

Coded Note Number: **LI027**

Revision: **C004**

Date: **June 27, 2012**

Title: **HEAT TREATMENT PROCEDURE FOR APPROVAL**

PROCEDURE SUBMITTAL:

Heat treatment procedure shall be submitted in accordance with MIL-STD-1684 for approval within 30 days after receipt of this purchase order. If the procurement specification allows the option of an alternate to MIL-STD-1684 and the alternate spec is used, notification that the alternate specification will be used is required.

The request for approval shall include:

Current purchase order/item number(s),

NN Material Number(s),

This coded note number,

The procedure number/revision,

The specific application for which inspection is required (i.e. welds, castings, casting repairs, forgings, wrought material or fasteners),

The fabrication document or material specification invoked by the drawing for technique requirements and acceptance criteria to accomplish the inspection.

In the event the scheduled date for submittal cannot be met, the supplier shall provide a complete list of all documents and revisions to be used in advance of submittal.

Full compliance to this submittal requirement is expected.

PRIOR APPROVED PROCEDURE(S):

If prior approval has been obtained from NNS but the procedure number and revision **is not listed** on this purchase order, re-submittal of the procedure is not required. A request for extension of the previous approval shall be submitted and shall include the information detailed above.

NO SUBMITTAL REQUIRED:

If prior approval has been obtained from NNS and the procedure and revision **is listed** on this purchase order, no additional submittal is required to satisfy this requirement. In this instance the supplier is authorized to perform HT.

The above requirements do not relieve the seller of his responsibility to comply with the specification requirements of the purchase order.

Documents/extensions shall be submitted as follows:

SPARS (Shipbuilding Partners and Suppliers) enabled suppliers are required to submit through <https://spars.huntingtoningalls.com/ngcspars/Auth>

All other suppliers shall submit via:

e-mail to pmo@hii-nns.com

or

Newport News Shipbuilding

4101 Washington Ave.

Newport News, VA 23607

Attn: E45 Software Coordinator

Bldg. 600-1