

MIL-W-63374(AR)

16 MARCH 1981

## MILITARY SPECIFICATION

### WARHEAD, INERT, FOR DEMOLITION KIT, TRAINING, XM270 LOADING ASSEMBLY

This specification is approved for use by 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 This specification covers the loading assembly for one type of warhead designated as Warhead, Inert, for Demolition Kit, Training, XM270.

#### 2. APPLICABLE DOCUMENTS

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

#### SPECIFICATIONS

##### MILITARY

MIL-A-48078 - Ammunition, Standard Quality Assurance Provisions, General Specification For

#### STANDARDS

##### MILITARY

MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes (ABC-STD-105)

FSC: 1375

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Commander, US Army Armament Research and Development Command, Attn. DRDAR-QA, Dover, New Jersey 07801 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

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DRAWINGS (See 6.4)

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND

9329744 - Warhead Loading Assembly (Inert)  
9244445 - Coupling, Flush Hatch, Warhead

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

3. REQUIREMENTS

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

3.2 Assembly. The assembly shall comply with all requirements specified on drawing (Dwg.) 9329744 and with all requirements specified in applicable specifications.

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 Workmanship. All parts and assemblies shall be fabricated and loaded in a thorough workmanlike manner, and all manufacturing, processing, and assembly operations shall be correctly performed. They shall be free of burrs, sharp edges, unblended radii, surface defects, chips, dirt, grease and oil (except where specifically required), corrosion products and other foreign matter. The cleaning method used shall not be injurious to any part or assembly nor shall they be contaminated by the cleaning agent. Exterior surface coatings shall be continuous except for a few light scratches not exposing base material. All required markings and stampings shall be neat and sharply defined. (Required packing shall be dry).

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection and standard quality assurance provisions. Unless otherwise specified herein or in the contract, the provisions of MIL-A-48078 shall apply and are hereby made a part of this detail specification. Each lot of warheads shall contain: Parts from not more than one lot interfix number for one manufacturer.

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4.2 Classification of inspections. The following types of inspections 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 and 4.3.3. The first article sample shall consist of the following items in sample quantities as indicated (see Table I).

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

4.3.3 Rejection. See MIL-A-48078.

TABLE I. First Article Inspection

**CLASSIFICATION OF DEFECTS & TESTS**

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PARAGRAPH	TITLE	SHEET		NO. OF SAMPLE UNITS	AQL OR 100%	REQUIREMENT PARAGRAPH	DRAWING NUMBER
		1	OF				
	Warhead, For Demolition Kit, M180 Loading Assembly		1				See Below
							NEXT HIGHER ASSEMBLY
							PARAGRAPH REFERENCE / INSPECTION METHOD
	Loading Assembly, Warhead (Dwg. 9329744) Examination for defects Weight of filler			10 10	100% 100%	3.2 3.3	4.4.2.1 4.4.3.1
NOTES:							

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

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4.4 Quality conformance inspection

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

4.4.2 Examination. See MIL-A-48078. Unless otherwise specified in the Classification of Defects and Test Tables, sampling plans for major and minor defects shall be in accordance with MIL-STD-105, Inspection Level II. Equipment necessary for the performance of the inspections listed shall be in accordance with 4.4.4.

**CLASSIFICATION OF DEFECTS & TESTS**

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PARAGRAPH	TITLE	EXAMINATION OR TEST	NO. OF SAMPLE UNITS	SHEET		DRAWING NUMBER
				1	OF 1	
CATEGORY				AQL OR 100%	REQUIREMENT PARAGRAPH	PARAGRAPH REFERENCE / INSPECTION METHOD
4.4.2.1	Loading Assembly, Warhead					9329744 NEXT HIGHER ASSEMBLY 9331717
<u>Critical</u>	None defined					
<u>Major</u>						
101	Diameter of fuze cavity			0.40%	3.2	Gage
102	Depth of fuze cavity			0.40%	3.2	Gage
103	True position of diameter of fuze cavity with outside diameter of flange			0.40%	3.2	Gage
104	Protrusion of inert filler above surface of flange			0.40%	3.2	Gage
105	Component missing or improperly assembled			0.40%	3.2	Visual/Manual
106	Marking missing or incorrect			0.40%	3.2	Visual
107	Flush latch coupling insecure or missing			100%	3.2	Visual/Manual
<u>Minor</u>						
201	Evidence of poor workmanship			1.00%	3.5	Visual

NOTES:

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#### 4.4.3 Testing

4.4.3.1 Weight of inert filler. Major defect. This test shall be performed one hundred percent as specified in 4.5.1 using test equipment in accordance with 4.4.4. Any warhead which does not meet the specified requirement shall be classified defective and removed from the lot (Non-destructive test).

4.4.4 Inspection equipment. The inspection equipment required to perform the inspections and tests prescribed in this specification is identified in the 'Paragraph Reference/Inspection Method' column in the tables starting with paragraph 4.4.2.1, and the test method paragraphs (see 4.5). 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 6.2 herein.

#### 4.5 Test methods and procedures

4.5.1 Weight of inert filler. Before loading, the shell assemblies shall be labeled and weighed to the nearest .01 pound (4.5 grams). This tared weight shall be subtracted from the loaded, machined warhead weight.

### 5. PACKING

5.1 Preservation and packaging. If the warhead is shipped interplant, separate from the rest of the kit, packaging shall be in accordance with MIL-STD-1188.

5.2 Packing. Packing shall be in accordance with MIL-STD-1188.

5.3 Marking. Marking shall be in accordance with MIL-STD-1188.

### 6. NOTES

6.1 Ordering data. Procurement documents shall specify the following:

- a. Title, number and date of this specification.
- b. Provisions for submission of first article samples.
- c. Provisions of MIL-A-48078.

6.2 Submission of inspection equipment designs for approval. (See MIL-A-48078). Submit equipment designs as required to Commander, US Army Armament Research and Development Command, ATTN: DRDAR-QAA-I, Dover, New Jersey 07801.

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6.3 Distribution of ammunition data cards. Distribution of data cards shall include the following: Commander, ARRADCOM, ATTN: DRDAR-QAA-M, Dover, New Jersey 07801.

6.4 Drawings. Drawings listed in Section 2 of this specification under the heading, "US Army Armament Research and Development Command (ARRADCOM)" may also include drawings prepared by, and identified as Edgewood Arsenal, Frankford Arsenal, Rock Island Arsenal or Picatinny Arsenal drawings. Technical data originally prepared by these activities is now under the cognizance of ARRADCOM.

Custodian:  
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Army-AR

Project No.: 1375-A139



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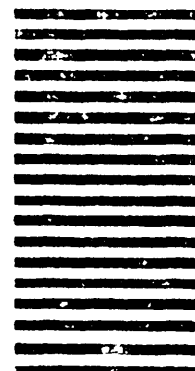
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