NOT MEASUREMENT SENSITIVE

MIL-DTL-18492B (OS)
15 February 2011
SUPERSEDING
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DETAIL SPECIFICATION

TANKS, CARTRIDGE, POWDER, ROCKET, AND COMPONENTS (ALUMINUM)

This specification is approved for use by the Naval Sea Systems Command, Department of the Navy, and is available for use by all departments and agencies of the Department of Defense.

1. SCOPE.

1.1 Scope. This specification establishes the requirements for aluminum cartridge, powder, and rocket tanks.

1.2 Classification. The tanks will be of the following types:

Type I	Cartridge tanks for fixed ammunition (cartridges with projectiles)
Type II	Cartridge tanks for cartridges of separated ammunition (without projectiles)

Comments, suggestions, or questions on this document should be addressed to DEPARTMENT OF THE NAVY, Indian Head Division, NSWC, Code E12AP, Document Control, 4123 Artisans Court, Suite 103, Indian Head, Maryland 20640-5085, OFFICIAL BUSINESS, or emailed to amanda.penn@navy.mil. Since contact information can change, you may want to verify the currency of this address information using the ASSIST Online database at https://assist.daps.dla.mil/

FSC 8140

Type III	Powder tanks for propelling charges (powder in bags)
Type IV	Rocket tanks for rocket ammunition.

2. APPLICABLE DOCUMENTS

2.1 General. The documents listed in this section are specified in sections 3, 4, or 5 of this specification. This section does not include documents cited in other sections of this specification or recommended for additional information or as examples. While every effort has been made to ensure the completeness of this list, document users are cautioned that they must meet all specified requirements of documents cited in sections 3, 4, or 5 of this specification, whether or not they are listed.

2.2 Government documents.

2.2.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those cited in the solicitation or contract.

FEDERAL SPECIFICATIONS

TT-P-1757	Primer Coating, Alkyd Base, One Component

DEPARTMENT OF DEFNSE SPECIFICATIONS

MIL-DTL-5541	Chemical Conversion Coatings on Aluminum and Aluminum Alloys
MIL-E-16663	Enamel, Semi-Gloss (For Metal Surfaces of Ammunition and Ammunition Containers)
MIL-PRF-81322	Grease, Aircraft, General Purpose Wide Temperature Range

FEDERAL STANDARDS

FED-STD-141	Paint, Varnish, Lacquer and Related Materials; Methods of Inspection, Sampling, and Testing
FED-STD-595-26231	Colors Used in Government Procurement

DEPARTMENT OF DEFENSE STANDARDS

MIL-STD-129	Military Marking for Shipment and Storage
MIL-STD-1916	DOD Methods for Acceptance of Product

(Copies of these documents are available online at https://assist.daps.dla.mil/quicksearch/ or from the Standardization Documents Order Desk, 700 Robbins Avenue, Building 4D, Philadelphia, PA 19111-5094.)

2.2.2 Other Government documents, drawings, and publications. The following other Government documents, drawings, and publications form a part of this document to the extent specified herein. Unless otherwise specified, the issues are those cited in the solicitation or contract.

DRAWINGS

BUWEPS

(10001) 99085	Load Test for Ends of Tanks
NAVSEA S9074-AQ-GIB-010/248	Requirements for Welding and Brazing Procedures and Performance Qualifications

(Application for copies should be addressed to the DEPARTMENT OF THE NAVY, Indian Head Division, NSWC, Code E12P, Document Control, 4123 Artisans Court, Suite 103, Indian Head, MD 20640-5115 OFFICIAL BUSINESS.)

2.3 Non-Government publications and drawings. The following document forms a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those cited in the solicitation or contract.

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM B117	Standard Practice for Operating Salt Spray (Fog) Apparatus
ASTM B633	Standard Specification for Electrodeposited Coatings of Zinc on Iron and Steel
ASTM D3951	Standard Practice for Commercial Packaging

(Copies of these documents are available online at http://www.astm.org or from the American Society for Testing and Materials Customer Service, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.)

AMERICAN WELDING SOCIETY (AWS)

AWS D17.2/D17.2M	Specification for Fusion Welding for Aerospace Applications

(Copies of these documents are available online at http://www.aws.org or from the American Welding Society, 550 N. LeJeune Rd., Miami, FL 33126)

2.4 Order of precedence. Unless otherwise noted herein or in the contract, in the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 General manufacture. Manufacture of all parts shall proceed in accordance with the requirements of the contract, purchase order or requisition, appropriate drawings, and this specification.

3.2 Materials. All materials used in the manufacture of these tanks shall conform to the specifications listed herein and to the specifications referred to on respective drawings, unless specific approval in writing, covering a departure therefrom, has been obtained from the Government prior to manufacture or use. When alternate materials or methods of manufacture are specified, the bidder's selections shall be stated clearly in the proposal.

3.3 Conformance to drawings. All dimensions shall be accurate within the tolerances specified on the drawings or in the applicable specification, unless otherwise stated in the contract, purchase order, or requisition.

3.4 Surface. All parts shall be finished as prescribed on the applicable drawings and specifications unless otherwise stated in the contract.

3.5 Interchangeability. All parts shall be capable of interchangeable assembly without interferences, binding, or misalignment. All parts comprising a permanent joint unit (as welding) and the unit thus formed shall be capable of interchangeable joining in the assembled unit and assembly.

3.6 Gages. The contractor shall provide whatever production gages are necessary and adequate to ensure complete interchangeability of all parts, and to determine that all dimensions are within the tolerance shown on the applicable drawings. If so stipulated in the procurement document, the Government will furnish drawings of pertinent Navy Final Inspection Gages for guidance in design of the contractor's inspection gages. Such procedures shall not serve to relieve the contractor of his responsibility in design

and manufacture of the other production gages as may be required for the satisfactory fulfillment of contract requirements.

3.7 Top ring. The top ring shall be assembled on the tank with its axis coincident with that of the tank body. The pressure or helical bearing surfaces of the top ring and the top of the cover ring, which will serve to secure the cover assembly to the tank, shall be a smooth true helix, with the axis coinciding with the axis of the tank. There shall be no tendency for the outside cylindrical surface of the cover ring to jam or bind with the opposing inside cylindrical surface of the top ring. All coincident axes shall be within tolerances specified on the applicable drawings.

3.8 Locking rings. For tanks fitted with tongue and groove locking rings, the tongue and grooves of the adjacent tanks shall so fit with each other that bearing between neighboring locking rings shall be on top of the tongues or ridges and on the bottom in grooves. There shall be no tendency for tongues to wedge in grooves, nor shall bearing between the tanks take place on the outer cylindrical surfaces of the top ring between the top edge and the locking ring.

3.9 Cover Assembly.

3.9.1 Cover. The cover shall be manufactured in accordance with the applicable drawing. The cover shall be free to rotate with respect to the cover ring after the cover has been formed into the groove in the cover ring. Prior to assembly, apply a thin continuous coating of grease, MIL-PRF-81322, between all sliding surfaces of the cover.

3.9.2 Cover ring. The axis of the cover ring shall be perpendicular to the surface of the cover which forms a seat for the gasket and shall be coincident with the axis of the helical bearing surface within tolerances specified on the applicable drawings. The cover ring and cover assembly, when in the unlocked position, shall be easily removed from the top ring at any of the positions in which it may be assembled to any tank.

3.9.3 Gasket and gasket bearing surface. A new gasket of the type prescribed by the applicable drawings shall be cemented in the tank cover with an adhesive of the type prescribed by the applicable drawings. The gasket mating surface shall have a 125/micro inch minimum finish and shall be flat within +/-.005 inches. Bearing surfaces shall not injure the gasket during closing and opening of the tank, and shall ensure proper seating of the gasket. The gasket shall provide sealing at closure of the cover assembly (see 3.13).

3.10 Bottom. The axis of the outside cylindrical surface of the bottom shall coincide with the axis of the tank body and the top ring within the tolerance specified on the applicable drawings. The bottom surface shall be perpendicular to the tank axis and parallel to the top surface of the top ring within tolerances specified on the applicable drawings.

3.11 Interior fittings. The interior fittings shall be true to form and all surfaces and edges shall be smooth and free from projections, sharp edges, rough spots, and similar defects that would tend to damage the contents, interfere with the assembly or loading of the tanks, or injure personnel. All supporting and positioning fittings shall be concentric, and the bottom surface on which the fittings rest shall be perpendicular, within the tolerances specified on the applicable drawings, to the axis of the fittings so that the contents will be properly aligned in the tank. Where multiple diaphragms are used, diaphragms shall be parallel and at right angles to the axis of the tank within the tolerances specified on the applicable drawings. If an extractor is used in the cartridge tanks, the extractor shall slide freely between the tank body and the cartridge case to ensure easy withdrawal of the cartridge.

3.12 Cleaning, preparation of surfaces, and painting.

3.12.1 Exterior surfaces (cover assembly). All aluminum surfaces to be painted shall have a chemical film applied by treatments and products in accordance with MIL-DTL-5541, Class 1A. The chemical films shall be produced by treatments controlled and operated to give a uniform product and shall be continuous and free from breaks, scratches, and other damage affecting the serviceability of the film.

3.12.2 Exterior surfaces (tank). Exterior surfaces of the tank shall be prepared in accordance with the applicable drawings to ensure good paint adhesion and good welds.

3.12.3 Faying surfaces. All faying surfaces which are not welded shall be coated with Primer Coating, TT-P-1757, color Y. Each surface shall be allowed to dry hard before assembly.

3.12.4 Painting. Exterior surfaces shall conform to the requirements specified on the applicable drawing, MIL-E-16663, and FED-STD-595. Enamel dry film thickness shall be 1.5 to 2.0 mils. The contacting surfaces between moving parts shall not be painted (see Section 3.9).

3.12.5 Corrosion resistance and paint adhesion. When tested in accordance with 4.5.5, the treated and painted tanks and cover assemblies shall withstand exposure to salt spray testing as specified in 4.5.5. Paint film shall show no evidence of wrinkling, blistering, cracking, powdering, or flaking in areas adjacent to the scribing, nor shall there be any evidence of corrosion on any other exposed surface of the tanks or tank covers when tested in accordance with FED-STD-141 and ASTM B117.

3.13. Air tightness. All tanks and cover assemblies shall be capable of withstanding the internal air pressure tests of Sections 4.5.1 and 4.5.2 without evidence of any structural weakness or permanent deformation. Formation of air bubbles shall be sufficient evidence of leaks serious enough to reject the tank or cover assembly.

3.14 Serviceability. While weight loaded and tested in accordance with 4.5.3, the cover assemblies of the tanks shall be easily tightened, loosened, applied or removed, and the contents shall be easily removed

from the tank. After removal of the loads, the tanks', top rings and bottoms shall show no permanent deformation.

3.15 Drop test. Upon completion of the drop tests in accordance with 4.5.4, the air tightness (3.13) and serviceability (3.14) requirements shall apply.

3.16 Marking. All marking or stamping on the tanks shall be as shown on the applicable drawings. Stamped or embossed lettering on the cover, body, and interior fittings of the tank shall be legible after the tank has been completely finished.

3.17 Welding. All surfaces to be welded shall be thoroughly cleaned and shall be free from grease, paint, or other foreign substances. All aluminum welding shall conform to the requirements as specified on the applicable drawings, and in accordance with AWS D17/D17.2M, and NAVSEA S9074-AQ-GIB-010/248.

3.18 Workmanship. Workmanship shall be that required by best commercial practices consistent with quality production of analogous parts, maintaining dimensions, finishes, and tolerances specified herein and on the applicable drawings and specifications. All components shall be sound and free from defects which would deleteriously affect the strength and performance of the tank and cover assembly, and all joints and seams shall be tight and sound. All surfaces shall be free from rough spots, sharp edges and burrs, protrusions, dents, cracks, dirt, grease, rust, other foreign matter, or similar defects which might interfere with the assembly of the tank components, loading of the tanks, interference with the stacking of the tanks, cause injury to personnel, or damage to the contents during loading, unloading, handling, and shipping. Exterior surface coatings shall be continuous and all required marking and stamping shall be neat and sharply defined.

3.19. Preproduction sample. Unless otherwise specified in the contract or purchase order, preproduction samples of the tanks and cover assemblies shall be manufactured using the methods and procedures proposed for production. The sample shall be tested as specified in section 4 herein for the purpose of determining that, prior to production, the supplier's production methods are capable of yielding items that comply with the technical requirements of this specification and the contract or purchase order.

4. VERIFICATION

4.1 Classification of inspection. The inspection requirements specified herein are classified as follows:

(1) Preproduction inspection (see 4.3)
(2) Quality conformance inspection (see 4.4)

4.2 Sampling requirements. Inspection sampling requirements for Critical, Major and Minor characteristics are defined in MIL-STD-1916. Unless specified otherwise, verification Level IV shall be

used for all characteristics defined as Majors and Verification Level II for all Minor characteristics; Critical characteristics shall be addressed in accordance with MIL-STD-1916. In addition to the sampling requirements stated herein, Verification Level VII shall be used to verify the 100% screening operation of Critical Characteristics.

4.2.1 Lot size. The term "lot" shall mean "inspection lot" i.e., a collection of units of product submitted by a supplier for Government inspection. Sampling plans and procedures when applicable in determination of the acceptability of the lots or products procured by the Government, unless otherwise specified, shall conform to the provisions of MIL-STD-1916.
Unless otherwise specified in the contract or purchase order, the production lot shall consist of maximum of 1000 complete tanks and/or cover assemblies plus those required for test purposes. Unless otherwise specified in the contract or purchase order, all tanks and cover assemblies for inspection purposes shall be provided at the expense of the supplier.

4.2.2 Production sample.

4.2.2.1 Tank assemblies. A preproduction sample of 10 complete tanks with covers, five painted and five unpainted, shall be submitted to a facility designated by the procuring activity for inspection and testing in accordance with Table I to determine conformance to the technical requirements of the contract. Further production of the tank and cover by the supplier, prior to approval of the preproduction sample, shall be at the supplier's risk.

4.2.2.2 Cover assemblies. A preproduction sample of 10 covers assemblies, five painted and five unpainted, shall be submitted to a facility designated by the procuring activity for inspection and testing in accordance with Table I to determine conformance to the technical requirements of the contract. Further production of the cover assembly by the supplier, prior to approval of the preproduction sample, shall be at the supplier's risk.

4.2.3 Quality conformance inspection sampling. Samples shall be selected and inspected in accordance with Tables I and II to determine the acceptability of the tank and cover, or the cover assembly.

TABLE I. Preproduction and quality conformance inspection and sampling.

Test Examination	Requirement Paragraph	Method Paragraph	Preproduction Lot Number of Units to be Inspected	Preproduction Lot Number of Defects Allowed Accept	Preproduction Lot Number of Defects Allowed Reject	Production Lot Number of Units to be Inspected	Production Lot Number of Defects Allowed Accept	Production Lot Number of Defects Allowed Reject
Airtightness (cover)	3.13	4.5.1	15	0	1	15	0	1
Airtightness (tank) (When Stacked)	3.13	4.5.2	10	0	1	15	0	1
Serviceability	3.14	4.5.3	10	0	1			
Drop Test	3.15	4.5.4	10	0	1			
Paint Test Paint Brittleness, toughness and tendency to ribbon Dry film thickness (1.5 to 2.0 mils)	3.12.4	4.5.5	5	0	1			
Salt Spray	3.12.5	4.5.5	2	0	1			

TABLE II. Inspection by classification of characteristics

CLASSIFICATION	EXAMINATION OR TEST	CONFORMANCE CRITERIA	REQUIREMENT PARAGRAPH	INSPECTION METHOD
Critical				
None				
Major				
101	Material	Level IV	3.2	Visual
102	Plating	Level IV	3.4	Visual
103	Dimensional	Level IV	3.3	Visual/Gage
104	Air Tightness	Level IV	3.13	Visual/Gage
105	Marking	Level IV	3.16	Visual
106	Welding	Level IV	3.17	Visual/Gage
107	Assembly	Level IV	3.1/3.5/3.10/3.11	Visual/Gage
108	Alignment	Level IV	3.1/3.5/3.10/3.11	Visual/Gage
109	Gasket Mating Surface	Level IV	3.9.3	Visual/Gage
110	Gasket Diameter	Level IV	3.9.3	Gage
111	Gasket Thickness	Level IV	3.9.3	Gage
112	Gasket Radius	Level IV	3.9.3	Gage
113	Painting (Cover Assembly)	5 Samples	4.5.5.1	Visual/Gage
	Painting (Tank Assembly)	5 Samples	4.5.5.2	
114	Salt Spray (Cover Assembly)	2 Samples	4.5.5.1	Visual/Gage
	Salt Spray (Tank Assembly)	2 Samples	4.5.5.2	
Minor				
201	Workmanship	Level II	3.18	Visual

4.3 Preproduction inspection. Preproduction inspection at the Government option shall consist of all the examinations and tests, unless declared "not applicable", in accordance with Table I to determine acceptability of the tank and tank covers.

4.4 Quality conformance inspection. Production quality conformance inspection shall consist of all examinations and tests as specified in Table I.

4.5 Test procedures (First Article).

4.5.1 Air tightness (cover assembly). Each cover assembly with its gasket shall be assembled with a master tank or equivalent. The assembly shall be subjected to an internal air pressure of 5 pounds per square inch gauge for a minimum of 30 seconds while submerged in water containing one of the following wetting agents: Polysorbate 20, Polysorbate 40, Sodium Laurly Sulfate, or alkylsulfonate, used at a concentration recommended by the manufacturer. The master tank or its equivalent shall have a means for applying air under pressure to the cover or tank to be tested. The tank shall be thoroughly examined for leaks. A tank which does not meet the requirements of 3.13 shall be considered defective.

4.5.2 Air tightness - tank assembly (when stacked). Each tank shall be assembled with a master cover and gasket, submerged, and weight loaded as indicated on BUWEPS Drawing 99085. The assembly shall be subjected to an internal air pressure of 5 pounds per square inch gauge for a minimum of 30 seconds while submerged in water containing one of the following wetting agents: Polysorbate 20, Polysorbate 40, Sodium Laurly Sulfate, or alkylsulfonate, used at a concentration recommended by the manufacturer. The master tank or its equivalent shall have a means for applying air under pressure to the cover or tank to be tested. The tank shall be thoroughly examined for leaks. A tank which does not meet the requirements of 3.13 shall be considered defective.

4.5.3 Serviceability (when stacked). The same tanks, when tested in accordance with 4.5.2, shall be loaded with dummy ammunition, or as otherwise stated by the Government. The tanks, assembled with their own covers, shall be weight loaded as shown on BUWEPS Drawing 99085. A tank which does not meet the requirements of 3.14 shall be considered defective.

4.5.4 Drop test. Five of the tanks, tested in accordance with 4.5.2, shall be assembled with their own covers and loaded with dummy ammunition or an equivalent inert configuration to simulate the service load. Each of the inert loaded tanks shall be dropped from a distance of 3 feet, four times onto a concrete or similarly unyielding surface so as to land initially on the bottom edge, top edge, top and bottom edges simultaneously, and the top and bottom edges simultaneously 180° from the preceding position. Each tank shall be then placed in a vertical position, top uppermost, and toppled over so as to land on a piece of lumber having a cross-section of 4 inches by 4 inches and to strike the tank approximately 10 inches from the top. Upon completion of the drop tests, the air tightness test of 4.5.2 and serviceability test of 4.5.3 shall be repeated.

4.5.5 Paint test.

4.5.5.1 Paint test (cover assembly). Prior to performing the test as specified in 4.5.1, five painted, but otherwise untested covers, shall be tested for paint film brittleness, toughness, and tendency to ribbon in accordance with the knife test of FED-STD-141 Method 6304.2. Two of the above covers shall be subjected to a 150 hour salt spray test in accordance with ASTM B117. Covers which do not meet the requirements of 3.12.5 shall be considered defective.

4.5.5.2 Paint test (tank assembly). Prior to performing the tests as specified in 4.5.2 and 4.5.3 five painted, but otherwise untested tanks with covers, shall be tested for paint film brittleness, toughness, and tendency to ribbon in accordance with the knife test of FED-STD-141 Method 6304.2. Two of the above tanks shall be subjected to a 150 hour salt spray test in accordance with ASTM B117. Tanks which do not meet the requirements of 3.12.5 shall be considered defective.

4.5.6. Special tests. When specifically requested by the Government, the contractor shall furnish 10 additional tanks with covers or covers without tanks from any lot of production for tests specified in this specification. In such cases, the contractor shall ship these tanks to the activity specifically designated by the Government.

4.6 Test procedures (production lot).

4.6.1 Material test. The inspector shall withdraw such samples of all ingredients, materials, and components entering into the completed tanks as may be required to determine compliance with the requirements of the appropriate drawings and specifications. The contractor shall furnish the inspector with such data as the inspector may require as to the lot or order number, manufacturer, test results, inspections, etc., of all parts entering the completed tanks and tank covers.

4.6.2 Acceptance tests. Each production lot shall be given the following acceptance tests. These tests shall be at the contractor's expense and shall be supervised by the inspector. Failure of one or more tanks shall constitute the basis for rejections of a lot.

4.6.3 Air tightness (cover assembly). Each cover assembly with its gasket shall be assembled with a master tank or an equivalent configuration. The assembly shall be subjected to an internal air pressure of 5 pounds per square inch gauge for a minimum of 30 seconds while submerged in water containing one of the wetting agents specified in 4.5.1. A cover which does not meet the requirements of 3.13 shall be considered defective.

4.6.4 Air tightness (tank assembly). After the contractor has completed the air tightness tests on the production lot, the inspector shall randomly select a sample of 15 tanks and covers. Each tank shall be assembled with a master cover or an equivalent configuration. These assemblies shall be subjected to an internal air pressure of 5 pounds per square inch gauge for a minimum of 30 seconds while submerged in

water containing one of the wetting agents specified in 4.5.2 and weight loaded in accordance with BUWEPS Drawing 99085. A tank which does not meet the requirements of 3.13 shall be considered defective.

4.6.5 Paint (cover assembly). Five painted covers of each 10 lots shall be subjected to the paint test as specified in 4.5.5. The five covers shall be selected at random from the 10 lots. Covers which do not meet the requirements of 3.12.4 shall be considered defective.

4.6.6 Paint (tank assembly). Five painted tanks with covers of each 10 lots shall be subjected to the paint test as specified in 4.5.5. The five tanks shall be selected at random from the 10 lots. Tanks which do not meet the requirements of 3.12.4 shall be considered defective.

5. PACKAGING

5.1 Packaging. For acquisition purposes, the packaging requirements shall be as specified in the contract or order (see 6.2). When packaging of materiel is to be performed by DoD or in-house contractor personnel, these personnel need to contact the responsible packaging activity to ascertain packaging requirements. Packaging requirements are maintained by the Inventory Control Point's packaging activities within the Military Service or Defense Agency, or within the military service's system commands. Packaging data retrieval is available from the managing Military Department's or Defense Agency's automated packaging files, CD-ROM products, or by contacting the responsible packaging activity.

6. NOTES

(This section contains information of a general or explanatory nature that may be helpful, but is not mandatory.)

6.1 Intended use. These cartridge, powder, rocket tanks, tank components, and cover assemblies are designed to protect the contents during shipping, handling, and storage. Since they were developed for the shipping, handling, and storage of military munitions, there are no commercial applications.

6.2 Ordering data. Procurement documents should specify the following:

(a) Title, number, and date of this specification.
(b) Type required (See 1.2).

6.3. Preparation for delivery

6.3.1 Preservation and packing.

6.3.1.1 Level C.

6.3.1.1.1 Interior fittings packaging. Loose interior fittings may be separately packaged in lots as convenient for shipping, or may be contained within the tanks. Fittings packaged in a tank should not exceed the number intended for use with that tank.

6.3.2 Packing.

6.3.2.1 Level C.

6.3.2.1.1 Unit packs. The tanks with covers attached, tightened in place so as to contact, but not compress, the gaskets, should be packaged in accordance with ASTM D3951 in commercial containers or palletized in such a way as to be acceptable to a common carrier for safe transportation. The contractor should replace immediately, and at his own expense, any tanks, tank covers, or parts thereof, damaged in shipment.

6.3.2.1.2 Cover assembly. Cover assemblies should be packaged in accordance with ASTM D3951 in commercial containers or palletized in such a way as to be acceptable to a common carrier for safe transportation. The contractor should replace immediately, at his won expense, any cover assembly damaged in shipment.

6.3.3 Marking.

6.3.3.1 Special markings. Any special markings required by the contract or purchase order should be provided.

6.3.3.2 Normal markings. In addition to any marking required by the contract or purchase order, each shipping container or pallet load should be marked in accordance with the requirements of MIL-STD-129.

6.4 Subject term (keyword) listing.

Shipping, handling and storage

6.5 Changes from previous issue. Marginal notations are not used to identify changes with respect to the previous issue because of the extensiveness of the changes.

Custodian:
Navy - OS

Preparing activity:
Navy – OS
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