

Introduction To Failure Analysis And Prevention

Microbial Corrosion: Failure Modes, Effects and Causes, and Analysis presents academic research about microbial corrosion (MIC), integrating it into engineering applications that result in a more thorough understanding of MIC and how it is recognized and treated. In addition, new concepts that will be useful in understanding integrity and corrosion management practices are explored. This book will be useful for industry professionals, particularly maintenance and operation engineers, corrosion and material engineers, and R&D personnel working in the field of corrosion protection. Focuses on the skills and knowledge necessary to understand how (Failure modes) and why (Effects and Causes) materials fail Explains why corrosion control measures, such as the use of coatings, cathodic protection and inhibitors are useful Discusses the practical side of MIC treatment in terms of fundamental concepts of time and cost of operation

Written in easy-to-read and -use format, this book updates and revises its bestselling predecessor to become the most complete, comprehensive resource on plastics testing. This book has an emphasis on significance of test methods and interpretation of results. The book covers all aspects of plastics testing, failure analysis, and quality assurance - including chapters on identification analysis, failure analysis, and case studies. The book concludes with a substantial appendix with useful data, charts and tables for ready reference. Note: CD-ROM/DVD and other supplementary materials are not included as part of eBook file.

Analysis of Failure and Survival Data is an essential textbook for graduate-level students of survival analysis and reliability and a valuable reference for practitioners. It focuses on the many techniques that appear in popular software packages, including plotting product-limit survival curves, hazard plots, and probability plots in the context of censored data. The author integrates S-Plus and Minitab output throughout the text, along with a variety of real data sets so readers can see how the theory and methods are applied. He also incorporates exercises in each chapter that provide valuable problem-solving experience. In addition to all of this, the book also brings to light the most recent linear regression techniques. Most importantly, it includes a definitive account of the Buckley-James method for censored linear regression, found to be the best performing method when a Cox proportional hazards method is not appropriate. Applying the theories of survival analysis and reliability requires more background and experience than students typically receive at the undergraduate level. Mastering the contents of this book will help prepare students to begin performing research in survival analysis and reliability and provide seasoned practitioners with a deeper understanding of the field.

Component failures result from a combination of factors involving materials science, mechanics, thermodynamics, corrosion, and tribology. With the right guidance, you don't have to be an authority in all of these areas to become skilled at diagnosing and preventing failures. Based on the author's more than thirty years of experience, Practical Plant Failure Analysis: A Guide to Understanding Machinery Deterioration and Improving Equipment Reliability is a down-to-earth guide to improving machinery maintenance and reliability. Illustrated with hundreds of diagrams and photographs, this book examines... · When and how to conduct a physical failure analysis · Basic material

properties including heat treating mechanisms, work hardening, and the effects of temperature changes on material properties · The differences in appearance between ductile overload, brittle overload, and fatigue failures · High cycle fatigue and how to differentiate between high stress concentrations and high operating stresses · Low cycle fatigue and unusual fatigue situations · Lubrication and its influence on the three basic bearing designs · Ball and roller bearings, gears, fasteners, V-belts, and synchronous belts Taking a detailed and systematic approach, *Practical Plant Failure Analysis* thoroughly explains the four major failure mechanisms—wear, corrosion, overload, and fatigue—as well as how to identify them. The author clearly identifies how these mechanisms appear in various components and supplies convenient charts that demonstrate how to identify the specific causes of failure.

Filling a gap in the literature, *Practical Engineering Failure Analysis* vividly demonstrates the correct methodology to conduct successful failure analyses, as well as offering the background necessary for these investigations. This authoritative reference covers procedures to reduce the occurrence of component failures due to errors in material se

Identifying failure modes and their effects is critical to software failure mode and effects analysis and it largely depends on the analysts' experience and the skill. This book develops a series of reading techniques based on common and prioritized failure modes in software requirements, software design, coding, and usability in order to make the benefits of software failure mode and effects analysis (FMEA) readily accessible to general software practitioners, particularly in small teams and resource-constrained organizations. After a general introduction it offers an overview of software FMEA and discusses software review procedures and software reading techniques. Subsequent chapters present the basic ideas behind failure-modes-based reading techniques and examine the use of these techniques for software requirements, software design, software coding, software usability, and software testing. Covering the entire creation process, and including checklists and examples, it provides an easy introduction to the topic for professionals in software engineering and quality assurance.

Design, manufacturing, maintenance, and operating professionals often do not have the opportunity for meaningful dialogue. Even when a complete failure analysis is performed, insights gained about how to improve a process or material specification is often not relayed back to the designers. Many failures could be prevented if those responsible for making critical decisions had more information, especially regarding previous problems. This May 2000 conference brought together product designers and materials engineers to share knowledge gained over the last 20 years in fractography, stress analysis, and interdisciplinary approaches to engineering in general and failure analysis in particular. Contents: The Roots of Failure Interdisciplinary Failure Analysis Keeping 'an open mind' During Root Cause Analysis Legal Definitions of Failure for Designers and Manufacturers Codes, Standards and Test Methods Comprehensive Failure Analysis on a Complex System Critical Factors in the Design Process New Tools for Design Failure Modes and Effects Credibility Analysis Scientific Materials Selection Processes Materials Specification and Failure Case Histories Characteristics of Castings and Forgings Working with Heat Treaters Using the Right Material to 'Make It Like the Drawing' Machining Issues Finishing Processes Unanticipated Service Conditions

Reliability Service Conditions.

This text introduces the important aspects associated with the failure analysis of engineering components; and provides a treatment of both macroscopic and microscopic observations of fracture surfaces. --

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The second volume in a series comprising a reliable source of failure analysis case studies for engineering professionals. Volume 1 (1992) was reviewed in the April 1993 SciTech Book News . Volume 2 contains 131 new case studies in the areas of transportation component failures (aircraft-aerospace/g

Handbook of Materials Failure Analysis: With Case Studies from the Aerospace and Automotive Industries provides a thorough understanding of the reasons materials fail in certain situations, covering important scenarios, including material defects, mechanical failure as a result of improper design, corrosion, surface fracture, and other environmental causes. The book begins with a general overview of materials failure analysis and its importance, and then logically proceeds from a discussion of the failure analysis process, types of failure analysis, and specific tools and techniques, to chapters on analysis of materials failure from various causes. Later chapters feature a selection of newer examples of failure analysis cases in such strategic industrial sectors as aerospace, oil & gas, and chemicals. Covers the most common types of materials failure, analysis, and possible solutions Provides the most up-to-date and balanced coverage of failure analysis, combining foundational knowledge, current research on the latest developments, and innovations in the field Ideal accompaniment for those interested in materials forensic investigation, failure of materials, static failure analysis, dynamic failure analysis, fatigue life prediction, rotorcraft, failure prediction, fatigue crack propagation, bevel pinion failure, gasketless flange, thermal barrier coatings Presents compelling new case studies from key industries to demonstrate concepts Highlights the role of site conditions, operating conditions at the time of failure, history of equipment and its operation, corrosion product sampling, metallurgical and electrochemical factors, and morphology of failure

Challenged by stringent regulations, vigorous competition, and liability lawsuits, medical device manufactures must develop safe, reliable, and cost-effective products, and managing and reducing risk is a vital element of reaching that goal. A practical guide to achieving corporate consistency while dramatically cutting the time required for studies, Guidelines for Failure Modes and Effects Analysis for Medical Devices focuses on Failure Modes and Effects Analysis (FMEA) and its application throughout the life cycle of a medical device. It outlines the major U.S. and E.U. standards and regulations and provides a detailed yet easy-to-read overview of risk management and risk analysis methodologies, common FMEA pitfalls, and FMECA-Failure Mode, Effects, and Criticality Analysis. Discover how the FMEA methodology can help your company achieve a more cost-effective manufacturing process by improving the quality and reliability of your products. This new FMEA manual from the experts at Dyadem is the ultimate resource for you and your colleagues to learn more about Failure Modes and Effects Analysis and then teach others at your facility. This comprehensive manual is sure to become a standard reference for engineering professionals.

Includes bibliographical references and index.

This book presents fractography and failure analysis at a level that is accessible for non-expert readers, without losing scientific rigor. It offers a comprehensive description of fracture surfaces in engineering materials, with an emphasis on metals, and of the methodology for the observation of fracture surfaces. It also discusses in detail the main fracture mechanisms and their corresponding fracture surfaces, including brittle, ductile, fatigue, and environmental fractures. The last chapter is dedicated to the use of fractography in determining of the causes component failure. In modern engineering, the analysis of fractured components is a common

practice in many fields, such as integrity management systems, materials science research, and failure investigations. As such this book is useful for engineers, scientists, engineering students, loss adjuster surveyors and any professional dealing with fractured components. The growing use of polymer composites is leading to increasing demand for fractographic expertise. Fractography is the study of fracture surface morphologies and it gives an insight into damage and failure mechanisms, underpinning the development of physically-based failure criteria. In composites research it provides a crucial link between predictive models and experimental observations. Finally, it is vital for post-mortem analysis of failed or crashed polymer composite components, the findings of which can be used to optimise future designs. Failure analysis and fractography of polymer composites covers the following topics: methodology and tools for failure analysis; fibre-dominated failures; delamination-dominated failures; fatigue failures; the influence of fibre architecture on failure; types of defect and damage; case studies of failures due to overload and design deficiencies; case studies of failures due to material and manufacturing defects; and case studies of failures due to in-service factors. With its distinguished author, Failure analysis and fractography of polymer composites is a standard reference text for researchers working on damage and failure mechanisms in composites, engineers characterising manufacturing and in-service defects in composite structures, and investigators undertaking post-mortem failure analysis of components. The book is aimed at both academic and industrial users, specifically final year and postgraduate engineering and materials students researching composites and industry designers and engineers in aerospace, civil, marine, power and transport applications. Examines the study of fracture surface morphologies in understanding composite structural behaviour Discusses composites research and post-modern analysis of failed or crashed polymer composite components Provides an overview of damage mechanisms, types of defect and failure criteria

Learning the proper steps for organizing a failure investigation ensures success. Failure investigations cross company functional boundaries and are an integral component of any design or manufacturing business operation. Well-organized and professionally conducted investigations are essential for solving manufacturing problems and assisting in redesigns. This book outlines a proven systematic approach to failure investigation. It explains the relationship between various failure sources (corrosion, for example) and the organization and conduct of the investigation. It provides a learning platform for engineers from all disciplines: materials, design, manufacturing, quality, and management. The examples in this book focus on the definition of and requirements for a professionally performed failure analysis of a physical object or structure. However, many of the concepts have much greater utility than for investigating the failure of physical objects. For example, the book provides guidance in areas such as learning how to define objectives, negotiating the scope of investigation, examining the physical evidence, and applying general problem-solving techniques. Failure analysis is the preferred method to investigate product or process reliability and to ensure optimum performance of electrical components and systems. The physics-of-failure approach is the only internationally accepted solution for continuously improving the reliability of materials, devices and processes. The models have been developed from the physical and chemical phenomena that are responsible for degradation or failure of electronic components and materials and now replace popular distribution

models for failure mechanisms such as Weibull or lognormal. Reliability engineers need practical orientation around the complex procedures involved in failure analysis. This guide acts as a tool for all advanced techniques, their benefits and vital aspects of their use in a reliability programme. Using twelve complex case studies, the authors explain why failure analysis should be used with electronic components, when implementation is appropriate and methods for its successful use. Inside you will find detailed coverage on: a synergistic approach to failure modes and mechanisms, along with reliability physics and the failure analysis of materials, emphasizing the vital importance of cooperation between a product development team involved the reasons why failure analysis is an important tool for improving yield and reliability by corrective actions the design stage, highlighting the 'concurrent engineering' approach and DfR (Design for Reliability) failure analysis during fabrication, covering reliability monitoring, process monitors and package reliability reliability resting after fabrication, including reliability assessment at this stage and corrective actions a large variety of methods, such as electrical methods, thermal methods, optical methods, electron microscopy, mechanical methods, X-Ray methods, spectroscopic, acoustical, and laser methods new challenges in reliability testing, such as its use in microsystems and nanostructures This practical yet comprehensive reference is useful for manufacturers and engineers involved in the design, fabrication and testing of electronic components, devices, ICs and electronic systems, as well as for users of components in complex systems wanting to discover the roots of the reliability flaws for their products.

Root Cause Failure Analysis provides the concepts needed to effectively perform industrial troubleshooting investigations. It describes the methodology to perform Root Cause Failure Analysis (RCFA), one of the hottest topics currently in maintenance engineering. It also includes detailed equipment design and troubleshooting guidelines, which are needed to perform RCFA on machinery found in most production facilities. This is the latest book in a new series published by Butterworth-Heinemann in association with PLANT ENGINEERING magazine. PLANT ENGINEERING fills a unique information need for the men and women who operate and maintain industrial plants. It bridges the information gap between engineering education and practical application. As technology advances at increasingly faster rates, this information service is becoming more and more important. Since its first issue in 1947, PLANT ENGINEERING has stood as the leading problem-solving information source for America's industrial plant engineers, and this book series will effectively contribute to that resource and reputation. Provides information essential to industrial troubleshooting investigations Describes the methods of root cause failure analysis, a hot topic in maintenance engineering Includes detailed equipment-design guidelines This book covers recent advancement methods used in analysing the root cause of engineering failures and the proactive suggestion for future failure prevention. The techniques used especially non-destructive testing such X-ray are well described. The failure analysis covers materials for metal and composites for various applications in mechanical, civil and electrical applications. The modes of failures that are well explained include fracture, fatigue, corrosion and high-temperature failure mechanisms. The administrative part of failures is also presented in the chapter of failure rate analysis. The book will bring you on a tour on how to apply mechanical, electrical and civil engineering fundamental concepts and to understand the prediction of root cause

of failures. The topics explained comprehensively the reliable test that one should perform in order to investigate the cause of machines, component or material failures at the macroscopic and microscopic level. I hope the material is not too theoretical and you find the case study, the analysis will assist you in tackling your own failure investigation case.

Understanding why and how failures occur is critical to failure prevention, because even the slightest breakdown can lead to catastrophic loss of life and asset as well as widespread pollution. This book helps anyone involved with machinery reliability, whether in the design of new plants or the maintenance and operation of existing ones, to understand why process equipment fails and thereby prevent similar failures.

Practical Plant Failure Analysis A Guide to Understanding Machinery Deterioration and Improving Equipment Reliability CRC Press

Handbook of Materials Failure Analysis: With Case Studies from the Construction Industry provides a thorough understanding of the reasons materials fail in certain situations, covering important scenarios including material defects, mechanical failure due to various causes, and improper material selection and/or corrosive environment. The book begins with a general overview of materials failure analysis and its importance, and then logically proceeds from a discussion of the failure analysis process, types of failure analysis, and specific tools and techniques, to chapters on analysis of materials failure from various causes. Failure can occur for several reasons, including: materials defects-related failure, materials design-related failure, or corrosion-related failures. The suitability of the materials to work in a definite environment is an important issue. The results of these failures can be catastrophic in the worst case scenarios, causing loss of life. This important reference covers the most common types of materials failure, and provides possible solutions. Provides the most up-to-date and balanced coverage of failure analysis, combining foundational knowledge and current research on the latest developments and innovations in the field Offers an ideal accompaniment for those interested in materials forensic investigation, failure of materials, static failure analysis, dynamic failure analysis, and fatigue life prediction Presents compelling new case studies from key industries to demonstrate concepts and to assist users in avoiding costly errors that could result in catastrophic events Written by Puck's pupil and appointed successor Martin Knops, this book presents Alfred Puck's failure model, which, among several other theories, predicts fracture limits best and describes the failure phenomena in FRP most realistically – as confirmed within the "World-wide Failure Exercise". Using Puck's model the composite engineer can follow the gradual failure process in a laminate and deduce from the results of the analysis how to improve the laminate design.

With the proliferation of packaging technology, failure and reliability have become serious concerns. This invaluable reference details processes that enable detection, analysis and prevention of failures. It provides a comprehensive account of the failures of device packages, discrete component connectors, PCB carriers and PCB assemblies.

The selection and application of engineered materials is an integrated process that requires an understanding of the interaction between materials properties, manufacturing characteristics, design considerations, and the total life cycle of the product. This reference book on engineering plastics provides practical and

comprehensive coverage on how the performance of plastics is characterized during design, property testing, and failure analysis. The fundamental structure and properties of plastics are reviewed for general reference, and detailed articles describe the important design factors, properties, and failure mechanisms of plastics. The effects of composition, processing, and structure are detailed in articles on the physical, chemical, thermal, and mechanical properties. Other articles cover failure mechanisms such as: crazing and fracture; impact loading; fatigue failure; wear failures, moisture related failure; organic chemical related failure; photolytic degradation; and microbial degradation. Characterization of plastics in failure analysis is described with additional articles on analysis of structure, surface analysis, and fractography.

The Electronic Device Failure Analysis Society proudly announces the Seventh Edition of the Microelectronics Failure Analysis Desk Reference, published by ASM International. The new edition will help engineers improve their ability to verify, isolate, uncover, and identify the root cause of failures. Prepared by a team of experts, this updated reference offers the latest information on advanced failure analysis tools and techniques, illustrated with numerous real-life examples. This book is geared to practicing engineers and for studies in the major area of power plant engineering. For non-metallurgists, a chapter has been devoted to the basics of material science, metallurgy of steels, heat treatment, and structure-property correlation. A chapter on materials for boiler tubes covers composition and application of different grades of steels and high temperature alloys currently in use as boiler tubes and future materials to be used in supercritical, ultra-supercritical and advanced ultra-supercritical thermal power plants. A comprehensive discussion on different mechanisms of boiler tube failure is the heart of the book. Additional chapters detailing the role of advanced material characterization techniques in failure investigation and the role of water chemistry in tube failures are key contributions to the book.

This book addresses the failures of structural elements, i.e. those components whose primary mission is to withstand mechanical loads. The book is intended as a self-contained source for those with different technical grades, engineers and scientists but also technicians in the field can benefit from its reading.

Applied Engineering Failure Analysis: Theory and Practice provides a point of reference for engineering failure analysis (EFA) cases, presenting a compilation of case studies covering a 35-year period, from the 1970s to 2012. This period spans the era from the time when slide rules were used routinely for engineering calculations, and when hard-copy photographs taken by film cameras were pasted onto typewritten sheets to make reports, to the present time when all these functions have become much less onerous through computer assistance. The cases are drawn from such diverse fields as mechanical engineering, metallurgy, mining, civil/structural engineering, electrical power systems, and radiation damage; the last two topics are quite scarce in current publications. It includes theoretical content that deals with useful topics in basic theory, material properties, failure mechanisms, EFA methodology, and applications. It provides high-quality illustrations throughout, which greatly helps to promote the understanding of the failure characteristics described. This book offers an integrated approach that serves as a useful first reference in the above topics, for undergraduate and postgraduate students, as well as for practicing engineers. The book provides a hands-on approach to EFA, which helps the user to develop an understanding of

potential failure situations, to explore the consequences, and to better understand how to solve similar problems; it also helps users to develop their own techniques for most other engineering failure problems. The authors include a section on technical report writing, which will assist failure investigators in getting their findings across. They also present simple engineering calculations that may serve as illustrative examples, and typical problems and solutions are included at the end of each chapter.

Handbook of Materials Failure Analysis: With Case Studies from the Oil and Gas Industry provides an updated understanding on why materials fail in specific situations, a vital element in developing and engineering new alternatives. This handbook covers analysis of materials failure in the oil and gas industry, where a single failed pipe can result in devastating consequences for people, wildlife, the environment, and the economy of a region. The book combines introductory sections on failure analysis with numerous real world case studies of pipelines and other types of materials failure in the oil and gas industry, including joint failure, leakage in crude oil storage tanks, failure of glass fibre reinforced epoxy pipes, and failure of stainless steel components in offshore platforms, amongst others. Introduces readers to modern analytical techniques in materials failure analysis Combines foundational knowledge with current research on the latest developments and innovations in the field Includes numerous compelling case studies of materials failure in oil and gas pipelines and drilling platforms

This book contains analysis of reasons that cause products to fail. General methods of product failure evaluation give powerful tools in product improvement. Such methods, discussed in the book, include practical risk analysis, failure mode and effect analysis, preliminary hazard analysis, progressive failure analysis, fault tree analysis, mean time between failures, Wohler curves, finite element analysis, cohesive zone model, crack propagation kinetics, time-temperature collectives, quantitative characterization of fatigue damage, and fracture maps. Methods of failure analysis are critical to for material improvement and they are broadly discussed in this book. Fractography of plastics is relatively a new field which has many commonalities with fractography of metals. Here various aspects of fractography of plastics and metals are compared and contrasted. Fractography application in studies of static and cycling loading of ABS is also discussed. Other methods include SEM, SAXS, FTIR, DSC, DMA, GC/MS, optical microscopy, fatigue behavior, multiaxial stress, residual stress analysis, punch resistance, creep-rupture, impact, oxidative induction time, craze testing, defect analysis, fracture toughness, activation energy of degradation. Many references are given in this book to real products and real cases of their failure. The products discussed include office equipment, automotive compressed fuel gas system, pipes, polymer blends, blow molded parts, layered, cross-ply and continuous fiber composites, printed circuits, electronic packages, hip implants, blown and multilayered films, construction materials, component housings, brake cups, composite pressure vessels, swamp coolers, electrical cables, plumbing fittings, medical devices, medical packaging, strapping tapes,

balloons, marine coatings, thermal switches, pressure relief membranes, pharmaceutical products, window profiles, and bone cements.

Fractography in Failure Analysis of Polymers provides a practical guide to the science of fractography and its application in the failure analysis of plastic components. In addition to a brief background on the theory of fractography, the authors discuss the various fractographic tools and techniques used to identify key fracture characteristics. Case studies are included for a wide range of polymer types, applications, and failure modes, as well as best practice guidelines enabling engineers to apply these lessons to their own work. Detailed images and their appropriate context are presented for reference in failure investigations. This text is vital for engineers who must determine the root causes of failure when it occurs, helping them further study the ramifications of product liability claims, environmental concerns, and brand image. Presents a comprehensive guide to applied fractography, enabling improved reliability and longevity of plastic parts and products Includes case studies that demonstrate material selection decisions and how to reduce failure rates Provides best practices on how to analyze the cause of material failures, along with guidelines on improving design and manufacturing decisions

Offering top-to-bottom coverage of this rapidly developing field; this book encompasses breakthrough techniques and technologies for both components and systems reliability testing; performance evaluation; and liability avoidance. -- Handbook of Materials Failure Analysis: With Case Studies from the Chemicals, Concrete and Power Industries provides an in-depth examination of materials failure in specific situations, a vital component in both developing and engineering new solutions. This handbook covers analysis of materials failure in the chemical, power, and structures arenas, where the failure of a single component can result in devastating consequences and costs. Material defects, mechanical failure as a result of improper design, corrosion, surface fracture, and other failure mechanisms are described in the context of real world case studies involving steam generators, boiler tubes, gas turbine blades, welded structures, chemical conversion reactors and more. This book is an indispensable reference for engineers and scientists studying the mechanisms of failure in these fields. Introduces readers to modern analytical techniques in materials failure analysis Combines foundational knowledge with current research on the latest developments and innovations in the field Includes many compelling case studies of materials failure in chemical processing plants, concrete structures, and power generation systems

This textbook covers the important steps in conducting a failure analysis, without boring the student to death. A material failure is defined as a part breaking unexpectedly. The part can be metal, plastic, ceramic or glass, and by breaking we mean that there is a fracture face or a damaged surface to examine. Failure analysis is the science of determining how and why the part broke. An accurate failure analysis is key to making a better product. If one does not understand why

a part failed, then it is only guesswork as to how to fix it. Failure analysis of materials is a multi-disciplinary field because it requires people skills in asking the right questions, engineering skills in calculating the stresses, and metallurgical skills in understanding the alloys and interpreting the micrographs. The final skill is writing a comprehensive report. These topics and more are covered in this book.

Detailed analyses of failures of material components have proved to be valuable in many ways; by preventing further failures, by assessing the validity of designs and the selection of materials, by uncovering shortcomings in the processing of the materials involved through characterizations of defects, and by revealing problems introduced during the manufacture or fabrication of the component. Increased recognition of the value of performing failure analyses has caused the field to develop into a very active area of technical endeavor. Failure analysis has been employed in numerous different technical disciplines and has proven beneficial. The increased activity has caused many new and improved methods for performing these analyses to be developed. Among these are many methods which can be characterized as generally belonging to the field of metallography. In recognition of the important role that metallography plays in the performance of failure analyses, the absence of a text that specifically discusses this subject, and the belief that communication of information on the subject would be of technical interest, The American Society for Metals and The International Metallographic Society co-sponsored a symposium. The intent was to bring together world-recognized authorities working in various aspects of the failure analysis and metallographic fields to share methods they use, results they have obtained, and the purposes to which they utilized these results. The symposium, entitled "Metallography in Failure Analysis", was held in Houston, Texas, USA, July 17-18, 1977.

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