

SPECIFICATION FOR TEST WEIGHT FABRICATION

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PREPARED BY

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SPECIFICATION FOR TEST WEIGHT FABRICATION

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PART 1 GENERAL REQUIREMENTS

1.1 REFERENCES

The following documents, of the issue in effect on date of procurement, form a part of this specification to the extent specified herein. In case of difference between the following documents and this specification, this specification shall govern to the extent of such difference. If standards other than those listed below are used, proof of equivalence shall be provided.

JAPANESE INDUSTRIAL STANDARD (JIS)

JIS B 0405	General Tolerances Part 1: Tolerance for linear and angular dimensions without individual tolerance indications
JIS G 3101	Rolled Steels for General Structure
JIS Z 2343	Nondestructive testing Penetrant testing Part 1: General Principles Method for liquid penetrant testing and classification of the penetrant indication
JIS Z 3211	Covered electrodes for mild steel, high tensile strength steel and low temperature service steel
JIS Z 3313	Flux cored wires for gas shielded and self-shielded metal arc welding of mild steel, high strength steel and low temperature service steel

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1.2 SYSTEM DESCRIPTION

The intent of this specification is to purchase test weights for use of rigging gear and ship's equipment load tests at U.S. Fleet Activities, Sasebo. The fabrication of the test weights shall be performed in accordance with provide concept design drawing as shown in enclosure 1. The general information of the test weights are listed below.

Table1. Weight lists

NO.	Qty.	Weight		ID Number
		Nominal (lbs.)	Tolerance (%)	
1	2	4,000	+0.0 ~ -1.0	SRF-4000LBS No.1~No.4
2	2	5,000	+0.0 ~ -1.0	SRF-5000LBS No.1~No.4

1.3 MODIFICATIONS

If the contractor would like to change the shape of test weights, the changes should be made in writing and approved by government.

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PARTS 2 PRODUCTS

2.1 MATERIALS

Materials shall be free from defects and imperfections that might affect the serviceability and appearance of the finished product. The contractor shall certify that the test weight specified by this contract does not contain asbestos, Polychlorinated Biphenyl's (PCB's), or elemental mercury, and that Chromates have been avoided where feasible. All materials shall be new and unused.

2.1.1 Steel Materials

Steel plates used in this work conform to following standard.

Table 3. Steel Material

Material	Standard	Symbol	Remarks
Steel Plate	JIS G 3101: Rolled Steel for general Structure	SS400	

2.1.2 Welding Materials

Welding materials for the test weight shall conform to following standard or equivalent product with different manufacture.

Table 4. Welding Materials

Standard	Example: Product name	Example: Manufacture	Base Metal
JIS Z 3211: Covered electrodes for mild steel, high tensile strength and low temperature service steel	LB-52	KOBE STEEL, CO	JIS G 3101 SS400
JIS Z 3313: Flux cored wires for gas shielded and self-shielded metal welding of mild steel, high strength steel and low temperature service steel	DW-10	KOBE STEEL, CO	JIS G 3101 SS400

2.2 FABRICATIONS

Fabrication shall be performed in accordance with the drawing as shown in enclosure 1.

2.2.1 Welding

Welding processes and groves are left up by fabricator in accordance with appropriate JIS standard per 1.1. All preheating was performed based on the process and applied material thickness in accordance with appropriate JIS standards per 1.1.

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2.2.2 Weight Adjustments

The allowance of the weight is per table 1. Weight shall be adjusted as shown in enclosure 1.

2.2.3 Burrs and sharp edges

All burrs and sharp edges shall be removed.

2.3 Painting system (Priming and finish painting)

The primer coat and the finish coat of paint shall be smooth, even and free of sags, orange peel, or other defects. Care shall be taken to preclude painting over non-painted surface. The painting system shall consist of anti-corrosive primers and 2-coats of acrylic epoxy gloss (cosmetic) topcoat as minimum, primers and topcoat shall be the products as shown below or equivalent product with different manufacture. The primer and finish coats shall be identified in the technical manual or drawings. Painting shall be applied several times. The contractor shall certify that the test weight specified by this contract does not contain lead paint.

Table 5. Painting system

Type of Paint	Example: Product name	Example: Manufacture
Epoxy Zinc Paint, High Build	EPICON ZINC HB-2	CHUGOKU MARINE PAINT., LTD
Epoxy Paint, High Build	HEMPADUR 45141-50630 with hardener	HEMPEL PAINT., LTD
Epoxy Paint, High Build	HEMPADUR 45141-12170 with hardener	HEMPEL PAINT., LTD
Top Coat	UNY MARINE No.300	CHUGOKU MARINE PAINT., LTD

2.5 Label Plates

Label plates for test weights are as shown in enclosure 2.

Table 6. PRODUCTS

NO.	Steel Materials	Painting system	Label Plates
		Top coat color (Munsell)	
1	SS400	2.5Y 8/12 (Yellow)	Need
2	SS400	2.5Y 8/12 (Yellow)	Need

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PART 3 SUBMITTAL

The contractor shall submit to the contracting officer all items of technical documentation listed hereinafter. The contractor shall ensure that all submittals are entirely legible and suitable for reproduction. All submittals shall be in a package and submitted at the same time as parts delivery. The package shall be two hard copies and one electrical copy. Compliance and fabrication requirements of this specification will be determined by a review of the design and fabrication submittals by the contracting officer and by SRF-JRMC S980 WHE field inspection. Submittals are listed as general items. Some items may not be applicable based on specific design.

SD-01 Dimensional Check Sheet Records

Contractor shall perform dimensional checks before painting and submit the records. Dimensions shall satisfy tolerances in accordance with JIS B 0405.

SD-02 Certificates

All certifications shall be dated and shall bear the original signature (above the printed name) of the authorized representative of the contractor or the manufacturer of the items or equipment being certified. Each certification shall clearly identify components, and location (as applicable) to which it applies.

SD-02.1 Material Certificates

Material certificate shall include Steel plate, welding material.

SD-02.2 Safety data sheet (SDS)

SDS shall include for paint.

SD-02.3 Mass Certificates

Mass certificates shall be guaranteed by calibration certificate as shown below.

SD-02.4 Calibration Certificate

Calibration certificate for load measurement tool shall be traceable to the Japan Calibration Service System (JCSS).

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SD-02.5 Welding Certificates

The contractor shall provide certificates stating that all welders, welding operators, weld inspector(s) and welding procedure (qualification) meet the requirements of related JIS standards per 1.1 of this specification.

Table 2. SUBMITTALS

NO.	SD-01	SD-02				
	Dimension Check Sheet Records	SD-02.1	SD-02.2	SD-02.3	SD-02.4	SD-02.5
		Material Certificates	SDS	Mass Certificates	Calibration Certificates	Welding Certificates
1	NEED	NEED	NEED	NEED	NEED	NEED
2						

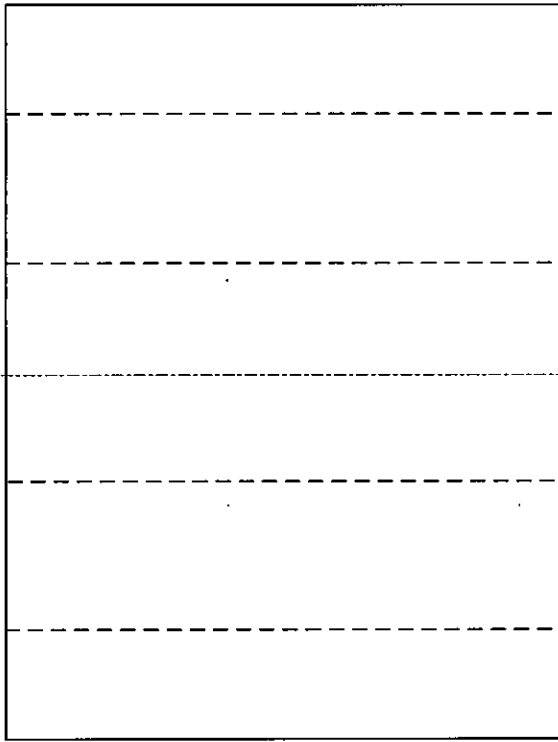
PART 4 EXECUTIONS

4. Acceptance

Final Government acceptance of the weight shall take only after the weight and documentation meets all contract requirements.

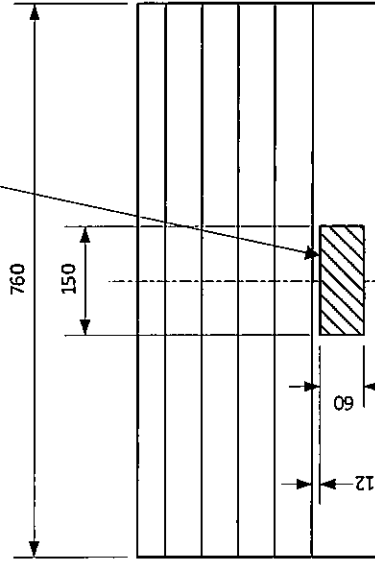
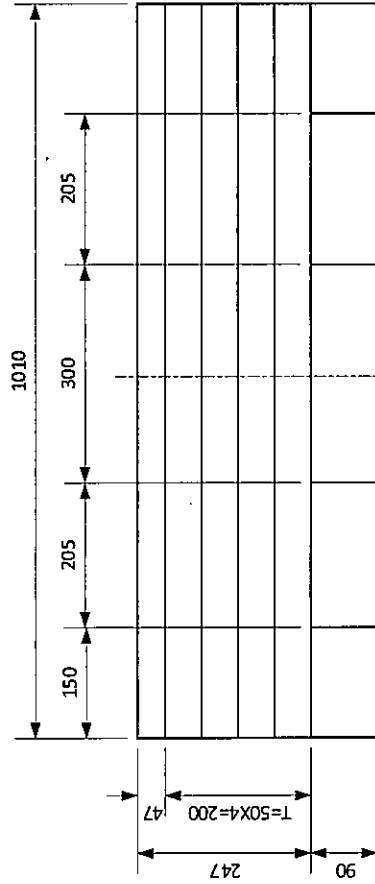
NO. ①

Enclosure 1
添付 1
(1 of 2)



Label plate (Both Side)
ラベルプレート(両側)

Label plate (Both Side)
ラベルプレート(両側)



SRF-JRMC DET SASEBO

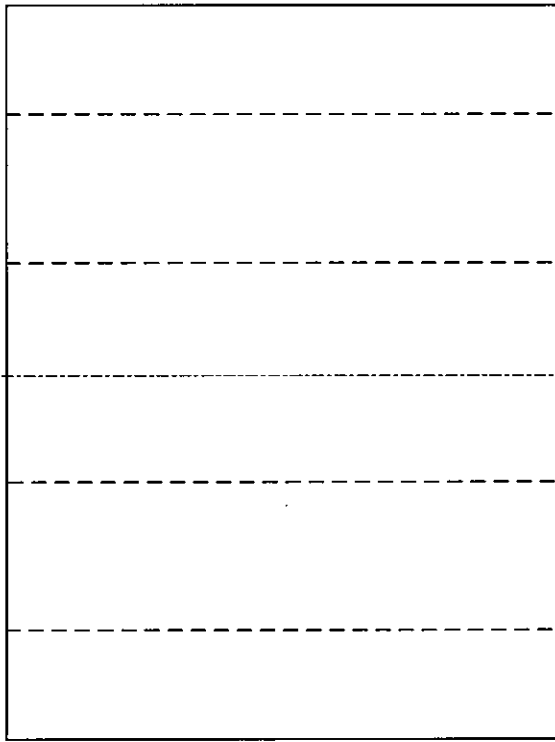
Test Weight
(4,000lbs)

1. Dimensions unit are millimeter other wise indicate.
(特記以外の寸法単位はミリメートルとする)

SIZE	FSCM NO	DWG NO	REV
		N/A	
SCALE	1:10	SHEET	1 OF 2

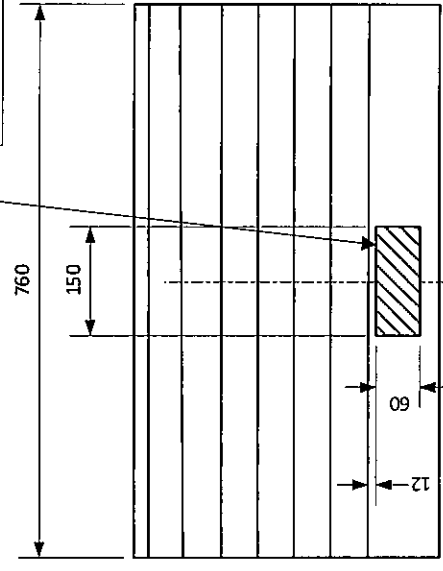
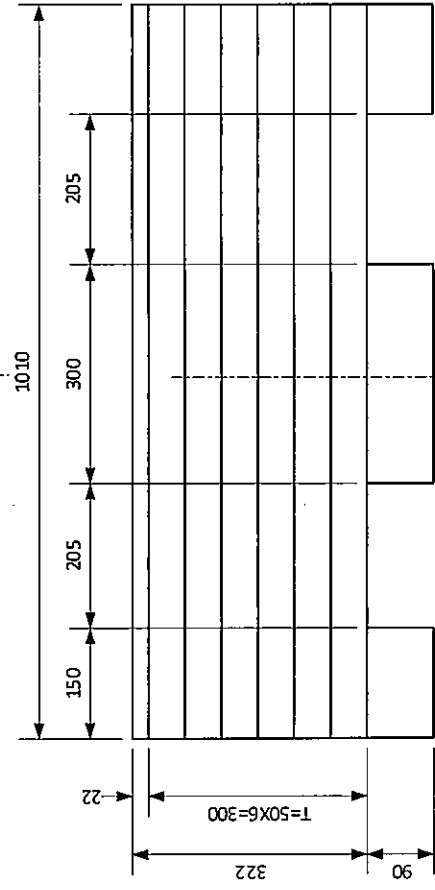
NO. ②

Enclosure 1
添付 1
(2 of 2)



Label plate (Both Side)
ラベルプレート(両側)

Label plate (Both Side)
ラベルプレート(両側)



SRF-JRMC DET SASEBO			
Test Weight (5,000lbs)			
SIZE	FSC/NO	DWG NO	REV
		N/A	
SCALE	1:10	SHEET	2 OF 2

1. Dimensions unit are millimeter otherwise indicate.
(特記以外の寸法単位はミリメートルとする)

Specification for label plates
(ラベルプレート仕様書)

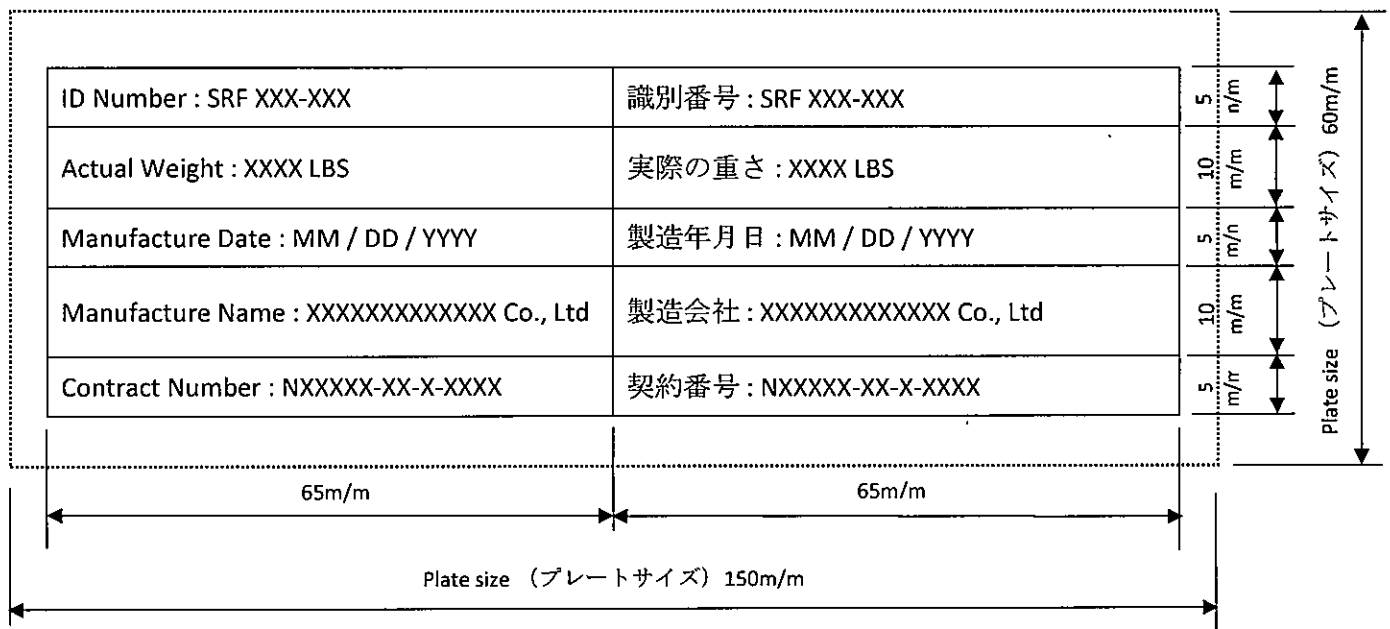
Enclosure 2 (添付 2)

1. ATTACH POINT (取り付け位置)

See Drawing for attach point (取り付け位置は添付図面を参照)

2. MATERIAL AND SIZE (材質、寸法)

Material (材質) : Stainless steel 1.5m/m thickness, Mirror (ステンレス鋼、板厚 1.5m/m、鏡面)



Font and type face : 2.5m/m and 3.0m/m Alphabet, 2.5m/m Japanese

(文字 : アルファベット 2.5m/m 及び 3.0m/m, 日本語 2.5m/m)