

MIL-P-19380/2
28 March 1981
SUPERSEDING IN PART
MIL-P-19380H
5 April 1972
With Amendment-1
15 November 1972

MILITARY SPECIFICATION

JOINING FITTINGS, TOOLS, AND GAGES, DETAIL SPECIFICATION FOR

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

The complete requirements for procurement of joining fittings, tools, and gages described herein shall consist of this document and the latest issue of Military Specification MIL-P-19380J.

1. SCOPE

1.1 Scope. This specification describes detail requirements for joining fittings, tools, and gages used to couple P-series sectional pontoons.

1.2 Classification. Joining fittings, tools, and gages shall be of the Mark numbers specified (see 6.2 and Table I).

2. APPLICABLE DOCUMENTS

2.1 Issues of documents. The following documents, of the issue in effect on date of invitation for bids or request for proposal, form a part of this specification to the extent specified herein.

3. REQUIREMENTS

3.1 General specification. The individual item requirements shall be as specified herein and in accordance with MIL-P-19380J. In the event of any conflict between requirements of this specification and the general specification, the detail specification shall govern.

3.2 First article. (See 3.2 of MIL-P-19380J.)

3.3 Drawings. (See 3.3 of MIL-P-19380J.)

3.4 Materials. (See 3.4 of MIL-P-19380J.)

3.4.1 Structural steel. (See 3.4.1 of MIL-P-19380J.)

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Commanding Officer (Code 156), Naval Construction Battalion Center, Port Hueneme, CA 93043, by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

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3.4.2 Forged steel. Flanged nut, Mark FN-1, shall be of forged steel conforming to ASSTM A576, grade range 1030 through 1040, heat treated and normalized, having a tensile strength of not less than 105,000 psi.

3.4.3 Alloy steel. Alloy steel shall conform to ASTM A322 or A331, grade range 4130 through 4140, hot rolled and annealed, having a hardness of not less than Rockwell C36. This material shall apply to the link, Mark P5-H1; and pins, Mark P5-H2 and Mark P5-G1.

3.4.4 Steel pipe. (See 3.4.3 of MIL-P-19380J.)

3.5 Construction. (See 3.5 of MIL-P-19380J.) Joining fittings, tools, and gages shall be fabricated as specified herein and as shown on the applicable drawings listed in Table I.

TABLE I. Joining fitting, tools, and gages.

Mark number	Description	Drawing number
J1	Jig, angle welding	813650
JT2	Clamp, top angle	889752
JT15	Roller, launching	889663
JT5	Wrench, pontoon plug	889752
JT7	Wrench, drive pontoon	1355562
JT8	Wrench, backup, pontoon	1355563
JT9	Wrench, plug, pontoon	816467
JT13	Alining tool, pontoon	1355564
PG	Positioning gage	816456
HSG	Hole spacing gage	816456
A, C, and C	Assembly angle gages	816456
LP5	Link and pin assembly	879112
		879113
HN6	Nut	879116
A6B	Bolt	879116
ES2	Angle, spacer, pontoon	816444
ES4	Gage "D"	816456
H17AF	Hinge, heavy duty, female	879117
H17AM	Hinge, heavy duty, male	879117
H21	Pin, hinge, heavy duty	879117
H40	Hinge, ramp	889766
A70	Pin, hinge	889766
KP1	Plate, keeper	879116
FN1	Flange nut (used with assembly bolts)	879116
AP-1, AP-8	Plate, assembly	879118
AP-12	Plate, assembly	879118
AP-4A	Plate, tie	879118
AP-5	Plate, end	879118
AP-7	Plate, gusset	879118
E915L, E915R, E917L, E917R, E919L, E919R,	Assembly angles	6002567
E921L, E921R		Sheet 2
1-1/4-7NC X 2" LG GLV	Bolt	816444

TABLE I. Joining fitting, tools, and gages - continued.

Mark number	Description	Drawing number
E701, E703, E705 E707, E709, E711 E713, E801, E901L E901R, E903L, E903R, E905L, E905R, E907L, E907R, E909L, E909R	Assembly angles	Sheet 2 816444
RA1	Ramp angle (for 3X5 tug)	879116

3.6 Interchangeability. (See 3.6 of MIL-P-19380J.)

3.6.1 Gaging. (See 3.6.1 of MIL-P-19380J.)

3.7 Performance characteristics. (See 3.7 of MIL-P-19380J.)

3.8 Cleaning and painting. (See 3.8 through 3.8.2.2 of MIL-P-19380J.)

3.9 Identification marking. (See 3.9 of MIL-P-19380J.)

3.10 Workmanship. (See 3.10 through 3.10.5 of MIL-P-19380J.)

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. (See 4.1 of MIL-P-19380J.)

4.2 First article. (See 4.2.1 of MIL-P-19380J.)

4.3 Examination. Examination shall be conducted as specified in Table I of MIL-P-19380J. Any item having one or more defects shall be rejected. (See 4.5 of MIL-P-19380J.)

4.3.1 Welding examination. (See 4.5.1 of MIL-P-19380J.)

4.4 Packaging inspection. (See 4.6 of MIL-P-19380J.)

5. PACKAGING

5.1 Preservation, packing, and marking. Preservation, packing, and identification marking shall be in accordance with Section 5 of MIL-P-19380J.

6. NOTES

6.1 Intended use. Joining fittings and tools are used for assembling and coupling the Navy P-series pontoons into floating and nonfloating platforms and structures.

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6.2 Ordering data. Acquisition documents should specify the following:

- (a) Title, number, and date of detail specification and associated general specification.
- (b) Mark number(s) and item(s) required (see 1.2).
- (c) When a first article is required for inspection and approval (see 3.2, 4.2.1, and 6.4 of MIL-P-19380J).
- (d) Identification marking required (see 3.9).
- (e) Level of preservation and packing required (see 5.1).

6.3 Contract data requirements. (See 6.3 of MIL-P-19380J.)

6.4 First article. (See 6.4 of MIL-P-19380J.)

Custodians:

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Project No. 1945-0018-02

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DOCUMENT IDENTIFIER (Number) AND TITLE

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1 OCT 76

Replaces edition of 1 Jan 72 which may be used.

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