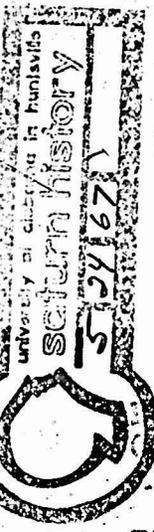


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PRIORITY

DATE

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(FWX)

5/25/67

15 May 67

DIRECTOR
ROBERT C. MARSHALL SPACE FLIGHT CENTER
MONTGOMERY, ALA.

DIRECTOR
KENNEDY SPACE CENTER
KENNEDY SPACE CENTER, FLORIDA

DIRECTOR,
MANNED SPACECRAFT CENTER
HOUSTON, TEXAS

INFO: NSPC/GEN. E. F. O'CONNOR (I-DIR)
NSPC/DR. A. RUDOLPH (I-V-MER)
NSPC/GEN. J. SHIRLEY (PA)
NSPC/G. LON (PA)

SUBJECT: INSPECTION OF WELDS ON S-II-1.

de-stacking

BASED ON THE RECOMMENDATIONS OF THE DIRECTOR, NSPC,
S-II-1 V PROGRAM MER, AND NAA SPACE DIVISION PRESENTED
AT THE EXECUTIVE SESSION AFTER THE NSP REVIEW ON MAY,
DESTACKING OF THE S-II-1 AND INSPECTION OF THE WELDS IS
RECOMMENDED. THE FOLLOWING DETAILS OF THE PROCEDURE AND
SCHEDULE WHICH WILL RESULT IN AN ESTIMATED DELAY OF
SPACECRAFT LAUNCH VEHICLE MECHANICAL MATE FROM JUNE 10
TO JUNE 15 WERE PRESENTED AT THE MEETING:
MAY 24 - 28: CONTINUE S-II-1 WORK ON STAGE, SWERING
FOR BAK FOR WELD INSPECTION.

PRIORITY

URGENT

MAY

MAY 29 & 30: DISEMBARK S-II-1, RETURN TO LOW BAY OF VAB.

MAY 31 & JUNE 2: PERFORM DRY FREESTRANT INSPECTION OF
INTERNAL SURFACE OF HYDROGEN TANK WELDS.

JUNE 3 - 7: PERFORM X-RAY INSPECTION OF EXTERNAL SURFACE
OF HYDROGEN TANK WELDS.

JUNE 8 - 11: PERFORM MINOR REPAIRS ON SIGNIFICANT WELD
CRACKS. THIS WOULD INCLUDE BURNISHING OR GROOVE-OUT
OF INTERNAL CRACKS AND REMOVAL OF A PATCH OF INSULATION
AND REPAIR OF AN INTERNAL CRACK.

JUNE 12 - 15: REPLACE S-II-1 ON TO STACK.

JUNE 15: IMMEDIATE MECHANICAL MATE OF S/C & LAUNCH
VEHICLE. PARA.

AS AGREED AT THE MEETING, I WILL EXPECT BY MAY 28 A
CONFIRMATION OF THE SCHEDULE BASED ON A DETAILED STUDY OF
ALL THE OPERATIONS REQUIRED, INCLUDING THE LOGISTICS OF
MOVING THE TANK TO COMPLETE THE INSPECTION, PHOTO-
GRAPHIC SUPPORT, AND OTHER FACTORS. PLEASE ALSO PROVIDE

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NASA HQ

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A SKETCH OF THE WELD AREAS TO BE INSPECTED, THE SAFETY
FACTORS AT THE VARIOUS LOCATIONS, AND AN ESTIMATE OF
WHICH WELD AREAS CANNOT BE INSPECTED.

Original signed by
General Phillips

SAMUEL C. PHILLIPS
MAJOR GENERAL, USAF
ARCULO PROGRAM DIRECTOR

25 MAY 1967

CO:
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M-2/2to
M-2

C. H. King, Jr.
Chief, L/V & Propulsion Test

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