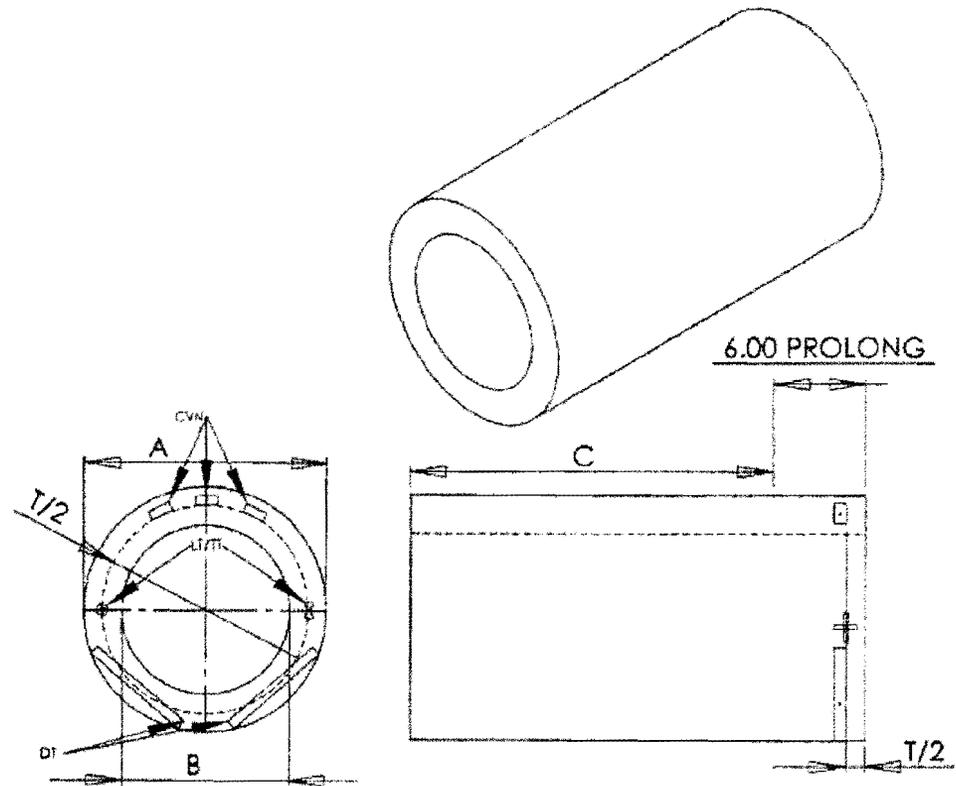


SPECIFICATIONS FOR HY-80 STEEL FORGINGS

1. FORGINGS ARE TO BE PRODUCED AND SUPPLIED IN A ROUGH MACHINED CONDITION.
2. IN GENERAL, THE FORGINGS ARE TO BE MANUFACTURED, TESTED, INSPECTED, AND ACCEPTED IN ACCORDANCE WITH NAVSEA TECHNICAL PUBLICATION T9074-BD-GIB-010/0300, BASE MATERIALS FOR CRITICAL APPLICATIONS: REQUIREMENTS FOR LOW ALLOY STEEL PLATE, FORGINGS, CASTINGS, SHAPES, BARS, AND HEADS OF HY-80/100/130 AND HSLA-80/100, DATED 9 AUGUST 2002. HOWEVER, THE FOLLOWING EXCEPTIONS WILL APPLY:
 - A. THE PREPRODUCTION TEST, PARAGRAPH 3.1 AND 4.2 IS HEREBY WAIVED.
 - B. IMPACT PROPERTIES AND NIL-DUCTILITY TRANSITION TEMPERATURE REQUIREMENTS, APPENDIX E.3.4, ARE HEREBY WAIVED.
 - C. EXPLOSION TESTING, E 3.5 IS HEREBY WAIVED.
 - D. DYNAMIC TEAR, CHARPY V-NOTCH AND CHARPY IMPACT TRANSITION CURVES TESTS, PARAGRAPHS E4.3.1.4.3, E4.3.1.4.4, AND E4.3.2.4.5 ARE HEREBY WAIVED.
3. WITH REGARD TO ULTRASONIC INSPECTION, ONLY THE FIRST FORGING SHALL BE INSPECTED. IF THIS FORGING MEETS THE REQUIREMENTS OF T9074-BD-GIB-010/0300 ULTRASONIC INSPECTION FOR THE REMAINING FORGINGS ARE WAIVED. IF THE FIRST FORGING DOES NOT MEET THE ABOVE REQUIREMENTS NSWCCD (CODE 6510) IS TO BE NOTIFIED IMMEDIATELY AND INSPECTION RESULTS FORWARDED TO NSWCCD (CODE 6510) FOR EVALUATION. PENDING EXAMINATION OF THESE RESULTS BY NSWCCD THE FORGING WILL EITHER BE ACCEPTED OR NEW FORGINGS WILL BE MADE.

Thickness = 1.344in.



	A	B	C
Upper Forging	21.43	18.84	26.3
Lower Forging	20.21	18.84	15.7

Tolerance on A: +0.125, -0.000
Tolerance on B: +0.000, -0.125
Tolerance on C: +0.125, -0.125