

NAVSEA
STANDARD ITEM

FY-11

ITEM NO: 009-98
DATE: 19 JUL 2007
CATEGORY: II

1. SCOPE:

1.1 Title: Monel Fasteners; inspect

2. REFERENCES:

2.1 S9086-CJ-STM-010/CH-075, Fasteners

3. REQUIREMENTS:

3.1 Maintain fastener accountability to ensure fasteners meeting the criteria of this item are reused in the same joint from which they came.

3.2 Clean each fastener free of foreign matter (including paint).

3.2.1 Chase and tap exposed threaded areas.

(V) "INSPECT FASTENER"

3.3 Visually inspect each fastener in accordance with the following requirements:

3.3.1 General inspection: Fasteners shall bear markings identifying material to be compatible with the system. Fasteners without markings are not acceptable. Joints with mixed material fasteners are not acceptable.

3.3.2 Engaged Thread Area:

3.3.2.1 Cracks are not acceptable.

3.3.2.2 Broken, chipped, or missing threads or other indications of brittle material failure, are not acceptable.

3.3.2.3 Gallings, spalling, or pitting is not acceptable.

3.3.2.4 Major defects are not acceptable. A major defect is a single defect (after removal of sharp edges and raised metal) that has a depth over one-half the thread depth.

3.3.2.5 Isolated minor defects are acceptable. A minor defect is a single nick, gouge, or flattened thread (after removal of sharp

edges and raised metal) that has a depth greater than 1/64-inch, but less than one-half the thread height (depth), and a width less than the thread spacing (pitch). Defects less than 1/64-inch deep may be ignored.

3.3.2.6 An isolated minor defect that exceeds the width criteria for a minor defect is acceptable when the total length of the defect does not exceed 15 percent of one thread length in any one complete thread.

3.3.2.7 Any combination of minor defects are acceptable when the total combined length of the defects does not exceed 15 percent of one thread length in any one complete thread.

3.3.2.8 Repaired threads that engage with a non-self-locking Class 3-B fit nut, turned with fingers, are acceptable.

3.3.3 Non-Engaged Thread Area:

3.3.3.1 Cracks are not acceptable.

3.3.3.2 For externally threaded fasteners, no minimum thread form is required, except as needed to provide initial thread engagement and passing of the nut.

3.3.4 Self-locking nuts shall have positive reinstallation torque. Cuts, tears, or looseness in self-locking elements or the adjacent metal are not acceptable.

3.3.4.1 Determine adequate torque values (i.e., positive reinstallation, breakaway, running) in accordance with Table 075-5-1 of 2.1.

3.3.5 Deformed or damaged flats on fasteners are not acceptable.

3.4 Discard fasteners not meeting the acceptance requirements of this item.

4. NOTES:

4.1 None.