

INCH-POUND

MIL-F-5591C  
AMENDMENT 2  
15 DECEMBER 1999

MILITARY SPECIFICATION

FASTENERS, PANEL, NONSTRUCTURAL

This amendment forms a part of MIL-F-5591C, dated 20 JUNE 1999, and is approved for use by all Departments and Agencies of the Department of Defense.

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3.1 Delete and Substitute: "3.1 Qualification. The fastener manufacturer shall be responsible for conducting qualification tests and furnishing part drawings, certified qualification test reports (if required by the purchaser) and test samples. The fasteners furnished under this specification shall be produced using the same manufacturing methods as those used to produce fasteners that have passed qualification tests. The purchaser may apply any or all tests specified herein to any product represented as meeting this specification, at any time, to verify conformance."

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3.7 Reidentify paragraph "3.7 Workmanship" as "3.8 Workmanship".

Add paragraph "3.7 Identification of product". The manufacturer's identification and code marking shall be marked on top of the stud head. Marking may be formed by forging, stamping, or laser. Marking may be raised or indented 0.010 inch maximum."

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4.4.1 Delete and Substitute: "4.4.1 Qualification samples. Test samples shall be of the same material and manufactured by the same method as production parts. Samples for qualification shall consist of eight specimens as shown on figure 2, eight specimens as shown on figure 4, one specimen as shown on figure 4, mounted on sheets having a total thickness of 0.010 inch less than the total nominal thickness specified on figure 4, and one as shown on figure 3."

AMSC N/A

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Add: "4.4.1.1 Certified test report. The manufacturer shall maintain on file a certified test report showing that the manufacturer's product satisfactorily conforms to this specification. The test report shall include, as a minimum, actual results of the tests specified herein. The manufacturer shall also maintain a dated drawing that completely describes the manufacturer's product. The drawing shall specify all dimensions and tolerances, material composition, coatings or platings applied, forming process, and heat treatment. The drawing shall also specify the manufacturer's part number for each size. Requalification will be required in the event any change is made in the product design, construction, materials, method of manufacture, heat treatment, finish, lubricant, or manufacturer's part number or designation."

Add: "4.4.1.2 Retention of qualification. To maintain product qualification status, manufacturers shall maintain on file, a certified qualification test report available for inspection by the procuring activity. The retention of a certified qualification test report by the manufacturer signifies that the manufacturer has demonstrated compliance to the qualification requirements of this specification. Products previously qualified via government-certified qualification tests and reports shall be considered qualified to this specification."

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6.3 Delete and Substitute: "6.3 Qualification. Awards will be made only for products that meet the qualification requirements of this document at the time set for opening of bids. Bolts that have not been previously qualified via government-certified qualification tests and reports may be acquired, provided that certified qualification test reports for these bolts are retained on file by the manufacturer along with the quality conformance inspection data, and they are made available to the buyer upon request."

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Army - AR  
Navy - AS  
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