

MIL-B-63992A (AR)

2 December 1983

SUPERSEDING

MIL-B-63992 (AR)

8 March 1982

MILITARY SPECIFICATION

BANDOLEER, 200 ROUND MAGAZINE
(M249 M.G.)

This specification is approved for use by the US Army Armament, Munitions and Chemical Command and is available for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification covers one type of bandoleer for use with 200 round, 5.56mm, ammunition magazine for the M249 machine gun.

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications, standards, and handbooks. Unless otherwise specified (See 6.2) the following specifications and standards of the issue listed in that issue of the Departments of Defense Index of Specifications and Standards (DoDISS) specified in the solicitation, form a part of this specification to the extent specified herein.

SPECIFICATIONS

MILITARY

MIL-A-48078 - Ammunition, Standard Quality Assurance Provisions, General Specification For

STANDARDS

MILITARY

MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes

FSC 1305

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Commander, US Army Armament Research and Development Center, Attn. DRSMC-QA, Dover, New Jersey 07801 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-STD-1169 - Packaging, Packing and Marking for Shipment for Inert Ammunition Components

2.1.2 Other Government documents, drawings, and publications. The following other Government documents, drawings, and publications form a part of this specification to the extent specified herein.

DRAWINGS

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER (ARDC)

9349295 - Bandoleer, 200 Round Magazine (M249 M.G.)
9349296 - Magazine, Ammunition

(Copies of specifications, standards, handbooks, drawings, and publications required by manufacturers in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting officer.)

2.1.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein, the text of this specification shall take precedence.

3. REQUIREMENTS

3.1 Material. Materials shall be in accordance with the applicable drawings and specifications.

3.2 Bandoleer. The bandoleer shall comply with all requirements specified herein, on drawing 9349295, all associated drawings, and with the applicable documents specified herein.

3.3 Assembleability. The ammunition magazine shall be capable of being inserted into and removed from the bandoleer without effort other than that necessary to overcome friction between the magazine and bandoleer. Tearing of the hood, body or strap is not permitted.

3.4 Strength of material. The bandoleer loaded with a weight of 7 pounds plus or minus 2 ounces shall not show any ripping of stitches or material when subjected to a 12 inch drop test as specified in 4.5.3.

3.5 First article submission. This specification contains technical provisions for first article inspection. Requirements for the submission of first article samples by the contractor shall be as specified in the contract.

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3.6 Workmanship. The bandoleer shall be uniform in appearance and free of defects affecting serviceability.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection and standard quality assurance provisions. Unless otherwise specified herein or in the contract, the provisions of MIL-A-48078 shall apply and are hereby made a part of this detail specification.

4.2 Classification of inspections. The following types of inspection shall be conducted on this item:

- a. First Article Inspection
- b. Quality Conformance Inspection

4.3 First article inspection.

4.3.1 Submission. The contractor shall submit a first article as designated by the Contracting Officer for evaluation in accordance with the provisions of 4.3.2. The first article sample shall consist of the following items in the sample quantities as indicated.

<u>Part Description</u>	<u>Drawing</u>	<u>Quantity</u>
Bandoleer	9349295	50

4.3.2 Inspections to be performed. See MIL-A-48078 and Table I specified herein.

4.3.3 Rejection. See MIL-A-48078.

TABLE I. FIRST ARTICLE INSPECTION

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CLASSIFICATION OF DEFECTS & TESTS

PARAGRAPH	TITLE	SHEET 1 OF 1			DRAWING NUMBER
	Bandoleer				9349295
					NEXT HIGHER ASSEMBLY
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE /INSPECTION METHOD
<u>Critical</u>	None defined				
<u>Major</u>					
101.	Assembleability	50	100%	3.3	4.5.2
102.	Improper stitching	50	100%	3.2	Visual - 4.5.1
103.	Presence of rips and/or tears	50	100%	3.2	Visual
104.	Missing bar tack	50	100%	3.2	Visual
105.	Height of bandoleer, min (2 places) <u>1/</u>	50	100%	3.2	Measure (SME) - 4.5.1
106.	Width of bandoleer, min <u>1/</u>	50	100%	3.2	Measure (SME) - 4.5.1
107.	Depth of bandoleer, min (2 places) <u>1/</u>	50	100%	3.2	Measure (SME) - 4.5.1
108.	Drop test	50	100%	3.4	4.5.3
<u>Minor</u>					
201.	Twisted strap	50	100%	3.2	Visual
202.	Marking illegible	50	100%	3.2	Visual
203.	Excessive bar tack	50	100%	3.2	Visual
204.	Height of bandoleer, max (2 places) <u>1/</u>	50	100%	3.2	Measure (SME) - 4.5.1
205.	Width of bandoller, max	50	100%	3.2	Measure (SME) - 4.5.1
206.	Depth of bandoleer, max (2 places) <u>1/</u>	50	100%	3.2	Measure (SME) - 4.5.1
207.	Evidence of poor workmanship	50	100%	3.6	Visual
NOTE:	<u>1/</u> Dimensions to be checked after assembly of strap.				

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4.4 Quality conformance inspection.

4.4.1 Inspection lot formation. Inspection lots shall comply with the first formation provisions of MIL-A-48078.

4.4.2 Examination. See MIL-A-48078.

a. Sampling plans. Unless otherwise specified in 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.

TABLE II. QUALITY CONFORMANCE INSPECTION

CLASSIFICATION OF DEFECTS & TESTS

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PARAGRAPH	TITLE	SHEET 1 OF 1			DRAWING NUMBER
4.4.2.1	Bandoleer				9349295
					NEXT HIGHER ASSEMBLY
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
<u>Critical</u>	None defined				
<u>Major</u>					
101.	Assembleability		.40	3.3	4.5.2, Manual
102.	Improper stitching		.40	3.2	Visual - 4.5.1
103.	Presence of rips and/or tears		.40	3.2	Visual
104.	Missing bar tacks		.40	3.2	Visual
105.	Height of bandoleer, min (2 places) <u>1/</u>		.40	3.2	Measure (SME) - 4.5.1
106.	Width of bandoleer, min <u>1/</u>		.40	3.2	Measure (SME) - 4.5.1
107.	Depth of bandoleer, min (2 places) <u>1/</u>		.40	3.2	Measure (SME) - 4.5.1
108.	Drop test	50 50	0-3 3-4	3.4	4.5.3
<u>Minor</u>					
201.	Twisted strap		.65	3.2	Visual
202.	Marking illegible		.65	3.2	Visual
203.	Excessive bar tack		.65	3.2	Visual
204.	Height of bandoleer, max (2 places) <u>1/</u>		.65	3.2	Measure (SME) - 4.5.1
205.	Width of bandoleer, max		.65	3.2	Measure (SME) - 4.5.1
206.	Depth of bandoleer, max (2 places) <u>1/</u>		.65	3.2	Measure (SME) - 4.5.1
207.	Evidence of poor workmanship		.65	3.6	Visual
NOTES:					
<u>1/</u> Dimensions to be checked after assembly of strap.					

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4.4.3 Testing.

4.4.3.1 Assembleability. Sample bandoleers shall be tested for assembleability using a 200 round ammunition magazine as specified in the contract or a Government approved facsimile. Should the sample fail to meet the acceptance criteria as specified, the lot shall be rejected.

4.4.3.2 Drop test. A sample of 50 bandoleers shall be subjected to the drop test. If three or more bandoleers fail to comply with the requirements of 3.4 the lot shall be rejected. If one or two bandoleers fail to comply with the requirements, a second sample consisting of the same number of units as specified in the first sample shall be tested. If in the accumulated sample four or more units fail to comply with the requirements, the lot shall be rejected.

4.5 Methods of inspection.

4.5.1 Visual examinations. The sample bandoleers shall be examined for the specified defects from the outside and then turned inside out for further examination. Failure of the samples to meet the acceptance criteria shall result in the rejection of the lot.

4.5.2 Assembleability test. The sample bandoleers, after passing visual inspection, shall be assembled to the specified ammunition magazine or the Government approved facsimile. The hood shall be pulled over the top of the container. The bandoleers shall then be disassembled and visually examined for tears. Additionally a defect shall be scored if, upon inserting or removing the ammunition magazine from the bandoleer, effort, other than overcoming friction, is expended.

4.5.3 Drop test. The bandoleer shall be filled with 7 pounds of weight (+ 2 ounces) approximating the shape of a loaded ammunition container. The filled bandoleer shall then be suspended by the strap with the weight evenly distributed from a rigid horizontal bar of approximately 1/2 inch in diameter. The strap, at the point of suspension, shall then be raised vertically one foot and dropped upon the bar. Bandoleers shall then be visually examined for ripping.

5. PACKAGING

5.1 Packaging, packing and marking. Packaging, packing and marking shall be Level A waterproof or Level B waterproof per MIL-STD-1169 or as specified in the contract.

6. NOTES

6.1 Intended use. The bandoleer governed by this specification is intended for use with the 200 round, 5.56mm, ammunition magazines (dwg. 9349296).

6.2 Ordering data. See MIL-A-48078.

6.3 Drawings. Drawings listed in Section 2 of this specification under the heading US Army Armament Research and Development Center (ARDC) may also include drawings prepared by, and/or identified as Edgewood Arsenal, Frankford Arsenal, Rock Island Arsenal, Picatinny Arsenal or US Army Armament Research and Development Command (ARRADCOM) drawings. Technical data originally prepared by these activities are now under the cognizance of ARDC.

6.4 Changes from previous issue. Asteristics are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.

Custodian:
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Preparing activity:
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