

MIL-G-18916(SHIPS)
AMENDMENT 3
8 July 1985

SUPERSEDING
AMENDMENT 2
15 January 1964

MILITARY SPECIFICATION

GOVERNORS, STEAM DRIVEN PUMP
PRESSURE REGULATING, NAVAL SHIPBOARD

This amendment forms a part of Military Specification MIL-G-18916(SHIPS), dated 19 September 1955, and is approved for use by the Naval Sea Systems Command, Department of the Navy and is available for use by all Departments and Agencies of the Department of Defense.

PAGE 3

2.1, continued, Under Military Specifications: Add

"MIL-F-1183 - Fittings, Tube; Bronze, Cast Silver-Brazing.
"MIL-Q-9858 - Quality Control System Requirements."

PAGE 4

2.1, continued, Under Bureau of Ships Drawings: Add

"B-214 - Root Connections for Attaching Piping."

PAGE 6

* 3.1 Delete and substitute:

"3.1 First article. When specified (see 6.1), a sample shall be subjected to first article inspection (see 4.4 and 6.2)."

PAGE 8

3.2.7.4: Delete.

PAGE 10

Add paragraph 3.2.7.6.3:

"3.2.7.6.3 Flange bolting shall straddle the vertical centerline. Where an odd number of bolts is used, the vertical centerline at the top of the flange shall be straddled."

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MIL-C-18916(SHIPS)
AMENDMENT 3

PAGE 11

Add paragraph 3.4.2.5:

"3.4.2.5 No packing glands, stuffing boxes, metal bellows or syphons shall be used on any automatically moving parts."

3.4.3.3: Delete and substitute:

"3.4.3.3 Unless otherwise specified in the contract or order, the main steam governing valves shall not be furnished as a part of the class 2 governors (see 6.1). When the main steam governing valves are required by the contract or order, the following shall apply:

"3.4.3.3.1 Valve seats may be separate or integral with the body. Where separate seat rings are used they shall be seal welded or seal brazed to the body to prevent steam cutting through the threads. Where seats are integral, they shall be faced with cobalt chromium composition facing (see table IV, note 1).

"3.4.3.3.2 Control valve packing shall be of the self lubricating type for temperatures up to 450°F. For temperatures over 450°F, lubricating of the stuffing box or other suitable means to insure low steam friction shall be used, and the bonnet and yoke shall be of a design to insure adequate cooling. All valves shall be furnished with the packing external to the stuffing box, enclosed in a waterproof bag which shall either be wired to the valve or inserted in the body bore and protective flange caps attached to the line flanges.

"3.4.3.3.3 Valve packing glands shall be of bolted construction."

PAGE 12

3.4.3.4: Delete and substitute:

"3.4.3.4 Ships service air will normally be supplied to the governor at pressures varying from 65 to 100 p.s.i.g. The governor shall be designed to operate in accordance with this specification when the air supply is as low as 65 p.s.i.g."

PAGE 13

3.4.3.9: Delete and substitute:

"3.4.3.9 All pipe connections other than for the control air shall be flanged, or have a union for disassembling. Flanges, if used, shall conform to the dimensions given in the applicable flange standards, and shall be finished on their gasket seats with a fine tool (F2 finish). Unions shall be in accordance with MIL-F-1183 for copper tubing, and to commercial standards for steel tubing.

"3.4.3.9.1 When it is not feasible to provide a flange or union connection directly on the unit, a nipple may be welded or silver-brazed directly into the unit and the breakdown joint located accordingly. The requirements of Drawing B-214 should be followed in this construction."

MIL-G-18916(SHIPS)
AMENDMENT 3

PAGE 15

Top of page: Delete "Table III - Materials (cont'd)." and substitute "Table IV - Materials (cont'd)."

PAGE 23

- * 3.9.5(g): Delete "qualification approval, and".

PAGE 25

4.1: Delete and substitute:

"4.1 Examination. Each governor shall be examined to determine conformance with this specification as to material, dimensions and workmanship."

4.3.1, lines 1 and 2: Delete "as selected by the Government inspector."

PAGE 26

- * 4.4: Delete "Qualification" and substitute "First article".
- * 4.4.1, line 1: Delete "qualification" and substitute "first article testing".
- * 4.4.1, line 2: Delete "Qualification" and substitute "First article testing".
- * 4.4.3: Delete "qualification" and substitute "first article".

4.5: Delete and substitute:

"4.5 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified, the supplier may utilize his own facilities or any commercial laboratory acceptable to the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

"4.5.1 Quality system control. The supplier shall provide and maintain a quality control system acceptable to the Government. The system of quality control shall be in accordance with MIL-Q-9858 and as specified in 4.5.1.1 to 4.5.1.3.1 inclusive. The supplier is in no way relieved of the final responsibility to furnish governors meeting the requirements of this specification.

"4.5.1.1 Description of procedures. Procedures shall be assembled in manual form and shall indicate organization and responsibility for the control of quality.

MIL-G-18916(SHIPS)
AMENDMENT 3

"4.5.1.2 Inspection during manufacture. The supplier shall establish and maintain inspection at approximately located points in the manufacturing process, beginning with the receipt of raw materials and subcontracted parts through fabrication, assembly, testing and preparation for shipment of completed units, to assure continuous control of quality of parts, components, assemblies, and construction including welding and fabrication.

"4.5.1.3 The supplier shall provide and maintain gauges, instruments and other measuring and testing devices necessary to assure that supplies conform to contract requirements. These devices shall be calibrated against measurement standards or designated measuring equipment at established periods to assure continued accuracy. The supplier shall prepare and maintain a written schedule for maintenance and calibration of such equipment based on the type, purpose and degree of usage.

"4.5.1.3.1 All instruments used in performance acceptance tests shall be calibrated before and after tests."

PAGE 32

- * 6.1: Add: "(q) First article inspection, if required (see 3.1)."
- * 6.2: Delete and substitute:

"6.2 First article inspection. Invitations for bids should provide that the Government reserves the right to waive the requirement for samples for first article inspection as to those bidders offering a product which has been previously acquired or tested by the Government, and that bidders offering such products, who wish to rely on such production or test, must furnish evidence with the bid that prior Government approval is presently appropriate for the pending contract."

PAGE 35

- * Index, first column: Delete "Qualification" and substitute "First article".
- * Index, first column: Delete "Tests, qualification" and substitute "Tests, first article".

NOTE: The margins of this amendment are marked with an asterisk to indicate where changes (additions, modifications, corrections, deletions) from the previous amendment were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous amendment.

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