REVISION No.: 2 Date: August 2017

TALON HELO LANDING GRID BOLT

P-588-0507

ORIGINATED BY: Arnold Abbas CTR DATE: 11/2016

REVIEWED BY: Stephen R. Twomey DATE: 11/2016

ORIGINATOR'S COMMAND: SURFACE FORCES LOGISTICS CENTER

DEPARTMENT/DIVISION: WMEC PRODUCT LINE SUPPLY BRANCH

Statement of Work

1. The Coast Guard requires manufacture of the following listed item:

NSN: 5340 01-481-3786
Item Name: Bolt, Talon Helicopter Landing
Part Number: FL-588-3, DETAIL 42-D

2. Applicable Documents:

a) American Society for Testing and Materials (ASTM): ASTM A276/A276M Rev A, Standard Specification for Stainless Steel Bars and Shapes, dated 2016.05.1.
b) Society of Automotive Engineers (SAE): SAE J 448A Surface Texture, 2011.08.01edition.
c) National Conference of Standards Labs: NCSL Z540-3 Calibration Laboratories and Measuring Equipment, dated 2006.08.03.
d) USCG-SFLC-SP-PP&M-001 Rev. D dtd 10/00, Change 1 05/10, Standard Preservation, Packaging & Marking Specification for USCG ELC.
e) Coast Guard ELC Bar Coding Specification: D-000-0100 Rev. G dated 02/06.

2.1 Coast Guard Drawing: FL-588-3 Rev -, Talon Grid, Supporting Skirt and Cover Fabrication and Inst.

2.2 Precedence: In the event of a conflict between this specification and its referenced documents this specification shall take precedence.

3. Requirements: Contractor shall provide all labor and materials to manufacture Bolt.

a) Bolt shall be manufactured of Type 316 Stainless Steel bar, in accordance with ASTM A276/A276M. Fabricate from 7/8" round bar in accordance with Drawing Number: FL-588-3 Rev -. Material certification shall be required.
b) A grade 316 stainless steel nylon insert locknut, Piece 20 shall be provided with each bolt, in accordance with the drawing.
c) Dimensional Tolerances shall be in accordance with the drawing.
d) Surface Texture shall be 125 RMS or smoother in accordance with SAE J-448A.

3.1 Workmanship: In addition to being manufactured to the stated requirements, all pieces shall be free of sharp edges, burrs or any non-conformity to the drawing or this specification.

4. Quality Assurance:

4.1 General: The Contractor is responsible for the conformance and overall quality of each item offered to the Coast Guard for acceptance or approval.

4.2 Notifications & Inspections: The contractor shall be responsible for notifying the Contracting Officer no less then seven (7) calendar days prior to the contractor being ready for any Quality Assurance (QA) inspections or testing required herein.

4.3 Responsibility for Inspection: The Contractor shall be responsible for the performance of all inspection requirements specified herein. The Contractor shall provide space, personnel and test equipment for the conduct of all inspection requirements. All inspection and testing shall be performed at the Contractors facility prior to the Coast Guards acceptance of the contracted items. The Coast Guard reserves the right to verify or have performed any of the inspections set forth herein where such inspections are deemed necessary to assure that supplies and services conform to prescribed requirements.

4.4 Inspections & Tests: The inspections & tests required herein are the minimum necessary and are not intended to replace any controls, examinations, or tests normally employed by the contractor to assure the quality of the product. The following are required:

a) Material Certification.

b) Conformance to dimensional tolerances and surface texture.

c) Inspection of packaging and marking as described in part 5.

4.5 Other Test & Inspection Reports: A copy of any standard contractor test or inspection report not covered by this requirement shall be turned over to the Coast Guard Q.A. Representative upon his arrival at the contractor's plant.

4.6 Calibration System: The Contractor shall be required to maintain a test equipment calibration program in compliance with NCSL Z540-3. The program shall be documented and traceable to the National Institute of Standards and Technology (NIST). The calibration system records shall be maintained for inspection for the duration of any contract referencing this specification

5. Preservation, Packaging & Marking (PP&M): In Accordance with USCG-SFLC SP-PP&M-001 DTD 10/00, Change 1 05/10. Each bolt shall be further protected, primarily from damage to the threads, by wrapping the entire bolt with corrugated paperboard and secured with monofilament plastic packaging tape. Each Bolt shall be packaged individually in a round corrugated paperboard box in a way to protect bolt from damage during multiple shipments.

5.1 Marking: An adhesive backed label shall be affixed to each box containing the information applicable to the packed item (see section 1.1 herein). Information contained on the label shall be laid out as follows:

National Stock Number (NSN): 5340 01-481-3786
Name: BOLT, TALON HELO LAN
Drawing and Detail Number: FL-588- 3, DETAIL 42-D
Government Contract Number: (fill in)
COAST GUARD SFLC MATERIAL CONDITION "A", 1 EA

5.2 Bar Coding: The National Stock Number (NSN) shall also be bar coded in addition to the markings required above. Bar coded labels shall be in accordance with ELC specification D-000-0100. The Bar Code Label can be applied separately or as part of the marking required in 5.2 of this specification. The actual labels shall be Type "V", Grade "C" Style "2", Composition "a" with or without plastic laminate.

6. Document Source:

Society of Automotive Engineers Inc. (SAE)
400 Commonwealth Drive
Warrendale, PA 15096
412-776-4841

American Society for Testing & Materials (ASTM)
1916 Race Street
Philadelphia, PA 19103-1187
215-299-5585
FAX 215-977-9679

National Conference of Standards Labs (ANSI/NCSL)
1800 30th St., Suite 305B
Boulder, CO 80301
303-440-3339