Quality Clause 241202 - Valve Rod Tubing Requirements (07/01/2025 - Rev A)

1) All segments to be marked with the ASTM number and heat number.

2) Each segment shall be marked (tagged or labeled) with the Bird Johnson Propeller Company part number and purchase order (PO) number.

3) If required by specification referenced in the ordering data, ALL sections to be pressure and ultrasonic tested. Valve rod (V/R) tubing to be pressure tested for 1500 psi for 30 minutes. In lieu of pressure testing to 1500 psi for 30 minutes, eddy-current inspection per ASTM E 309 (or in accordance with EN10204 3.1) or flux leakage inspection per ASTM E 570 can be completed by a certified NDT Level 2 or Level 3 Inspector. Pressure testing will then be completed by Bird Johnson Propeller Company at completion of V/R section. The supplier must provide test results to Bird Johnson Propeller Company.

4) Inside and outside diameters of tube to be clean, free of foreign matter, and coated with 4FVD9 Mobilcut 100, Quaker FERROCOTE 61 MAL HCL 1 (product code 011527-11 03) or FERROCOTE EGL-1 (product code 003385-20). Both ends must be capped (Bird Johnson Propeller Company part number shall appear on each cap).

5) Mill certification of actual chemical, physical and required testing MUST be emailed to BirdJohnsonCerts@fmdefense.com with the PO number and part number referenced in the email subject line in the following format: “Documentation for PO XXXXXXXXXX, Part Number YYYYYYYYY”. Documentation must be legible and of reproducible quality. Files cannot contain macros or executables.

6) Supplier shall preserve, protect, and package materials to prevent damage during transit from any elements that may affect future manufacturing steps. No rust or surface contamination is permitted.