

Coded Note Number: **IC040**

Revision: **C004**

Date: **September 5, 2018**

Title: **PROTECTION, PACKING, AND PACKAGING REQUIREMENTS**

1. Capping and sealing of orifices. Components with orifices (end connections and other openings) require individual capping and sealing prior to shipment in order to maintain cleanliness and provide protection against damage and contamination during shipment and storage at Newport News Shipbuilding (NNS).
 - 1.1. Standard shipping packaging shall not be used as an alternative for capping and sealing of orifices.
2. Protection of machined sealing surfaces. Flange sealing surfaces (phonographic finish) and machined sealing surfaces such as end preps, end connections, threads (male and female), etc., shall be protected from potential damage from material transport and storage using caps, covers, or plugs.
3. Covering requirements for flanges attached to components. For flanges that are attached to piping components with internal crevices or inaccessible areas (e.g. valves, pumps, etc.), a cleanliness cover shall be attached to the flange mating surface. The back of the bolt holes shall be taped to prevent particles or contaminants from entering through the bolt hole cavity, unless the cover is secured inside of the bolt holes.
4. Allowed materials. Caps, covers, or plugs shall be made of any of the following materials:
 - a) silicon rubber
 - b) stainless steel
 - c) aluminum
 - d) rigid Teflon
 - e) rigid polyethylene
 - f) ethylene propylene rubber
 - g) nitrile butadiene (Buna-N) rubber
 - h) polyamide (Nylon)
 - i) acetal homopolymer (Delrin)
 - j) rigid polyurethane (Pellethane)
5. Sealing tape. If used, sealing tape shall be 3M Performance Plus Duct Tape 8979N, slate blue in color.
6. Color prohibitions. The use of yellow wrapping or protection devices, such as caps, covers, and plugs, are strictly prohibited.

7. Packing and packaging standards. Packing and packaging shall be such that the component or part is not damaged, cleanliness is maintained, and that the tags on each item remain intact, secure, and legible for temporary storage and handling after receipt.

7.1. The material furnished for each item on the Purchase Order shall be packaged in separate container unless the Purchase Order specifically requires multiple items to be either assembled or packaged together for delivery. Each individual container (defined as a box, crate, or bag; not material such as shrink wrap) shall be prominently tagged or clearly marked with:

- a) Newport News Purchase Order Number
- b) Purchase Order Line Item Number
- c) Newport News Part Number

Revision History Table		
Rev	Description	Revision Date
C004	<u>REVISED:</u> 1. Revised title to better reflect content. Title was "Packing and Shipping Requirements". 2. Editorial changes (numerous occurrences): Updated Coded Note format; re-organized wording, and combined or removed redundant requirements to add clarity where necessary. <u>REMOVED:</u> 3. Every occurrence of previous revision control removed (Revision Control paragraph, [Text deleted], and bold text). 4. Paragraph for "preferred material requirements" removed because requirements are covered by the list of specific materials in Paragraph 4.	9/5/2018

This revision history is provided for convenience and does not alleviate the supplier's responsibility with understanding and complying with the full coded note.