INCH-POUND

MIL-F-22606C(SH)
AMENDMENT 1
17 September 1993

MILITARY SPECIFICATION

FLASK, COMPRESSED GAS, AND END PLUGS FOR AIR, OXYGEN, AND NITROGEN

This amendment forms a part of Military Specification MIL-F-22606C(SH), dated 22 August 1992 and is approved for use by the Naval Sea Systems Command and is available for use by all Departments and Agencies of the Department of Defense.

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2.1.1, Under SPECIFICATIONS, FEDERAL, delete "O-T-620".

Under SPECIFICATIONS, MILITARY, add,

"MIL-C-24782 - Coating, Powdered Fluoropolymer for use on High Pressure Gas Flask Interiors"

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3.4.1, delete and substitute the following:

"3.4.1 Blasting. Flask surfaces shall be abrasive blasted to a minimum of a near-white finish in accordance with SSP SP 10. The abrasive and particle size shall be selected by the manufacturer to produce surface finishes suitable for the application of protective coatings as specified herein. The abrasive debris shall be removed by vacuuming or other suitable means. Protection shall be provided for threads during the blasting operations."

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3.4.4, Delete and substitute the following:

"3.4.4 Plugs. Plugs shall be free of oil, grit, products of machining, and other debris. They shall be rinsed with detergent trisodium phosphate (O-S-642), or commercially acceptable cleaners until ultraviolet light examination shows no oil contamination."

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3.5.1, Delete and substitute the following:

"3.5.1 Interior. Unless otherwise specified (see 6.2) service A flask interiors shall be coated with a fluoropolymer resin coating in accordance with MIL-C-24782 or an organic zinc rich coating. Service B flask interiors shall, if specified, (see 6.2) be phosphated."

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3.5.2, Delete and substitute the following:

"3.5.2 Exterior. Unless otherwise specified (see 6.2) the exterior surfaces of all flasks, regardless of service, shall be coated with an organic zinc rich primer system to a nominal dry film thickness of 0.002-inch to 0.004-inch. Heavier thicknesses at spray pass intersections and areas of potential buildup, such as skirt attachments are acceptable, but shall be kept to a minimum consistent with normal coating procedures."

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4.4.4.3, Delete and substitute the following:

"4.4.4.3 Flask ultrasonic inspection. After the hydrostatic test has been completed, each flask shall be ultrasonically examined over the external cylindrical section to a point 3 inches beyond the start of curvature of the integrally formed head, except where prevented by welded attachments (i.e. lifting lugs, skirts, body rings, etc.). This examination in accordance with MIL-STD-271, shall use shear wave testing in both the circumferential and axial direction, and longitudinal wave testing."

Preparing activity:
NAVY-SH
(Project 8120-N431)

Review activity:
DLA - GS