

ACIS Verification Summary Report

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| Specification: | ACIS Contract End Item Specification |
| Requirement Number/Title: | 3.3.4.2.2.1 Threaded Fasteners (VRSD 3.3.4.2.2.1) |
| Requirement Statement: Installation torque values for threaded fasteners shall be in accordance with MSFC-STD-486 and MSFC-STD-557, and secured in accordance with MSFC-STD-561. | |
| Verification Method: | Inspection and Validation of Records |
| Procedure Number: | |
| Configuration: | |
| Cycle Time: | |
| Verification Discussion/Results: | |
| <p>ACIS does not use any titanium alloy fasteners.</p> <p>Torquing of threaded fasteners is required on the assembly drawings. Torque values are listed on the assembly drawings. These torque values are in full conformance with MSFC-STD-486. All threaded fasteners are spot bonded after final torquing. The torque and spot bonding requirements are restated in the applicable assembly travelers. The operator sets the torque value on the torque wrench and the inspector checks the torque setting and calibration date. After fabrication, the assembly travelers are reviewed to insure all torque, spot bond, and inspection operations have been performed and signed by the responsible persons.</p> | |

Brian Klatt
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5/13/97
 Date