

ATTACHMENT 4
TECHNICAL ORDERING DATA (TOD)

CONTRACT No: _____
ITEM: 0001

SECTION B - SUPPLIES/SERVICES:

NATIONAL STOCK NUMBER (NSN): 1H 5310-01-311-9729 X2

ITEM NAME: NUT, HEX, NICKEL-COPPER, SELF-LOCKING, SPECIAL

SPECIAL CHARACTERISTICS: 1.000"-08UNJC-3B, NAVSEA DRAWING 820-4530015, LEVEL 1

Qty: 420 Ea.

SECTION C - DESCRIPTION/SPECIFICATIONS:

C.1. Manufacture per the attached Individual Repair Part Ordering Data (IRPOD), NAVSEA drawing 820-4530015, and as modified by this contact.

C.1.1. The order of precedence for any conflicting documentation/requirements shall be as follows:

- (a) The contract (including attachments, modifications, amendments, etc.).
- (b) The IRPOD.
- (c) Drawings referenced by the IRPOD.
- (d) Specifications referenced by the IRPOD or drawing.

C.1.2. Material is to be NiCu per 688-1864, Table 1, Material No. 8 for self-locking nuts as modified by the following:

C.1.2.1. Material shall be per QQ-N-281, Class A, Form 1 (Bar), cold drawn and stress relieved.

Ultrasonic Testing (UT) of the starting material shall be performed per MIL-STD-2132 with acceptance criteria per QQ-N-281.

C.1.2.2. Material shall meet MCS-6 Level B requirements.

C.1.2.3. Required mechanical properties are provided by NAVSEA drawing 820-4530015.

C.1.3. Thread inspection shall be accomplished per ASME B1.3, System 22 (variable gaging).

C.1.4. Per the IRPOD, Liquid Penetrant Testing (Examination) of the finished fastener is not required.

C.2. Section 2.0 of the IRPOD lists applicable documents to be used (e.g., drawings, specifications, standards, etc.) and their required version level (e.g., revisions, amendments, change notices, interim changes, etc.). The following list of documents and version information takes precedence over version information (including the lack of any version information) identified by the IRPOD or NAVSEA drawing 820-4530015:

- (a) QQ-N-281D, Am(2), IC(1); NICKEL-COPPER ALLOY BAR, ROD, PLATE, SHEET, STRIP, WIRE, FORGINGS, AND STRUCTURAL AND SPECIAL SHAPED SECTIONS
- (b) MCS-6G; STANDARD FOR CONTROL OF MATERIAL FOR PLANT COMPONENTS
- (c) MIL-STD-792F; IDENTIFICATION MARKING REQUIREMENTS FOR SPECIAL PURPOSE COMPONENTS
- (d) MIL-STD-2132E; NONDESTRUCTIVE EXAMINATION REQUIREMENTS FOR SPECIAL APPLICATIONS (CONTROLLED DISTRIBUTION)
- (e) MIL-STD-129R; MARKING FOR SHIPMENT AND STORAGE
- (f) SAE J122, JUL 75 (REAFFIRMED MAY 1998); SURFACE DISCONTINUITIES ON NUTS
- (g) NASM 25027, REV. 1; NUT, SELF-LOCKING, 250F, 450F, AND 800F
- (h) MIL-DTL-24354F; STUDS, BOLT-STUD, BOLTS, NUTS, CAPSCREWS CORROSION-RESISTANT AND NON-FERROUS MATERIALS
- (i) ASTM D3951-18; STANDARD PRACTICE FOR COMMERCIAL PACKAGING

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C.2.1. If no document version is identified (anywhere in the contract or referenced documents), then use the latest version identified in the Acquisition Streamlining and Standardization Information System (ASSIST) at the time of contract award; ASSIST information is available at the following website:

<https://quicksearch.dla.mil>. If no document version information is available in ASSIST, then any version of the document may be used provided its version is dated 1 November 1969 or later.

C.2.2. In any case, the vendor shall use only one version in its entirety (i.e., the vendor shall not use portions of different versions of a document).

C.3. DATA REQUIREMENTS:

C.3.1. Material Certification; See Exhibit A, Data Item No. A001.

C.3.2. Procedure Approvals; See Exhibit A, Data Item No. A002. The vendor shall provide, and obtain approval for, the procedures identified below prior to their use:

C.3.2.1. ULTRASONIC TEST PROCEDURE

- a. For Starting Material, per Note 9 of NAVSEA drawing 820-4530015.
- b. Procedure (per MIL-STD-2132), including acceptance criteria (per QQ-N-281), shall be submitted.

C.4. CLEANLINESS REQUIREMENTS:

C.4.1. Cleanliness requirements shall be per Section 3.2 of the IRPOD.

C.5. MATERIAL MARKING (LEVEL 1 MATERIAL):

C.5.1. Each piece shall be permanently marked at least once with the information of (a), (b), (c), and (d) below using the permanent marking methods of MIL-STD-792 authorized by NAVSEA drawing 820-4530015. If any marking specified below cannot be applied due to space limitation, a waiver request shall be submitted to the contracting officer.

- (a) "ANICU" and the Material Designator "NCH".
- (b) The manufacturer's name, trademark, or symbol.
- (c) The vendor traceability number traceable to all manufacture test and inspection information and to a unique set of physical, mechanical, and chemical test results which represent the material used to make the piece.
- (d) Any information required by the specification or drawing in addition to that required by (a), (b), and (c) above shall be marked either per the specification/drawing or at least once per the permanent marking methods authorized above. The Material Designator listed in the specification or drawing need not be marked on material, if it is different from that specified by (a) above.

C.5.2. The location of the markings shall be on the flats of the nut per NAVSEA drawing 820-4530015.

C.5.3. If feasible, consolidate the placement of the permanent marking(s) to accommodate the marking of a nine digit final acceptance marking at Portsmouth Naval Shipyard. Do not compromise the legibility of the permanent markings to meet this request.

C.6. NAVSEA HQ C-2-0023 Mercury Control.

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SECTION D - PRESERVATION/PACKAGING/PACKING:

D.1. Marking requirements for packaging shall be per Section 5.0 of the IRPOD.

D.2. Preservation, Packaging, and Packing shall be in accordance with ASTM D3951, except that each externally threaded item shall be furnished with a thread protector and each item shall be individually packaged in a colored (except yellow) transparent zip-lock type package with a minimum size of 4-inch by 7-inch.

D.3. The use of MIL-STD-2073-1 packaging codes are not required for this contract.

SECTION E - INSPECTION ACCEPTANCE:

E.1. Government inspection is required during manufacture and prior to shipment from this facility. Upon receipt of this order, promptly notify the Representative of the Government office who normally serves your facility so that appropriate planning for Government inspection can be accomplished. In the event a Representative of the Government office cannot be located, the Contracts Specialist should be notified promptly. Provide the location where Procurement Quality Assurance (PQA) of the supplies will be made along with the organization that will be performing PQA.

E.2. All non-conformances to contract requirements affecting product and/or documentation shall require procuring activity waiver approval to accept.

E.3. FAR 52.246-11, Higher-Level Contract Quality Requirements

Supplemented by:

NAVSEA HQ H-246-H001 Calibration System Requirements (NAVSEA)

NAVSEA HQ E-246-H020 Quality Management System Requirements (NAVSEA)

NAVSEA HQ C-246-H002 Government use of Contractor's Inspection Equipment (NAVSEA)
(MIL-I-45208 or ISO 9001/9002 with STR-9000 Supplement A or B or C)

E.4. FAR 52.246-2 Inspection of Supplies-Fixed-Price (Aug 1996).