

Leak Test Certification – Alpha NRF Docking System ALPHA FLANGE TEST

System Description:	ALPHA	NRF ASSEMBL	٢
System date of manufacture	8-18-11	Alpha Serial Number:	20677/11

Test set up and Procedure

Materials

- 1. Ammonia 30% concentration: JT Baker Part Number JT9733
- 2. Ammonia sensitive cloth: La Calhene, P/N LAC-12502
- 3. Pressure gage: Dwyer #2010C, 0-10 in-H2O Calibrated by ICC on 12/14/2010

Test Fixture Description

The test fixture consists of a Stainless Steel base (Isolator) plate onto which the alpha NRF flange is installed. Attached to the base plate is a polycarbonate enclosure, the enclosure permits creating a sealed environment around the sterile side of the assembly.

Connected to the enclosure is a pressure gage capable of measuring up to 10 inches of H2O (2500 Pa). Also connected to the enclosure is a needle valve that is manually adjusted during the test to obtain the desired pressure level inside the chamber.

System Preparation

- 1. The Alpha NRF assembly must be installed onto the appropriate test fixture.
- 2. See the enclosed figures.

Test configurations

The system is tested in one configuration.

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Test procedure - Configuration #1

- 1. Remove the test box from the fixture to gain access to the inside.
- 2. Place a cup filled with approximately 20ml of ammonia inside the test box, install the test box and tighten in place to create a seal.
- 3. Using the flow metering valve, allow enough ammonia vapor to escape from the chamber until an internal pressure of 1 In-H2O (250 pa) is achieved.
- 4. Place the ammonia sensitive cloth over the following areas of the assembly:
 - The joints of the NRF flange, all around its circumference.
 - The clamping ring joint, all around its circumference.
 - o The joint between the Alpha NRF flange and the Alpha flange.
 - The joint between the alpha flange and the alpha door.

Allow a minimum of 5 seconds per location. Watch for blue/green discoloration of the cloth at each location.

5. Record findings for each general location of the joints in the table below

Test results su	mmary table – C	onfiguration #1	
Location description	Pass/Fail	Tested by	Date tested
Alpha NRF joint	PASS	JS/GM	8-18-11
Clamping ring joint	PASS	JS/GM	8-18-11
Alpha NRF to Alpha Flange joint	PASS	JS/GM	8-18-11
Alpha flange to alpha door	PASS	JS/GM	8-18-11

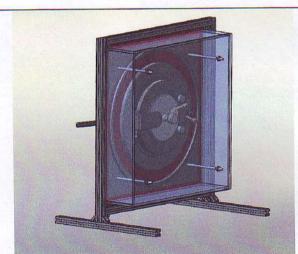


Figure 1: Configuration #1 Leak test enclosure viewed from sterile side with the alpha door closed

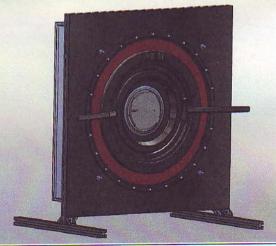


Figure 2: Configuration #1 Leak test set up for testing alpha NRF seal and alpha port seal



Leak Test Certification – Alpha NRF Docking System ALPHA FLANGE TEST

System Description:	ALPHA	NRF ASSEMBLY	
System date of manufacture _	8/19/11	Alpha Serial Number: 20020/11	_

Test set up and Procedure

Materials

- 1. Ammonia 30% concentration: JT Baker Part Number JT9733
- 2. Ammonia sensitive cloth: La Calhene, P/N LAC-12502
- 3. Pressure gage: Dwyer #2010C, 0-10 in-H2O Calibrated by ICC on 12/14/2010

Test Fixture Description

The test fixture consists of a Stainless Steel base (Isolator) plate onto which the alpha NRF flange is installed. Attached to the base plate is a polycarbonate enclosure, the enclosure permits creating a sealed environment around the sterile side of the assembly.

Connected to the enclosure is a pressure gage capable of measuring up to 10 inches of H2O (2500 Pa). Also connected to the enclosure is a needle valve that is manually adjusted during the test to obtain the desired pressure level inside the chamber.

System Preparation

- 1. The Alpha NRF assembly must be installed onto the appropriate test fixture.
- 2. See the enclosed figures.

Test configurations

The system is tested in one configuration.

	System Certification
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Test procedure - Configuration #1

- 1. Remove the test box from the fixture to gain access to the inside.
- 2. Place a cup filled with approximately 20ml of ammonia inside the test box, install the test box and tighten in place to create a seal.
- 3. Using the flow metering valve, allow enough ammonia vapor to escape from the chamber until an internal pressure of 1 In-H2O (250 pa) is achieved.
- 4. Place the ammonia sensitive cloth over the following areas of the assembly:
 - The joints of the NRF flange, all around its circumference.
 - o The clamping ring joint, all around its circumference.
 - The joint between the Alpha NRF flange and the Alpha flange.
 - The joint between the alpha flange and the alpha door.

Allow a minimum of 5 seconds per location. Watch for blue/green discoloration of the cloth at each location.

5. Record findings for each general location of the joints in the table below

255 55 55 55 mments:	8/19 1/5/GM 8/19 5/5/GM 8/19 5/5/GM 8/19 4/5/GM 8/19/	7/11 3/11 3/11 111
	St /GM 8/19	1/11 7/11 111
	111.	<u> </u>
	45/Gm 8/19/	111
		Figure 2: Configuration #1 Leak test set up for testing alpha NRF s

the alpha door closed

Figure 2: Configuration #1 Leak test set up for testing alpha NRF seal a alpha port seal



Leak Test Certification – Alpha NRF Docking System ALPHA FLANGE TEST

System Description:	ALPHA	NRF ASSE	MBLY	
System date of manufacture	8/19/11	_ Alpha Serial Number: _	20002	10

Test set up and Procedure

Materials

- 1. Ammonia 30% concentration: JT Baker Part Number JT9733
- 2. Ammonia sensitive cloth: La Calhene, P/N LAC-12502
- 3. Pressure gage: Dwyer #2010C, 0-10 in-H2O Calibrated by ICC on 12/14/2010

Test Fixture Description

The test fixture consists of a Stainless Steel base (Isolator) plate onto which the alpha NRF flange is installed. Attached to the base plate is a polycarbonate enclosure, the enclosure permits creating a sealed environment around the sterile side of the assembly.

Connected to the enclosure is a pressure gage capable of measuring up to 10 inches of H2O (2500 Pa). Also connected to the enclosure is a needle valve that is manually adjusted during the test to obtain the desired pressure level inside the chamber.

System Preparation

- 1. The Alpha NRF assembly must be installed onto the appropriate test fixture.
- 2. See the enclosed figures.

Test configurations

The system is tested in one configuration.

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Test procedure - Configuration #1

- Remove the test box from the fixture to gain access to the inside. 1.
- 2. Place a cup filled with approximately 20ml of ammonia inside the test box, install the test box and tighten in place to create a seal.
- 3. Using the flow metering valve, allow enough ammonia vapor to escape from the chamber until an internal pressure of 1 In-H2O (250 pa) is achieved.
- 4. Place the ammonia sensitive cloth over the following areas of the assembly:
 - The joints of the NRF flange, all around its circumference. 0
 - The clamping ring joint, all around its circumference. 0
 - The joint between the Alpha NRF flange and the Alpha flange.
 - The joint between the alpha flange and the alpha door.

Allow a minimum of 5 seconds per location. Watch for blue/green discoloration of the cloth at each location.

5. Record findings for each general location of the joints in the table below

Location description	mmary table – Co Pass/Fail	Tested by	Date tested
Alpha NRF joint	PASS	1.5/GM	8/19/4
Clamping ring joint	PASS	S/GM	8/19/1
Alpha NRF to Alpha Flange joint	PASS	15/6M	8/19/1
Alpha flange to alpha door	PASS	95/GM	8/19/11
-		6	

the alpha door closed



Leak Test Certification - Alpha NRF Docking System **ALPHA FLANGE TEST**

System Description: <u>ALPHA NRF ASSEMBLY</u> System date of manufacture <u>B/22/11</u> Alpha Serial Number: <u>20009/10</u>

Test set up and Procedure

Materials

- 1. Ammonia 30% concentration: JT Baker Part Number JT9733
- 2. Ammonia sensitive cloth: La Calhene, P/N LAC-12502
- 3. Pressure gage: Dwyer #2010C, 0-10 in-H2O Calibrated by ICC on 12/14/2010

Test Fixture Description

The test fixture consists of a Stainless Steel base (Isolator) plate onto which the alpha NRF flange is installed. Attached to the base plate is a polycarbonate enclosure, the enclosure permits creating a sealed environment around the sterile side of the assembly.

Connected to the enclosure is a pressure gage capable of measuring up to 10 inches of H2O (2500 Pa). Also connected to the enclosure is a needle valve that is manually adjusted during the test to obtain the desired pressure level inside the chamber.

System Preparation

- 1. The Alpha NRF assembly must be installed onto the appropriate test fixture.
- 2. See the enclosed figures.

Test configurations

The system is tested in one configuration.

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Test procedure - Configuration #1

- 1. Remove the test box from the fixture to gain access to the inside.
- 2. Place a cup filled with approximately 20ml of ammonia inside the test box, install the test box and tighten in place to create a seal.
- 3. Using the flow metering valve, allow enough ammonia vapor to escape from the chamber until an internal pressure of 1 In-H2O (250 pa) is achieved.
- 4. Place the ammonia sensitive cloth over the following areas of the assembly:
 - The joints of the NRF flange, all around its circumference.
 - The clamping ring joint, all around its circumference.
 - The joint between the Alpha NRF flange and the Alpha flange.
 - The joint between the alpha flange and the alpha door.

Allow a minimum of 5 seconds per location. Watch for blue/green discoloration of the cloth at each location.

5. Record findings for each general location of the joints in the table below

Test results su	ımmary table – Co	onfiguration #1	
Location description	Pass/Fail	Tested by	Date tested
Alpha NRF joint	PASS	d.5/6M	8/22/4
Clamping ring joint	PASS	1.5/GM	8/22/11
Alpha NRF to Alpha Flange joint	PASS	01.5/GM	8/22/11
Alpha flange to alpha door	PASS	S/GM	8/22/11



Leak Test Certification – Alpha NRF Docking System ALPHA/BETA FLANGE TEST

BETA FLANGE DOCKED TO ALPHA NRF System Description:

System date of manufacture 8-18-11 Alpha Serial Number: 20677 /11

Beta Serial Number: 10716

Test set up and Procedure

Materials

- 1. Ammonia 30% concentration: JT Baker Part Number JT9733
- 2. Ammonia sensitive cloth: La Calhene, P/N LAC-12502
- 3. Pressure gage: Dwyer #2010C, 0-10 in-H2O Calibrated by ICC on 12/14/2010

Test Fixture Description

The test fixture consists of a Stainless Steel base (Isolator) plate onto which the alpha NRF flange is installed. Attached to the base plate is a polycarbonate enclosure, the enclosure permits creating a sealed environment around the sterile side of the assembly.

Connected to the enclosure is a pressure gage capable of measuring up to 10 inches of H2O (2500 Pa). Also connected to the enclosure is a needle valve that is manually adjusted during the test to obtain the desired pressure level inside the chamber.

System Preparation

- 1. The Alpha NRF assembly must be installed onto the appropriate test fixture.
- 2. Beta Flange to be attached to Alpha Flange.
- 3. See the enclosed figures.

Test configurations

The system is tested in one configuration. The Alpha Flange which the Beta Flange is attached to has been previously tested for leaks; see accompanying Leak Test Certification for the matching Alpha Flange for passing test results.

Figures 1 and 2 show the configuration, with the beta flange connected and the alpha/beta door slightly opened.

	System Certification
Date: <u>8/18/11</u>	Location: MISSION VIEJO
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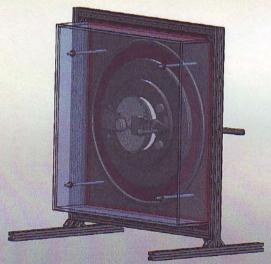
Test procedure - Configuration #2

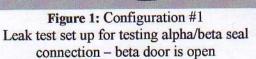
- 1. Dock the beta flange with sealed canister adapter attached
- 2. Remove the test box from the fixture to gain access to the inside.
- 3. Open the alpha/beta door slightly
- 4. Place a cup filled with approximately 20ml of ammonia inside the fixture, install the rear wall and tighten in place to create a seal.
- 5. Using the flow metering valve, allow enough ammonia vapor to escape from the chamber until an internal pressure of 1 In-H2O (250 pa) is achieved.
- 6. Place the ammonia sensitive cloth over the following areas of the assembly:
 - The joints between the alpha and the beta seal

Allow a minimum of 5 seconds per location. Watch for blue/green discoloration of the cloth at each location.

7. Record findings for each general location of the joints in the table below

Location description	ts summary table – Cor Pass/Fail	Tested by	Date tested
Alpha/Beta joint	PASS	15./GM	8/18/11
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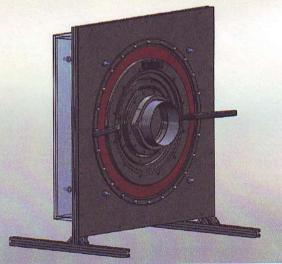


Figure 2: Configuration #1 Leak test set up for testing alpha/beta seal Canister connection opening closed with standard 6 inch cap (not shown)



Leak Test Certification – Alpha NRF Docking System ALPHA/BETA FLANGE TEST

System Description:	BETA FLA	NGE	DOCKED	75	ALPHA NRF
System date of manufac	ture <u>8/18/11</u>	_ Alpha	Serial Number:	20	2677/11
	Beta Serial Number:				

Test set up and Procedure

Materials

- 1. Ammonia 30% concentration: JT Baker Part Number JT9733
- 2. Ammonia sensitive cloth: La Calhene, P/N LAC-12502
- 3. Pressure gage: Dwyer #2010C, 0-10 in-H2O Calibrated by ICC on 12/14/2010

Test Fixture Description

The test fixture consists of a Stainless Steel base (Isolator) plate onto which the alpha NRF flange is installed. Attached to the base plate is a polycarbonate enclosure, the enclosure permits creating a sealed environment around the sterile side of the assembly.

Connected to the enclosure is a pressure gage capable of measuring up to 10 inches of H2O (2500 Pa). Also connected to the enclosure is a needle valve that is manually adjusted during the test to obtain the desired pressure level inside the chamber.

System Preparation

- 1. The Alpha NRF assembly must be installed onto the appropriate test fixture.
- 2. Beta Flange to be attached to Alpha Flange.
- 3. See the enclosed figures.

Test configurations

The system is tested in one configuration. The Alpha Flange which the Beta Flange is attached to has been previously tested for leaks; see accompanying Leak Test Certification for the matching Alpha Flange for passing test results.

Figures 1 and 2 show the configuration, with the beta flange connected and the alpha/beta door slightly opened.

System Certification
Location: MISSION VIEJO
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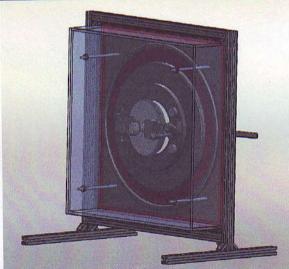
Test procedure - Configuration #2

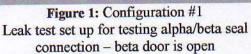
- 1. Dock the beta flange with sealed canister adapter attached
- 2. Remove the test box from the fixture to gain access to the inside.
- 3. Open the alpha/beta door slightly
- 4. Place a cup filled with approximately 20ml of ammonia inside the fixture, install the rear wall and tighten in place to create a seal.
- 5. Using the flow metering valve, allow enough ammonia vapor to escape from the chamber until an internal pressure of 1 In-H2O (250 pa) is achieved.
- 6. Place the ammonia sensitive cloth over the following areas of the assembly:
 - The joints between the alpha and the beta seal

Allow a minimum of 5 seconds per location. Watch for blue/green discoloration of the cloth at each location.

7. Record findings for each general location of the joints in the table below

Test resu	lts summary table – Cor	nfiguration #2	
Location description	Pass/Fail	Tested by	Date tested
Alpha/Beta joint	PASS	1.5/GA	4 8/18/11
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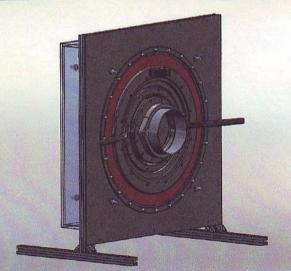


Figure 2: Configuration #1 Leak test set up for testing alpha/beta seal Canister connection opening closed with standard 6 inch cap (not shown)



Leak Test Certification – Alpha NRF Docking System ALPHA/BETA FLANGE TEST

System Description:	BE.	TA	FLAM	LE	DOCKED	70	ALPHA	NRF
System date of manuf	acture	81	18/11	Alph	a Serial Number:	20	2677/	11

Beta Serial Number: 10248 /11

Test set up and Procedure

Materials

- 1. Ammonia 30% concentration: JT Baker Part Number JT9733
- 2. Ammonia sensitive cloth: La Calhene, P/N LAC-12502
- 3. Pressure gage: Dwyer #2010C, 0-10 in-H2O Calibrated by ICC on 12/14/2010

Test Fixture Description

The test fixture consists of a Stainless Steel base (Isolator) plate onto which the alpha NRF flange is installed. Attached to the base plate is a polycarbonate enclosure, the enclosure permits creating a sealed environment around the sterile side of the assembly.

Connected to the enclosure is a pressure gage capable of measuring up to 10 inches of H2O (2500 Pa). Also connected to the enclosure is a needle valve that is manually adjusted during the test to obtain the desired pressure level inside the chamber.

System Preparation

- 1. The Alpha NRF assembly must be installed onto the appropriate test fixture.
- 2. Beta Flange to be attached to Alpha Flange.
- 3. See the enclosed figures.

Test configurations

The system is tested in one configuration. The Alpha Flange which the Beta Flange is attached to has been previously tested for leaks; see accompanying Leak Test Certification for the matching Alpha Flange for passing test results.

Figures 1 and 2 show the configuration, with the beta flange connected and the alpha/beta door slightly opened.

	System Certification
Date: 8/18/11	Location: MISSION VIETO
Print: JOE SACCA	Signature:

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Test procedure - Configuration #2

- 1. Dock the beta flange with sealed canister adapter attached
- 2. Remove the test box from the fixture to gain access to the inside.
- 3. Open the alpha/beta door slightly
- 4. Place a cup filled with approximately 20ml of ammonia inside the fixture, install the rear wall and tighten in place to create a seal.
- 5. Using the flow metering valve, allow enough ammonia vapor to escape from the chamber until an internal pressure of 1 In-H2O (250 pa) is achieved.
- 6. Place the ammonia sensitive cloth over the following areas of the assembly:
 - The joints between the alpha and the beta seal

Allow a minimum of 5 seconds per location. Watch for blue/green discoloration of the cloth at each location.

7. Record findings for each general location of the joints in the table below

Location description	ts summary table – Cor Pass/Fail	Tested by	Date tested
Alpha/Beta joint	PASS	15/GM	8/18/11
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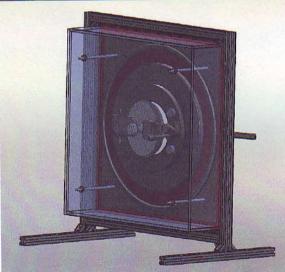


Figure 1: Configuration #1 Leak test set up for testing alpha/beta seal connection – beta door is open



Figure 2: Configuration #1 Leak test set up for testing alpha/beta seal Canister connection opening closed with standard 6 inch cap (not shown)



Leak Test Certification – Alpha NRF Docking System ALPHA/BETA FLANGE TEST

System Description: BETA FLAM	GE DOCKED TO ALPHA NRF
System date of manufacture 8/18/11	Alpha Serial Number: 20677/11
Beta Serial Number:	10258/11

Test set up and Procedure

Materials

- 1. Ammonia 30% concentration: JT Baker Part Number JT9733
- 2. Ammonia sensitive cloth: La Calhene, P/N LAC-12502
- 3. Pressure gage: Dwyer #2010C, 0-10 in-H2O Calibrated by ICC on 12/14/2010

Test Fixture Description

The test fixture consists of a Stainless Steel base (Isolator) plate onto which the alpha NRF flange is installed. Attached to the base plate is a polycarbonate enclosure, the enclosure permits creating a sealed environment around the sterile side of the assembly.

Connected to the enclosure is a pressure gage capable of measuring up to 10 inches of H2O (2500 Pa). Also connected to the enclosure is a needle valve that is manually adjusted during the test to obtain the desired pressure level inside the chamber.

System Preparation

- 1. The Alpha NRF assembly must be installed onto the appropriate test fixture.
- 2. Beta Flange to be attached to Alpha Flange.
- 3. See the enclosed figures.

Test configurations

The system is tested in one configuration. The Alpha Flange which the Beta Flange is attached to has been previously tested for leaks; see accompanying Leak Test Certification for the matching Alpha Flange for passing test results.

Figures 1 and 2 show the configuration, with the beta flange connected and the alpha/beta door slightly opened.

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Test procedure - Configuration #2

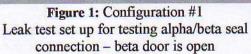
- 1. Dock the beta flange with sealed canister adapter attached
- 2. Remove the test box from the fixture to gain access to the inside.
- 3. Open the alpha/beta door slightly
- 4. Place a cup filled with approximately 20ml of ammonia inside the fixture, install the rear wall and tighten in place to create a seal.
- 5. Using the flow metering valve, allow enough ammonia vapor to escape from the chamber until an internal pressure of 1 In-H2O (250 pa) is achieved.
- 6. Place the ammonia sensitive cloth over the following areas of the assembly:
 - The joints between the alpha and the beta seal

Allow a minimum of 5 seconds per location. Watch for blue/green discoloration of the cloth at each location.

7. Record findings for each general location of the joints in the table below

Location description	Pass/Fail	Tested by	Date tested
Alpha/Beta joint	PASS	45/6M	8/18/11
		-	





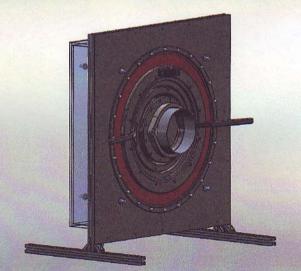


Figure 2: Configuration #1 Leak test set up for testing alpha/beta seal Canister connection opening closed with standard 6 inch cap (not shown)



Leak Test Certification – Alpha NRF Docking System ALPHA/BETA FLANGE TEST

System Description:	BETA FLA	NGE	DOCKE.	075	ALPHA	NRF
System date of manufac	ture <u>8/18/11</u>	_ Alpha S	erial Number	: 20	677/11	
	Beta Serial Number:	106	95/11			

Test set up and Procedure

Materials

- 1. Ammonia 30% concentration: JT Baker Part Number JT9733
- 2. Ammonia sensitive cloth: La Calhene, P/N LAC-12502
- 3. Pressure gage: Dwyer #2010C, 0-10 in-H2O Calibrated by ICC on 12/14/2010

Test Fixture Description

The test fixture consists of a Stainless Steel base (Isolator) plate onto which the alpha NRF flange is installed. Attached to the base plate is a polycarbonate enclosure, the enclosure permits creating a sealed environment around the sterile side of the assembly.

Connected to the enclosure is a pressure gage capable of measuring up to 10 inches of H2O (2500 Pa). Also connected to the enclosure is a needle valve that is manually adjusted during the test to obtain the desired pressure level inside the chamber.

System Preparation

- 1. The Alpha NRF assembly must be installed onto the appropriate test fixture.
- 2. Beta Flange to be attached to Alpha Flange.
- 3. See the enclosed figures.

Test configurations

The system is tested in one configuration. The Alpha Flange which the Beta Flange is attached to has been previously tested for leaks; see accompanying Leak Test Certification for the matching Alpha Flange for passing test results.

Figures 1 and 2 show the configuration, with the beta flange connected and the alpha/beta door slightly opened.

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Test procedure - Configuration #2

- 1. Dock the beta flange with sealed canister adapter attached
- 2. Remove the test box from the fixture to gain access to the inside.
- 3. Open the alpha/beta door slightly
- 4. Place a cup filled with approximately 20ml of ammonia inside the fixture, install the rear wall and tighten in place to create a seal.
- 5. Using the flow metering valve, allow enough ammonia vapor to escape from the chamber until an internal pressure of 1 In-H2O (250 pa) is achieved.
- 6. Place the ammonia sensitive cloth over the following areas of the assembly:
 - The joints between the alpha and the beta seal

Allow a minimum of 5 seconds per location. Watch for blue/green discoloration of the cloth at each location.

7. Record findings for each general location of the joints in the table below

Test results summary table – Configuration #2				
Location description	Pass/Fail	Tested by	Date tested	
Alpha/Beta joint	PASS	8-5/GM	8/18/11	

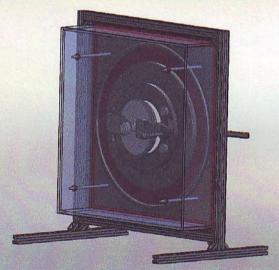


Figure 1: Configuration #1 Leak test set up for testing alpha/beta seal connection – beta door is open



Figure 2: Configuration #1 Leak test set up for testing alpha/beta seal Canister connection opening closed with standard 6 inch cap (not shown)



Leak Test Certification – Alpha NRF Docking System ALPHA/BETA FLANGE TEST

System Description:		
System date of manufacture <u>$\mathcal{E}/1\mathcal{E}/1$</u>	_Alpha Serial Number: _	20677/11
Beta Serial Number:	10700/11	/

Test set up and Procedure

Materials

- 1. Ammonia 30% concentration: JT Baker Part Number JT9733
- 2. Ammonia sensitive cloth: La Calhene, P/N LAC-12502
- 3. Pressure gage: Dwyer #2010C, 0-10 in-H2O Calibrated by ICC on 12/14/2010

Test Fixture Description

The test fixture consists of a Stainless Steel base (Isolator) plate onto which the alpha NRF flange is installed. Attached to the base plate is a polycarbonate enclosure, the enclosure permits creating a sealed environment around the sterile side of the assembly.

Connected to the enclosure is a pressure gage capable of measuring up to 10 inches of H2O (2500 Pa). Also connected to the enclosure is a needle valve that is manually adjusted during the test to obtain the desired pressure level inside the chamber.

System Preparation

- 1. The Alpha NRF assembly must be installed onto the appropriate test fixture.
- 2. Beta Flange to be attached to Alpha Flange.
- 3. See the enclosed figures.

Test configurations

The system is tested in one configuration. The Alpha Flange which the Beta Flange is attached to has been previously tested for leaks; see accompanying Leak Test Certification for the matching Alpha Flange for passing test results.

Figures 1 and 2 show the configuration, with the beta flange connected and the alpha/beta door slightly opened.

		System Certification
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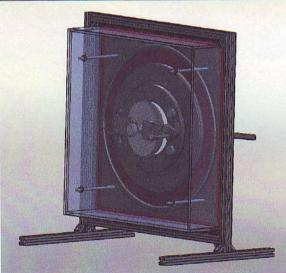
Test procedure - Configuration #2

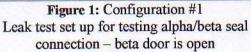
- 1. Dock the beta flange with sealed canister adapter attached
- 2. Remove the test box from the fixture to gain access to the inside.
- 3. Open the alpha/beta door slightly
- 4. Place a cup filled with approximately 20ml of ammonia inside the fixture, install the rear wall and tighten in place to create a seal.
- 5. Using the flow metering valve, allow enough ammonia vapor to escape from the chamber until an internal pressure of 1 In-H2O (250 pa) is achieved.
- 6. Place the ammonia sensitive cloth over the following areas of the assembly:
 - The joints between the alpha and the beta seal

Allow a minimum of 5 seconds per location. Watch for blue/green discoloration of the cloth at each location.

7. Record findings for each general location of the joints in the table below

	ts summary table – Col		Date tested
Location description	Pass/Fail	Tested by	Date testeu
Alpha/Beta joint	PASS	9-5/GM	8/18/4
		0/	
			Carl and the little





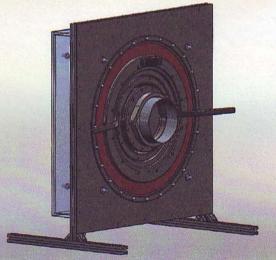


Figure 2: Configuration #1 Leak test set up for testing alpha/beta seal Canister connection opening closed with standard 6 inch cap (not shown)