

METRIC

DOD-F-24669/6

7 July 1986

SUPERSEDING

MIL-S-862B

23 March 1959

MILITARY SPECIFICATION

FORGINGS AND FORGING STOCK, STEEL BARS
AND BILLETS, CORROSION RESISTING; FOR REFORGING (METRIC)

This specification is approved for use by all Departments and Agencies of the Department of the Defense.

1. SCOPE

1.1 Scope. This specification covers corrosion resisting steel for reforging.

1.2 Classification. Bars and billets shall be classified by chemical composition by reference to the UNS or type number as defined by ASTM A 314 (see 6.2).

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specification and standard. The following specification and standard forms a part of this specification to the extent specified herein. Unless otherwise specified, the issues of these documents shall be those listed in the issue of the Department of Defense Index of Specifications and Standards (DoDISS) and supplement thereto, cited in the solicitation.

SPECIFICATION

MILITARY

DOD-F-24669 - Forgings and Forging Stock, Steel Bars, Billets and Blooms, General Specification for. (Metric)

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Commander, Naval Sea Systems Command, SEA 5523, Department of the Navy, Washington, DC 20362-5101 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

AREA FORG

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STANDARD

MILITARY

MIL-STD-105 - Sampling Procedures and Tables for Inspection By
Attributes.

(Copies of specifications and standards required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting activity.)

2.2 Other publication. The following document forms a part of this specification to the extent specified herein. Unless otherwise specified, the issue of the documents which are DoD adopted shall be those listed in the issue of the DoDISS specified in the solicitation. Unless otherwise specified, the issues of documents not listed in the DoDISS shall be the issue of the nongovernment documents which is current on the date of the solicitation.

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

A 314 - Standard Specification for Stainless and Heat-Resisting
Steel Billets and Bars for Forging.

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.)

(Nongovernment standards and other publications are normally available from the organizations which prepare or which distribute the documents. These documents also may be available in or through libraries or other informational services.)

2.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein (except for associated detail specifications, specification sheets or MS standards), the text of this specification shall take precedence. Nothing in this specification, however, shall supersede applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 General. The material furnished under this specification shall be in accordance with the requirements of DOD-F-24669 and as specified herein.

3.2 Manufacture. The material shall be manufactured in accordance with DOD-F-24669 except that electric furnace or vacuum induction processes shall be the only ones permitted.

3.3 Chemical composition. The chemical composition shall comply with the requirements of ASTM A 314.

3.4 Mechanical properties. No mechanical properties or heat treatments are required by this specification.

3.5 Dimensions and tolerances. Dimensions and form shall be as specified (see 6.2). Tolerances shall be in accordance with DOD-F-24669.

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4. QUALITY ASSURANCE PROVISIONS

4.1 The quality assurance provisions shall be in accordance with DOD-F-24669 and as specified herein.

4.2 Dimensional examination. Sampling shall be in accordance with MIL-STD-105, general inspection level I, acceptance quality level 1.5.

5. PACKAGING

(The packaging requirements specified herein apply only for direct Government acquisition.)

5.1 Preservation, packing, packaging, and marking shall be in accordance with DOD-F-24669.

6. NOTES

6.1 Intended use. Corrosion resisting steel bars and billets acquired to this specification are intended for reforging purposes only. Material for reforging should not be stocked and should not be ordered unless it is certain that the material will be used for reforging purposes. Corrosion resisting steel for items to be welded should be types 304L, 316L, 321 or 347.

6.2 Ordering data. In addition to the ordering data of DOD-F-24669, acquisition documents should specify the following:

- (a) Alloy required (see 1.2).
- (b) Dimension and form (see 3.5).
- (c) Size and quantity of bars or reforging stock required.
- (d) For bars and billets in excess of 645 square centimeters (100 square inches), the acceptance criteria for macrostructure examination (see DOD-F-24669).

Custodians:

Army - MR
Navy - SH
Air Force - 99

Preparing activity:

Navy - SH
(Project FORG-0128-06)

Review activities:

Army - AR, MI, GL
Navy - AS, OS
Air Force - 84

User activity:

Navy - MC

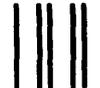
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NOTE: This form may not be used to request copies of documents, nor to request waivers, deviations, or clarification of specification requirements on current contracts. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements.

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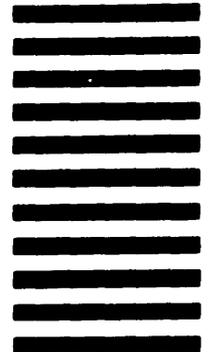
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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions – Reverse Side)

1. DOCUMENT NUMBER DOD-F-24669/6	2. DOCUMENT TITLE
3a. NAME OF SUBMITTING ORGANIZATION	4. TYPE OF ORGANIZATION <i>(Mark one)</i> <input type="checkbox"/> VENDOR <input type="checkbox"/> USER <input type="checkbox"/> MANUFACTURER <input type="checkbox"/> OTHER <i>(Specify):</i> _____
b. ADDRESS <i>(Street, City, State, ZIP Code)</i>	
5. PROBLEM AREAS	
a. Paragraph Number and Wording:	
b. Recommended Wording:	
c. Reason/Rationale for Recommendation:	
6. REMARKS	
7a. NAME OF SUBMITTER <i>(Last, First, MI)</i> – Optional	b. WORK TELEPHONE NUMBER <i>(Include Area Code)</i> – Optional
c. MAILING ADDRESS <i>(Street, City, State, ZIP Code)</i> – Optional	8. DATE OF SUBMISSION <i>(YYMMDD)</i>

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