

DEPARTMENT OF THE NAVY  
NSY PUGET SOUND DET BOSTON



LANDING CRAFT AIR CUSHION

SPECIFICATIONS FOR WORK TO BE ACCOMPLISHED

SPECIFICATION NUMBER: SSP:BOST-076-12

CRAFT CHARACTERISTICS

LENGTH OVERALL	87 FEET 11 INCHES
MAX. BEAM AT DESIGN WATERLINE	47 FEET 0 INCHES
EXTREME BEAM INCLUDING APPENDAGES	0 FEET 0 INCHES
DRAFT (MAX. NAVIGABLE) (FWD.)	0 FEET 0 INCHES
DRAFT (MAX. NAVIGABLE) (AFT.)	0 FEET 0 INCHES
LIGHT DISPLACEMENT	78 LONG TON
FULL LOAD DISPLACEMENT	163 LONG TON
HEIGHT OF MAST ABOVE DESIGN WATERLINE	18 FEET 6 INCHES

23 AUG 2011

DATE PREPARED

## I N D E X

ITEMS THAT ARE STRUCK OUT ON THIS INDEX DO NOT APPLY TO THIS CONTRACT.

CATEGORY I. FY-12 STANDARD ITEMS APPLICABLE TO THIS JOB ORDER WITHOUT FURTHER REFERENCE

<u>ITEM NO.</u>	<u>TITLE</u>	<u>DATE</u>
009-01	General Criteria; accomplish	30-JUL-10
009-02	Environmental Compliance Reports for Material Usage at Naval Facilities; provide	01-AUG-08
009-03	Toxic and Hazardous Substances; control	24-JUL-09
009-04	Quality Management System; provide	30-JUL-10
009-05	Temporary Accesses; provide	30-JUL-10
009-06	Maintaining Protection and Cleanliness from Non-Radioactive Contaminate-Producing Operations; accomplish	24-JUL-09
<del>009-07</del>	<del>Confined Space Entry, Certification, Fire Prevention and Housekeeping; accomplish</del>	<del>30-JUL-10</del>
<del>009-08</del>	<del>Fire Protection at Contractor's Facility; accomplish</del>	<del>24-JUL-09</del>
<del>009-10</del>	<del>Shipboard Asbestos-Containing Material (ACM); control</del>	<del>30-JUL-10</del>
<del>009-18</del>	<del>Magnetic Material; control</del>	<del>24-JUL-09</del>
009-19	Provisioning Technical Documentation (PTD); provide	30-JUL-10
009-20	Government Property; control	30-JUL-10
009-21	Logistics and Technical Data; provide	30-JUL-10
009-23	Interferences; remove and install	30-JUL-10
009-24	Authorization, Control, Isolation, Blanking, and Tagging Requirements; accomplish	30-JUL-10
<del>009-29</del>	<del>Asbestos-Free Pipe Hanger Liner Material; install</del>	<del>29-JUL-04</del>
<del>009-34</del>	<del>Fire Protection of Unmanned Vessels at Contractor's Facility; provide</del>	<del>24-JUL-09</del>
<del>009-35</del>	<del>Confined Space Entry, Certification, Fire Prevention Utilizing Military Fire Watches, and Housekeeping; accomplish</del>	<del>30-JUL-10</del>

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<del>009-39</del>	<del>Technical Manual Contract Requirement (TMCR) for New Technical Manuals for Commercial Equipment/ Component; provide</del>	<del>19-JUL-07</del>
009-40	Requirements for Contractor Cranes, Multi-Purpose Machines and Material Handling Equipment at Naval Facilities; accomplish	30-JUL-10
<del>009-59</del>	<del>Organotin Antifouling Material; control</del>	<del>01-AUG-08</del>
009-60	Schedule and Associated Reports for Availabilities Over 9 Weeks in Duration; provide and manage	30-JUL-10
009-61	Shipboard Use of Fluorocarbons; control	24-JUL-09
<del>009-64</del>	<del>Synthetic Fire-Resistant Hydraulic Fluid; control</del>	<del>19-JUL-07</del>
<del>009-65</del>	<del>Polychlorinated Biphenyls (PCBs); control</del>	<del>01-AUG-08</del>
009-67	Integrated Total Ship Testing; manage	30-JUL-10
009-69	Heavy Weather Plan; provide	30-JUL-10
009-70	Confined Space Entry, Certification, Fire Prevention and Housekeeping for Unmanned Vessels; accomplish	30-JUL-10
<del>009-72</del>	<del>Physical Security at Private Contractor's Facility; accomplish</del>	<del>09-MAY-11</del>
009-73	Shipboard Electrical/Electronic/Fiber Optic Cable; remove, relocate, repair, and install	30-JUL-10
009-74	Occupational, Safety and Health Requirements; accomplish	30-JUL-10
<del>009-77</del>	<del>Cofferdam Requirements; accomplish</del>	<del>31-JAN-11</del>
009-79	Government Owned Material (GOM); status reporting	30-JUL-10
<del>009-80</del>	<del>Ship's Facilities; provide</del>	<del>19-JUL-07</del>
009-81	Compartment Closeout; accomplish	30-JUL-10
009-82	Data Requirements When Installing an Equal Component Vice Specified Component; provide	19-JUL-07
<del>009-83</del>	<del>Wire Rope Fitting Verification; provide</del>	<del>19-JUL-07</del>

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009-84	Accountability of Temporary Fasteners; provide	19-JUL-07
009-86	Recovery of Chlorofluorocarbon (CFC) Refrigerants and Fire Suppressant Halon (H) Materials; accomplish	01-AUG-08
<del>009-87</del>	<del>Chlorination Procedures; accomplish</del>	<del>30-JUL-10</del>
<del>009-88</del>	<del>Collection, Holding and Transfer (CHT) and Mogas Tanks, Spaces, and Piping, including Sewage or Mogas-Contaminated Tanks, Spaces, and Piping; certify</del>	<del>30-JUL-10</del>
<del>009-89</del>	<del>Purchase and Inspection Requirements for Contractor Furnished Anodes; accomplish</del>	<del>30-JUL-10</del>
009-93	Emergency Planning and Community Right-to-Know Act (EPCRA) and Pollution Prevention Act (PPA) Information; provide	01-AUG-08
<del>009-94</del>	<del>General Environmental Requirements for Work at Contractor's Facility; accomplish</del>	<del>30-JUL-10</del>
009-95	Mechanically Attached Fittings (MAF's) for Piping Systems; install	19-JUL-07
009-97	Shipbuilding and Ship Repair Operations National Emission Standard for Hazardous Air Pollutants (NESHAPS) for Surface Coating Information; provide	01-AUG-08
009-99	Ship Departure Report; provide	30-JUL-10
<del>009-100</del>	<del>Ship's Stability Process Control Procedure (PCP); maintain</del>	<del>30-JUL-10</del>
<del>009-101</del>	<del>Requirements for Mooring, Entry to and Departure from Contractor's Facility; accomplish</del>	<del>19-JUL-07</del>
009-102	Alteration Verification; provide	19-JUL-07
<del>009-103</del>	<del>Weight and Moment Change Data; provide</del>	<del>19-JUL-07</del>
<del>009-106</del>	<del>Work Authorization Form Coordinator (WAFCOR); provide</del>	<del>30-JUL-10</del>
<del>009-108</del>	<del>Aircraft Carrier Requirements for Mooring, Entry to, Movement within, and Departure from Contractor's Facility; accomplish</del>	<del>19-JUL-07</del>
<del>009-109</del>	<del>Special Requirements for Non-SUBSAFE Work on SUBSAFE-Certified Vessels; accomplish</del>	<del>30-JUL-10</del>
<del>009-110</del>	<del>Special Requirements for Non-Nuclear Work on Nuclear Vessels; accomplish</del>	<del>19-JUL-07</del>

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<del>009-111</del>	<del>Schedule and Associated Reports for Availabilities 9 Weeks or Less in Duration; provide and manage</del>	<del>30-JUL-10</del>
<del>009-112</del>	<del>Prevention of Radiographic-Inspection Ionizing-Radiation Hazards; accomplish</del>	<del>30-JUL-10</del>
<del>099-059</del>	<del>CG Deck Loading; accomplish</del>	<del>07-JUL-11</del>
<del>099-74</del>	<del>General Safety Requirements; accomplish</del>	<del>07-JUL-11</del>

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## CATEGORY II. FY-12 STANDARD ITEMS WHICH MAY BE INVOKED IN THE WORK ITEMS OF THIS JOB ORDER

<u>ITEM NO.</u>	<u>TITLE</u>	<u>DATE</u>
009-09	Process Control Procedure (PCP); provide and accomplish	30-JUL-10
009-11	Insulation and Lagging Requirements; accomplish	30-JUL-10
009-12	Welding, Fabrication, and Inspection Requirements; accomplish	30-JUL-10
009-13	Meters; repair and certify calibration	30-JUL-10
009-14	Gages and Thermometers; repair and certify calibration	30-JUL-10
009-15	Rotating Machinery; balance	01-AUG-08
009-16	Electronic Equipment; repair	30-JUL-10
009-17	Rotating Electrical Equipment; repair	31-JUL-10
009-22	Shipboard Electric Cable; test	30-JUL-10
009-25	Structural Boundary Test; accomplish	30-JUL-10
009-26	Deck Covering Requirements; accomplish	30-JUL-10
009-27	Material Identification and Control (MIC) for Level I Systems; accomplish	24-JUL-09
009-28	Cancelled 30 JUL 2010	30-JUL-10
009-30	Boiler Sample Tubes; inspect	19-JUL-07
009-31	Boiler Waterjet Cleaning; accomplish	19-JUL-07
009-32	Cleaning and Painting Requirements; accomplish	31-JAN-11
009-33	Rotating Electrical Equipment; rewind	30-JUL-10
009-36	Controller; repair	30-JUL-10
009-37	General Procedures for Woodwork; accomplish	30-JUL-10

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009-38	Boiler Dry Lay-up; accomplish	19-JUL-07
009-41	Technical Manual Contract Requirement (TMCR) for a Topically Structured Technical Manual; provide	19-JUL-07
009-42	Technical Manual Contract Requirement (TMCR) for Updating Technical Manuals; provide	19-JUL-07
009-43	Light-Off Assessment (LOA) Support for Steam Propulsion System; provide	19-JUL-07
009-44	Light-Off Assessment (LOA) Support for Gas Turbine Propulsion System; provide	19-JUL-07
009-45	Tapered Plug Valve; repair	01-AUG-08
009-46	Butterfly Valve, Synthetic and Metal Seated; repair	01-AUG-08
009-47	Gate Valve; repair	30-JUL-10
009-48	Pressure Seal Bonnet Valve; repair (shop)	30-JUL-10
009-49	Pressure Seal Bonnet Valve; repair (in-line)	30-JUL-10
009-50	Horizontal Swing Check Valve; repair	30-JUL-10
009-51	Globe, Globe Angle, and Globe Stop Check Valve; repair	30-JUL-10
009-52	Relief Valve; repair	24-JUL-09
009-53	Bolted Bonnet Steam Valve; repair (shop)	30-JUL-10
009-54	Bolted Bonnet Steam Valve; repair (in-line)	30-JUL-10
009-55	Regulating/Reducing Valve; repair	30-JUL-10
009-56	Boiler Wet Lay-Up; accomplish	19-JUL-07
009-57	Reduction Gear Security Requirements; accomplish	30-JUL-10
009-58	Pump and Driver Shaft Alignment; accomplish	30-JUL-10
009-62	Boiler Handhole and Manhole Seats and Plates; inspect	19-JUL-07
009-63	Lubricating Oils and Hydraulic Fluids; analyze	01-AUG-08

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009-66	Light-Off Assessment (LOA) Support for Diesel Propulsion System; provide	19-JUL-07
009-68	Bolted Bonnet Valve; repair	30-JUL-10
009-71	Testing Requirements for Piping Systems; accomplish	30-JUL-10
009-75	Circuit Breaker; repair	30-JUL-10
009-76	Waveguide and Transmission Line Temporary Lay-Up, Pressurization, and Purging; accomplish	19-JUL-07
009-78	Passive Countermeasures System (PCMS) Material Repair/Installation Requirements; accomplish	30-JUL-10
009-85	Government Sponsored Planning Yard/Configuration Data Manager (CDM) On-Site Representative Facility; provide	19-JUL-07
009-90	Technical Representative; provide	30-JUL-10
009-91	Propeller In-Place Inspection; accomplish	01-AUG-08
009-92	Resilient Mount; remove and install	19-JUL-07
009-96	Ball Valve; repair	30-JUL-10
009-98	Monel Fasteners; inspect	30-JUL-10
009-104	Vibration Testing and Analysis; accomplish	01-AUG-08
009-105	Thermal Sprayed Coatings for Machinery Component Repair; accomplish	14-JUL-05
009-107	Piping System Cleanliness (Non-Nuclear); accomplish	30-JUL-10
009-113	Rotating Electrical Equipment with Sealed Insulation Systems (SIS); rewind	30-JUL-10
009-114	Mold Remediation; accomplish	30-JUL-10

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<u>ITEM NO.</u>	<u>TITLE</u>
077-01-001	Hazardous Waste Produced on Naval Vessels; control
123-80-001	LCAC Craft Change Document-295 Rev 02, Waterwash Tank Modification; accomplish
123-85-001	LCAC1 Class AER-0411 Rev 01, Aft Fuel Tank Modification at Inner Hinge Line; accomplish
123-85-002	LCAC1 Class AER-0541 Rev -, Oily Waste Tank Wet Deck Plating Replacement; accomplish
150-80-001	LCAC CraftAlt-0475D Rev 00, Structural Modification Frame 15 Partial Removal; accomplish
164-90-001	LCAC1 Class Craft Change Document 518K Rev 00 Increment 01, Lightweight Armor Installation; accomplish
234-90-001	LCAC1 Class CraftAlt-0519K Rev 00, Water Wash Simplification Modification; accomplish
243-85-001	LCAC1 Class AER-0452, Bulkhead Modification for Offset Gearbox Shaft Seal Replacement; accomplish
245-85-001	LCAC1 Class AER-0489, Composite Transfer Sleeve; accomplish
246-80-001	LCAC Craft Change Document-487 Rev 00, Propeller Stator Fitting Fastener Modification; accomplish
248-11-001	Lift Fan Bearing; replace
248-80-001	LCAC Craft Change Document-361 Rev 01, Modification to Lift Fan Bearing Mount Support Structure; accomplish
248-85-001	LCAC1 Class AER-0526, Lift Fan Bearing Grease Relief; accomplish
248-85-002	LCAC1 Class AER-0514, Isomag Lift Fan Bearing Seal; accomplish
248-85-003	LCAC1 Class AER-391, Lift Fan Shaft Journal and Thread Repair; accomplish
259-85-001	LCAC1 Class AER-0538, APU Exhaust Stack Alignment Alteration; accomplish
261-90-001	LCAC Craft Change Document-0549K Rev 00, Water Detector AC Electronic Module; accomplish

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- 426-85-001 LCAC AER-0537 Rev 00, Fabricate and Install Protective Cover for EGI and Cabling; accomplish
- 523-85-001 LCAC1 Class AER-0520, Auxiliary Propulsion Unit (APU) Modified Start Bypass Valve (SBV) Exhaust Installation; accomplish
- 555-80-001 LCAC CraftAlt-0451D Rev 01, Halon Squib Circuitry RCCB Replacement; accomplish
- 562-11-001 Port and Starboard Rudder Bearing; replace
- 562-85-001 LCAC Craft Change Document-471 Rev 00, Modification to Split Rudder Bearing Fitting; accomplish
- 625-80-001 LCAC1 Class CraftAlt-0402D Rev 00, Replace Side Windshield Wiper; accomplish (IN PART)
- 631-90-001 LCAC1 Class CraftAlt-0445K Rev 01, Limited Compartment Painting; accomplish (IN PART)
- 841-11-001 System and Component Flushing, Pressure and Functional Test; accomplish
- 992-31-001 Cleaning and Pumping; accomplish

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SEVENTY-SIX (LCAC-76)  
COAR: 16-076 PCN: LC76-B077  
SWT FILE NO: 077-001 CMP: NONE  
REVISED: 04 APR 2011 PLANNER: ROGERS

1. SCOPE:

1.1 Title: Hazardous Waste Produced on Naval Vessels; control

1.2 Location of Work:

1.2.1 Throughout the Ship

1.3 Identification:

1.3.1 Not Applicable

2. REFERENCES:

2.1 Resource Conservation and Recovery Act (RCRA)

2.2 49 U.S.C. 5103, Federal Hazardous Materials Transportation Act

2.3 Applicable Hazardous Waste Manifest Form

2.4 10 U.S.C. 7311

3. REQUIREMENTS:

3.1 Manage and dispose of all hazardous waste listed in 3.5 in accordance with 2.1 and 2.2.

3.1.1 When a Navy generator number is required by this Work Item, submit the original of 2.3 to the SUPERVISOR for assignment of Environmental Protection Agency (EPA) or delegated state environmental agency identification number.

3.1.2 Manage and transport for Navy disposal, Navy-generated hazardous waste listed in 3.5 in accordance with 2.1 and 2.2, as designated by the SUPERVISOR.

3.1.3 Submit one legible copy of 2.3 signed by the owner or operator of the disposal facility to the SUPERVISOR within 48 hours of receipt from owner or operator of disposal facility.

3.2 Complete documentation required by 2.1 and 2.2, using EPA or delegated

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state environmental agency identification number in accordance with 2.4.

3.2.1 Documentation related to hazardous waste generated solely by the physical actions of Ship's Force or Navy employees (termed Navy-Generated Hazardous Waste) on board the vessel shall only bear a generator identification number issued to the Navy pursuant to applicable law. The contractor shall obtain SUPERVISOR'S concurrence with the categorization of the waste as Navy-generated before completion of the manifest. The manifest prepared shall be presented to the SUPERVISOR for completion after the hazardous waste has been identified.

3.2.2 Documentation related to hazardous waste generated solely by the physical actions of contractor personnel (termed Contractor-Generated Hazardous Waste) shall bear a generator identification number issued to the contractor pursuant to applicable law. Regardless of the presence of other material in or on the shipboard systems or structure which may have qualified a waste stream as hazardous, where the contractor performs work on a system or structure using materials (whether or not the use of such materials was specified by the Navy) which by themselves would cause the waste from such work to be a hazardous waste, documentation related to such waste shall only bear a generator number issued to the contractor.

3.2.3 Documentation related to hazardous waste generated by the combined physical actions of Navy and contractor personnel (termed Co-Generated Hazardous Waste) shall bear a generator identification number issued to the contractor pursuant to applicable law and shall also cite in the remarks block a generator identification number issued to the Navy pursuant to applicable law. When the contractor merely drains a system and such drainage creates hazardous waste or the contractor performs work on system or structure using materials which by themselves would not cause the waste from such work to be hazardous waste but such work nonetheless creates a hazardous waste, documentation related to such waste shall bear a generator identification number issued to the contractor and shall also cite in the remarks block a generator identification number issued to the Navy. The contractor shall sign the generator certification on the Uniform Hazardous Waste Manifest whenever use of the manifest is required for disposal. The contractor shall obtain SUPERVISOR'S concurrence with the categorization of the wastes as co-generated before completion of the manifest. Manifests prepared shall be presented to the SUPERVISOR for completion after the hazardous waste has been identified.

3.3 If the contractor, while performing work at a Government facility, cannot obtain a separate generator identification number from the state in which the availability will be performed, the contractor shall notify the SUPERVISOR within three business days of receipt of written notification by the state. After obtaining approval of the SUPERVISOR, the contractor shall use the Navy

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site generator identification number and insert in the remarks block the contractor generator identification number issued for the site where his main facilities are located.

3.4 If, for availabilities at a contractor-owned or controlled facility, the Navy cannot obtain a separate generator identification number for use at a contractor facility, the Navy shall notify the contractor within three business days of receipt of notification by the state. The contractor shall dispose of hazardous waste in accordance with 2.1, 2.2, and 3.2.3.

3.5 Hazardous waste, as identified in 2.1, expected to be produced during performance of this Job Order:

TYPE	NAVY	AMOUNT	
		CO-GENERATED	CONTRACTOR
Acid Solutions (may include spent sulfamic, citric, chromic, nitric, sulfuric, hydrochloric, etc.)	_____	_____	_____
Ethylene Glycol (Antifreeze)	_____	_____	_____
Sodium Hydroxide	_____	_____	_____
Cleaning Solvents	_____	15 Gallons	_____
Sodium Phosphates (Tri, Bi, or Mono)	_____	_____	_____
Fluorocarbons	_____	_____	_____
Morpholine	_____	_____	_____
Sodium Chromates	_____	_____	_____
Hydrazine	_____	_____	_____
Methyl Ethyl Ketone	_____	_____	_____
Spent Abrasive Blast Material (contaminated with a known hazardous waste)	_____	10 Tons	_____
Trichloroethane	_____	10 Gallons	_____
Miscellaneous Chemicals	_____	25 Pounds	50 Pounds

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(Ignitable)

Miscellaneous Chemicals (Corrosive)	_____	10 Gallons	_____
Miscellaneous Chemicals (TCLP Toxic)	_____	_____	_____
Miscellaneous Chemicals (Reactive)	_____	10 Gallons	_____
Oil (Synthetic)	_____	25 Gallons	_____
Paints (Enamel, Latex, Epoxy, thinners, oil based, rubber paint, nonskid, lacquer, remover, varnishes)	_____	5 Gallons	_____
Paints (May include lead, cadmium, or chrome)	_____	_____	_____
Paint Strippers (phenols, lead, chromium)	_____	5 Pounds	_____
Sludge (Contaminated with a known hazardous waste)	_____	25 Gallons	_____
Wool Felt (contaminated with chromium and PCB's)	_____	_____	_____
Ventilation Debris/Residue (heavy metals, e.g., cadmium, chromium)	_____	_____	_____
Insulation	_____	40 Square Feet	_____

3.6 Notify the SUPERVISOR at least one working day prior to shipment of hazardous waste for disposal.

3.7 Submit one legible copy, in hard copy or electronic media, of a report identifying type, amount, and disposal cost of waste listed in 3.5 that was removed during the performance of this Job Order to the SUPERVISOR.

3.7.1 The report shall include analysis or other method used to identify the waste and state whether each listed waste was hazardous (with

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generator assignment), non-hazardous, or did not exist.

3.7.1.1 Chemical analysis shall be accomplished by laboratories with state or EPA approved quality assurance programs.

3.7.2 The contractor shall make an effort to minimize hazardous waste generation by reducing the volume or toxicity by neutralizing, recycling, or otherwise removing it from the requirements of Subtitle C of 2.1 and include a description of such efforts in the report.

3.8 Nothing contained in this Work Item shall relieve the contractor from complying with applicable federal, state, and local laws, codes, ordinances, and regulations, including the obtaining of licenses and permits in connection with hazardous waste handling and disposal in the performance of this contract.

4. NOTES:

4.1 The waste listed in 3.5 is based on the best information available at the time of preparation of the solicitation. Hazardous waste generated during the actual performance of the work may vary in type or amount from waste listed in 3.5 which may result in renegotiation for credit or increase pursuant to Paragraph (b) of 2.4. The contractor is expected to use best management practice to identify and dispose of all hazardous waste. Some of the substances listed in 3.5 may be neutralized, recycled, or otherwise removed from the requirements of Subtitle C of 2.1. Inclusion of these substances in the waste listed in 3.5 does not preclude the contractor from taking action consistent with 2.1 to reduce or eliminate the hazardous constituents of any waste required to be disposed of under the contract in accordance with 2.2. Processes that add hazardous constituents to the bilges may require that bilge water be disposed of as a hazardous waste.

4.1.1 The types and amounts of wastes listed in 3.5 are estimates of waste to be disposed of under this contract as required by 2.4. They are not estimates of the amount of the work involved in generating that waste. The work requirements of each individual Work Item specify the actual work to be accomplished.

4.2 Hazardous wastes are determined by one or more of the following methods:

4.2.1 Chemical analysis which shows that the material characteristics of ignitability, corrosivity, reactivity, and/or toxicity (Toxicity Characteristic Leachate Procedure - TCLP) exceed the limits for that material in 40 CFR 261.20 Subpart C.

4.2.2 Reference to a Material Safety Data Sheet (MSDS).

4.2.3 Applying knowledge of the hazardous characteristics of the waste

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in light of the materials or the process used.

4.3 Asbestos, bilge water, oil/water including sludge, debris and other contaminants, sludge which includes solids and sludge from ballast tanks, CHT tanks, voids, oily waste tanks, fuel ballast tanks, fuel oil tanks, skegs (West coast), PCB's (Maryland), etc., apply only in those states listing them as hazardous waste. When an availability is to be performed in a state where these items are hazardous waste, an estimate of the amount to be generated shall be included in 3.5.

5. GOVERNMENT FURNISHED MATERIAL (GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.



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3.2.1 Template exact size, configuration, and location from existing shipboard conditions.

3.2.2 Accomplish the requirements of 009-12 of 2.1, including Table 4, Column C, Lines One through 7.

3.2.2.1 Accomplish nondestructive testing in accordance with Line 10.

3.3 Accomplish the requirements of 009-25 of 2.1 for air test of the waterwash tank listed in 1.2. Test pressure shall be 2 PSIG. Maintain test pressure for 15 minutes for temperature stabilization prior to start of test. Hold test pressure for 10 minutes. Allowable drop in pressure: None.

3.3.1 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.3 to the SUPERVISOR.

3.4 Accomplish the requirements of 009-32 of 2.1, including Table 4, Line 19, Column A for surface preparation of the waterwash tank listed in 1.2.

3.4.1 Accomplish the requirements of 009-32 of 2.1, including Table 4, Line 11, Columns B through D for surfaces prepared in 3.4.

4. NOTES:

4.1 None.

5. GOVERNMENT FURNISHED MATERIAL (GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.



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3.2.1 Template exact size, configuration, and location from existing Landing Craft conditions.

3.3 Accomplish the requirements of 009-12 of 2.1, including Table 4, Column C, Lines One through 7.

3.3.1 Accomplish nondestructive testing in accordance with Line 10.

(I)(G) "HYDROSTATIC TEST"

3.4 Accomplish the requirements of 2.5, for twenty-four hour continuous hydrostatic test of each fuel tank listed in 1.2. Allowable drop in pressure: None.

3.4.1 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.4 to the SUPERVISOR.

4. NOTES:

4.1 Preservation of Aft Fuel Tanks is covered on Work Item, 631-90-001, LCAC1 Class CraftAlt-445K Rev 01, Limited Compartment Painting; accomplish

5. GOVERNMENT FURNISHED MATERIAL (GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.



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Class AER-0541 Rev -, Oily Waste Tank Wet Deck Plating Replacement, at the location listed in 1.2, in accordance with 2.2 through 2.6, using 2.7 for guidance.

3.2.1 Chip and grind surfaces flush and smooth in way of removals.

3.2.2 Template exact size, configuration, and location from existing landing craft conditions.

3.3 Remove existing and install new hatting in way of plating replacement in accordance with 2.3 through 2.5.

3.4 Accomplish the requirements of 009-12 of 2.1, including Table 4, Column C, Lines One through 7.

3.4.1 Accomplish nondestructive testing in accordance with Line 10.

(I)(G) "HYDROSTATIC TEST"

3.5 Accomplish the requirements of 2.8, for twenty-four hour continuous hydrostatic test of oily waste tank listed in 1.2. Allowable drop in pressure: None.

3.5.1 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.5 to the SUPERVISOR.

4. NOTES:

4.1 Preservation of Oily Waste Tank is covered on Work Item, 631-90-001, LCAC1 Class CraftAlt-0445K Rev 01, Limited Compartment Painting; accomplish

5. GOVERNMENT FURNISHED MATERIAL (GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.



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3.1.1 Template exact size, configuration, and location from existing landing craft conditions.

3.1.2 Chip and grind surfaces flush and smooth in way of removals.

3.1.3 Accomplish the requirements of 009-12 of 2.1, including Table 4, Column C, Lines One through 7.

3.2 Accomplish the requirements of 009-32 of 2.1, for new and disturbed surfaces.

3.3 Turn in all removed materials to the Assault Craft Unit by way of the SUPERVISOR for retention or final disposition.

4. NOTES:

4.1 None.

5. GOVERNMENT FURNISHED MATERIAL (GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.



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2.12 7614-947915 Rev A, Process Specification for Adhesive Bonding of  
Materials LCAC

2.13 S9100-AC-MMA-010 Rev 6, Operation and Maintenance Manual For Landing  
Craft, Air Cushion (LCAC) Structural Maintenance and Repair

2.14 631-6266706 Rev N, LCAC Paint and Marking

3. REQUIREMENTS:

3.1 Accomplish removals, modifications, relocations and installations  
incidental to LCAC1 Class Craft Change Document 518K Rev 00 Increment 01,  
Lightweight Armor Installation, for the equipment listed in 1.3 and located in  
1.2, in accordance with 2.2 through 2.4, using 2.5 for guidance.

3.1.1 Turnover removed materials to the SUPERVISOR for disposition.

3.1.2 Accomplish a visual inspection of the forward and inboard  
bulkheads and 02 level deck plating located in 1.2, for structural integrity,  
deterioration, pitting, cracks, and areas of damage or distortion prior to  
installation of lightweight armor kit.

3.1.2.1 Submit one legible copy, in hard copy or electronic  
media, of a report listing results of the requirements of 3.1.2 to the  
SUPERVISOR.

3.1.3 Remove existing and install new a total of 32 square feet of  
plating in location listed in 1.2.1 resulting from inspection of 3.1.2 as  
authorized by the SUPERVISOR, in accordance with 2.6 through 2.9.

3.1.3.1 Remove existing and install new a total of 16 linear  
feet of stiffeners as authorized by the SUPERVISOR.

3.1.3.2 Vee-out, safe end and weld repair a total of 8 linear  
feet of cracked plating as authorized by the SUPERVISOR.

3.1.4 Template exact size, configuration, and location from existing  
landing craft conditions.

3.1.5 Chip and grind surfaces flush in way of repairs.

3.1.6 Accomplish the requirements of 009-12 of 2.1, including Table 4,  
Column C, Lines One through 7.

3.1.6.1 Accomplish nondestructive testing in accordance with  
Line 10.

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3.1.7 Accomplish the requirements of 009-11 of 2.1 for new and disturbed insulation, in accordance with 2.10.

3.1.7.1 Clean structure prior to bonding insulation in accordance with 2.11.

3.1.7.2 Bond insulation to structure in accordance with 2.12.

3.1.8 Accomplish the requirements of 009-25 of 2.1 for a local air hose test in way of each new plating insert, repair, and each attachment weld to watertight bulkheads and decks. Allowable leakage: None.

3.1.9 Install Government Furnished Material (GFM) and Lightweight Armor Kit provided and listed in 5.3.

3.1.10 Fit and install new the following parts in accordance with 2.4:

TOTAL QUANTITY REQUIRED	NAME OF PART	PIECE NO.	REF. NO.	FIGURE DRAWING NO.	PART NO.
4 EA	Screw, CRES 1/4-20 UNC X 1-1/2	26	2.4	N/A	91773A546
15 EA	Nut, Nylock, CRES 1/4-20 UNC	27	2.4	N/A	90715A125
30 EA	Washer, CRES 1/4" Nominal	28	2.4	N/A	91860A029
4 EA	Screw, CRES 10-24 UNC X 1	29	2.4	N/A	91720A247
8 EA	Nut, Nylock, CRES 10-24 UNC	30	2.4	N/A	91240A011
16 EA	Washer, CRES #10 Nominal	31	2.4	N/A	91525A109
4 EA	Screw, CRES 10-24 UNC X 1	32	2.4	N/A	91773A247
4 EA	Bolt, CRES 3/8-16 UNC X 1-3/4	34	2.4	N/A	93190A630
4 EA	Nut, Nylock, CRES 3/8-16 UNC	35	2.4	N/A	90715A145
8 EA	Washer, CRES 3/8" Nominal	36	2.4	N/A	91860A031
2 EA	Washer, CRES 5/16" Nominal	37	2.4	N/A	91950A030
One EA	Pin, Quick Release	45	2.4	N/A	93750A803
One EA	Pin, Quick Release	46	2.4	N/A	93750A733

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4 EA	Bolt, CRES 1/4-20 UNC X 2-1/4	47	2.4	N/A	93190A551
2 EA	Bolt, CRES 5/16-18 UNC X 1-1/2	48	2.4	N/A	93190A587
2 EA	Rod, Alum 1/2 Dia. X 5-3/4	49	2.4	N/A	N/A
One EA	Mirror	50	2.4	N/A	01-314-1190
One EA	Bracket, Hand Rail	52	2.4	N/A	N/A
One EA	Strap, Gun Shield	53	2.4	N/A	N/A
One EA	Tongue, Life Ring	54	2.4	N/A	N/A
3 EA	Pin, Quick Release	56	2.4	N/A	93750A303
One EA	Stop, Gun Shield	58	2.4	N/A	N/A
7 EA	Bolt, CRES 1/4-20 UNC X 1-1/4	59	2.4	N/A	93190A544

(I)(G) "PULL TEST"

3.1.11 Accomplish a pull test of the modified handrail stanchion assembly in 2.4 in accordance with Appendix E and Figure 5-7 of 2.13. Apply a pull test of 200 pounds. Hold for 10 minutes. Remove the test load and inspect the handrail stanchion, stanchion base and surrounding structure for evidence of damage or permanent deformation. Allowable damage: None.

3.2 Accomplish the requirements of 009-32 of 2.1 for new and disturbed surfaces.

3.2.1 Apply craft markings in accordance with 2.14.

4. NOTES:

4.1 Insulation handling is covered on Work Item 077-01-001, Hazardous Waste Produced on Naval Vessels; control

5. GOVERNMENT FURNISHED MATERIAL(GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

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	TOTAL						
	QUANTITY		NAME OF	PIECE	REF	NATIONAL	
	PROVIDED		PART	NO.	NO.	STOCK NO.	
						PARA	
						NO.	
1.	One	KT	Lightweight Armor Kit CCD 518K Rev 00, Incr 01	None	2.4	None	3.1.9
2.	10	EA	Panel Assy, Armor	None	2.3	None	3.1.9



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- 2.11 625-5749102 Rev W, LCAC Windshield Wash Installation
- 2.12 505-6800352 Rev B, LCAC Non-Conductive Insert for Cres Fittings Thru Alum. Decks, Bulkheads & Brackets
- 2.13 LCAC1 CLASS CRAFTALT-0519K Rev 00, Waterwash Simplification Mods
- 2.14 MIL-STD-1310, Shipboard Bonding, Grounding and other Techniques for Electromagnetic Compatibility and Safety
- 2.15 LCAC SLEP Craft Specification Dated 26 April 2001
- 2.16 S9523-AF-MMA-030, Operation and Maintenance Manual for Landing Craft Air Cushion (LCAC) TF40B Water Wash System with CraftAlt 519K

3. REQUIREMENTS:

3.1 Accomplish removals, fabrications, modifications, and new installations incidental to LCAC1 Class CraftAlt-0519K Rev 00, Water Wash Simplification Modification in accordance with 2.2 through 2.6, using 2.7 through 2.13 for guidance.

3.1.1 Install Government Furnished Material (GFM) provided in 5.

3.1.1.1 Material required for installation of Assembly 27 of 2.2 shall be provided as GFM in 5.3.

3.1.2 Chip and grind surfaces flush and smooth in way of removals.

3.1.3 Template exact size, configuration, and location from existing landing craft conditions.

3.1.4 Accomplish the requirements of 009-12 of 2.1, including Table 4, Column C, Lines One through 7.

3.1.4.1 Accomplish nondestructive testing in accordance with Line 10.

3.1.5 Accomplish the requirements of 009-12 of 2.1, including Table One, Columns A and B, Lines One through 10.

3.1.5.1 Accomplish nondestructive testing in accordance with Line 13.

3.1.6 Accomplish the requirements of 009-25 of 2.1 for local air hose test of each new insert, attachment weld, penetration, and fitting to watertight bulkheads and decks. Allowable leakage: None.

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3.1.7 Accomplish the requirements of 009-22 of 2.1 for new, rerouted and modified cables.

3.1.8 Bond and ground equipment in accordance with 2.14. Grounding straps shall be CRES 316L for topside equipment.

3.1.9 Mark tubing for fluid identification and flow direction in accordance with General Note 40 of 2.2, using Section 507g of 2.15 for guidance.

3.2 Accomplish the requirements of 009-71 of 2.1 for new and disturbed water wash piping.

3.2.1 Test pressure shall be 105 PSIG, using clean fresh water in accordance with Test Note T-1 of 2.2, when the hydrostatic test option is selected.

(V)(G) "WATER WASH/WINDSHIELD WASH/DETERGENT WASH SYSTEM TEST"

3.3 Accomplish an operational test on each the water wash, windshield wash and detergent wash systems under normal system operating pressures, in accordance with Test Note T-3 of 2.2 and 2.16. Allowable leakage at new and disturbed joints: None.

3.3.1 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.3 to the SUPERVISOR.

4. NOTES:

4.1 None.

5. GOVERNMENT FURNISHED MATERIAL(GFM):

5.1 LLTM:

1. One EA Panel, Relay 001 2.3 None 3.1

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. One KT CraftAlt 519K, Kit 27 None 2.2 None 3.1.1.1



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3.2 Accomplish the requirements of 009-12 of 2.1, including Table 4, Column C, Lines One through 7.

(V)(G) "CLEARANCE CHECK"

3.3 Accomplish a fit check of shaft seal access cover plates and gearbox seal cover plates prior to final installation and check for proper clearance in accordance with Note 3.f of 2.2.

3.3.1 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.3 to the SUPERVISOR.

4. NOTES:

4.1 None.

5. GOVERNMENT FURNISHED MATERIAL (GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.



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accordance with 2.3.

3.1.4 Install shims and other components removed in 3.1.1.

(V)(G) "CLEARANCE FIT"

3.1.5 Ensure proper clearance between the oil transfer (Beta) tubes and the newly installed transfer sleeve.

3.2 Accomplish the requirements of 009-32 of 2.1 for disturbed surfaces.

4. NOTES:

4.1 None.

5. GOVERNMENT FURNISHED MATERIAL (GFM):

5.1 LLTM:

TOTAL	QUANTITY	NAME OF	PIECE	REF	NATIONAL	PARA	
<u>PROVIDED</u>		<u>PART</u>	<u>NO.</u>	<u>NO.</u>	<u>STOCK NO.</u>	<u>NO.</u>	
1.	2	EA	Composite Sleeve PN:694003203	6	2.3	01-506-6867	3.1.2
2.	2	EA	O-Ring PN:750420134	7	2.3	01-193-9381	3.1.2
3.	2	EA	O-Ring PN:AS3209-328		None	01-007-5144	3.1.2.1
4.	2	EA	O-Ring PN:750420132	9	2.3	01-191-6070	3.1.2

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.



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2.9 S9243-A2-MMA-A10 Rev 3 CHG A, Operation and Maintenance Manual for Landing Craft, Air Cushion (LCAC) Ancillary Propeller Equipment (LCAC 61 and Subsequent)

3. REQUIREMENTS:

3.1 Accomplish the requirements of 2.2 for removals, modifications and installations incidental to LCAC Craft Change Document-487 Rev 00, Propeller Stator Fitting Fastener Modification, for the equipment listed in 1.3 and located in 1.2, in accordance with 2.3, using 2.4 through 2.9 for guidance.

3.1.1 Accomplish a visual inspection of the existing stator fittings for damage and wear to each fitting and associated bolt holes using 2.4 for guidance.

3.1.1.1 Measure and record sizes and clearances of each bolt hole using 2.4 for guidance.

3.1.1.2 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.1.1 and 3.1.1.1 to the SUPERVISOR.

3.1.2 Relieve cover plates with simple radiused clearance cuts above the heads to ensure clearances in accordance with General Note 8 of 2.3.

3.1.3 File, grind or sand backing plate ends and edges to ensure clearances in accordance with General Note 10 of 2.3.

3.1.4 Apply sealant to all faying surfaces and fasteners in accordance with Paragraph 6-6.1.2 of 2.8.

3.1.5 Install each access cover using new fasteners in accordance with 2.7 and Paragraph 6-6.1.2 of 2.8.

(V)(G) "STATOR ALIGNMENT"

3.2 Inspect alignment and movement of each stator, stator attachment fitting and propeller blade tip to shroud inside diameter for proper clearance and relation to the shroud in accordance with 2.8.

3.2.1 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.2 to the SUPERVISOR.

4. NOTES:

4.1 None.

5. GOVERNMENT FURNISHED MATERIAL (GFM):

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5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.



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3.1.3 Accomplish a visual inspection of each part exposed by disassembly and removals for cracks, pitting, nicks, scratches, corrosion, galling, spalling, damaged threads and other defects in accordance with Paragraph 6-5.9.2.2 of 2.2.

3.1.3.1 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.1.3 to the SUPERVISOR.

3.1.4 Accomplish a visual inspection of each bearing liner (Figure 8-6, Index No. 15A of 2.2) for wear, scratches, nicks and other defects.

3.1.4.1 Submit one legible copy, in hard copy or electronic media, of a report listing inspection results of 3.1.4 to the SUPERVISOR.

3.2 Install new the equipment listed in 1.3.1 and located in 1.2, using serviceable parts retained in 3.1 and 3.1.1, in accordance with 2.2 through 2.5.

3.2.1 Remove existing, fit, and install new the following parts:

TOTAL QUANTITY REQUIRED	NAME OF PART	PIECE NO.	REF. NO.	FIGURE DRAWING NO.	PART NO.
8 EA	Check Seal, Plain	4	2.2	8-6	RS0140-340
8 EA	Rub Ring Assy	5	2.2	8-6	5750173-007
64 EA	Bolt, Machine	6	2.2	8-6	NAS501-6-46A
64 EA	Washer, Flat	7	2.2	8-6	AN960C616
64 EA	Nut, Self-lkg	8	2.2	8-6	MS21044C6
8 EA	O-Ring	11	2.2	8-6	2-171N674-70
8 EA	Fitting, Grease	13	2.2	8-6	MS15720-1
8 EA	Bearing	17	2.2	8-6	MRC124KS
8 EA	O-Ring	21	2.2	8-6	2-171N674-70
6 EA	Rub Ring Assy	26	2.2	8-6	5750173-019
48 EA	Bolt, Machine	27	2.2	8-6	NAS501-3H6A
48 EA	Washer, Flat	28	2.2	8-6	AN960C10L
6 EA	Check Seal, Plain	29	2.2	8-6	RS0130-340
16 EA	Bolt, Machine	31	2.2	8-6	NAS501-3H6A
16 EA	Washer, Flat	32	2.2	8-6	AN960C10L

3.2.2 Apply grease conforming to MIL-PRF-81322 to each new bearing and pillow block in accordance with General Note 39 of 2.3.

3.3 Plug weld existing bolting holes for the equipment listed in 1.3.2 used for anchoring the pillow block to the U-channel foundation to facilitate installation. Layout and drill new anchoring holes during installation after all

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final alignments are accomplished, in accordance with Paragraph 6-5.9.2.3.4 of 2.2.

3.3.1 Accomplish the requirements of 009-12 of 2.1, including Table 4, Column C, Lines One through 7.

4. NOTES:

4.1 LCAC Craft Change Document-361 Rev 01, Modification to Lift Fan Bearing Mount Support Structure; is accomplished on Work Item 248-80-001

4.2 LCAC1 Class AER-0526, Lift Fan Bearing Grease Relief; is accomplished on Work Item 248-85-001

4.3 LCAC 1 Class AER-0514, Isomag Lift Fan Bearing Seal; is accomplished on Work Item 248-85-002

5. GOVERNMENT FURNISHED MATERIAL(GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.



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2.10 248-5749546 Rev P, LCAC Volute Sub-Assemblies

2.11 248-5749562 Rev M, LCAC Bearing Mount Details

2.12 LCAC Craft Change Document-361 Rev 01, Modification to Lift Fan Bearing Mount Support Structure

3. REQUIREMENTS:

3.1 Accomplish alignment checks for Total Indicated Runout (TIR) for the equipment listed in 1.3 and located in 1.2, in accordance with Paragraph 6-5.9.2.3.3 of 2.2.

3.1.1 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.1 to the SUPERVISOR.

3.2 Accomplish removals, modifications and installations incidental to LCAC Craft Change Document-361 Rev 01, Modification to Lift Fan Bearing Support Structure, at each location listed in 1.2 in accordance with 2.3 through 2.6, using 2.2 and 2.7 through 2.12 for guidance.

3.2.1 Chip and grind surfaces flush and smooth in way of removals.

3.2.2 Template exact size, configuration, and location from existing Landing Craft conditions.

3.3 Accomplish the requirements of 009-12 of 2.1, including Table 4, Column C, Lines one through 7.

3.3.1 Accomplish nondestructive testing in accordance with Line 10.

3.4 Accomplish the requirements of 009-71 of 2.1, for new and disturbed piping.

(I)(G) "HYDROSTATIC TEST"

3.4.1 Test pressure shall be 95 PSIG, using clean fresh water, when the hydrostatic test option is selected for the waste water wash system.

3.4.2 Remove fluid upon completion of hydrostatic tests. Allowable residual fluid: None.

3.4.3 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.4 to the SUPERVISOR.

3.5 Accomplish alignment checks for Total Indicated Runout (TIR) for the equipment listed in 1.3 and located in 1.2 upon completion of repairs in 3.2, in

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accordance with Paragraph 6-5.9.2.3.3 of 2.2.

3.5.1 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.5 to the SUPERVISOR.

(V)(G) "OPERATIONAL TEST"

3.6 Accomplish an operational test of each piping system disturbed by this Work Item, under normal system operating pressure.

3.6.1 Allowable leakage at new and disturbed joints: None.

3.6.2 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.6 to the SUPERVISOR.

4. NOTES:

4.1 None.

5. GOVERNMENT FURNISHED MATERIAL (GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.



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1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.



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3.1.4 Lightly lubricate each O-ring to help glide the seal over the shaft.

(V)(G) "OPERATIONAL TEST"

3.2 Accomplish an operational test of the lift system fan and ducting assembly disturbed by this Work Item in accordance with 2.4.

3.2.1 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.2 to the SUPERVISOR.

4. NOTES:

4.1 None.

5. GOVERNMENT FURNISHED MATERIAL (GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.



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3.2.1 Accomplish the requirements of 009-12 of 2.1, including Table One, Column F, Lines One through 10.

3.2.1.1 Accomplish nondestructive testing in accordance with Line 13.

3.2.2 Accomplish the requirements of 009-09 of 2.1, for process control procedure of welding process.

3.3 Accomplish the requirements of 009-105 of 2.1, for application of High Velocity Oxygen Flame (HVOF) thermal spray coating of tungsten carbide to the equipment listed in 1.3.

3.3.1 Accomplish the requirements of 009-09 of 2.1, for process control procedure of NAVSEA approved process.

4. NOTES:

4.1 None.

5. GOVERNMENT FURNISHED MATERIAL (GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.



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3.1.2 Accomplish a visual inspection of each deck mount flange assembly for structural integrity, deterioration, pitting, cracks, and areas of damage or distortion in each location listed in 1.2, using 2.7 for guidance.

3.1.2.1 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.1.2 to the SUPERVISOR.

3.1.3 Adhesive bond gasket in accordance with Note One of 2.2 and 2.8.

3.1.4 Apply sealant to faying surfaces and fasteners in accordance with Note 9 of 2.2 and 2.8.

(V)(G) "ALIGNMENT"

3.1.5 Align the APU exhaust elbow to the APU exhaust extension and ensure there is a 0.070 clearance between the outside diameter of the APU exhaust extension and the inside diameter of the APU exhaust elbow in accordance with APU Exhaust Stack Alignment Alteration (AER 538) Procedure F.e. of 2.3.

4. NOTES:

4.1 Known sources for St. Gobain gasket material Part No. R10450 listed in 2.6:

Green Rubber Co.  
20 Cross St  
Woburn, MA 01801  
Tel: (781) 497-1855 Ext. 113  
POC: Charlie Fabiano

John G. Shelley Co.  
16 Mica Lane  
Wellesley Hills, MA 02481  
Tel: (781) 237-0900 Ext. 123  
POC: Frank Capezzuto

5. GOVERNMENT FURNISHED MATERIAL (GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

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1. None.



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3.1.1 Install Government Furnished Material (GFM) provided in 5.

3.1.2 Accomplish the requirements of 009-22 of 2.1.

3.1.3 Identify cabling and the equipment by installing new label plates, cable bands and wire markers as follows:

3.1.3.1 Install new label plates conforming to MIL-DTL-15024.

3.1.3.2 Mark applicable lead designations on the lead markers by hot stamping (Branding). Lead markers are to be made of white insulating sleeving conforming to MIL-I-631, Type F, Grade A, Form U. Install lead markers hot stamped (Branded) with the word "SPARE" and the cable designation of the cable containing the spare conductors on spare conductors. When cables have more than one spare conductor, bind the spare conductors together and identify them with a single lead marker.

3.1.3.3 Cable tags (Bands) shall be of soft aluminum and conform to MIL-A-2877 and shall be embossed with the applicable cable designation using numbers and capital letters having minimum height of 3/16 inch and embossed to at least 1/64 inch above the surface. Cable tags and securing strips shall have a thickness of 0.014 to 0.016 inch. Cable tags shall have a minimum width of one-half inch.

3.1.4 Bond and ground equipment in accordance with 2.7. Grounding straps shall be CRES 316L for topside equipment.

3.1.4.1 Acceptable criteria for equipment to hull ground via bond or ground strap is one-tenth ohm maximum.

(V)(G) "OPERATIONAL TEST"

3.2 Energize with Craft's power and accomplish operational testing of the equipment listed in 1.3 and located in 1.2 to ensure equipment functions to designed sequence of operation.

3.2.1 Submit one legible copy, in hard copy or electronic media of a report listing results of the requirements of 3.2 to the SUPERVISOR.

4. NOTES:

4.1 None.

5. GOVERNMENT FURNISHED MATERIAL (GFM):

5.1 LLTM:

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TOTAL							
QUANTITY		NAME OF	PIECE	REF	NATIONAL	PARA	
<u>PROVIDED</u>		<u>PART</u>	<u>NO.</u>	<u>NO.</u>	<u>STOCK NO.</u>	<u>NO.</u>	
1.	2	EA	AC Electronic Module Assy	003	2.2	01-579-2051	3.1.1

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.



CRAFT: LANDING CRAFT AIR CUSHION  
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3.1.3 Bond and ground equipment in accordance with 2.5. Grounding straps shall be CRES 316L for topside equipment.

3.1.3.1 Acceptable criteria for equipment to hull ground via bond or ground strap is one-tenth ohm maximum.

4. NOTES:

5. GOVERNMENT FURNISHED MATERIAL(GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.



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3.1 Accomplish a visual inspection of the 01 Level deck plating and ring assembly in way of each APU exhaust stack for the equipment listed in 1.3, for structural integrity, deterioration, pitting, cracks, and areas of damage or distortion in each location listed in 1.2, using 2.2 for guidance.

3.1.1 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.1 to the SUPERVISOR.

3.2 Remove existing and install new a total of 3 square feet of 01 Level deck plating in each location listed in 1.2, resulting from inspection of 3.1 as authorized by the SUPERVISOR, in accordance with 2.2 and 2.3.

3.2.1 Remove existing and install new a total of 4 linear feet of stiffeners as authorized by the SUPERVISOR.

3.2.2 Vee-out and weld repair a total of 4 linear feet of cracked plating as authorized by the SUPERVISOR.

3.2.3 Template exact size, configuration, and location from existing landing craft conditions.

3.2.4 Accomplish the requirements of 009-12 of 2.1, including Table 4, Column C, Lines One through 7.

3.2.4.1 Accomplish nondestructive testing in accordance with Line 10.

3.2.5 Accomplish the requirements of 009-25 of 2.1 for the local air hose test of each new deck insert and deck plating weld repairs. Allowable leakage: None.

3.3 Accomplish removals, modifications and installations incidental to LCAC1 Class AER-0520, APU Modified Start Bypass Valve (SBV) Exhaust Installation for the equipment listed in 1.3 at each location listed in 1.2, in accordance with 2.4 through 2.8.

3.3.1 Install Government Furnished Kit AER1-T62-K1-REV0-LCAC listed in 5.3.

3.3.2 Template exact size, configuration, and location from existing landing craft conditions.

3.3.3 Chip and grind surfaces flush and smooth in way of repairs.

3.3.4 Accomplish the requirements of 009-12 of 2.1, including Table 4, Columns C and D, Lines One through 7.

(V)(G) "OPERATIONAL TEST"

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3.3.5 Accomplish an operational test of the equipment listed in 1.3 at each location listed in 1.2. Check for leaks around the duct assembly in accordance with procedure F.12 of 2.5. Allowable leakage of new and disturbed joints: None.

3.3.5.1 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.3.5 to the SUPERVISOR.

3.4 Accomplish the requirements of 009-32 of 2.1 for new and disturbed surfaces.

4. NOTES:

4.1 None.

5. GOVERNMENT FURNISHED MATERIAL(GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

TOTAL	NAME OF	PIECE	REF	NATIONAL	PARA
QUANTITY	PART	NO.	NO.	STOCK NO.	NO.
PROVIDED					
1. One KT	AER1-T62-K1 REV0-LCAC	None	2.5	None	3.3.1



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and modified cables.

3.1.2 Identify cabling and equipment by installing new label plates, cable bands and wire markers as follows:

3.1.2.1 Install new label plates conforming to MIL-DTL-15024.

3.1.2.2 Mark applicable lead designations on the lead markers by hot stamping (Branding). Lead markers are to be made of white insulating sleeving conforming to MIL-631, Type F, Grade A, Form U. Install lead markers hot stamped (Branded) with the word "SPARE" and the cable designation of the cable containing the spare conductors on spare conductors. When cables have more than one spare conductor, bind the spare conductors together and identify them with a single lead marker.

3.1.2.3 Cable tags (Bands) shall be of soft aluminum and conform to MIL-A-2877 and shall be embossed with the applicable cable designation using numbers and capital letters having minimum height of 3/16 inch and embossed to at least 1/64 inch above the surface. Cable tags shall have a minimum width of one-half inch.

3.1.3 Bond and ground equipment in accordance with 2.5. Grounding straps shall be CRES 316L for topside equipment.

3.1.3.1 Acceptance criteria for equipment to hull ground via bond or ground strap is one-tenth ohm maximum.

(V)(G) "OPERATIONAL TEST"

3.2 Accomplish an operational test of new and disturbed equipment and circuitry to ensure systems and circuits function to designed sequence of operation in accordance with 2.6.

3.2.1 Submit one legible copy, in hard copy or electronic media of a report listing results of the requirements of 3.2 to the SUPERVISOR.

4. NOTES:

4.1 None.

5. GOVERNMENT FURNISHED MATERIAL(GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

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1. None.

5.3 KITTED MATERIAL:

1. None.



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1.3 and located in 1.2, and remove existing upper and lower rudder fittings and each rudder assembly in accordance with 2.2 and 2.3, using 2.4 through 2.8 for guidance. Retain fasteners for reuse.

(V)(G) "CLEANLINESS"

3.1.1 Clean the bearing bores internal surfaces of the upper and lower bearing housing for each rudder free of debris and foreign matter.

3.1.2 Accomplish a visual inspection of each rudder fitting, upper and lower, for structural integrity, deterioration, pitting, cracks and other defects.

3.1.3 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.1.2 to the SUPERVISOR showing exact locations of discrepancies and recommendations for repairs.

3.2 Install the equipment removed in 3.1, using the retained fasteners. Connect each hydraulic actuator to each rudder assembly listed in 1.3 and located in 1.2 in accordance with 2.2, 2.3, and 2.8, using 2.4 through 2.7 for guidance.

3.2.1 Remove existing, fit, and install new the following parts:

TOTAL

QUANTITY REQUIRED	NAME OF PART	PIECE NO.	REF. NO.	FIGURE DRAWING NO.	PART NO.
4 EA	Bearing Assembly Rudder Upper, LCAC	37	2.3	7.2	KPD1264
4 EA	Bearing Assembly Rudder Lower, LCAC	64	2.3	7.2	KPD892

(V)(G) "OPERATIONAL TEST"

3.3 Accomplish an operational test of each rudder assembly listed in 1.3 and located in 1.2 in accordance with 2.2.

3.3.1 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.3 to the SUPERVISOR.

4. NOTES:

4.1 LCAC Craft Change Document-471 Rev 00, Modification to Split Rudder Bearing Fitting; accomplish, is covered on Work Item 562-85-001.

5. GOVERNMENT FURNISHED MATERIAL (GFM):

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5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.



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- 2.7 S9246-AA-MMA-010 Rev 5, Operation and Maintenance Manual for Landing Craft, Air Cushion (LCAC) Propeller Duct Shrouds and Support Structures
- 2.8 562-5749958 Rev N, LCAC Rudder Assembly and Installation
- 2.9 562-5749959 Rev K, LCAC Rudder Details
- 2.10 246-5749947 Rev M, LCAC Rudder Fitting, Top
- 2.11 246-5749948 Rev M, LCAC Rudder Fitting, Assy Bottom
- 2.12 LCAC AER-0390 Rev 01, Rudder Fitting Repair
- 2.13 T9074-AS-GIB-010/271, Requirements for Nondestructive Testing Methods
- 2.14 MIL-STD-2035, Nondestructive Testing Acceptance Criteria

3. REQUIREMENTS:

3.1 Accomplish removals, modifications and installations incidental to LCAC Craft Change Document-471 Rev 00, Modification to Split Rudder Bearing Fittings, for the equipment listed in 1.3 and located in 1.2, in accordance with 2.1 through 2.4, using 2.5 through 2.12 for guidance.

3.1.1 Disassemble each rudder bearing fitting, using 2.10 and 2.11 for guidance.

3.1.1.1 Inspect each rudder bearing fitting for wear and defects in accordance with Drawing Note 4 of 2.1 and 2.2, using 2.10 and 2.11 as guidance for accept or reject criteria.

3.1.1.2 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.1.1.1 to the SUPERVISOR.

(I) "NONDESTRUCTIVE TESTING"

3.1.2 Accomplish a liquid penetrant inspection on indications of suspect areas resulting from machining process in accordance with 2.13. The accept or reject criteria shall be in accordance with Paragraph 7 of 2.14.

3.1.3 Remove existing, fit, and install new the following parts:

TOTAL	QUANTITY	NAME	FIND	REF.	FIGURE	PART
REQUIRED	OF	PART	NO.	NO.	DRAWING NO.	NO.

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64 EA	Bolt, Hex Head	22	2.1 & 2.2	N/A	NAS1007-14A
128 EA	Washer, Flat	23	2.1 & 2.2	N/A	AN960C716
64 EA	Nut, Self-lkg	24	2.1 & 2.2	N/A	MS21044C7
32 EA	Screw, Socket Head	16	2.1 & 2.2	N/A	NAS1351C5H28
32 EA	Washer, Flat	15	2.1 & 2.2	N/A	AN960C516
32 EA	Insert, Helicoil	14	2.1 & 2.2	N/A	MS21209-F5-25

(V)(G) "TORQUE FASTENERS"

3.1.4 Torque hex head bolts to 475-628 Inch-lbs and socket head screws to 250 Inch-lbs in accordance with Drawing Notes 16 and 17 of 2.1 and 2.2.

(V)(G) "OPERATIONAL TEST"

3.2 Accomplish an operational test of each rudder assembly listed in 1.3 and located in 1.2 in accordance with 2.6. Allowable binding or erratic operation: None.

3.2.1 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.2 to the SUPERVISOR.

4. NOTES:

4.1 Port and Starboard Rudder Bearing; replace is covered by Work Item 562-11-001.

5. GOVERNMENT FURNISHED MATERIAL (GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.



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3. REQUIREMENTS:

3.1 Accomplish removals, modifications and installations incidental to LCAC1 Class CraftAlt-0402D Rev 00, Replace Side Windshield Wiper, for the equipment listed in 1.3 and located in 1.2, in accordance with 2.2 through 2.7.

3.1.1 Install new mounting bracket (Find No. 64 of 2.3) including hardware for the middle window located in 1.2.2 in accordance with 2.3 and 2.4.

3.1.1.1 Accomplish the requirements of 009-12 of 2.1, including Table 4, Column C, Lines One through 7.

3.1.2 Accomplish the requirements of 009-22 of 2.1 for the cable terminating in the equipment listed in 1.3.

3.1.3 Bond and ground equipment in accordance with 2.8. Grounding straps shall be CRES 316L for topside equipment.

3.1.4 Spray the metal portions of each windshield wiper with corrosion preventive compound conforming to MIL-PRF-81309, Type II.

3.1.5 Lubricate the hinge pin area of each windshield wiper with lubricating preservative conforming to MIL-PRF-32033.

3.2 Weatherproof and seal connectors exposed to the weather in accordance with 2.9.

(V)(G) "OPERATIONAL TEST"

3.3 Energize with craft's power and accomplish operational testing of the equipment installed in 3.1 to ensure equipment functions to designed sequence of operation, in accordance with manufacturer's instructions supplied with the equipment.

4. NOTES:

4.1 None.

5. GOVERNMENT FURNISHED MATERIAL(GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

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5.3 KITTED MATERIAL:

1. None.



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3.1 Accomplish surface preparation and preservation of surfaces incidental to LCAC1 Class CraftAlt-0445K Rev 01, Limited Compartment Painting, in each compartment listed in 1.2, using 2.2 through 2.5 for guidance.

3.2 Accomplish the requirements of 009-32 of 2.1, including Table 3, Line 42, Column A, for surface preparation of aluminum surfaces as follows:

3.2.1 Method of surface preparation shall be abrasive blasting with garnet or aluminum oxide conforming to CID A-A-59316 to an average profile of 2.5 to 4.0 mils.

3.2.2 Aluminum surfaces shall be coated within 8 hours of surface preparation.

3.2.3 Accomplish the requirements of 009-32 of 2.1, for surface preparation of wet deck surfaces, and 6 inches above deck of bulkhead surfaces for each compartment listed in 1.2.1 and 1.2.2.

3.2.4 Accomplish the requirements of 009-32 of 2.1, for surface preparation of bulkhead, overhead and deck surfaces in their entirety for each compartment listed in 1.2.3 through 1.2.8.

3.3 Accomplish the requirements of 009-32 of 2.1, including Table 2, Line 21, Columns B through D, for preservation of surfaces prepared in 3.2.

4. NOTES:

4.1 Accomplish structural repairs and welding prior to application of coating materials.

5. GOVERNMENT FURNISHED MATERIAL (GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.



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3. REQUIREMENTS:

3.1 Review each Flushing, Pressure and Functional Test Procedure of 2.2 through 2.9, and edit each test procedure for accomplishment.

3.1.1 Flushing, Pressure and Functional Test Procedures shall be edited to correspond to actual scope of work required to verify satisfactory completion of Contractor's work, and testing necessary to accomplish craft light-off.

3.1.1.1 Each Flushing Procedure shall show locations of loops, jumpers, vents and drains, and all flushing equipment needed to accomplish the required flushing procedure.

3.1.2 Submit each edited Flushing, Pressure and Functional Test Procedure of 3.1 to the SUPERVISOR at least 30 days prior to accomplishment for review and approval.

(V)(G) "FLUSHING, PRESSURE AND FUNCTIONAL TESTS"

3.2 Accomplish the prerequisites and Flushing, Pressure and Functional Tests in accordance with each approved test procedure submitted in 3.1.2. Record test results on Test Data Sheets. Verify operation during harbor trials, using data contained in each test procedure for acceptance criteria.

3.2.1 Adjust and correct equipment and systems to ensure successful completion of each test prior to accomplishing Flushing, Pressure and Functional Test Procedures.

3.2.2 Ensure filters are installed during flushing operations of 3.2 in accordance with each approved test procedure. Install new system filters after completion of each individual flushing operation.

3.2.3 Submit one legible copy, in hard copy or electronic media, of completed Flushing, Pressure and Functional Test Data Sheets applicable to each test procedure accomplished in 3.2 to the SUPERVISOR.

4. NOTES:

4.1 None.

5. GOVERNMENT FURNISHED MATERIAL (GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

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1. None.

5.3 KITTED MATERIAL:

1. None.



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- 1.2.19 Engine Room No. 2 Access Room (1-12-4-Q)
- 1.2.20 Engine Room No. 4 Access Room (1-13-4-Q)
- 1.2.21 Engine Room No. 3 Inlet Air Filters (1-13-1-Q)
- 1.2.22 Engine Room No. 4 Inlet Air Filters (1-13-2-Q)
- 1.2.23 Floodable Void (2-1-1-V)
- 1.2.24 Floodable Void (2-1-2-V)
- 1.2.25 Flotation Void (2-1-3-V)
- 1.2.26 Flotation Void (2-1-4-V)
- 1.2.27 Flotation Void (2-2-1-V)
- 1.2.28 Flotation Void (2-2-2-V)
- 1.2.29 Stowage Space (Line Locker)(2-2-3-A)
- 1.2.30 Stowage Space (Line Locker)(2-2-4-A)
- 1.2.31 Flotation Void (2-3-1-V)
- 1.2.32 Flotation Void (2-3-2-V)
- 1.2.33 Fuel Tank No. One (2-3-3-F)
- 1.2.34 Fuel Tank No. 2 (2-3-4-F)
- 1.2.35 Fuel Equipment Space (2-4-1-Q)
- 1.2.36 Fuel Equipment Space (2-4-2-Q)
- 1.2.37 Electronic Equipment Space (2-5-1-Q)
- 1.2.38 Electronic Equipment Space (2-5-2-Q)
- 1.2.39 Electronic Equipment Space (2-5-3-Q)
- 1.2.40 Electronic Equipment Space (2-5-4-Q)
- 1.2.41 Fuel Overflow Tank (2-5-6-F)
- 1.2.42 Stowage Space (2-6-1-A)
- 1.2.43 Stowage Space (2-6-2-A)
- 1.2.44 Floodable Void (2-6 1/2-1-V)

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- 1.2.45 Floodable Void (2-6 1/2-2-V)
- 1.2.46 Air Plenum, Lift Fan No. One (2-6 1/2-3-P)
- 1.2.47 Air Plenum, Lift Fan No. 2 (2-6 1/2-4-P)
- 1.2.48 Floodable Void (2-6 1/2-5-V)
- 1.2.49 Floodable Void (2-6 1/2-6-V)
- 1.2.50 Flotation Void (2-7-1-V)
- 1.2.51 Flotation Void (2-7-2-V)
- 1.2.52 Air Plenum (2-7-0-P)
- 1.2.53 Air Plenum (2-8-1-P)
- 1.2.54 Air Plenum (2-8-2-P)
- 1.2.55 Floodable Void (2-8 1/2-1-V)
- 1.2.56 Floodable Void (2-8 1/2-2-V)
- 1.2.57 Air Plenum, Lift Fan No. 3 (2-8 1/2-3-P)
- 1.2.58 Air Plenum, Lift Fan No. 4 (2-8 1/2-4-P)
- 1.2.59 Floodable Void (2-8 1/2-5-V)
- 1.2.60 Floodable Void (2-8 1/2-6-V)
- 1.2.61 Stowage Space (2-9-1-A)
- 1.2.62 Stowage Space (2-9-2-A)
- 1.2.63 Stowage Space (2-10-1-A)
- 1.2.64 Stowage Space (2-10-2-A)
- 1.2.65 Electronic Equipment Space (2-10-3-Q)
- 1.2.66 Electronic Equipment Space (2-10-4-Q)
- 1.2.67 Electronic Equipment Space (2-11-1-Q)
- 1.2.68 Electronic Equipment Space (2-11-2-Q)
- 1.2.69 Electronic Equipment Space (2-11-3-Q)
- 1.2.70 Electronic Equipment Space (2-11-4-Q)

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- 1.2.71 Electronic Equipment Space (2-12-1-Q)
- 1.2.72 Stowage Space (2-12-2-A)
- 1.2.73 Flotation Void (2-12-3-V)
- 1.2.74 Electronic Equipment Space (2-12-4-Q)
- 1.2.75 Water Wash Tank (2-12-6-W)
- 1.2.76 Stowage Space (2-13-1-A)
- 1.2.77 Flotation Void (2-13-2-V)
- 1.2.78 Flotation Void (2-13-3-V)
- 1.2.79 Flotation Void (2-13-4-V)
- 1.2.80 Electronic Equipment Space (2-14-1-Q)
- 1.2.81 Electronic Equipment Space (2-14-2-Q)
- 1.2.82 Flotation Void (2-14-3-V)
- 1.2.83 Flotation Void (2-14-4-V)
- 1.2.84 Fuel Equipment Space (2-15-1-Q)
- 1.2.85 Fuel Equipment Space (2-15-2-Q)
- 1.2.93 Electronic Equipment Space (2-15-3-Q)
- 1.2.94 Battery Space (2-15-4-Q)
- 1.2.95 Flotation Void (2-16-1-V)
- 1.2.96 Flotation Void (2-16-2-V)
- 1.2.97 Flotation Void (2-16-3-V)
- 1.2.98 Oily Waste Tank (2-16-4-F)
- 1.2.99 Fuel Tank No. 3 (2-16-5-F)
- 1.2.100 Fuel Tank No. 4 (2-16-6-F)
- 1.2.101 Electronic Equipment Space (2-17-1-Q)
- 1.2.102 Electronic Equipment Space (2-17-2-Q)
- 1.2.103 Fuel Equipment Space (2-17-3-Q)

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- 1.2.104 Fuel Equipment Space (2-17-4-Q)
- 1.2.105 Floodable Void (2-18-1-V)
- 1.2.106 Floodable Void (2-18-2-V)
- 1.2.107 Flotation Void (2-18-3-V)
- 1.2.108 Hydraulic Equipment Space (2-18-4-Q)
- 1.2.109 Flotation Void (2-18-5-V)
- 1.2.110 Flotation Void (2-18-6-V)
- 1.2.111 Flotation Void (2-18-7-V)
- 1.2.112 Flotation Void (2-18-8-V)
- 1.2.113 Flotation Void (2-18-9-V)
- 1.2.114 Flotation Void (2-18-10-V)
- 1.2.115 Floodable Void (2-19-1-V)
- 1.2.116 Floodable Void (2-19-2-V)
- 1.2.117 Floodable Void (2-19-3-V)
- 1.2.118 Floodable Void (2-19-4-V)

1.3 Identification:

- 1.3.1 Not Applicable

2. REFERENCES:

- 2.1 Standard Items
- 2.2 802-6800306 Rev C, LCAC Plan View of Each Level, Deck & Platform
- 2.3 S9086-SP-STM-010/CH-542, Gasoline and JP-5 Fuel Systems
- 2.4 MIL-HDBK-291, Military Handbook Cargo Tank Cleaning
- 2.5 S9086-CJ-STM-010/CH-075, Fasteners
- 2.6 7614-947911 Rev A, Process Specification for Cleaning, Chemical, and Mechanical LCAC
- 2.7 7614-947921 Rev E, Process Specification for Sealants LCAC

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3. REQUIREMENTS:

3.1 Open, ventilate, empty, clean, render dry and maintain any tank or space including adjacent tanks, spaces or piping systems where the scope of repairs will result in a need for certification during the performance of this Job Order, using 2.2 for location guidance.

3.1.1 A total of 20 tanks or spaces listed in 1.2 designated by the SUPERVISOR shall be certified and maintained throughout the availability.

3.1.2 "Intentionally Left Blank"

3.1.3 Ensure that harmful vapors, fumes, or mists are ventilated to the exterior of the vessel.

3.1.4 Submit one legible copy, in electronic media, of a report listing the location, origin, and quantity of each manhole cover removed in 3.1 with respect to its tank, craft's frame, and distance off centerline to the SUPERVISOR.

3.1.5 Clean each tank and any associated piping in accordance with 2.3 and 2.4.

3.1.6 Clean and inspect each removed fastener for wear and defects, using Paragraph 075-8.3 of 2.5 for accept or reject criteria. Visually inspect to ensure material type is the same as required in 3.8 (CRES, Brass, Nickel-copper, galvanized or zinc coated steel). Retain fasteners found acceptable for reuse.

3.1.6.1 Accomplish a visual inspection to verify correct material for application.

3.1.6.2 Submit one legible copy, in hard copy or electronic media, of a report listing results of the requirements of 3.1.6 and 3.1.6.1 to the SUPERVISOR.

3.2 Pump tanks containing petroleum products to the low suction level of each tank.

3.2.1 Off-loading or transferring of petroleum products shall be accomplished during daylight hours only.

3.2.2 Hoses, pumps, and containers shall be clean and dry prior to start of off-loading.

3.2.3 Submit one legible copy, in hard copy or electronic media, of completed Attachment A (INVENTORY SCHEDULE-PETROLEUM PRODUCTS) to the SUPERVISOR.

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(V)(G) "VERIFY OFF LOAD/TRANSFERRING COORDINATION"

3.3 Coordinate the off loading or transferring of fluids through the craft's Damage Control Assistant (DCA), via the SUPERVISOR, to maintain craft's stability and to prevent flooding.

3.3.1 Obtain a list from the SUPERVISOR of petroleum soundings for tanks prior to start of pumping operations.

3.4 Clean each deck surface of spaces designated by the SUPERVISOR in 3.1.1 and listed in 1.2.23 through 1.2.118 free of trash, debris, grease, oily liquids, and other liquid contaminants prior to the initial certification.

3.4.1 Maintain each deck surface to a clean, dry condition for the duration of the availability on a 7-day-a-week, 24-hour-a-day basis.

3.4.2 Remove and dispose of an additional 5 gallons of non-hazardous liquids from deck surfaces generated by the Navy, after initial cleaning and certification is obtained. Removals shall be measured. Total amount of liquids removed greater or less than the above amount will be the subject of an equitable adjustment.

(V)(G) "SOURCE DETERMINATION"

3.4.2.1 Submit one legible copy, in electronic media, of a report listing the amount of gallons removed in 3.4.2, responsible source of liquids, and date liquids were removed after each pumping operation.

(V)(G) "CLEAN AND DRY DECK SURFACES"

3.4.3 Prior to space turnover, when directed by the SUPERVISOR, accomplish a final detergent cleaning of each deck surface of spaces designated by the SUPERVISOR in 3.1.1 and listed in 1.2.23 through 1.2.118, removing all trash, debris, grease, oily liquids, and other liquid contaminants from the deck surfaces.

3.5 Clean each line locker listed in 1.2.29 and 1.2.30 free of silt, mud, and foreign matter.

3.6 Remove and dispose of liquids, sludge, and debris, in accordance with federal, state, and local laws, codes, ordinances, and regulations.

3.6.1 Accomplish a chemical analysis of liquid waste, sludge, and debris in accordance with applicable federal, state, and local laws, codes, ordinances, regulations, and Naval Facility requirements.

3.6.1.1 One chemical analysis is required for each containment (Engine Room, Space, etc.) or for each type of liquid (fuel oil, JP-5, etc.).

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3.6.1.2 Submit one legible copy, in electronic media, of each analysis to the SUPERVISOR. Also identify the volume of the liquid from which each sample was taken.

3.7 Tank Closure Repairs:

3.7.1 Clean, chase, or tap threaded areas prior to installing covers.

3.7.2 Weld up, drill, and tap a total of 10 stripped manhole cover bolting ring holes for tanks opened in 3.1.

3.7.3 Accomplish the requirements of 009-12 of 2.1, including Table 4, Column C, Lines One through 7.

3.7.4 Accomplish the requirements of 009-32 of 2.1 for new and disturbed interior surfaces.

(V)(G) "INSPECT TANK CLEANLINESS AND COMPLETION OF REPAIRS"

3.8 Inspect each tank for cleanliness and completion of repairs prior to final closing. Document the personnel who were present during the inspection and confirm that they have exited the space prior to closure of tanks, voids, and cofferdams. Designate one person to account for all personnel who may have entered the space.

3.8.1 Reinstall existing fasteners found acceptable in 3.1.6.

3.8.2 Install manhole cover for each tank, using new gaskets conforming to MIL-PRF-6855, Class One, Grade 60, new CRES washers conforming to AN960C516, new CRES 316 stainless steel nuts conforming to MS21044C5, and new CRES 316 hex head cap screws conforming to NAS501-5-10A.

3.8.3 Install access cover for the fresh water tank listed in 1.2.75, using new gasket conforming to MIL-PRF-900, 45 Durometer Hardness, new CRES washers conforming to NAS1149CO632R, new CRES 316 stainless steel nuts conforming to MS21044C6, and new CRES 316 hex head cap screws conforming to NAS501-6-11A.

3.8.4 Clean the gasket mating surfaces in accordance with 2.6, Type A.

3.8.5 Apply sealant to fasteners and bond the gasket in accordance with 2.7, Type I.

3.9 Accomplish the requirements of 009-32 of 2.1, for new and disturbed surfaces.

4. NOTES:

4.1 For the purpose of this Work Item, the term "tank or space" includes

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voids, cofferdams, and inaccessible or confined areas.

4.2 Consider each deck surface to contain contaminated oily salt water.

4.3 Booklet of General Plans and Tank Sounding Tables are available for review at the office of the SUPERVISOR.

4.4 The SUPERVISOR will provide sequence of tanks and dates of inspections referenced in 3.1.2.

4.5 Associated piping is defined as, "An assembly of pipe, tubing, valves, fittings and related components forming a whole or a part of a system which starts or terminates in subject area, thus being common to and associated with same."

4.6 Cotton wax wicking (6 plies per strand) conforming to MIL-DTL-713 may be used as a means of ensuring a watertight seal of manhole and access covers.

5. GOVERNMENT FURNISHED MATERIAL (GFM):

5.1 LLTM:

1. None.

5.2 PUSH MATERIAL:

1. None.

5.3 KITTED MATERIAL:

1. None.