

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

## CLASSIFICATION OF DEFECTS &amp; TESTS

| PARAGRAPH | TITLE                                   | EXAMINATION OR TEST                           | NO. OF SAMPLE UNITS | AQL OR 100%           | SHEET                |   | DRAWING NUMBER                          |
|-----------|---|---|---------------------|-----------------------|----------------------|---|---|
|           |   |   |                     |                       | OF                   | 2 |   |
| CATEGORY  | SWITCH ASSEMBLY, IMPACT, AND COMPONENTS |   |                     | REQUIREMENT PARAGRAPH | NEXT HIGHER ASSEMBLY |   |   |
|           |   |   |                     |                       |                      |   | PARAGRAPH REFERENCE / INSPECTION METHOD |
|           |   | Group B 1/<br>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:

**CLASSIFICATION OF DEFECTS & TESTS**

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

QUALITY CONFORMANCE INSPECTION

CLASSIFICATION OF DEFECTS & TESTS

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

NOTE: