

INCH-POUND

MIL-C-13931H  
AMENDMENT 1  
29 December 1992

MILITARY SPECIFICATION  
CANNON: GENERAL SPECIFICATION FOR

This amendment forms a part of MIL-C-13931H, dated 11 February 1991, and is approved for use by all Departments and Agencies of the Department of Defense.

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2.1.1: Add the following under the heading "SPECIFICATIONS, MILITARY":

"MIL-G-81322 - Grease, Aircraft, General Purpose, Wide Temperature Range".

2.1.1: Delete the following under the heading "STANDARDS, FEDERAL":

"FED-STD-66 - Steel, Chemical Composition and Hardenability".

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3.2.1, line 2: Delete "FED-STD-66" and substitute "a standard AISI (American Iron & Steel Institute) grade or designation."

3.2.1, line 2: Add "or any combinations thereof," at the end of the line.

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3.3.1.1: Delete and substitute:

"3.3.1.1 Interpretation. Dimensions and tolerances shall be interpreted in accordance with the standard that was current at the time the drawing was originally prepared. For drawings revised prior to 30 September 1991, the revised dimensions and tolerances only shall be interpreted in accordance with the standard that was current at the time of revision, unless otherwise specified on the drawing. For drawings revised after 30 September 1991, the revised

AMSC N/A

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dimensions and tolerances shall be interpreted in accordance with the standard that was current at the time of original drawing preparation, unless otherwise specified on the drawing. Where a unilateral tolerance is specified without showing that the variation in the other direction is zero (e.g. 0.123 + 0.004) the general tolerance shall not apply. Where features are not controlled in accordance with the applicable standard(s) the requirements of drawing B8769390 shall apply. All features depicted as symmetrical to a centerline, without locational dimensions, are considered to have a common axis or center plane."

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3.4.6.5.2, line 2: Delete "MIL-G-10924" and substitute "MIL-G-81322".

3.4.6.5.3, line 3: Delete "MIL-G-10924" and substitute "MIL-G-81322".

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4.5.10.3: Delete and substitute:

"4.5.10.3 Measuring tube bores. For rifled cannon, all bore measurements made in a tube shall be located relative to the "vertical land", which is defined as the land at the six o'clock position at the commencement of rifling location when the cannon is in a normal (as mounted) position. The adjacent groove in a clockwise rotation, as one faces the muzzle, is designated the "vertical groove". Due to various rifling lengths/bore diameters/rifling twists, the correct land and groove "clocking" position for application of the stargage at muzzle end must be computed for each model cannon; such that upon full insertion, a stargage probe tip will align with the vertical land/groove at the commencement of rifling location."

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5.4, line 3: Delete "for the period of storage time." and substitute "in accordance with the item SPI and AR 700-15."

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5.4: Delete "AR 700-15" and substitute "AR 740-1".

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6.5: Delete and substitute:

"6.5 Suggested Steels. The following is a list of suggested steels based on drawing callouts. This list is furnished for informational purposes only and its use does not excuse the bidder or contractor from the sole responsibility of meeting all contract, drawing, and specification requirements. The UNS (Unified Numbering System for Metals and Alloys) equivalents may be used in lieu of the suggested steels listed.

<u>DRAWING CALLOUT</u>	<u>SUGGESTED STEELS</u>
.23C Max. AISI "C" Carbon or Alloy Steel	.23C Max. AISI Plain Carbon (10XX only) or Alloy (4XXX or 8XXX only) Steel
.23C Max. AISI Alloy Steel	.23C Max. AISI Alloy (4XXX or 8XXX only) Steel
.34C Max. AISI "C" Carbon or Alloy Steel	.34C Max. AISI Plain Carbon (10XX only) or Alloy (4XXX or 8XXX only) Steel
.13-.34C AISI "C" Carbon or Alloy Steel	.13-.34C AISI Plain Carbon (10XX only) or Alloy (4XXX or 8XXX only) Steel
.28-.46C AISI "C" Carbon or Alloy Steel	.28-.46C AISI Plain Carbon (10XX only) or Alloy (4XXX or 8XXX only) Steel
.27-.46C AISI Alloy Steel	.27-.46C AISI Alloy (4XXX or 8XXX only) Steel
.28-.46C AISI Alloy Steel	.28-.46C AISI Alloy (4XXX or 8XXX only) Steel

Custodian:  
Army-AR

User activity:  
Navy - MC, OS

Preparing activity:  
Army-AR

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