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6 June 1974
SUPERSEDING
MIL-C-0010464D (MU)
28 March 1973 AND
MIL-C-10464C
7 August 1968

MILITARY SPECIFICATION

CANS, HERMETIC SEALING, METAL, LIGHT GAGE, TEAR-STRIP TYPE

This specification is approved for use by all Departments and Agencies of the Department of Defense.

1. SCOPE AND CLASSIFICATION

1.1 Scope. This specification covers two types of integral tear strip, hermetically sealed, light gage metal cans for packing of ammunition and pyrotechnics items.

1.2 Classification. Metal cans shall be of the following types as specified (see 6.2):

Type I - Round
Type II - Rectangular

* 2. APPLICABLE DOCUMENTS

2.1 The following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of this specification to the extent specified herein.

SPECIFICATIONS

Federal

QQ-P-416	Plating, Cadmium (Electrodeposited)
QQ-S-571	Solder; Tin Alloy; Lead-Tin Alloy; and Lead Alloy
QQ-T-425	Tinplate (Hot Dip and Electrolytic)
QQ-W-461	Wire, Steel, Carbon, (Round, Bare and Coated)
QQ-Z-325	Zinc Coating, Electrodeposited, Requirements for

FSC: 8140

TT-E-516 Enamel, Lusterless, Quick Drying Styrenated Alkyd Type

PPP-B-636 Box, Fiberboard

Military

MIL-A-2550 - Ammunition, General Specification for

MIL-P-11414 - Primer Coating, Lacquer, Rust Inhibiting

MIL-F-14256 - Flux, Soldering, Liquid (Rosin-Base)

MIL-P-19602 - Primer, Size Coating, Baking for Roller Coat Application

MIL-E-19603 - Enamel, Baking for Roller Coat Application

STANDARDS

Federal

FED-STD-141 Paint, Varnish, Lacquer, and Related Materials; Methods of Inspection, Sampling and Testing

Military

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

MIL-STD-109 - Quality Assurance Terms and Definitions

MIL-STD-129 - Marking for Shipment and Storage

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

3. REQUIREMENTS

3.1 First article inspection. This specification makes provisions for first article inspection. Requirements for the submission of first article samples by the contractor shall be as specified in the contract. Unless otherwise specified in the contract or order, the can body and ends submitted for first article inspection shall be subjected to the salt spray test for 168 hours (see 6.2).

3.2 Material

3.2.1 Materials and parts shall be in accordance with applicable drawings and specifications. When drawings are not available, dimensions shall be furnished as directed by the contract or purchase order in accordance with Figure 1 (see 6.2).

3.2.2 Lining compound. The lining compound shall be the type which provides an air-tight seal for dry pack contents. The compound shall provide a seal which meets the air pressure test requirements of 3.8. The compound shall be uniformly applied to all sealing surfaces of the ends.

3.2.3 Soldering. The solder metal used to fabricate containers under this specification shall conform to the Sn compositions of QQ-S-571. With the approval of the procuring activity, other solder metal may be used.

3.2.3.1 Soldering flux. The flux used for soldering shall conform to MIL-F-14256, Type W. If other fluxes are needed to be compatible with the manufacturing process they may be used, with approval of the procuring activity.

3.3 Body and ends. Body and ends shall be fabricated from electrolytic tinplate conforming to QQ-T-425, Class 100 or better. Can ends shall be fabricated from the same gage as the bodies to which they are to be attached. Both ends of the body shall be flanged for double seaming ends. Unless otherwise specified, beads are acceptable provided the beading does not interfere with the attachment of the key (see 6.2).

3.4 Interior supports. Interior supports shall be made, coated, if required, and inserted as specified on the applicable drawings.

3.5 Key. Unless a commercial type key is specified in the contract or order (see 6.2) the key shall be

manufactured from steel wire approximately 0.1055 to 0.135 inch in diameter. Fabrication shall be such that the key can be easily removed from the can by hand and will satisfactorily remove the tear strip from the can when operated by hand. The overall length of the head of the key shall be 1-1/4 inches minimum for cans having an inside diameter of 2.5 inches and larger. The overall length of the head of the key shall be 7/8 inch minimum for cans having an outside diameter less than 2.5 inches. The key shall be constructed in a manner which will allow not more than 90-degree twist in the shank of any key. The key shall be fabricated so that a minimum spacing of 1/16 inch is maintained between the can, after seaming of end, and the head of the key when key is in position on tongue of tear strip. The key shall be coated in accordance with Type I, Class 2 of QQ-Z-325 or Type II, Class 2 of QQ-P-416 before or after forming. Alternatively, when specified, the key may be coated with a corrosion resistant coating.

3.6 Handles (applicable to Type II only). Unless otherwise specified, handles shall be fabricated from galvanized wire conforming to Grade 1020, Finish 5, Class 1, Medium temper of QQ-W-461.

3.7 Cleat (applicable to Type II only). Each cleat shall be fabricated as shown on applicable drawings.

3.8 Air pressure. Each can body, with the key end seamed in place by the can manufacturer shall be capable of withstanding a minimum internal air pressure of 3 pounds per square inch in excess of outside pressure for a minimum of 15 seconds or an equivalent test which will assure that no leakage will occur (see 4.4.1).

3.9 Tear Strip. The body shall be provided with a tear strip formed by two or more scores on the inside surface of the can. A herring bone score pattern may be added between scores to assure complete removal of tear strip (see 6.2) The tongue of the tear strip shall be tapered and centered between the score lines and shall be free of solder for a minimum length of 5/16 inch to permit free entrance into the key and a firm hold. The minimum depth of the score shall be such that when the strip is tested in accordance with 4.4.2, it shall tear evenly and straight and shall leave no jagged edges on the body. When the welded body seam passes across the tear strip it shall be made so as to permit clean removal of the tear strip.

3.10 Seams. Side seams shall be either soldered or welded. The ends shall be attached by means of a double seam with minimum overlaps as shown on Figure 3. Can

end opposite that shown on drawing with flange extended shall be seamed in place by the can manufacturer.

3.10.1 Soldered. The body shall be lock-seamed the entire length, except for a lap seam at each end to facilitate flanging and removal of the tear strip when tested as specified in 4.4.3. Lap seam at tear strip end shall be continuous from body end through tear strip as indicated on Figure 2, or alternatively may include a segment of lock seam between tear strip and end of body. Also, lap seam may be located only at extreme end of body, utilizing a lock seam through tear strip provided that end of tear strip opposite tongue is slit completely through metal sheet at location of score lines for distance of approximately 1/8 inch from end of width to hook of seam to facilitate final break of tear strip upon removal. The lock and lap seams shall be soldered the entire length, internally or externally (see 3.2.3) and Figure 2).

3.10.2 Welded. The body shall be seamed the entire length by overlapping the body blank edges and applying a continuous electrical resistance seam weld. Alternatively, there may be a skip in the weld at the tear strip and the seam completed by soldering in accordance with 3.10.1. The welded seam shall be capable of bending without breakage when tested as specified in 4.4.7.

3.10.3 End seams. Both ends of can shall be seamed in place as depicted in figure 3.

3.11 Attachment of key

3.11.1 Type I container. The key shall be attached to one end of the can by soldering or welding in a manner which insures easy removal by hand when tested as specified in 4.4.4. Unless otherwise specified, the key shall be attached to the end of the can which is seamed in place by the can manufacturer.

3.11.2 Type II container. The key shall be attached as specified in paragraph 3.11.1 unless otherwise specified on the applicable drawing.

3.12 Attachment of handle and handle cleat (applicable to Type II only). The handle shall be inserted in the handle cleat and then the handle cleat attached to the can by projection welding in a location as shown on the applicable drawing and tested as specified in 4.4.5.

3.13 Coating. The exterior of the cans, excluding side seam and key soldering or welding area, shall be completely roller coated using a primer in accordance with MIL-P-19602 and Class 2 enamel of MIL-E-19603. The color of the coating shall be black unless otherwise specified (see 6.2). Alternatively the cans may be coated with an enamel complying with TT-E-516. A primer in accordance with MIL-P-11414 may be used prior to the application of the enamel if required for compliance with the salt spray test. After the can has been fabricated, the side seam and key soldering or welding areas shall be coated by the can manufacturer with an enamel or lacquer of the same color and gloss specified for the can.

3.14 Salt spray

3.14.1 First article sample. The coated cans shall show no rust on the exterior painted areas or show any substantial loss of adhesion or removal of the film under the following conditions.

3.14.1.1 Body and ends. Expose to a 168 hour salt spray as specified in 4.4.6.1, except that bare key attachment areas shall be exposed for 48 hours.

3.14.1.2 Side seam area. Expose bare area to a 48 hour salt spray as specified in 4.4.6.1.

3.14.1.3 Key. The bare key shall withstand a 48 hour salt spray test when tested in accordance with 4.4.6.1.

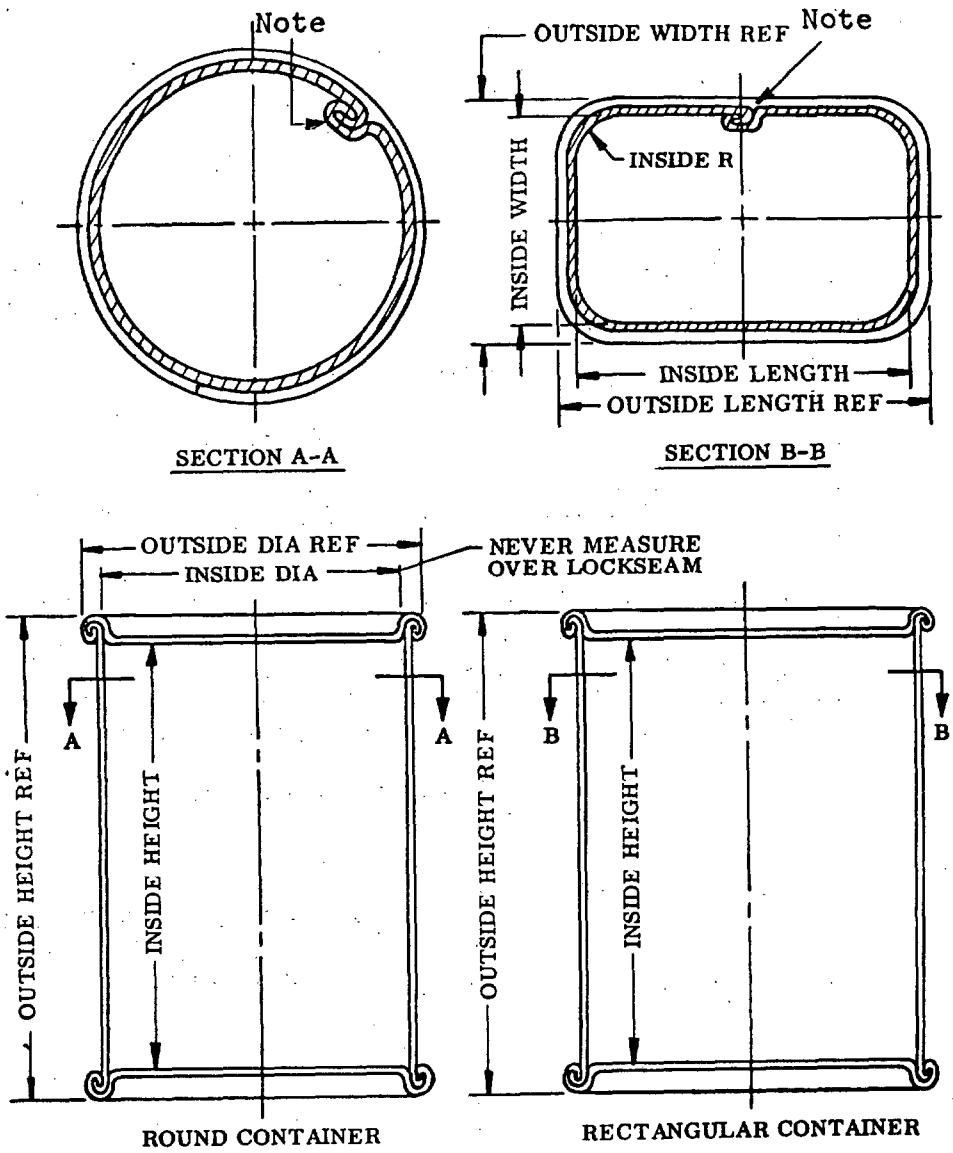
3.14.2 Production lots. Unless otherwise specified the metal shall not rust on the exterior painted areas or show any substantial loss of adhesion or removal of the film when exposed to a 24 hour salt spray as specified in 4.4.6.2.

3.15 Can labeling. When lithographing with ink or silk screening with enamel is specified on the drawing, the marking shall be with white letters and figures on a black background (see 6.2)

3.16 Manufacturer's marking. Unless otherwise specified, the can manufacturer's name, initials, or symbol shall be embossed, stamped, or permanently marked on the end of the can which is seamed in place by the can manufacturer (see 6.2)

3.17 Workmanship. All parts and assemblies shall be fabricated in a thorough workmanlike manner. They shall be free of burrs, chips, sharp edges, surface defects, dirt, grease, rust, corrosion products and other foreign matter. The cleaning method used shall not be injurious to any part nor shall the parts be contaminated by the cleaning agent.

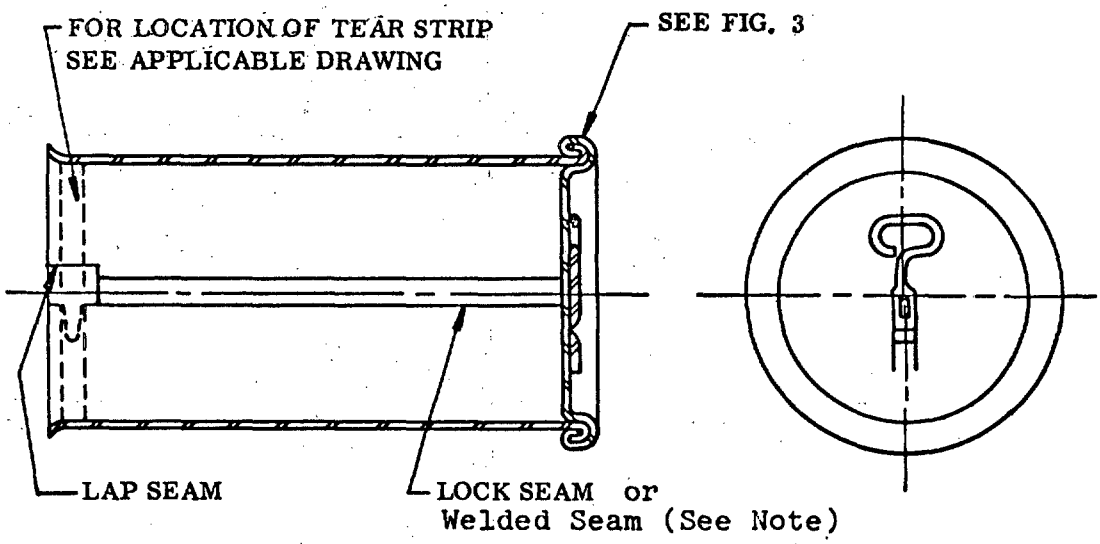
INFORMATION TO BE INCLUDED IN PROCUREMENT DOCUMENTS
WHEN DRAWING OF CONTAINER IS NOT AVAILABLE



OTHER REQUIREMENTS
VOLUME, TYPE AND GAGE,
MATERIAL AND COATING

FIGURE 1

Note: Simple Overlap Replaces Lock Seam When Welding Construction Is Used.



TYPICAL ASSEMBLY, TYPE I

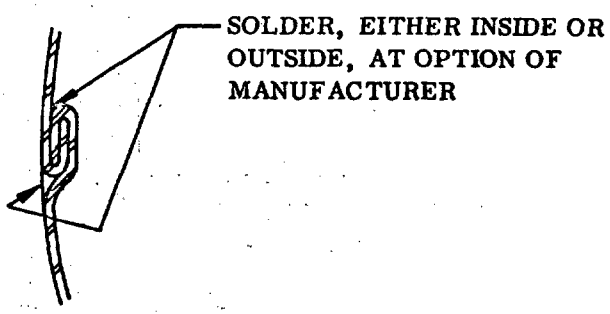
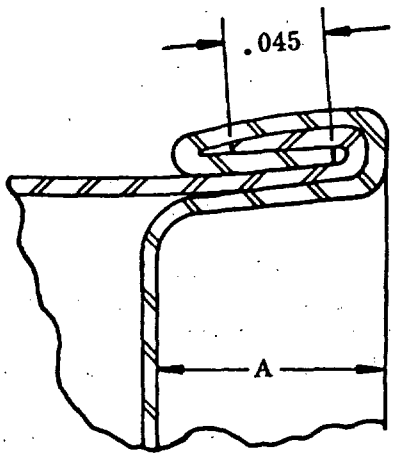


FIGURE 2. TYPICAL LOCK SEAM

Note: Simple Overlap Replaces Lock Seam When Welding Construction Is Used.



MINIMUM OVERLAP DIMENSION OF DOUBLE SEAM. TO BE OBTAINED WITH 1/8 INCH NOMINAL PANEL DEPTH (A) OR GREATER.

FIGURE 3. DOUBLE SEAM REQUIREMENTS

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements, as specified herein. Except as otherwise specified in the contract or order, the supplier may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements. Reference shall be made to Standard MIL-STD-109 in order to define terms used herein. The provisions of Specification MIL-A-2550 shall apply.

4.1.1 Submission of product. At the time each completed lot of items deliverable under the contract is submitted to the Government for acceptance, the contractor shall supply the following information accompanied by a certificate which attests that the information provided is correct and applicable to the product being submitted:

a. A statement that the lot complies with all of the quality assurance provisions specified in this specification.
b. Drawing and specification number and date, together with identification and date of changes thereto.
c. A statement that all material purchased by the contractor meets requirements, when such material is controlled by Government or commercial specifications referenced in any of the contractual documents, and that certificates of conformance are on file and available for review.
d. Number of items in the lot.
e. Date submitted.

The certificate shall be signed by a responsible agent of the certifying organization. The initial certificate submitted shall be substantiated by evidence of the agent's authority to bind his prinicpal. Substantiation of the agent's authority will not be required with subsequent certificates unless, during the course of the contract, this authority is vested in another agent of the certifying organization.

4.2 First article inspection

4.2.1 Submission. Prior to initiation of regular production, the contractor shall submit a first article sample as designated by the contracting officer (see 6.2) for evaluation in accordance with the provisions of 4.2.2. The sample shall consist of 25 assemblies with the closure end unassembled and 25 sets of parts which have been produced by the contractor or furnished by a supplier, and which have been manufactured using the same production processes, procedures and equipment which will be used in fulfilling the contract. All parts and materials shall be obtained from the same source of supply as will be used in regular production. Prior to submission, the contractor shall inspect the sample to the degree necessary to assure that it conforms to the requirements of the contract and submit a record of this inspection with the sample, including statements of findings for materials, processes and tests. A sample containing known defects will not be submitted unless specifically authorized by the contracting officer. A first article sample, or portion thereof, as directed by the contracting officer, shall also be submitted whenever there is a lapse in production for a period in excess of 90 days or whenever a change occurs in manufacturing process, material used, drawing or specification such as to significantly affect product uniformity as determined by the Government.

4.2.2 Inspection to be performed. Assemblies and components will be subjected by the Government to any or all of the examinations or tests specified in 4.3 and 4.4 of this specification and any or all requirements of the applicable drawings.

4.2.3 Rejection. If any assembly or component fails to comply with any of the applicable requirements, the first article sample shall be rejected. The Government reserves the right to terminate its inspection upon any failure of an assembly or component to comply with any of the stated requirements.

4.3 Inspection provisions

4.3.1 Lot formation. The term "inspection lot" as used in this specification is defined as essentially homogeneous collection of units of product from which a representative sample is drawn and inspected to determine conformance with applicable requirements.

The sample selected shall represent only that quantity of units from which the sample was drawn and shall not be construed to represent any prior or subsequent quantities presented for inspection. Homogeneity shall be considered to exist provided the inspection lot has been produced by one manufacturer in one unchanged process, in accordance with the same drawing, same drawing revision, same specification and same specification revision and complies with the provisions for submission of product as specified in MIL-STD-105. Changes to the process, specification, or drawing not affecting safety, performance, interchangeability, or storage, as determined by the Government, shall not be deemed to alter the homogeneity of an inspection lot. All material submitted for inspection in accordance with this specification shall comply with the homogeneity criteria specified herein regardless of the type of sampling procedure which is being applied to determine conformance with requirements.

4.3.2 Sampling for inspection. Sampling for inspection shall be performed in accordance with the provisions set forth in MIL-STD-105, except where otherwise indicated. For purposes of sampling, an inspection lot shall consist of all cans of the same type made by the same process from the same components by one manufacturer and submitted for acceptance and delivery at one time.

4.3.2.1 Component and material inspection. In accordance with 4.1 above, the supplier is responsible for insuring that materials and components used were manufactured, tested and inspected in accordance with the requirements of referenced subsidiary specifications and standards to the extent specified, or, if none, in accordance with this specification. In the event of conflict, this specification shall govern.

TABLE I

CLASSIFICATION OF DEFECTS

Category	Defect	Method Inspection	Code No. (see 6.4)
Salt spray (see 4.3.4.2)	Major	Test	01001
Air Pressure (see 4.3.4.2)	Major	Test (CD)	01002

Dimension incorrect (4.3.3.1.3)	Major	Gage (CD)	01003
Tear Strip (see 4.3.3.1.1, 4.3.4.2)	Major	Manual	01004
End Seams (see 4.3.3.1.1)	Major	Gage (CD)	01005
Coating (see 4.3.3.1.1, 4.3.3.1.2)	Minor	Gage (CD)	01006
Soldering (see 4.3.3.1.1)	Minor	Manual/ Visual	01007
Welding (see 4.3.4.2)	Minor	Manual/ Visual	01008
Appearance (see 4.3.3.1.1, 4.3.3.1.2)	Minor	Visual	01009
Lining compound (see 4.3.3.1.2)	Minor	Visual	01010
Component (see 4.3.3.1.1)	Minor	Visual	01011
Workmanship (see 4.3.3.1.1, 4.3.3.1.4)	Minor	Visual	01012
Marking (see 4.3.3.1.4)	Minor	Visual	01013
Material (see 4.3.3.1.4)	Minor	Visual	01014
Content (see 4.3.3.1.4)	Minor	Visual	01015

4.3.3 Inspection

4.3.3.1 Examination of cans and ends. The cans and unassembled ends shall be examined in accordance with the classification of defects, inspection levels and acceptable quality levels (AQL's) set forth below. The inspection levels for determining the sample size and acceptable quality levels expressed in defects per 100 units shall be as shown in Table II. The lot size, for purposes of determining the sample size in accordance with MIL-STD-105 shall be expressed in units of cans for examinations under 4.3.3.1.1 to 4.3.3.1.3 inclusive, and in units of shipping containers for examination under 4.3.3.1.4.

4.3.3.1.1 Examination for defects of assembly with one end open.

EXAMINE	DEFECT
Appearance	Distortion
	Foreign matter present
Coating	Damaged in excess of 1/4 inch square, cumulative.
	Not dry.
	Color incorrect
	Excessive gloss
Soldering	Loose, spattered, or excessive
Tear Strip	Tear strip fails to enter key
Component	Key missing
	Tear strip missing
	Component missing or incorrectly positioned, when applicable
	Flange missing or incorrect
Workmanship	Not in accordance with the best commercial practice of industry (3.17)

4.3.3.1.2 Examination for defects of unassembled end.

EXAMINE	DEFECT
Lining compound	Any circumferential discontinuity
Appearance	Distortion
	Curl incorrect or missing
	Foreign matter present
Coating	Damaged in excess of 1/4 inch square, cumulative.
	Not dry
	Color incorrect

4.3.3.1.3 Examination for dimensional defects. The sample unit for this examination shall be one can (one assembly with closure end unassembled).

EXAMINE	DEFECT
All components	Any dimension not within tolerances specified

4.3.3.1.4 Examination for defects in packaging, packing, and marking. An examination shall be made to determine that packaging, packing and markings as required by Section 5 of this specification are complied with.

EXAMINE	DEFECT
Marking	Missing, incorrect, incomplete, illegible; of improper size location, sequence, or method of application
Materials	Any nonconforming component; component missing, damaged, or otherwise defective

Workmanship	Inadequate application of the components, such as incomplete closure of the container flaps, loose strapping, etc; bulging or distortion of the containers.
Content	Number per container incorrect

4.3.4 Testing

4.3.4.1 Quality conformance testing. Quality conformance testing of the end item for lot acceptance shall be conducted in accordance with 4.4, for compliance with the characteristics indicated therein.

4.3.4.2 Sampling for test. Except for the air pressure test (see 4.4.1) salt spray test (see 4.4.6) and weld test (see 4.4.7) a random sample of cans shall be selected from each lot offered for acceptance in accordance with MIL-STD-105 at Inspection Level I and an AQL of 0.65. For the air pressure test the Inspection Level shall be Level II with an AQL of 0.15. For the salt spray test and weld test, eight sample cans shall be selected from each 8 hour shift (or from lots containing 10,000 cans or less) Failure of any sample to meet the applicable requirement will be cause for rejection. Sample cans for testing of seam weld shall be selected prior to assembly of body end.

TABLE II

Inspection Levels and AQL's

Examination Paragraph	Inspection Levels	AQL
4.3.3.1.1	S-3	4.0
4.3.3.1.2	S-3	4.0
4.3.3.1.3	S-3	4.0
4.3.3.1.4	S-2	4.0

4.3.4.3 Sampling for Packaging. Packing and Marking. The sample unit for this examination shall be one shipping container, Classification of defects shall be in accordance with Table I.

4.3.5 Inspection equipment. The inspection equipment required to perform the examinations and tests prescribed in this section is identified under the "Method of Inspection" heading in 4.3.2 (see 6.3)

4.4 Test Methods and Procedures

4.4.1 Air pressure test. The contractor shall test each can body (see 4.3.4.2) with welded key or handle attached, in the lot on equipment capable of performing the required test consistently. The equipment shall be provided with a satisfactory means for applying and maintaining the required air pressure during the test and for showing evidence of any leakage. The equipment shall be checked with a suitable standard at least twice each 8 hour shift and immediately after each down time period to determine if the test is being applied in the proper manner. If at any time the testing operation is found to be improper, all can bodies and covers tested subsequent to the last satisfactory check point shall be rejected. These rejected can bodies may be screened, retested and resubmitted if desired by the contractor.

4.4.2 Test of tear strip

4.4.2.1 Procedure. The score of representative sample can shall meet the requirements of 3.9 when the key is attached to the tear strip tongue and rotated in a clockwise direction.

4.4.3 Test of seam

4.4.3.1 Procedure. Using the same cans used in 4.4.2.1, the test shall be conducted in accordance with 4.4.3.1.1.

4.4.3.1.1 Section the representative cans to determine that the requirements of 3.10 have been complied with. Both ends of the representative samples submitted for examination shall be seamed. Each end of each representative can shall be dimensionally examined.

4.4.4 Test of attachment of key

4.4.4.1 Procedure. The key attached to each representative sample can shall be removed manually to ensure that it meets the requirements of 3.11. The key shall be removed by lifting the head of the key through an arc in the direction of the tab.

4.4.5 Test of attachment of handle and handle cleats (applicable to Type II only)

4.4.5.1 Procedure. The handle and handle cleats attached to representative sample cans shall be tested for conformity to the requirements of the applicable drawings, for security of attachment of the cleat to the can, and for satisfactory butt welding of the handle ends. This test shall be made by slowly applying a static load, as specified on the applicable drawing, for a period of 1 minute through a bearing surface 2-1/2 inches wide affixed to the handle in such a manner that the direction of pull is at a right angle to the surface of the cover.

4.4.6 Salt spray test

4.4.6.1 First article lot. Prior to production, the representative sample cans and cover ends shall be subjected to the required salt spray test in accordance with Method 6061 of FED-STD-141. When no concentration is specified, 20 percent salt solution shall be used (see 6.2) After removal from the test chamber and thorough flushing with tap water, the test samples shall be air dried 8 hours minimum before inspection.

4.4.6.1.1 Rejection. If any sample can or end fails to comply with the requirements of 3.14.1, a new first article sample shall be required for this test. The manufacture of a production lot, prior to notification of acceptance of the first article sample, will be at no risk to the Government.

4.4.6.2 Production lot. The representative sample cans shall be subjected to the required salt spray test in accordance with 4.4.6.1. The test shall be performed by the contractor in the presence of the Government inspector.

4.4.6.2.1 Rejection. If any representative sample can fails to comply with the requirements of 3.14.2., the production lot shall be rejected without further test.

4.4.7 Test of weld

4.4.7.1 Procedure. From the sample selected, specimens of sufficient size shall be prepared to permit manual folding or bending of weld creating 90° bends throughout the length of seam. Folding or bending in direction of weld will be performed a minimum of three times in opposite directions.

Additionally, the top and bottom edges shall withstand manual curling (270 to 300 degrees) without evidence of breaking. Diagonal pliers, or substantial equivalent capable of performing said operation may be used provided satisfactory performance is assured.

5. PREPARATION FOR DELIVERY

5.1 Packaging Not applicable

5.2 Packing

5.2.1 Level A - Metal cans and unassembled ends shall be packed in V3c or better weather resistant fiber boxes conforming to PPP-B-636. Each layer of cans shall be separated by a plain fiberboard pad constructed from the same fiberboard as the box. Closure of the boxes shall be in accordance with the box specification requirements.

5.2.2 Level B. Packing shall be the same as Level A except Type CF, Domestic Class boxes shall be used. Closure shall be in accordance with the appendix of the fiber box specification.

5.2.3 Level C. Metal cans and unassembled ends that require overpacking by the carrier shall be packed in exterior type shipping containers in a manner that will ensure safe transportation at the lowest rate to the point of delivery and shall meet as a minimum, the requirements of the rules and regulations applicable to the mode of transporation selected.

5.3 Marking. Lot number of the contents shall be plainly marked on each shipping container. In addition

to any special marking required by the contract or purchase order (see 6.2) shipments shall be marked in accordance with MIL-STD-129.

* 6. NOTES

6.1 Intended use. The cans procured under this specification are intended for use in packing fuzes, signals and other ammunition and pyrotechnic items.

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6.2 Ordering data. Procurement documents shall specify the following:

a. Title, number and date of this specification.

b. Type of can required (see 1.2)

c. Dimensions - When drawings not available supply dimensions as per Figure 1 (see 3.2.1)

d. Type of can end (plain or ribbed) (see 3.3)

e. When a commercial type key is required (see 3.5)

f. When alternative coating of key is required (see 3.5)

g. Pattern of tear strip (plain or herring bone; see 3.9)

h. Color of coating if different from 3.13

i. Salt spray test requirements (see 3.1)

j. When salt spray test exposure for First Article Inspection is other than 168 hours (see 3.1)

k. Can labeling, if different from 3.15.

l. If manufacturer's marking is not required (see 3.16)

m. Provisons for submission of First Article samples (see 4.2.1)

n. Concentration of sodium chloride (salt) solution (see 4.4.6.1)

o. Level of packing required (see 5.2)

p. Special marking, when required (see 5.3)

6.3 Inspection Equipment Designs. Inspection equipment designs are designated two types - Government Special Inspection Equipment (SIE) designs and contractor designs. SIE designs are designated by drawing numbers (on the Equipment Lists referenced on the Equipment Tabulation) or (under the "Method of Inspection" headings in Section 4). Design responsibility for all other inspection equipment is assigned to the contractor. Equipment to be designed by the contractor is designated "CD". The contractor need not furnish any design when a complete Government SIE design is provided. Unless otherwise specified, however, the contractor may submit alternate or modified contractor designs of SIE in accordance with 6.3.2 and 6.3.3 should he elect to do so.

6.3.1 SIE designs. SIE designs may consist of any of the following:

a. Detailed drawings which completely depict all information necessary for the fabrication and use of the item of inspection equipment.

b. A source control drawing or a specification control drawing as defined in MIL-STD-100.

c. An envelope drawing, as defined in MIL-STD-100 which establishes the criteria which a detail design shall meet. When envelope drawings are specified, the contractor shall prepare designs which comply with the criteria therein.

6.3.2 Contractor designs. Contractor designs are required for all inspection equipment for which SIE designs are not specified and may include commercial equipment which the contractor proposes to use. (Commercial equipment is defined as unmodified equipment which is cataloged and available for purchase by the general public). Contractor designs shall include appropriate operating instructions, calibration procedures and maintenance procedures. Commercial equipment shall be fully described by catalog listings or other means which provide sufficient information to permit identification and evaluation by the Government and may include illustrations

and engineering data. Designs shall be prepared for any special fixture (s) required to be used with commerical equipment, or with SIE designs if not otherwise covered thereby (see 6.3.1c). Designs shall be of the category and form (per MIL-D-1000) specified in the Contract Data Requirements Lists (DD Form 1423).

The contractor is referred to MIL-HDBK-204, "Inspection Equipment Design" for guidance. The specification number and the applicable five digit defect code number (or other specific identifying information) from Section 4 of this specification shall be referenced on each contractor design together with the component or assembly drawing number and revision letter to which the specific design applies.

6.3.3 Submission of designs for approval. Contractor designs shall be approved by the Government prior to fabricating or procuring the equipment. Designs shall be submitted for approval to: Picatinny Arsenal, ATTN: SARPA-QA-A-P, Dover, New Jersey 07801 in accordance with the stipulations, time frame and distribution specified in the Contract Data Requirements List (DD Form 1423) or in the contract. Partial submission of inspection equipment designs is permissible and encouraged. However, the completion date for design review will be based on the date of the final submission of designs. Picatinny Arsenal design review will normally be accomplished within one month after receipt.

6.4 Inspection code numbers. The five digit code numbers assigned to the inspections herein are to facilitate future data collection and analysis by the Government. These code numbers are also used to correlate the characteristics cited on Equipment Lists with the inspections listed in this specification. In addition, they should be cited as references on drawings of equipment designs submitted by the contractor to the Government for approval (see 6.3.3)

6.5 Marginal notations. The margin of this specification are marked with an asterisk to indicate

where changes (additions, modifications, corrections deletions) from the previous issue 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 issue.

Custodian:
Army-PA

Preparing Activity:
Army-PA

Review Activities:
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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

OMB Approval
No. 22-R255

INSTRUCTIONS: The purpose of this form is to solicit beneficial comments which will help achieve procurement of suitable products at reasonable cost and minimum delay, or will otherwise enhance use of the document. DoD contractors, government activities, or manufacturers/vendors who are prospective suppliers of the product are invited to submit comments to the government. Fold on lines on reverse side, staple in corner, and send to preparing activity. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements. Attach any pertinent data which may be of use in improving this document. If there are additional papers, attach to form and place both in an envelope addressed to preparing activity.

DOCUMENT IDENTIFIER AND TITLE

NAME OF ORGANIZATION AND ADDRESS

CONTRACT NUMBER

MATERIAL PROCURED UNDER A

☐ DIRECT GOVERNMENT CONTRACT ☐ SUBCONTRACT

1. HAS ANY PART OF THE DOCUMENT CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE?

A. GIVE PARAGRAPH NUMBER AND WORDING.

B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES

2. COMMENTS ON ANY DOCUMENT REQUIREMENT CONSIDERED TOO RIGID

3. IS THE DOCUMENT RESTRICTIVE?

☐ YES ☐ NO *(If "Yes", in what way?)*

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SUBMITTED BY *(Printed or typed name and address - Optional)*

TELEPHONE NO.

DATE

DD FORM 1 JAN 72 1426 REPLACES EDITION OF 1 JAN 66 WHICH MAY BE USED