

INCH-POUND

MIL-B-3060E(AR)
 AMENDMENT 4
 5 March 1992
 SUPERSEDING
 AMENDMENT 3
 25 March 1991

MILITARY SPECIFICATION

BOXES, SMALL ARMS AMMUNITION: M19A1 AND M2A1

This Amendment forms a part of Military Specification MIL-B-3060E(AR), dated 12 December 1979, and is approved for use by the U.S. Army Armament, Munitions and Chemical Command, and is available for use by all Departments and Agencies of the Department of Defense.

PAGE 1

- * 2.1 STANDARDS, MILITARY, add the following:

"MIL-STD-129 -Marking for Shipment and Storage"

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- 3.6 Delete in its entirety and substitute the following:

"Airtightness of box assembly. The assembled box shall not release more than 4 bubbles of air when subjected to an air pressure differential of three (3) pounds per square inch (psi) when tested in accordance with 4.5.4.1 or 4.5.4.2. When airtightness is tested in accordance with 4.5.4.3, the assembled box shall not release more than 4 cubic centimeters (cc) of air."

- * 3.6 Change "4 cubic centimeters" to ".4 cubic centimeters".

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- 4.5.4 Delete in its entirety and substitute the following:

"Airtightness of box assembly. The container shall be conditioned to a minimum temperature of 50°F and ambient pressure prior to testing. The containers shall be tested in accordance with 4.5.4.1 or with Government approval 4.5.4.2 (see 6.6) or 4.5.4.3 (see 6.7). A wetting agent may be used to minimize air bubbles clinging to the exterior surface."

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4.5.5.1 Vacuum method - Delete in its entirety and substitute the following:

"4.5.4.1 Vacuum method. The assembled container shall be tested for leakage by immersing the closed box, in a vacuum vessel, to a depth of at least one inch below the surface of the water. The air pressure in the vessel shall be lowered to 3 psi below ambient pressure. Observation for leakage of air from the interior of the box assembly shall be made for a minimum of 16 seconds while the 3 psi pressure differential is maintained."

4.5.4.2 Hot water method - Delete in its entirety and substitute the following:

"4.5.4.2 Hot water method. The assembled container shall be tested for leakage by immersing the closed container to a depth of one inch below the surface of the water. The temperature of the water and the length of time of immersion shall be that which will assure an increase in pressure to a minimum of 3 psi above ambient pressure (see 6.6). Observation for air leakage from the interior to the box assembly shall be made during the period of pressure build up and for a minimum of 16 seconds after the 3 psi pressure differential has been reached."

Add the following paragraph:

"4.5.4.3 Dry vacuum method. The assembled container shall be tested for leakage in a dry vacuum chamber by using an Army Peculiar Equipment (APE) 1958 test device or equal (see 6.7). Air leakage will not exceed 4 cubic centimeters for a minimum of 5 seconds."

* 4.5.4.3 Change "4 cubic centimeters" to ".4 cubic centimeters"

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* 5.1 Delete in its entirety and substitute:

"5.1 LEVEL A and B: The boxes with covers attached and the hasps closed shall be packed in shipping cartons as shown on Drawings 7692103 or 7553352, whichever is applicable, and marked as shown on the applicable drawing."

* 5.2 Delete in its entirety and substitute:

"5.2 LEVEL C: The boxes shall be packed using best commercial practices to arrive at the receiving activity in good condition. Packages shall be marked in accordance with MIL-STD-129."

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Add the following paragraph:

"6.6 Hot water method for airtightness. The hot water test procedure for each container shall be submitted to Commander, US Army ARDEC, ATTN: AMSMC-QAF-S (D), Picatinny Arsenal, NJ 07806-5000, for approval. The test procedure shall include water temperature, immersion time, the data to support time and periodic verification procedure."

Add the following paragraph:

"6.7 Dry vacuum method for airtightness. The dry vacuum test procedure shall be submitted to Commander, US Army ARDEC, ATTN: AMSMC-QAF-S (D), Picatinny Arsenal, NJ 07806-5000, for approval. The test procedure shall include periodic verification procedure and test device specification."

Add Appendix A (Pages 18, 19, 20, 21):

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APPENDIX A

QUALITY ASSURANCE PROVISIONS FOR RENOVATION
OF
M2A1 AMMUNITION BOX ASSEMBLY

10. Scope

10.1 Scope. This appendix provides the Quality Assurance Provisions for the renovation of Box, Ammunition, M2A1 Assembly.

20. Applicable documents. This section is not applicable to this appendix.

30. Renovation

30.1 Dents. Dents shall be removed as required to comply with the provisions of 40.1.

30.2 Cleaning. All rust shall be removed and the exterior and interior of the container assembly cleaned.

30.3 Seams. Defective seams shall not be repaired. Container assemblies with this defect shall be rejected and properly disposed of.

30.4 Refinishing. Bare metal shall be primed and the complete exterior of the container assembly repainted. The interior of the body assembly and the inside of the cover assembly may be spot primed and repainted as required.

30.5 Gaskets. The gasket on the cover assembly shall be replaced.

30.6 Marking. The renovated body assembly shall be marked in accordance with Dwg. 7553297.

40. Requirements

40.1 Dents. Dents which do not preclude good stenciling and/or do not affect proper functioning (see 40.6) of the container assembly or hinder proper packing of ammunition shall be acceptable. The container assembly shall not contain any dents greater than 1/4 inch in depth.

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40.2 Cleaning. There shall be no rust present and the interior and exterior of the container assembly shall be free of chips, dirt, grease, rust and foreign matter.

40.3 Refinishing. Bare metal shall be primed and finish coated as specified on the applicable drawings (Dwg. 7553297 and 7553298) and 3.4.1.

40.4 Protective coating.

40.4.1 Paint. See 3.4.1.

40.4.2 Corrosion resistance. See 3.4.2.

40.5 Functioning.

40.5.1 Cover assembly. See 3.5.1.

40.5.2 Hasp and latch. See 3.5.2.

40.5.3 Elevated temperature storage. See 3.5.3.

40.6 Airtightness. See 3.6.

40.7 Workmanship. See 3.9.

50. Inspection.

50.1 Quality conformance inspection.

50.1.1 Inspection lot formation. The term "inspection lot" is defined as a homogeneous collection of renovated container assemblies from which a representative sample is drawn or which is inspected 100 percent to determine conformance with applicable requirements. Units of product selected for inspection shall represent only the inspection lot from which drawn and shall not be construed to represent any prior or subsequent quantities presented for inspection. The inspection lot shall have been produced by one container assembly manufacturer. In addition, the inspection lot shall consist of container assemblies renovated in one unchanged process using the same drawings, revisions, materials and methods. All material submitted for inspection in accordance with this specification shall comply with the homogeneity criteria specified herein, regardless of the type of inspection procedure which is being applied to determine conformance with requirements. Lot numbering, as required, shall be in accordance with MIL-STD-1168.

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50.1.2 Examination. Unless otherwise specified in the Classification of Defects and Test Tables, sampling plans and procedures for major and minor defects shall be in accordance with MIL-STD-105, Inspection Level II, except that inspection for critical defects shall be 100 percent. Continuous sampling plans in accordance with MIL-STD-1235 may be used if approved by the procuring activity.

50.1.2.1 Classification of Defects and Tests.

<u>Catagory</u>	<u>Examination or Test</u>	<u>No. Sampling Units</u>	<u>AQL/100%</u>	<u>Req. para.</u>	<u>Para. Inspection Method</u>
101.	Airtightness		100%	3.6	4.5.4
102.	Seam weld cracked		100%	3.3	Visual
103.	Paint thickness	3	ACC-0 REJ-1	40.4.1	4.5.1
104.	Paint adhesion	3	ACC-0 REJ-1	40.4.1	4.5.1
105.	Corrosion resistance	3	ACC-0 REJ-1	40.4.2	4.5.2
106.	Functioning - cover assembly	13	ACC-0 REJ-1	40.5.1	4.5.3
107.	Functioning - hasp and latch	13	ACC-0 REJ-1	40.5.2	4.5.3
108.	Functioning - elevated temperature storage	13	ACC-0 REJ-1	40.5.3	4.5.3
109.	Gasket compression		1.0 <u>1/</u>	3.3	4.5.6
110.	Dents affecting stenciling, functioning or packing of ammunition or dents greater than 1/4"		0.65	40.1	Visual/ SMTE
111.	Cleaning improper prior to priming and painting		0.65	40.2	Visual
112.	Gasket not replaced properly		0.65	3.3	Visual
113.	Bare metal not primed prior to painting		0.65	40.3	Visual
114.	Paint improper		0.65	3.4.1	Visual
115.	One or more spot or projection welds broken on cover assembly or body assembly		0.65	3.3	Visual

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MINOR

201. Marking on body assembly missing, incomplete or illegible	1.00	3.3	Visual
202. Evidence of poor workmanship	1.00	3.9	Visual

Note: 1/ MIL-STD-414, Section C, Table C-3 and Code Letter F.

60. Packaging.

60.1 The renovated container assemblies shall be packaged in accordance with dwg. 7553352 or procedures approved by the Government for packaging and palletization.

70. Notes.

70.1 Submission of renovation, inspection and packaging and palletization procedures. The procedures for the renovation, inspection, and packaging and palletization of the M2A1 Ammunition Box Assembly shall be submitted for approval to: Commander, ARDEC, ATTN: AMSMC-QAF-S (D), Picatinny Arsenal, NJ 07806-5000.

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The margins of this amendment are marked with an asterisk to indicate where changes (additions, modifications, corrections, deletions) from the previous amendment were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous amendment.

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