBRATION TEST REQUIREMENT IN THE MIL-S-46163. THERE IS REFERENCE TO SOME VIBRATION DATA IN LOCTITE LITERATURE. ALL OTHER AEROSPACE TYPE SECONDARY RETENTION METHODS (PATCH, LOCKNUTS ETC.) HAVE VIBRATION TEST REQUIREMENTS IN THE RESPECTIVE PROCUREMENT SPECIFICATION.

• THE LOCKING FEATURE IS NOT VERIFIABLE BECAUSE ONCE IT IS CURED, IT CANNOT BE VERIFIED WITHOUT BREAKING THE BOND. IT CANNOT BE CLASSIFIED AS A VERIFIABLE POSITIVE LOCKING FEATURE. HENCE, USE OF LOCTITE (OR ANY OTHER LOCKING COMPOUND) DOES NOT MEET THE REQUIREMENT OF JSC 27301D (MATERIALS CONTROL PLAN).

• LOCTITE FREQUENTLY HAS CURING PROBLEMS. PROPER APPLICATION PROCEDURE NEEDS TO BE FOLLOWED ALONG WITH USE OF PRIMER. PROPER CURING DEPENDS ON THREAD TOLERANCES, PRIMER, CURE TIME, BASE METAL ETC.
LOCKING ADHESIVES – LOCTITE

- GOOD PROCESS STEPS TO FOLLOW: A) SURFACE PREPARATION OR CLEANING B) PRIMER APPLICATION ON BOTH MALE AND FEMALE THREADS C) APPLICATION OF LOCTITE (WHICHEVER GRADE IS SPECIFIED ON DWG.) TO THE MALE THREAD OR BOTH MATING THREADS D) TORQUE THE FASTENER TO ENGINEERING DRAWING TORQUE CALL-OUT. E) WIPE OFF EXCESS LOCTITE ON SURFACE WITH LINT FREE CLOTH.

- PROCESS VERIFICATION: NO STANDARD PRACTISE OF PROCESS VERIFICATION IS PUBLISHED.

LOCKING ADHESIVES – LOCTITE

- MEASURE THE BREAKLOOSE TORQUE AS PART OF THE VERIFICATION TEST. IF THE CORRECT LOCTITE COMPOUND IS USED, THE BREAKLOOSE TORQUE OF THE JOINT SHALL BE AT LEAST EQUAL TO THE TIGHTENING TORQUE. (REFERENCE: LOCTITE CORPORATION LITERATURE ATTACHED). AFTER JOINT IS BROKEN, INSPECT BOLT THREADS FOR ANY UNCURED LOCTITE BY WIPING WITH A CLOTH.

- PROCESS VERIFICATION MAY ALSO BE CARRIED OUT ON A 3/8" BOLT AS SPECIFIED IN SECTION 4.6.2.1 OF MIL-S-46163A. THE BREAKAWAY TORQUE SHALL BE WITHIN THE RANGE SPECIFIED IN TABLE 3 OF THE SPECIFICATION, CORRESPONDING TO THE GRADE OF LOCTITE USED.

- ALL THE ABOVE VERIFICATION METHODS ARE RECOMMENDATIONS FROM LOCTITE LITERATURE AND HAS SELDOM BEEN FOLLOWED AS A STANDARD PROCESS FOR JSC FLIGHT HARDWARE. HENCE, M&P DISCOURAGES USE OF LOCTITE COMPOUNDS IN FLIGHT HARDWARE.

- IT IS RECOMMENDED THAT QUALIFICATION OF LOCTITE FOR EACH UNIQUE FLIGHT HARDWARE APPLICATION BE PERFORMED AND MAY INCLUDE VIBRATION AND THERMAL CYCLE TESTING.
FASTENER RETENTION
REQUIREMENTS AND PRACTICES IN
SPACEFLIGHT HARDWARE

Augmentation

Breaking torque of an UNC bolt will be about 73% of the
breaking torque which it has been tightened (UNF = 50%)

The amount of a thread locking compound added to a bolt is called the torque augmentation. This is shown in the shaded
area in Fig. 19.

The torque value of augmentation is related to the breaking "
torque and may vary between 75 to 140% of the breaking.

Upon structural fasteners are torqued to at least 75% of their
minimum yield strength (Grade 5). To prevent shearing of a
brazed bolt while being loosened, a locking material should be
used which has an augmentation or breaking torque that would make
the breaking torque roughly equal to the tightening torque.

The torque, as a design tool to prevent shearing on loosening,
must be material to:

3. < < 0.5 x Bolt Rate: Torque

To find the correct locking taper, refer to the charts Fig. 17
and 18 with 30% of the bolt tightening torque

Selection of Materials for Loosening Severity

Loosening: Loosening of threads always starts from the sides of
the engaged threads. The side motion is caused by -
mechanical forces from applied loads or thermal expansion.

As a matter of fact, the failure of a bolt from longitudinal force or vibration,

is a point usually prevented by proper tightening of the bolt but
brazing condition can only be prevented by filling the
breaks completely Fig. 20 shows the relative effectiveness
of thread locking means to retain the bolt tension under
me side loading (transverse shock and vibration)

D. Selection of Viscosity to Assure Thread Filling

Select a viscosity which will apply easily, not run off, and will fill
threads which have the maximum clearance (maximum clearance
is computed from tables of standard UNC thread dimensions).

<table>
<thead>
<tr>
<th>Material</th>
<th>Viscosity</th>
<th>Suggested Bolt Range</th>
<th>Maximum Diameter Clearance</th>
</tr>
</thead>
<tbody>
<tr>
<td>222</td>
<td>1000 cP</td>
<td>2 to 1/4&quot;</td>
<td>.316 in (8.0 mm)</td>
</tr>
<tr>
<td>24 2</td>
<td>1500 cP</td>
<td>3 to 1/2&quot;</td>
<td>.322 in (8.0 mm)</td>
</tr>
<tr>
<td>26 2</td>
<td>2000 cP</td>
<td>4 to 1&quot;</td>
<td>.329 in (8.0 mm)</td>
</tr>
<tr>
<td>26 3</td>
<td>2500 cP</td>
<td>5 to 1 1/4&quot;</td>
<td>.335 in (8.0 mm)</td>
</tr>
<tr>
<td>377</td>
<td>750 cP</td>
<td>6 to 1 1/2&quot;</td>
<td>.350 in (8.0 mm)</td>
</tr>
<tr>
<td>377</td>
<td>1000 cP</td>
<td>7 to 1 1/2&quot;</td>
<td>.355 in (8.0 mm)</td>
</tr>
<tr>
<td>396</td>
<td>1250 cP</td>
<td>8 to 1 1/2&quot;</td>
<td>.370 in (8.0 mm)</td>
</tr>
</tbody>
</table>

*Loctite Primer T is recommended to assure cure in gaps. Ask
for Product Data Sheet 271 regarding these products.
LOCTITE

- LOCTITE GRADES COMMONLY USED IN JSC FLIGHT HARDWARE ARE
  (A) LOCTITE 222: REMOVABLE GRADE FOR UP TO 0.25” SCREWS.
  (B) LOCTITE 242: REMOVABLE GRADE FOR UP TO 0.75” BOLTS.
  (C) LOCTITE 262: PERMANENT LOCKING FOR UP TO 0.75” BOLTS.
VIBRATITE

- VIBRATITE SHOULD NOT BE USED WITHOUT PRIOR APPROVAL FROM THE JSC STRUCTURAL ENGINEERING DIVISION ON A CASE BY CASE BASIS. USE IS GENERALLY LIMITED TO NON-STRUCTURAL AND NON-SAFETY CRITICAL FASTENERS (EX: CONNECTOR SCREWS, AVIONICS BOXES), WHICH ARE LAUNCHED IN A LOCKER STOWED CONFIGURATION AND IN WHICH THE FASTENERS ARE NOT IN LOAD PATH OF LAUNCH VIBRATION OR ON-ORBIT VIBRATIONS.

- VIBRATITE IS A BLEND OF ACRYLIC RESINS AND PLASTICIZERS HELD IN LIQUID FORM BY A SOLVENT MEDIUM. IT DOES NOT REQUIRE ANAEROBIC CURE. PRE-APPLIED AND CURED BEFORE INSTALLING FASTENER. HENCE, DOES NOT BOND BETWEEN MATING THREADS.

- VIBRATITE HAS ACCEPTABLE VACUUM OUTGASSING VCM VALUES. OFFGASSING / TOXICITY PROPERTIES SIMILAR TO LOCTITE PRODUCTS.
LIMITATIONS OF VIBRATITE

- PREVAILING TORQUE OF VIBRATITE IS NOT VERIFIABLE. PERFORMANCE SPECIFICATION (MIL-S-28867) DOES NOT SPECIFY ANY VALUES OF BREAKING AND PREVAILING TORQUE. NOT QUALIFIED FOR VIBRATION ENVIRONMENT.

- MANUFACTURER DOES NOT RECOMMEND USE OF VIBRATITE FOR LARGER BOLTS (ABOVE ¼”). VIBRATITE IS NOT RECOMMENDED FOR LARGER SCREWS EVEN IN NON-STRUCTURAL AND NON-SAFETY CRITICAL APPLICATIONS.

- VIBRATITE IS SOMETIMES USED AS LUBRICANT TO INCREASE CYCLE LIFE OF LOCKING HELICOILS. NASA / JSC DOES NOT RECOMMEND THIS PRACTISE.