

Coded Note Number: **LI120**

Coded Note Revision: **C001**

Date: **July 19, 2023**

Title: **CHEMICAL TEST REPORT FOR PIPE BENDING LUBRICANT**

1. PURPOSE:

To specify Newport News Shipbuilding's (NNS) testing requirements for the procurement of bending lubricant. NNS has issued this Coded Note in order to assure compliance with applicable portions of MIL-STD-1627C (SH).

2. DEFINITIONS:

A. Halides- chlorides, fluorides, and bromides.

3. GENERAL INFORMATION

A. Lubricants may be used in bending operations to prevent wear of pipe material and of the die. An effective lubricant shall be easy to remove after bending, not stain the pipe, and have good surface adhesion and film strength at bending temperatures. The effectiveness a specific lubricant can vary from one pipe to another.

B. The following Test Report must be:

- Readily identifiable to the NNS PO and Item Number
- In the form of reports issued by the organization performing the analysis or exact copies thereof. Data transcribed to another organization's forms are not acceptable.
- Certified correct with a signature and date by the seller's authorized representative.

C. The Test Report shall be submitted to APL_QPL@hii-nns.com and approved prior to shipment of material. If the seller is unable to provide the required Test Report, the seller shall submit the following information to the email above and await further instructions from NNS: Manufacturer's Name, Product Name and Description, and Lot Number(s).

D. The seller shall accomplish the following analysis for each manufacturer and each lot of the bending lubricant procured. Products must be re-verified to meet the detrimental limits if the manufacturer identifies that a change in the formulation has been made. If no manufacturer lot identification is

present, all items (products) of one type received from the same manufacturer in the same shipment may be considered a single lot.

4. REQUIREMENTS

- A. A copy of the Certified Test Report showing the results of the chemical analysis, verifying:
 - 1) Contains no more than 250 ppm each of total halides
 - 2) Contains no more than 250 ppm of total sulfur.
 - 3) Contains no more than 250 ppm of total phosphorus.
 - 4) Contains no more than 250 ppm each of total antimony, copper, arsenic, bismuth, cadmium, lead, tin, and zinc.
- B. Ozone depleting lubricants not meeting local volatile compound (VOC) requirements shall not be used

Revision History Table		
Rev	Description	Revision Date
C001	1. Original Issue	07/19/2023