

MIL-C-48360 (AR)

3 July 1980

MILITARY SPECIFICATION

CHARGE, PROPELLING, M200, FOR 105MM HOWITZER, M204 LOADING, ASSEMBLING, AND PACKING

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

1. SCOPE

1.1 This specification covers the loading, assembling, and packing for one type of Propelling Charge designated as M200 for the M204 Howitzer.

2. APPLICABLE DOCUMENTS

2.1 The following documents of the issue in effect on the date of invitation for bids, or requests for proposals, 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
MIL-STD-129	-Marking for Shipment and Storage
MIL-STD-414	-Sampling Procedures and Tables for Inspection by Variables for Percent Defective
MIL-STD-1235	Single and Multilevel Continuous Sampling Procedures and Tables for Inspection by Attributes.

FSC: 1315

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 Command, Attn. DRDAR-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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DRAWINGS (see 6.9)

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND

9217087	-Marking Diagram and Sealing of Steel Drums for Shipment of Propellants and Bagged Charges
9282042	-Charge, Propelling M200 Loading Assembly

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

2.2 Other publications. The following document forms a part of this specification to the extent specified herein. Unless otherwise indicated, the issue in effect on date of invitations for bids shall apply.

CODE OF FEDERAL REGULATIONS

Title 49 Transportation, CFR 49 Part 100-199

(The Interstate Commerce Commission Regulations are now a part of the Code of Federal Regulations, available from the Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402. Orders for the above publications should cite, "49 CFR 100-199". (Latest revision)).

3. REQUIREMENTS

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

3.2 Propelling charge assembly. The propelling charge assembly shall comply with all requirements specified on Drawing (dwg) 9282042 and with all the requirements specified in applicable specifications.

3.3 Propellant weight. The net weight of the propellant shall not differ by more than the 0.07 ounce from that specified in the loading authorization.

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3.4 Proving ground. The propelling charge, when fired in the M204 Howitzer and with the weight of projectile (33 lbs + 0.10 lbs) for which it was manufactured, shall comply with the following requirements when tested as specified in 4.5.3.

3.4.1 PIMP Pressure (+145°F). The propelling charge, at recommended charge weight, shall not produce a PIMP (permissible individual maximum pressure) greater the 57,000 psi at +145°F when fired in a M204 Howitzer.

3.4.2 Average Pressure (+145°F). The propelling charge, at recommended charge weight, shall not produce an average chamber pressure greater than 54,000 psi at +145°F when fired in a M204 Howitzer.

3.4.3 Average pressure. (70°F). The propelling charge at recommended charge weight shall function and not produce an average chamber pressure greater than 47,000 psi when fired in a M204 Howitzer.

3.4.4 Muzzle velocity. The muzzle velocity at 70°F temperature shall not be less than 2170 feet per second nor greater than 2220 feet per second and the standard deviation of the lot shall not be greater than 8 feet per second.

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

3.6 Workmanship. The propellant grains shall be free of dirt, foreign material and other defects that would make the item unsuitable for its intended use. The cloth and thread used for the manufacture of propelling charge bags shall be void of grease, oil, dirt, foreign material, holes, rips or tears. All components and assemblies shall be fabricated and finished in a thorough workmanlike manner. All required marking shall be neat and sharply defined.

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.

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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 sample as designated by the contracting officer for evaluation in accordance with provisions of 4.3.2. The First Article sample shall consist of fifteen (15) propellant charge assemblies packed in a fiber drum and fifteen (15) complete sets of parts (i.e. 15 each of every component and every sub-assembly) which have been produced by the contractor.

4.3.2 Inspection to be performed. The First Article assemblies submitted in accordance with 4.3.1 will be subjected by the Government to any or all the requirements of the applicable drawings and to the inspections of Table I. All inspections listed in Table I shall be classified Major unless otherwise specified.

4.3.3 Rejection. See MIL-A-48078.

TABLE I - FIRST ARTICLE INSPECTION
CLASSIFICATION OF DEFECTS & TESTS
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PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER	
		AQL OR 100%	REQUIREMENT PARAGRAPH	See Below	NEXT HIGHER ASSEMBLY
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS		PARAGRAPH REFERENCE / INSPECTION METHOD	
	Body (Dwg - 9281867) Examination for Defects	100%	3.2	4.4.2.1	
	Foil, Lead (Dwg - 9282047) Examination for Defects	100%	3.2	4.4.2.2	
	Body and Liner Assembly (Dwg - 9282044) Examination for Defects	100%	3.2	4.4.2.3	
	Charge, Propelling, M200, Assembly (Dwg - 9282042) Examination for Defects	100%	3.2	4.4.2.4	
	Propellant weight from assembled propelling charge.	100%	3.3	4.5.2.1	
NOTES:					

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4.4 Quality conformance inspection

4.4.1 Inspection lot information. Inspection lots shall comply with the lot formation provisions of MIL-A-48078. In addition, inspection lots of propellant shall contain M30 propellant, Type I, from not more than one lot from one manufacturer.

4.4.2 Examination. See MIL-A-48078.

- a. Inspection for Critical Defects (and Major Defects, when so Specified) shall be 100 percent.
- b. Unless otherwise specified in the Classification of Defects and Test Tables, sampling plans for Major and Defects shall be in accordance with MIL-STD-105, Inspection Level II.

QUALITY CONFORMANCE INSPECTION

CLASSIFICATION OF DEFECTS & TESTS

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PARAGRAPH	TITLE	SHEET 1 OF 1		NO. OF SAMPLE UNITS	EXAMINATION OR TEST	AQL OR 100%	REQUIREMENT PARAGRAPH	DRAWING NUMBER 9281867 NEXT HIGHER ASSEMBLY 9282044	PARAGRAPH REFERENCE / INSPECTION METHOD
4.4.2.1	Body								
<u>Critical</u>									
<u>Major</u>									
101	None Defined								
102	Cloth improper					0.40%	3.1		4.5.1
103	Length					0.40%	3.2		Gage/Scale
	Width					0.40%	3.2		Gage/Scale
<u>Minor</u>									
201	Marking missing, misleading or unidentifiable					0.65%	3.2		Visual
202	Evidence of poor workmanship					0.65%	3.6		Visual
NOTE:									

DRLAR-QA Form 160 Jul 77 Replaces SARPA-QA Form 2567 Feb 74 Which is Obsolete

QUALITY CONFORMANCE INSPECTION

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PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH
4.4.2.2	Foil, Lead			9282047
				NEXT HIGHER ASSEMBLY 9282044
				PARAGRAPH REFERENCE / INSPECTION METHOD
<u>Critical</u>	None Defined			
<u>Major</u> 101. 102.	Length Width		0.40% 0.40%	Gage/Scale Gage/Scale
<u>Minor</u> 201.	Evidence of poor workmanship		0.65% 3.6	Visual

NOTE:

DRP-7-QA Form 160 Jul 77 Replaces SARPA-QA Form 2567 Feb 74 Which is Obsolete

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PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AOL OR 100%	REQUIREMENT PARAGRAPH
4.4.2.3	Body and Liner Assembly			9282044
				NEXT HIGHER ASSEMBLY 9282042
				PARAGRAPH REFERENCE / INSPECTION METHOD
<u>Critical</u>	None defined			
<u>Major</u>				
101.	Broken or incomplete stitches		0.40%	3.2
102.	Foil missing or improperly assembled		0.40%	3.2
103.	Length from edge of lead foil to edge of liner		0.40%	3.2
104.	Width from edge of lead foil to edge of liner.		0.40%	3.2
<u>Minor</u>				
201.	Evidence of poor workmanship		0.65%	3.6
				Visual
				Visual
				Gage/Scale
				Gage/Scale
				Visual

NOTE:

DDA-R-QA Form 160 Jul 77 Replaces SARPA-QA Form 2567 Feb 74 Which is Obsolete

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CLASSIFICATION OF DEFECTS & TESTS

PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER	
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	9282042
					PARAGRAPH REFERENCE / INSPECTION METHOD
4.4.2.4	Charge, Propelling M200 Loading Assembly				NEXT HIGHER ASSEMBLY
					NA
<u>Critical</u>	None defined				
<u>Major</u> 101.	Weight of propellant		100%	3.3	Scale/4.5.2
102.	Assembly damaged to the extent that propellant can escape		0.40%	3.2	Visual
103.	Any seam or opening incompletely stitched		0.40%	3.2	Visual
104.	Thread broken		0.40%	3.2	Visual
<u>Minor</u> 201.	Evidence of poor workmanship		0.65%	3.6	Visual
NOTES:					

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CLASSIFICATION OF DEFECTS & TESTS

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PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	SHEET 1 OF 1	DRAWING NUMBER	
						NEET HIGHER ASSEMBLY	N/A
CATEGORY						REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
4.4.2.5	Fiber drum prior to filling						
<u>Critical</u>							
<u>Major</u>							
101.	None defined			0.40%		5.2	Visual
102.	Foreign material in drum			0.40%		5.2	Visual
103.	Gasket missing or damaged			0.40%		5.2	Visual
104.	Holes in cover or end			0.40%		5.2	Visual
<u>Minor</u>							
201.	Locking device damaged						
	Nicks, dents, body bulged or scratches			0.65%		5.2	Visual
NOTE:							

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PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER
CATEGORY	EXAMINATION OR TEST	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
4.4.2.6	Unsealed fiber drum.			N/A
<u>Critical</u>	None defined			
<u>Major</u>				
101.	Contents missing	0.40%	5.2	Visual
102.	Packing component missing	0.40%	5.2	Visual
<u>Minor</u>				
201.	Packing component improperly assembled	0.65%	5.2	Visual
NOTES:				

DDA-R-QA Form 160 Jul 77 Replaces SARPA-QA Form 2567 Feb 74 which is Obsolete

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PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	SHEET 1 OF 1		DRAWINGS NUMBER
				AQL OR 100%	REQUIREMENT PARAGRAPH	
4.4.2.7	Fiber drum, sealed					NA NEXT HIGHER ASSEMBLY
CATEGORY						PARAGRAPH REFERENCE / INSPECTION METHOD
<u>Critical</u>	None defined					
Major	Contents move when drum is tilted			0.40%	5.2	Manual
101	Locking device damaged or improperly closed			0.40%	5.2	Visual
102	Holes or breaks in cover or body			0.40%	5.2	Visual
103	Damage to coating or cover			0.40%	5.2	Visual
104						
Minor	Marking missing, misleading or illegible			0.65%	5.2	Visual
201	Exterior, torn or delaminated			0.65%	5.2	Visual
202						
NOTES:						

DDIR-QA Form 160 Jul 77 Replaces SARPA-QA Form 2567 Feb 74 Which is Obsolete

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PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER	
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
4.4.2.8	Applicable to reusable fiber drums before filling				NA NEXT HIGHER ASSEMBLY
<u>Critical</u>	None defined.				
<u>Major</u>					
101	Top chime bent, deformed or cut		100%	5.2	Visual
102	Bottom chimes collapsed (annular groove closed or partially closed) or deformed.		100%	5.2	Visual
103	Body bulged, cut or dented		100%	5.2	Visual
104	Gasket in cover missing or damaged		100%	5.2	Visual
105	Cover bent, creased or deformed in gasket area or around edge.		100%	5.2	Visual
106	Locking ring damaged so as to prevent closing.		100%	5.2	Visual
<u>Minor</u>					
201	Outer body surface seriously scuffed or metal scratched.		1.5%	5.2	Visual
202	Nicks or dents in chimes or cover not affecting function		1.5%	5.2	Visual
203	Locking rings bent or deformed		1.5%	5.2	Visual
NOTES:					

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4.4.3 Testing

4.4.3.1 Propellant weight (see 3.3) - Major defect. Propellant charge shall be weighed and checkweighed 100% prior to filling the bag. Any propellant charge that does not comply with the weight requirements of 3.3 shall be rejected and removed from the filling operation.

4.4.3.2 Propellant weight from assembled propelling charge (see 3.3) - Major defect. The propelling charges shall be sampled in accordance with MIL-STD-105 or MIL-STD-1235 (CSP - 1 Plan) with an AQL of 0.40%.

4.4.3.3 Proving ground

4.4.3.3.1 Pressure (+145°F) (see 3.4.1) and average pressure (145°F) (see 3.4.2) - Major defects. For the first three lots manufactured, a ballistic quantity of twenty (20) charge assemblies shall be randomly selected from each lot. If any individual pressure exceeds the requirement specified in 3.4.1, or if the average pressure exceeds the requirement in 3.4.2, the lot shall be rejected.

4.4.3.3.1.1 After three (3) consecutive lots have complied with the criteria of 4.4.3.3.1, the contractor shall submit a quantity of ten (10) charge assemblies randomly selected from each lot. If any individual pressure exceeds the requirement specified in 3.4.1, or if the average pressure exceeds the requirement specified in 3.4.2, the lot shall be rejected. If lot failure occurs with three lots in succession, the sampling provisions shall revert back to 4.4.3.3.1.

4.4.3.3.2 Average pressure (+70°F) (see 3.4.3) and muzzle velocity (see 3.4.4) - Major defect. Beginning with the first lot produced and continuing until three consecutive lots have complied with the applicable requirements specified, the sampling plan shall be in accordance with MIL-STD-414, Section B and Code Letter H. For the average pressure calculation, Table B-1 and an AQL of 0.15 percent shall be used. The calculation of the muzzle velocity shall be in accordance with Table B-3 using an AQL of 2.5 percent. In addition, if the standard deviation of the sample muzzle velocities multiplied by the factor (see 6.5) exceeds the applicable requirement, the lot shall be rejected.

4.4.3.3.2.1 After the three consecutive lots have met the criteria of 4.4.3.3.2, the sampling plan as above shall be used except that the code letter shall be changed to Code Letter F. In addition, if the standard deviation of the sample muzzle velocities

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multiplied by the factor (see 6.5) exceeds the applicable requirement, the lot shall be rejected. If lot failure occurs with three lots in succession, the sampling provisions shall revert back to 4.4.3.3.2.

4.4.4 Inspection equipment. The inspection equipment required to perform the examination and tests prescribed herein is described in the "Paragraph/Inspection Method" column in the tables starting with 4.4.2.1. The contractor shall submit for approval inspection equipment designs in accordance with the terms of the contract. See 6.2.

4.5 Test methods and procedures

4.5.1 Cloth. At the time cloth is introduced to the sewing and/or cutting operation, an identification will be made for each roll to verify that proper material is used. Any cloth failing to be identified as proper material in accordance with applicable drawings and specifications shall be rejected from the lot.

4.5.2 Propellant weight. The propellant charge, placed in a container, shall be weighed and then check weighed on a different balance. If the weighing is performed manually, use another operator for checkweighing. Propellant charge weights shall be in accordance with the limits specified in 3.3. The propellant charges that are not within the limits will be rejected and removed from the system or reworked for re-use.

4.5.2.1 Propellant weight from assembled propelling charge

4.5.2.1.1 Average weight of propellant bags. A minimum of four (4) weighings must be made of empty bags during each shift to check for variation from nominal weight. Two (2) of these weighings shall be made within the first half of the shift and the other two weighings shall be made in the second half of the shift. Additional bag weights shall be taken, as required.

4.5.2.1.2 Procedure. Accurately weigh the assembled charge on a balance. Then, calculate the net weight of the propellant by difference using an average weight of the empty bags (as determined in 4.5.2.1.1). The calculation may also be performed by using the tare as marked on the individual bag instead of the average weight of the empty bags.

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4.5.3 Proving ground

4.5.3.1 These tests shall be conducted at a Government proving ground (designated by the contracting officer) in accordance with the applicable Proving Ground Acceptance Test Procedure.

4.5.3.2 The charge assemblies shall be assembled in cartridge cases, inert filled projectiles and dummy fuzes at ambient temperature. Condition the complete rounds at the required temperatures prior to firing. Fire the complete rounds, within five minutes after removal from the conditioning chamber, as specified in 4.4.3.3 for compliance with 3.4. The rounds shall be fired in a M205 Cannon which has a tube wear of no greater than 0.015 in. (0.381mm) when measured 25.25 in. (641.3mm) from the rear face of the tube.

4.5.3.2.1 PIMP pressure and average pressure (+145°F). Condition the rounds for 16 hours minimum for Zone 8 firings, at +145°F +5°F. Determine the pressure for each round. Calculate the mean pressure and pressure standard deviation.

4.5.3.2.2 Muzzle velocity and pressure (70°F). Condition the rounds for 16 hours minimum, for Zone 8 firings at 70°F + 2 1/2°F. Calculate the mean muzzle velocity, muzzle velocity standard deviation, mean pressure and pressure standard deviation.

5. PACKAGING

5.1 Packaging requirements. There are no packaging requirements in this specification.

5.2 Packing. Level B- Twenty four (24) propelling charges shall be packed in fiber drums as described in 5.2.1. Fiber drums are approved for truck or trailer on flat car (TOFC) shipment only and for storage not exceeding two years.

5.2.1 Fiber drums. Fiber drums shall comply with DOT Specification 21C, 250 pounds, MINIMUM, Code of Federal Regulations, Title 49, Parts 100-199, and the following additional requirements. Size shall be 15 1/2 + 1/2 inches in diameter by 26 + 1 inches in height, inside dimensions. The drum shall have a 23 or 24 gauge steel cover with rubber gasket, lever locking band with provision for sealing wire and wire bottom chime (2 inch minimum formed height). All metal parts shall be hot-dipped galvanized. Top and bottom chime shall be 23 or 24 gauge steel and shall be welded. The body shall be wound with a hot melt or thermoplastic adhesive. The bottom shall be a waterproof laminated fiberboard. Body and bottom disc shall also have a laminated aluminum foil barrier. The bottom crimp shall be caulked. The finished drum with closure assembled shall be moisture proof and leak tight. The fiber drums may be reused if the drums comply with the inspection requirements of 4.4.2.8.

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5.2.1.1 Alternative fiber drum. Alternatively, fiber drums shall be constructed as specified in 5.2.1 except that a layer of aluminum foil 0.010 thick shall be laminated to the inside of the body and the aluminum foil between the layers of Kraft paper in the body shall not be required.

5.3 Marking

5.3.1 Level B. In addition to any marking by the contract or order, marking shall be in accordance with 9217087 except that the DOT nomenclature shall be "PROPELLANT EXPLOSIVES, SOLID CLASS B" and have Storage Compatibility Group "C" and Quantity Distance "1.3".

6. NOTES

6.1 Ordering data. (See MIL-A-48078).

6.2 Inspection equipment designs. (See MIL-A-48078).

6.3 Definitions. (See MIL-A-48078).

6.4 Standard deviation. The standard deviation shall be calculated with (n-1) as the divisor in a standard statistical technique equivalent to the shown in MIL-STD-414, Section B, Example B-1.

6.5 Factors. The factors, as taken from Table A-21 of AMC Pamphlet 706-114 using the 95 percent upper confidence limit (A.05) and n-1 degrees of freedom, make allowance for the probability that a standard deviation exceeds the true standard deviation by chance alone. The factor for a normal 20 round group is 0.79, and the factor for a normal 10 round group is 0.73.

6.6 Tolerance. A tolerance of +50°F applies to all -50°F and +50°F to all +145°F requirements and a tolerance of plus or minus 2 1/2°F to all 70°F requirements.

6.7 Proving ground test summary.

Test	Temp. (°F)	Requirement	Sample Size (Tightened Insp)	Sample Size (Normal Insp)
PIMP Pressure	+145	57,000 psi	20	10
Av. Pressure max.	+145	54,000 psi	Same sample as above	Same sample as above

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Test	Temp. (°F)	Requirement	Sample Size (Tightened Insp)	Sample Size (Normal Insp)
Av. Pressure (max)	70	47,000 psi	20	10
Muzzle velocity (individual)	70	2170 to 2220 fps	Same sample as above	Same sample as above
Standard Deviation Lot		σ lot \leq 8 fps		

6.8 Submission of test data. In addition to the normal distribution of records, when the propellant charge assembly is procured by the Department of the Army, one copy of all ballistic test data shall be forwarded to: Commander, ARRADCOM, ATTN: DRDAR-QAR-Q and one copy to ATTN: DRDAR-LCA-G, Dover, NJ 07801.

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

Custodian:
Army-AR

Preparing activity:
Army-AR

Project Number: 1315-A045

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL	
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<p>DOCUMENT IDENTIFIER (Number) AND TITLE MIL-C-48360 CHARGE, PROPELLING, M200, FOR 105MM HOWITZER, M204 LOADING, ASSEMBLING, AND PACKING</p>	
<p>NAME OF ORGANIZATION AND ADDRESS OF SUBMITTER</p>	
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<p>1. <input type="checkbox"/> HAS ANY PART OF THE DOCUMENT CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE? <input type="checkbox"/> IS ANY PART OF IT TOO RIGID, RESTRICTIVE, LOOSE OR AMBIGUOUS? PLEASE EXPLAIN BELOW.</p> <p>A. GIVE PARAGRAPH NUMBER AND WORDING</p> <p>B. RECOMMENDED WORDING CHANGE</p> <p>C. REASON FOR RECOMMENDED CHANGE(S)</p>	
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