

INCH-POUND

**MIL-I-8846D
AMENDMENT 1
30 September 1994**

**MILITARY SPECIFICATION
INSERTS, SCREW-THREAD, HELICAL COIL
GENERAL SPECIFICATION FOR**

This amendment forms a part of MIL-I-8846, dated 8 March 1994, and is approved for use by all Departments of and Agencies of the Department of Defense.

PAGE 2

Delete.

Specifications

Federal

PPP-H-1581 - Hardware (Fasteners and Related Items) Packing of

PAGE 3

American Society for Testing and Materials (ASTM)

Add:

ASTM D 3951-90 - Standard Practice for Commercial Packaging

PAGE 6

4 1.2 - Renumber second paragraph 4.1.2 to read 4.1.3.

AMSC N/A

1 of

FSC 5340

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

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PAGE 6

4.3.23 - Delete and substitute

4.3.2.3 Destructive tests - screw locking torque. A random sample shall be selected from each production sample lot as per Table III Normal sample size inspection shall be in effect until conditions for adjusting from normal to reduced sampling size are satisfied. Normal sampling size inspection shall resume when the conditions for switching from reduced to normal sample size occur.

4 3.2.3.1 - Add.

4 3 2.3.1 Normal to reduced sample size switching. Switching from normal to reduced sample shall be instituted providing the following conditions are satisfied

- a The preceding 10 lots have been on normal inspection (Note 6 5) and all have been accepted; and
- b Production of a sample item or items using similar processes has been continuous under normal size sampling without a break longer than 90 days; and
- c. Reduced inspection is considered desirable

4.3.2 3.2 Add

4 3 2.3 2 Reduced to normal sample size switching. When reduced sample size inspection is in effect, normal sample size inspection shall be instituted if any of the following conditions occur on original inspection:

- a A lot is rejected; or
- b. Production of a sample item or items using similar processes ceases or is delayed for a period greater than 90 days; or
- c. Other conditions warrant that normal sample size inspection be resumed

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TABLE III - SAMPLE SIZES:

Modify TABLE III *

Table III. Sample Sizes

| Nondestructive Tests Visual and Dimensional Characteristics | | Destructive Tests Screw-Locking Torque | | |
|---|----------------|---|--------------------------|---------------------------|
| Production Inspection Lot Size | Sample Size | Production Inspection Lot Size | Normal Sample Size | Reduced Sample Size |
| 90 & under | 8 | 50 & under | 2 | 2 |
| 91 to 150 | 12 | 51 to 500 | 3 | 2 |
| 151 to 280 | 19 | 501 to 35000 | 5 | 2 |
| 281 to 500 | 21 | 35001 & over | 8 | 5 |
| 501 to 1200 | 27 | | | |
| 1201 to 3200 | 35 | | | |
| 3201 to 10000 | 38 | | | |
| 10001 to 35000 | 46 | | | |
| 35001 to 150000 | 56 | | | |
| 150001 & over | 64 | | | |

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5. PACKAGING

5.1 Delete and substitute: Packaging requirements preservation, packaging, packing, and marking shall conform to ASTM D 3951-90 Standard Practice for Commercial Packaging

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Renumber paragraph 6.5 to read 6.6, add new paragraph 6.5 to read as follows

“6.5 Sampling. Only tests conducted after this issue date of MIL-I-8846D are to be considered for satisfying normal to reduced sample size switching conditions.”

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Add

Agent:

DLA - IS

Custodians:

Army - AV

Navy - AS

Air Force - 99

Preparing Activity:

Air Force - 82

Review Activities:

Army - AR, MI, EA, AT, CR, GL, ME

Navy - SH

(Project 5340-2207)