

MIL-F-2980E

6 April 1976

SUPERSEDING

MIL-F-2980D

6 December 1971

MILITARY SPECIFICATION

FIRING ATTACHMENTS, BLANK AMMUNITION

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

1. SCOPE

1.1 This specification covers blank ammunition firing attachments for caliber .30 machine guns, 7.62 millimeter (mm) rifles and machine guns, and 5.56 millimeter (mm) rifles.

1.2 Classification. Blank ammunition firing attachments shall be of the following models, as specified (see 6.2):

Adapter, Blank Firing, Mark 107, Mod. 0
Firing Attachment, Blank Ammunition: M6
Firing Attachment, Blank Ammunition: M9
Firing Attachment Kit, Blank Ammunition: M12
Firing Attachment, Blank Ammunition: M13A1
Firing Attachment, Blank Ammunition, 5.56mm: M15A2

2. APPLICABLE DOCUMENTS

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

SPECIFICATIONS

Military

MIL-P-116	- Preservation-Packaging, Methods of
MIL-W-13855	- Weapons: Small Arms and Aircraft Armament Subsystems, General Specification for
MIL-P-14232	- Parts, Equipment and Tools for Army Materiel, Packaging and Packing of
MIL-I-45607	- Inspection Equipment, Acquisition, Maintenance and Disposition of

FSC 1005

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STANDARDS

Federal

Fed. Std. No. 356 Commercial Packaging of
Supplies and Equipment

Military

MIL-STD-105 Sampling Procedures and Tables
for Inspection by Attributes
MIL-STD-109 Quality Assurance Terms and
Definitions

DRAWINGS

U.S. Navy Ordnance

C3013015 - Adapter, Blank Firing, Mark 107,
Mod. 0

Rock Island Arsenal

C8412139 Attachment, Blank Ammunition
Firing, M6
C7162790 Attachment, Blank Ammunition
Firing, M9
A5910570 Firing Attachment Kit, Blank
Ammunition: M12
C12002981 Firing Attachment Blank
Ammunition, M13A1
C12002900 Blank Firing Attachment,
5.56mm M15A2

PUBLICATIONS

Rock Island Arsenal

IEL8412139 Inspection Equipment List: M6
IEL7162790 Inspection Equipment List: M9
IEL12002981 Inspection Equipment List: M13A1
IEL12002900 Inspection Equipment List: M15A2
P8412139 Packagaing Data Sheet for Attachment,
Blank Ammunition Firing, M6
P7162790 Packaging Data Sheet for Attachment,
Blank Ammunition Firing, M9
P5910570 Packaging Data Sheet for Kit, Firing
Attachment, Blank Ammunition, M12
P12002981 Packaging Data Sheet for Firing Attach-
ment, Blank Ammunition, M13A1
P12002900 Packaging Data Sheet for Firing Attach-
ment, Blank Ammunition, M15A2

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(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. Requirements for submission of first article shall be as specified in the contract (see 6.2). Unless otherwise specified (see 6.2), the first article shall include the pilot pack (see 5.1).

3.2 Materials, construction and design. Blank ammunition firing attachments shall conform to the materials, construction and design requirements specified herein, on drawings C3013015, C8412139, C7162790, A5910570, C12002981 and C12002900 as applicable, and in MIL-W-13855.

3.2.1 Assembleability. Blank ammunition firing attachments shall readily attach to and detach from the specified weapon or a fixture simulating the specified weapon. When attached, firing attachments shall be securely retained on a simulator fixture or the specified weapon.

3.3 Performance characteristics.

3.3.1 Functioning. When assembled to the applicable weapon, the blank firing attachments shall permit the weapon to function properly. There shall be no stoppages or malfunctions directly attributable to the blank ammunition firing attachment. Testing shall be as specified in 4.5.3.2.

3.4 Marking. Blank ammunition firing attachments shall be clearly marked in accordance with the applicable drawing and MIL-W-13855.

3.5 Workmanship. Workmanship shall be in accordance with MIL-W-13855.

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

4.2 Quality assurance terms and definitions. Quality assurance terms and definitions used herein are in accordance with MIL-STD-109.

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

- a. First article inspection (see 4.4)
- b. Quality conformance inspection (see 4.5)

4.4 First article inspection. The first article (initial production unit(s)) shall be submitted for inspection in accordance with contract requirements (see 6.2). The first article shall be representative of the production processes to be used during quantity production. The first article shall be subjected to the quality conformance inspection specified herein and such other inspection deemed necessary to determine that all requirements of the contract have been met.

4.5 Quality conformance inspection.

* 4.5.1 Inspection lot. Unless otherwise specified (see 6.2) the formation, size and presentation of inspection lots shall be in accordance with MIL-STD-105 and MIL-W-13855. Blank firing attachments shall be assembled from component parts that have met all inspection requirements specified herein.

4.5.2 Examination.

* 4.5.2.1 Classification of defects. Classification of defects and acceptable quality levels (AQL's) for examination in accordance with MIL-STD-105 shall be as specified herein and shall include the following provisions:

- a. Unless otherwise specified, AQL's apply to each listed characteristic.
- b. The term "Gage" under "Inspection Method" column indicates the existence of Government gage designs (see applicable Inspection Equipment List).
- c. Where "Visual" is specified as the method of inspection, the sample shall be either scaled or compared with specimen of known acceptable quality.
- d. Where SME (Standard Measuring Equipment) is specified as the method of inspection, the contractor may use any type of industry developed, commercially available, multi-usage equipment or special inspection equipment approved by the Government.
- e. Where "Visual" is specified as the inspection method for protective coating, the coating shall be visually examined for completeness, uniformity in appearance and color, and for freedom from pits, corrosion, scratches, and worn or bare spots.

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- f. Where "Visual" is specified as the inspection method for assemblies, the assembly shall be visually examined for completeness, security, function and conformance to specified requirements.
- g. Alternative inspection methods and equipment may be used by the contractor when such methods and equipment equal or exceed the specified accuracy and provide as a minimum, the quality assurance required in the contractual documents. Prior to applying such alternative inspection methods and inspection equipment, the contractor shall describe them in a written proposal and shall demonstrate for the approval of the Procuring Contracting Officer (PCO) that their effectiveness is equal to or better than the contractual quality assurance method or equipment.

4.5.2.2 Blank ammunition firing attachments except adapter, blank firing, Mark 107, Mod. 0.

<u>Characteristics</u>	<u>AOL</u>	<u>Inspection Method</u>
(1) Missing parts or incorrect assembly	1.0	Visual
(2) Attachment to weapon/fixture	1.0	Gage
(3) Welding, not as specified	2.5	SME
(4) Incorrect or missing part number or markings	2.5	Visual
(5) Discontinuity or missing protective coating	2.5	Visual
(6) Workmanship	4.0	Visual

4.5.2.3 Adapter, blank firing, Mark 107, Mod. 0.

<u>Characteristic</u>	<u>AOL</u>	<u>Inspection Method</u>	<u>Dimension</u>
(1) Diameter gas orifice	1.0	SME	0.089 Dia ± .005
(2) Thread size	100	SME	0.500 - 28 NEF -3B
(3) All other characteristics	2.5	---	

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4.5.3 Testing.

* 4.5.3.1 Failure data. Unless otherwise specified herein, all tests shall be conducted on a complete firing attachment. If test requirements cited herein are not met, acceptance of the firing attachment shall be deferred and the contractor shall accomplish as applicable, the following actions:

- a. Conduct a failure analysis study performing a dimensional, physical and visual examination of the components which are suspected to be the cause of failure or malfunction.
- b. Evaluate and correct the applicable production processes and procedures to prevent recurrence of the same defect(s) in future production.
- c. Examine firing attachments, partially assembled firing attachments, and components (including components and subassemblies at in-process or final assembly) to insure that material containing the same defect is purged from the inventory and not presented to the Government for acceptance.
- d. Submit the results of the failure analysis and the corrective actions taken to the Government for review and approval prior to submitting a reconditioned lot or reconditioned subsystem for retest.

4.5.3.2 Functioning testing. Samples of blank firing attachments shall be taken from each inspection lot in accordance with MIL-STD-105, Level II, using an AQL of 0.65, and shall be tested for functioning (see 3.3.1) using the test methods specified in 4.6.

* 4.5.3.3 Certification. Unless otherwise specified, the contractor shall be responsible for testing necessary to accomplish certification. For each inspection lot, the contractor shall provide the Government representative with Certification of Compliance with applicable drawings and specifications.

* 4.5.3.4 Packaging examination and testing. Unless otherwise specified (see 6.2), the packaging examination and testing shall be in accordance with MIL-P-14232.

4.5.4 Inspection equipment.

4.5.4.1 Acquisition, maintenance and disposition. Unless otherwise specified (see 6.2), responsibility for acquisition, maintenance and disposition of acceptance inspection and test equipment prescribed on Inspection Equipment List IEL8412139, IEL7162790, IEL12002981 and IEL12002900 as applicable, and for all other inspection equipment required to perform inspection prescribed by applicable specifications shall be in accordance with MIL-I-45607.

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4.5.4.2 Accuracy of standard meaasuring equipment. When commercial and modified commercial inspection and test equipment is used, it must be capable of repetitive measurements to an accuracy of 10 percent of the total tolerance of the characteristic being inspected.

4.6 Test methods.

4.6.1 Functioning test. Samples of blank ammunition firing attachments shall be tested for functioning as follows:

4.6.1.1 Firing attachments, M6 and M9. Government standard caliber .30, M1909 blank cartridges and the M1919A4 (Flexible) or M1919A6 machine gun, as applicable, shall be used for testing the M6 and M9 blank ammunition firing attachments. The blank firing attachment shall be assembled to its respective weapon and a belt of fifty rounds fired in bursts of 3 to 5 rounds.

4.6.1.2 Firing attachment kit, blank ammunition, M12. Government standard 7.62mm, M82 blank cartridges and the 7.62mm, M14 rifle shall be used for testing the blank ammunition firing attachments. The blank ammunition firing attachment M12 shall be assembled to the M14 rifle with blank ammunition firing breech shield M3 and 40 rounds fired as follows: 10 rounds semiautomatic (selector set with blank face to the rear); 10 rounds automatic (selector set with the letter "A" facing to the rear) in bursts of approximately 5 rounds each; and 20 rounds automatic in one burst.

4.6.1.3 Firing attachment, M13A1. Government standard 7.62mm blank M82 cartridges and the 7.62mm, M60 machine gun shall be used for testing M13A1 blank ammunition firing attachments. The blank firing attachment shall be assembled to the M60 machine gun and a belt of one hundred rounds fired in bursts of 3 to 5 rounds.

4.6.1.4 Firing attachment, M15A2 and adapter, blank firing, Mark 107, Mod. 0. Government standard 5.56mm, M200 blank cartridges and the 5.56mm, M16 or M16A1 rifle shall be used for testing M15A2 blank ammunition firing attachments and adapter, blank firing, Mark 107, Mod. 0. The blank ammunition firing attachment or adapter shall be assembled to the M16 or M16A1 rifle and 30 rounds fired as follows: 10 rounds fired semiautomatic; 10 rounds fired automatic in 2 bursts of approximately 5 rounds each; and 10 rounds automatic in one burst.

5. PACKAGING

5.1 Pilot pack.

5.1.1 All attachments except adapter, blank firing, Mark 107, Mod. 0. A pilot pack shall consist of a complete blank ammunition firing attachment

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packaged in accordance with Packaging Data Sheet P8412139, P7162790, P5910570, P12002981 or P12002900 as applicable, for the level of protection specified in the contract (see 6.2), packed Level B and forwarded as specified in 3.1.

5.1.2 Adapter, blank firing, Mark 107, Mod. 0. A pilot pack shall consist of a complete blank firing attachment packaged in accordance with 5.2.2.

5.2 Levels A and B.

5.2.1 All attachments except adapter, blank firing, Mark 107, Mod. 0. Packaging shall be in accordance with Packaging Data Sheet P8412139, P7162790, P5910570, P12002981 or P12002900 as applicable, for the level of protection specified in the contract (see 6.2).

5.2.2 Adapter, blank firing, Mark 107, Mod. 0. Packaging shall be in accordance with MIL-P-116, Method 1A-8. Adapters shall be packaged separately. Packages shall be marked with nomenclature and National Stock Number.

5.3 Commercial. Packaging shall be in accordance with Fed. Std. No. 356.

6. NOTES

6.1 Intended use.

6.1.1 Firing attachment, M6. The M6 blank ammunition firing attachment is used with the Cal. .30, M1919A4 (flexible) machine gun.

6.1.2 Firing attachment, M9. The M9 blank ammunition firing attachment is used with the Cal. .30, M1919A6 machine gun.

6.1.3 Firing attachment kit, blank ammunition, M12. The M12 blank ammunition firing attachment is used with the 7.62mm, M14 rifle, and is comprised of the M12 blank ammunition firing attachment and the M3 breech shield.

6.1.4 Firing attachment, M13A1. The M13A1 blank ammunition firing attachment is used with the 7.62mm, M60 machine gun.

6.1.5 Firing attachment, M15A2 and adapter, blank firing, Mark 107, Mod. 0. The M15A2 blank ammunition firing attachment or adapter Mark 107, Mod. 0 is used with the 5.56mm, M16 or M16A1 rifles.

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6.2 Ordering data. Procurement documents should specify the following:

- a. Title number and date of this specification
- b. Lists of drawings, specifications and publications pertinent to the applicable blank ammunition firing attachment, showing applicable revision dates (see 1,2, 2.1 and 3.2).
- c. Shipping instructions for first article (see 3.1, 4.4) and pilot pack (see 3,1 and 5.1).
- d. Inspection lot size, if different (see 4.5.1).
- e. Packaging examination and testing, if different (see 4.5.3.4).
- f. Responsibilities for acquisition, maintenance and disposition of acceptance inspection equipment if other than specified (see 4.5.4).
- g. Selection of applicable level of protection (A or B), or commercial packaging (see 5.1, 5.2 and 5.3).
- h. Provisions for providing ammunition and guns for testing.

6.3 The margins 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.

Custodians:
 Army - WC
 Navy - OS
 Air Force - 84

Preparing activity:
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Project number:
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User activity:
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