

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

MIL-I-8846D
AMENDMENT 1

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

MIL-I-8846D
AMENDMENT 1

PAGE 7

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			

**MIL-I-8846D
AMENDMENT 1**

PAGE 9

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

PAGE 10

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.”

PAGE 10

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)