

INCH-POUND

MIL-F-48382A (AR)
AMENDMENT 1
27 January 1989

MILITARY SPECIFICATION

FUZE, M934E6, IMPACT SWITCH FOR

This Amendment forms part of Military Specification MIL-F-48382A (AR), dated 1 July 1985, and is approved for use within the U.S. Army Armament Munitions and Chemical Command, and is available for use by all Departments and Agencies of the Department of Defense.

PAGE 4

Add new paragraph 3.2.11 as follows:

"3.2.11 Solderability. The solderability shall meet the requirements of MIL-STD-202, Method 208."

Delete page 7 in its entirety.

Add new page 7A.

Add new page 7B.

Delete page 17 in its entirety.

Add new page 17.

Delete page 18 in its entirety.

Add new page 18.

PAGE 20

4.5.5 Particle impact noise detection (PIND).

Delete "along S-T axis" and substitute "perpendicular to the M-N axis"

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4.5.10 Shock-operating.

Delete "free-fall".

Delete "Parallel to the M-N axis in an N to M direction" and substitute "Parallel to the M-N axis in a direction to move the switch weight towards contact."

Add new paragraph 4.5.11 as follows:

"4.5.11 Solderability. Solderability shall be performed as specified in MIL-STD-202, Method 208, with the exception that the aging requirement shall be one hour."

6.4 Submission of designs for approval.

Delete "Dover, NJ 07801-5000." and substitute "Picatinny Arsenal, NJ 07806-5000.".

Custodian:
Army-AR:

Preparing Activity:
Army-AR:
(Project 1336-A568)

TABLE 1 FIRST ARTICLE INSPECTION

MIL-F-48382A (AR)
Amendment 1

CLASSIFICATION OF DEFECTS & TESTS

PARAGRAPH	TITLE	NO. OF SAMPLE UNITS	AQL OR 100%	SHEET OF	DRAWING NUMBER
	SWITCH ASSEMBLY, IMPACT, AND COMPONENTS			1 2	9297012
					NEXT HIGHER ASSEMBLY
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE /INSPECTION METHOD
	SWITCH ASSEMBLY, IMPACT Group A 1/	6			
	Soft Solder at Screw End Missing or Improper Adhesive at Terminal Stud Missing or Improper Insulation Dimension Insulation of Contact Soldering in Accordance with MIL-S-45743 Marking Workmanship Steady State Acceleration Sensitivity Velocity Change Sensitivity Resistance Insulation Resistance Particle Detection Solderability			3.4 3.4 3.3 3.4 3.4 3.4 3.7 3.2.1 3.2.2 3.2.3 3.2.4 3.2.5 3.2.11	Visual Visual Gage Visual Visual Visual Visual 4.5.1/Gage 4.5.2/Gage 4.5.3/Gage 4.5.4/Gage 4.5.5/Gage 4.5.11

NOTES:

- 1/ Destructive Test
- 2/ 1/2 Hot 1/2 Cold. The units subjected to hot temperature shall be subjected to hot operating temperature. The units subjected to cold temperature shall be subjected to cold operating temperature.
- 3/ Initiate test within 5 minutes of removal from temperature chamber, with temperatures per note 2 (above).

TABLE 1 FIRST ARTICLE INSPECTION

MIL-F-48382A (AR)
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CLASSIFICATION OF DEFECTS & TESTS

PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	SHEET		DRAWING NUMBER
				AQL OR 100%	OF 2	
	SWITCH ASSEMBLY, IMPACT, AND COMPONENTS				2	9297012
CATEGORY						NEXT HIGHER ASSEMBLY
						PARAGRAPH REFERENCE / INSPECTION METHOD
	Group B 1/ Environmental Sequence		12			
	Soft Solder at Screw End Missing or Improper				3.4	Visual
	Adhesive at Terminal Stud Missing or Improper				3.4	Visual
	Insulation Dimension				3.3	Gage
	Insulation of Contact				3.4	Visual
	Soldering in Accordance with MIL-S-45743				3.4	Visual
	Marking				3.7	Visual
	Workmanship				3.2.8	4.5.8
	Temperature 2/				3.2.6	4.5.6
	Transportation Vibration 2/				3.2.9	4.5.9
	Vibration-Acceleration Operating 2/				3.2.7	4.5.7
	Handling Shock 3/				3.2.10	4.5.10
	Shock, Operating 3/				3.2.1	4.5.1/Gage
	Steady State Acceleration Sensitivity				3.2.2	4.5.2/Gage
	Velocity Change Sensitivity				3.2.3	4.5.3/Gage
	Resistance 3/				3.2.4	4.5.4/Gage
	Insulation Resistance				3.2.5	4.5.5/Gage
	Particle Detection					

NOTE:

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QUALITY CONFORMANCE INSPECTION

CLASSIFICATION OF DEFECTS & TESTS

PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	SHEET OF 1 2	DRAWING NUMBER 9297012 NEXT HIGHER ASSEMBLY 9297045 PARAGRAPH REFERENCE / INSPECTION METHOD
4.4.2.8	SWITCH ASSEMBLY, IMPACT					
CATEGORY						
Major 101	SWITCH ASSEMBLY, IMPACT Group A					
102	Softer Solder at Screw End Missing or Improper	3.4	0.25%			Visual
103	Adhesive at Terminal Stud Missing or Improper	3.4	0.25%			Visual
104	Insulation Dimension	3.3	0.25%			Gage
105	Insulation of Contact	3.4	0.25%			Visual
106	Solder in Accordance with MIL-S-45743	3.4	0.25%			Visual
107	Steady State Acceleration Sensitivity	3.2.1	100%			4.5.1
108	Velocity Change Sensitivity	3.2.2	100%			4.5.2/Gage
109	Resistance	3.2.3	100%			4.5.2/Gage
110	Insulation Resistance	3.2.4	100%			4.5.4/Gage
	Particle Detection	3.2.5	100%			4.5.5/Gage
Minor 201	Marking	3.4	0.40%			Visual
202	Workmanship	3.7	0.40%			Visual

NOTES:

- 1/Destructive Test.
- 2/1/2 Hot 1/2 Cold. The units subjected to hot temperature shall be subjected to hot operating temperature. The units subjected to cold temperature shall be subjected to cold operating temperature.
- 3/Initiate test within 5 minutes of removal from temperature chamber, with temperatures per note 2 (above).
- 4/Test sample 5% of the lot but not less than 5 units, with no defects permitted.

AMSMC Form 1570a, 1 Apr 85

Replaces DRDAR-QA Form 160a, 1 Jun 83, which may not be used.

QUALITY CONFORMANCE INSPECTION

CLASSIFICATION OF DEFECTS & TESTS

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PARAGRAPH	TITLE	NO. OF SAMPLE UNITS	AQL OR 100%	SHEET OF 2	DRAWING NUMBER
4.4.2.8	SWITCH ASSEMBLY, IMPACT			2	9297012
CATEGORY	EXAMINATION OR TEST			REQUIREMENT PARAGRAPH	NEXT HIGHER ASSEMBLY 9297045 PARAGRAPH REFERENCE /INSPECTION METHOD
Major 111 112 113 114 115 116 117 118 119 120	Group B 1/ Environmental Sequence Temperature 2/ Transportation Vibration 2/ Vibration-Acceleration Operating 2/ Handling Shock 3/ Shock, Operating 3/ Steady State Acceleration Sensitivity 3/ Velocity Change Sensitivity 3/ Resistance 3/ Insulation Resistance Particle Detection	4/		3.2.8 3.2.6 3.2.9 3.2.7 3.2.10 3.2.1 3.2.2 3.2.3 3.2.4 3.2.5	4.5.8 4.5.6 4.5.9 4.5.7 4.5.10 4.5.1/Gage 4.5.2/Gage 4.5.3/Gage 4.5.4/Gage 4.5.5/Gage
Minor 203 204 205	Marking Workmanship Solderability			3.4 3.7 3.2.11	Visual Visual 4.5.11

NOTE: