MIL-F-45813 (Ord)
19 August 1959

SUPERSEDING
FA(FC)-PD-249
30 October 1958

MILITARY SPECIFICATION

FIXTURE, TEST, FINAL INSPECTION, 8237268; PACKAGING OF

1. SCOPE

1.1 This specification covers the packaging and packing of Test Fixture Final Inspection 8237268 for each level of protection. (See 6.1)

2. APPLICABLE DOCUMENTS

2.1 The following documents, of the issue in effect on date of invitation for bids, form a part of this specification:

SPECIFICATIONS

Federal

UU-T-106	Tape, Masking, Paper (Pressure-Sensitive)
UU-T-111	Tape, Paper Gummed (Sealing and Securing)
LLL-F-291	Fiberboard, Corrugated, Single-Face (Flexible)
PPP-B-601	Boxes, Wood, Cleated Plywood
PPP-B-621	Boxes, Wood, Nailed and Lock-Corner
PPP-B-636	Boxes, Fiber
PPP-C-843	Cushioning Material, Cellulosic
PPP-T-76	Tape, Pressure-Sensitive Adhesive, Paper, Water Resistant

FSC 4931

Military

MIL-P-116	Preservation, Methods of
MIL-B-117	Bags, Interior Packaging
MIL-B-121	Barrier Material, Greaseproofed, Flexible (Waterproofed)
MIL-B-131	Barrier Material; Water Vaporproof, Flexible
MIL-L-3150	Lubricating Oil, Preservative, Medium
MIL-C-3769	Crates Intermediate, Sheathed, Wood Nailed (For maximum net loads of 3000 pounds)
MIL-A-5092	Adhesive, Rubber (Synthetic and Reclaimed Rubber Base)
MIL-C-11796	Corrosion Preventive, Petrolatum, Hot Application
MIL-G-12803	Gasket Material, Nonmetallic

STANDARDS

Military

MIL-STD-105	Sampling Procedure and Tables for Inspection by Attributes
MIL-STD-129	Marking for Shipment and Storage

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

3. REQUIREMENTS

3.1 Materials and methods. - The materials, methods and procedures used in the packaging of items shall be in accordance with this specification. Materials and methods not covered by a specification shall be suited to the intended use and subject to the approval of the contracting officer.

3.1.1 Materials. - The following shall apply wherever packaging materials are referred to in this specification by name only:

REFERENCE	FULL IDENTIFICATION
Fiberboard box	Class 2 or 3, any compliance symbol and any style, except FTC, TS, OPF and FPF, of Specification PPP-B-636.
Flexible greaseproofed barrier material	Type II, grade A, class 2 of Specification MIL-B-121
Flexible single-face corrugated fiberboard	Type II of Specification LLL-F-291
Gummed tape	Class 2 of Specification UU-T-111
Pressure-sensitive tape	Specification UU-T-106
Water-vaporproof bag	Type I, class e of Specification MIL-B-117

3.2 Size of containers. - Bags, boxes, and exterior containers shall be of a minimum size that will adequately contain the items.

3.3 Preservation and packaging

3.3.1 Level A

3.3.1.1 Disassembling. - The simulated gun trunnion, stand and base locking bolts shall be removed from test fixture. Leveling screws shall be backed off so that the screws will not protrude beyond the bottom of the base of the fixture.

3.3.1.2 Cleaning. - Cleaning process C-1 of Specification MIL-P-116 shall be followed to clean all surfaces of the test fixture, gun trunnion, stand, locking bolts, cant blocks, trunnion adjusting rods, and screw collet.

3.3.1.3 Drying. - Immediately after cleaning, the items shall be thoroughly dried in accordance with any applicable procedure specified in Specification MIL-P-116 that will not damage the items.

3.3.1.4 Preservative application. - All unprotected metal surfaces of the test fixture, gun trunnion, stand, locking bolts, cant blocks, trunnion adjusting rods, and screw collet shall be coated with preservative conforming to class 3 of Specification MIL-P-11796 (P-6 of Specification MIL-P-116). Preservative shall be applied on the unprotected surfaces by the brushing procedure specified in Specification MIL-P-116. Excess preservative shall be removed.

3.3.1.5 Unit packaging. - The test fixture, gun trunnion, stand, lock bolts, cant blocks, trunnion adjusting rods and screw collet shall be packaged as described herein, which is in conformance with the following packaging methods specified in Specification MIL-P-116:

ITEM	METHOD
Screw collet	IA-8
Cant blocks	IA-8
Trunnion adjusting rods	IA-8
Gun trunnion	IA-8
Stand and lock bolts	I
Test fixture	IA-16

3.3.1.5.1 Screw collet

3.3.1.5.1.1 Wrapping screw collet. - The screw collet shall be wrapped with flexible greaseproofed barrier material and overwrapped with flexible single-face corrugated fiberboard. The flexible greaseproofed barrier wrap shall be secured in place with pressure-sensitive tape. The flexible single face corrugated fiberboard overwrap shall be secured in place with gummed tape.

3.3.1.5.1.2 Bagging screw collet. - The wrapped screw collet shall be placed in a water-vaporproof bag. Air shall be exhausted from the bag prior to sealing. The sealed bag shall pass the heat seal and quick leak tests of Specification MIL-P-116.

3.3.1.5.1.3 Fiberboard box. - The bagged screw collet shall be immobilized in a fiberboard box. Closure of fiberboard box shall be with tape conforming to Specification PPP-T-76 as specified in the appendix of Specification PPP-B-636.

3.3.1.5.2 Cant blocks.

3.3.1.5.2.1 Wrapping cant blocks. - Each of the four cant blocks (minus 5 degrees, plus 5 degrees, plus 10 degrees and plus 15 degrees) shall be wrapped with flexible greaseproofed barrier material and overwrap each barrier wrapped cant block with flexible single-face corrugated fiberboard. Each flexible greaseproofed barrier wrap shall be secured in place with pressure-sensitive tape. Each flexible single-face corrugated fiberboard overwrap shall be secured in place with gummed tape.

3.3.1.5.2.2 Bagging wrapped blocks. - Each wrapped cant block shall be placed in a water-vaporproof bag. Exhausting air, sealing the bag, and tests shall be as specified in 3.3.1.5.1.2.

3.3.1.5.2.3 Fiberboard box. - Each bagged cant block shall be immobilized in a fiberboard box conforming to class 2 or 3, any compliance symbol and any style of Specification PPP-B-636. The box shall be closed as specified in 3.3.1.5.1.3.

3.3.1.5.3 Trunnion adjusting rods.

3.3.1.5.3.1 Wrapping trunnion adjusting rods. - Each of the two adjusting rods shall be wrapped separately with flexible greaseproofed barrier material and each wrapped rod shall be overwrapped with flexible single face corrugated fiberboard. Each flexible greaseproofed barrier wrap shall be secured in place with pressure-sensitive tape. Each flexible single face corrugated fiberboard overwrap shall be secured in place with gummed tape. The wrapped rods shall be taped together with pressure-sensitive tape in such a fashion that the hand crank wheels will be at opposite ends from each other.

3.3.1.5.3.2 Bagging wrapped trunnion adjusting rods and immobilizing in fiberboard box. - The wrapped trunnion adjusting rods shall be placed in a water-vaporproof bag. Exhausting air, sealing the bag, and tests shall be as specified in 3.3.1.5.1.2. The bagged adjusting rods shall be immobilized in a fiberboard box. The fiberboard box shall be closed as specified in 3.3.1.5.1.3.

3.3.1.5.4 Gun trunnion

3.3.1.5.4.1 Wrapping gun trunnion. - The gun trunnion shall be wrapped with flexible greaseproofed barrier material and overwrapped with two thicknesses of flexible single-face corrugated fiberboard. The flexible greaseproofed barrier wrap shall be secured in place with pressure-sensitive tape. The flexible single face corrugated fiberboard overwrap shall be secured in place with gummed tape.

3.3.1.5.4.2 Bagging wrapped gun trunnion and immobilizing in fiberboard box. - The wrapped gun trunnion shall be placed in a water-vaporproof bag. Exhausting air, sealing the bag and tests shall be as specified in 3.3.1.5.1.2. The bagged gun trunnion shall be immobilized in a fiberboard box. The fiberboard box shall be closed as specified in 3.3.1.5.1.3.

3.3.1.5.5 Stand and lock bolts. - The stand shall be wrapped with flexible greaseproofed barrier material and overwrapped with two thicknesses of flexible single face corrugated fiberboard. The flexible greaseproofed barrier wrap shall be secured in place with pressure-sensitive tape. The flexible single face corrugated fiberboard overwrap shall be secured in place with gummed tape. Locking bolts shall be placed together and wrapped with flexible greaseproofed barrier material and taped to the wrapped stand with pressure-sensitive tape.

3.3.1.5.6 Test fixture.

3.3.1.5.6.1 Covering preservative coated surfaces. - All preservative coated surfaces of the test fixture shall be wrapped or covered with flexible greaseproofed barrier material. The flexible greaseproofed barrier material shall be secured in place with pressure-sensitive tape.

3.3.1.5.6.2 Immobilizing test table. - The zero degree cant block shall be placed in the proper position between the base and the test table of the test fixture. The zero degree cant block shall be locked in place for shipping by securing the base and the test table together with threaded hooks and turnbuckle. The hooks shall be attached to the table section and base section by any suitable arrangement.

3.3.1.5.6.3 Cushioning sharp corners and projections. - All sharp corners and projections shall be covered with 1/2 inch thick cellulosic cushioning material conforming to any type, class c of Specification PPP-C-843. The cellulosic cushioning material shall be secured in place with pressure-sensitive tape.

3.3.1.5.6.4 Water-vaporproof barrier and gaskets. - Water-vaporproof barrier material, conforming to class 1 of Specification MIL-B-131, shall be used in fabricating the floating bag. Appropriate size bolt holes shall be made in the barrier material to permit the bolts to pass through for securing the fixture to the load bearing members of the crate as specified in 3.4.1.2.3. The holes shall be located in such a manner that they coincide with the locking bolt holes in the base of the test fixture. Gaskets, with appropriate size bolt holes, shall be cemented to each side of the water-vaporproof barrier in such

a manner that the holes in the gaskets and the holes of the water-vaporproof barrier material coincide. The gaskets shall be fabricated from material conforming to type I, any class, group 2, grade 2 of Specification MIL-G-12803. The adhesive used to cement the gaskets in place shall conform to type III of Specification MIL-A-5092. The size of the gaskets shall be such that protection is provided for the barrier between the load bearing surface of the crate and the base of the test fixture.

3.3.2 Level C.

3.3.2.1 Disassembling, cleaning and drying. - Disassembling, cleaning and drying shall be as specified in 3.3.1.1, 3.3.1.2 and 3.3.1.3.

3.3.2.2 Preservative application. - Preservative application shall be as specified in 3.3.1.4, except that the preservative shall conform to Specification MIL-L-3150(P-7 of Specification MIL-P-116).

3.3.2.3 Unit packaging. - The test fixture, gun trunnion, stand, lock bolts, cant blocks, trunnion adjusting rods, and screw collet shall be packaged as described herein which is in conformance with Method I of Specification MIL-P-116.

3.3.2.3.1 Screw collet. - The screw collet shall be packaged as specified in 3.3.1.5.1.1 to 3.3.1.5.1.3 inclusive, except that the bag, specified in 3.3.1.5.1.2, shall be omitted and the fiberboard box, specified in 3.3.1.5.1.3, shall conform to type I or II, class 1, any style, except FTC, TS, OPF and FPF of Specification PPP-B-636. The fiberboard box shall be closed as specified in the appendix of Specification PPP-B-636.

3.3.2.3.2 Cant blocks. - The cant blocks shall be packaged as specified in 3.3.1.5.2.1 to 3.3.1.5.2.3 inclusive, except that the bag specified in 3.3.1.5.2.2 shall be omitted and the fiberboard box, specified in 3.3.1.5.2.3, shall conform to type I or II, class 1, any style of Specification PPP-B-636. The fiberboard box shall be closed as specified in the appendix of Specification PPP-B-636.

3.3.2.3.3 Trunnion adjusting rods. - The trunnion adjusting rods shall be packaged as specified in 3.3.1.5.3.1 and 3.3.1.5.3.2, except that the bag specified in 3.3.1.5.3.2 shall be omitted and the fiberboard box, specified in 3.3.1.5.3.2, shall conform to the characteristics (except for size) of the box specified in 3.3.2.3.1. The box shall be closed as specified in 3.3.2.3.1.

3.3.2.3.4 Gun trunnion. - The gun trunnion shall be packaged as specified in 3.3.1.5.4.1 and 3.3.1.5.4.2, except that the bag specified in 3.3.1.5.4.2 shall be omitted and the fiberboard box, specified in 3.3.1.5.4.2, shall conform to the characteristics (except for size) of the box specified in 3.3.2.3.1. The box shall be closed as specified in 3.3.2.3.1.

3.3.2.3.5 Stand and locking bolts. - The stand and the locking bolts shall be packaged as specified in 3.3.1.5.5.

3.3.2.3.6 Test fixture. - The test fixture shall be packaged as specified in 3.3.1.5.6.1 and 3.3.1.5.6.2.

3.4 Packing.

3.4.1 Level A.

3.4.1.1 Packaged loose fixture items.

3.4.1.1.1 Container. - The packaged screw collet, cant blocks, trunnion adjusting rods, and gun trunnion shall be immobilized in a box conforming to one of the following specifications:

PPP-B-601 - Any style under domestic type
PPP-B-621 - Class 1 (domestic type), style 2 or 4

3.4.1.1.2 Closure of container. - The container shall be closed as specified in the applicable container specification.

3.4.1.2 Shipping container, fixture, and securing the items.

3.4.1.2.1 Shipping container. - The shipping container shall be a wood sheathed crate constructed to conform with Specification MIL-C-3769, except that the base of the crate shall be constructed with 3 skids so positioned that the mounting bolts will pass through the center of the width of the skids. The inside dimensions of the shipping container shall be such that adequate base space shall be provided for the wood box containing the packaged items and for the packaged stand and lock bolts which are strapped to the base of the test fixture as specified in 3.4.1.2.3. A clearance of at least two inches shall be maintained between the floating bag and the crate members.

3.4.1.2.2 Drilling bolt holes. - Appropriate size bolt holes shall be drilled through the load bearing members and the 3 skids. The holes shall be located in such a manner that the holes in the load bearing floor members

of the crate base will coincide with the bolt holes in the fixture base when the fixture is positioned on the load bearing floor members of the skid.

3.4.1.2.3 Positioning and securing items to base of crate that will be inclosed in the water-vaporproof barrier. - Cement, conforming to the cement specified in 3.3.1.5.6.4, shall be applied to the surfaces of the gaskets on the water-vaporproof barrier that will contact the load bearing floor members of the crate. The water-vaporproof barrier shall then be positioned on the base of the crate in such a manner that the bolt holes in the load bearing floor members, gaskets, and water-vaporproof barrier coincide. The test fixture shall then be positioned on the gasketed water-vaporproof barrier so that the bolt holes in the base of the test fixture coincide with the other holes. The fixture shall be secured to the crate base with zinc or cadmium coated 3/4 inch diameter step bolts, flat washers, lock washers and nuts. The step bolts shall be adequate in length to pass through the skid, floor member of the crate, water-vaporproof barrier, base of the test fixture and provide ample thread length for bolting. Unthinned paint shall be applied on the exposed threads above the nuts to prevent backing off. The packged stand with lock bolts shall be secured to the base of the test fixture with metal strapping. Metal strapping shall not interfere with the turnbuckle arrangement specified in 3.3.1.5.6.2.

3.4.1.2.4 Water-vaporproof bag. - The water-vaporproof barrier material shall be heat sealed in such a manner as to form a bag that will pass the heat seal and quick leak tests of Specification MIL-P-116. Entrapped air shall be exhausted prior to final closure.

3.4.1.2.5 Securing wood box containing packaged fixture items. - The wood container containing the packaged fixture items shall be secured to the base of the crate in such a manner that it will remain secured in place during transportation.

3.4.1.2.6 Sides, end and top panels of shipping container. - The sides, ends and top panels of the shipping container shall be constructed and assembled as specified in Specification MIL-C-3769.

3.4.2 Level C. - Packing shall be as specified in 3.4.1.1 to 3.4.1.2.6 inclusive, except as follows:

(a) The water-vaporproof barrier specified in 3.4.1.2.3 shall be omitted.

(b) The bolts, flat washers, lock washers and nuts need not be zinc or cadmium coated as specified in 3.4.1.2.3.

(c) Since there is no water-vaporproof barrier, 3.4.1.2.4 is not applicable.

3.5 Marking.

3.5.1 Interior packages. - Each bag and each box shall be marked in accordance with Standard MIL-STD-129.

3.5.2 Shipping container. - Each shipping container shall be marked in accordance with Standard MIL-STD-129. The serial number of the test fixture shall be added in the identification data on the crate for Level A and omitted on the crate for Level C.

3.5.3 Stock number. - The stock number to be added in the identification data shall be obtained from the contracting officer.

3.6 Pilot pack. - Prior to quantity production a pilot pack, consisting of a complete and packed shipping container shall be inspected to determine conformance with the applicable requirements of this specification for Level A or C.

3.7 Workmanship. - All operations involved in accomplishing corrosion prevention, preservation, packaging, and packing by the procedures specified herein shall be in accordance with the highest grades of practice associated with this type of work.

4. QUALITY ASSURANCE PROVISIONS

4.1 General quality assurance provisions

4.1.1 Contractor inspection. - Unless otherwise specified herein, the supplier is responsible for the performance of all inspection requirements prior to submission for Government inspection and acceptance. Except as otherwise specified, the supplier may utilize his own facilities or any commercial laboratory acceptable to the Government. Inspection records of the examinations and tests shall be kept complete and available to the Government as specified in the contract or order.

4.1.2 Contractor quality assurance system. - The contractor shall provide and maintain an effective quality assurance system acceptable to the Government covering the supplies under this contract. A current written description of the system shall be submitted to the contracting officer prior to initiation of production. The written description will be considered acceptable when, as a minimum, it provides the quality assurance required by the

specification and other documents referenced in this specification. The contractor will not be restricted to the inspection station or to the method of inspection listed provided that the substitute procedures will provide, as a minimum, the quality assurance required in the contractual documents. In cases of dispute as to whether certain procedures of the system provide equal assurance, the comparable procedure of this specification shall be used. The contractor shall notify the Government of, and obtain approval for, any change to the written procedure that affects the degree of assurance required by this specification or other documents referenced therein.

4.1.3 Government verification. - All quality assurance operations performed by the contractor will be subject to Government verification at unscheduled intervals. Verification will consist of surveillance of the operations to determine whether the practices, methods, and procedures of the written inspection plan are being properly applied, and Government product inspection, when deemed necessary by the Government, to measure quality product offered for acceptance. Deviation from the prescribed or agreed-upon procedures, or instances of poor practices which might have an affect upon the quality of the product will immediately be called to the attention of the contractor. Failure of the contractor to promptly correct deficiencies discovered will be cause for suspension of acceptance until correction has been made or until conformance of product to prescribed criteria has been demonstrated. To avoid interference with operations, the contractor will designate a responsible official or officials to whom the Government inspector will report such instances.

4.2 Inspection provisions. - Quality assurance provisions specified in Specification MIL-P-116 shall apply where applicable and are not in conflict with the provisions specified herein.

4.2.1 Control of materials. - Materials shall be tested to determine conformance to contractually applicable specifications. Such tests may be conducted in the prime contractor's or subcontractor's facilities, or in other suitably equipped laboratories. The test results shall be available to the Government inspector for review. Certified test reports, identifiable with the material, may be accepted in lieu of repeated tests. The Government reserved the right, in any case, to require retests to assure that the materials are acceptable.

4.2.2 Lot formation. - Unless otherwise specified by the contracting officer, or his representative, inspection lot sizes and lot formation shall be in accordance with Standard MIL-STD-105.

4.2.3 Examination. - The classification of defects in Table II shall constitute the minimum inspection requirements to be performed prior to acceptance or rejection by lot. The Government reserves the right to inspect for any applicable requirement and to reject individual non-conforming items.

4.2.3.1 All rejected lots shall be screened for all defective characteristics. After corrections have been made and the Government inspector informed of the corrective action taken, the lot shall be resubmitted for acceptance inspection as outlined in Standard MIL-STD-105.

TABLE I - CLASSIFICATION OF DEFECTS

The characteristics listed in Table 1 shall be inspected on a 100% basis.

		Req't Par.	Test Method
1.	Disassembly of fixture not as specified (Level A, C)	3.3.1.1 3.3.2.1	Visual
2.	Cleanliness of test fixture, components and packaging materials (Level A, C)	3.3.1.2 3.3.2.1	MIL-P-116 Visual
3.	Improper and/or inadequate drying of test fixture and components (Level A, C)	3.3.1.3 3.3.2.1	Visual
4.	Preservation application not as specified (Level A, C)	3.3.1.4 3.3.2.2	Visual
5.	Screw collet not wrapped as specified (Level A, C)	3.3.1.5.1.1 3.3.2.3.1	Visual
6.	Water-vaporproof bag containing screw collet damaged, improperly sealed (Level A)	3.3.1.5.1.2	Visual
7.	Insufficient vacuum within water-vaporproof bag (Level A)	3.3.1.5.1.2	Visual
8.	Screw collet not immobilized as specified (Level A, C)	3.3.1.5.1.3 3.3.2.3.1	Visual-Tactile

TABLE I - CLASSIFICATION OF DEFECTS (Cont'd)

		Req't Par.	Test Method
9.	Cant blocks -5°, +5°, +10°, +15° not wrapped as specified (Level A, C)	3.3.1.5.2.1	Visual
10.	Water-vaporproof bag containing cant blocks damaged, improperly sealed (Level A)	3.3.1.5.2.2	Visual
11.	Insufficient vacuum within water-vaporproof bag (Level A)	3.3.1.5.2.2	Visual
12.	Cant blocks not immobilized as specified (Level A, C)	3.3.1.5.2.3 3.3.2.3.2	Visual-Tactile
13.	Trunnion adjusting rods not wrapped as specified (Level A, C)	3.3.1.5.3.1 3.3.2.3.3	Visual
14.	Water-vaporproof, containing trunnion adjusting rods, damaged, improperly sealed (Level A)	3.3.1.5.3.2	Visual
15.	Insufficient vacuum within water-vaporproof bag (Level A)	3.3.1.5.3.2	Visual
16.	Trunnion adjusting rods not immobilized as specified (Level A, C)	3.3.1.5.3.2 3.3.2.3.3	Visual-Tactile
17.	Gun trunnion not wrapped as specified (Level A, C)	3.3.1.5.4.1 3.3.2.3.4	Visual
18.	Water-vaporproof bag, containing gun trunnion, damaged, improperly sealed (Level A)	3.3.1.5.4.2	Visual
19.	Insufficient vacuum within water-vaporproof bag (Level A)	3.3.1.5.4.2	Visual
20.	Gun trunnion not wrapped as specified (Level A, C)	3.3.1.5.4.2 3.3.2.3.4	Visual

TABLE I - CLASSIFICATION OF DEFECTS (Cont'd)

		Req't Par.	Test Method
21.	Stand and lock bolts not wrapped as specified (Level A, C)	3.3.1.5.5 3.3.2.3.5	Visual
22.	Lock bolts not secured to stand as specified (Level A, C)	3.3.1.5.5 3.3.2.3.5	Visual
23.	Test fixture not wrapped as specified (Level A, C)	3.3.1.5.6.1 3.3.2.3.6	Visual
24.	Base, zero degree cant block and test table not immobilized as specified (Level A, C)	3.3.1.5.6.2 3.3.2.3.6	Visual-Tactile
25.	Projections, sharp corners not protected as specified (Level A)	3.3.1.5.6.3	Visual
26.	Water-vaporproof floating bag w/gaskets not fabricated, not positioned and secured as specified (Level A)	3.3.1.5.6.4 3.4.1.2.3	Visual
27.	Packaged screw collet, cant blocks, trunnion adjusting rods, gun trunnion not immobilized in box (Level A, C)	3.4.1.1.1 3.4.2	Visual-Tactile
28.	Box and closure of box not as specified (Level A, C)	3.4.1.1.1 3.4.1.1.2 3.4.2	Standard Measuring Equipment (SME) PPP-B-601 PPP-B-621
29.	Shipping container not conforming to specifications (Level A, C)	3.4.1.2.1 3.4.1.2.2	SME MIL-C-3769
30.	Packing hardware not as specified (Level A)	3.4.1.2.3	Visual
31.	Fixture not secured to base as specified (Level A, C)	3.4.1.2.3 3.4.2	Visual

TABLE I - CLASSIFICATION OF DEFECTS (Cont'd)

		Req't Par.	Test Method
32.	Water-vaporproof floating bag damaged, improperly sealed (Level A)	3.4.1.2.4	Visual
33.	Packaged fixture items not secured to base as specified (Level A, C)	3.4.1.2.5 3.4.2	Visual-Tactile
34.	Markings illegible, incorrect, not conforming to specifications (Level A, C)	3.5	Visual MIL-P-116 MIL-STD-129
35.	Workmanship (Level A, C)	3.7	Visual

TABLE II - CLASSIFICATION OF DEFECTS

Use Inspection Level L7, and Sampling Plan Table IV-A of Standard MIL-STD-105

MAJOR: AQL 6.5		Req't Par.	Test Method
1.	Heat seal (Level A)	3.3.1.5.1.2 3.3.1.5.2.2 3.3.1.5.3.2 3.3.1.5.4.2	MIL-P-116
2.	Quick leak (Level A)	3.3.1.5.1.2 3.3.1.5.2.2 3.3.1.5.3.2 3.3.1.5.4.2	MIL-P-116
3.	Preservative retention (Level A, C)	3.3.1.4 3.3.2.2	MIL-P-116
4.	Vacuum retention (Level A)	3.4.1.2.4	MIL-P-116

4.3 Test methods and procedures.

4.3.1 Pilot pack. - A pilot pack shall be inspected by the contractor or his agent and witnessed by the Government inspector to determine conformance with the requirements of this specification for the packaging and packing levels specified.

4.3.1.1 Pilot pack failure. - Should the pilot pack fail to pass the test for Government acceptance, production of those components causing rejection will cease until the defective characteristics have been corrected in the process used to produce the pilot pack. When corrections in the process have been made, a new pilot pack shall be completely inspected by the contractor and witnessed by the government inspector.

4.3.2 Sample packs for heat seal, quick leak, preservative retention and vacuum retention shall be selected from acceptable packs of the sample that has met the minimum inspection requirements listed in Table I of 4.2.

4.3.3 Cleanliness, rough handling, heat seal, quick leak, preservative retention and vacuum retention test shall be conducted as specified in Specification MIL-P-116.

5. PREPARATION FOR DELIVERY

5.1 There are no applicable requirements.

6. NOTES

6.1 Intended use. - This specification covers the packaging and packing of test fixtures used in the final inspection of Telescope Mounts, M99 (T197) series.

6.2 Ordering data. - Procurement documents should specify the following:

(a) Title, number and date of this specification.
(b) Selection of applicable levels of preservation, packaging and packing.

6.3 Definitions.

6.3.1 Standard measuring equipment. - Standard measuring equipment includes the common handtype measuring devices which are usually stocked by commercial supply houses for ready supply (shelf items), and which are normally used by an inspector to perform dimensional inspection of items under procurement. This category also includes commercial testing equipment.

6.3.2 Tactile. - Skillful manipulation or sensing.

NOTICE: When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility nor any obligation whatsoever; and the fact that the Government may have formulated, furnished, or in any way supplied the said drawings, specifications, or other data is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any invention that may in any way be related thereto.

Custodian:

Army - Ordnance Corps

Preparing Activity:

Army - Ordnance Corps