

N00189-16-T-E046

CONTINUATION REPORT

ICN 36KSO86008	KO S21	MATL ITEM ID 00146
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REQ DOC NO. N42158-6040ZN01	REV	CONTRACT NO.	REFERENCE DOC NO.	ATTACHMENT A	
NAME OF OFFEROR OR CONTRACTOR					
ITEM NO.	SUPPLIES/SERVICES	QTY	UNIT	UNIT PRICE	AMOUNT
0001	9B 5340 LLR150381 TURNBUCKLE JAW AND JAW TURNBUCKLE ASSEMBLY 3-1/2" X 25" TURNBUCKLE BODY 24" MINIMUM TAKE-UP 75 TON CAPACITY TURNBUCKLES SHALL MEET THE REQUIREMENTS OF ATTACHMENT (1) CERTIFICATE OF CONFORMANCE AND CERTIFIED TEST REPORTS REQUIRED PER ATTACHMENT (2).	4	EA		
CERTIFICATE OF COMPLIANCE REQUIRED VENDOR BIDS SHALL BE ACCOMPANIED BY A PROPOSAL DRAWING FOR ENGINEERING EVALUATION AND APPROVAL PRIOR TO AWARD OF CONTRACT.					
ACR:					

N00189-16-T-ED46

Attachment (A1) Document Number 6040ZN01
Jaw and Jaw Turnbuckle Ordering Specifications

Jaw and Jaw Turnbuckle Assembly
3-1/2" x 25" Turnbuckle Body
24" minimum Take-up
75 Ton Capacity (Working Load)
Quantity: 4

1. Turnbuckles shall be weld-less and forged.
2. Turnbuckles shall have a minimum breaking strength of 5 times the manufacturer's safe working load (750,000 lbs.). Break test on one extra assembly for verification is required.
3. Shall meet the same technical requirements of Federal Specification RR-C-271 Rev F. for material composition as for shackles and shall be made of carbon steel conforming to ASTM A576, ASTM A920/920M, ASTM A909/A909M, or ASTM A921/A921M or alloy steel conforming to ASTM A322. The limitation in the chemical composition shall be as follows:

Carbon: 0.45% max
Phosphorus: 0.04% max
Sulfur: 0.045% max
Silicon: 0.35% max

Forged bolts and pins of jaw-end type turnbuckles can be made from ASTM A325 Type 1, ASTM A449 Type 1, ASTM A576 Grade 5, or SAE J429 Grade 5 carbon steel.

4. Turnbuckles shall have heavy jam nuts on both thread ends as seen in Figure (1).
5. Turnbuckles shall have jaw openings to accommodate the bail of a standard 3-1/2" shackle.
6. Turnbuckles shall have a minimum take-up of 24".
7. Each turnbuckle shall be load tested to 150%, (+5%, -0%) of the working load limit. Load shall be held for 10 minutes minimum. LOAD TEST SHALL BE PERFORMED PRIOR TO MT INSPECTION. No yield, permanent deformation, or break is allowed.
8. After load testing, all turnbuckles shall be 100% wet magnetic particle (MT) inspected per NAVSEA Technical Publication T9074-AS-GIB-010/271 ACN 1. MT acceptance criteria shall be per MIL-STD-2035A, Section 6.4.
 - 8.1 MT Inspection Records per Para. 4.3.1.9 of NAVSEA Technical Publication T9074-AS-GIB-010/271 ACN 1 shall be provided by vendor for each turnbuckle provided by this contract.

Attachment (H) Document Number 6040ZN01
Jaw and Jaw Turnbuckle Ordering Specifications

9. Turnbuckle shall be self-colored and have no plating or coatings that would interfere with MT inspection by the purchaser. Rust preventative coating is acceptable.
10. Vendor bids shall be accompanied by a proposal drawing for engineering evaluation and approval prior to award of contract.
11. Vendor shall provide Certificate(s) of Conformance that certify the turnbuckles provided meet the following requirements:
 - 11.1 The turnbuckles are weld-less and forged.
 - 11.2 The turnbuckles meet the same technical requirements of Federal Specification RR-C-271 Rev. F for material composition as for shackles as specified in paragraph 3.
 - 11.3 Certificates shall be traceable to the purchase contract under which the material is provided.
12. Vendor shall provide the following Certified Test Reports:
 - 12.1 Break test report for assembly tested per paragraph 2 for verification that the minimum breaking strength is 5 times the manufacturer's rated safe working load (750,000 lbs).
 - 12.2 Load Test Report/Certificate for each turnbuckle to include test load and duration of test per Para. 7. Above.
 - 12.3 MT Inspection Records per Para. 4.3.1.9 of NAVSEA Technical Publication T9074-AS-GIB-010/271 ACN 1 for each turnbuckle tested, inspected and accepted per Para. 8 above.
 - 12.4 All above required information shall be traceable to the turnbuckles received per this order by a serial number that corresponds to above requested certification test reports and other data sheets. Test reports and other documentation must be traceable to the purchase contract under which the material is provided.

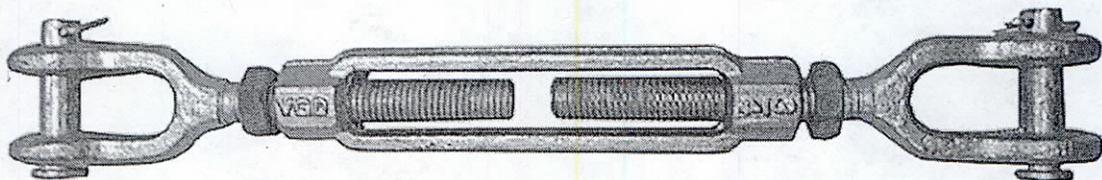


Figure (1)

N00189-16-T-E046

CERTIFICATE OF COMPLIANCE

* SAMPLE *

COMPANY NAME _____

MATERIAL IDENTIFICATION (COMPLETE APPLICABLE ITEMS)

CONTRACT NO. _____ ORDER NO _____

ITEM NO. _____

NATIONAL/LOCAL STOCK NUMBER NSN/LSN _____

MANUFACTURER'S PART NO. _____

MANUFACTURER'S SERIAL NO. _____

DRAWING AND PIECE NO. _____

MANUFACTURER'S LOT/HEAT NOS. AS MARKED ON THE MATERIAL: _____

I ATTEST ALL ITEMS FURNISHED ON THIS CONTRACT ARE IN FULL COMPLIANCE WITH ALL CONTRACT REQUIREMENTS.

SIGNATURE _____ DATE _____
QUALITY ASSURANCE OFFICIAL

TITLE _____

THE INSPECTION AND TEST REPORTS (AS APPLICABLE) PROVIDED REPRESENT THE ACTUAL ATTRIBUTES OF THE ITEMS FURNISHED ON THIS CONTRACT AND INDICATE FULL COMPLIANCE WITH ALL CONTRACT REQUIREMENTS.

REQ'D N/A
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SIGNATURE _____ DATE _____
QUALITY ASSURANCE OFFICIAL

TITLE _____

“NOTE”: WHEN ITEM(S) HAVE BEEN SHIPPED, PLEASE COMPLETE CERTIFICATION(S) AND RETURN. THIS WILL EXPEDITE RECEIPT AND PAYMENT.

MAIL TO:

NORFOLK NAVAL SHIPYARD
BLDG. 1500, 2ND FLOOR
PORTSMOUTH, VA 23709-5000
ATTN: CODE 2305.23, EXPEDITING SECTION
DELIVER ONE (1) COPY WITH MATERIAL

ENCLOSURE (1)