

MIL-C-50863B(AR)
AMENDMENT 2
11 July 1986
SUPERSEDING
AMENDMENT 1
26 July 1985

MILITARY SPECIFICATION

CARTRIDGE, 40MM, HEPD, M430
LOADING, ASSEMBLY AND PACKAGING

This Amendment forms a part of Military Specification MIL-C-50863B(AR), dated 3 April 1985, and is approved for use within the US Army Armament Munitions and Chemical Command and is available for use by all Departments and Agencies of the Department of Defense.

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- * 3.3, Delete in its entirety and substitute the following:

"3.3 X-Ray examination of fuze assembly, less spitback assembly and prior to assembling to body assembly. The fuze assembly, less spitback assembly, shall be x-rayed for improper assembly, missing, improperly formed or damaged parts and arming or partial arming."

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- * 4.4.2.1, Critical; Delete: "None defined" and substitute the following:

"CRITICAL 1. Closing cup missing 100% 3.2 Probe".

Delete Major "101" in its entirety.

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- * 4.4.2.4, Change title to read: "Fuze, PIBD, M549; Less Spitback Assembly".

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Change drawing number "9287860" to "9287861".

- Delete "Critical: None defined" and substitute, "CRITICAL
1. X-Ray examination 1/ 100% 3.3 4.5.5".

Change Major 101 to read:

"101. X-Ray examination 2/ 100% 3.3 4.5.5".

Major 102, Delete: "See Note" and substitute "3/".

Add the following:

- "1/ Critical defect is defined as:
a. Setback pin not adjacent to the rotor gear.
b. Setback pin not seated in bottom of counterbore of escapement housing.
c. Setback pin missing.
d. Setback spring missing.
e. Safety spring missing.
f. Safety spring not engaged in teeth of rotor gear.
g. O-ring missing.
h. Pinion missing.
i. Verge assembly missing.
j. Rotor gear assembly in armed or partially armed position.

2/ Major defect is defined as any defect not specified in Note 1/."

Delete "Two (2)...production" and substitute "3/ Two (2) ...production."

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- * 4.4.2.6, Under Notes change "AQL .040%" to "AQL 0.40%".

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- 4.4.2.7, Major; Delete: "None defined" and substitute the following:

"Major 101 O-ring (packing) missing in groove
0.65% 3.2 Visual".

Delete Minor "201" in its entirety and substitute "None defined".

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- * 4.4.2.8, Delete: "Critical 1" in its entirety and substitute:

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1/ "Critical 1. X-ray examination of ballistic samples
0-1 3.4 4.5.13".

Delete "Major 102" in its entirety and substitute:

"102. X-ray examination of ballistic samples 2/ 3/
3.4 4.5.13".

Under notes add:

"1/ Critical defect:

- a. Closing cup missing.
- b. Low propellant charge.
- c. Any critical defect listed in 4.4.2.4, Note 1/.

2/ Major defect: All defects not listed in Note 1/.

3/ Any major defect found shall be reported.".

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Add QUALITY CONFORMANCE INSPECTION TABLE, 4.4.2.14, Page 18a
(included).

CLASSIFICATION OF DEFECTS & TESTS

PARAGRAPH	TITLE	SHEET OF		DRAWING NUMBER
		AQL OR 100%	REQUIREMENT PARAGRAPH	
4.4.2.14	Fuze, PIBD, M549, Prior to assembling spitback assembly			9287860 NEXT HIGHER ASSEMBLY 9287852
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS		PARAGRAPH REFERENCE / INSPECTION METHOD
CRITICAL	None defined			
MAJOR 101.	Cup spitback missing on spitback assembly			
MINOR	None defined			
		.40%	3.2	Visual
NOTES:				

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- * 4.4.3.1, a, Add: "Info correlated with the MK19 MOD III".
b. Add "Penetration acceptance".
- * 4.4.3.1.1, a, Delete: "Combined phases".

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- * 4.4.2.1.1, i. Add: "Duds and low orders are to be declared a "NO TEST", recorded and replaced."

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- * 4.4.3.2, a. Add: "Info correlated with the MK19 MOD III".
b. Add "Penetration acceptance".
- * 4.4.3.2.1, a. Delete: "Combined phases".

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- * 4.4.3.2.1, i, Add: "Duds and low orders are to be declared a "NO TEST", recorded and replaced."
- * 4.4.3.2.1.1, Delete: "If thirteen (13)...(MK19, MOD III)".

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- * 4.5.5, Delete in its entirety and substitute the following:
"4.5.5 X-Ray examination of fuze assemblies, less spitback assembly and prior to assembling to body assembly. Improperly assembled, missing, improperly formed parts, armed or partially armed fuze assemblies shall be determined by x-ray equipment or any other method satisfactory to the contracting officer. This test shall be conducted in two (2) planes. From the top of the fuze assembly down and from the side. Side view shall show the flange of the setback pin seated against the bottom surface of the rotor plate."
- * 4.5.15, Delete: "If a major defect is found, it shall be noted and replaced with a good sample and forwarded to the proving ground." and substitute "If a major defect is found, it shall be reported and the sample forwarded to the proving ground."
- * 4.5.16, Delete: "eight (8) hours" and substitute "two (2) hours provided the skin temperature of the case is between 45OF and 90OF".

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Delete: "four rounds per minute" and substitute "ten (10) rounds per minute".

Add: "An outlier shall be permitted up to ± 25 percent of the mean velocity of the lot. No more than one value on the high side and no more than one value on the low side shall be omitted from the mean velocity and standard deviation calculations. If a velocity value is greater than ± 25 percent of the mean velocity of the lot, the lot shall be rejected."

The margins of this amendment are marked with an asterisk or vertical lines 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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