

CONTINUATION SHEET	Reference No. of Document Being Continued		Page 2 of 4
	PIIN/SIIN W56HZV-13-P-0244	MOD/AMD P00002	
Name of Offeror or Contractor: ALPHA TECHNOLOGIES			

SECTION A - SUPPLEMENTAL INFORMATION

Buyer Name: THOMAS OZARSKI
Buyer Office Symbol/Telephone Number: CCTA-AHR-B/(586)282-3392
Type of Contract: Firm Fixed Price
Kind of Contract: Supply Contracts and Priced Orders
Type of Business: Other Small Business Performing in U.S.
Surveillance Criticality Designator: B

*** End of Narrative A0000 ***

The purpose of this modification P00002 is to incorporate the following:

Reference contract clause 52.210-4502 Heavy Phosphate Coating Requirement. The Modification P00002 is a Unilateral Administrative action.

1. The revised procedure submitted on August 15, 2013 was reviewed as requested and is APPROVED as follows:
 - a. Request submits the MIL-DTL-16232 manganese phosphate coating procedure proposed for use by ALPHA TECHNOLOGIES on contract W56HZV-13-P-0244 with ALPHA TECHNOLOGIES for PN: 11581692 (NSN: 5340-01-531-4477), DOG COUPLER used on the M776 CANNON (M777 LW TH, 155 MM). The procedure was reviewed for a part hardness of Rockwell C 35-40.
 - b. The proposed procedure was reviewed as requested and is approved.
 - c. Process approval does not guarantee compliance with the procedure or acceptance of the actual parts per the Quality Assurance Provision (QAP) in the Technical Data Package (TDP).
2. Point of contact for this review is Engineering Technician, Mr. David R. Presto at (309) 782-8131/email: david.r.presto.civ@mail.mil or the Chemist, Mr. Joseph T. Menke at (309) 782-3065/email: joseph.t.menke.civ@mail.mil.
3. As a result of Modification P00002, the total obligated dollar amount is neither increased nor decreased.
4. Except as written, all other terms and conditions of the contract remain in effect.

*** END OF NARRATIVE A0002 ***

CONTINUATION SHEET

Reference No. of Document Being Continued
 PIIN/SIIN W56HZV-13-P-0244 MOD/AMD P00002

Name of Offeror or Contractor: ALPHA TECHNOLOGIES

ITEM NO	SUPPLIES/SERVICES	QUANTITY	UNIT	UNIT PRICE	AMOUNT																														
0003	<p>SECTION B - SUPPLIES OR SERVICES AND PRICES/COSTS</p> <p><u>DATA ITEM</u></p> <p>NOUN: HEAVY PHOSPHATE COATING PROCEDURE The contractor will prepare and deliver the pre-production phosphate coating procedure to the Contracting Officer for approval no later than 60 das after contract award and before production. (DD Form 1423, Sequence Number A004).</p> <p>(End of narrative B005)</p> <p>Submit the official phosphae coating procedure (electronically) to:</p> <p>Thomas W. Ozarski, Contract Specialist (thomas.w.ozarski.civ@mail.mil) US Army Contracting Command - Warren, CCTA-AHR-B 6501 E. 11 Mile Rd., M/S 509, 2nd Floor Warren, MI</p> <p>Mark E. Otto, Procurement Contracting Officer (PCO) (mark.e.otto.civ@mail.mil)</p> <p>(End of narrative B006)</p> <p><u>Packaging and Marking</u></p> <p><u>Inspection and Acceptance</u> INSPECTION: Destination ACCEPTANCE: Destination</p> <p><u>Deliveries or Performance</u></p> <table border="0"> <tr> <td>DOC</td> <td></td> <td>SUPPL</td> <td></td> <td></td> <td></td> </tr> <tr> <td>REL CD</td> <td>MILSTRIP</td> <td>ADDR</td> <td>SIG CD</td> <td>MARK FOR</td> <td>TP CD</td> </tr> <tr> <td>001</td> <td></td> <td></td> <td></td> <td></td> <td>3</td> </tr> <tr> <td><u>DEL REL CD</u></td> <td><u>QUANTITY</u></td> <td><u>DEL DATE</u></td> <td></td> <td></td> <td></td> </tr> <tr> <td>001</td> <td>1</td> <td>13-AUG-2013</td> <td></td> <td></td> <td></td> </tr> </table> <p>FOB POINT: Destination</p> <p>SHIP TO: (Y00003) SEE NARRATIVE ON DD 1423</p> <p><u>CONTRACT/DELIVERY ORDER NUMBER</u> W56HZV-13-P-0244/0000</p>	DOC		SUPPL				REL CD	MILSTRIP	ADDR	SIG CD	MARK FOR	TP CD	001					3	<u>DEL REL CD</u>	<u>QUANTITY</u>	<u>DEL DATE</u>				001	1	13-AUG-2013				1	EA		
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Name of Offeror or Contractor: ALPHA TECHNOLOGIES

SECTION C - DESCRIPTION/SPECIFICATIONS/WORK STATEMENT

<u>Status</u>	<u>Regulatory Cite</u>	<u>Title</u>	<u>Date</u>
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C-1 CHANGED	52.210-4502	HEAVY PHOSPHATE COATING REQUIREMENT	NOV/2012
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The following requirements regarding heavy phosphate coatings are applicable to this solicitation and any resultant contract in addition to those requirements set forth in specification MIL-DTL-16232G.

a. Paragraph 3.1 of MIL-DTL-16232G refers to "Preproduction Inspection." The procedure shall be submitted IAW the Contract Data Requirements List (CDRL) contained in the contract. The contract number must be cited on all phosphate coating procedures submitted for review and approval. Procedures shall include product name and manufacturer of all chemicals/materials to be used. All processes, equipment, controls along with testing and test frequencies used for phosphating including application of supplemental finishes shall be described in detail.

b. Paragraph 3.2.5-c of MIL-DTL-16232G refers to the "Chromic acid rinse, (Classes 1, 2 and 3)." The final rinse shall be checked by a standard free and total acid titration along with a pH reading "prior to starting production and at least every 8 hours thereafter."

c. Paragraph 4.7.3 of MIL-DTL-16232G refers to "Weight per unit area of phosphate coatings." The frequency for testing coating weight is "per lot, at least every 8 hours."

d. Paragraph 4.7.5 of MIL-DTL-16232G refers to "Accelerated corrosion resistance." Accelerated corrosion resistance shall be determined in accordance with 4.7.5.1. The frequency for testing accelerated corrosion resistance per ASTM B117 is "per lot, at least every 8 hours."

e. The "product name" along with the manufacturer of the supplemental dry film lubricant or CARC paint (primer/topcoat) shall be stated in the procedure and shall be traceable to the applicable Qualified Products List (QPL) or Qualified Products Database (QPD) at Assist Online. QPD products may be obtained at the quick search site, type the specification number (i.e., 3150) in the second block and click the "Submit" button. Then click on the specification (i.e., MIL-PRF-3150). In the next screen, click on the word "Qualification".

To obtain MIL Specs, MIL Standards, QPL and QPD products see <https://assist.daps.dla.mil/quicksearch/>.

To obtain MIL Specs, MIL Standards, QPD products see <https://assist.daps.dla.mil/online/start/>.

f. A thickness range for the supplemental dry film lubricant or CARC paint (primer/topcoat) shall be stated in the procedure along with a frequency for testing. A daily frequency is required.

g. Heat cured dry film lubricant shall be air dried for 1.0 hour (until dry to touch) after dipping/spraying or flash dried at 155-175 degrees F for 10-30 minutes and then heat cured at a temperature of 375-425 degrees F for 55-65 minutes per paragraph 4.3.2.3 of MIL-PRF-46010.

h. Air cure dry film lubricant shall be air dried at room temperature for 24 hours minimum.

i. Adhesion testing shall be stated in the procedure for a supplemental coating of dry film lubricant per ASTM D2510 or CARC paint per ASTM D3359, method B along with the frequency for testing. A daily frequency is required.

j. Salt spray testing of parts with phosphate and supplemental dry film lubricant per ASTM B117 for 100 hours shall be stated in the procedure along with the frequency for testing. The frequency for testing is "per lot or weekly." Parts shall show no more than 3 rust spots per 3" x 6" area with none larger than 1.0mm in diameter. Salt spray testing of parts with phosphate and primer per ASTM B117 for 336 hours shall be included in the procedure for supplemental coatings of CARC paint along with a frequency for testing. The frequency for salt spray testing is "per lot or monthly." Parts shall show no visible rust exceeding rust grade no. 9 per ASTM B610, no more than 5 blisters per 4" x 6" area with none larger than 3/64 inch in diameter. Underfilm attack at the scribe shall not exceed 1/8 inch.

k. Topcoat color shall be visual/equipment checked against the specified chip no. of FED-STD-595 per paint batch. The procedure shall include the specified color chip number.

l. Cure of the paint shall be checked daily by solvent wipe per paragraph 4.2.3.2 of MIL-DTL-53072. The manufacturer of the MEK solvent shall be stated in the procedure.

(End of Clause)