

12x56 MRC PERFORMANCE SPECIFICATIONS AND REQUIREMENTS-July 2003

Objectives

Phase I- Fabricate eight (8) tubes for inspection and First Article Testing per the provided technical drawings.

Phase II- Upon successful completion of First Article Testing, fabricate 100 tubes per technical drawing M1256004 and deliver to Pine Bluff Arsenal.

Design Requirements

Configuration: Each tube must meet the dimensional, material, and radiography requirements per drawing M1256004.

Performance: Each tube must pass First Article performance testing as designated by SBCCOM-RI. Performance will be validated on the prototypes by SBCCOM-RI.

Statement of Work

General: The contractor shall furnish the necessary services, labor, personnel, facilities, supplies, materials, and equipment (including fabrication machinery and quality assurance measurement devices) to perform the following manufacturing work.

Specific: Phase I: Fabricate Eight (8) Tubes for First Article Testing.
Contractor will complete the eight First Article items within 30 days of the contract award. Careful attention must be paid to achieving roundness of tubes and welds that are free of defects. Each tube will be radiographed for weld defects. If tubes pass inspection they will be delivered to Pine Bluff Arsenal at the address listed in section 4 of the Phase II requirements section. If not, contractor will repair or replace tubes entirely at their own expense. First Article testing will consist of a helium leak test by the government and will be completed within 45 days of receipt of FAT items at Pine Bluff Arsenal. Radiographs will be delivered to Rock Island Arsenal at the address listed in Section 3 of the Phase II requirements section.

Specific: Phase II: Manufacturing, Production, and Quality Assurance

1. The contractor shall, following successful First Article Test completion, commence production of 100 tubes for the 12x56 MRC program.
2. The contractor shall serialize each tube by marking in 1 inch high lettering using designated serial numbers 001-100 so each tube can be identified.

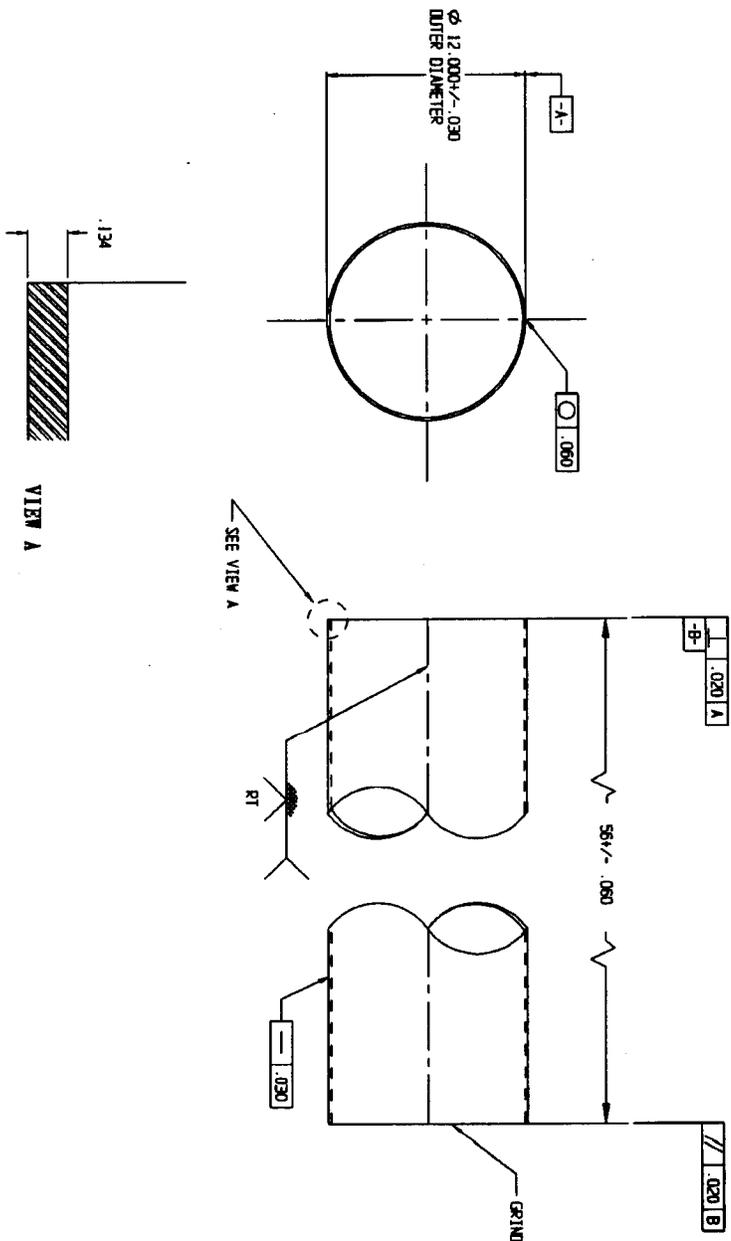
3. The contractor shall have 100% of items radiographed for weld defects, and will not deliver any tubes unless inspections are completed successfully. Contractor will produce radiographs and associated inspection documents, including material certifications for each item and send them to Attn: 12x56 MRC Program AMSSB-RSO-SDM Bldg 62 Rock Island Arsenal, Rock Island Illinois 61299. If quality inspections show that the items do not meet the requirements of the technical drawings, then the contractor will agree to rework those items until they meet specifications or replace the items entirely at the contractor's own expense.
4. The contractor shall deliver FOB destination no later than 120 days after Government First Article testing is completed, the 100 tubes to Pine Bluff Arsenal at the following address:

12x56 Multiple Round Container Project
ATTN: Herman Vaughn (x3260)
PBA Shipping and Receiving, Bldg. 23-330
Pine Bluff, Arkansas
71602

Friday, July 11, 2003 14:47:48

NOTES:

1. THIS DRAWING SHALL BE INTERPRETED IN ACCORDANCE WITH APPLICABLE STANDARDS LISTED IN DDD-STD-100, ANSI Y14.5-DATED 1994 APPLIES, AMS 2.4-86 APPLIES.
2. MATERIAL: STAINLESS STEEL, DE 304 PER ASTM A 240 TO GAUGE. HEAT TREATED, ROUND MECHANICAL TUBING PER ASTM A554-94, WELDED JMW.
3. TIG WELDED IN ACCORDANCE WITH AWS B2.1 009-96. ASTM A554-94 APPLIES. RADIOGRAPHIC INSPECTION OF SEAM WELD SHALL BE IN ACCORDANCE WITH ASTM E390-95 GRADE 2 AND MIL STD 453C-1988. PLANISH TO REMOVE UNDERCUT
4. REMOVE BURRS AND BREAK SHARP EDGES .016 INCHES.
5. TOLERANCES ON STOCK MATERIAL SIZES SHALL BE AS SPECIFIED IN VENDOR SPECIFICATIONS.



DISTRIBUTION STATEMENT A.
 APPROVED FOR PUBLIC RELEASE;
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REVISION		DATE	APPROVED
1	PRODUCT BASELINE	03-27-77	

DESIGN ACTIVITY		DATE	
DESIGNED BY	BOVAWITTO	03-07-07	
CHECKED BY	BOVAWITTO		
APPROVED BY			
DATE			
STATION			
TEST ASST			
USED ON			
APPLICATION			

U.S. GOVT. CONTRACTING CENTER ATTENTION: DDD FORM 131 REVISION 01-68	TUBE BODY FOR 12x56 MULTIPLE ROUND CONTAINER.
SCALE: NONE	SIZE: C/D: C/D: 1
	Q1301
	M1256004
	SHEET 1 OF 1