

Title: **MIL-T-16420 Conformance Requirements and Testing**

This summarizes the minimum quality conformance testing required to be submitted as Objective Quality Evidence based on all amendments to MIL-T-16420 as of 23 May 2017.

Lot Definition

Section 4.2.1.2 (Grade 2) of MIL-T-16420 provides the definition of a lot for chemical analysis and mechanical properties

Sampling per Section 4.2.2 for quality conformance inspection

Visual and Dimensional Examination:

Results conforming to 4.3 and 3.8.2 of MIL-T-16420

For Visual, Number of Samples per 4.2.2.2 of MIL-T-16420

For Dimensional, Number of Samples per 4.2.2.3 of MIL-T-16420

- *Note: 1. A statement within the Certificate of Conformance recording full compliance with specification requirements or Test Report as invoked.
- 2. Wall thickness at any point less than minimum is not permitted. UT wall gauging is required to verify that wall thickness meets the minimum requirement for sampling as in 4.2.3.

Hydrostatic Test

Class 50 and 200 tube requires Hydrostatic testing in accordance with Section 3.4.1 and 4.4.3, or when specified per contract requirements

*Note: If Ultrasonic Testing is performed, Hydrostatic Testing is not required

Hydrostatic Test Pressure Range is required to be recorded

Ultrasonic Test Inspection

Alloy 715 tube is required to be Ultrasonically tested

(When specified per contract requirements)
Test Specification: MIL-T-16420 Section 3.4.3

Chemical Analysis

Results conforming to section 3.2

Number of samples per 4.2.2.4 and 4.4.1 of MIL-T-16420

Mechanical Properties Test

Results conforming to section 3.3

Number of Samples per 4.2.2.1 of MIL-T-16420

Expansion/Flattening Test

Results conforming to section 3.3.2

Number of Samples per 4.2.2.2 of MIL-T-16420

Radiographic Inspection

IAW Section 3.4.2 Type II tube shall be radiographed as specified in Section 4.4.8

Extent of Radiographic Inspection per 4.2.2.5

Etch Test

IAW Section 3.5, if the mill produces both seamless and welded tube and does not mark the tube IAW section 3.10 at the fabrication site, seamless tube shall be weld free when etch tested as specified in 4.4.4

Number of Samples and Sampling per 4.2.2.1

***Note: 1. This Document supports Type II tubing that is class 200 or less.**

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Date: **January 23, 2018**

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