

MIL-F-48388A (AR)
 AMENDMENT 1
 27 January 1989

MILITARY SPECIFICATION

FUZE, M934E6, LAUNCH SENSING SWITCH FOR

This Amendment forms part of Military Specification MIL-F-48388A (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 3

Delete paragraph 3.2.5 in its entirety.

Add new paragraph 3.2.5 as follows:

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

Delete page 6 in its entirety.

Add new page 6A.

Add new page 6B.

PAGE 18

Paragraph 4.4.2.9 Major category:

Major 101: In column labeled "Para. Ref. / Insp. Meth.", delete "Gage" and substitute "Visual".

Delete page 20 in its entirety.

Add new page 20.

Delete page 21 in its entirety.

Add new page 21.

PAGE 22

Delete paragraph 4.5.2 in its entirety and substitute the following:

AMSC N/A

FSC 1336

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"4.5.2 Closing time. The switch shall be mounted on a shock machine capable of producing a 30 g minimum square wave pulse of 17 milliseconds minimum duration. An accelerometer shall be mounted on the drop fixture to measure the shock pulse. The accelerometer's wave form may be low-pass filtered with a minimum band width of 200 Hz. Data shall be recorded showing the shock pulse and closure time of the launch switch using a storage oscilloscope. The wave form shall be recorded (eg. photograph, plotter trace) to provide a permanent record of the test. To verify switch closing time, the launch switch shall be subjected to an acceleration in a direction to move the switch weight towards contact along the longitudinal M-N axis of figure 1."

PAGE 23

Delete paragraph 4.5.5 in its entirety.

Add new paragraph as follows.

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

4.5.10 Shock, operating.

Delete "free-fall".

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

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-A569)

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TABLE I FIRST ARTICLE INSPECTION

CLASSIFICATION OF DEFECTS & TESTS

| PARAGRAPH | TITLE | EXAMINATION OR TEST | NO. OF SAMPLE UNITS | SHEET OF | | DRAWING NUMBER |
|-----------|---|--|---------------------|-------------|--|---|
| | | | | AQL OR 100% | REQUIREMENT PARAGRAPH | |
| | SWITCH ASSEMBLY, LAUNCH, AND COMPONENTS | | | | 1 2 | 9297015 NEXT HIGHER ASSEMBLY |
| CATEGORY | | | | | | PARAGRAPH REFERENCE / INSPECTION METHOD |
| | SWITCH ASSEMBLY, LAUNCH Group A 1/ | Marking Workmanship Launch Acceleration Sensing Lead Resistance Insulation Resistance Solderability | 6 | | 3.1 3.5 3.2.1 3.2.3 3.2.4 3.2.5 | Visual Visual 4.5.1/Gage 4.5.3/Gage 4.5.4/Gage 4.5.5 |

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.

TABLE I FIRST ARTICLE INSPECTION

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CLASSIFICATION OF DEFECTS & TESTS

| PARAGRAPH | TITLE | NO. OF SAMPLE UNITS | AQL OR 100% | SHEET OF | DRAWING NUMBER |
|-----------|---|---------------------|-------------|----------|---|
| | SWITCH ASSEMBLY, LAUNCH, AND COMPONENTS | | | 2 | 9297015 |
| | EXAMINATION OR TEST | | | 2 | NEXT: HIGHER ASSEMBLY |
| | Group B 1/ Environmental Sequence | 12 | | 2 | PARAGRAPH REFERENCE /INSPECTION METHOD |
| | Marking Workmanship Temperature 2/ Transportation Vibration 2/ Vibration-Acceleration Operating 2/ Handling Shock 3/ Shock, Operating 3/ Launch Acceleration Sensing 3/ Lead Resistance 3/ Closing Time Insulation Resistance | | | | Visual Visual 4.5.8 4.5.6 4.5.9 4.5.7 4.5.10 4.5.1 4.5.3/Gage 4.5.2/Gage 4.5.4/Gage |
| | NOTE: | | | | |

QUALITY CONFORMANCE INSPECTION
CLASSIFICATION OF DEFECTS & TESTS

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| PARAGRAPH | TITLE | EXAMINATION OR TEST | NO. OF SAMPLE UNITS | SHEET | | DRAWING NUMBER |
|-----------------------------------|---|---|---------------------|----------------------|-------------------------|--|
| | | | | 1 | 2 | |
| CATEGORY | | | | AQL OR 100% | REQUIREMENT PARAGRAPH | PARAGRAPH REFERENCE /INSPECTION METHOD |
| 4.4.2.11 | SWITCH ASSEMBLY - LAUNCH | | | | | 9297015 NEXT HIGHER ASSEMBLY 9297030 |
| | | SWITCH ASSEMBLY, LAUNCH <u>Group A</u> | | | | |
| Major <u>101</u> 102 103 | Launch Acceleration Sensing Lead Resistance Insulation Resistance | | | 100% 100% 100% | 3.2.1 3.2.3 3.2.4 | 4.5.1/Gage 4.5.3/Gage 4.5.4/Gage |
| Minor <u>201</u> 202 | Marking Workmanship | | | 0.40% 0.40% | 3.1 3.5 | Visual 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).

QUALITY CONFORMANCE INSPECTION
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| PARAGRAPH | TITLE | NO. OF SAMPLE UNITS | AOL OR 100% | SHEET OF | DRAWING NUMBER |
|--|---|--|-------------|----------|---|
| 4.4.2.11 | SWITCH ASSEMBLY - LAUNCH | | | 2 | 9297015 |
| CATEGORY | EXAMINATION OR TEST | REQUIREMENT PARAGRAPH | | | 9297030 |
| Major 104 105 106 107 108 109 110 111 112 | Group B 1/ Environmental Sequence Temperature 2/ Transportation Vibration 2/ Vibration-Acceleration Operating 2/ Handling Shock 3/ Shock Operating 3 Launch Acceleration Sensing 3/ Lead Resistance 3/ Closing Time Insulation Resistance | 3.2.8 3.2.6 3.2.9 3.2.7 3.2.10 3.2.1 3.2.3 3.2.2 3.2.4 | 4/ | | PARAGRAPH REFERENCE / INSPECTION METHOD 4.5.8 4.5.6 4.5.9 4.5.7 4.5.10 4.5.1/Gage 4.5.3/Gage 4.5.2/Gage 4.5.4/Gage |
| Minor 203 204 205 | Marking Workmanship Solderability | 3.1 3.5 3.5.2 | | | Visual Visual 4.5.5 |
| NOTES | | | | | |