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28 March 1974
SUPERSEDING
MIL-R-13577B
15 April 1968

MILITARY SPECIFICATION

RODS, CLEANING, FOR SMALL ARMS

This specification is approved for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

* 1.1 This specification covers cleaning rods, one piece and jointed, used for cleaning operations of bores and firing pin wells of small arms weapons.

2. APPLICABLE DOCUMENTS

* 2.1 The following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of this specification to the extent specified herein.

SPECIFICATIONS

Military		
MIL-W-13855	-	Weapons, Small Arms and Aircraft Armament Subsystems, General Specification for.
MIL-P-14232	-	Parts, Equipment and Tools for Army Material, Packaging and Packing of.

STANDARDS

Military		
MIL-STD-105	-	Sampling Procedures and Tables for Inspection by Attributes.
MIL-STD-109	-	Quality Assurance Terms and Definitions.

FSC 1005

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

3. REQUIREMENTS

* 3.1 First article. Requirements for submission of first article shall be as specified in the contract (see 6.2). Unless otherwise specified (see 6.2), the first article shall include the pilot pack (see 5.1).

* 3.2 Materials, construction and design. Rods shall conform to the materials, construction and design requirements specified on the applicable drawings (see 6.2) and MIL-W-13855.

3.2.1 Assembly. Cleaning rods shall be capable of assembly and disassembly by hand, without the use of tools.

3.2.2 Function. When applicable, swivel joints shall function without binding.

3.3 Marking. Marking shall be in accordance with the MIL-W-13855.

3.4 Workmanship. Workmanship shall be in accordance with MIL-W-13855.

4. QUALITY ASSURNACE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the supplier may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.2 Quality assurance terms and definitions. Quality assurance terms and definitions used herein are in accordance with MIL-STD-109.

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* 4.3 Classification of inspection. The inspection requirements specified herein are classified as follows:

a. First article inspection (see 4.4).
b. Quality conformance inspection (see 4.5).

4.4 First article inspection. The first article (initial production unit(s)) shall be submitted for inspection in accordance with the contract (see 6.2). The first article shall be representative of the production processes to be used during quantity production. The first article shall be subjected to the quality conformance inspection specified herein and such other inspection as necessary to determine that all requirements of the contract have been met.

* 4.5 Quality conformance inspection.

* 4.5.1 Inspection lot. The formation, size and presentation of inspection lots shall be in accordance with MIL-STD-105 and MIL-W-13855. The sample size for examination of parts, components and assemblies shall be determined using General Inspection Level I of MIL-STD-105.

* 4.5.2 Examination. Examination of cleaning rods shall be as specified herein and in MIL-W-13855. The examination provisions should be applied at the earliest practical point in manufacture at which it is feasible to inspect for acceptance without risk of change in the characteristic by subsequent operations. Reinspections of these characteristics on the completed product is not required provided assurance exists that the characteristic has not been changed, degraded or damaged by subsequent manufacturing, assembly or handling and that adequate inspection records are maintained.

* 4.5.2.1 Classification of defects. Classification of defects and acceptable quality levels (AQL's) for examination in accordance with MIL-STD-105 shall be as specified herein and shall include the following provisions:

a. Unless otherwise specified, AQL's apply to each listed characteristic.
b. Where "Visual" is specified as the inspection method for protective coating, the coating shall be visually examined for completeness, uniformity in appearance and color, and for freedom from pits, corrosion, scratches, and worn or bare spots.

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c. Where "Visual" is specified as the inspection method for assemblies, the assembly shall be visually examined for conformance to the requirements specified on the applicable assembly drawing.

d. Where "Visual" is specified as the inspection method for functioning assembly requirements, the assembly shall be visually examined for completeness and manually operated for functioning requirements specified on the applicable drawing.

e. Where "SAITED" (Special Acceptance Inspection and Test Equipment Design) is specified as the method of inspection, the contractor shall use inspection equipment fabricated in accordance with the Government drawing referenced on the QA Data List.

f. Where "SMTE" (Standard Measuring and Test Equipment) is specified as the method of inspection, the contractor may use any type of industry-developed, commercially available, multi-usage equipment or special inspection and/or testing equipment approved by the Government.

* 4.5.2.1.1 Rods, Cleaning, For Small Arms. Parts, components and assemblies shall be examined in accordance with the classification of defects as applicable, see table I.

TABLE I

Class	Defects	AQL	Inspection method
Critical:	None defined.		
Major:			
101	Hardness	1.0	SMTE
102	Concentricity of threads to the outside diameter (Female and Male)	1.5	SAITED
103	Interchangeability of ends or sections	1.5	Visual
104	Function of handle assy.	1.5	Visual
Minor:			
201	Slot for swab holder	2.5	SMTE
202	Outside diameter	2.5	SMTE
203	Missing or defective protective coating	4.0	Visual
204	Missing or illegible part number	4.0	Visual
205	Missing or illegible Manufacturer's Identification symbol	4.0	Visual
206	Workmanship.	4.0	Visual

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* 4.5.2.2 Certification. Unless otherwise specified, the contractor shall furnish certified statements that each inspection lot conforms to the applicable drawings, specification of the materials and processes specified (see 6.2).

* 4.5.3 Packaging examination and testing. Unless otherwise specified (see 6.2), the packaging examination and testing shall be in accordance with MIL-P-14232.

5. PREPARATION FOR DELIVERY

* 5.1 Pilot pack. The pilot pack shall consist of a cleaning rod or cleaning rods as required by and packaged in accordance with the applicable packaging data sheet for the level of protection specified in the contract (see 6.2), packed level C and forwarded in accordance with 3.1.

* 5.2 Preservation, packaging, packing and marking. Rods shall be preserved, packaged, packed and marked in accordance with the applicable packaging data sheet for the level of protection specified in the contract (see 6.2).

6. NOTES

* 6.1 Intended use. This specification is intended to cover, but not be limited to, procurement of the following cleaning rods:

Drawing		Nomenclature
C5564102	-	Rod, Cleaning, Cal. .45, M4.
C6301446	-	Rod, Cleaning, Shotgun, M9.
D6508237	-	Rod, Cleaning, Jointed, Cal. .30, M1.
D6535441	-	Rod, Cleaning, Jointed, Cal. .50, M7.
D7162920	-	Rod, Cleaning, Jointed, Caliber .30, M10.
D8766012	-	Staff, Cleaning, 20MM (5 Section Aluminum Alloy Rod).
C8436777	-	Rod, Cleaning, Small Arms, M11E3.

* 6.2 Ordering data. Procurement documents should specify the following:

a. Title, number and date of this specification.
b. List of applicable drawings and specifications pertinent to the cleaning rods, showing applicable revision dates.
c. Requirements for submission of first article and pilot pack (see 3.1, 4.4 and 5.1).

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d. Applicable packaging data sheet (6.3).
e. Selection of applicable levels of packaging and packing.
f. Packaging examination and testing, if different (see 4.5.5).

* 6.3 The following Packaging Data Sheets are applicable to the cleaning rods covered by this specification as specified in the contract (see 6.2).

Packaging Data Sheets:

P5564102	-	Rod, Cleaning, Cal. .45, M4.
P6301446	-	Rod, Cleaning, Shotgun, M9
P6508237	-	Rod, Cleaning, Jointed, Cal. .30, M1.
P6535441	-	Rod, Cleaning, Jointed, Cal. .50, M7.
P7162920	-	Rod, Cleaning, Jointed, Cal. .30, M10.
P8766012	-	Staff, Cleaning, 20MM (5 Section Aluminum Alloy Rod).
P8436777	-	Rod, Cleaning, Small Arms, M11E3.

6.4 Management control system requirements. When warranted, the contract should specify the application of MIL-I-45208 on the Management Control Systems Summary List, DD Form 1660.

6.5 The margins of this specification are marked with an asterisk to indicate where changes (additions, modifications, corrections, deletions, from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous issue.

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DOCUMENT IDENTIFIER AND TITLE

MIL-R-13577C; Rods, Cleaning, For Small Arms

NAME OF ORGANIZATION AND ADDRESS

CONTRACT NUMBER

MATERIAL PROCURED UNDER A

☐ DIRECT GOVERNMENT CONTRACT ☐ SUBCONTRACT

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A. GIVE PARAGRAPH NUMBER AND WORDING.

B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES

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