

INCH-POUND

MIL-L-45585D (AR)
 AMENDMENT 1
 7 September 2000

MILITARY SPECIFICATION

LINK CARTRIDGE, METALLIC BELT, 40MM, M16A2

MIL-L-45585D was inactivated on 2 February 1996 for new design.

This amendment forms a part of Military Specification MIL-L-45585D (AR), dated 12 September 1983, and is approved for use by the U.S. Army Armament, Research, Development, and Engineering Center, and is available for use by all Departments and Agencies of the Department of Defense.

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2.1.2, Inspection Equipment Drawings, delete:

"11018359 - Gage, Special Ring
 IEL 11691393 - Index of Inspection Equipment"

And substitute the following:

"8440212 - Gage, Location
 8440213 - Gage, Location
 8441408 - Gage, Indicator
 11017978 - Operating Instructions for Location Gage
 D8440213
 11017979 - Operating Instructions for Location Gage
 D8440212
 11017980 - Operating Instructions for use with Gage,
 Holding Fixture D11018357
 11017981 - Operating Instructions for use with Gage,
 Holding Fixture D11018356
 11018116 - Gage, Holding Fixture
 11018215 - Gage, Indicator
 11018216 - Gage, Width
 11018217 - Gage, Special Snap
 11018218 - Operating Instructions for use with Gage,
 Holding Fixture B11018116
 11018351 - Gage, Functional

AMSC N/A

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FSC: 1310

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

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11018354 - Gage, Flush Pin
11018355 - Gage, Special Snap
11018356 - Gage, Holding Fixture
11018357 - Gage, Holding Fixture
11018359 - Gage, Special Ring
12989029 - Operating Instructions for Indicator Gage
8441408"

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4.4.1b, Delete in its entirety and substitute the following:

"b. Loops from more than one (1) heat treat batch provided each batch has successfully passed the inspections specified in paragraph 4.4.2.2, 4.4.2.3, and 4.4.3.5."

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4.4.2.1, Major 104, under Paragraph Reference/Inspection Method, delete "11018359" and substitute "4.5.16"

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4.4.2.2:

After No. of sample units, add "1/"

After 8440212 add "11017979" wherever it appears

After 8440213 add "11017978" wherever it appears

After 8441408 add "12989029" wherever it appears

After Notes, add "1/ Sample except for Major 118 shall be selected from each heat treat batch."

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4.4.2.2:

After 8440212 add "11017979" wherever it appears

After 8440213 add "11017978" wherever it appears

Delete Major 118 and 119 in their entirety and substitute the following:

"118. Salt spray prior to oil treatment 2/ 2/ 3.2
4.5.2"

Notes, delete "*" and substitute "2/" wherever it appears

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4.4.2.3, Delete in its entirety and substitute new 4.4.2.3 included.

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4.4.3.1, 4.4.3.2, 4.4.3.3, and 4.4.3.4, delete in their entirety.

4.5.1, Delete last 2 sentences and substitute the following:

"This is a destructive test. Parts so tested shall not be returned to the lot."

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4.5.10, Second sentence, add the following at the end:

"using Drawing 11018116 and 11018218."

4.5.11, Line 2, delete "Drawing 11691396" and substitute "Drawing 11017981, 11018356, and 11691396."

4.5.12, Line 2, delete "Drawing 11018356" and substitute "Drawing 11017981, 11018356, and 11691396."

QUALITY CONFORMANCE INSPECTION
CLASSIFICATION OF CHARACTERISTICS

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PARAGRAPH	TITLE	SHEET 1 OF 1			DRAWING NUMBER
4.4.2.3	Link, M16A2				11691396
CATEGORY	EXAMINATION OR TESTS	NO. OF SAMPLE UNITS	AQL Or 100%	REQUIREMENT PARAGRAPH	NEXT HIGHER ASSEMBLY
					11691393
					PARAGRAPH REFERENCE/INSPECTION METHOD
<u>CRITICAL:</u>	None defined				
<u>MAJOR:</u>					
101.	Breakaway Force Test 2/	200	1-2	3.2	4.5.11, 11017981, 11018356
102.	Stripping Force Test 2/	200	1-2	3.2	4.5.12, 11017981, 11018357
103.	Uncoupling Force Test 2/ 3/	200	1-2	3.2	4.5.13, 11017980, 11018357
104.	Functioning	144 4/	0-1	3.4	4.5.15
105.	Nose Fan, Butt Fan, Twist and Free Hinging Test	100 5/	0-1	3.2	4.5.6, 4.5.7, 4.5.8, 4.5.9
106.	Tensile Test	100 5/	0-1	3.2	4.5.10, 11018116, 11018218
107.	Hardness	80	1-2	3.2	4.5.4
108.	Carburization & Decarburization Test	3	0-1	3.2	4.5.5
109.	Cleanliness	6/	6/	3.2	4.5.14
<u>MINOR:</u>	None defined				
NOTES: 1/ Sample shall be selected from each heat treat batch except for Major 104. 2/ Same links shall be used for these tests. 3/ Coupling used for this test shall be from the same lot or lots being shipped with the loops. 4/ Sample shall be selected randomly from entire inspection lot by local Government representative. 5/ Ten (10) belts of 10 links each. Same links shall be used for these tests. 6/ Sampling and rejection shall be in accordance with MIL-P-116.					

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4.5.13, Line 2, delete "IEL11691393" and substitute "Drawing 11017980, 11018357, and 11691396."

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Add new paragraph 4.5.16 as follows:

"4.5.16 Pivot lug diameter inspection. The pivot lug diameter, max., shall be inspected on each side of the coupling in two (2) places approximately 90 degrees apart for a total of four (4) measurements. Standard measuring and test equipment, a go ring (1 measurement per side), or a contractor designed gage shall be used. The pivot lug diameter, max., shall be inspected on each side of the coupling in two (2) places approximately 90 degrees apart for a total of four (4) measurements. Standard measuring and test equipment or a contractor designed gage shall be used. All gaging shall be approved by the Government."

Custodian:
Army-AR

Preparing activity:
Army-AR

(Project 1310-0602)