

MIL-T-45890A(AR)  
 4 February 1982  
 Superseding  
 MIL-T-45890(PA)  
 23 June 1975

MILITARY SPECIFICATION

TOOLS FOR PROJECTILE, M422

This specification is approved for use by the US Army Armament Research and Development Command and is available for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification covers requirements, quality assurance provisions, and the preparation for delivery for tools used on 8 inch Projectile, M422.

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications and standards. Unless otherwise specified (see 6.4), the following specifications and standards of the issue listed in that issue of the Department of Defense Index of Specifications 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
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STANDARDS

FEDERAL

Federal Test Method Standard No.151.	Metals: Test Method
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MILITARY

MIL-STD-1188	Commercial Packaging of Supplies and Equipment
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NO DELIVERABLE DATA  
 REQUIRED BY THIS DOCUMENT

NUOR

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MIL-STD-1169

Packaging, Packing and Marking for Shipment of Inert Ammunition Components.

## DRAWINGS

## ARRADCOM

7231161	-	Wrench, Fuze T12E1 (M18)
8592962	-	Fuze Setter Assembly, H-4003
8787024	-	Fixture, Dashpot Assembling & Filling
8787025	-	Compressor, Ring
8787026	-	Base
8787043	-	Plate Bottom
8787175	-	Pin Filling
8787605	-	Wrench, Detent H-4115
8787614	-	Gage, Flush Pin T-4075-1
8787616	-	Case, Gage Installation T-4075-2
8787626	-	Wrench, Spanner H-4011
8787869	-	Creep Stop Setting Tool T-4076
8787870	-	Wrench Spanner H-4111
8787873	-	Tool Adjusting H-4113
8787874	-	Wrench Spanner H-4007
8787879	-	Handle Assembly
8787882	-	Sleeve
8787884	-	Wrench, Spanner H-4009
8787887	-	Wrench, Spanner H-4004
8787890	-	Wrench, Spanner H-4005
8787891	-	Wrench, Spanner H-4129
8787892	-	Handle
8787893	-	Pin
8787894	-	Wrench, Spanner H-4008
8787895	-	Wrench, Spanner H-4006
8794334	-	Insertor, Spring Pin H-4021
8794359	-	Maintenance Fixture Atomic Warhead H4001
8794385	-	Post Center
8794387	-	Spring
8794393	-	Post Assembly
8794598	-	Tool Insert Removal H4020
8795637	-	Tool Holding H4112
8848825	-	Test and Handling Equipment, Atomic Weapon
9253873	-	Plug

(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.)

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## 3. REQUIREMENTS

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

3.2 Tools. The tools shall comply with all requirements specified on the drawings listed in paragraph 2.1 and associated drawings and with all requirements specified in applicable specifications and standards.

3.3 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.

3.4 Spring distortion. The springs shall comply with all requirements on dwg 8794387 and shall withstand a tension load test as specified in 4.4.2.

3.5 Welds. The welds shall be complete, of uniform size, width, smoothness and reinforcement, and shall show no evidence of pock marks, slag pockets, gas pipes porosity, overlaps, or undercuts. There shall be no visible evidence of cracks or separations in the weld metal or base metal.

3.6 Workmanship.

3.6.1 Plastic and metal characteristics. All components shall be free from cracks, splits, cold flow, shrinkage, cold shuts, inclusions, porosity, or any similar characteristic.

3.6.2 Threads. Threads shall be full and undamaged for the entire minimum length or depth as required on the applicable drawing.

3.6.3 Burrs. Parts shall be free from burrs.

3.6.4 Foreign matter. Parts shall be free from chips, dirt, grease, rust, corrosion, or any embedded foreign material.

3.6.5 Cleaning. The cleaning method shall not be injurious to any of the parts, nor shall the parts be contaminated by the cleaning agent.

## 4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection and standard quality assurance provisions. Unless otherwise specified

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herein or in the contract, the provisions of MIL-A-48078 shall apply and are thereby 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. The first article sample shall consist of the following items in sample quantities as indicated.

<u>Part description</u>	<u>Drawing no.</u>	<u>Quantity</u>
Wrench, Fuze T12E1(M18)	7231161	1
Fuze Setter Assembly, H-4003	8592962	3
Fixture, Dashpot Assembling and Filling	8787024	3
Pin, Filling	8787175	1
Wrench, Detent H-4115	8787605	1
Gage, Flush Pin T-4075-1	8787614	3
Case, Flush Pin Gage T4075-2	8787616	1
Wrench Spanner H-4011	8787626	1
Creep Stop Setting Tool T4076	8787869	3
Wrench, Spanner H-4111	8787870	1
Tool, Adjusting H-4113	8787873	1
Wrench, Spanner H-4007	8787874	1
Wrench, Spanner H-4009	8787884	1
Wrench, Spanner H-4004	8787887	1
Wrench, Spanner H-4005	8787890	1
Wrench, Spanner H-4129	8787891	1
Wrench, Spanner H-4008	8787894	1
Wrench, Spanner H-4006	8787895	1
Insertor, Spring Pin H-4021	8794334	1
Maintenance Fixture, Atomic Warhead H-4001	8794359	3
Tool, Insert Removal H-4020	8794598	1
Tool, Handling H-4112	8795637	1
Plug	9253873	1

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

4.3.3 Inspection equipment. The inspections and test specified in 4.4.2 shall be accomplished with the gages and test equipment specified in 4.4.4.

4.3.4 Rejection. See MIL-A-48078.

TABLE I.  
FIRST ARTICLE INSPECTION  
**CLASSIFICATION OF DEFECTS & TESTS**  
MIL-T-45890A (AR)

PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	SHEET 1 OF 4		DRAWING NUMBER
				AQL OR 100%	REQUIREMENT PARAGRAPH	
	Tools for Projectile, M422					See Below NEXT HIGHER ASSEMBLY
	Wrench, Fuze T12E1 (M18) (Dwg. 7231161) Examination for Defects		1	-	3.2	4.4.2.1
	Fuze Setter Assembly, M4003 (Dwg. 8592962) Examination for Defects		3	-	3.2	4.4.2.2
	Fixture, Dashpot Assembling and Filling (Dwg. 8787024) Examination for Defects		3	-	3.2	4.4.2.3 4.4.2.4 4.4.2.5
	Pin Filling (Dwg. 8787175) Examination for Defects		1	-	3.2	4.4.2.6
	Wrench Detent H-4115 (Dwg. 8787605) Examination for Defects		1	-	3.2	4.4.2.7
	Gage, Flush Pin T-4075-1 (Dwg. 8787614) Examination for Defects		3	-	3.2	4.4.2.8
<b>NOTES:</b>						

DRD:R-QA Form 160 Jul 77 Replaces SARPA-QA Form 2567 Feb 74 Which is Obsolete

TABLE I.  
FIRST ARTICLE INSPECTION  
MIL-T-45890A (AR)  
**CLASSIFICATION OF DEFECTS & TESTS**

PARAGRAPH	TITLE	NO. OF SAMPLE UNITS	AQL OR 100%	SHEET 2 OF 4		DRAWING NUMBER See Below NEXT HIGHER ASSEMBLY
				REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD	
	Tools For Projectile, M422					
CATEGORY	EXAMINATION OR TEST					
	Case, Flush Pin Gage T4075-2 (Dwg. 878616) Examination for Defects	1	-	3.2	4.4.2.9	
	Wrench Spanner H-4011 (Dwg. 8787626) Examination for Defects	1	-	3.2	4.4.2.10	
	Creep Stop Setting Tool T4076 (Dwg. 8787869) Examination for Defects	3	-	3.2	4.4.2.11 4.4.2.15 4.4.2.16	
	Wrench, Spanner H-4111 (Dwg. 8787870) Examination for Defects	1	-	3.2	4.4.2.12	
	Tool, Adjusting H-4113 (Dwg. 8787873) Examination for Defects	1	-	3.2	4.4.2.13	
	Wrench, Spanner H-4007 (Dwg. 8787874) Examination for Defects	1	-	3.2	4.4.2.14	
NOTES						

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TABLE I.  
FIRST ARTICLE INSPECTION  
MIL-T-45890A (AR)  
**CLASSIFICATION OF DEFECTS & TESTS**

PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	SHEET 3 OF 4		DRAWING NUMBER See Below NEXT HIGHER ASSEMBLY
				AQL OR 100%	REQUIREMENT PARAGRAPH	
CATEGORY	PARAGRAPH REFERENCE /INSPECTION METHOD					
	Tools For Projectile, M422					
	Wrench, Spanner H-4009 (Dwg. 8787884) Examination for Defects		1	-	3.2	4.4.2.17
	Wrench, Spanner H-4004 (Dwg. 8787887) Examination for Defects		1	-	3.2	4.4.2.18
	Wrench, Spanner H-4005 (Dwg. 8787890) Examination for Defects		1	-	3.2	4.4.2.19
	Wrench, Spanner H-4129 (Dwg. 8787891) Examination for Defects		1	-	3.2	4.4.2.20 4.4.2.21 4.4.2.22
	Wrench, Spanner H-4008 (Dwg. 8787894) Examination for Defects		1	-	3.2	4.4.2.23
	Wrench, Spanner H-4006 (Dwg. 8787895)		1	-	3.2	4.4.2.24
	Insertor, Spring Pin H-4021 (Dwg. 8794334) Examination for Defects		1	-	3.2	4.4.2.25
NOTES:						

TABLE I.  
FIRST ARTICLE INSPECTION  
CLASSIFICATION OF DEFECTS & TESTS  
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PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	SHEET 4 OF 4	DRAWING NUMBER
	Tools For Projectile, M422					See Below NEXT HIGHER ASSEMBLY
	Maintenance Fixture, Atomic Warhead (Dwg. 8794359) Examination for Defects		3	-	3.2	4.4.2.26 4.4.2.27 4.4.2.28 4.4.2.29
	Tool, Insert Removal H-4020 (Dwg. 8794598) Examination for Defects		1	-	3.2	4.4.2.30
	Tool, Holding H-4112 (Dwg. 8795637) Examination for Defects		1	-	3.2	4.4.2.31
	Plug (Dwg. 9253873) Examination for Defects		1	-	3.2	4.4.2.32
NOTES:						

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4.4 Quality conformance inspection.

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

4.4.2 Examination. See MIL-A-48078 and the Quality Conformance Inspection Tables herein.

- a. Major defect sampling plans. Unless otherwise specified, inspection for major defects shall be sampled in accordance with Table II.
- b. Minor defect sampling plans. Unless otherwise specified, inspection for minor defects shall be sampled in accordance with Table III.

Table II. Major Defects/Characteristics

<u>Lot Size</u>	<u>Sample Size</u>						
1-16	all	28-29	23	52-56	31	132-156	39
17	16	30-31	24	57-62	32	157-191	40
18	17	32-34	25	63-69	33	192-244	41
19-20	18	35-36	26	70-76	34	245-334	42
21	19	37-40	27	77-86	35	335-519	43
22-23	20	41-43	28	87-97	36	520-1120	44
24-25	21	44-47	29	98-112	37	over 1120	45
26-27	22	48-51	30	113-131	38		

Table III. Minor Defects/Characteristics

<u>Lot Size</u>	<u>Sample Size</u>						
1-9	all	14-16	12	28-33	16	77-121	20
10	9	17-18	13	34-41	17	122-273	21
11	10	19-22	14	42-54	18	over 273	22
12-13	11	23-27	15	55-76	19		

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

PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	SHEET 1 OF 1		DRAWING NUMBER
				AQL OR 100%	REQUIREMENT PARAGRAPH	
4.4.2.1	Wrench, Fuze, T12E1 (M18)					7231161 NEXT HIGHER ASSEMBLY
<u>Critical</u>	None defined					
<u>Major</u>						
101.	Torque Test	(a)	3.2	Gage/8815262		
102.	Profile of throat	(a)	3.2	Gage/8803623		
103.	Length of point	(a)	3.2	Gage/8803624		
104.	Width of point	(a)	3.2	Gage/8803624		
105.	Thickness of point	(a)	3.2	Gage/8803624		
106.	Hardness	(a)	3.2	4.5.1		
<u>Minor</u>						
201.	Profile of point	(b)	3.2	Gage/8803624		
202.	Total length	(b)	3.2	Gage/5210-220-4560		
203.	Width of handle	(b)	3.2	Gage/5210-222-4559		
204.	Large outside width	(b)	3.2	Gage/5210-222-4559		
205.	Protective finish damaged exposing base metal	(b)	3.2	Visual		
206.	Marking illegible	(b)	3.2	Visual		
207.	Evidence of poor workmanship	(b)	3.6	Visual		
<b>NOTES:</b>						
	(a) Sample size per Table II					
	(b) Sample size per Table III					

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

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PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER
		EXAMINATION OR TEST	REQUIREMENT PARAGRAPH	
CATEGORY		NO. OF SAMPLE UNITS	AQL OR 100%	PARAGRAPH REFERENCE / INSPECTION METHOD
	Fuze Setter Assembly, H-4003			NEXT HIGHER ASSEMBLY
<u>Critical</u>	None defined			
<u>Major</u>				
101.	Any component missing, loose or damaged	(a)	3.2	Visual/Manual
<u>Minor</u>				
201.	Marking illegible	(b)	3.2	Visual
202.	Evidence of poor workmanship	(b)	3.6	Visual

**NOTES:**  
 (a) Sample size per Table II  
 (b) Sample size per Table III

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QUALITY CONFORMANCE INSPECTION

**CLASSIFICATION OF DEFECTS & TESTS**

PARAGRAPH	TITLE	SHEET 1 OF 1		NO. OF SAMPLE UNITS	EXAMINATION OR TEST	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE /INSPECTION METHOD
		AQL OR 100%					
4.4.2.4	Base						
<b>Critical</b>	None defined						
<b>Major</b>	Inside diameter		(a)				Gage/5210-790-2526
101.	Diameter of counterbore		(a)				Gage/5210-790-0368
102.	Depth of counterbore		(a)				Gage/5210-221-1961
103.	Length		(a)				Gage/5210-222-4559
104.							
<b>Minor</b>	Finish incorrect		(b)				Visual
201.	Protective finish damaged exposing base metal		(b)				Visual
202.	Marking illegible		(b)				Visual
203.							

NOTES: (a) Sample size per Table II  
(b) Sample size per Table III

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

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PARAGRAPH	TITLE	SHEET 1 OF 1		NO. OF SAMPLE UNITS	EXAMINATION OR TEST	AQL OR 100%	REQUIREMENT PARAGRAPH	DRAWING NUMBER	NEXT HIGHER ASSEMBLY	PARAGRAPH REFERENCE /INSPECTION METHOD
4.4.2.5	Plate, Bottom							8787043		
CATEGORY								8787026		
<u>Critical</u>	None defined									
<u>Major</u>										
101.	Length to base		(a)							Gage/5210-274-2861
102.	Diameter of base		(a)							Gage/5210-222-4559
103.	Profile at end of shaft		(a)							Gage/8815318
104.	Diameter of shaft		(a)							Gage/8815318
<u>Minor</u>										
201.	Finish improper		(b)							Visual
202.	Protective finish damaged exposing base metal		(b)							Visual
203.	Evidence of poor workmanship		(b)							Visual
204.	Marking illegible		(b)							Visual

NOTE:

- (a) Sample size per Table II
- (b) Sample size per Table III

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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER
		AQL OR 100%	REQUIREMENT PARAGRAPH	
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	PARAGRAPH REFERENCE / INSPECTION METHOD	NEXT HIGHER ASSEMBLY
4.4.2.6	Pin Filling			8787175
<u>Critical</u>	None defined			
<u>Major</u>	None defined			
<u>Minor</u>				
201.	Small outside diameter	(b)	3.2	Gage/5210-790-0238
202.	Large outside diameter	(b)	3.2	Gage/5210-790-0238
203.	Length to shoulder (max)	(b)	3.2	Gage/5210-274-2861
204.	Total length (min)	(b)	3.2	Gage/5210-790-0238
205.	Protective finish damaged exposing base metal	(b)	3.2	Visual
206.	Finish improper	(b)	3.2	Visual
207.	Evidence of poor workmanship	(b)	3.6	Visual

**NOTES:**  
 (b) Sample size see Table III

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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	SHEET 1 OF 2		DRAWING NUMBER
				AQL OR 100%	REQUIREMENT PARAGRAPH	
CATEGORY						PARAGRAPH REFERENCE /INSPECTION METHOD
4.4.2.7	Wrench, Detent H-4115					8787605 NEXT HIGHER ASSEMBLY
<u>Critical</u>	None defined					
<u>Major</u>						
101.	Pitch diameter of small thread on handle assembly	(a)		3.2		Gage/5220-751-4644 5220-751-4645 5220-751-4646 5220-751-4647 5220-751-5448 5220-751-5449 5220-751-5450 5220-751-5451
102.	Major diameter of small thread on handle assembly	(a)		3.2		Gage/5220-747-9460
103.	Pitch diameter of large thread on handle assembly (min)	(a)		3.2		Gage/5220-751-5448 thru 5551
104.	Major diameter of large thread on handle assembly (min)	(a)		3.2		Gage/5220-747-9462
105.	Length to end of large thread on handle assembly (min)	(a)		3.2		Gage/8803593
106.	Length to start of large thread on handle assembly	(a)		3.2		Gage/5210-274-2861
107.	Pitch diameter of wing nut thread (max)	(a)		3.2		Gage/5220-751-4220

**NOTES:**

(a) Sample size per Table II

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**CLASSIFICATION OF DEFECTS & TESTS**

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PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	SHEET	2 OF 2	DRAWING NUMBER	PARAGRAPH REFERENCE /INSPECTION METHOD
							8787605	
CATEGORY								
Major (cont)								
108.		Minor diameter of wing nut thread (max)	(a)					Gage/5220-746-0120
109.		Profile of bottom contour of wing nut	(a)					Gage/8803392
110.		Hardness	(a)					4.5.1
Minor								
201.		Protective finish damaged exposing base metal	(b)					Visual
202.		Marking illegible	(b)					Visual
203.		Handle loose	(b)					Manual
204.		Pin loose	(b)					Manual
205.		Any operation missing	(b)					Visual
206.		Evidence of poor workmanship	(b)					Visual

**NOTES:**  
 (a) Sample size per Table II  
 (b) Sample size per Table III

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**CLASSIFICATION OF DEFECTS & TESTS**

MIL-T-45890A (AR)

PARAGRAPH	TITLE	SHEET 1 OF 2		NO. OF SAMPLE UNITS	EXAMINATION OR TEST	AQL OR 100%	REQUIREMENT PARAGRAPH	DRAWING NUMBER	PARAGRAPH REFERENCE / INSPECTION METHOD
4.4.2.8	Gage Flush Pin T-4075-1							8787614	
								NEXT HIGHER ASSEMBLY	
<u>Critical</u>									
1	Protrusion of pin with opposite end flush					100%	3.2	Gage/7284949	Gage/7284949 /5210-229-9518
2	Depth to face of holder flange with opposite end flush					100%	3.2	Gage/7284949	
<u>Major</u>									
101.	Outside diameter of fingers			(a)			3.2	Gage/5210-220-1934	Gage/5210-220-1934
102.	Inside diameter of fingers			(a)			3.2	5210-221-2076	5210-221-2076
103.	Depth of cavity inside fingers (min)			(a)			3.2	Gage (c)/5210-221-1934	Gage (c)/5210-221-1934
104.	Thickness of holder flange (max)			(a)			3.2	Gage (c)/5210-790-1836	Gage (c)/5210-790-1836
105.	Holder not free in body			(a)			3.2	Gage (c)/5210-222-4559	Gage (c)/5210-222-4559
106.	Pin not free in holder			(a)			3.2	Manual	Manual
<u>Minor</u>									
201.	Total length (max)			(b)			3.2	Gage/7284949	Gage/7284949 8815319

**NOTES:**

(a) Sample size per Table II, (b) Sample size per Table III, (c) To be checked after disassembly

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**CLASSIFICATION OF DEFECTS & TESTS**

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PARAGRAPH	TITLE	SHEET 2 OF 2		DRAWING NUMBER
4.4.2.8 (cont)	Gage Flush Pin T-4075-1			8787614
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH
<u>Minor</u> (cont)				
202.	Width of fingers	(b)		3.2
203.	Profile between fingers	(b)		3.2
204.	Protective finish damaged exposing base metal	(b)		3.2
205.	Finish incorrect	(b)		3.2
206.	Marking illegible	(b)		3.2
207.	Evidence of poor workmanship	(b)		3.6
				Gage/5210-222-4559 Visual Visual c) Visual Visual Visual

**NOTES:**  
 (a) Sample size per Table II, (b) Sample size per Table III, (c) To be checked after disassembly

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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	SHEET 1 OF 1		NO. OF SAMPLE UNITS	EXAMINATION OR TEST	AQL OR 100%	REQUIREMENT PARAGRAPH	DRAWING NUMBER	PARAGRAPH REFERENCE / INSPECTION METHOD
		NEXT HIGHER ASSEMBLY							
4.4.2.9	Case, Flush Pin Gage T-4075-2							8787616	
<u>Critical</u>	None defined								
<u>Major</u>	Inability of box to accept simulated gage (functional)	(a)					3.2	Gage/8815320	
<u>Minor</u>	Height (max)	(b)					3.2	Gage/5210-222-4560	
	Length over hardware	(b)					3.2	Gage/5210-222-4560	
	Marking illegible	(b)					3.2	Visual	
	Any component missing	(b)					3.2	Visual	
	Evidence of poor workmanship	(b)					3.6	Visual	

**NOTES:**

- (a) Sample size per Table II
- (b) Sample size per Table III

DRDA-R-QA Form 160 Jul 77 Replaces SARPA-QA Form 2567 Feb 74 Which is Obsolete

QUALITY CONFORMANCE INSPECTION  
MIL-T-45890A (AR)  
**CLASSIFICATION OF DEFECTS & TESTS**

PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	SHEET 1 OF 1		DRAWING NUMBER
					REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE /INSPECTION METHOD	
4.4.2.10	Wrench, Spanner H-4011						8287626 NEXT HIGHER ASSEMBLY
<u>Critical</u>	None defined						
<u>Major</u>							
101.	Pitch diameter of nut thread (max)	(a)	3.2	Gage/8781653			
102.	Major diameter of nut thread (min)	(a)	3.2	8781654			
103.	Location of pins (functional)	(a)	3.2	Gage/5220-747-9374			
104.	Protrusion of pins	(a)	3.2	Gage/8815321			
105.	Length of nut thread pilot (max)	(a)	3.2	Gage/5210-274-1961			
106.	Handle or plate weld insecure	(a)	3.2	Gage/5210-274-2861			
107.	Knob and shaft assembly bound	(a)	3.2	Manual			
108.	Hardness	(a)	3.2	Manual 4.5.1			
<u>Minor</u>							
201.	Length of handle	(b)	3.2	Gage/5210-222-4560			
202.	Width of handle	(b)	3.2	Gage/5210-222-4560			
203.	Length of plate	(b)	3.2	Gage/5210-222-4559			
204.	Width of plate	(b)	3.2	Gage 5210-222-4559			
205.	Marking illegible	(b)	3.2	Visual			
206.	Protective finish damaged exposing base metal	(b)	3.2	Visual			
207.	Any component missing	(b)	3.2	Visual			
208.	Evidence of poor workmanship	(b)	3.6	Visual			
<b>NOTES:</b>							
(a)	Sample size per Table II						
(b)	Sample size per Table III						

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MIL-T-45890A (AR)  
**CLASSIFICATION OF DEFECTS & TESTS**

PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	SHEET 1 OF 2		DRAWING NUMBER
				AQL OR 100%	REQUIREMENT PARAGRAPH	
CATEGORY	NEXT HIGHER ASSEMBLY					
						PARAGRAPH REFERENCE / INSPECTION METHOD
4.4.2.11	Creep Stop Setting Tool T-4076					8287869
<u>Critical</u>	None defined					
<u>Major</u>						
101.	Small outside diameter of sleeve (max)	(a)	3.2			Gage/5210-250-0867
102.	Large outside diameter of sleeve (max)	(a)	3.2			Gage/5210-250-0867
103.	Concentricity of large outside diameter of sleeve with small outside diameter	(a)	3.2			Gage/8815322
104.	Length of sleeve (min)	(a)	3.2			Gage/5210-222-4560
105.	Length to large outside diameter of sleeve (max)	(a)	3.2			Gage/5210-224-2861
106.	Total length (max)	(a)	3.2			Gage/3460-529-1379
107.	Handle assembly loose in sleeve	(a)	3.2			Gage/5210-239-8570 Gage/5210-790-2354 Visual
<u>Minor</u>						
201.	Inside diameter of sleeve	(b)	3.2			Gage/5210-790-0368
202.	Protective finish damaged exposing base metal	(b)	3.2			Visual
203.	Stake missing	(b)	3.2			Visual
204.	Nut protrudes above sleeve	(b)	3.2			Visual
205.	Any operation missing	(b)	3.2			Visual
206.	Marking illegible	(b)	3.2			Visual

NOTES:  
(a) Sample size per Table II  
(b) Sample size per Table III

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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	SHEET 2 OF 2		NO. OF SAMPLE UNITS	EXAMINATION OR TEST	AQL OR 100%	REQUIREMENT PARAGRAPH	DRAWING NUMBER	PARAGRAPH REFERENCE /INSPECTION METHOD
4.4.2.11 (cont)	Creep Stop Setting Tool T-4076							8287869	NEXT HIGHER ASSEMBLY
<u>Minor</u> 207. 208.	Finish incorrect Evidence of poor workmanship			(b) (b)			3.2 3.6		Visual Visual

**NOTES:**

- (a) Sample size per Table II
- (b) Sample size per Table III

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QUALITY CONFORMANCE INSPECTION  
**CLASSIFICATION OF DEFECTS & TESTS**  
 MIL-T-45890A (AR)

PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	SHEET 1 OF 1		PARAGRAPH REFERENCE / INSPECTION METHOD
					REQUIREMENT PARAGRAPH	DRAWING NUMBER	
4.4.2.12	Wrench, Spanner H-4111						8787870 NEXT HIGHER ASSEMBLY
<u>Critical</u>	None defined						
<u>Major</u>							
101.	Diameter of hole	(a)	3.2				Gage/5210-790-2546 /5210-221-1930
102.	Concentricity of hole with outside diameter of pin (functional)	(a)	3.2				Gage/8815323
103.	Diameter of pin (max)	(a)	3.2				Gage/5210-790-0238
104.	Length of pin (min)	(a)	3.2				Gage/5210-274-2861
105.	Protrusion of lip on pin	(a)	3.2				Gage/5210-274-2861
106.	Width of lip on pin	(a)	3.2				Gage/5210-222-4559
107.	Location of lip	(a)	3.2				Gage/8815324
108.	Hardness	(a)	3.2				4.5.1
<u>Minor</u>							
201.	Length of handle	(b)	3.2				Gage/5210-222-4560
202.	Angle of handle wings (functional)	(b)	3.2				Gage/5210-273-9869
203.	Marking illegible	(b)	3.2				Visual
204.	Any operation missing	(b)	3.2				Visual
205.	Finish incorrect	(b)	3.2				Visual
206.	Evidence of poor workmanship (see 3.6)	(b)	3.2				Visual
207.	Protective finish damaged exposing base metal	(b)	3.2				Visual

NOTES:  
 (a) Sample size per Table II  
 (b) Sample size per Table III

MIL-T-45890A (AR)

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

PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	SHEET 1 OF 1	DRAWING NUMBER 87873	NEXT HIGHER ASSEMBLY	PARAGRAPH REFERENCE /INSPECTION METHOD
4.4.2.13	Tool, Adjusting, H-4113							
<u>Critical</u>		None defined						
<u>Major</u>								
101.	Profile of angle at point	(a)						Gage/8815325
102.	Width of blade	(a)						Gage/8815325
103.	Diameter of shank	(a)						Gage/5210-790-0238
104.	Length of blade (min)	(a)						Gage/8815325
105.	Length of shank (min)	(a)						Gage/5210-274-2861
106.	Hardness	(a)						4.5.1
<u>Minor</u>								
201.	Marking illegible	(b)						Visual
202.	Evidence of poor workmanship (see 3.6)	(b)						Visual
203.	Protective finish damaged exposing base metal	(b)						Visual

NOTES:  
 (a) Sample size per Table II  
 (b) Sample size per Table III

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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	SHEET 1 OF 1		DRAWING NUMBER
				AQL OR 100%	REQUIREMENT PARAGRAPH	
CATEGORY						PARAGRAPH REFERENCE / INSPECTION METHOD
4.4.2.14	Wrench, Spanner H-4007					8287874 NEXT HIGHER ASSEMBLY
<u>Critical</u>	None defined					
<u>Major</u>						
101.	Location of pins (functional)	(a)	3.2			Gage/8815493
102.	Protrusion of pins	(a)	3.2			Gage/5210-221-1961
103.	Diameter of pins (max)	(a)	3.2			Gage/5210-790-0238
104.	Weld inadequate	(a)	3.5			Visual
105.	Hardness	(a)	3.2			4.5.1
<u>Minor</u>						
201.	Width of pin plate	(b)	3.2			Gage/5210-222-4559
202.	Length of pin plate	(b)	3.2			Gage/5210-222-4559
203.	Length of handle	(b)	3.2			Gage/5210-222-4559
204.	Any operation missing	(b)	3.2			Visual
205.	Protective finish damaged exposing base metal	(b)	3.2			Visual
206.	Marking illegible	(b)	3.2			Visual
207.	Evidence of poor workmanship	(b)	3.6			Visual
208.	Any component loose	(b)	3.2			Visual

NOTES:  
 (a) Sample size per Table II  
 (b) Sample size per Table III

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MIL-T-45890A (AR)  
**CLASSIFICATION OF DEFECTS & TESTS**

PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	SHEET 1 OF 1		DRAWING NUMBER 8287879 NEXT HIGHER ASSEMBLY
				AOL OR 100%	REQUIREMENT PARAGRAPH	
CATEGORY	PARAGRAPH REFERENCE / INSPECTION METHOD					
4.4.2.5	Handle Assembly					
<u>Critical</u>	None defined					
<u>Major</u>						
101.	Pitch diameter of thread (min)	(a)	3.2			Gage/5220-751-6248 5220-751-6249
102.	Major diameter of thread (min)	(a)	3.2			Gage/5220-747-9398
<u>Minor</u>						
201.	Thickness of nut	(b)	3.2			Gage/5210-790-0238
202.	Evidence of poor workmanship	(b)	3.6			Visual

NOTES:  
(a) Sample size per Table II  
(b) Sample size per Table III

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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER
4.4.2.16	Sleeve			8287882
		AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE /INSPECTION METHOD
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS		
<u>Critical</u>	None defined			
<u>Major</u>				
101.	Pitch diameter of thread (max)	(a)	3.2	Gage/5220-751-4552
102.	Minor diameter of thread (max)	(a)	3.2	Gage/5220-751-6753
103.	Depth of thread (min)	(a)	3.2	Gage/8828852
<u>Minor</u>				
201.	Evidence of poor workmanship	(b)	3.6	Visual

NOTES:

- (a) Sample size per Table II
- (b) Sample size per Table III

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**CLASSIFICATION OF DEFECTS & TESTS**

MIL-T-45890A (AR)

PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AOI OR 100%	SHEET 1 OF 1		PARAGRAPH REFERENCE / INSPECTION METHOD
					DRAWING NUMBER	NEXT HIGHER ASSEMBLY	
4.4.2 (7)	Wrench, Spanner H-4009						8787884
<u>Critical</u>	None defined						
<u>Major</u>	Protrusion of pins Location of pins (functional) Diameter of pins Pin loose Weld inadequate Hardness	(a) (a) (a) (a) (a) (a)			3.2 3.2 3.2 3.2 3.5 3.2		Gage/5210-221-1961 Gage/8815326 Gage/5210-221-1930 Manual Visual 4.5.1
<u>Minor</u>	Protective finish damaged exposing base metal Any operation missing Marking illegible Evidence of poor workmanship	(b) (b) (b) (b)			3.2 3.2 3.2 3.6		Visual Visual Visual Visual

NOTES:  
 (a) Sample size per Table II  
 (b) Sample per size Table III

QUALITY CONFORMANCE INSPECTION  
MIL-T-45890A(AR)  
**CLASSIFICATION OF DEFECTS & TESTS**

PARAGRAPH	TITLE	SHEET		NO. OF SAMPLE UNITS	EXAMINATION OR TEST	DRAWING NUMBER
		1	OF 1			
CATEGORY		AQL OR 100%	REQUIREMENT PARAGRAPH			PARAGRAPH REFERENCE / INSPECTION METHOD
	Wrench, Spanner H-4004					
<u>Critical</u>	None defined					
<u>Major</u>						
101.	Length of pin protrusion		3.2	(a)		Gage/5210-221-1961
102.	Location of pins (functional)		3.2	(a)		Gage/8815328
103.	Component or operation missing		3.2	(a)		Visual
104.	Weld inadequate		3.5	(a)		Visual
105.	Hardness		3.2	(a)		4.5.1
<u>Minor</u>						
201.	Length of handle		3.2	(b)		Gage/5210-222-4560
202.	Marking illegible		3.2	(b)		Visual
203.	Protective finish damaged exposing base metal		3.2	(b)		Visual
204.	Evidence of poor workmanship		3.6	(b)		Visual

NOTES:  
(a) Sample size per Table II  
(b) Sample size per Table III

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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	SHEET 1 OF 1		DRAWING NUMBER 8787890
				AQL OR 100%	REQUIREMENT PARAGRAPH	
CATEGORY	NEXT HIGHER ASSEMBLY					
<u>Critical</u>	None defined					
<u>Major</u>						
101.	Inside radius of jaws Thickness of lip Opening between jaw (min) Hardness		(a)			Gage/5210-222-4559 Gage/5210-790-0238 Gage/8815329 4.5.1
102.						
103.						
104.						
<u>Minor</u>						
201.	Profile of handle (functional) Overall length Protective finish damaged exposing base metal Marking illegible Evidence of poor workmanship		(b)			Gage/5210-239-0490 Gage/5210-790-2494 Visual Visual Visual
202.						
203.						
204.						
205.						
NOTES: (a) Sample size per Table II (b) Sample size per Table III						

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PARAGRAPH 4.4.2.20	TITLE Wrench, Spanner H-4129	SHEET 1 OF 1		DRAWING NUMBER 8787891
		NO. OF SAMPLE UNITS	REQUIREMENT PARAGRAPH	
CATEGORY	EXAMINATION OR TEST	AOL OR 100%	PARAGRAPH REFERENCE /INSPECTION METHOD	NEXT HIGHER ASSEMBLY
<u>Critical</u>	None defined			
<u>Major</u>				
101.	Protrusion of pin	(a)	3.2	Gage/5210-221-1961
102.	Profile between jaws	(a)	3.2	Gage/8815333
103.	Location of pins (functional)	(a)	3.2	Gage/8815331
104.	Hardness	(a)	3.2	4.5.1
<u>Minor</u>				
201.	Thickness of handle (min)	(b)	3.2	Gage/5210-222-4559
202.	Profile of handle (functional)	(b)	3.2	Gage/5210-239-0490
203.	Evidence of poor workmanship	(b)	3.6	Visual
204.	Any operation missing	(b)	3.2	Visual
205.	Marking illegible	(b)	3.2	Visual
206.	Protective finish damaged exposing base metal	(b)	3.2	Visual

NOTES: (a) Sample size per Table II  
(b) Sample size per Table III

MIL-T-45890A (AR)

QUALITY CONFORMANCE INSPECTION

**CLASSIFICATION OF DEFECTS & TESTS**

PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER
		EXAMINATION OR TEST	REQUIREMENT PARAGRAPH	
CATEGORY		NO. OF SAMPLE UNITS	AQL OR 100%	PARAGRAPH REFERENCE / INSPECTION METHOD
4.4.2.21	Handle			8787892
				NEXT HIGHER ASSEMBLY
<u>Critical</u>	None defined			
<u>Major</u>				
101.	Diameter of holes (max)	(a)		Gage/8815332
<u>Minor</u>				
201.	None defined			

NOTES: (a) Sample size per Table II

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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	SHEET 1 OF 1	DRAWING NUMBER	PARAGRAPH REFERENCE / INSPECTION METHOD
CATEGORY	EXAMINATION OR TEST	AQL OR 100%	NEXT HIGHER ASSEMBLY	
		NO. OF SAMPLE UNITS		
4.4.2.22	Pin		8787893	
<u>Critical</u>	None defined		8787891	
<u>Major</u>				
101.	Diameter (min)	(a)		Gage/5210-221-1930
102.	Length (min)	(a)		Gage/5210-790-0238
<u>Minor</u>	None defined			
				3.2. 3.2.

NOTES:  
 (a) Sample size per Table II

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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	SHEET 1 OF 1		PARAGRAPH REFERENCE /INSPECTION METHOD
					REQUIREMENT PARAGRAPH	DRAWING NUMBER	
4.4.2.23	Wrench, Spanner H-4008						8787894 NEXT HIGHER ASSEMBLY
<u>Critical</u>							
<u>Major</u>							
101.	None defined		(a)		3.2		Gage/5210-274-2861
102.	Length of lug (max)		(a)		3.2		Gage/8815334
103.	Location of lugs (functional)		(a)		3.2		Gage/5210-790-0239
104.	Outside diameter of body		(a)		3.2		Gage/5210-221-2087
105.	Inside diameter of body		(a)		3.2		Gage/5210-790-0239
106.	Width of lug		(a)		3.2		Gage/5210-790-0238
107.	Depth of body cavity (min)		(a)		3.5		Gage/5210-274-2861
108.	Width across flats of nut (functional)		(a)		3.2		Gage/8815349
109.	Weld inadequate		(a)		3.2		4.5.1
<u>Minor</u>							
201.	Hardness		(b)		3.2		Gage/5210-222-4559
202.	Total length (max)		(b)		3.2		Visual
203.	Protective finish damaged exposing base metal		(b)		3.2		Visual
204.	Marking illegible		(b)		3.5		Visual
205.	Evidence of poor workmanship		(b)		3.2		Manual
205.	Nut insecure		(b)				

**NOTES:**

- (a) Sample size per Table II
- (b) Sample size per Table III

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MIL-T-45890A (AR)

PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	SHEET 1 OF 1		DRAWING NUMBER
				AQL OR 100%	REQUIREMENT PARAGRAPH	
4.4.2.24	Wrench, Spanner H-4006					8787895 NEXT HIGHER ASSEMBLY
<u>Critical</u>	None defined					
<u>Major</u>						
101.	Outside diameter of disc	(a)	3.2	Gage/5210-233-9167		
102.	Width of lug (functional)	(a)	3.2	Gage/8815335		
103.	Length of lug	(a)	3.2	Gage/5210-790-0238		
104.	Protrusion of lug (functional)	(a)	3.2	Gage/8815335		
105.	Height of disc	(a)	3.2	Gage/5210-790-0230		
106.	Weld inadequate	(a)	3.5	Visual		
107.	Hardness	(a)	3.2	4.5.1		
<u>Minor</u>						
201.	Length of handle	(b)	3.2	Gage/5210-222-4560		
202.	Protective finish damaged exposing base metal	(b)	3.2	Visual		
203.	Marking illegible	(b)	3.2	Visual		
204.	Any component or operation missing	(b)	3.2	Visual		
205.	Any component loose	(b)	3.2	Manual		
206.	Evidence of poor workmanship	(b)	3.6	Visual		

**NOTES:**  
 (a) Sample size per Table II  
 (b) Sample size per Table III

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PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	SHEET 1 OF 1	DRAWING NUMBER	
						8794334	NEXT HIGHER ASSEMBLY
CATEGORY						PARAGRAPH REFERENCE / INSPECTION METHOD	
4.4.2.25	Inserter, Spring Pin H-4021						
<u>Critical</u>	None defined						
<u>Major</u>							
101.	Diameter of hole	(a)	3.2			Gage/5220-742-0412	
102.	Depth of hole	(a)	3.2			Gage/5220-745-8334	
103.	Location of hole	(a)	3.2			Gage/8815336	
104.	Outside diameter	(a)	3.2			Gage/8815537	
						Gage/5210-790-0238	
<u>Minor</u>							
201.	Total length (min)	(b)	3.2			Gage/5210-222-4559	
202.	Marking illegible	(b)	3.2			Visual	
203.	Protective finish damaged exposing base metal	(b)	3.2			Visual	
204.	Evidence of poor workmanship	(b)	3.6			Visual	

NOTES:  
 (a) Sample size per Table II  
 (b) Sample size per Table III

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PARAGRAPH	TITLE	SHEET 1 OF 2		DRAWING NUMBER
		NO. OF SAMPLE UNITS	REQUIREMENT PARAGRAPH	
CATEGORY	EXAMINATION OR TEST	AQL OR 100%	PARAGRAPH REFERENCE / INSPECTION METHOD	NEXT HIGHER ASSEMBLY
4.4.2.26	Maintenance Fixture Atomic Warhead H-4001			8794359
<u>Critical</u>	None defined			
<u>Major</u>				
101.	Outside diameter of cylinder	(a)	3.2	Gage/5210-223-9166
102.	Inside diameter of cylinder (min)	(a)	3.2	Gage/5210-790-0368
103.	Outside diameter of center post guide	(a)	3.2	Gage/5210-223-9167
104.	Diameter of base end of post (min)	(a)	3.2	Gage/5210-790-0238
105.	Length of cylinder	(a)	3.2	Gage/5210-267-4899
106.	Diameter of large cavity in base	(a)	3.2	Gage/8815347
107.	Ball on depressor assembly bound	(a)	3.2	Manual
<u>Minor</u>				
201.	Pitch diameter of thread on positioning screw (min)	(b)	3.2	Gage/5220-751-5632 Gage/5220-751-5633
202.	Major diameter of thread on positioning screw (min)	(b)	3.2	Gage/5220-747-9464 Gage/8815348
203.	Diameter of small cavity in base	(b)	3.2	Gage/7152985
204.	Thickness through bottom of large cavity	(b)	3.2	Gage/5210-221-1961
205.	Depth of small cavity	(b)	3.2	Gage/5220-751-4244
206.	Pitch diameter of positioning screw thread in positioning plate (max)	(b)	3.2	Gage/5220-746-1810
207.	Minor diameter of positioning screw thread in positioning plate (max)	(b)	3.2	

NOTES:

- (a) Sample size per Table II
- (b) Sample size per Table III

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MIL-T-45890A (AR)

PARAGRAPH	TITLE	SHEET 2 OF 2	DRAWING NUMBER
CATEGORY	EXAMINATION OR TEST	AQL OR 100%	REQUIREMENT PARAGRAPH
		NO. OF SAMPLE UNITS	PARAGRAPH REFERENCE / INSPECTION METHOD
4.4.2.26 (cont)	Maintenance Fixture Atomic Warhead H-4001		8794359
Minor (cont)			NEXT HIGHER ASSEMBLY
208.	Positioning handle loose	(b)	Manual
209.	Protective finish damaged exposing base metal	(b)	Visual
210.	Marking illegible	(b)	Visual
211.	Any component or operation missing	(b)	Visual
212.	Evidence of poor workmanship	(b)	Visual

**NOTES:**  
 (a) Sample size per Table II  
 (b) Sample size per Table III

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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER
		AQL OR 100%	REQUIREMENT PARAGRAPH	
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS		NEXT HIGHER ASSEMBLY
	Post Center			8794385
	None defined			8794359
<u>Critical</u>				PARAGRAPH REFERENCE / INSPECTION METHOD
<u>Major</u>				
101.	Location of collar pin hole	(a)	3.2	Gage/8815342
102.	Location of guide pin holes	(a)	3.2	Gage/8815343
103.	Location of base pin hole	(a)	3.2	Gage/8815344
<u>Minor</u>				
201.	Evidence of poor workmanship	(b)	3.6	Visual

NOTES:

- (a) Sample size per Table II
- (b) Sample size per Table III

DRDAIR-QA Form 160 Jul 77 Replaces SARPA-QA Form 2567 Feb 74 Which is Obsolete

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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	SHEET	DRAWING NUMBER
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	REQUIREMENT PARAGRAPH
4.4.2.28	Spring	1 OF 2	8794387
			NEXT HIGHER ASSEMBLY 8794359
	Lot Size		
	Sample Size		
	2-8	1	
	9-15	2	
	16-25	3	
	26-40	5	
	41-65	8	
	66-110	13	
	111-180	22	
	181-300	36	
	301 and over		
	MIL-STD-105 (AQL 0.25 percent)		
	None defined		
	Test load at height of 0.81 inches (min)	(a)	4.5.2/6510948
	Load at 0.61 inches (max)	(a)	4.5.2/8829086
	Solid height (max)	(b)	Gage/8829087
	Outside diameter (max)	(b)	Gage/5210-790-0239
	Inside diameter (min)	(b)	Gage/5220-743-7276

NOTES: (a) Sample size shall be selected in accordance with lot size table listed in Examination or Test column.  
 (b) Sample size per Table II

MIL-T-45890A (AR)

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

PARAGRAPH	TITLE	SHEET 2 OF 2		DRAWING NUMBER
		AQL OR 100%	REQUIREMENT PARAGRAPH	
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	PARAGRAPH REFERENCE / INSPECTION METHOD	NEXT HIGHER ASSEMBLY
4.4.2.28 (cont)	Spring			8794387
<u>Minor</u>				8794359
201.	Spring ends not squared and ground	(c)	3.2	Visual
202.	Protective finish damaged exposing base metal	(c)	3.2	Visual
203.	Evidence of poor workmanship	(c)	3.6	Visual

NOTE: (c) Sample size per Table III

DDAR-QA Form 160 Jul 77 Replaces SARRA-QA Form 2567 Feb 74 Which is Obsolete

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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	SHEET 1 OF 1		DRAWING NUMBER
				AQL OR 100%	REQUIREMENT PARAGRAPH	
4.4.2.29	Post Assembly					8794393
CATEGORY						NEXT HIGHER ASSEMBLY 8794359
<u>Critical</u>						PARAGRAPH REFERENCE /INSPECTION METHOD
1	Burr on cylinder			100%	3.2	Visual
<u>Major</u>						
101.	Minor diameter of post thread in depressor (max)		(a)		3.2	Gage/8815346
102.	Pitch diameter of post thread in depressor (max)		(a)		3.2	Gage/8815345
103.	Major diameter of depressor thread on post		(a)		3.2	Gage/5220-747-9366
104.	Pitch diameter of depressor thread on post		(a)		3.2	Gage/8815338 Thru 8815341
105.	Length of depressor thread on post (min)		(a)		3.2	Gage/8815415
106.	Total length of center post (min)		(a)		3.2	Gage/5210-222-4564
<u>Minor</u>						
201.	Evidence of poor workmanship		(b)		3.6	Visual

**NOTES:**

- (a) Sample size per Table II  
 (b) Sample size per Table III

DRDAR-QA Form 160 Jul 77 Replaces SARPA-QA Form 2567 Feb 74 Which is Obsolete



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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	SHEET 1 OF 1		NO. OF SAMPLE UNITS	EXAMINATION OR TEST	AQL OR 100%	REQUIREMENT PARAGRAPH	DRAWING NUMBER	PARAGRAPH REFERENCE /INSPECTION METHOD
								8795637	
CATEGORY	NEXT HIGHER ASSEMBLY								
4.4.2.31	Tool, Holding H-4112								
<u>Critical</u>	None defined								
<u>Major</u>									
101.	Diameter of tip (min)								
102.	Length of tip (min)								
<u>Minor</u>									
201.	Total length (min) -								
202.	Marking illegible								
203.	Protective finish damaged exposing base metal								
204.	Evidence of poor workmanship								
				(a)			3.2	Gage/5210-790-0238	
				(a)			3.2	Gage/5210-221-1961	
				(b)			3.2	Gage/5210-222-4559	
				(b)			3.2	Visual	
				(b)			3.2	Visual	
				(b)			3.6	Visual	

NOTES:  
 (a) Sample size per Table II  
 (b) Sample size per Table III

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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	SHEET 1 OF 1		PARAGRAPH REFERENCE /INSPECTION METHOD
				AQL OR 100%	REQUIREMENT PARAGRAPH	
4.4.2.32	Plug					DRAWING NUMBER 9253873 NEXT HIGHER ASSEMBLY
<u>Critical</u>	None defined					
<u>Major</u>						
101.	Diameter around eye section (min)	(a)	3.2	Gage/5210-790-0239		
102.	Length to shoulder (min)	(a)	3.2	Gage/5210-222-4559		
103.	Pitch diameter of thread	(a)	3.2	Gage/5210-751-6248 /5210-751-6249		
104.	Major diameter of thread	(a)	3.2	Gage/5220-747-9398		
105.	Wall thickness of threaded portion (min)	(a)	3.2	Gage/5210-222-4859		
106.	Number of threads below min.	(a)	3.2	Gage		
<u>Minor</u>						
201.	Eye hole diameter (min)	(b)	3.2	Gage/7284907		
202.	Depth of core (max)	(b)	3.2	Gage/5210-221-1961		
203.	Any operation missing	(b)	3.2	Visual		
204.	Protective finish damaged exposing base metal	(b)	3.2	Visual		
205.	Evidence of poor workmanship	(b)	3.6	Visual		

**NOTES:**  
 (a) Sample size per Table II  
 (b) Sample size per Table III

## MIL-T-45890A(AR)

4.4.3 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 examination and tests prescribed herein is described in the Paragraph Reference/Inspection Method Column in the tables starting with paragraph 4.4.2.1. 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 6.3 herein.

4.5 Test methods and procedures.

4.5.1 Hardness. The tools shall be tested as specified in Federal Test Method Standard No. 151.

4.5.2 Spring distortion. The sample spring shall be subjected to a tension test load of 68 lbs by placing one end of the spring in a suitable fixture so that the spring is hanging in a vertical position. The required weight shall then be attached to the opposite end of the spring allowing the weight to be slowly applied until the spring has been fully extended. Springs so tested for embrittlement shall be scrapped.

5. PACKAGING

5.1 Package

5.1.1 Maximum military packaging (Level A) - The Tools shall be packaged in accordance with MIL-STD 1169.

5.1.2 Commercial packaging - The Tools shall be packaged in accordance with MIL-STD-1188 unless otherwise specified in the contract.

5.2 Packing

5.2.1 Maximum military packing (Level A) - The Tools packaged in accordance with 5.1 above shall be packed in accordance with MIL-STD-1169.

5.2.2 Commercial packing - The Tools shall be packed in accordance with MIL-STD-1188, unless otherwise specified in the contract.

5.3 Marking

5.3.1 Maximum military packaging (Level A) - Packaging marking shall be in accordance with MIL-STD-129. Packaging marking shall be in accordance with MIL-STD-129.

MIL-T-45890A(AR)

5.3.2 Commercial packaging marking shall be in accordance with MIL-STD-1188, unless otherwise specified in the contract. Commercial packing marking shall be in accordance with MIL-STD-1188, unless otherwise specified in the contract.

6. NOTES

6.1 Intended use. The components covered by this specification are intended for use on the M422, 8 inch projectile.

6.2 Ordering data. See MIL-A-48078.

6.3 Submission of inspection equipment for design approvals. See MIL-A-48078. Submit designs as required to Commander, US Army Armament Research and Development Command, ATTN: DRDAR-QAN-I, Dover, NJ 07801.

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