References:

a) Dwg 1380529, Fin Assy, Conical, MK84  
b) Dwg 923AS900, Fin Assy, Bomb, BSU-33 C/B  
c) Dwg 923AS151, Skin, Segment, Fin, Sheet 1 of 2  
d) Dwg 923AS152, Wedge, Fin

Industry Questions

Question 1: Notes 4 and 6.B on references (a) and (b), respectively, require the application of polyester powder coating as the finish top coat. Is the electrostatic application of MIL-DTL-11195 enamel, the touch-up coating referred to on both references, an acceptable alternative to powder coating?

Government Response:
The fins must be coated with the TGIC polyester powder in accordance with WSD-C-0181. MIL-DTL-11195 should only be used for touch-up.

Question 2: Note 6.A on reference (b) excludes a list of items from the application of a TT-C-490 Zinc Phosphate coating. Not included in this list is Item No. 12, P/N 4902233, Bolt, Socket Head. Should this item, which is cadmium plated, also be excluded per note 6.A?

Government Response:
4902233 Bolt, Socket Head should be excluded from the phosphate note at the assembly level. The bolt restrains the Clamping Ring (4902080, Item 19), which is also excluded via Note 6A. The Government plans to do an ADL exception to include Find No. 12 in list of items exempt from TT-C-490 in note 6A.

Question 3: Note 7 of reference (a) requires that the wedge in reference (d) be installed after application of the paint coating. Would it be allowable to preassemble the wedge to the reference (c) part prior to painting?

Government Response:
Note that this question is referring to the Mk84 assembly (reference (a)), but should be referring to the BSU-33 assembly (reference (b)). The fin assembly must be coated prior to the installation of the wedge in order to reduce the risk of crevice corrosion of the riveted butt joint.
**Question 4:** Reference (c) does not show the three rivet holes needed for assembly of the wedge. Is it permissible to form the 3-rivet hole pattern in the reference (c) part during part fabrication? The pattern would be set to match that shown on reference (b).

**Government Response:**

The holes may be fabricated at the part level as long as the wedge aligns with fin sides as depicted in Detail C on drawing 923AS900. Match drilling is not required.

**Question 5:** Likewise, reference (d) does not show the three rivet holes needed for assembly of the wedge. Is it permissible for these holes to be added during fabrication of the wedge using the same pattern shown on reference (b)?

**Government Response:**

The holes may be fabricated at the part level as long as the wedge aligns with fin sides as depicted in Detail C on drawing 923AS900. Match drilling is not required.

**Question 6:** Reference (c) shows two .31 dia. holes defined in zone C-5 of the drawing. Are these holes required as a functional characteristic of the finished fin assembly or are they for fabrication assistance as an optional feature? These holes are covered up on one side by the wedge as installed on reference (a).

**Government Response:**

The two Ø.31 holes on the fin segments are required.

**Question 7:** Do you have the CAD or 3 dimensional modeling you could share?

**Government Response:**

No, the Government does not have a 3 dimensional model.