

PROCEDURE	NUMBER: FAM-P-0015
	DATE: 04-01-19
	REVISION: 4

SUBJECT

CORROSION CONTROL FACILITY OPERATIONS

PURPOSE

This procedure outlines operating procedures for the Base Operations and Spaceport Services (BOSS) Contract Corrosion Control Facility, (CCF) M6-1625.

SCOPE AND APPLICABILITY

This procedure pertains to all equipment received for abrasive media blasting and or coatings of flight hardware, Ground Support Equipment (GSE), and BOSS 80KSC018C0017 PWS 2.6, equipment for corrosion control at the Corrosion Control Facility.

PROCESS

1. CCF REQUIREMENTS ARE RECEIVED THROUGH WORK CONTROL/SCHEDULING.
2. CCF SHALL ORDER NECESSARY MATERIALS TO COMPLETE WORK ORDER TASK.
3. AFTER COMPLETING WORK ORDER REQUIREMENTS BLASTERS/PAINTERS SHALL SIGN OFF RESPECTIVE WORK ORDER AS COMPLETE, AND ROUTE TO THE CCF SUPERVISION.
4. THE CCF SUPERVISION WILL VERIFY THE COMPLETED REQUIREMENTS BY SIGNING THE WORK ORDER AND DELIVERING THE COMPLETED WORK ORDER TO THE FACILITY SCHEDULER.
5. ALL FLIGHT HARDWARE DOCUMENTS ARE COPIED AND FILED FOR CONTRACT DURATION.

6. SPECIFIC INSTRUCTIONS

ALL CCF WORK

6.1. Station 1- Receiving

Inspect Incoming Equipment

- a. Inspect for degreasing cleanliness
- b. Inspect for detailed disassembly

Identify Equipment

- a. Identify equipment with customer control number
- b. Enter control number on travel document
- c. Apply control numbered steel tag to equipment
- d. Move equipment to customer color coded area

Documentation

- a. Locate work authorization document for equipment
- b. Contact BOSS Quality for N.A.C.E. inspection (if required)
- c. Complete in-house traveler document
- d. Schedule start and completion dates for equipment
- e. Log onto scheduling board with date
- f. Assign project to shop painter

6.2. Station 2 - Surface PreparationMove Equipment

- a. Determine type (s) of surface preparation
- b. Locate equipment to surface preparation area(s)
- c. Inspect Equipment
 - Inspect for cleanliness
 - Determine specific area to be prepared
 - Determine specific areas to be masked
- d. Prepare Surfaces
 - Inspect after surface preparation for compliance
 - NACE inspector approval (if required)

6.3. Station 3 – Coatings ApplicationCoatings Application

- a. Determine type of coatings to be applied per the specified travel document
- b. Retrieve specified material from POL and mix in accordance with manufacturer's written instruction.
- c. Apply coatings per the manufacturer's written instruction and the parameters of the travel document.

- d. Verify that coatings applications were performed within the specified travel document.
- e. N.A.C.E. inspector approval (if required)

6.4. Station 4 – Staging and Final Inspection

Staging

- a. Locate equipment to colored coded customer area
- b. Verify all equipment is accounted for and complete

Documentation Closure

- a. Complete travel document(s)
- b. Complete work authorization document(s)
- c. Notify customer for equipment pick-up
- d. Obtain customer pick-up signature.

Note: After completion of all respective BOSS Work Orders, the CCF Supervision verifies completed requirements by signing and delivering all records to the facility scheduler.

7. FACILITIES DESCRIPTION

The Corrosion Control Facility consists of several facilities used for completing their specified tasks. The following is a short description of each facility and its intended use:

- M6-1623, Scaffold Storage Facility – This facility houses all the scaffold materials used by BOSS Scaffold Crew. This facility also houses miscellaneous rigging equipment.
- M6-1624, NEW Blast Media and General Storage Facility – This facility houses all incoming (unused) abrasive blast media and also provides shelter for miscellaneous parts and equipment used by the CCF personnel.
- M6-1625, Administrative and Spray Booth Facility – This facility houses the administrative offices, break room, facility restroom, shower, and spray booth operations. This facility has two spray booths where the specified coatings systems are applied.
- M6-1626, Hazardous Storage Facility – This facility houses locker type POL's and is also the 90 day storage site for all hazardous waste generated at the facility.

- M6-1627, Steel Blast Facility - Is an abrasive blast facility that utilizes a more aggressive abrasive such as steel to provide a specified anchor pattern on the substrate such as carbon steel, stainless steel and other hardened alloys.
- M6-1628, Plastic Media Blast Facility - Is an abrasive blast media facility where a Plastic Media is used to abrasive blast soft alloys such as Aluminum and Copper or where substrate anchor profile is not needed. This facility also houses all of the waterborne latex paint components.
- M6-1629, Compressor Building – This facility houses the compressors that provide all of the supplied air needed for operations at the CCF.
- POL KO26, KO27, KO28, & KO29 – These POLS are located on the south end of the facility and houses the solvent based industrial coatings.

8. ENVIRONMENTAL CONSIDERATIONS

All hazardous waste generated at the CCF will be handled in accordance with EAP-I-2100, BOSS Waste Generator's Handbook. Inspections of M6-1626 will take place once a week utilizing KSC FORM 28-1167, Waste Accumulation in accordance with Florida Administrative Code (FAC) 62-730.160. Shipment of Hazardous Waste will be documented on KSC FORM 26-541V2 "Controlled Waste Manifest." This document shall remain on site for a period of three years. All coatings dispensed or applied at the CCF will be documented on Form EAP-F-1200A, "Monthly Paint/Thinner Usage Report" and sent to the Environmental Assurance Branch monthly for reporting to FDEP. This document will remain on site for contract duration. Filter change outs for abrasive blast bays and spray booths will be documented on Form EAP-F-1200B, "Air Filter/Curtain Replacement Log" and reported to the Environmental Assurance Branch monthly for reporting to FDEP. This document is to remain on site for the contract duration.

Waste Minimization is done by using the proper amounts of product for the job task as well as utilizing the solvent recycling machine to minimize Hazardous Air Pollutants. Changing filters in Plastic Media Bay, Spray Booth Filters, and Dust Collectors help eliminate hazardous particulates from entering the air.

9. HAZARDOUS WASTE CODES

KGG-HG0004 AEROSOL CANS, KGG-HK0012 SOLID WASTE, KGG-NJ0006 LATEX, KGG-HJ0055 LIQUID WASTE AND KGG-HJ0079 CAULKING TUBES.

RECORDS

The following records are retained by the organizations listed below:

Record	Responsible Organization
Controlled Waste Manifest KSC FORM 26-541V2 (copy)	FSEU OM&E
Weekly Inspection form KSC Form 28-1167 (copy)	FSEU OM&E
Monthly Paint/Thinner Usage EAP-F-1200A (copy)	FSEU OM&E
Air Filter/Curtain Replacement Log EAP-F-1200B(copy)	FSEU OM&E

AFFECTED DIVISIONS

FSEU and OM&E
Safety & Mission Assurance

MANAGEMENT ROLES AND RESPONSIBILITIES

Program Manager: Ensures Contract compliance to the requirements stated in this procedure. Reviews and approves or disapproves waiver requests written against this standard.

Division Manager: Ensures compliance within the Division to the requirements stated in this procedure.

Branch Manager: Ensures compliance at the branch level to the requirements stated in this procedure.

FUNCTIONAL ROLES AND RESPONSIBILITIES

Shop Supervision – Supervisor will ensure that operational procedures as described within this document are followed.

Shop Personnel – Shop personnel are to follow the operational procedures as described within this document.

REFERENCE DOCUMENTS

The following documents are referenced in this procedure:

Document Number	Title
80KSC018C0017	Base Operations and Spaceport Services (BOSS) Contract
KNPR 8500.1	KSC Environmental Requirements
NASA-STD-5008	Protective Coatings of Carbon Steel, Stainless Steel and Aluminum on Launch Structures
MIL-P-85891A	Military Specs. Plastic Media for Removal of Organic Coatings - 1992

Document Number	Title
OSHA-29CFR-1926.62	Occupational Safety and Healthy Admin. Standards – 29CFR and 1926.62
QAL-P-0002	Quality Inspection
FAC 62-730.160	Standards Applicable to Generators of Hazardous Waste.

ACRONYMS

CCF - Corrosion Control Facility
CFR – Code of Federal Regulations
FAC - Florida Administrative Code
GSE - Ground Support Equipment
BOSS - Base Operations and Spaceport Services
KSC – Kennedy Space Center
N.A.C.E – National Association of Corrosion Engineers International
OSHA – Occupational Safety and Health Administration
POL – Petroleum, Oil & Lubricants

DEFINITIONS

Anchor Profile – is the altering of a surface usually a metal by an abrasive through abrasive blasting with air or water.

REVISION RECORD

The following revisions have been applied to this document:

Revision Number	Change Description	Date
0	No History	
1	This revision removes the statement “SGS Company Proprietary – JBOSC Competition Sensitive” from this document	5-27-2007
2	This revision updated safety requirements and quality requirements as required per ISC	5-26-2009
3	Initial release to define BOSS policy	05-27-2010
4	Administrative change only. Document updated to remove branding of previous contract.	04-01-2019

DOCUMENT APPROVALS

Signature on file

X

Manager, FSEU OM&E