

**STATEMENT OF WORK
FOR
PRIMER CUPS AND ANVILS
PRODUCTION AND SUPPORT**

1.0 GENERAL

The Government requires fabrication, inspection and delivery of Primer Cups and Anvils in accordance with technical drawings to support PVU-1/A; PVU-2/A; PVU-7/A; PVU-10/A; and PVU-12/A programs. The Government will supply all facilities, materials, and equipment maintenance required to fabricate, inspect, and deliver these Primer Cups and Anvils. The Government will provide the production equipment as government furnished equipment (GFE) and raw material in the form of government furnished material (GFM).

2.0 APPLICABLE DOCUMENTS

The following documents form a part of this Statement of Work (SOW) to the extent specified herein.

Document Number	Document Title
1496AS102	NAVAIR PVU-10/A CUPS
851AS502	NAVAIR PVU-7/A CUPS
851AS862	NAVAIR PVU-2/A ANVILS
851AS501 rev A	NAVAIR PVU-7/A ANVILS
851AS114 rev B	NAVAIR PVU-2/A/PVU-12/A & PVU-1/A CUPS
851AS251 rev B	NAVAIR PVU-12/A ANVILS
1496AS101	NAVAIR PVU-10/A ANVILS
851AS113 rev A	NAVAIR PVU-1/A ANVILS
SK10007-E26HA1-1	NSWCIHDIV PVU-10/A CUP DIE BUSHING
SK10007-E26HA1-2	NSWCIHDIV PVU-10/A CUP DIE BOTTOM STRIPPER
SK10007-E26HA1-3	NSWCIHDIV PVU-10/A CUP DIE PUNCH
SK10007-E26HA1-4	NSWCIHDIV PVU-10/A CUP DIE PINCH
SK10007-E26HA1-5	NSWCIHDIV PVU-10/A CUP DIE TOP STRIPPER
SK09034-E213L-1	NSWCIHDIV PVU-2/A CUP DIE BUSHING
SK09034-E213L-2	NSWCIHDIV PVU-2/A CUP DIE BOTTOM STRIPPER
SK09034-E213L-3	NSWCIHDIV PVU-2/A CUP DIE PUNCH
SK09034-E213L-4	NSWCIHDIV PVU-2/A CUP DIE PINCH
SK09034-E213L-5	NSWCIHDIV PVU-2/A CUP DIE TOP STRIPPER
SK09057-E26HA1-1 REV A	PVU-7/A CUP DIE BUSHING
SK09057-E26HA1-2	PVU-7/A CUP DIE BOTTOM STRIPPER
SK09057-E26HA1-3 REV A	PVU-7/A CUP DIE PUNCH
SK09057-E26HA1-4 REV A	PVU-7/A CUP DIE PINCH
SK09057-E26HA1-5	PVU-7/A CUP DIE TOP STRIPPER

3.0 SCOPE

Using Government provided Facilities, GFE and GFM as listed in SOW paragraph 5.0, the Contractor shall fabricate, inspect, and deliver Primer Cups and Anvils in accordance with technical drawings identified in SOW paragraph 2.0. The Government will supply the raw materials (brass strip stock with certification of analysis) needed to manufacture the Primer Cups and Anvils. The raw materials for the manufacture of the Primer Cups and Anvils are identified within the parts list of the applicable drawing packages. The Contractor shall provide the consumable operating

supplies, to include, but not be limited to drawing lubricant, towels, cleaning supplies, material for cleaning and protecting the finished cups and anvils, and the tumbling and polishing media.

The Contractor shall use the Government's production equipment to manufacture the parts required by this SOW. The Contractor shall provide the labor and consumable supplies to keep the equipment in working order throughout the life of the contract and to meet production requirements. As set forth in SOW section 4.3, the Government will repair all GFE, with the exception of the die sets.

The Contractor shall maintain the production condition of the Government furnished die sets. The Contractor shall make adjustments to the condition of the tooling, and/or create new critical wear die set pieces, as required to ensure the parts meet all of the drawing requirements, as listed in SOW paragraph 2.0.

4.0 REQUIREMENTS

4.1 Fabrication and Test

4.1.1 Manufacturing Process

The Contractor shall maintain and control manufacturing processes to fabricate, inspect, and deliver Primer Cups and Anvils. The processes should cover all phases from the requests for raw material and ordering of supplies, to the acceptance of the finished product at Naval Surface Warfare Center / Indian Head Division (NSWC/IHDIV). All parts shall be manufactured in accordance with the drawings and specifications referenced in SOW Section 2.0.

4.1.2 Production Units

The Contractor shall submit a certificate of compliance certifying that the production units meet all requirements as specified on the drawings and specifications. The Contractor shall also submit the Government provided certificates of analysis for the brass strip stock per the attached Quality Assurance Requirements sheet.

4.1.3 Manufacturing Process Description

The Government process for manufacturing Primer Cups and Anvils is described in this section. These processes are shown for information only and illustrate the use of the brass cleaning and protecting materials approved for use and listed in SOW section 4.1.4.

Primer Cup Manufacture:

- Punch Cup
- Clean, Rinse, Dry (detergent and water)
- Inspect
- Deburr (Nova Vibratory Tumbler)
- Clean (Ultrasonic cleaner with Iosso, or Sagebrush Tumblebright Cleaner)
- Polish (Tumbler with Sagebrush Tumblebright Cleaner)
- Protect (Brulin Copper Protector)
- Dry (Tumbler with dry Corn Cob media)
- Screen Height (if required 100 percent screen with Roller Micrometer)
- Final Inspection

Primer Anvil Manufacture:

- Punch
- Clean, Rinse, Dry (detergent and water)
- Inspect
- Clean (Ultrasonic cleaner with Iosso, or Sagebrush Tumblebright Cleaner)
- Protect (Brulin Copper Protector)
- Dry (Tumbler with dry Corn Cob media)

- Final Inspection

4.1.4 Approved Materials for Cleaning and Protecting Finished Cups and Anvils

The following materials are approved for use in cleaning and protecting Primer Cups and Anvils. The Contractor shall use **Brulin Copper Protector in accordance with the manufacturer's instructions to protect all parts**. The use of a chemical cleaner is not required, however the use of chemical cleaners and copper protectors other than those specified require the approval of the Government. Chemical cleaners containing ammonia or mercury shall not be used.

Chemical Cleaners:

Product: Tumble Bright Cleaning Solution

Sagebrush Products
1639 Industrial Avenue
Sidney, Ne.69162
888-552-7376
MSDS #18488

Product: Iosso Case Cleaner

Iosso Products
1485 Lively Blvd
Elk Grove, Ill. 60007
888-747-4332
MSDS #18452

Copper Protector:

Product: Brulin Copper Protector product no. 431009

Brulin & Company Inc.
P.O. Box 270
Indianapolis, In. 46206-0270
(317)-923-3211
MSDS#18451

4.2 Quality Control

4.2.1 Quality System and Quality Control Processes

The Contractor shall create and maintain a Quality Control System and associated Certification(s) or Compliances. The Contractor shall maintain quality and process controls that will be used to ensure that the end item will be in compliance with the applicable drawings, specifications, and contract. The Contractor shall maintain documentation and processes that will be used to identify, record, and dispose of non-conforming material, in-process rejects/reworks and characteristic discrepancies.

4.2.2 Inspection of Product

4.2.2.1 Inspection Requirement

There are no First Article inspection requirements for this contract. At the Contractor's request the Government will provide Government inspection of first off, or set up parts as required during a production run for individual items listed in SOW section 2.0. If the Government can not provide inspection results within one week after the Contractor's request, then the Government will adjust the Contractor's delivery schedule by the extra time required to complete the inspections.

4.2.2.2 Receipt and Acceptance

The Government will receive and accept all parts at the Government's facility. The Technical Point of Contact (TPOC) listed in SOW paragraph 6.1 will designate a receipt and acceptance point of contact. The Contractor shall perform all inspection requirements as specified in this SOW. The Contractor shall utilize best engineering practices to design test procedures that will ensure end items meet requirements identified in the drawings referenced in SOW paragraph 2.0.

4.2.3 Government Inspection of Facilities

The Government, through any representative authorized by the TPOC listed in SOW paragraph 6.1, will inspect Government furnished production areas, or that of any subcontractors, engaged in the performance of this contract. If any examination/test is made by the Government on the premises furnished to the Contractor/ subcontractor, the Contractor and any subcontractors shall provide due access and assistance for the safety and convenience of the Government inspectors in the performance of their duties.

4.3 Equipment Maintenance

For GFE/GFM, the Government will provide inspection and maintenance of the equipment at a minimum of once per year. The inspections will be in accordance with the manufacturer's recommended maintenance schedule for the specific piece of equipment being maintained. For the laser micrometer, the Government will be responsible for costs associated with electronic re-calibration of the equipment when required.

The Contractor shall be monetarily responsible for all labor and material costs associated with adjusting for normal wear of the die sets and maintaining the die sets in good quality condition. Maintenance of the die sets shall include the manufacture of critical wear parts needed to manufacture primer cups and anvils which meet the dimensional requirements of the drawings in SOW section 2.0.

For GFE other than the die sets, the Government will be responsible for labor and material costs associated with repair of equipment that fails during use. The Contractor shall be responsible for replacement and repair of equipment resulting from abuse, mishandling or anything other than normal wear and tear of equipment.

5.0 GOVERNMENT FURNISHED EQUIPMENT AND MATERIAL

The Government will furnish the following GFM/GFE:

- Government Furnished Equipment (GFE)
 1. Benchmaster 15 ton punch press model 251-GXA-2/3PRF3 serial number 69231.
 2. Rapid Air Cabinet Reel (strip stock feeder) model R46A serial number 72014.
 3. Tool and Die Sets (Eight each corresponding to drawings listed in section 2.0)
 4. Nova Tumbler model 1003 (parts deburring machine)
 5. Laser Micrometer
 6. Roller Micrometer
 7. Ultrasonic Cleaning Equipment
- Government Furnished Material (GFM)
 1. Condition Code A brass strip stock in quantities sufficient to meet delivery requirements of the contract. Reasonable scrap is allowed.

The use of GFE and / or GFM does not alleviate the Contractor from responsibility of meeting the requirements of the contract and drawings. Should potential Contractors wish to inspect GFE and GFM, it will be available for viewing at the Government site prior to the deadline for bids.

6.0 REPORTING REQUIREMENTS AND DELIVERABLES

6.1 Technical Point of Contact

All deliverables as specified herein shall be inspected and approved by the Technical Point of Contact (TPOC) as listed below:

Indian Head Division/Naval Surface Warfare Center
Attn:
CAD/PAD Department
4939 Benson Road, Suite 120
Indian Head, MD 20640

6.2 Production Quantities

The Contractor shall deliver primer cups and anvils in accordance with the contract quantities. Supporting documentation including a Certificate of Compliance certifying that the production units meet all requirements as specified on the drawings and specifications, and a certificate of analysis for the brass strip stock shall be included with each shipment.

The Government will place orders for quantities of 0 to 200,000 units per year for each of the eight types of cups and anvils listed in SOW section 2.0. Requirements will be for at least 10,000 parts per order. The guaranteed minimum for this contract is \$500.00.

6.4 Delivery Schedules

The contractor shall deliver primer cups and anvils within the following schedule:

10,000 to 100,000 units per item 120 days ARO
Over 100,000 units per item 150 days ARO

If more than one item from SOW section 2.0 is ordered at a time, the delivery schedules for these items will be mutually established.

6.5 Equipment

Upon the completion of the contract, the Contractor shall turn over to the Government the production equipment and eight die sets.

7.0 SECURITY

The Contractor shall maintain a SECRET clearance to perform manufacturing operations at the Naval Surface Warfare Center located in Indian Head, Maryland. Contractor personnel security clearances shall be verified by the Contractor in the Joint Personnel Adjudication System (JPAS).

Contractors using the Government facilities are subject to the availability of hours as set forth by the base Commander. Depending on the current threat condition of the base, contractors may be denied access to base facilities at times.