

MIL-F-63107C(AR)
 6 January 1986
 SUPERSEDING
 MIL-F-63107B(AR)
 16 March 1981

MILITARY SPECIFICATION

FLARE, AIRCRAFT COUNTERMEASURE: M206

This specification 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.

1. SCOPE

1.1 Scope. This specification covers the parts and assembly of one type of aircraft countermeasure flare designated as M206.

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications and standards. Unless otherwise specified (see 6.2), the following specifications and standards of the issue listed in that issue of the Department of Defense Index of Specification and Standards (DoDISS) specified in the solicitation, form a part of this specification to the extent specified herein.

SPECIFICATIONS

MILITARY

MIL-A-48078 - Ammunition, Standard Quality Assurance Provisions, General Specification For.

STANDARDS

MILITARY

MIL-STD-105 - Sampling Procedures and Tables For Inspection By Attributes.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Commander, US Army Armament Research and Development Center, Attn: AMSMC-QA, Dover, New Jersey 07801-5001 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 1370

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

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- MIL-STD-410 - Non-Destructive Testing Personnel Qualification and Certification.
- MIL-STD-453 - Inspection, Radiographic.
- MIL-STD-810 - Environmental Test Methods.

2.1.2 Other Government documents, drawings, and publications.

The following other Government documents, drawings, and publications form a part of this specification to the extent specified herein.

DRAWINGS (See 6.5)

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER (ARDC)

PRODUCT AND PACKAGING DRAWINGS

- 9311623 - Flare, Aircraft, Countermeasure: M206
- 9313716 - Packing and Marking For Box, Wirebound, For M206 Aircraft Countermeasure Flare
- 9313717 - Packing and Marking For Container: PA19 For M206 Aircraft Countermeasure Flare
- 9321956 - Packing and Marking For Box, Wood For Interplant Shipment of M206 Aircraft Countermeasure Flare
- 9321957 - Packing and Marking For Box, Fiberboard For M206 Aircraft Countermeasure Flare

INSPECTION EQUIPMENT DRAWINGS

- 9311428 - Breech Plate Assembly
- 9311434 - Dispenser Assembly
- 9311451 - Payload Module Assembly
- 9311660 - Cartridge, Impulse: M796
- 9380372 - Standard Test Procedure For Infra-Red Flares (MG-Teflon) (Confidential Dwg)

U.S. ARMY MATERIEL DEVELOPMENT AND READINESS COMMAND

UNITIZATION DRAWINGS

- 19-48-4116/115B - Unitization Procedures For Flare Countermeasure, M206 On 4-Way Entry Pallets
- 19-48-4116/115C - Unitization Procedures For Flare, Aircraft Countermeasure, M206 On 4-Way Entry Pallets

2.1.3 Other publications. The following documents form a part of this specification to the extent specified herein. The issues of the documents which are indicated as DoD adopted shall be the issue listed in the current DoDISS and the supplement thereto, if applicable.

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AMERICAN SOCIETY FOR TESTING MATERIALS SPECIFICATIONS

ASTM-D570

- Standard Test Method For Water
Absorption of Plastic

(Application of copies of ASTM publications should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.)

(Copies of specifications, standards, and drawings required by suppliers in connection with specific procurement functions should be obtained from the procuring activity or as directed by the Contracting Officer).

2.2 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein, the text of this specification shall take precedence.

3. REQUIREMENTS

3.1 Materials. Materials shall be in accordance with applicable drawings, specifications and standards.

3.2 Components and assemblies. The components and assemblies shall comply with all requirements specified on Drawing 9311623 and with all requirements specified in applicable specifications and standards.

3.3 Environmental requirements. Prior to and following environmental tests, the flares shall comply with the visual inspection criteria of paragraph 4.4.2.9 and shall be X-rayed for defects specified in 3.4.

3.3.1 Humidity. The flares shall be capable of meeting the requirements of 3.5 after being subjected to MIL-STD-810C, Test Method 507.1, Procedure I. (10 days).

3.3.2 Transportation vibration. The flares shall be capable of meeting the requirements of 3.5 after being subjected to MIL-STD-810C, Test Method 514.2, Procedure X, Curve AW.

3.3.3 Aircraft vibration. The flares shall be capable of meeting the requirements of 3.5 after being subjected to MIL-STD-810C, Method 514.2, Procedure IIC.

3.3.4 Temperature-altitude. The flare shall be capable of meeting the requirements of 3.5 after being subjected to MIL-STD-810C, Test Method 504.1-II, Category 6.

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3.3.5 Shock. The flare shall be capable of meeting the performance requirements of 3.5 after being subjected to MIL-STD-810C, Test Method 516.2, Procedure I, Figure 516.2-2.

3.3.6 Moisture absorption. The moisture absorption of the plastic cartridge case shall not exceed .3 percent max. when tested as specified in 4.5.7.

3.4 Radiographic examination. Radiographic equipment procedures and evaluation shall be in accordance with MIL-STD-453. Radiographic personnel shall be qualified in accordance with MIL-STD-410. Equipment and procedures will be submitted for approval to the Government (see 6.3). Flare samples shall not exhibit any indications of loose, deformed or missing components, foreign material, or defects within the flare pellet i.e., cracks, voids or discontinuities. Minimum optical density of each radiograph in the area being inspected shall not be less than 1.25 and shall be within a density range that will permit proper identification of defects.

3.5 Functioning requirements

3.5.1 Ignition. All flare pellets shall ignite when tested in accordance with 4.5.4.1.

3.5.2 Velocity. Upon ejection the flare pellet shall have a velocity of 75 to 165 feet per second. There shall be no physical break-up of the flare pellet.

3.5.3 Static output. Testing shall be performed at standard altitude (0 to 6000 feet). Bandwidth is indicated in Dwg. 9380372.

3.5.3.1 Decoy intensity time. Data shall be recorded for the bandwidth indicated in Figure I. Decoy intensity requirement is 1480 watts/steradian.

3.5.3.1.1 Individual samples. Each sample shall reach decoy intensity within .14 seconds and shall remain at or above this intensity for an additional 2.3 seconds.

3.5.3.1.2 Sample average. The sample average time to reach decoy intensity shall be .1 second maximum and the average duration at or above this intensity shall not be less than 2.7 seconds.

3.5.3.2 High intensity time. Data shall be recorded for bandwidth indicated in Dwg. 9380372.

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3.5.3.2.1 Individual samples. Each sample shall reach an intensity of 6175 watts per steradian within .5 seconds and shall remain at or above this intensity for an additional 1.25 seconds. Furthermore, each sample shall attain a minimum output of 7245 per steradian (see following paragraph).

3.5.3.2.2 Sample average. The sample average time to reach 7245 watts per steradian min. shall be within .5 seconds. The average duration at or above this intensity shall not be less than 1.25 seconds.

3.5.3.3 Intensity at .25 seconds. (Information only). The output shall be 6175 watts per steradian minimum (bandwidth per Dwg. 9380372).

3.6 Pellet characteristics

3.6.1 Crush strength. The pressed pellet (Dwg. 9362861 and 9342954) shall demonstrate a crush strength greater than 500 pounds when tested in accordance with 4.5.3.1 (for information only).

3.6.2 Bend strength. The pressed pellet (Dwg. 9362861 and 9342954) shall demonstrate a bending strength greater than 15 pounds when tested in accordance with 4.5.3.2 (for information only).

3.7 Seal integrity. The flare cartridge shall show no signs of leakage when tested in accordance with 4.5.4.3.

3.8 Foreign matter. The plastic cartridge case shall not show evidence of foreign matter larger than 1/16 of an inch and not more than five (5) pieces per sq. inch within three (3) in. from the bottom flange. The cartridge case shall not exhibit melted foreign matter, color blemishes, cracks, voids or bubbles when tested as specified in 4.5.8.

3.9 Stress. The plastic cartridge case shall show no evidence of cracks, crazing or visual discoloration when subjected to the stress test specified in 4.5.9.

3.10 Burst. The plastic cartridge case shall withstand a pressure of 170 PSIG without bursting when tested as specified in 4.5.10. (First Article Testing only).

3.11 Distortion. The end cap shall be tested for resistance to distortion as specified in 4.5.11.

3.12 First article inspection. This specification contains technical provisions for first article inspection. Requirements for the submission of first article samples by the contractor shall be as specified in the contract.

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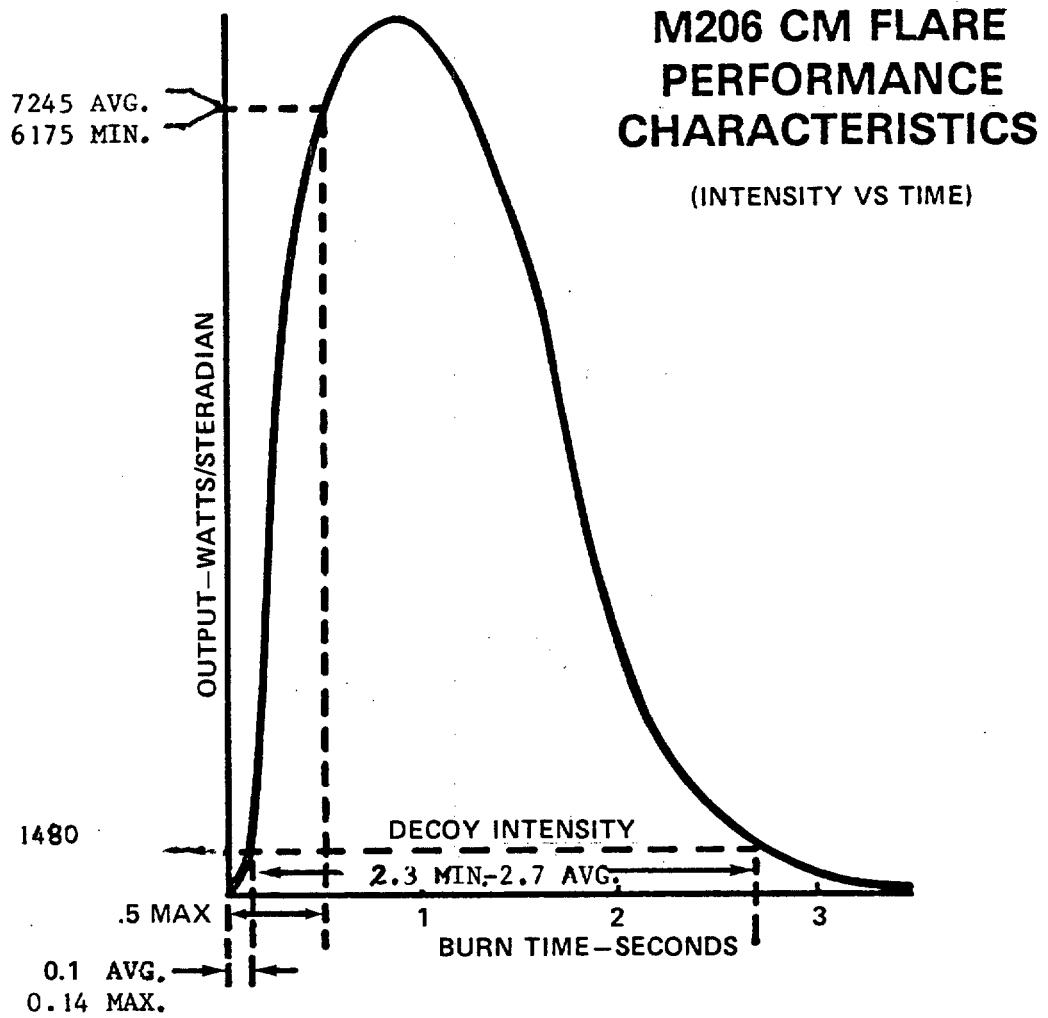


FIGURE 1

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3.13 Workmanship. All parts and assemblies shall be fabricated and finished in a thorough workmanlike manner and all manufacturing, processing, and assembly operations shall be correctly performed. They shall be free of burrs, chips, sharp edges, cracks, crazes, unblended radii, porosity, warpage, burn marks, checks, chipped edges, blisters, excess flash, dirt, and other defects and foreign matter which would affect their serviceability. The cleaning method used shall not be injurious to any part or assembly nor shall the parts be contaminated by the cleaning agent. All required markings shall be neat, legible and sharply defined.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection and standard quality assurance provisions. Unless otherwise specified herein or in the contract, the provisions of MIL-A-48078 shall apply and are hereby made a part of this detail specification.

4.2 Classification of inspections. The following types of inspection shall be conducted on this item.

- a. First Article Inspection
- b. Quality Conformance Inspection

4.3 First article inspection

4.3.1 Submission. The contractor shall submit a first article sample as designated by the Contracting Officer for evaluation in accordance with provisions of 4.3.2 and 4.3.3. The first article sample shall consist of the following items in sample quantities as indicated in Table I.

4.3.2 Inspections to be performed. See MIL-A-48078 and Table I specified herein.

4.3.3 Rejection. See MIL-A-48078. Except as noted in Table I.

TABLE I. First article inspection.

CLASSIFICATION OF DEFECTS & TESTS		MIL-F-63107C (AR)			
PARAGRAPH	TITLE	SHEET 1 OF 3		DRAWING NUMBER	SEE BELOW
		NEXT HIGHER ASSEMBLY			
		--			
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
	Flare, Aircraft Countermeasure: M206				
	Cap, End (Dwg. 9344022) Examination for defects	5/ cavity		3.2	4.4.2.1
	Cap, End, Plastic Case (Dwg. 9362854) Examination for defects	5/ cavity	Note 1	3.2	4.4.2.2
	Distortion Test	30		3.13	4.5.12
	Cap, End (ALT) (Dwg. 9362906) Examination for defects	5/ cavity	Note 1	3.2	4.4.2.3
	Distortion Test	30		3.13	4.5.12
	Cap, End Assembly (Dwg. 9344023, 9362904, 9369938) Examination for defects	20		3.2	4.4.2.4
	Piston Cushion Assembly (Dwg. 9342952/9362905) Examination for defects	5/ cavity		3.2	4.4.2.5
	Case, Cartridge (Dwg. 9311624) Examination for defects	5		3.2	4.4.2.6
NOTES:					
1. Quantity shall be 5/cavity but not less than 10 total if only a one cavity mold used.					
2. For information only.					

TABLE I. First article inspection.**CLASSIFICATION OF DEFECTS & TESTS**

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PARAGRAPH	TITLE	SHEET 2 OF 3		DRAWING NUMBER See Below	
					NEXT HIGHER ASSEMBLY ---
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
	<u>Flare, Aircraft Countermeasure: M206</u>				
	<u>Case, Cartridge</u> (Dwg. 9362853 - ALT) Examination for defects Foreign matter	5 5/ cavity	Note 1	3.2 3.10	4.4.2.7 4.5.8
	Moisture absorption	5/ cavity	Note 1	3.6.6	4.5.7
	Stress test	5/ cavity	Note 1	3.11	4.5.9
	Burst test	10/ cavity		3.12	4.5.10
	<u>Pellet, Flare</u> (Dwg. 9342954 & 9362861 - PRESSED) Examination for defects-Machined pellet	Note 1		3.2	4.4.2.8
	Bend strength-Prior to machining	5	Note 2	3.6.2	4.5.3.2
	Crush strength-Prior to machining	5	Note 2	3.6.1	4.5.3.1
	<u>Pellet, Flare</u> (Dwg. 9347038 - EXTR.) Examination for defects	5/ cavity		3.2	4.4.2.9
	<u>Pellet Assembly</u> (Dwg. 9342955/9362918) Examination for defects	30		3.2	4.4.2.10
	Static output test	30	Note 3	3.5.3	4.5.4.2
NOTES:	3. These 30 pellets are from examination for defects above. 4. A total of 90 samples shall be submitted to all tests in the order listed.				

TABLE I. First article inspection.**CLASSIFICATION OF DEFECTS & TESTS**

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PARAGRAPH	TITLE	SHEET 3 OF 3			DRAWING NUMBER
	Flare, Aircraft Countermeasure: M206				See Below
					NEXT HIGHER ASSEMBLY
					--
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
	<u>Pellet Assembly (Dwg. 9347036 - EXTR)</u>				
	Examination for defects	30		3.2	4.4.2.11
	Static output test	30		3.5.3	4.5.4.2
	<u>Flare, Aircraft, Countermeasure: M206 (Dwg. 9311623)</u>				
	Examination for defects/radiographed	90		3.2	4.4.2.12 (Omit 108)
	Transportation vibration	90	Note 4	3.3.2	4.5.1
	Shock	90		3.3.5	4.5.1
	Humidity	90		3.3.1	4.5.1
	Aircraft vibration	90		3.3.3	4.5.1.1
	Temperature - altitude	90		3.3.4	4.5.1
	Examination for defects/radiographed	90		3.2	4.4.2.12 (Omit 108)
	Ignition and velocity	90	Note 5 Note 6	3.5.1/ 3.5.2	4.5.4.1
NOTE:	5. Test 30 flares each at high, low and ambient temperatures defined in 4.5.4.1.				
	6. Total of 2 defects allowed in velocity range 60-210 FPS. No defects allowed in the ambient condition.				

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4.4 Quality conformance inspection

4.4.1 Inspection lot formation. Inspection lots shall comply with the lot formation provisions of MIL-A-48078.

4.4.2 Examination. (See MIL-A-48078). Unless otherwise specified in the Classification of Defects and Test Tables, sampling plans for major and minor defects shall be in accordance with MIL-STD-105, Inspection Level II. Equipment necessary for the performance of inspections listed shall be in accordance with 4.4.4.

TABLE IISample plan for static output and velocity

<u>Inspection Lot Size</u>	<u>Normal Plan</u>	<u>Reduced Plan</u>
Up to 3200	50	20
3201 - 35,000	125	50

The normal plan shall be used until ten consecutive lots are accepted. The reduced plan may be used thereafter. If any lot is rejected under the reduced plan, normal sampling shall not be reinstated until three consecutive lots are accepted.

TABLE IIIAcceptance criteria for static output

<u>Sample Size</u>	<u>Accept</u>	<u>Reject</u>
20	0	1
50	1	2
125	3	4

TABLE IVLot acceptance testing for velocity

The following table lists maximum acceptable quantities of test samples to be outside of the listed velocity requirements. In any case where the number of sample readings exceeds the number permitted by the table, the lot shall be rejected. The velocities shall be tested in conjunction with other tests as listed in Table I:

<u>Sample Size</u>	<u>20</u>	<u>50</u>	<u>125</u>
Over 220 fps	0	0	0
Over 210 fps	1	1	2
Over 165 fps	2	4	6
Under 75 fps	2	4	6
Under 60 fps	1	1	2
Under 46 fps	0	0	0
Max defects permitted	3	5	7

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CLASSIFICATION OF DEFECTS & TESTS

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PARAGRAPH	TITLE	SHEET 1 OF 1			DRAWING NUMBER
4.4.2.1	Cap, End				9344022
					NEXT HIGHER ASSEMBLY 9344023
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
<u>Critical</u>	None defined				
<u>Major</u>					
101	Diameter of shear pin holes, max.		0.40%	3.2	Gage
102	Inside radius (4 places)		0.40%	3.2	Gage
103	Outside (large) square dimension, min.		0.40%	3.2	Gage
104	"O" Ring groove, dimension across square		0.40%	3.2	Gage
105	"O" Ring groove width		0.40%	3.2	Gage
<u>Minor</u>					
201	Thickness, min.		0.65%	3.2	Gage
202	Poor workmanship		1.00%	3.9	Visual

NOTE:

Plastic molded parts to be inspected per para. 4.5.7.

QUALITY CONFORMANCE INSPECTION**CLASSIFICATION OF DEFECTS & TESTS**

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PARAGRAPH	TITLE	SHEET 1 OF 1			DRAWING NUMBER
4.4.2.2	Cap, End, Plastic Case				9362854
					NEXT HIGHER ASSEMBLY
					9362904
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE /INSPECTION METHOD
<u>Critical</u>	None defined				
<u>Major</u>					
101	Holding pins missing (4 places)		0.40%	3.2	Visual
102	Lead in square dimension, min. (below "O" ring groove)		0.40%	3.2	Gage
103	Outside square dimension, min. (top section)		0.40%	3.2	Gage
104	"O" ring groove, dimension across square		0.40%	3.2	Gage
105	"O" ring groove, width		0.40%	3.2	Gage
106	Distortion test	30		3.13	4.5.11
<u>Minor</u>					
201	Poor workmanship		1.00%	3.9	Visual

NOTE:

Plastic molded part to be inspected per para. 4.5.7.

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CLASSIFICATION OF DEFECTS & TESTS

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PARAGRAPH	TITLE	SHEET 1 OF 1			DRAWING NUMBER
4.4.2.3	Cap, End (ALT)				9362906
					NEXT HIGHER ASSEMBLY
					9369928
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
<u>Critical</u>	None defined				
<u>Major</u>					
101	Holding pins missing		0.40%	3.2	Visual
102	Inside square dimension, min. (below "O" ring groove)		0.40%	3.2	Gage
103	Outside square dimension, min. (top section)		0.40%	3.2	Gage
104	"O" ring groove, dimension across square		0.40%	3.2	Gage
105	"O" ring groove, width		0.40%	3.2	Gage
106	Distortion test	30		3.13	4.5.11
<u>Minor</u>					
201	Poor workmanship		1.00%	3.9	Visual
NOTES:					
Plastic molded part to be inspected per para. 4.5.7.					
Alternate end cap for aluminum cartridge case.					

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PARAGRAPH	TITLE		SHEET 1 OF 1		DRAWING NUMBER
4.4.2.4	Cap, End Assembly				9344023/9362904/9369928
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	NEXT HIGHER ASSEMBLY
					9311623/9362852
					PARAGRAPH REFERENCE /INSPECTION METHOD
<u>Critical</u>	None defined				
<u>Major</u>					
101	"O" ring missing or damaged		0.40%	3.2	Visual
102	Grease on "O" ring missing or inadequate		0.40%	3.2	Visual
<u>Minor</u>					
201	Poor workmanship		1.00%	3.9	Visual

NOTES:

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PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER
4.4.2.5	Piston, Cushion Assembly			9342952/9362905
				NEXT HIGHER ASSEMBLY
				9311623
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH
				PARAGRAPH REFERENCE /INSPECTION METHOD
<u>Critical</u>	None defined			
<u>Major</u>				
101	Squareness dimensions, min.		Note 1	3.2 Gage
102	Corner radius		Note 1	3.2 Gage
103	Hole diameter (ignition/vent hole)		Note 1	3.2 Gage
104	Total height (4 places), (9342952)		Note 1	3.2 Gage
105	Cushion missing, misaligned or improperly assembled		0.40%	3.2 Visual
106	Piston hole blocked (ignition/vent hole)		Note 1	3.2 Visual
107	Small diameter height		Note 1	3.2 Gage
<u>Minor</u>				
201	Position of legs (4), (9342952)		Note 1	3.2 Gage
202	Poor workmanship		Note 1	3.9 Visual
NOTES:				
1. Plastic parts to be inspected per para. 4.5.7.				

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PARAGRAPH	TITLE	SHEET 1 OF 1			DRAWING NUMBER
4.4.2.6	Case, Cartridge				9311624
					NEXT HIGHER ASSEMBLY
					9311623
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE /INSPECTION METHOD
<u>Critical</u>	None defined				
<u>Major</u>					
101	Internal squareness, min.		Note 1	3.2	Gage
102	External squareness, max.		Note 1	3.2	Gage
103	Internal depth, to bottom of chamfer		Note 1	3.2	Gage
104	"O" ring groove diameter		Note 1	3.2	Gage
105	Impulse cartridge hole diameter		Note 1	3.2	Gage
106	Overall length incorrect		Note 1	3.2	Gage
107	True position of "O" ring groove		Note 1	3.2	Gage
<u>Minor</u>					
201	Poor workmanship		Note 1	3.9	Visual
NOTES:					
1. See 4.5.5 for qualification and production control of extruded parts.					

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PARAGRAPH	TITLE	SHEET 1 OF 1			DRAWING NUMBER
4.4.2.7	Case Cartridge				9362853 (ALT)
					NEXT HIGHER ASSEMBLY
					9311623
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
<u>Critical</u>	None defined				
<u>Major</u>					
101	Internal squareness, min.		Note 1	3.2	Gage
102	External squareness, min.		Note 1	3.2	Gage
103	"O" Ring surface diameter		Note 1	3.2	Gage
104	Impulse cartridge hole, true position		Note 1	3.2	Gage
105	Overall length incorrect		Note 1	3.2	Gage
106	Secure pin hole location (4 places)		Note 1	3.2	Gage
107	Foreign matter, cracks, voids or bubbles		100%	3.8	4.5.8
108	Moisture absorption test	10	0-1	3.6.6	4.5.7
109	Stress test	10	0-1	3.11	4.5.9
<u>Minor</u>					
201	Poor workmanship		1.0%	3.9	Visual
NOTES: Plastic part to be inspected per para. 4.5.7.					

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PARAGRAPH	TITLE	SHEET 1 OF 1			DRAWING NUMBER
4.4.2.8	Pellet, Flare (Pressed)				9342954/9362861
					NEXT HIGHER ASSEMBLY
					9342955/9362918
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
<u>Critical</u>	None defined				
<u>Major</u>					
101	Total length		0.40%	3.2	Gage
102	Width		0.40%	3.2	Gage
103	Corner radius/9342954		0.40%	3.2	Gage
104	End groove width incorrect		0.40%	3.2	Gage
105	Groove width (4 places)		0.40%	3.2	Gage
106	Groove depth (4 places)		0.40%	3.2	Gage
107	Height of pellet in direction of pressing (within one hr. max. after pressing)/9342954		0.40%	3.2	Gage
108	Corner angle/9362861		0.40%	3.2	Gage
<u>Minor</u>					
201	Poor workmanship		100%	3.9	Visual

NOTES:

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PARAGRAPH	TITLE	SHEET 1 OF 1			DRAWING NUMBER
4.4.2.9	Pellet, Flare (EXTR)				9347038
					NEXT HIGHER ASSEMBLY
					9347036
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE /INSPECTION METHOD
<u>Critical</u>	None defined				
<u>Major</u>					
101	Total length		Note 1	3.2	Gage
102	Width & height		Note 1	3.2	Gage
103	Corner radius (16 places)		Note 1	3.2	Gage
104	Groove radius (8 places)		Note 1	3.2	Gage
<u>Minor</u>					
201	Poor workmanship		1.00%	3.2	Visual

NOTES:

- See Para. 4.5.5 for Dimensional Control of Extruded Pellet.

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QUALITY CONFORMANCE INSPECTION

CLASSIFICATION OF DEFECTS & TESTS

MIL-F-63107C (AR)

PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER 9342955/9362918	
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	NEXT HIGHER ASSEMBLY 9311623
					PARAGRAPH REFERENCE /INSPECTION METHOD
<u>Critical</u>	None defined				
<u>Major</u>					
101	Tape missing, loose, torn or improperly applied		0.40%	3.2	Visual
102	Felt obturator(s) missing,* loose, overlapped or improperly applied		0.40%	3.2	Visual
103	First fire missing from ignition end		0.40%	3.2	Visual
104	First fire composition above flush with respect to grooves		0.40%	3.2	Visual
105	Piston cushion, missing, not centered/ 9362918		0.40%	3.2	Visual
106	Static output test	(a)	0.40%	3.5.3	4.5.4.2
<u>Minor</u>					
201	Poor workmanship		1.00%	3.9	Visual
	* Obturator felts are not required when those pellet assemblies are used in the plastic cartridge case - 9362853.				
NOTES:	(a) Sample size and accept/reject criteria shall be in accordance with Table II and Table III.				

QUALITY CONFORMANCE INSPECTION

CLASSIFICATION OF DEFECTS & TESTS

MIL-F-63107C (AR)

PARAGRAPH	TITLE	SHEET 1 OF 1			DRAWING NUMBER
4.4.2.11	Pellet Assembly (EXTR)				9347036
					NEXT HIGHER ASSEMBLY
					9311623
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE /INSPECTION METHOD
<u>Critical</u>	None defined				
<u>Major</u>					
101	Tape missing, loose, torn or improperly applied		0.40%	3.2	Visual
102	First fire missing or improperly applied on ignition end		0.40%	3.2	Visual
103	First fire composition above flush with respect to groove		0.40%	3.2	Visual
104	Static output test	(a)		3.5.3	4.5.4.2
<u>Minor</u>					
201	Poor workmanship		1.00%	3.9	Visual
NOTE: (a) Sample size and accept/reject criteria shall be in accordance with Table II and III.					

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QUALITY CONFORMANCE INSPECTION**CLASSIFICATION OF DEFECTS & TESTS**

MIL-F-63107C (AR)

PARAGRAPH	TITLE	SHEET 1 OF 1			DRAWING NUMBER
4.4.2.12	Flare, Aircraft, Countermeasure: M206				9311623/Sh. 1 & 2
					NEXT HIGHER ASSEMBLY
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE /INSPECTION METHOD
<u>Critical</u>					
1	Piston missing from assembly		100%	3.2	Visual
<u>Major</u>					
101	Shear pin(s) missing from end cap 9311623 (Sheet 1)		0.40%	3.2	Visual
102	Cartridge case "O" ring missing, damaged or grease missing		0.40%	3.2	Visual
103	Piston inserted backward		0.40%	3.2	Visual
104	Pellet assembly inserted backwards (Prior to insertion of end cap assy)		0.40%	3.2	Visual
105	Pellet assembly loose (felt missing) (prior to insertion of end cap assy)		0.40%	3.2	Visual
106	Letter "F" missing on red end cap		1.00%	3.2	Visual
107	Seal integrity test		0.40%	3.7	Visual/4.5.4.3
108	Radiographic examination	(a)	0-1	3.4	4.5.2
109	Velocity and ignition at ambient temperature	(b)		3.5.2	4.5.4.1
110	Cracked case		100%	3.2	Visual
<u>Minor</u>					
201	Marking improper or illegible		0.65%	3.2	Visual
202	Poor workmanship		1.00%	3.9	Visual
NOTE:					
(a) Sample size criteria shall be in accordance with Table II.					
(b) Sample size and accept/reject criteria shall be in accordance with Table IV.					
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QUALITY CONFORMANCE INSPECTION

CLASSIFICATION OF DEFECTS & TESTS

MIL-F-63107C (AR)

PARAGRAPH	TITLE	SHEET 1 OF 1			DRAWING NUMBER
4.4.2.13	Packing and Marking for Container: PA19 For M206 Aircraft Countermeasure Flare				9313717
					NEXT HIGHER ASSEMBLY
					9313716
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE /INSPECTION METHOD
<u>Critical</u>	None defined				
<u>Major</u>					
101	Cushions missing or damaged		0.40%	3.2	Visual
102	Partition missing or damaged		0.40%	3.2	Visual
103	Improper number of flares		0.40%	3.2	Visual
<u>Minor</u>					
201	Markings improper, missing or illegible		0.65%	3.2	Visual
202	Poor workmanship		1.00%	3.9	Visual
NOTES:					

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QUALITY CONFORMANCE INSPECTION**CLASSIFICATION OF DEFECTS & TESTS**

MIL-F-63107C (AR)

PARAGRAPH 4.4.2.14	TITLE Packing and Marking For Box, Wire- bound, Packing For M206 Aircraft Countermeasure Flare	SHEET 1 OF 1			DRAWING NUMBER 9313716
NEXT HIGHER ASSEMBLY					
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE /INSPECTION METHOD
<u>Critical</u>	None defined				
<u>Major</u>					
101	Separator missing		0.40%	3.2	Visual
102	Contents loose		0.40%	3.2	Visual
<u>Minor</u>					
201	Markings improper, missing or illegible		0.65%	3.2	Visual
202	Poor workmanship		1.00%	3.9	Visual
NOTES:					

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4.3.4 Testing. Testing is described in the First Article and Quality Conformance Inspection tables.

4.4.4 Inspection equipment. The inspection equipment required to perform the inspections and tests prescribed in this specification is identified in the "Paragraph Reference/Inspection Method" column in the tables starting with paragraph 4.4.2.1, and the test method paragraphs (see 4.5). The contractor shall submit for approval, inspection equipment designs in accordance with the terms of the contract. See Section 6 of MIL-A-48078, and Section 6.3 herein.

4.5 Methods of inspections.

4.5.1 Environmental tests. The first article flare samples with M796 Impulse Cartridges (9311660) inserted, shall be mounted in a Payload Module Assembly (9311451) and subjected to the environmental tests in the order specified in Table I. Upon completion of environmental tests the flare cartridges shall be examined for obvious damage and X-rayed in accordance with 4.5.2.

4.5.1.1 Aircraft vibration. The following data shall be used in performing the required test of paragraph 3.3.3 in conjunction with MIL-STD-810C. See Figure 2 for axis orientation. (Destructive Test)

- a. Table 514.2-IIA and Figure 514.2-2A. " W_0 " shall be $0.2G^2/Hz$.
- b. Figure 514.2-2A. Random vibration envelope, the frequency " VAR " shall be 89.5 Hz., and the acceleration power spectral density at the 2000 Hz. cutoff point shall be $.05G^2/Hz$.
- c. Table 514.2-IVA. The number of missions shall be 101.
- d. Figure 514.2-4C. The number of missions shall be 100.
- e. Figures 514.2-4D, 514.2-4E and 514.2-4F. The weight used for the test item shall be 50 pounds.

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4.5.1.2 Vibration - Axis Orientation

a. Payload Module/Item Assembly Test Axis Orientation should be as follows:

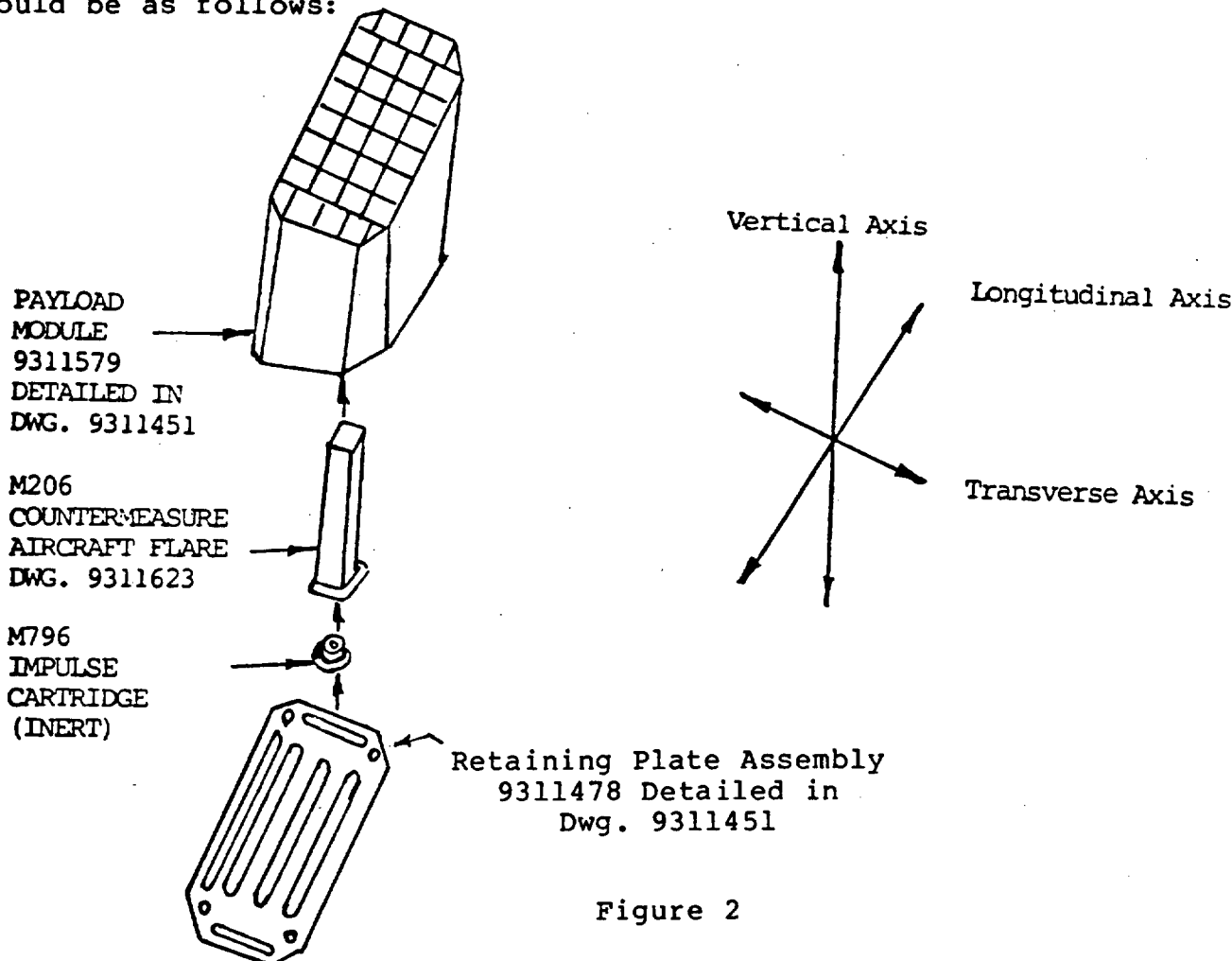


Figure 2

b. Orientation/Mounting of Payload Module Assembly to the vibration table for each of the three axes should be such that the open end of the Payload Module Assembly is at the top with the Flare Cartridge in place and the Inert Impulse Cartridge assembled at the bottom as shown.

c. To best meet the vibration requirements for the Longitudinal Axis and Transverse Axis it is recommended that a slip plate should not be used. In lieu of utilizing the slip plate, the vibrator should be turned 90° and the Payload Module Assembly attached/positioned to maintain orientation as indicated in para. b.

d. It is required that the stud nuts be replaced with high strength rods threaded on both ends in order to secure the Payload Module Assembly containing test items to the vibration table attachment plate (Ref. Dwg. 9311428). Use a washer and two nuts on each rod.

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4.5.1.3 Shock. This test shall be performed in accordance to MIL-STD-810C, Test 516.3, Procedure I, Figure 516.3-2 (see paragraph 4.5.1.2 for axis orientation).

4.5.1.4 Humidity. This test shall be performed in accordance to MIL-STD-810C, Test Method 507.2, Procedure II (10 days). Observation shall be made for compliance with para. 3.3.1. (Destructive Test)

4.5.1.5 Transportation vibration. This test shall be performed according to MIL-STD-810C, Test Method 514.3, Procedure II, Category 3, Test Condition I-3.2.3. Observation shall be made for compliance to para. 3.3.2. (Destructive Test)

4.5.1.6 Temperature-altitude. This test shall be performed in accordance to MIL-STD-810C, Test Method 520.0, Procedure II. Observation shall be made for compliance to para. 3.3.4. (Destructive Test)

4.5.2 Radiographic examination. Prior to functional testing, the flare samples shall be examined in accordance with MIL-STD-453 procedure. Radiographic personnel shall be qualified in accordance with MIL-STD-410. Two exposures shall be made of each flare, each forming a 90 degree angle with the other and with the longitudinal axis of the flare. Examination of the radiograph shall be made to determine compliance with the applicable requirement (see 3.4). Rejected flare for low density areas and voids shall be tested per para 4.5.2.2.

4.5.2.1 Radiographic sensitivity. The penetrameter used in the application specified in MIL-STD-453 shall be designed and constructed to insure a 2.0 percent sensitivity or better. The penetrameter shall be made of plastic having a density equal to the pellet. (Penetrameter for .62 inch aluminum or 1.0 inch magnesium is acceptable) One penetrameter shall be used on each film exposed. The film density measurement shall be made with a photo electric densitometer calibrated to National Bureau of Standards (Photographic Step Tablet).

4.5.2.2 Low density areas or voids. A rejected lot due to low density areas or voids shall be environmental and velocity tested. Sixty (60) flares with voids shall be subjected to aircraft vibration per para 4.5.1.1, temperature-altitude per para 4.5.1.6 and shock per para 4.5.1.3. Upon completion of above test the flares shall be velocity tested at -65°F per para 4.5.4.1. Any flare failing the velocity test shall be cause for lot rejection.

4.5.3 Pellet characteristics

4.5.3.1 Crush strength. A one-inch maximum length section, machined from the center of each test pellet (Dwg. 9342954 or 9362861) prior to drilling and grooving shall be placed in the test

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configuration depicted in Figure 3. A flat horizontal press will be lowered onto the pellet segment at a rate of $0.2 \pm 02\%$ inches per minute and the maximum force recorded. (For information only - See 6.6).

4.5.3.2 Bend strength. The test pellet (Dwg. 9342954 or 9362861) as pressed prior to machining shall be placed in the test configuration depicted in Figure 4. The one half inch diameter bar shall be lowered on the the pellet center at a rate of $0.2 \pm 02\%$ inches per minute and the maximum force recorded. (For information only - See 6.6).

4.5.4 Functioning tests

4.5.4.1 Ignition and velocity tests. First Article samples shall be conditioned for four hours minimum at -65°F to -75°F , 60°F to 80°F and 130°F to 140°F as required in Table I. Each M206 Flare Cartridge to be temperature conditioned shall be fitted with an inert M796 Impulse Cartridge. After conditioning the inert cartridge is removed and a functional impulse cartridge preconditioned at 68°F to 80°F shall be used prior to loading into a payload module assembly, Drawing 9311451. All items must be functioned within fifteen (15) minutes of removal from conditioning chamber. Normal lot acceptance testing will be performed at ambient temperatures only. The payload module assembly (Dwg. 9311451) shall be mounted to a dispenser assembly (Dwg. 9311434) oriented to fire vertically upward ($90 \pm 2^{\circ}$ elevation). Instrumentation capable of sensing a burning flare shall be located four feet and twelve feet above the dispenser assembly (Dwg. 9311434). The average velocity of the flare traveling the eight feet $\pm 1/2$ in. between the sensors shall be calculated. Small chips breaking off of the flare during this test shall not in itself be cause for rejection; however, if any flare breaks up into two or more pieces or fails to ignite, the lot shall be rejected. If a non-ignition is attributed to improper functioning of the impulse cartridge, the sample shall be considered as "no test" and be replaced with an additional flare assembly.

4.5.4.2 Static output test. (See Dwg. 9280372 for Standard Test Procedure). Using equipment in accordance with 4.4.4, the flare shall be tested for compliance with the requirements of 3.5.3 and Figure 1. The IR output shall be measured with one or more radiometers, as required. Tests will be conducted at ambient temperature (30°F to 100°F). If ambient storage temperatures are outside the specified range, the pellet assembly shall be submitted to a minimum of four hours of temperature conditioning at $70 \pm 5^{\circ}\text{F}$ prior to testing.

A standard M100 electric match (or equivalent as approved by ARDC) will be used to ignite the pellet assembly. Insert M100 Electric Match through $3/16$ " hole of a wooden block or equivalent ($3/4$ SQ. x $7/16$ " TH'K with a $3/16$ " hole in the center of the $3/4$ " surface; dimensional tolerance to be $\pm .010$) and bend leads to facilitate attachment of match and block to pellet assembly.

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Position and center match and block on pellet assembly in a manner which will bring match head into contact with ignition end of pellet. Secure match and block in position on sample by applying a two and one half inch length of one inch wide aluminum tape across end of block, and bend ends of tape down and along sides of pellet. Rotate pellet 90° and apply another two and one half inch strip of tape over the first strip, and down the two remaining sides of the pellet. Secure by wrapping a three and one half inch strip of tape circumferentially around the block covered by side strips. Assure tape is flush but does not extend past forward end of block.

The non-ignition end of the pellet will be prepared for mounting by drilling a 9/64" diameter hole, 5/8" deep. A No. 10 sheet metal screw with a minimum 5/8" thread length on one end and opposite end suitable for mounting to the test stand shall be carefully threaded into the 9/64" drilled hole. (For extruded pellet a 16 penny nail, 1 3/4 in. long x .150 in. dia. is inserted into the pellet approximately 5/8 in. deep). Prior to assembly, screw threads shall be coated with RTV-106 or an approved substitute to reduce friction and possible ignition.

The pellet assembly shall be oriented horizontally on a test stand with radiometer optics in line with the axial centerline of the flare pellet. The ignition end of the pellet assembly will face the radiometer.

Variables type data in the form of IR output versus time charts will be made available to the Government upon request. Sufficient air flow shall be maintained in the test chamber to prevent smoke from obscuring or attenuating the flare output signal. The IR output at the wavelengths indicated in Figure 1 shall be measured and recorded. The analog output shall be recorded to provide results in chart form for each pellet assembly tested. (See Dwg. 9280372 Standard Test Procedure for Infra-Red Flares (MG-Teflon)).

a. Samples shall be tested for decoy intensity times of para. 3.5.3.1.1 and 3.5.3.2.1 in accordance with criteria of Table III. Any pellet failing to meet any of the applicable requirements shall be classed defective.

b. Failure to meet either of the sample average requirements of para. 3.5.3.1.2 and 3.5.3.2.2 shall result in rejection of the lot. Data from any non-conforming pellet(s) from (a) above shall not be utilized in calculating sample averages.

c. In the event of non-ignition attributed to improper functioning of the electric match, the pellet assembly shall be considered as "no test" and shall be retested using a new electric match.

d. In the event that a flare drops from the metal screw on

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to the floor, the test shall be considered "no test". More than two "no test" requires a formal notification shall be made to AMSMC-QAT-M(D) for test review and disposition.

4.5.4.3 Seal integrity. Using equipment in accordance with 4.4.4, each test cartridge shall be tested for compliance with 3.7. The test equipment necessary shall consist of an dry air supply regulated to $5 + 1/2$ psig, a shut-off valve, an indicator gage and a flexible line ending in an adapter conforming to the outer dimensions of the M796 Impulse Cartridge.

a. Remove the plug at ignition end and insert the leak test adapter. Open the air valve and insert the cartridge (red cap end) in water for five (5) seconds minimum and visually inspect for the presence of bubbles indicating a leak.

b. If no bubbles are observed, remove cartridge from water and close air supply valve. Observe indicator gage for loss of pressure. (15 seconds minimum).

c. If no indication of leakage or loss of pressure is observed, the item is acceptable.

(NOTE: Inspection lots not meeting an AQL of 0.40% may be screened 100% for compliance with this test, and all items which meet this requirement may be submitted to other tests for lot acceptance).

4.5.5 Dimensional control and extruded parts. In place of the normal sampling associated with the Classification of Defects, and with the approval of the Contracting Officer, a sample of at least three (3) parts (as extruded) from each die shall be dimensionally inspected to qualify a new or reworked die for use in production or as a control of the die during production. Inspection for control of each die during production shall be performed on the above quantities from each die after production of 5000 parts.

If any defective parts are found during qualification of the die, the die producing the defective part shall not be used in production. If any defective parts are found when inspection is performed for control of the die, the die producing the defective part shall be removed from production. Further, that portion of production since the last control check shall be returned to the contractor for corrective action.

All dies formerly removed from production because of some fault may, after reworking, be returned to production providing they pass the qualification test specified above. The contractor may request a change of inspection frequency providing he presents objective evidence to substantiate the request to the Contracting Officer.

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4.5.6 Dimensional control of molded or plastic parts. In place of normal sampling and inspections associated with the Classification of Defects, and after a curing time for the parts has been approved (see Note 1) a sample of three (3) parts (as molded) from each cavity shall be fully inspected dimensionally to qualify a new or reworked cavity for use in production. The molded parts shall carry the individual cavity identification. As a control of the cavity during production, the above quantity of parts from each cavity shall be inspected for at least the defects listed in paragraph 4.4.2.1, 4.4.2.3, 4.4.2.4 and 4.4.2.8 after continuous production of each 5,000 parts or at the end of each week, whichever occurs first. Of the three (3) samples; one (1) sample shall be the last part produced. If any defective parts are found during qualification of the cavity, the cavity producing the defective part will not be used in production. If any defective parts are found when inspection is performed for the control of the cavity, the cavity producing the defective part shall be removed from production. Further, that portion of production since the last control check shall be returned to the contractor for inspection for each separate type of defect according to MIL-STD-105, using an AQL of 0.40 percent for each major defect and an AQL of 0.65 percent for each minor defect. All cavities removed from production because of some fault may, after reworking, be returned to production providing they pass the qualification test above. The contractor may request a change of inspection frequency providing he presents objective evidence to the Contracting Officer to substantiate the request. Contractor design of gages and test equipment required to perform the inspections listed herein shall be submitted per 6.3 for approval prior to manufacture of equipment. The noted subparagraphs identify those items and minimum inspections subject to the requirements of this paragraph.

NOTE 1: In establishing a curing time, dimensionally check ten (10) parts from each cavity at periodic intervals (e.g. every 30, 60, etc. mins.) until dimensional stability is attained. The curing time will be from the time the part comes out of the mold until dimensional stability is attained. The inspection data used in determining the curing time shall be sent to ARDC, Dover, New Jersey 07801-5001, ATTN: AMSMC-QAT-M(D). If there is a change in material, or in the cycle time, or if a cavity is reworked, or a new cavity is used, a new curing time shall be established and approved.

4.5.7 Moisture absorption test. The plastic cartridge case shall be tested for moisture absorption per ASTM-D570, immersion test at $70 \pm 5^{\circ}\text{F}$ for twenty-four (24) hrs. min. (Destructive Test)

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4.5.8 Foreign matter test. The plastic cartridge case shall be inspected 100% for foreign matter, cracks, voids or bubbles under a high intensity fluorescent light (min. 110 watts daylight white lite). Light to be within 1/2" from plastic cartridge case. Any defective parts shall be removed from the lot. (Non-Destructive Test)

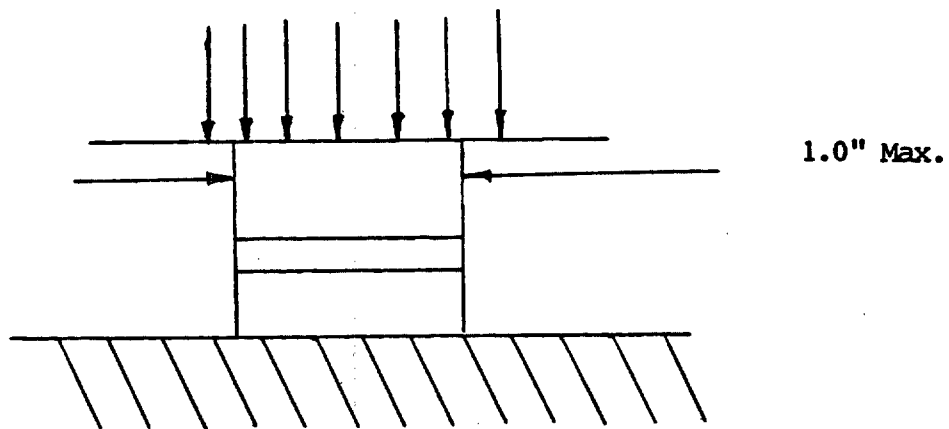
4.5.9 Stress test. The plastic cartridge case shall be submerged in a 5% water solution of USP grade white calcium chloride (CaCl_2), previously heated to $140 \pm 5^\circ\text{F}$ ($60 \pm 2^\circ\text{C}$) and maintained at this temperature.

The cartridge case shall be submerged for four hours. Upon removal, the cartridge case shall be rinsed with water and examined for cracks, crazing, or visual discoloration relative to an unstressed part. Evidence of the above defects indicate areas of high stress and all parts produced under the same molding process conditions shall be rejected. (Destructive Test)

4.5.10 Burst test (for Plastic Cartridge Case Dwg. 9362853). The Plastic Cartridge Cases from each mold cavity shall be assembled with an "O" ring seal at the ignition end and an end cap assembly in a suitable fixture that will prevent the end cap from being pushed out when the case is filled with water and hydrostatic pressure applied at the ignition end. The hydrostatic pressure is increased at a constant rate until the case bursts. The peak pressure prior to bursting shall be 170 psig (min.) (Destructive Test)

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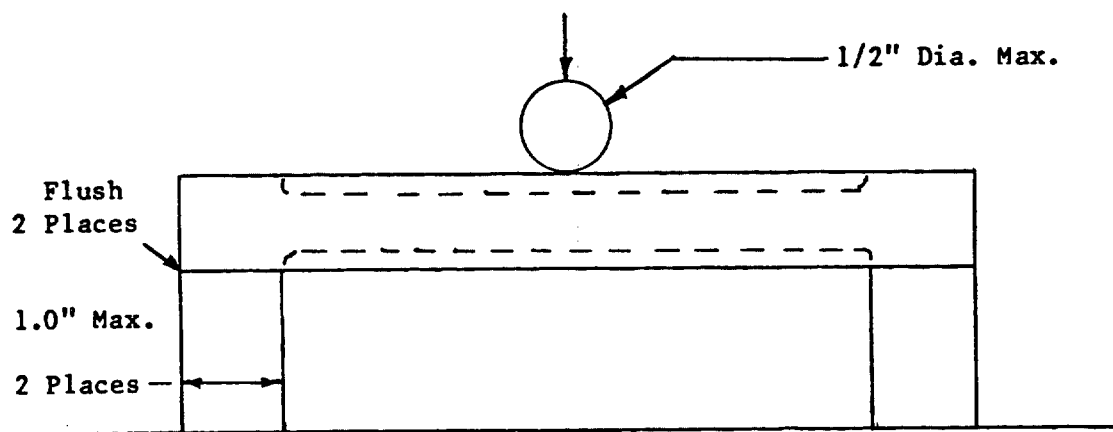
Press at 0.2"/Min.



Crush test

Figure 3

Press at 0.2"/Min.



Bend test

Figure 4

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4.5.11 Distortion test (for Plastic Case End Cap Dwg. 9362854 and Alt End Cap Dwg. 9362906). The Plastic Case End Cap shall be assembled to M206 Flares in the plastic cartridge case configuration. All rounds will be leak tested as described in paragraph 4.5.4.3. After passing the leak test, the rounds shall be conditioned at $200 \pm 5^{\circ}\text{F}$ ($93 \pm 3^{\circ}\text{C}$) for 16 hours and the leak test repeated. Evidence of visual deformation or leakage shall be cause for rejection. The Alternate End Cap is tested using the same procedure except that an aluminum cartridge case is used.

5. PACKAGING

5.1 Packaging. Packaging shall be as specified on Drawing 9313717 or Drawing 9321957 if shipment is interplant.

5.2 Packing and marking. Packing and marking shall be as specified on Drawing 9313716 or Drawing 9321956 if shipment is interplant.

5.3 Unitization. Unitizing shall be as specified on Drawings 19-48-4116/115B and 19-48-4116/115C.

6. NOTES

6.1 Intended use. The M206 flare is intended for use with the M130 Aircraft General Purpose Dispenser.

6.2 Ordering data. Procurement documents shall specify the following:

- a. Title, number and date of this specification.
- b. Provisions for submission of first article samples.
- c. Provisions of MIL-A-48078.

6.3 Submission of inspection equipment designs for approval. (See MIL-A-48078). Submit equipment designs as required to Commander, U.S. Army Armament Research and Development Center, ATTN: AMSMC-QAT-I(D), Dover, New Jersey 07801-5001.

6.4 Distribution of ammunition data cards. Distribution of data cards shall include the following: Commander, U.S. Army Armament Research and Development Center, ATTN: AMSMC-QAT-M(D), Dover, New Jersey 07801-5001.

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6.5 Drawings. Drawings listed in Section 2 of this specification under the heading U.S. Army Armament Research and Development Center (ARDC) may also include drawings prepared by, identified as, Edgewood Arsenal, Frankford Arsenal, Rock Island Arsenal or Picatinny Arsenal drawings. Technical data originally prepared by these activities is now under the cognizance of ARDC.

6.6 Data requirement. Deliverable data required by this specification is cited in the following paragraphs:

Paragraph 4.5.3
Data requirement
Applicable DID

Engineering Data
DI-R-1721

(Copies of data item description required by the contractors in connection with specific procurement functions should be obtained from the procuring activity or as directed by the Contracting Officer).

6.7 Changes from Previous Issue. Asterisks are not used in this revision to identify changes with respect to the previous issue, due to the extensiveness of the changes.

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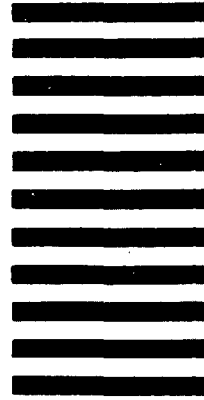


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