

Y2230-20000511

## COMPONENT OVERHAUL TECHNICAL REQUIREMENTS AND INSTRUCTIONS.

1. GENERAL REQUIREMENTS - THIS PART NUMBER IS FOR AN OVERHAUL (AS DEFINED IN APPENDIX B) OF THE ITEM(S) DESCRIBED HEREIN AND INITIALLY INCLUDES PRICING FOR:

- RECEIVE, INVENTORY, AND STORE NNS SUPPLIED COMPONENT.
- OPEN, CLEAN, AND INSPECT COMPONENTS.
- ISSUE COMPONENT CONDITION REPORT TO NNS.
- INSTALLATION OF MANDATORY REPLACEMENT MATERIAL.
- REASSEMBLY.
- PERFORMANCE TEST.
- SHIPMENT OF COMPONENT BACK TO NNS.
- SHIPMENT OF REPLACED PARTS AND EXCESS REPAIR MATERIAL BACK TO NNS.

ANY ADDITIONAL WORK, BASED ON NNS REVIEW OF THE COMPONENT CONDITION REPORT, WILL BE CONTRACTED BY NNS VIA MODIFICATION TO THIS REQUIREMENT.

THE ITEM SPECIFIED MUST BE RESTORED TO MEET THE ORIGINAL OPERATING AND PERFORMANCE CHARACTERISTICS.

THE IDENTITY OF EACH COMPONENT SHALL BE MAINTAINED DURING THE PERFORMANCE OF THE WORK REQUIRED HEREIN. EXISTING PARTS FROM DIFFERENT COMPONENTS SHALL NOT BE INTERCHANGED WITHOUT PRIOR APPROVAL BY NNS.

THE COMPONENTS SHIPPED TO THE VENDOR AND ANY MATERIAL ORDERED OR SUPPLIED BY NNS ARE GOVERNMENT-OWNED PROPERTY AND ARE SUBJECT TO APPENDIX A-GP.

2. DETAIL REQUIREMENTS - IF UPON INSPECTION, THE COMPONENT DOES NOT CONFORM TO ITS ORIGINAL DESIGN SPECIFICATIONS, NNS SHALL BE NOTIFIED SO THAT FURTHER INSTRUCTIONS CONCERNING THESE COMPONENT CHANGES CAN BE PROVIDED. THE VENDOR SHALL SUPPLY RECOMMENDATIONS TO RETURN THE COMPONENT TO ITS DESIGN SPECIFICATIONS.

THE VENDOR SHALL, AS APPLICABLE, PERFORM A HYDROSTATIC TEST TO THE PRESSURE BOUNDARY SPECIFIED ON EACH UNIT PRIOR TO DISASSEMBLY TO VERIFY INTEGRITY OF THE PRESSURE CONTAINING PARTS. THE RESULTS OF THE HYDROSTATIC TEST SHALL BE ANNOTATED ON THE ASSOCIATED COMPONENT CONDITION REPORT.

THE USE OF TEMPORARY DRIVERS OR OTHER SUB-COMPONENTS TO CONDUCT THE

PERFORMANCE TEST IS NOT PERMITTED EXCEPT AS AUTHORIZED BY NNS.

DURING THE PERFORMANCE TEST WHILE THE COMPONENT IS AT NORMAL OPERATING PRESSURE, THE COMPONENT SHALL BE VISUALLY INSPECTED FOR LEAKAGE (BOTH THROUGH-WALL AND AT MECHANICAL JOINTS). NO LEAKAGE IS ALLOWED, EXCEPT AS MODIFIED BY ADDITIONAL CODED NOTES. LEAKAGE IS DEFINED AS THE ACCUMULATION OF FLUID, OVER A THREE-MINUTE PERIOD, LARGE ENOUGH TO FORM A DROP OR FLOW AWAY FROM THE POINT OF FORMATION.

3. VENDOR SUPPLIED MATERIAL - THE VENDOR IS RESPONSIBLE FOR ALL MATERIAL, EQUIPMENT, ETC. REQUIRED TO CONDUCT THE PERFORMANCE TEST.

4. VENDOR RESPONSIBILITY - THE VENDOR IS RESPONSIBLE FOR THE REPAIR/REPLACEMENT OF PARTS DAMAGED BY HIS ACTIONS. REPAIR PROCEDURES/METHODS SHALL BE IN ACCORDANCE WITH THE REQUIREMENTS CONTAINED HEREIN AND SHALL BE APPROVED BY NNS PRIOR TO THE REPAIR ACTION.

5. REPAIR PROCEDURES/METHODS - THE USE OF NON-STANDARD PARTS, EITHER BY MODIFICATION OF AN EXISTING PART OR BY MANUFACTURE OF A NEW PART, IN THE OVERHAUL OF A COMPONENT IS PROHIBITED WITHOUT PRIOR NNS APPROVAL. THE VENDOR IS REQUIRED TO SUBMIT ALL NON-STANDARD REPAIR PROCEDURES/METHODS TO NNS FOR APPROVAL PRIOR TO PERFORMING THE ACTUAL REPAIR.

6. PRESERVATION - AFTER SUCCESSFUL COMPLETION OF THE PERFORMANCE TEST AND PRIOR TO DELIVERY, ALL COMPONENTS SHALL BE DRAINED OF SYSTEM FLUID AND LUBRICATING OIL. ALL STEM AND SHAFT FLEXIBLE PACKING SHALL BE REMOVED AND DISCARDED, IF APPLICABLE.

OVERHAULED COMPONENTS SHALL NOT RECEIVE A PRESERVATION TREATMENT UNLESS SPECIFICALLY DIRECTED. THE VENDOR SHALL INFORM NNS WHEN THE COMPONENT IS READY FOR DELIVERY. IF A PRESERVATIVE TREATMENT IS SPECIFIED BY NNS, NNS WILL INFORM THE VENDOR AS TO PRESERVATION. A TAG SHALL BE ATTACHED TO EACH COMPONENT STATING WHAT PRESERVATIVE MATERIAL WAS UTILIZED AND ITS SPECIFICATION OR IF NO PRESERVATIVE WAS USED. THIS PARAGRAPH TAKES PRECEDENCE OVER THE REQUIREMENTS SPECIFIED IN APPENDIX B TO THIS PURCHASE ORDER.

7. PAINTING - PAINTING OF EXTERNAL, FERROUS, NON-MACHINED SURFACES OF THE COMPONENTS COVERED BY THIS PURCHASE ORDER MAY BE ACCOMPLISHED IN

ORDER TO RESTORE EQUIPMENT TO ITS ORIGINAL PAINTED CONDITION.

8. LUBRICANTS AND HYDRAULIC FLUIDS - ALL COMPONENT LUBRICANTS, INCLUDING OIL, GREASES, AND HYDRAULIC FLUIDS SHALL BE REPLACED AS PART OF THE OVERHAUL IN ORDER TO PERMIT OPERATION DURING THE PERFORMANCE TEST.

9. INSTRUMENTATION - ALL INSTRUMENTATION (THERMOMETERS, PRESSURE GAGES, TEMPERATURE/PRESSURE SWITCHES, ALARMS, AMMETERS, VOLTMETERS, PUSHBUTTONS, INDICATOR LIGHTS, ETC.) SHALL BE REPAIRED/REPLACED AND CALIBRATED.

10. HYDROSTATIC TESTING - NEW OR WELD/BRAZE REPAIRED PRESSURE BOUNDARY PARTS SHALL BE HYDROSTATICALLY TESTED. THE RESULTS OF THIS HYDROSTATIC TEST, ALONG WITH THE TEST PRESSURE AND FLUID, SHALL BE ANNOTATED ON THE ASSOCIATED COMPONENT REPAIR REPORT.