

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 Mark-  
ing 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	-	Insert, 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	SHEET 1 OF 4		DRAWING NUMBER	
				See Below	NEXT HIGHER ASSEMBLY
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE /INSPECTION METHOD
	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
NOTES:					

DDAAR-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 &amp; TESTS

PARAGRAPH	TITLE	SHEET 2 OF 4		DRAWING NUMBER See Below	
				NEXT HIGHER ASSEMBLY	
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE /INSPECTION METHOD
	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:					

DRLA-QA Form 160 Jul 77 Replaces SAPPA-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	SHEET 3 OF 4		DRAWING NUMBER See Below NEXT HIGHER ASSEMBLY
			AQL OR 100%	REQUIREMENT PARAGRAPH	
CATEGORY	EXAMINATION OR TEST				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

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**CLASSIFICATION OF DEFECTS & TESTS**

PARAGRAPH	TITLE	SHEET 4 OF 4		DRAWING NUMBER See Below NEXT HIGHER ASSEMBLY	
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE /INSPECTION METHOD
	Maintenance Fixture, Atomic Warhead H-4001 (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>	<u>Lot Size</u>	<u>Sample Size</u>	<u>Lot Size</u>	<u>Sample Size</u>	<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>	<u>Lot Size</u>	<u>Sample Size</u>	<u>Lot Size</u>	<u>Sample Size</u>	<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		

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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER
CATEGORY	EXAMINATION OR TEST	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER
		AQL OR 100%	REQUIREMENT PARAGRAPH	
4.4.2.2	Fuze Setter Assembly, H-4003			8592962 NEXT HIGHER ASSEMBLY
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS		PARAGRAPH REFERENCE / INSPECTION METHOD
<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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER
		AQL OR 100%	REQUIREMENT PARAGRAPH	8787025
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS		NEXT HIGHER ASSEMBLY
				8787024
				PARAGRAPH REFERENCE / INSPECTION METHOD
4.4.2.3	Compressor, Ring			
<u>Critical</u>				
<u>Major</u>				
101.	Inside diameter	(a)	3.2	Gage/7284907
102..	Outside diameter	(a)	3.2	Gage/5210-790-0239
103.	Angle of taper	(a)	3.2	Gage/8815315 & 8815410
104.	Interior finish improper	(a)	3.2	Visual
<u>Minor</u>				
201.	Length to tapered surface	(b)	3.2	Gage/8815316
202.	Length	(b)	3.2	Gage/5210-222-4559
203.	Profile of curved bottom	(b)	3.2	Gage/8815317
204.	Protective finish damaged exposing base metal	(b)	3.2	Visual
205.	Evidence of poor workmanship	(b)	3.6	Visual
206.	Marking illegible	(b)	3.2	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	SHEET 1 OF 1		DRAWING NUMBER
4.4.2.5	Plate, Bottom			8787043
				NEXT HIGHER ASSEMBLY
				8787026
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH
				PARAGRAPH REFERENCE / INSPECTION METHOD
<u>Critical</u>	None defined			
<u>Major</u>				
101.	Length to base	(a)		
102.	Diameter of base	(a)		Gage/5210-274-2861
103.	Profile at end of shaft	(a)		Gage/5210-222-4559
104.	Diameter of shaft	(a)		Gage/8815318
				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

**NOTES:**

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

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

PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER
		AQL OR 100%	REQUIREMENT PARAGRAPH	
4.4.2.6	Pin Filling			8787175 NEXT HIGHER ASSEMBLY
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS		PARAGRAPH REFERENCE / INSPECTION METHOD
<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
<b>NOTES:</b> (b) Sample size see Table III				

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

## QUALITY CONFORMANCE INSPECTION

## CLASSIFICATION OF DEFECTS &amp; TESTS

MIL-T-45890A (AR)

PARAGRAPH	TITLE	SHEET 1 OF 2		DRAWING NUMBER
CATEGORY	EXAMINATION OR TEST	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
4.4.2.7	Wrench, Detent H-4115			8787605 NEXT HIGHER ASSEMBLY
Critical	None defined			
Major				
101.	Pitch diameter of small thread on handle assembly		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)		
103.	Pitch diameter of large thread on handle assembly (min)	(a)		Gage/5220-747-9460 Gage/5220-751-5448 thru 5551
104.	Major diameter of large thread on handle assembly (min)	(a)		Gage/5220-747-9462
105.	Length to end of large thread on handle assembly (min)	(a)		Gage/8803593
106.	Length to start of large thread on handle assembly	(a)		Gage/5210-274-2861
107.	Pitch diameter of wing nut thread (max)	(a)		Gage/5220-751-4220

## NOTES:

(a) Sample size per Table II

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QUALITY CONFORMANCE INSPECTION  
MIL-T-45890A (AR)

**CLASSIFICATION OF DEFECTS & TESTS**

PARAGRAPH	TITLE	SHEET 2 OF 2		DRAWING NUMBER
CATEGORY	EXAMINATION OR TEST	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
4.4.2.7 (cont)	Wrench, Detent H-4115			8787605 NEXT HIGHER ASSEMBLY
Major (cont)				
108.	Minor diameter of wing nut thread (max)	(a)	3.2	Gage/5220-746-0120
109.	Profile of bottom contour of wing nut	(a)	3.2	Gage/8803392
110.	Hardness	(a)	3.2	4.5.1
Minor				
201.	Protective finish damaged exposing base metal	(b)	3.2	Visual
202.	Marking illegible	(b)	3.2	Visual
203.	Handle loose	(b)	3.2	Manual
204.	Pin loose	(b)	3.2	Manual
205.	Any operation missing	(b)	3.2	Visual
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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QUALITY CONFORMANCE INSPECTION  
**CLASSIFICATION OF DEFECTS & TESTS**

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PARAGRAPH	TITLE	SHEET 1 OF 2		DRAWING NUMBER	
4.4.2.8	Gage Flush Pin T-4075-1			8787614	
				NEXT HIGHER ASSEMBLY	
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
<u>Critical</u>					
1	Protrusion of pin with opposite end flush		100%	3.2	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
102.	Inside diameter of fingers	(a)		3.2	5210-221-2076 Gage (c)/5210-221-1934
103.	Depth of cavity inside fingers (min)	(a)		3.2	Gage (c)/5210-790-1836
104.	Thickness of holder flange (max)	(a)		3.2	Gage (c)/5210-222-4559
105.	Holder not free in body	(a)		3.2	Manual
106.	Pin not free in holder	(a)		3.2	Manual
<u>Minor</u>					
201.	Total length (max)	(b)		3.2	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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QUALITY CONFORMANCE INSPECTION  
MIL-T-45890A (AR)  
**CLASSIFICATION OF DEFECTS & TESTS**

PARAGRAPH	TITLE	SHEET 2 OF 2		DRAWING NUMBER 8787614
		AQL OR 100%	REQUIREMENT PARAGRAPH	
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS		PARAGRAPH REFERENCE / INSPECTION METHOD
<u>Minor</u> (cont) 202. 203. 204. 205. 206. 207.	Width of fingers Profile between fingers Protective finish damaged exposing base metal Finish incorrect Marking illegible Evidence of poor workmanship	(b) (b) (b) (b) (b) (b)	3.2 3.2 3.2 3.2 3.2 3.6	Gage/5210-222-4559 Visual Visual (c) Visual Visual Visual
<b>NOTES:</b> (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  
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**CLASSIFICATION OF DEFECTS & TESTS**

PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER	
4.4.2.9	Case, Flush Pin Gage T-4075-2			8787616	
				NEXT HIGHER ASSEMBLY	
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
<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
201.	Length over hardware	(b)		3.2	Gage/5210-222-4560
202.	Marking illegible	(b)		3.2	Visual
203.	Any component missing	(b)		3.2	Visual
204.	Evidence of poor workmanship	(b)		3.6	Visual
205.					

**NOTES:**

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

DDAAR-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	SHEET 1 OF 1		DRAWING NUMBER
4.4.2.10	Wrench, Spanner H-4011			8287626
				NEXT HIGHER ASSEMBLY
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH
				PARAGRAPH REFERENCE / INSPECTION METHOD
<u>Critical</u>	None defined			
<u>Major</u>				
101.	Pitch diameter of nut thread (max)	(a)		3.2 Gage/8781653 8781654
102.	Major diameter of nut thread (min)	(a)		3.2 Gage/5220-747-9374
103.	Location of pins (functional)	(a)		3.2 Gage/8815321
104.	Protrusion of pins	(a)		3.2 Gage/5210-274-1961
105.	Length of nut thread pilot (max)	(a)		3.2 Gage/5210-274-2861
106.	Handle or plate weld insecure	(a)		3.2 Manual
107.	Knob and shaft assembly bound	(a)		3.2 Manual
108.	Hardness	(a)		3.2 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				

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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	SHEET 1 OF 2		DRAWING NUMBER	
4.4.2.11	Creep Stop Setting Tool T-4076			8287869	
		NEXT HIGHER ASSEMBLY			
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE /INSPECTION METHOD
Critical	None defined				
Major					
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
Minor					Gage/5210-790-2354
201.	Inside diameter of sleeve	(b)		3.2	Visual
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

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## QUALITY CONFORMANCE INSPECTION

MIL-T-45890A (AR)

## CLASSIFICATION OF DEFECTS &amp; TESTS

PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER	
4.4.2.12	Wrench, Spanner H-4111			8787870	
				NEXT HIGHER ASSEMBLY	
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
<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
<b>NOTES:</b> (a) Sample size per Table II (b) Sample size per Table III					

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## QUALITY CONFORMANCE INSPECTION

MIL-T-45890A (AR)

## CLASSIFICATION OF DEFECTS &amp; TESTS

PARAGRAPH	TITLE	NO. OF SAMPLE UNITS	AQL OR 100%	SHEET 1 OF 1	DRAWING NUMBER 87873
CATEGORY	EXAMINATION OR TEST			REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
	Tool, Adjusting, H-4113				NEXT HIGHER ASSEMBLY
<u>Critical</u>	None defined				
<u>Major</u>	Profile of angle at point	(a)		3.2	Gage/8815325
	Width of blade	(a)		3.2	Gage/8815325
	Diameter of shank	(a)		3.2	Gage/5210-790-0238
	Length of blade (min)	(a)		3.2	Gage/8815325
	Length of shank (min)	(a)		3.2	Gage/5210-274-2861
	Hardness	(a)		3.2	4.5.1
<u>Minor</u>	Marking illegible	(b)		3.2	Visual
	Evidence of poor workmanship (see 3.6)	(b)		3.2	Visual
	Protective finish damaged exposing base metal	(b)		3.2	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	SHEET 1 OF 1		DRAWING NUMBER
4.4.2.14	Wrench, Spanner H-4007			8287874
NEXT HIGHER ASSEMBLY				
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT / PARAGRAPH
Critical	None defined			
Major				
101.	Location of pins (functional)	(a)		Gage/8815493
102.	Protrusion of pins	(a)		Gage/5210-221-1961
103.	Diameter of pins (max)	(a)		Gage/5210-790-0238
104.	Weld inadequate	(a)		Visual
105.	Hardness	(a)		4.5.1
Minor				
201.	Width of pin plate	(b)		Gage/5210-222-4559
202.	Length of pin plate	(b)		Gage/5210-222-4559
203.	Length of handle	(b)		Gage/5210-222-4559
204.	Any operation missing	(b)		Visual
205.	Protective finish damaged exposing base metal	(b)		Visual
206.	Marking illegible	(b)		Visual
207.	Evidence of poor workmanship	(b)		Visual
208.	Any component loose	(b)		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  
MIL-T-45890A (AR)  
**CLASSIFICATION OF DEFECTS & TESTS**

PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER	
4.4.2.5	Handle Assembly			8287879	
				NEXT HIGHER ASSEMBLY	
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
<u>Critical</u>	None defined				
<u>Major</u>					
101.	Pitch diameter of thread (min)	(a)		3.2	Gage/5220-751-6248
102.	Major diameter of thread (min)	(a)		3.2	5220-751-6249 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

MIL-T-45890A (AR)

## CLASSIFICATION OF DEFECTS &amp; TESTS

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

PART NUMBER	TITLE	SHEET 1 OF 1		DRAWING NUMBER	
		NO. OF SAMPLE UNITS	ADL OR 100%		
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	ADL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
4.4.2 (7)	Wrench, Spanner H-4009				8787884 NEXT HIGHER ASSEMBLY
<u>Critical</u>	None defined				
<u>Major</u>					
101.	Protrusion of pins	(a)		3.2	Gage/5210-221-1961
102.	Location of pins (functional)	(a)		3.2	Gage/8815326
103.	Diameter of pins	(a)		3.2	Gage/5210-221-1930
104.	Pin loose	(a)		3.2	Manual
105.	Weld inadequate	(a)		3.5	Visual
106.	Hardness	(a)		3.2	4.5.1
<u>Minor</u>					
201.	Protective finish damaged exposing base metal	(b)		3.2	Visual
202.	Any operation missing	(b)		3.2	Visual
203.	Marking illegible	(b)		3.2	Visual
204.	Evidence of poor workmanship	(b)		3.6	Visual
NOTES: (a) Sample size per Table II (b) Sample per size Table III					

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## QUALITY CONFORMANCE INSPECTION

MIL-T-45890A(AR)

## CLASSIFICATION OF DEFECTS &amp; TESTS

PARAGRAPH 4.4.2.18	TITLE Wrench, Spanner H-4004	SHEET 1 of 1		DRAWING NUMBER 8287887
CATEGORY	EXAMINATION OR TEST	AQL OR 100%	REQUIREMENT PARAGRAPH	NEXT HIGHER ASSEMBLY
<u>Critical</u>	None defined			
<u>Major</u>				
101.	Length of pin protrusion		3.2	Gage/5210-221-1961
102.	Location of pins (functional)		3.2	Gage/8815328
103.	Component or operation missing		3.2	Visual
104.	Weld inadequate		3.5	Visual
105.	Hardness		3.2	4.5.1
<u>Minor</u>				
201.	Length of handle		3.2	Gage/5210-222-4560
202.	Marking illegible		3.2	Visual
203.	Protective finish damaged exposing base metal		3.2	Visual
204.	Evidence of poor workmanship		3.6	Visual
NOTES: (a) Sample size per Table II (b) Sample size per Table III				

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## QUALITY CONFORMANCE INSPECTION

MIL-T-45890A (AR)

## CLASSIFICATION OF DEFECTS &amp; TESTS

PARAGRAPH 4.4.2.19	TITLE Wrench, Spanner H-4005	SHEET 1 of 1		DRAWING NUMBER 8787890
		AQL OR 100%	REQUIREMENT PARAGRAPH	
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS		PARAGRAPH REFERENCE /INSPECTION METHOD
<u>Critical</u>	None defined			
<u>Major</u>				
101.	Inside radius of jaws	(a)	3.2	Gage/5210-222-4559
102.	Thickness of lip	(a)	3.2	Gage/5210-790-0238
103.	Opening between jaw (min)	(a)	3.2	Gage/8815329
104.	Hardness	(a)	3.2	4.5.1
<u>Minor</u>				
201.	Profile of handle (functional)	(b)	3.2	Gage/5210-239-0490
202.	Overall length	(b)	3.2	Gage/5210-790-2494
203.	Protective finish damaged exposing base metal	(b)	3.2	Visual
204.	Marking illegible	(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				

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## QUALITY CONFORMANCE INSPECTION

MIL-T-45890A (AR)

**CLASSIFICATION OF DEFECTS & TESTS**

PARAGRAPH 4.4.2.20	TITLE Wrench, Spanner H-4129	SHEET 1 OF 1		DRAWING NUMBER 8787891
CATEGORY	EXAMINATION OR TEST	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE /INSPECTION METHOD
<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

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

PARAGRAPH 4.4.2.21	TITLE Handle	SHEET 1 of 1		DRAWING NUMBER 8787892
				NEXT HIGHER ASSEMBLY
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH
<u>Critical</u>	None defined			
<u>Major</u>				
101.	Diameter of holes (max)	(a)		3.2
<u>Minor</u>				
201.	None defined			Gage/8815332
NOTES: (a) Sample size per Table II				

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

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

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

MIL-T-45890A (AR)

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

**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)

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

MIL-T-45890A(AR)

PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER	
4.4.2.25	Insertor, Spring Pin H-4021			8794334	
		NEXT HIGHER ASSEMBLY			
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
<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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**CLASSIFICATION OF DEFECTS & TESTS**

MIL-T-45890A (AR)

PARAGRAPH	TITLE	SHEET 1 OF 2		DRAWING NUMBER	
4.4.2.26	Maintenance Fixture Atomic Warhead H-4001			8794359	NEXT HIGHER ASSEMBLY
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
<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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## QUALITY CONFORMANCE INSPECTION

MIL-T-45890A (AR)

**CLASSIFICATION OF DEFECTS & TESTS**

<b>PARAGRAPH</b> 4.4.2.26 (cont)	<b>TITLE</b> Maintenance Fixture Atomic Warhead H-4001	<b>SHEET 2 OF 2</b>		<b>DRAWING NUMBER</b> 8794359
<b>CATEGORY</b>	<b>EXAMINATION OR TEST</b>	<b>AQL OR 100%</b>	<b>REQUIREMENT PARAGRAPH</b>	<b>NEXT HIGHER ASSEMBLY</b>
Minor (cont)				
208.	Positioning handle loose		3.2	Manual
209.	Protective finish damaged exposing base metal		3.2	Visual
210.	Marking illegible	(b)	3.2	Visual
211.	Any component or operation missing	(b)	3.2	Visual
212.	Evidence of poor workmanship	(b)	3.6	Visual
<b>NOTES:</b> (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
CATEGORY	EXAMINATION OR TEST	AQL OR 100%	REQUIREMENT PARAGRAPH	8794385 NEXT HIGHER ASSEMBLY 8794359 PARAGRAPH REFERENCE / INSPECTION METHOD
4.4.2.27	Post Center			
<u>Critical</u>	None defined			
<u>Major</u>				
101.	Location of collar pin hole		3.2	Gage/8815342
102.	Location of guide pin holes		3.2	Gage/8815343
103.	Location of base pin hole		3.2	Gage/8815344
<u>Minor</u>				
201.	Evidence of poor workmanship		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

MIL-T-45890A (AR)

## CLASSIFICATION OF DEFECTS &amp; TESTS

PARAGRAPH	TITLE	SHEET 1 OF 2		DRAWING NUMBER
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH
4.4.2.28	Spring			8794387
				NEXT HIGHER ASSEMBLY 8794359
				PARAGRAPH REFERENCE / INSPECTION METHOD
	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			
Critical				
Major				
101.	Test load at height of 0.81 inches (min)	(a)		3.4
102.	Load at 0.61 inches (max)	(a)		3.4
103.	Solid height (max)	(b)		3.2
104.	Outside diameter (max)	(b)		3.2
105.	Inside diameter (min)	(b)		3.2
				4.5.2/6510948 4.5.2/8829086 Gage/8829087 Gage/5210-790-0239 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

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

MIL-T-45890A (AR)

PARAGRAPH	TITLE	SHEET 2 OF 2		DRAWING NUMBER
		NO. OF SAMPLE UNITS	EXAMINATION OR TEST	
4.4.2.28 (cont)	Spring			8794387
CATEGORY		AQL OR 100%	REQUIREMENT PARAGRAPH	NEXT HIGHER ASSEMBLY
Minor				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
<b>NOTES:</b> (c) Sample size per Table III				

QUALITY CONFORMANCE INSPECTION  
MIL-T-45890A (AR)

**CLASSIFICATION OF DEFECTS & TESTS**

PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER
4.4.2.29	Post Assembly			8794393
				NEXT HIGHER ASSEMBLY
				8794359
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH
				PARAGRAPH REFERENCE /INSPECTION METHOD
<u>Critical</u>				
1	Burr on cylinder		100%	3.2
<u>Major</u>				
101.	Minor diameter of post thread in depressor (max)	(a)		3.2
102.	Pitch diameter of post thread in depressor (max)	(a)		3.2
103.	Major diameter of depressor thread on post	(a)		3.2
104.	Pitch diameter of depressor thread on post	(a)		3.2
105.	Length of depressor thread on post (min)	(a)		3.2
106.	Total length of center post (min)	(a)		3.2
<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

## QUALITY CONFORMANCE INSPECTION

MIL-T-45890A (AR)

**CLASSIFICATION OF DEFECTS & TESTS**

PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER 8794598
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH
				NEXT HIGHER ASSEMBLY
				PARAGRAPH REFERENCE /INSPECTION METHOD
<u>Critical</u>	None defined			
<u>Major</u>	None defined			
<u>Minor</u>				
201.	Handle cracked or split	(b)		Visual
202.	Suction cup torn or perforated	(b)		Visual
203.	Coating missing	(b)		Visual
204.	Marking illegible	(b)		Visual
205.	Evidence of poor workmanship	(b)		Visual

NOTES: (b) Sample size per Table II

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
								8795637
								NEXT HIGHER ASSEMBLY
CATEGORY								PARAGRAPH REFERENCE /INSPECTION METHOD
<u>Critical</u>	None defined							
<u>Major</u>								
101.	Diameter of tip (min)	(a)					3.2	Gage/5210-790-0238
102.	Length of tip (min)	(a)					3.2	Gage/5210-221-1961
<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

DRDAR-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 &amp; TESTS

PARAGRAPH	TITLE	SHEET 1 OF 1		DRAWING NUMBER	
4.4.2.32	Plug			9253873	
				NEXT HIGHER ASSEMBLY	
CATEGORY	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
<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

DDAR-0A Form 160 Jul 77 Replaces SARPA-QA Form 2567 Feb 74 Which is Obsolete

## 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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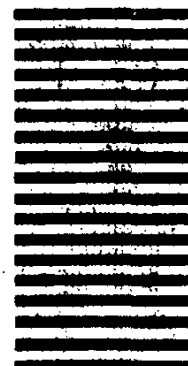
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**NOTE:** This form shall not be used to submit requests for waivers, deviations or clarification of specification requirements on current contracts. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements.

## DOCUMENT IDENTIFIER (Number) AND TITLE

MIL-T-45890A (AR) Tools For Projectile, M422

## NAME OF ORGANIZATION AND ADDRESS OF SUBMITTER

☐ VENDOR ☐ USER ☐ MANUFACTURER

1. ☐ HAS ANY PART OF THE DOCUMENT CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE? ☐ IS ANY PART OF IT TOO RIGID, RESTRICTIVE, LOOSE OR AMBIGUOUS? PLEASE EXPLAIN BELOW.

A. GIVE PARAGRAPH NUMBER AND WORDING

B. RECOMMENDED WORDING CHANGE

C. REASON FOR RECOMMENDED CHANGE(S)

## 2. REMARKS

SUBMITTED BY (Printed or typed name and address — Optional)

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