

WHENEVER MIL-H-24135 IS SPECIFIED, IT SHALL BE IN ACCORDANCE WITH REVISION B, DATED SEPTEMBER 3, 1993 AS MODIFIED BELOW.

DELETE TABLE IV AND REPLACE WITH:

TABLE IV. SAMPLING FOR QUALITY CONFORMANCE TESTS.

| | |
|------------------------|--------------------|
| NO. OF 18 INCH SAMPLES | LINEAR FEET IN LOT |
| UP TO 50 | 1 |
| 51 TO 100 | 2 |
| 101 TO 500 | 3 |
| 1000 | 5 |

WHENEVER MIL-H-24136 IS SPECIFIED, IT SHALL BE IN ACCORDANCE WITH REVISION B, DATED SEPTEMBER 3, 1993 AS MODIFIED BELOW.

DELETE TABLE IV AND REPLACE WITH:

TABLE IV. SAMPLING FOR QUALITY CONFORMANCE TESTS.

| | | |
|-----------|-------------------------|----------------|
| LENGTHS | LINEAR FEET IN LOT | NO. OF 18 INCH |
| UP TO 50 | 1 | 51 TO 100 |
| 100 | 2 | 101 TO 500 |
| | 501 TO 1000 | 3 |
| OVER 1000 | 4 + 1 FOR EACH 500 FEET | 4 |

WHENEVER EB-3461 IS SPECIFIED, IT SHALL BE IN ACCORDANCE WITH REVISION B, DATED JUNE 6, 1994, AS MODIFIED BELOW
DELETE PARA

4.4.3.1 AND REPLACE WITH:

4.4.3.1 HOSE. AS A MINIMUM, THE CONTRACTOR SHALL RANDOMLY SELECT A SAMPLE QUANTITY, IN 18 INCH LENGTHS, FROM EACH LOT OF COMPLETED HOSE IN ACCORDANCE WITH TABLE IA AND TEST THEM IN ACCORDANCE WITH 4.6.2 AND 4.6.6.
DELETE TABLE IA AND REPLACE WITH:

TABLE IA. SAMPLING FOR QUALITY CONFORMANCE TESTS.

| | |
|--------------------|-------------------------|
| LINEAR FEET IN LOT | NO. OF 18 INCH SAMPLES |
| UP TO 50 | 1 |
| 51 TO 100 | 2 |
| 101 TO 500 | 3 |
| 501 TO 1000 | 4 |
| OVER 1000 | 4 + 1 FOR EACH 500 FEET |

DELETE PARA 4.4.3.2.

THE FOLLOWING APPLIES TO EB-3461, MIL-H-24135, MIL-H-24136, MIL-F-24787, AND ALL SLASH SHEETS:

1) HOSE FITTINGS ARE TO BE DIMENSIONAL INSPECTED BY UTILIZING A DIMENSIONAL CHECK AGAINST THE MANUFACTURES DRAWINGS.

2) WHENEVER MATERIAL TO QQ-C-390, ALLOY C90300 IS SPECIFIED, ALTERNATE MATERIAL PER ALLOY C95400 OR C95800 IAW ASTM-B148, ASTM-B271 OR ASTM-B505 IS ACCEPTABLE PROVIDED THAT WELD REPAIR IS IAWMIL-B-24480. MECHANICAL TEST IS REQUIRED.

3) WHENEVER MATERIAL TO MIL-B-24480 IS SPECIFIED, ALTERNATE MATERIALPER ALLOY C95800 IAW ASTM-B148, ASTM-B271, ASTM-B505, OR ASTM-B763 ISACCEPTABLE PROVIDED THAT WELD REPAIR IS IAW MIL-B-24480.

MECHANICAL TEST IS REQUIRED.

4) CAST HOSE FITTINGS:

A) EACH NON-IMPREGNATED CAST FITTING IS TO BE HYDROSTATIC PROOF TESTED (SEE PARA D) PER MIL-STD-276 PARA 4.10. AEROSTATIC LEAK TEST (SEE PARA E) MAY BE SUBSTITUTED IF IT IS SPECIFIED ON THE VENDOR DRAWING. CASTINGS MAY BE IMPREGNATED PER PARA B PRIOR TO PRESSURE TESTING. FITTINGS THAT EXHIBIT NO EVIDENCE OF LEAKAGE ARE ACCEPTABLE.

B) IMPREGNATION TO SEAL

MICROPOROSITY OF THE HOSE FITTING (IN LIEU OF WELD REPAIR) IS TO BE IAW MIL-STD-276 AND THE FITTING SHALL BE MARKED "IMP". RADIOGRAPHY OF THE CAST FITTING PER MIL-STD-278 (TO DETERMINE THE STRUCTURAL SOUNDNESS) IS NOT REQUIRED DUE TO THE ROBUST DESIGN OF THE FITTING.

C) EACH IMPREGNATED CAST FITTING SHALL BE HYDROSTATICALLY PROOF TESTED (SEE PARA D) PER MIL-STD-276 PARA 4.10. AEROSTATIC LEAK TEST (SEE PARA E) MAY BE SUBSTITUTED IF IT IS SPECIFIED ON THE APPLICABLE VENDOR DRAWING. AN IMPREGNATED FITTING THAT EXHIBITS LEAKAGE IS TO BE REIMPREGNATED PER MIL-STD-276 PARA 4.11 AND RETESTED (HYDROSTATICALLY OR AEROSTATICALLY). FITTINGS THAT LEAK AFTER ONE REIMPREGNATION SHALL BE REJECTED.

D) HYDROSTATIC PRESSURE IS TWICE (SEE MIL-STD-276 PARA 4.10) THE MAXIMUM PRESSURE OF THE HOSE IN WHICH THE CAST FITTING MAY BE USED WITH. IF STRONGBACKS ARE NOT USED ON FLANGED FITTINGS, THE FITTING SHALL BE TESTED TO TWICE THE WORKING PRESSURE OF THE FLANGE RATING.

E) AEROSTATIC PRESSURE SHOULD BE SPECIFIED ON THE APPLICABLE VENDOR DRAWING. IF THE AEROSTATIC TEST PRESSURE IS NOT SPECIFIED, THEN IT IS TWICE (SEE MIL-STD-276 PARA 4.10) THE MAXIMUM PRESSURE OF THE HOSE IN WHICH THE CAST FITTING MAY BE USED WITH. IF STRONGBACKS ARE NOT USED ON FLANGED FITTINGS, THE FITTING SHALL BE TESTED TO TWICE THE WORKING PRESSURE OF THE FLANGE RATING.

F) WHERE REFERENCED ABOVE, MIL-STD-276 IS REVISION A DATED DECEMBER 03, 1992.

5)

THE WELD JOINT OF HOSE FITTINGS SHALL BE HYDROSTATICALLY TESTED TO TWICE THE MAXIMUM PRESSURE OF THE HOSE IN WHICH IT MAY BE USED WITH.

6) NOTES PER THE

CORRESPONDING FIGURES OF MIL-F-24787 PER SUPERSESSON TABLE IV ARE ACCEPTABLE FOR THE NOTE OF MIL-H-24135, MIL-H-24136 AND/OR EB-3461 EXCEPT:

A) MIL-F-24787/4 FIG.2 TABLE X & TABLE XI SHALL BE IAW MIL-B-24480 (QQ-C-390 IS UNACCEPTABLE).

B) MIL-F-24787/5 NOTE 5 OF TABLE VII SHALL STATE "ALTERNATE MATERIAL FOR THE FITTING ASSEMBLY SOCKET SHALL BE STEEL CONFORMING TO AISI 4140 (SEGMENT) OR AISI-SAE PER AMS 6381 (RING AND BAND)."

7) VENDORS ON

THE QUALIFIED PRODUCTS LIST (QPL) FOR MIL-F-24787 CAN SUPPLY MATERIAL IAW MIL-H-24135, MIL-H-24136 OR EB-3461 AS MODIFIED BY THIS STANDARD CLAUSE AS THEY MEET THE REQUIREMENTS OF PORTSMOUTH TEST AGENDA T-743.

8) MARKING IS TO BE IAW MIL-H-24135, MIL-H-24136, MIL-F-24787, OR EB-3461 AS APPLICABLE. pen\xmlns2{\factoidname State}}IA.{*\xmlclose}{*\xmlclose} SAMPLING FOR QUALITY CONFORMANCE TESTS.

\par

\par LINEAR FEET IN LOT NO. OF 18 INCH SAMPLES

\par UP TO 50 1

| | | |
|------|-------------|-------------------------|
| \par | 51 TO 100 | 2 |
| \par | 101 TO 500 | 3 |
| \par | 501 TO 1000 | 4 |
| \par | OVER 1000 | 4 + 1 FOR EACH 500 FEET |
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\par \tab DELETE {*\xmloopen\xmlns2{\factoidname place}}PARA{*\xmlclose}
4.4.3.2.

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\par THE FOLLOWING APPLIES TO EB-3461, MIL-H-24135, MIL-H-24136, MIL-F-24787, AND ALL SLASH SHEETS:

\par

\par 1) HOSE FITTINGS ARE TO BE DIMENSIONAL INSPECTED BY UTILIZING A DIMENSIONAL CHECK AGAINST THE MANUFACTURES DRAWINGS.

\par

\par 2) WHENEVER MATERIAL TO QQ-C-390, ALLOY C90300 IS SPECIFIED, ALTERNATE MATERIAL PER ALLOY C95400 OR C95800 IAW ASTM-B148, ASTM-B271 OR ASTM-B505 IS ACCEPTABLE PROVIDED THAT WELD REPAIR IS IAW MIL-B-24480. MECHANICAL TEST IS REQUIRED.

\par

\par 3) WHENEVER MATERIAL TO MIL-B-24480 IS SPECIFIED, ALTERNATE MATERIAL PER ALLOY C95800 IAW ASTM-B148, ASTM-B271, ASTM-B505, OR ASTM-B763 IS ACCEPTABLE PROVIDED THAT WELD REPAIR IS IAW MIL-B-24480. MECHANICAL TEST IS REQUIRED.

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\par 4) CAST HOSE FITTINGS:

\par \tab A) EACH NON-IMPREGNATED CAST FITTING IS TO BE \tab HYDROSTATIC PROOF TESTED SEE PARA D) PER MIL-STD-276 {*\xmloopen\xmlns2{\factoidname place}}PARA{*\xmlclose} \tab 4.10. AEROSTATIC LEAK TEST (SEE {*\xmloopen\xmlns2{\factoidname place}}PARA{*\xmlclose} E) MAY BE SUBSTITUTED \tab IF IT IS SPECIFIED ON THE VENDOR DRAWING. CASTINGS MAY BE \tab IMPREGNATED PER {*\xmloopen\xmlns2{\factoidname place}}PARA{*\xmlclose} B PRIOR TO PRESSURE TESTING. \tab FITTINGS THAT EXHIBIT NO EVIDENCE OF LEAKAGE ARE \tab ACCEPTABLE.

\par

\par B) IMPREGNATION TO SEAL MICROPOROSITY OF THE HOSE FITTING \tab (IN LIEU OF WELD REPAIR) IS TO BE IAW MIL-STD-276 AND THE \tab FITTING SHALL BE MARKED "IMP". RADIOGRAPHY OF THE CAST \tab FITTING PER MIL-STD-278 (TO DETERMINE THE STRUCTURAL \tab SOUNDNESS) IS NOT REQUIRED DUE TO THE ROBUST DESIGN OF

\par THE FITTING.

\par C) EACH IMPREGNATED CAST FITTING SHALL BE \tab HYDROSTATICALLY PROOF TESTED(SEE PARA D) PER MIL-STD-276 \tab PARA 4.10. AEROSTATIC LEAK TEST (SEE {*\xmloopen\xmlns2{\factoidname place}}PARA{*\xmlclose} E) MAY BE \tab SUBSTITUTED IF IT IS SPECIFIED ON THE APPLICABLE VENDOR

\par DRAWING. AN IMPREGNATED FITTING THAT EXHIBITS LEAKAGE IS \tab TO BE REIMPREGNATED PER MIL-STD-276 {*\xmloopen\xmlns2{\factoidname place}}PARA{*\xmlclose} 4.11 AND RETESTED \tab (HYDROSTATICALLY OR AEROSTATICALLY). FITTINGS THAT LEAK \tab AFTER ONE REIMPREGNATION SHALL BE REJECTED.

\par

\par D) HYDROSTATIC PRESSURE IS TWICE (SEE MIL-STD-276 {*\xmloopen\xmlns2{\factoidname place}}PARA{*\xmlclose} \tab 4.10) THE MAXIMUM PRESSURE OF THE HOSE IN WHICH THE CAST \tab FITTING MAY BE USED WITH.

IF STRONGBACKS ARE NOT USED ON \tab
FLANGED FITTINGS, THE FITTING SHALL BE TESTED TO TWICE THE \tab WORKING
PRESSURE OF THE FLANGE RATING.

\par

\par E) AEROSTATIC PRESSURE SHOULD BE SPECIFIED ON THE \tab APPLICABLE
VENDOR DRAWING. IF THE AEROSTATIC TEST PRESSURE \tab IS NOT SPECIFIED, THEN
IT IS TWICE (SEE MIL-STD-276 {*\xmlopen\xmlns2{\factoidname
place}}PARA{*\xmllclose} \tab

4.10) THE MAXIMUM PRESSURE OF THE HOSE IN WHICH THE CAST \tab FITTING MAY BE
USED WITH. IF STRONGBACKS ARE NOT USED

\par ON FLANGED FITTINGS, THE FITTING SHALL BE TESTED TO TWICE \tab THE
WORKING PRESSURE OF THE FLANGE RATING.

\par

\par F) WHERE REFERENCED ABOVE, MIL-STD-276 IS REVISION A DATED \tab
DECEMBER 03, 1992.

\par

\par 5) THE WELD JOINT OF HOSE FITTINGS SHALL BE HYDROSTATICALLY TESTED TO
TWICE THE MAXIMUM PRESSURE OF THE HOSE IN WHICH IT MAY BE USED WITH.

\par

\par 6) NOTES PER THE CORRESPONDING FIGURES OF MIL-F-24787 PER SUPERSESSON
TABLE IV ARE ACCEPTABLE FOR THE NOTE OF MIL-H-24135, MIL-H-24136 AND/OR
EB-3461 EXCEPT:

\par

\par A) MIL-F-24787/4 FIG.2 TABLE X & TABLE XI SHALL BE IAW \tab
MIL-B-24480 QQ-C-390 IS UNACCEPTABLE).

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\par \tab B) MIL-F-24787/5 NOTE 5 OF TABLE VII SHALL STATE \tab "ALTERNATE
MATERIAL FOR THE FITTING ASSEMBLY SOCKET SHALL \tab BE STEEL CONFORMING TO
AISI 4140 (SEGMENT) OR AISI-SAE PER \tab AMS 6381 (RING AND BAND)."

\par

\par 7) VENDORS ON THE QUALIFIED PRODUCTS LIST (QPL) FOR MIL-F-24787 CAN
SUPPLY MATERIAL IAW MIL-H-24135, MIL-H-24136 OR EB-3461 AS MODIFIED BY THIS
STANDARD CLAUSE AS THEY MEET THE REQUIREMENTS OF

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{*\xmlopen\xmlns2{\factoidname place}}PORTSMOUTH{*\xmllclose}{*\xmllclose}
TEST AGENDA T-743.

\par

\par 8) MARKING IS TO BE IAW MIL-H-24135, MIL-H-24136, MIL-F-24787, OR
EB-3461 AS APPLICABLE.

\par }}TINGS SHALL BE HYDROSTATICALLY TESTED TO TWICE THE MAXIMUM PRESSURE OF
THE HOSE IN WHICH IT MAY BE USED WITH.

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NOTES PER THE CORRESPONDING FIGURES OF MIL-F-24787 PER SUPERSESSON TABLE IV
ARE ACCEPTABLE FOR THE NOTE OF MIL-H-24135, MIL-H-24136 AND/OR EB-3461 EXCEPT:

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\f2\fs24\cgrid0 MIL-F-24787/4 FIG. 2 TABLE X & TABLE XI SHALL BE IAW MIL-B-24480. (QQ-C-390 IS UNACCEPTABLE)

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