DEPARTMENT OF THE NAVY
NAVAL SEA SYSTEMS COMMAND
WASHINGTON, DC 20362-5101

IN REPLY REFER TO
NAVSEAINST 9100.1A
Ser 05/128
29 April 1987

NAVSEA INSTRUCTION 9100.1A

From: Commander, Naval Sea Systems Command

Subj: STORAGE AND QUALITY CONTROL REQUIREMENTS FOR NAVY STANDARD RESILIENT MOUNTS

Encl: (1) NAVY STANDARD RESILIENT MOUNT LIST

1. Purpose. This is a major revision of NAVSEAINST 9100.1 which:

a. Specifies mount age limits and eliminates the provision of requalification testing as a recourse for salvaging mounts having "mold dates" exceeding seven years prior to the installation or load date.

b. Restates the resilient mount storage requirements and changes the requirements for disposal of overage mounts that fail inspection criteria.

2. Cancellation. NAVSEAINST 9100.1 of 24 May 1977.

3. Scope. This instruction shall be applicable to Government and Commercial activities that procure, store or stock standard Navy resilient mounts for shipboard use.

4. Background. NAVSEAINST 9100.1 eliminated a maximum shelf-life period for Navy standard resilient mounts and substituted a testing requirement for those mounts with "mold dates" greater than seven years prior to shipboard installation. This revision reinstates shelf-life periods and adds inspection, marking, and disposal instructions.

5. Action. The following shall govern resilient mount storage to reduce loss in useful mount life and to assure quality control.

a. Stocking Activities. General requirements for all stocking activities having resilient mounts on hand:

(1) Elimination of Overage Mounts. All Navy standard resilient mounts whose "mold dates" exceed seven years shall be marked, cut, notched, stamped, or otherwise identified and disposed of per existing regulations.

(2) Inventory Control. Ensure that a First-In-First-Out method of inventory control is used so that the oldest mounts are issued prior to those received at later dates except in filling requisitions for new construction ships. For new construction ship requisitions, mounts with the most current "mold dates" shall be issued.

(3) Mount Acceptance Criterion. Assure that the age, measured from the "mold date", of mounts when received from the manufacturer is not in excess of 24 months; if so, they shall not be accepted.

(4) Storage. Mounts shall be covered or otherwise protected from exposure to air, sunlight, fuel, oil, water, dust and ozone (generated by electric arcs, fluorescent lamps and similar electrical equipment). The storage temperature shall not exceed 125°F. The requirements of paragraph 5.b (4) are applicable.

b. Procuring Activities

(1) Age Constraints in Mount Procurement. Procurement of Navy standard resilient mounts shall be per the age requirements of paragraphs 5.a.(1), and 5.c.(2) of this instruction.

(2) Inspection and Receiving Report Requirement. Navy standard mounts are of a critical nature, and are utilized in highly sensitive applications. Therefore, a quality product is of the essence. Accordingly, a copy of Material Inspection and Receiving Report, form DD 250, shall be inserted in each individual mount shipping container by the manufacturer. Shipping containers shall be marked with storage requirements of paragraph 5.a.(4). The form DD 250 will assure the initial receiving station that the mounts were produced in a single production run and that each lot was sampled per the specification requirements. Mounts forwarded from initial receiving stations need not include a form DD 250. For mounts procured and stored under NAVSEAINST 9100.1, the absence of a form DD 250 in each individual mount container shall not be cause for rejection of the mounts.

(3) Mount Stamping Requirements. The procurement document shall assure that the following data, as required by the applicable drawing, will be stamped on the mount:

(a) Rubber Element Manufacturer Code Number.

(b) TYPE number, e.g., 5B5000, 6E100, etc.

(c) Mold Date and Lot Number. The "mold date" is defined as the quarter and year of manufacture. The lot number, when taken together with the type number and the "mold date" designates a specific lot which shall be referred to on the form DD 250. The designation 5B5000 (Type number), 1Q/87/3 (mold date and lot number) indicates a mount from the third lot of

5B5000 mounts manufactured during the first quarter of 1987. The "mold date" shall be indicated by quarter of year and year. The year shall be divided into quarters as follows:

1st quarter - January, February, March
2nd quarter - April, May, June
3rd quarter - July, August, September
4th quarter - October, November, December

Mounts manufactured during any given quarter will not be considered one quarter old until the end of the succeeding quarter.

Examples: A mount molded during January, February or March of any year will not be considered one quarter old until July 1 of that same year. A mount cured during October, November, or December of any year will not be considered one quarter old until April 1 of the following year.

The receiving stations shall accept the form DD 250 in lieu of the Inspector's stamp as assurance that the lot was sampled per the specifications.

(4) Unbonded Spool Type Mounts. For the unbonded spool type mounts, as listed in enclosure (1), the shipping containers for the elastomers shall be marked to show the National Stock No., Contract No., Cure Date and Manufacturer. Because of the difficulty of placing this identifying information on the elastomers, activities storing unbonded spool type mounts shall develop procedures which will keep the identifying information with unbonded spool type mounts. The identifying information shall be forwarded along with the mount to its end-user.

(5) Inspection and Resealing of Packages. Packaging is not violated if the package is opened to inspect the mounts; however, the package shall be resealed to afford maximum protection.

c. Installing Activities

(1) General. Take action per paragraph 5.a (1), 5.a.(3) and 5.a (4).

(2) Avoidance of Installation of Overage Mounts. No mount shall be installed aboard ship whose age at the date of installation or loading exceeds seven years beyond its "mold date". Mounts with the most current "mold date" shall be used for new construction ships and installations with difficult access.

(3) Disposal of Mounts

(a) Overage Mounts. All mounts in stock which are in excess of seven years from their applicable "mold dates" shall be marked, cut, notched, stamped or otherwise identified and disposed of per existing regulations.

(b) Failed Mounts. Mounts that fail inspection criteria shall be marked per paragraphs 5.c.(3)(a) and disposed of following existing regulations.

(4) Verification of Adequate Supply. Verify that the "mold dates" of available mounts are sufficiently recent to ensure an adequate supply of units that meet the requirements specified in paragraph 5.c.(2).

6. Forms. Material Inspection and Receiving Report, form DD 250 is stocked in the Forms and Publications segment of the Navy Supply System and may be requisitioned per NAVSUP Publications 2002 and 437.

M. V. RICKETTS
Deputy Commander for
Ship Design and Engineering

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NAVY STANDARD RESILIENT MOUNTS

MOUNT DESIGNATION	STOCK NO.	PLAN NO.	MILITARY SPECIFICATION NO.
		MACHINERY MOUNTS	
11M15	9Z5340-01-063-8188	1385824	MIL-M-19379
11M25	9Z5340-00-530-8810	1385824	MIL-M-19379
10M50	1H5340-00-687-5684	1385824	MIL-M-19379
6E100	9Z5340-00-543-3574	1385778	MIL-M-17508
6E150	9Z5340-00-543-3575	1385778	MIL-M-17508
7E450	9Z5340-00-664-4473	1385778	MIL-M-17508
7E450BZ	KZ5340-00-663-3276	1385778	MIL-M-17508
6E900	9Z5340-00-598-8824	1385778	MIL-M-17508
6E900BZ	KZ5340-00-663-3275	1385778	MIL-M-17508
6E2000	9Z5340-00-598-8825	1385778	MIL-M-17508
6E2000BZ	KZ5340-00-546-9224	1385778	MIL-M-17508
5E3500	*	1385778	MIL-M-17508
5B5000H	9Z5340-00-543-3867 (6-HOLE)	1385709	MIL-M-19863
5B5000H	9Z5340-00-653-3518 (AUX SNUBBER)	1385709	MIL-M-19863
5B5000H	9Z5340-01-219-7448 (4-HOLE)	1385709	MIL-M-19863
5M10000H	9Z5340-00-064-8269 (COMP)	1385873	MIL-M-21649
5M10000H	9Z5340-00-064-8292 (SHEAR)	1385873	MIL-M-21649
5M10000H	9Z5340-00-064-8291 (SNUBBER)	1385873	MIL-M-21649
5M10000H	9Z5340-00-671-8166 (ASSEMBLY)	1385863	MIL-M-21649
15P50A	9Z5340-00-473-3397	1385777	MIL-M-17191
15P50ABZ	KZ5340-00-558-3115	1385777	MIL-M-17191
15P100A	9Z5340-00-550-2968	1385777	MIL-M-17191
15P100ABZ	KZ5340-00-558-4022	1385777	MIL-M-17191
15P150A	9Z5340-00-550-9525	1385777	MIL-M-17191
15P150ABZ	KZ5340-00-546-9213	1385777	MIL-M-17191
15P220A	9Z5340-00-531-9170	1385777	MIL-M-17191
15P300A	9Z5340-00-473-3400	1385777	MIL-M-17191
15P300ABZ	KZ5340-00-546-9208	1385777	MIL-M-17191
15P400A	9Z5340-00-598-6118	1385777	MIL-M-17191
15P550A	9Z5340-00-550-2969	1385777	MIL-M-17191
15P550B	KZ5340-00-558-4021	1385777	MIL-M-17191
15P700A	9Z5340-00-531-9174	1385777	MIL-M-17191
15P800A	9Z5340-00-531-9171	1385777	MIL-M-17191
15P800B	KZ5340-00-531-9172	1385777	MIL-M-17191
15P1000A	9Z5340-00-531-9173	1385777	MIL-M-17191
15P1000B	KZ5340-00-469-8791	1385777	MIL-M-17191

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MOUNT DESIGNATION	STOCK NO.	PLAN NO.	MILITARY SPECIFICATION NO.
		MACHINERY MOUNTS	
15P1200A	9Z5340-00-473-3402	1385777	MIL-M-17191
15P1200A	KZ5340-00-558-3116	1385777	MIL-M-17191
15P2000A	9Z5340-00-550-9526	1385777	MIL-M-17191
15P2000B	KZ5340-00-558-8817	1385777	MIL-M-17191
		PIPE HANGER MOUNTS	
7M50HT	*		
7M50	1H5340-01-177-8693	5001002	MIL-M-24476
6M150	1H0099-LL-HDA-V537**	5001002	MIL-M-24476
6M450	9Z5340-01-028-6211	5001002	MIL-M-24476
6M900	9Z5340-01-028-7076	5001002	MIL-M-24476
6M2000	9Z5340-01-020-5589	5001002	MIL-M-24476
6M3500	*	5001002	MIL-M-24476
12E50	*		
8E120	*		
8E250	*		
7E450BB	*	1385778	MIL-M-17508
6E100BB	*	1385778	MIL-M-17508
6E150BB	*	1385778	MIL-M-17508
6E900BB	9Z5340-01-020-5071	1385778	MIL-M-17508
UBST1	9Z5340-00-375-6645	2145600	ZZ-R-768
UBST8	9Z5340-00-473-3199	2145600	ZZ-R-768
UBST15	9C3040-00-473-3206	2145600	ZZ-4-768
UBST50	9C3040-00-473-3216	2145600	ZZ-R-768
UBST100	1H3040-00-473-3208	2145600	ZZ-R-768
UBST200	1H3040-00-473-3212	2145600	ZZ-R-768

* Numbers to be assigned later.
** Activity Control number assigned as interim identification.