20--DESURGER ASSEMBLY,F

Buyer: NAVSUP WEAPON SYSTEMS SUPPORT MECH

Description:
CONTACT INFORMATION|4|N743.7|WVE|717-605-3875|jill.sabol@navy.mil|
ITEM UNIQUE IDENTIFICATION AND VALUATION (MAR 2016)|19||||||||||||||||||
HIGHER-LEVEL CONTRACT QUALITY REQUIREMENT (NAVICP REVIEW FEB 1991)(FEB 1999)|1|See specification section C |
INSPECTION OF SUPPLIES--FIXED-PRICE (AUG 1996)|2|||
INSPECTION AND ACCEPTANCE - SHORT VERSION|8|X||X||||||
GENERAL INFORMATION-FOB-DESTINATION|1|B|
WIDE AREA WORKFLOW PAYMENT INSTRUCTIONS (DEC 2018)|16|Material - Invoice & Receiving Report (COMBO) Certifications - Stand-Alone Receiving Report |Material - Inspection & Acceptance at SOURCE Certifications - Inspection at DESTINATION & Acceptance at OTHER |TBD|N00104|TBD|Certifications - N39040; Material -S4306A |N50286|TBD|133.2|N/A|N/a|Certifications - N39040|N/A|N/A|See DD Form 1423|PORT_PTNH_WAWF_Notification@navy.mil|
NAVY USE OF ABILITYONE SUPPORT CONTRACTOR - RELEASE OF OFFEROR INFORMATION (3-18))|1||
EQUAL OPPORTUNITY (SEP 2016)|2|||
WARRANTY OF SUPPLIES OF A NONCOMPLEX NATURE (JUNE 2003)|6|one year from the date of delivery |one year from the date of delivery |||||
WARRANTY OF DATA--BASIC (MAR 2014)|2|||
FIRST ARTICLE APPROVAL--GOVERNMENT TESTING (SEP 1989)|7|1|0001AC|270|N50286|120|x||
AUTHORIZED DEVIATIONS IN CLAUSES (NOV 2020)|2|||
NOTICE OF TOTAL SMALL BUSINESS SET-ASIDE (OCT 2020)(DEVIATION 2020-O0008)|1||
ALTERNATE A, ANNUAL REPRESENTATIONS AND CERTIFICATIONS (NOV 2020)|13|||||||||||||
ANNUAL REPRESENTATIONS AND CERTIFICATIONS (JAN 2022)|13|336612|1000||||||||||
NOTICE OF PRIORITY RATING FOR NATIONAL DEFENSE, EMERGENCY PERPARDENESS, AND ENRGY PROGAM USE (APRIL 2008))|2||x|
EVALUATION OF FIRST ARTICLE TESTING|3|x|TBD||
EVALUATION CRITERIA AND BASIS FOR AWARD-|1||
1. THIS SOLICITATION IS BEING ISSUED UNDER SPECIAL EMERGENCY PROCUREMENT AUTHORITY.
2. The resultant award of this solicitation will be issued bilaterally, requiring the contractor's written acceptance prior to execution.
3. Any contract/order awarded as a result of this solicitation will be a "DO" rated order certified for national defense use under the Defense Priorities and Allocations System (DPAS). See 52.211-14, Notice of Priority Rating for National Defense, Emergency
Preparedness, and Energy Program Use.
4. Vendors submitting quality manuals shall submit them to jill.sabol@navy.milinstead of 0243.QAMANUAL@navy.mil. Per WSSTERMLZ02, offerors are cautioned that this procurement will not be delayed solely for approving additional sources. DD 1423 Data Item
A001 (Inspection and Test Plan) may be waived if already on file at NAVSUP WSS Mechanicsburg.
5. Consistent with FAR 52.216-18, "All contractual documents (i.e. contracts, purchase orders, task orders, delivery orders and modifications) related to the instant procurement are considered to be "issued" by the Government when copies are either deposited
in the mail, transmitted by facsimile, or sent by other electronic commerce methods, such as email. The

Government's acceptance of the contractor's proposal constitutes bilateral agreement to "issue" contractual documents as detailed herein.
6. NAVSUP WSS Mech will be considering past performance in the evaluation of offers. See Clauses DFARS 252.213-7000 and WSSTERMMZ01.
7. Available drawings and additional documents can be accessed through SAM.gov.
8. This procurement requires First Article Testing (FAT), process control plan, qualificaiton testing, welding procedures, brazing procedures, and a forging manufacturing sketch.
9. The following delivery schedule will apply:
PROCESS CONTROL PLAN 60 DAYS ADC
PROCESS CONTROL PLAN REVIEW/APPROVAL 180 DAYS AFTER RECEIPT or
60 DAYS AFTER RECEIPT IF PRIOR APPROVAL SUBMITTED
QUALIFICATION TEST 60 DAYS ADC
QUALIFICATION TEST REVIEW/APPROVAL 180 DAYS AFTER RECEIPT or
60 DAYS AFTER RECEIPT IF PRIOR APPROVAL SUBMITTED
FORGING MANUFACTURING SKETCH 90 DAYS ADC
FORGING MANUFACTURING SKETCH REVIEW/APPROVAL 120 DAYS AFTER RECEIPT
WELD PROCEDURE AND QUAL DATA 120 DAYS ADC
APPROVAL OF WELD PROCEDURES AND QUAL DATA 90 DAYS AFTER RECEIPT
BRAZING PROCEDURE AND QUAL DATA Prior to brazing
APPROVAL OF BRAZING PROCEDURES AND QUAL DATA 90 DAYS AFTER RECEIPT
FAT REPORT 270 DAYS ADC
APPROVAL OF FAT REPORT 120 DAYS AFTER RECEIPT
Submission of all other form 1423 certification data (CDRLs) will be on or before 20 days prior to delivery. PNSY review/acceptance of CDRLs shall be 6 working days after receipt of CDRLs. Final delivery of material will be on orbefore 999 days after the
effective date of the contract.
10. THE FOLLOWING CLAUSE IS HEREBY INCORPORATED:
CONTRACT CLAUSE FOR PROTECTION OF NAVAL NUCLEAR PROPULSION INFORMATION
During the performance of this contract Naval Nuclear Propulsion Information (NNPI (NOFORN)) may be developed or used. Naval Nuclear Propulsion Information is defined as that information and/or hardware concerning the design, arrangement, development,
manufacturing, testing, operation, administration,training, maintenance, and repair of the propulsion plants of Naval Nuclear Powered Ships, including the associated shipboard and shore-based nuclear support facilities. Appropriate safeguards must be proposed by the contractor, and approved by the Contracting Officer for Security for the safeguarding from actual, potential, or inadvertent release by the contractor, or any subcontractor, of any NNPI (NOFORN) in any form,
classified or unclassified. Such safeguards shall ensure that only governmental and contractor parties, including subcontractors that have an established need-to-know, have access in order to perform work under this contract, and then only under
conditions which assure that the information is properly protected. Access by foreign nationals or immigrant aliens is not permitted. A foreign national or immigrant alien is defined as a person not a United States citizen or a United States national.
United States citizens representing a foreign government, foreign private interests or other foreign nationals, are considered to be foreign nationals for industrial security purposes and the purpose of this restriction.
In addition, any and all issue or release of such information beyond such necessary parties, whether or not ordered through an administrative or judicial tribunal, shall be brought to the attention of the Contracting Officer for Security.
The Contracting Officer for Security shall be immediately notified of any litigation, subpoenas, or requests which either seek or may result in the release of NNPI (NOFORN).
In the event that a court or administrative order makes immediate review by the Contracting Officer for Security

impractical, the contractor agrees to take all necessary steps to notify the court or administrative body of the Navy's interest in
controlling the release of such information through review and concurrence in any release.
The Contracting Agency reserves the right to audit contractor facilities for compliance with the above restrictions.
Exceptions to these requirements may only be obtained with prior approval from the Commander, Naval Sea Systems Command (SEA 09B2). Additional guidance may be obtained from NAVSEA Instruction 5511.32
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1. SCOPE
1.1 The material covered in this contract/purchase order will be used in a crucial shipboard system. The use of incorrect or defective material would create a high probability of failure resulting in serious personnel injury, loss of life, loss of vital
shipboard systems, or loss of the ship itself. Therefore, the material has been designated as SPECIAL EMPHASIS material (Level I, Scope of Certification, or Quality Assured) and special control procedures are invoked to ensure receipt of correct material.
2. APPLICABLE DOCUMENTS
2.1 Order of Precedence - In the event of a conflict between the text of this contract/purchase order and the references and/or drawings cited herein, the text of this contract/purchase order must take precedence. Nothing in this contract/purchase order,
however, must supersede applicable laws and regulations unless a specific exemption has been obtained.
2.2 Applicable Documents - The document(s) listed below form a part of this contract/purchase order including modifications or exclusions.
2.2.1 Specification Revisions - The specification revisions listed under "Documents References" below are the preferred revision. Older and/or newer r evisions are acceptable when listed within Contract Support Library Reference Number CSD155 in ECDS (Electric
Contractor Data Submission) at: ht tps://register.nslc.navy.mil/. This is to allow Contractors to use certain acceptable older specification revisions to purge their existing stock of material certified to those older revisions or to use newer specification
revisions when material is certified to newly released revisions,without requiring the submittal of waiver/deviation requests for each specification revision on every contract. Revisions of specifications reflecting editorial and/or re-approval (e.g. E2009,
R2014, etc.) are considered inconsequential, but are acceptable when their revisions are listedwithin CSD155 or elsewhere within this contract.
2.2.2 Documents, drawings, and publications supplied are listed under "Drawing Number". These items should be retained until an award is made.
2.2.3 "Document References" listed below must be obtained by the Contractor. Ordering information is included as an attachment to this contract/purchase order.
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DOCUMENT REF DATA=ASTM-F606 | | | |191115|A| | |
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DOCUMENT REF DATA=ASTM-E1417 | | | |160615|A| | |
DOCUMENT REF DATA=ASTM-E1444 | | | |160601|A| | |
DOCUMENT REF DATA=ASME-B18.3 | | | |120101|A| | |
DOCUMENT REF DATA=MIL-STD-2035 | | |A |950515|A| | |
DOCUMENT REF DATA=ASTM-D4066 | | | |130701|A| | |
DOCUMENT REF DATA=ISO_9001 | | | |081115|A| | |
DOCUMENT REF DATA=ISO10012 | | | |030415|A| | |
DOCUMENT REF DATA=ISO/IEC 17025 | | | |050515|A| | |
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DOCUMENT REF DATA=QPL 25027 | | |17 |000207|A| | |
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DOCUMENT REF DATA=MIL-STD-45662 | | |A |880801|A| | |
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DOCUMENT REF DATA=SAE AMS-QQ-S-763 | | |D |150301|A| | |
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DOCUMENT REF DATA=AIA/NAS NASM 17828 | | |1 |130430|A| | |
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DOCUMENT REF DATA=S9074-AR-GIB-010A/278 (CHG A) | | | |130214|A| | |
DOCUMENT REF DATA=T9074-BD-GIB-010/0300 | | |2 |121218|A| | |

3. REQUIREMENTS

3.1 ;Desurger assembly FWD to be in accordance with Naval Sea System Command drawing 6985426 Part A3 and all EB ERs invoked in this contract, except as amplified or modified herein.;

3.2 Material for Parts Requiring Certification - Quantitative chemical and mechanical analysis is required for the parts listed below unless specifically stated otherwise:
Part - ;Head Desurger, part 3-1;
Material - ;T9074-BD-GIB-010/0300, Grade HY-80, Forged, Appendix E;
Part - ;Tailpiece FWD Part 3-2;
Material - ;SAE AMS-QQ-S-763, CL 304, COND A;
Part - ;Bushing part 6-1;
Material - ;ASTM-B150 UNS C63200, TQ50 OR TQ55;
Part - ;Barrel Part 22;
Material - ;ASTM-B564 forged, UNS N06625, Condition Annealed and meeting the mechanical properties of General note 7006. Chrome plated in accordance with General Note 7021;
Part - ;Piston Part 23;
Material - ;SAE AMS-QQ-A-250/11, Alloy 6061, Temper T651 or ASTM B209, Alloy 6061, Temper T651. Anodized in accordance with General Note 2221;
Part - ;Rod Tie Part 24;
Material - ;ASTM-A193 GRADE B7;
Part - ;Rod piston Part 25;
Material - ;SAE-AMS- QQ-A-200/8 Alloy 6061, Temper T6 anodized in accordance with General Note 2221 and plated in accordance with General Note 7202;
PART - ;Nut, Self-locking Part 78;
MATERIAL - QQ-N-281, class A annealed (hot finished or cold drawn) or class B cold drawn. All material must be from the same class.
SELF-LOCKING ELEMENT- ASTM-D4066, Group 01, Class 1 or 2, Grade 1
Part - ;Self Locking Cap Screw, Part 79;
Material - ;MIL-DTL-1222, Type II, QQ-N-286, Solution Annealed and Age Hardened and marked .K. Self-locking element to be in accordance with MIL-DTL-18240. Cross drill 2 holes IAW ANSI-B18.3;
3.3 Testing Certification - Certifications are required for the following tests on the items listed below. Additional testing on other piece parts (if any) per applicable drawings is still required, but certifications are only required as listed below.
Test - 5x Visual Magnification or Dye Penetrant Inspection (root layer)
Item - Weldments
Performance - T9074-AS-GIB-010/271
Acceptance - MIL-STD-2035
Test - Visual and Dye Penetrant Inspection (final layer)
Item - Weldments
Performance - T9074-AS-GIB-010/271
Acceptance - MIL-STD-2035
Test - ;Ultrasonic Inspection;
Item - ;Bushing part 6-1(with a diameter or minimum distance between parallel surfaces of 4 inches or greater of the starting material);
Performance - ;T9074-AS-GIB-010/271;
Acceptance - ;General Note 125 of drawing 6985426;
Test - ;Ultrasonic Inspection;
Item - ;Barrel Part 22 (starting material);
Performance - ;EB-2937, paragraph 4.5.4;
Acceptance - ;EB-2937, paragraph 4.5.4;
Test - ;Ultrasonic Inspection;
Item - ;HY-80 Forged Material;
Performance - ;T9074-BD-GIB-010/300 Appendix E;

Acceptance - ;T9074-BD-GIB-010/300 Appendix E;
Test - ;Magnetic Particle Inspection;
Item - ;HY-80 Forged Material;
Performance - ;T9074-BD-GIB-010/300 Appendix E;
Acceptance - ;T9074-BD-GIB-010/300 Appendix E;
Test - Quality Conformance/Compliance Inspection
Item - ;HY-80 starting material;
Performance - ;T9074-BD-GIB-010/300, Appendix E;
Acceptance - ;T9074-BD-GIB-010/300, Appendix E;
Test - Intergranular Corrosion Test (Only for SAE-AMS-QQ-S-763, Classes 304-condition A, 304L, 316-condition A, 316L, 317-condition A, 321 and 347 material. Test must be performed prior to fabrication/machining)
Item - ;Tailpiece, Part 3-2;
Performance - SAE-AMS-QQ-S-763
Acceptance - SAE-AMS-QQ-S-763
Test - ;Liquid Penetrant Inspection;
Item - ;Rod Tie Part 24;
Performance - T9074-AS-GIB-010/271; Sampling must be per MIL-DTL-1222
Acceptance - MIL-DTL-1222
Test - ;Dye Penetrant Inspection for Non-Magnetic Grades;
Item - ;Nut Self locking Part 78;
Performance - T9074-AS-GIB-010/271 or ASTM-E1417/ASTM-E1444
(Method C solvent removal techniques must not be used on thread)
Acceptance - ;NASM25027;
Test - Quality Conformance Tests
Item - Self-Locking Nuts
Performance - ;NASM25027;
Acceptance - ;NASM25027;
Attribute - Certificate of Completion
Item - Self-Locking Nut Nonmetallic Insert
Performance - ;ASTM-D4066, Group 01, Class 1, Grade 1;
Attribute - Certificate of Compliance
Item - Self-Locking Nuts
Performance - This Certificate must state that self-locking nuts were manufactured by an approved source. Approved sources are those listed on QPL-25027 for the appropriate fastener. This QPL may also be considered as approved sources for Heavy Hex
self-locking nuts.
Test - ;Liquid Penetrant Inspection;
Item - ;Screw Cap Self Locking Part 79;
Performance - T9074-AS-GIB-010/271; Sampling must be per MIL-DTL-1222
Acceptance - MIL-DTL-1222
Attribute - Annealing and Age Hardening
Item - ;Screw Cap Self Locking Part 79;
Performance - QQ-N-286
Test - ;Hydrostatic Test;
Item - ;Each Assembly;
Performance - ;Note 7400 of drawing 6985426;
Acceptance - ;Note 7400 of drawing 6985426;
3.4 The pressure tolerance must be as specified in the assembly drawing, detail drawing, design specification or

elsewhere in this contract. Where pressure tolerances are not provided by drawings, specifications or specified elsewhere in this contract, the
following must be used:
For pressure tests below 100 PSIG, the pressure tolerance must be +1 PSIG/-0PSIG.
For pressure tests at or above 100 PSIG up to and including 2500 PSIG, the pressure tolerance must be +2% / -0 PSIG rounded off to the nearest multiple of thesmallest graduation on an analog test pressure gauge, not to exceed 50 PSIG.
30 minutes / - 0 minutes. above 2500 PSIG, the pressure tolerance must be +2%/-0 PSIG, rounded off to the nearest multiple of the smallest graduation on an analog test pressure gauge, not to exceed 200 PSIG.
The pressure test time tolerance must be as specified in the assembly drawing, detail drawing, design specification or elsewhere in this contract. Where pressure test time tolerances are not provided by drawings, specifications or specified elsewhere in
this contract, the following must be used:
For a test duration up to and including 1 hour, the tolerance must be +5 minutes / - 0 minutes.
For a test duration of more than 1 hour up to and including 24 hours, the tolerance must be +30 minutes / - 0 minutes.
For a test duration of more than 24 hours, the tolerance must be + 60 minutes/- 0 minutes.
3.5 O-ring grooves and mating sealing surfaces must be inspected per the contractually invoked drawings or specifications. When the drawings or specifications do not provide specific defect criteria or state that no defects are allowed, the General Acceptance
Criteria (GAC) standard must be used for inspecting O-ring grooves and mating sealing surfaces only. Repairs to sealing surfaces and O-ring grooves with unacceptable defects may be accomplished within the limits of the size and tolerances provided in the
applicable drawing. Repairs thatwould exceed these limits require approval (including final dimensions). The data that is red lined (crossed out) is excluded from the GAC for this contract and is not to be used for acceptance or rejection criteria. The GAC
document is identified as Contract Support Library Reference Number CSD008 at https://register.nslc.navy.mil/
3.6 K-MONEL Fasteners - Material must be heat treated per QQ-N-286.
3.6.1 Fasteners that have been hot or cold headed or roll threaded must be solution annealed followed by age hardening subsequent to all heading and thread rolling operations. The mechanical properties on certifications must be actual properties of the
annealed and age hardened material and must meet the requirements of QQ-N-286.
3.6.2 QQ-N-286 fasteners that have been headed and/or roll threaded must not beage hardened unless the material has been solution annealed subsequent to the heading and threading operations. Threads formed after the final age hardening heat treatment must be
cut or ground only.
3.7 Internal Threads - All internal threads must be formed by cutting. Cold forming of internal threads is not acceptable.
3.8 K-MONEL Fasteners - K-MONEL externally threaded fasteners must have mechanical properties determined in accordance with MIL-DTL-1222. Test results must include Tensile, Yield, Elongation and Hardness as required by MIL-DTL-1222. (The Hardness tests must be
performed on a full size fastener.)
3.8.1 Studs require an Axial Tensile test in accordance with MIL-DTL-1222.
3.8.2 Headed fasteners require a Wedge Tensile test as specified elsewhere in this contract/purchase order.
3.9 Slow Strain Rate Tensile Test Laboratories - The Slow Strain Rate Tensile Test of QQ-N-286 must be performed by one of the following laboratories:
Huntington Alloys, a Special Metals Company
Attn: Bill Bolenr
3200 Riverside Drive
Huntington, WV 257059

Phone: (304) 526-5889
FAX: (304) 526-5973
Metallurgical Consultants, Inc.
Attn: W. M. Buehler
4820 Caroline
PO Box 88046
Houston, TX 77288-0046
Phone: (713) 526-6351
FAX: (713) 526-2964
Naval Surface Warfare Center, Carderock Division
Attn: Eric Focht Code 614
9500 Macarthur Blvd
West Bethesda, MD 20817-5700
Phone: (301) 227-5032
FAX: (301) 227-5576
Teledyne Allvac
Attn: Dr. W. D. Cao
2020 Ashcraft Ave.
Monroe, NC 28110
Phone: (704) 289-4511
FAX: (704) 289-4269
Westmoreland Mechanical Testing and Research Inc.
Attn: Andrew Wisniewski
P.O. Box 388
Youngstown, PA 15696-0388
Mannesmann Rohrenwerke
Mannesmann Forschungsinstitut (MFI)
Attn: Dr. Weiss
Postfach 251160
47251 Duisburg
Germany
Phone: 011-49-0203-9993194
FAX: 011-49-0203-9994415
ThyssenKrupp VDM USA, Inc.
Attn: D. C. Agarwal
11210 Steeplecrest Drive, Suite 120
Houston, TX 77065-4939
Phone: (281) 955-6683
3.10 Certification is required for the following as identified further below:
- Process Control Plan
- Qualification Plan
- Qualification Testing (First Article)
All manufacturing facilities which have been approved to an earlier revision of this specification are required to meet the recertification requirements of T9074-BD-GIB-010/0300 Revision 2. An updated Process Control Plan incorporating any changes necessary to
meet the requirements of T9074-BD-GIB-010/0300 Revision 2 must be submitted.
Re-certification of the first article approval of vendor facilities, processes, and manufacturing methods is required every 5 years and must meet all the requirements of T9074-BD-GIB-010/0300. The certification must be current at the delivery date of procured

products.
3.10.1 Qualification Testing (First Article Inspection) - See DI-NDTI-80809 (First Article Test Report) - Certification is required for the following test on the items listed below:
Test - First Article Inspection
Item - ;HY-80 starting material;
Performance - T9074-BD-GIB-010/0300
Acceptance - T9074-BD-GIB-010/0300
Previous FAT approvals that were based upon previous specifications are not valid for meeting the requirements of T9074-BD-GIB-010/0300 Revision 2, unless otherwise approved by NAVSEA.
The Contractor may request the FAT submission requirement be waived by providing the PCO with evidence of NAVSEA approval, provided it meets the requirements of this contract/purchase order.
3.10.2 Process Control Plan - See DI-NDTI-80809 (Process Control Plan) - Certification is required for the following attribute on the items listed below:
Attribute - Process Control Plan
Item - ;HY-80 starting material;
Performance - T9074-BD-GIB-010/0300
The PCP must be reviewed and approved by NAVSEA prior to initiating First Article Testing. The Contractor may request the PCP submission requirement be waived by providing the PCO with evidence of NAVSEA approval.
3.10.3 Qualification Plan - See DI-NDTI-80809 (Qualification Plan) - Certification is required for the following attribute on the items listed below:
Attribute - Qualification Plan
Item - ;HY-80 starting material;
Performance - T9074-BD-GIB-010/0300
The QP must be reviewed and approved by NAVSEA prior to initiating First Article Testing. The Contractor may request the QP submission requirement be waived by providing the PCO with evidence of NAVSEA approval.
3.11 ;See CDRL DI-FORG-80412 (Forging Manufacturing Sketches) Forging Sketches are required for the Head Desurger, Part 3-1, per T9074-BD-GIB-010-0300, Appendix E.;
3.12 Wedge Tensile Test Specimens (Headed fasteners) - A wedge tensile test must be conducted on a Full Size Fastener for each production lot and reported aspart of the Mechanical Properties. The required specimens for the Wedge Tensile Test must be separate
fasteners from those required for the Yield Test.
3.12.1 Testing for Socket Head Cap Screws must be in accordance MIL-DTL-1222, paragraphs 4.5.2.3 and 4.5.2.3.1.
3.12.2 Testing for all other Headed Fasteners with a nominal diameter greater than 1/4-inch must be in accordance with ASTM-F606 for grades 5, 8, B7, and B16.For all other grades, the following wedge angles must be used.
a. Except as specified in item c below, fasteners with a nominal diameter of 1/4-inch through 1-inch (inclusive) must be tested with a ten degree wedge.
b. Except as specified in item c below, fasteners with a nominal diameter over 1-inch must be tested with a six degree wedge.
c. Fasteners that are of grades 8, B7, B16, 410, 416, 416Se, 431, and 630 and are threaded within one diameter to the underside of the head must be tested as follows:
Sizes 1/4 inch through 3/4 inch (inclusive) Use a six degree wedgeSizes over 3/4 inch Use a four degree wedge
d. Fasteners which have passed testing with wedge angles greater than those specified should be considered acceptable.
3.12.3 For fasteners having a length less than the minimum specified in Table 1 of ASTM-F606, one "test specimen fastener" must be manufactured from each lot of fasteners and tested to represent that lot. The length of these test specimen fasteners must meet

the minimum specified in table 1 of ASTM-F606 but must not exceed it by more than 1/4 inch. Test specimen fasteners must be the same type, style, and diameter as the production lot and must be manufactured from the same starting material, using the same
manufacturing techniques as the production lot, and must be heat treated (if required) along with the production lot.
3.13 Thread Inspection Requirements - All threads on threaded parts must be inspected using appropriate inspection methods, inspection systems, and inspection gages/instruments in accordance with FED-STD-H28 series. Substitution of thecommercial equivalent
inspection in accordance with ASME B1 series is acceptable.
3.13.1 System 21 of FED-STD-H28/20 must be used as a minimum inspection requirement for threads when the design drawing or design specification does not specify an inspection requirement.
3.13.2 For Navy and Shipyard drawings, system 21 of FED-STD-H28/20 may be substituted for System 22 without further Navy approval when the design drawing invokes System 22 and does not cite governing specifications that specifically require system 22. System
22 of FED-STD-H28/20 must be used when the drawing references other governing specifications that specifically require System 22, such as certain thread types of MIL-DTL-1222.
3.13.3 A written request for concurrence must be submitted when utilizing alternative measuring equipment or measuring systems not applicable to the specified inspection system.
3.14 Specification Change - For QQ-N-281, Class B material:
1 - Footnote 9 to Table II of QQ-N-281 does not apply.
2 - When starting material is Round Bar greater than 3" dia,
the mechanical properties of Hex Bar apply.
3.15 Welding or Brazing - When welding, brazing, and allied processes are required, as invoked by Section C paragraph 3 requirements, they must be in accordance with S9074-AR-GIB-010A/278, (S9074-AQ-GIB-010/248 for brazing) by personnel and procedures
qualified under S9074-AQ-GIB-010/248 for all production and repair welding and brazing. Procedures and Qualification Data must be submitted for review and approval prior to performing any welding or brazing.
3.16 Certificate of Compliance - (SPECIAL EMPHASIS MATERIAL) The Contractor must prepare and submit a certificate of compliance certifying that the items/components furnished under this contract comply with the requirements of the procurement document,
including any/all invoked specifications and drawings.
3.17 Configuration Control - The Contractor must maintain the total equipment baseline configuration. For items of proprietary design, Contractor drawings showing the latest assembly configuration must be provided to the Government in electronic (C4) format.
Definitions are provided elsewhere in the Contract/Purchase Order.
3.17.1 Waivers/Deviations - All waivers and deviations, regardless of significance or classification require review and approval by the Contracting Officer. Waivers and Deviations must be designated as Critical, Major, or Minor. The Contractor must provide
a copy of this request to the QAR. Requests must include the information listed below.
a. A complete description of the contract requirement affected
and the nature of the waiver/deviation (non-conformance),
including a classification of Critical, Major, or Minor.
b. Number of units (and serial/lot numbers) to be delivered in this
configuration.
c. Any impacts to logistics support elements (such as software,
manuals, spares, tools, and similar) being utilized by Government
personnel or impacts to the operational use of the product.
d. Information about remedial action being taken to prevent reoccurrence
of the non-conformance.
3.17.2 All requests for Waivers/Deviations on NAVSUP-WSS Contracts must be submitted using the ECDS

(Electronic Contractor Data Submission) system at https://register.nslc.navy.mil/
3.17.3 ECPs - The Government will maintain configuration control and change authority for all modifications or changes affecting form, fit, function, or interface parameters of the Equipment and its sub-assemblies. The Contractor must submit an Engineering
Change Proposal (ECP) for any Class I or II changes that impact the Equipment covered by this contract. ECPs must be prepared in Contractor format, and must include the following information:
a. The change priority, change classification (Class I or Class II),
and change justification.
b. A complete description of the change to be made and the need for
that change.
c. A complete listing of other Configuration Items impacted by the
proposed change and a description of the impact on those CIs.
d. Proposed changes to documents controlled by the Government.
e. Proposed serial/lot number effectivities of units to be
produced in, or retrofitted to, the proposed configuration.
f. Recommendations about the way a retrofit should be accomplished.
g. Impacts to any logistics support elements (such as software,
manuals, spares, tools, and similar) being utilized by Government
personnel in support of the product.
h. Impacts to the operational use of the product.
i. Complete estimated life-cycle cost impact of the proposed change.
j. Milestones relating to the processing and implementation of the
engineering change.
3.18 Mercury Free - Mercury and mercury containing compounds must not be intentionally added or come in direct contact with hardware or supplies furnished under this contract. Mercury contamination of the material will be cause for rejection.
3.19 NAVSEA 0948-LP-045-7010 - Any applicable requirements of NAVSHIPS 4410.17,NAVSEA 0948-LP-045-7010, or 0948-045-7010 which the contractor must meet are included in this contract/purchase order. The above documents are for GovernmentUse Only. Further
application of the above documents is prohibited.prohibited.
3.19.1 Marking of material with a Material Designator per the Drawing is also prohibited, with the exception of Fasteners. Fasteners must be marked with a Material Symbol/Designator as specified elsewhere in this contract.
^ QUALITY ASSURANCE REQUIREMENTS ^
3.20 See CDRL DI-MISC-80678 (Test Certification) - A statement of tests performed, listing the pieces tested must be furnished along with a copy of the test results. Certification must include the contractor's name, address and date, quantity inspected,
identified to the contract/purchase order and item number, and the Contractor's or authorized personnel's signature. Test certifications must reference the standard/specification, including the revision, to which the testing was performed and the acceptance
criteria used. Test procedure numbers may also be referenced on test reports. Test reports on weldments must be identified to weld joint and layer.
3.21 Additional Marking for Fasteners - Fasteners must be marked in accordance with ;MIL-DTL-1222, except the Self-Locking Hex Nuts must be marked in accordance with NASM 17828. NASM 17828 Nuts must be marked on the wrenching surface with the manufacturer's
identification symbol, material symbol and heat/lot traceability code; . The method of marking must be types I, II, III, V, VIII or IX of MIL-STD-792 except for grades 410, 416 and 431 in the H condition and grades 8, 630, A574, and 4340 which must be marked
by method II when marking is applied after the final heat treatment. Markings on fasteners that are to be coated must be marked prior to coating and have a minimum depth of 4 mils. Traceability marking must be legible after the application of protective

compounds.
3.21.1 Marking is required for all fasteners regardless of size and must include the material symbol, the manufacturer's identification symbol, and the traceability marking. Marking must be applied on the head of headed fastener (top preferred, side
location if necessary). Self-Locking screws must also be marked with six dots. Where no contract invoked specification requirement exists for this marking, self-locking fasteners must be marked with six dots approximately .032" diameter, raised or depressed
by approximately .010" located on the top perimeter of the head of the fastener in an arc or circular pattern. The six dots must be distinguishable from all other required markings.
3.22 See CDRL DI-MISC-80678 (Special Emphasis C of C) - The certificate of compliance must show traceability to the marking applied on each individual item, and must contain the following information:
1. Contractor's name, address and date.
2. The contract/purchase order number (for example: N00104-11-P-FA12)
3. The National Stock Number (NSN). The 18 character National Stock Number for Special Emphasis Material includes the two digit COG, the four digit FSC, the 9 digit NIIN, and the two digit SMIC
(for example: 1H 4820 012345678 L1) ("N/A" when Not Applicable).
4. Lubricants, sealants, anti-seize, and/or thread locking compounds ("N/A" when Not Applicable).
5. Certification that O-rings, packing, gaskets, or other elastomeric products were installed in a compressed state within an assembly or sub-assembly, prior to expiration of the shelf life ("N/A" when Not Applicable).
6. Manufacturer's compound number ("N/A" when Not Applicable).
7. When weld procedure submittal is required by the contract, a statement that the approval date of the qualification data precedes any production or repair welding performed on this Contract. ("N/A" when Not Applicable).
8. A statement to the effect that all items furnished on this contract are in full compliance with the specifications and requirements and list each contractually invoked conformance/compliance test performed by name and that it was performed
satisfactorily.
9. Contractor's or authorized personnel's signature.
3.23 See CDRL DI-MISC-80678 (Special Emphasis C of C) - The certificate of compliance must show traceability to the marking applied on each individual item made to T9074-BD-GIB-010/0300, and must contain the following information:
1. Contractor's name, address and date.
2. The contract/purchase order number (for example: N00104-11-P-FA12).
3. The national stock number (NSN). The 18 character National Stock Number for Special Emphasis Material includes the two digit COG, the four digit FSC, the 9 digit NIIN, and the two digit SMIC (for example: 1H 4820 012345678 L1) ("N/A" when Not Applicable).
4. The revision of the Process Control Plan used and the date of most recent first article approval or recertification.
5. Actual data of specified chemical and mechanical tests and a record of the final heat treatment (if applicable).
6. Qualitative results of nondestructive tests and other inspections or tests.
7. The melt processes used and the melting source of the material if the Contractor is not the melter.
8. A statement that each lot has been sampled, tested, and inspected in accordance with the specification requirements and that the manufacturer has maintained adequate manufacturing procedures demonstrated in first article testing as listed and maintained as
specified in paragraph 4.3.2 of T9074-BD-GIB-010/0300 and quality assurance practices to produce a product that meets the chemical and mechanical property requirements specified throughout the product.
9. A statement that each lot meets all specification requirements.
10. Contractor's or authorized personnel's signature.
3.24 See CDRLs DI-MISC-80875 (welding procedures) and DI-MISC-80876 (weld procedure qualification data) - When production or repair welding is required, the applicable welding procedure(s) and qualification

data must be submitted for review and approval. In
addition, the CONSUMED WELD METAL C of C as defined below must be submitted as part of the certification OQE package submitted by the Contractor.
Note: These requirements do not apply to tack/spot welds.
3.24.1 Approval of the Contractor's qualification data must be obtained prior to performing any welding (production or repair).
3.24.2 If the Contractors qualification data has previously been approved by the Navy for other contracts, a copy of the original approval letter may be submitted along with the procedures and qualification data report to expedite the approval process. The
approval letter must reference the applicable welding procedure and qualification data report identification/number. Prior approval does not guarantee acceptance for this or any future contracts. As far as practical, all procedures for the contract must be
submitted at the same time. Welding procedures and qualification data must be submitted in a commercially available electronic format such as Adobe Acrobat PDF. The contractor must state the applicability of each weld procedure and qualification data submitted,
citing the drawing number and pieces to be welded. (i.e. "WP-123 and QD-123 are submitted for the weld joint between pieces 1 and 2 on drawing ABC." WP-456 and QD-456 are submitted for the hardfacing of piece 3 on drawing XYZ.")
3.24.3 The PCO's authorization for the use of weld procedure(s) and qualification data for the specific application as submitted does not mitigate the vendors responsibility to comply with the requirements of S9074-AQ-GIB-010/248, S9074-AR-GIB-010A/278, and
the contract.
3.24.4 Authority for the repair of Special Repairs in castings, the repair of wrought material, or the repair of forged material must be obtained via request for waiver from the Procurement Contracting Officer. This request must describe the defect; including
size, depth, location, and a description of the proposed repair. Repairs deemed minor or nominal in accordance with S9074-AR-GIB-010/278 can be made at contractor discretion in accordance with S9074-AR-GIB-010/278 requirements; however, Weld Procedure
Specification (WPS) and Procedure Qualification Record (PQR) submittals are still required. This request for NAVSUP-WSS Contracts must be submitted via the Electronic Contractor Data Submission (ECDS) application.
3.24.5 Any new procedure qualification performed under this Contract will require the vendor to provide a minimum 72 hour notification to DCMA with an offer to observe the welding of the test assemblies. The 72 hour time limit may be modified upon mutual
agreement between the vendor and DCMA.
3.24.6 When drawings require hardfacing surface Iron or Nickel content not to exceed 5%, the contractor must verify surface Iron or Nickel content by performing chemical testing as defined by the applicable drawing. The chemical test results must be submitted
as part of the qualification data.
3.24.7 Additional qualification requirements for production hardfacing thickness less than 1/8-inch: Macro-etch (or legible photomacrographs clearly showing the fusion area) must be submitted for review and show consistent, minimized dilution. All essential
elements and any elements not listed in S9074-AQ-GIB-010/248 that influence dilution must be in the qualification data and weld procedure, with strict limits placed on each essential element.
3.24.8 Preparation and retention of weld records is required, as specified by paragraph 4.1.3 of S9074-AR-GIB-010A/278.
3.24.9 When production or repair welding is required on titanium materials, the applicable fabrication plan, facilities procedure, training plan, and active welder qualification must also be submitted for review and approval.
3.24.10 If the contractor's fabrication plan, facilities procedure, training plan, or active welder qualification has

previously been approved by the Navy for other contracts, a copy of the original approval letter may be submitted along with the applicable
documentation to expedite the approval process. The approval letter must reference the applicable documentation. Prior approval does not guarantee acceptance for this or any future contracts. The contractor's fabrication plan, facilities procedure, training
plan, and active welder qualification must be submitted at the same time as the applicable welding procedure(s) and weld procedure qualification data. All documentation must be submitted in a commercially available electronic format, such as Adobe Acrobat PDF.
3.24.11 See CDRL DI-MISC-80678 (Consumed Weld Metal) - A Certificate of Compliance is required for all weld filler metals used for production or repair welding, and must include the following:
a) Filler Metal LOT number(s)
b) Specification and Type
c) A positive statement that the vendor has obtained OQE and verified that each LOT of weld filler material conforms to specification requirements.
d) A positive statement verifying that the weld filler metals were the correct material type or grade prior to consumption.
3.24.12 When production welds or repair welds are performed by a subcontractor, the requirement for submission of all certification documentation required herein must be passed down to the subcontractor.
3.25 See CDRLs DI-MISC-80875 (Brazing Procedures) and DI-MISC-80876 (Braze Proc Qual Data) - Prior to perfo

Country:
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Published date:
Apr 01 2022

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ocds-0c46vo-0421-937ffdb4b1dd41299138fd75be23468a

Saved on:
Apr 02 2022

Source ID:
937ffdb4b1dd41299138fd75be23468a

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