

INCH-POUND

MIL-P-19380J
NOTICE 1
10 MAY 1995

MILITARY SPECIFICATION

PONTOONS, STEEL, SECTIONAL, P-SERIES: INCLUDING FITTINGS
AND TOOLS (FOR COUPLING INTO FLOATING STRUCTURES),
GENERAL SPECIFICATION FOR

This notice should be filed in front of MIL-P-19380J dated 28 March 1981.
MIL-P-19380J is inactive for new design and is no longer used, except for
replacement purposes.

Preparing activity:

Navy - YD1

(Project 1945-0071)

AMSC N/A

FSC 1945

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MIL-P-19380J
AMENDMENT-2
26 July 1982
SUPERSEDING
AMENDMENT 1
24 AUGUST 198 1

MILITARY SPECIFICATION

PONTOONS, STEEL, SECTIONAL, P-SERIES: INCLUDING FITTINGS
AND TOOLS (FOR COUPLING INTO FLOATING STRUCTURES),
GENERAL SPECIFICATION FOR

This Amendment forms a part of Military Specification MIL-P-19380J,
dated 28 March 1981, and is approved for use by all Departments and
Agencies of the Department of Defense.

PAGE 4

2.1, DRAWINGS, NAVAL FACILITIES ENGINEERING COMMAND (NAVFAC), Insert after
"6002567, Sheet 34...":

6028355 - Causeway Lifting Padeye (PH10).
6028362 - Flexor Assembly Instructions.

PAGE 5

2.1, CIVIL ENGINEERING LABORATORY (CEL), insert after 77-26-8F:

79-13-1F - Center Universal End Pontoon".

Delete:

CIVIL ENGINEER SUPPORT OFFICE (CESO)

Drawing No.	Description
SK9103	Pad, Lift/Launch, Pontoon Causeway Barge.
SK9114	Flexor Connector Assembly Instructions.

PAGE 8

3.8.2.1, line: 6 Change: "completed the same day as blast cleaning." to
read: "completed within a maximum of 4 hours after blast cleaning."

Custodians:

Preparing activity:

Army - ME
Navy - YD

Navy - YD

Project No. 1945-0048

FSC 1945

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

MILITARY SPECIFICATION

PONTOONS, STEEL, SECTIONAL, P-SERIES: INCLUDING FITTINGS AND TOOLS (FOR COUPLING INTO FLOATING STRUCTURES), GENERAL SPECIFICATION FOR

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

1. SCOPE

1.1 Scope. This specification discusses requirements for steel pontoon units, components, and fittings for coupling together to form barges, causeways, and other types of floating structures (see 6.1 of the applicable detail specification).

1.2 Classification. Units, components, and parts shall be of the mark numbers specified (see 6.2 and Table I of the applicable detail specification).

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.

SPECIFICATIONS

FEDERAL

A-A-880 - Strapping, Steel, and Seals.
TT-V-121 - Varnish, Spar, Water-Resisting.
TT-W-571 - Wood Preservation: Treating Practices.
UU-T-81 - Tags, Shipping and Stock.
PPP-B-601 - Boxes, Wood, Cleated-Plywood.
PPP-B-621 - Boxes, Wood, Nailed and Lock-Corner.
PPP-B-636 - Boxes, Shipping, Fiberboard.

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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MIL-P-116 - Preservation-Packaging, Methods of.
 MIL-B-121 - Barrier Material, Greaseproofed, Waterproofed, Flexible.
 MIL-P-13983 - Paint, Temporary, Lusterless, Gasoline Removable.
 MIL-F-16723 - Fairleads and Rollers (for Pontoon Assemblies and Marine Railways).
 MIL-C-18295 - Chain and Fittings for Fleet Moorings.
 MIL-T-22085 - Tape, Pressure-Sensitive Adhesive, Preservation and Sealing.
 MIL-D-23003 - Deck covering Compound, Nonslip, Lightweight.
 MIL-P-24441 - Paint, Epoxy Polyamide.
 MIL-T-27730 - Tape, Antiseize, Polytetrafluoroethylene.

DETAIL SPECIFICATIONS

MIL-P-19380/1 - Pontoons, Steel, Sectional, P-Series.
 MIL-P-19380/2 - Joining Fittings, Tools, and Gages.
 MIL-P-19380/3 - Deck Fittings and Outfitting Accessories.
 MIL-P-19380/4 - Drydock Equipment and Miscellaneous Fittings and Accessories.

STANDARDS

FEDERAL

FED-STD-H2B - Screw-Thread Standards for Federal Services.

MILITARY

MIL-STD-105 - Sampling Procedures and Tables for Inspection.
 MIL-STD-129 - Marking for Shipment and Storage.

DRAWINGS

NAVAL FACILITIES ENGINEERING COMMAND (NAVFAC)

Drawing No.	Description
142877	N.L. Equipment P-Series Pontoons Fuel Storage Barge 1500 BBL Wood Foundation for 500 BBL Tank.
146294	Landing Ramp for 30 Ton Tank.
146520	Fairlead Roller - Single Line.
146608	Pontoon Gear Chocks.
494620	Running Lights for Pontoon Barges Assembly and Details.
813634	P-1 Assembly and Connection Details.
813635	P-1 Parts Details.
813636	P-2 Assembly.
813637	P-2 Connection Details.
813638	P-2 Parts Details.
813639	P-2 Parts Details.

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Drawing No.	Description
813640	P-3 Assembly.
813641	P-3 Connection Details.
813642	P-3 Parts Details.
813643	P-4 Assembly.
813644	P-4 Connection Details.
813645	P-4 Parts Details.
813650	Welding Jig-J1 for Assembly Details.
813651	R-1A Ramp for P-4 Pontoon Details.
813654	Pontoon Gear Miscellaneous Fittings Details.
816433	Pontoon Drydock Manifolds, MDL and DMS Details.
816444	Pontoon Assembly Angles (Modified Design) Details.
816452	Winch Support, Mark WT5.
816455	Fairleads Anchor Davit Details.
816456	Hole Spacing Gages for Assembly Angles and Pontoons, Arrangement and Details.
816461	Hatch Cover and Floor Panel Assembly Erection Details.
816462	Anchor Hoist Pontoon Barge Arrangement and Details.
816463	Pontoon Drydocks Blocking Frame (Adjustable) Parts Detail.
816464	Pontoon Drydocks Blocking Frame (Adjustable) Erection Details.
816466	Erection Details for Miscellaneous Fittings on Pontoon Drydocks.
816467	Pontoon Drydocks Miscellaneous Fittings Parts Detail.
816468	Pontoon Drydocks Miscellaneous Fittings Parts Detail.
816408	P5F, P5M Pontoon Mating Assembly.
879112	Pontoon P5F, P5M Assembly.
879113	Pontoon P5F, P5M Parts Details.
879116 Sheets 1 through 3	Pontoon Gear Miscellaneous Fittings.
879117	Heavy Duty Hinge H17AF and H17AM.
879118	Pontoon Gear Miscellaneous Fittings.
879125	Propelling Unit Foundation Model 0A31 Engine Bed Assembly and Details.
879160	Anchor Housing Assembly.
879162	Warping Tug A-Frame Assembly and Details.
879175	Barge, Net Tending.
889663	Lighterage and Barge Gear Miscellaneous Fittings.
889752	Pontoon Assembly Gear.
889764	Pontoon Gear Miscellaneous Fittings.
889766	Landing Ramp for 30 Ton Tank.
889767	Landing Ramp for 30 Ton Tank.
889772	Pontoon Gear Deck Fittings.
1290786	Lashing-Causeway/Barge Hinged Padeye PH6 LST side Carry Parts Detail.
1332752	Flexor Coupling Parameters.
1332753	Flexor System.

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Drawing No.	Description
1332754	Flexor Body Assembly.
1332755	Tensor Assembly, Bearing Block and Separators.
1332756	Fair Details.
1355562	Drive Wrench Extension JT7, Pontoon Assembly, Parts Details.
1355563	Back up Wrench JT8, Pontoon Erection, Parts Details.
1355564	Alignment Tool JT13, (2PC).
6002567	
Sheet 1	3X14 Causeway Offshore Section (Atlantic), Erection Diagram.
Sheet 2	Assembly Angles Details.
Sheet 3	Miscellaneous Fittings Parts Details.
Sheet 4	Pontoon P6L, P6R Assembly Details.
Sheet 5	Pontoon P6L, P6R Sectional Views.
Sheet 6	Pontoon P6L, P6R Cross Frame Front.
Sheet 7	Pontoon P6L, P6R Bottom Frame.
Sheet B	Pontoon P6L, P6R Peripheral Frame.
Sheet 9	Pontoon P6L, P6R Frame, Plates, and Angles.
Sheet 10	Pontoon P6L, P6R Frame Angles.
Sheet 11	Pontoon P6L, P6R Cross Frames.
Sheet 12	Pontoon P6L, P6R Trough.
Sheet 13	Pontoon P6L, P6R Deck Plates.
Sheet 14	Pontoon P6L, P6R Plates.
Sheet 15	Pontoon P6L, P6R Filler Plates.
Sheet 16	Pontoon P6L, P6R Channels and Angles.
Sheet 17	Pontoon P6C Assembly Details.
Sheet 18	Pontoon P6C Cross Frames and Sectional Views.
Sheet 19	Pontoon P6C Cross Bottom Frame.
Sheet 20	Pontoon P6C Pontoon Frame Assembly Details.
Sheet 21	Pontoon P6C Pontoon Frame Sectional Views.
Sheet 22	Pontoon P6C Pontoon Frame parts Detail.
Sheet 23	Pontoon P6C Angles and Plates.
Sheet 24	Pontoon P6C Plates.
Sheet 25	Pontoon P6C Plates.
Sheet 26	Pontoon P6C Deck Channels.
Sheet 27	Pontoon P6C Angles and Plates.
Sheet 28	Bumper R6 and R7 Assembly Details.
Sheet 29	Bumper R6 and R7 Stiffener Plates.
Sheet 30	Bumper R6 and R7 Plates.
Sheet 31	Bumper R6 and R7 Front Plates.
Sheet 32	Bumper R6 and R7 Rail Connection.
Sheet 33	Bumper R6 and R7 Rocket Plates.
Sheet 34	Bumper R6 and R7 and Assembly Details.

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CIVIL ENGINEERING LABORATORY (CEL)

Drawing NO.	Description
77-17-1F	N.L. Equipment P-Series, P-8 Type pontoons End Connector for Pontoon Causeway - CEL Flexor Head.
77-26-1F	Pontoon Connector-Receiver Assembly.
77-26-2F	Sections.
77-26-3F	Details and Sections.
77-26-4F	Pontoon Plates.
77-26-5F	End Supports and Closures.
77-26-6F	Frames.
77-26-7F	Guillotines and Frame Details.
77-26-8F	Deck Plates.

CIVIL ENGINEER SUPPORT OFFICE (CESO)

Drawing No.	Description
SK 9103	Pad, Lift/Launch, pontoon Causeway Barge.
SK 9114	Flexor Connector Assembly Instructions.

(Copies of specifications, standards, drawings, and publications required by contractors in connection with specific acquisition functions should be obtained from the contracting officer.)

2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless otherwise indicated, the issue in effect on date of invitation for bids or request for proposal shall apply.

AMERICAN NATIONAL STANDARDS INSTITUTE, INC. (ANSI)

A190.1 - Structural Glued Laminated Timber.

(Application for copies should be addressed to the American National Standards Institute, Inc., 1430 Broadway, New York, NY 10018.)

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

- A27 - Mild- to Medium-Strength Carbon-Steel Castings for General Applications.
- A36 - Structural Steel.
- A53 - Pipe, Steel, Black and Hot Dipped, Zinc Coated, Welded and Seamless.
- A148 - High-Strength Steel Castings for Structural Purposes.
- A167 - Stainless and Heat-Resisting Chromium-Nickel Steel Plates, Sheet, and Strip.
- A283 - Low and Intermediate Tensile Strength Carbon Steel Plate or Structural Quality.
- A322 - Hot Worked Alloy Steel Bars.
- A331 - Steel Bars, Alloy, Cold-Finished.

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A570 - Hot-Rolled Carbon Steel, Sheet and Strip, Structural Quality.
A576 - Steel Bars, Carbon, Hot-Rolled, Special Quality.
D2000 - Rubber Products in Automotive Applications.

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19102.)

AMERICAN SOCIETY OF MECHANICAL ENGINEERS (ASME)

Boiler and Pressure Vessel Code, Section IX.

(Application for copies should be addressed to the American Society of Mechanical Engineers, United Engineering Center, 345 East 47th Street, New York, NY 10017.)

AMERICAN WELDING SOCIETY (AWS)

D1.1 - Structural Welding Code.

(Application for copies should be addressed to the American Welding Society, 2501 N.W. 7th Street, Miami, FL 33125.)

NATIONAL HARDWOOD LUMBER ASSOCIATION (NHLA)

Rules for the Measurement and Inspection of Hardwood and Cypress Lumber.

(Application for copies should be addressed to the National Hardwood Lumber Association, 332 South Michigan, Chicago, IL 60606.)

SOCIETY OF AUTOMOTIVE ENGINEERS, INC. (SAE)

SAE Handbook.

(Application for copies should be addressed to the Society of Automotive Engineers, Inc., 400 Commonwealth Drive, Warrendale, PA 15096).

Technical society and technical association specifications and standards are generally available for reference from libraries. They are also distributed among technical groups and using Federal agencies.

3. REQUIREMENTS

3.1 Detail specification. Individual item requirements shall be as specified herein and in accordance with the applicable detail specification. In the event of any conflict between requirements of this specification and the detail specification, the latter shall govern.

3.2 First article. When specified (see 6.2 of applicable detail specification), the contractor shall furnish one complete contract item as a sample for first article inspection and approval (see 4.2.1 and 6.4).

3.3 Drawings. The drawings forming a part of this specification are engineering design drawings. The contractor is responsible for preparing their own shop drawings. Where tolerances prescribed may cumulatively result

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in incorrect fits, the contractor shall provide tolerances within those prescribed on the drawings to insure correct fit, assembly and operation of the items. No deviation from the prescribed dimensions or tolerances is permissible without prior approval of the contracting officer.

3.4 Materials. Materials used shall be free from defects which would adversely affect the performance or maintainability of individual components or of the overall assembly. Materials not specified herein shall be of the same quality used for the intended purpose in commercial practice. Unless otherwise specified herein, all equipment, material, and articles incorporated in the work covered by this specification are to be new and fabricated using materials produced from recovered materials to the maximum extent possible without jeopardizing the intended use. The term "recovered materials" means materials which have been collected or recovered from solid waste and reprocessed to become a source of raw materials, as opposed to virgin raw materials. None of the above shall be interpreted to mean that the use of used or rebuilt products are allowed under this specification unless otherwise specified.

3.4.1 Structural steel. Except where specified herein or in the referenced drawings, steel plates, sheets, shapes, and bars shall conform to ASTM A36, A283 grade D, or A570 grade C, as applicable.

3.4.2 Cast steel. Steel castings shall conform to ASTM A27, grade 70-36.

3.4.3 Steel pipe. Steel pipe shall be welded or seamless, conforming to ASTM A53, grade B, of weight, sizes, and characteristics as specified on the drawings.

3.4.4 Hardwood lumber. Bed timbers shall be commercial hardwood timbers of red or white oak, in accordance with grading rules of NHLA.

3.5 Construction. Items, parts, and assemblies shall be as listed in the detail specification and shall be constructed to the dimensions, tolerances, and strength requirements shown on the applicable drawings and as specified herein.

3.5.1 Fasteners. Bolts, nuts, and washers shall be zinc coated, and of the dimensions, thread characteristics, and quantities indicated on the drawings as specified herein.

3.6 Interchangeability. Pontoon units and all parts and fittings are to be fabricated and assembled so that units of the same type shall be interchangeable. Critical dimensions and tolerances for all pontoons, components, and joining fittings shall be as shown on the applicable drawings, and shall be strictly observed.

3.6.1 Gaging. Mark PG positioning gage, and Mark HSG gage with Mark A-6 (MOD) bolt, and Marks A, B, and C hole spacing gages as shown on drawing 816456, shall be provided by the manufacturer for use in the fabrication of each pontoon and joining angle and final checking by the Government inspector for verification of exact interchangeability features.

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3.7 Performance characteristics. All units, components, and parts shall be subject to examination and testing as specified herein and in the applicable detail specification. All units, components, and parts offered to the Government for delivery shall have successfully passed applicable examinations and tests.

3.8 Cleaning and painting.

3.8.1 Cleaning. All steel surfaces of the fabrications to be painted shall be cleaned by blasting. Blast cleaning shall be to a near white metal blast or cleaner. Near white metal blast is described as a surface with 95 percent of each square inch free of all visible residue with the remaining 5 percent of each square inch having no more than very light shadows or streaks caused by rust stains or mill scale oxides. Blast cleaning shall utilize either dry sand or crushed grit made of cast iron, steel, or synthetic grit. Grit shall be of a maximum particle size no larger than that which is able to pass through a 16 mesh screen.

3.8.2 Epoxy-polyamide painting. Epoxy-polyamide paint shall conform to MIL-P-24441. Formulations of MIL-P-24441 shall be applied only to dry surfaces in an atmosphere having a relative humidity not greater than 80 percent and a temperature of 70 deg Fahrenheit (F) or higher. When ambient atmosphere does not meet these requirements, all painting shall be accomplished in a humidity and temperature controlled environment. There shall be 16 hours of curing between each coat. If more than 7 days elapse between epoxy coats, the surface shall be cleaned with water and detergent, rinsed with fresh water, dried, and then a tack coat (1 to 2 mils wet film thickness) of the last coat applied before application of the next full coat called for. The two components of all the MIL-P-24441 coatings should be mixed in equal volume by first thoroughly stirring each component separately and then stirring the components together. After mixing, there shall be a waiting period of approximately 2 hours at 50 deg to 60 deg F, 1 to 1/2 hours at 60 deg to 70 deg F, and 1/2 to 1 hour above 70 deg F before applying the coating to insure complete curing. If spray or roller painting is utilized, all corners and welds shall first be thoroughly brush coated for each coat of paint. The paint application shall be uniform in thickness and color, smooth in appearance, free of dry over-spray, pinholes, orange peel, sags, or other film defects. Threaded surfaces and gages shall not be painted. All painted areas shall be touched-up where paint is removed as a result of handling or assembly at the manufacturer's plant.

3.8.2.1 Primer and intermediate coat. Primer and intermediate coats shall consist of epoxy-polyamide paint conforming to MIL-P-24441. The primer coat shall be green, formula 150, and shall have a minimum 2.5 mil dry film thickness. The intermediate coat shall be white, formula 152, and shall have a minimum 2.5 mil dry film thickness. Priming of the cleaned surface shall be completed the same day as blast cleaning. Epoxy-polyamide paint shall be applied in accordance with 3.8.2

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3.8.2.2 Finish coat. All metal surfaces to be painted shall be given one finish coat of epoxy-polyamide paint conforming to MIL-P-24441. The finish coat shall be haze gray No. 27, Formula 151, and shall have a minimum 3.0 mil dry film thickness.

3.9 Identification marking. Equipment shall be marked with its noun name, mark number, and NSN as specified (see 6.2 of applicable detail specification). The required marking shall be applied directly to the surface of the item by metal stamp, vibro peening, embossing, forging, casting, or molding. Where these methods are not practicable, the marking shall be applied directly to the item by stencil or on a cloth tag conforming to UU-T-81, type A, with wire. Marking on the tags shall be waterproof. Bolts, nuts, connector plates, or deck closures need not be individually marked. Marking shall be in Gothic type capital letters and Arabic numerals not less than 1-inch high for stenciled information and not less than 3/16-inch high for information on cloth tags.

3.10 Workmanship.

3.10.1 Steel fabrication. Steel used in the fabrication of metal parts shall be free from kinks and sharp bends. Straightening of material shall be done by methods that will not cause injury to the metal. Shearing and chipping shall be done neatly and accurately. Flame cutting, using a tip suitable for the thickness of the metal, may be employed in place of shearing or sawing. Re-entrant cuts shall be made in the best possible manner. All bends of a major character shall be made with controlled means to insure uniformity of size and shape. Precautions shall be taken to avoid overheating and heated metal shall be allowed to cool slowly.

3.10.2 Bolted connections. Bolt holes and alignment holes shall be accurately punched or drilled and shall have the burrs removed. Washers shall be provided and all bolts, nuts, and pins shall fit holes properly and connections shall be tight.

3.10.3 Welding. Manual and machine welding process and material shall conform to AWS D1.1 for the type of welding to be performed. The surface of parts to be welded shall be free from rust, scale, paint, grease, or other foreign matter. Weld penetration shall be such as to provide transference of maximum design stress through the base metal juncture. Fillet welds shall be provided, when necessary, to reduce stress concentration. Spot or tack welds for strength will not be permitted. Welds shall be full and continuous, except that intermittent welds may be used where specified on drawings. Sequence in welding shall minimize the residual stresses in the steel. Faulty weldments shall be corrected by welding only. Peening shall not be used to correct faults or leaks. Particular care shall be exercised on interior welds. Weld spatter shall be removed from mating surfaces.

3.10.3.1 Welder qualification. All welders shall be qualified for the types of welds and for welding positions required for use in the construction and fabrication of each unit, part, and fitting shown on applicable drawings and specified in the detail specification. Qualification shall be on the type of base material and filler utilized in actual construction or on similar

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alternate materials not requiring operator requalification. Welder qualification shall be performed in accordance with the applicable sections of the AWS D1.1. Copies of the qualification record for each qualified welder shall be kept by the manufacturer or contractor and shall be available to authorized Government inspectors.

3.10.4 Machine work. Tolerances and gages for metal fits shall conform to the limitations specified herein and on the applicable drawings. If not specified, the standards of best commercial practice shall be adopted.

3.10.5 Castings and forgings. All castings shall be sound and free from patching, misplaced coring, warping, or any other defect which reduces capability of casting to perform the intended function. Forgings shall be uniform in quality and condition, and shall be free from tears, cracks, seams, laps, internal ruptures, imbedded scale, segregation, or other defects which may detrimentally effect the suitability of forgings for the purpose intended.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by 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.

4.2 Classification of inspections. Inspection requirements specified herein are classified as follows:

- (a) First article inspection (see 4.2.1).
- (b) Quality conformance inspection (see 4.2.2).
- (c) Packaging inspection (see 4.6).

4.2.1 First article inspection. First article inspection shall be performed on one complete unit when a first article sample is required (see 3.2 and 6.2). This inspection shall include the examination and tests as specified herein and in the applicable detail specification.

4.2.2 Quality conformance inspection. Quality conformance inspection shall be performed on the sample units selected in accordance with 4.4. This inspection shall include the examination in 4.5 and as specified, in MIL-P-19380J/1, the hydrostatic tests for pontoons only.

4.3 Inspection lot. Except as specified in MIL-P-19380/1, all units of the same description offered to the Government at one time shall be considered a lot for purposes of inspection.

4.4 Sampling. A random sample of units shall be selected from each lot in accordance with MIL-STD-105.

4.4.1 Sampling for examination. Examination of the units shall be based on inspection level S-3 and an Acceptable Quality Level (AQL) of 2.5 percent.

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4.4.2 Sampling for tests. The only tests required are those for pontoon units in MIL-P-19380/1. Sampling for these tests shall be as specified therein.

4.5 Examination. The first article, when furnished, and each sample selected in accordance with 4.4.1 shall be examined to verify conformance with the requirements of Section 3 of this specification and as specified in the detail specification. Examination shall be conducted as specified in Table I, 4.5.1, and the detail specification.

TABLE I. Classification of defects

Paragraph	Defects
3.4	Material not as specified in 3.4. Material obviously defective or not suited for the purpose.
3.5	Construction, including welding, fabrication, and dimensions not as specified.
3.5.1	Fasteners not zinc coated or of the characteristics, dimensions, and quantities specified on the applicable drawings.
3.6	Units, Fittings, or parts not interchangeable as specified. Critical dimensions not within the tolerances specified on applicable drawings.
3.8 through 3.8.2.2	Cleaning, treating, prime coating, finish coating film thickness, and general paint application not as specified.
3.9	Units, fittings, or parts not marked for identification as specified. Marking missing, illegible or incorrect.
3.10 through	Workmanship does not meet the requirements and standards specified.

4.5.1 Welding examination. Visual inspection of welds and weldments shall be performed utilizing the proper mechanical gages, fixtures, and appropriate weld gages. Applicable sections of the AWS Structural Welding Code shall be followed including, but shall not be limited to, verification of the following:

- (a) Dimensional accuracy of the weldment (including warpage).
- (b) Conformity to drawing requirements. (This involves determination of whether all required welding has been done, and whether finished welds conform with regard to size and contour).
- (c) Acceptability of welds with regard to appearance (including such items as surface roughness, weld spatter, etc.).
- (d) The presence of unfilled craters, pock marks, undercuts, overlaps, and cracks.
- (e) Evidence of mishandling from center punch or other inspection markings or excessive grinding.
- (f) Proper marking of areas requiring weld repair.
- (g) Subsequent inspection of weld repair.

4.6 Packaging inspection. Preservation, packing, and marking of the pontoons, drydock equipment, components, and accessories, shall be inspected to verify conformance to the requirements of Section 5.

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5. PACKAGING

5.1 Preservation. Preservation shall be level A, or commercial, as specified (see 6.2 of applicable detail specification).

5.1.1 Level A

5.1.1.1 Disassembly. Disassembly shall be accomplished to the minimum necessary to safeguard parts known to be subject to damage or loss and to accomplish reduction in cube. Bolts, nuts, and washers removed shall be reinstalled in one of the mating part.

5.1.1.2 Matchmarking. When necessary to facilitate reassembly, removed parts and mating parts shall be matchmarked. Large parts shall be matchmarked identically by stenciled letters or numerals, using lusterless white enamel overcoated with varnish conforming to TT-V-121, or identically matchmarked with paint conforming to MIL-P-13983. Small parts may be matchmarked with cloth shipping tags conforming to UU-T-81, type A. The information on the tags shall be applied with waterproof ink.

5.1.1.3 Preservatives. Preservatives specified herein shall conform to the applicable specifications listed in and shall be applied in accordance with MIL-P-116.

5.1.1.4 Uncoated surfaces. Uncoated exterior exposed ferrous metal surfaces, including threaded surfaces and surfaces exposed by disassembly, shall be coated with type P-1 preservative.

5.1.1.5 Machined surfaces. Exterior ferrous metal machined surfaces of component parts and assemblies shall be coated with type P-11 preservative. Preservative coated surfaces wrapped or covered with barrier material shall conform to MIL-B-121, type I, grade A, class 2, and be secured in place with tape conforming to MIL-T-22085, type II.

5.1.1.6 Fittings, gages, and accessories. Small components of the same description, such as fittings, gages, tools, and accessories requiring unit packaging, shall be packaged in fiberboard, weather-resistant boxes conforming to PPP-B-636. Cushioning, blocking, and bracing shall be provided within the boxes to prevent movement. Boxes shall be closed and sealed as specified for method IV in the appendix to the box specification. Maximum weight of each unit package shall not exceed approximately 30 pounds (lb).

5.1.1.7 Lights. Port, starboard, stern, and bow lights shall be packaged in accordance with MIL-P-116, method III.

5.1.2 Commercial. Pontoons, fittings, accessories, and other components shall be preserved in a manner to insure arrival at the destination in satisfactory condition. Small items requiring use of a unit container shall be packaged in commercial containers. When required, disassembly and matchmarking as specified in 5.1.1.1 and 5.1.1.2 shall apply.

5.2 Packing. Packing shall be level A, B, or commercial as specified (see 6.2 of applicable detail specifications).

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5.2.1 Level A

5.2.1.1 Boxed items. Items such as mast light assemblies, hatchcovers, plates, rings, kingpins, tools, gages, welding jigs, bolts, nuts, washers, pins, and any other small items of a similar nature, which require a container for safe and convenient handling and stowing, shall be packed in close-fitting boxes conforming to PPP-B-621, class 2; or PPP-B-601, overseas type. Contents shall be blocked and braced to prevent movement within the boxes. Only items of the same description shall be packed in the same box.

5.2.1.2 Bundled items. Knocked-down pontoons, launching angles, assembly angles, deck closure assemblies, fenders, and any other large items or assemblies of a similar nature shall be bundled in secure lifts of a weight and size convenient for handling and stowing. In no case shall the weight of a bundle exceed approximately 4,000 lb. Items shall be nested, arranged, and secured with steel strapping or bolts with suitable 2-inch by 4-inch wood blocking and battens, as required to form compact, nonshifting bundles. Strapping shall be 0.035-inch by 1-1/4 inch flat steel conforming to A-A-880. Metal edge protectors shall be used where strapping bears on sharp metal edges. Skids shall be provided on the bottom of the bundle to allow fork lift handling.

5.2.1.3 Loose items. Assembled pontoons and ramps shall be shipped loose as individual items.

5.2.2 Level B. Pontoons, fittings, accessories, tools, and gages shall be packed as specified for level A, except that boxes shall conform to PPP-B-621, class 1; or PPP-B-601, domestic type; and strapping for bundled items shall be either class A or B.

5.2.3 Commercial. Pontoons, fittings, accessories, tools, and gages shall be prepared for shipment in a manner which will insure arrival at destination in satisfactory condition. Containers and packing shall comply with applicable carrier rules and regulations. Assembled pontoons and ramps shall be shipped as loose items.

5.3 Marking. Shipping containers, bundles, and loose items shall be marked in accordance with MIL-STD-129.

6. NOTES

6.1 Intended use. (Use 6.1 of applicable detail specification.)

6.2 Ordering data. (See 6.2 of applicable detail specification.)

6.3 Contract data requirements. When this specification is used in an acquisition which incorporates a DD Form 1423 and invokes the provisions of paragraph 7-104.9(n) of the Defense Acquisition Regulations (DAR), the data requirements will be developed as specified by an approved Data Item Description (DD Form 1664) and delivered in accordance with the Contract Data Requirements List (DD Form 1423) incorporated into the contract. When the provisions of DAR 7-104.9(n) are not invoked, the data shall be delivered in accordance with the contract requirements.

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6.4 First article. When a first article is required, it shall be tested and approved under the appropriate provisions of paragraph 7-104.55 of the DAR. The first article should be a first production item consisting of one complete contract item. The contracting officer should include specific instructions in all acquisition instruments regarding arrangement for examinations, tests, and approval of the first article.

6.5 Clarification of documents. ANSI A190.1 was originally published by the Department of Commerce as Voluntary Product Standard PS 56 and has been accepted by ANSI.

6.6 Detail specifications. The following detail specifications are applicable to this specification and, in combination with this specification, comprise the total revision of MIL-P-19380H.

MIL-P-19380/1 - pontoons, Steel, Sectional, P-Series.

MIL-P-19380/2 - Joining Tools, Fittings, and Gages.

MIL-P-19380/3 - Deck Fittings and Outfitting Accessories.

MIL-P-19380/4 - Drydock Equipment, Miscellaneous Fittings and Accessories.

Custodians:

Army - ME

Navy - YD

Preparing activity:

Navy - YD

Project No. 1945-0018