Downloaded from http://www.everyspec.com

NOT MEASUREMENT SENSITIVE

MIL-STD-40001(AT)
21 September 1990
SUPERSEDING
(see 6.4)

MILITARY STANDARD

PREPARATION OF FINAL INSPECTION RECORD (FIR)

AMSC

AREA QCIC

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

Downloaded from http://www.everyspec.com

FOREWORD

1. This military standard is approved for use by the U.S. Army Tank-Automotive Command, Department of the Army and is available for use by all Departments and Agencies of the Department of Defense.

2. Beneficial Comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: U.S. Army Tank-Automotive Command, ATTN: AMSTA-GDS, Warren, MI 48397-5000, by using the self-addressed standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

3. Quality Assurance Provisions prepared by industry and Government for End Item Final Inspection have varied considerably for several years. Problems have been attributed to the omission of stringent inspection controls and at times the establishment of unnecessary and costly examinations and tests. To alleviate these problems, this standard has been prepared.

4. This standard will provide a convenient means of implementing uniform methods of preparing and maintaining Final Inspection Records (FIRs). Additionally, it can serve as a text book for specialized programs of instruction for centralized or local training and as a preparedness measure for accelerated training of Government and industry personnel during mobilization.

Downloaded from http://www.everyspec.com

C O N T E N T S

PARAGRAPH		PAGE
1.	SCOPE	1
1.1	Scope	1
1.2	Application	1
1.3	Compliance	1
2.	APPLICABLE DOCUMENTS	2
2.1	Government documents	2
2.1.1	Specifications, standards and handbooks	2
2.2	Order of precedence	2
3.	DEFINITIONS	3
3.1	Acronyms used in this standard	3
3.2	FIR	3
4.	GENERAL REQUIREMENTS	4
4.1	General	4
4.2	Responsibilities	4
4.2.1	Contractor	4
4.2.2	Government	4
4.3	Format	4
4.3.1	Safety considerations	4
4.4	Procedures for developing FIR	4
4.5	Approval of FIR	5
4.6	Reproduction	5
4.6.1	Microfilm	5
5.	DETAILED REQUIREMENTS	6
5.1	General	6
5.1.1	Circled numbers	6
5.2	Cover page	6
5.3	Title pages	7
5.4	Specific inspection requirements	9
5.4.1	Control tests	10
5.5	Deficiency sheet	10
5.6	Waiver sheet	11
5.7	Preparation of final inspection record for kits	11
5.8	Maintenance of FIRs	11
6.	NOTES	12
6.1	Intended use	12
6.2	Issue of DODISS	12
6.3	Data requirements	12
6.4	Supersession data	12
6.5	Subject term (keyword) listing	12

Downloaded from http://www.everyspec.com

CONTENTS

FIGURE		PAGE
1.	Example of cover page	13
2.	Example of title pages	14
3.	Format for listing specific inspection requirements	19
4.	Example of specific inspection requirements sheets	20
4A.	Example of in process inspection requirements sheets	28
5.	Example of deficiency sheet	36
6.	Example of waiver sheet	37

Downloaded from http://www.everyspec.com

1. SCOPE

1.1 Scope. This military standard establishes the content and format requirements for the FIR and provides the instructions for its preparation and maintenance (revision).

1.2 Application. FIRs are to be used as technical data for vehicles/end items controlled, used or procured by the U.S. Army Tank-Automotive Command. Government quality assurance personnel shall use this military standard for the review and approval of FIRs. Quality Engineering Contractor (QEC) personnel shall use this military standard for the preparation and maintenance of FIRs.

1.3 Compliance. This military standard is mandatory for use by Government and contractor personnel engaged in the preparation, maintenance, review and approval of FIRs.

Downloaded from http://www.everyspec.com

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications, standards and handbooks. The following specifications, standards, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issue of these documents are those listed in the issue of the Department of Defense Index of specification and standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

SPECIFICATION

MILITARY

MIL-M-9868 - Microfilming of Engineering Documents, 35 mm, Requirements for.

(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from the Navy Publication and Printing Service Office, ATTN: Standardization Documents Order Desk, Bldg 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.)

2.2 Order of precedence. In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

Downloaded from http://www.everyspec.com

3. DEFINITIONS

3.1 Acronyms used in this standard. The symbols used in this standard are defined as follows:

a. ECP - Engineering Change Proposal.

b. ERR - Engineering Release Record.

c. FIR - Final Inspection Record.

d. QEC - Quality Engineering Contractor.

e. TDP - Technical Data Package.

3.2 FIR. The FIR is a contractual document which sets forth the minimum inspection characteristics determined necessary to assure conformance to end items specifications and drawings.

Downloaded from http://www.everyspec.com

4. GENERAL REQUIREMENTS

4.1 General. This section includes the responsibilities of Quality Engineering Contractor (QEC) and of Government personnel. It also includes format and procedures for developing and maintaining FIRs.

4.2 Responsibilities.

4.2.1 Contractor. The QEC is responsible to prepare and maintain FIRs in accordance with the requirements of this military standard.

4.2.2 Government: The Government's product assurance representative is responsible to review and approve/disapprove FIRs prepared/revised by the contractor. When applicable, the Government's product assurance representative is also responsible for the preparation/revision of FIRs in accordance with this military standard when the work is done by Government personnel.

4.3 Format. The format of the FIR shall be organized so as to be compatible with assemblies, installations, and end item performance and acceptance requirements. FIRs are to be developed and maintained current with engineering drawings and end item specification requirements. A FIR is to be included with each Technical Data Package (TDP) released for procurement purposes and should carry the same date as the Engineering Release Record (ERR) released for the procurement. This FIR shall be retained and updated when Engineering Change Proposal (ECP) action requires a change.

4.3.1 Safety considerations. The FIR shall assure that a complete visual examination of all items affecting the safety of the operating personnel and/or the end item is accomplished prior to functional or road testing.

4.4 Procedures for developing FIR. The procedures to be followed in the preparation and maintenance of FIRs shall be in accordance with the steps listed below (see 6.3). Detailed instructions are covered in section 5.

Step 1. Analyze end item requirements to determine how the FIR is to be prepared.

Step 2. Develop the FIR.

Step 3. Establish and maintain FIR master file for duration of contract through all subsequent manufacturing cycles and/or overhaul.

Step 4. Maintain FIRs current with drawing revisions and supplements to applicable specifications.

Step 5. Microfilm all FIRs and make distribution as required.

Step 6. Maintain File for cancelled or backfiled FIRs.

Downloaded from http://www.everyspec.com

4.5 Approval of FIR. Submission for approval shall be to the TACOM product assurance representative or to the person designated as authorized to approve the FIR.

4.6 Reproduction. The quality of the FIRs for microfilm or reproducible copies shall permit five (5) generations of legible copies with dark lines and clear backgrounds. Fifth generation copy is defined as the last printing of a series as follows:

First Generation made from original.
Second Generation made from first Generation.
Third Generation made from second Generation.
Fourth Generation made from third Generation.
Fifth Generation made from fourth Generation.

4.6.1 Microfilm. The microfilm shall be in accordance with current general requirements as detailed in MIL-M-9868.

Downloaded from http://www.everyspec.com

5. DETAILED REQUIREMENTS

5.1 General. The format of the FIR is comprised of five sections. Depending on the complexity of the vehicle/end item, some variation from this format may be necessary. Approval from the Government quality assurance representative is required for any variation from the FIR format. The five sections of the FIR are as indicated below.

a. Cover page (see 5.2).
b. Title pages (see 5.3).
c. Specific inspection requirements (see 5.4).
d. Deficiency sheets (see 5.5).
e. Waiver sheets (see 5.6).

5.1.1 Circled numbers. The circled numbers referenced herein and in the figures are shown only to cross-reference them to each other and to relate them to the corresponding instructions and requirements for completing the FIR. The blocks are numbered for instructional purposes only and will not be numbered on the regular form.

5.2 Cover page. This section of the FIR contains the following information. The term vehicle is used to include all wheeled and tracked vehicles or trailers. Some items such as engines, transmissions, etc. that have FIRs will simply have model numbers and/or series numbers (see figure 1).

(1) Title - FINAL INSPECTION RECORD (FIR), XXXXXXXX (Part number as it appears on end item drawing), U.S. ARMY TANK-AUTOMOTIVE COMMAND (TACOM). ACCEPTANCE TESTS AND AREA INSPECTION REQUIREMENT SHEETS.

(2) FIR FOR - Vehicle/Item Model Number.

(3) SERIES - Vehicle/Item Series.

(4) END ITEM SPECIFICATION - Enter specification number.

(5) PROCESSING FOR STORAGE AND SHIPMENT SPECIFICATION - Enter specification number if applicable.

(6) SUBMITTED BY - Name of Quality Engineering Contractor

(7) APPROVED BY - Name of Government representative.

(8) APPROVAL DATE - The approval date of the FIR shall not be revised or retyped unless an error was made during the initial FIR preparation. The original approval date of the FIR shall be preceded by Revision Ø.

(9) REVISION CONTROL - Fill in the following information.

Downloaded from http://www.everyspec.com

(10) REVISION LETTER - The letters I, O, Q and X shall be excluded as revision letters.

(11) REVISION DATE - Enter date of revision.

(12) CHANGE DESCRIPTION - Enter brief description of change in the item.

(13) CHANGE AUTHORITY - Enter ERR Number.

(14) CHANGE APPROVED - Government product quality manager's initials.

(15) FIR NUMBER - Enter Number XXXXXXXX same as in the title.

(16) DATE - Enter effective date of FIR.

5.3 Title pages - The title pages shall contain the following information (see figure 2).

(17) Title - FINAL INSPECTION RECORD (FIR) US ARMY TANK-AUTOMOTIVE COMMAND (TACOM).

(18) FIR FOR - Vehicle/ Item Nomenclature and Series.

(19) Description of test and vehicle data - Enter the description of test to be performed such as "ROAD TEST AND FINAL INSPECTION, VEHICLE DATA".

(20) VEHICLE/ITEM SERIAL NO - Enter vehicle serial No. such as 1234.

(21) MANUFACTURER VEHICLE/ITEM NUMBER AND MODEL - Enter Mfg. Vehicle No. and model e.g. M923.

(22) ENGINE SERIAL NUMBER - Enter serial number of engine e.g. 12345.

(23) TRANSMISSION SERIAL NUMBER - Enter serial number of transmission e.g. 23456.

(24) TRANSFER TRANSMISSION SERIAL NUMBER - Enter serial number of Transfer Transmission e.g. 34567.

(25) MANUFACTURER - Enter name of the company e.g. ABC Corporation.

(26) CONTRACT NUMBER - Enter contract number e.g. DAAK49-X-0001.

(27) MILEAGE BEFORE TEST - Enter mileage of the vehicle before starting the test.

(28) MILEAGE AFTER TEST - Enter mileage of the vehicle after completing the test.

(29) MANUFACTURER'S INSPECTION - Initials of the inspector of manufacturer.

Downloaded from http://www.everyspec.com

(30) GOVERNMENT INSPECTOR - Initials of the inspector of Government.

(31) SUBMITTED BY - Enter name of the company's representative.

(32) APPROVED BY GOVERNMENT INSPECTOR - Enter name of the Government inspector.

(33) DATE - Enter the date of approval by Government inspector.

(34) INSTRUCTIONS TO INSPECTOR - If applicable enter adequate but brief instructions to guide the inspector in performing inspections and recording the results on both the Specific Inspection Requirements Sheets and the Deficiency Sheets.

(35) IN-PROCESS MANUFACTURING/ASSEMBLY INSPECTION RECORDS REVIEW - If in-process manufacturing/assembly characteristics are not included in the FIR per paragraph (38), an entry for this records review must be provided in the FIR.

(36) SAFETY CHECK BEFORE ROAD TEST - The safety check must be performed prior to road or functional testing. Do not operate the vehicle or item if any item in the safety check is defective.

(36A) SAFETY CHECK BEFORE ROAD TEST (TRACTOR-TRAILER COMBINATION) - Enter safety checks (if applicable) for Tractor-trailer combination, otherwise enter N/A.

(36B) NOTES - Enter notes (if applicable).

(37) GENERAL INSPECTION REQUIREMENTS - Some characteristics are common to most items and are to be considered as part of each. They are defined in general terms in this section to avoid their repetition. The examples shown in Figure 2 are representative but are not meant to be exclusive.

(38) GENERAL INSPECTION SEQUENCE - It is intended that the FIR be developed in the same sequence that the major assemblies and all subassemblies, major system and/or subsystems are to be inspected. In any event, any characteristics that cannot be inspected after final assembly shall be inspected as the item is assembled during the normal manufacturing process. This does not preclude the contractor from changes in sequence to satisfy the inspection program. At the discretion of the procuring activity, the FIR may also include characteristics that are to be inspected and recorded during in-process manufacturing/assembly operations. Following items are included in this section.

(39) SYMBOLS - Appropriate inspection symbols shall be identified for use by the manufacturers and the Government inspectors in order to provide uniform records and evaluation.

(40) Index of Section and Area Inspections - The index shall include the nomenclature and the appropriate page number where the section or area begins.

Downloaded from http://www.everyspec.com

5.4 Specific inspection requirements - This section of the FIR contains the specific inspection requirements that must be performed to verify conformance to the drawings and specification for the vehicle/end item. The specific inspection requirements shall be specified in tabular form as illustrated in figure 3. The circled numbers indicate the approximate location where the specific inspection requirements will be placed. Figure 4 is an example of a completed FIR containing specific inspection requirements prepared in accordance with these instructions. Each page in this section shall have the number of columns and column headings as shown in figure 3. All typing shall be in capital letters. The following instructions for completing this section of the FIR shall be followed:

(41) AREAS - The vehicle/end item shall be divided into areas in a logical manner that is compatible with the item covered by the FIR. Each area shall be identified with a number which is sequentially assigned starting with the numeral 1 and given a title. A block of numbers shall be reserved for each area for later use in identifying the characteristics (43) to be inspected within the area. This information shall be centered in the "characteristics" column. For example:

Area No. 1 Front of vehicle: 101 through 199
Area No. 2 Engine compartment: 201 through 299

(42) Identification of installations and major assemblies - Each area shall be subdivided to account for each installation and major assembly that requires inspection. The installations and major assemblies shall be appropriately identified by its nomenclature and drawing number as shown on the drawing. Inspection requirements to verify conformance to specifications and standards shall also be appropriately identified by the documents paragraph heading and number. This information shall be listed in the "characteristics" column, starting at the left-hand border.

(43) Numbering of installations and major assemblies - Each installation and major assembly listed under (42) shall be sequentially assigned a number from the block of numbers (41) reserved for the area, starting with the first number. The sequentially assigned number shall be located in the "item number" column, adjacent to the listed installation/major assembly (42).

(44) Specific characteristics to be inspected - For each listed installation and major assembly, specify the specific characteristic to be inspected. This information shall be listed immediately following the identification of the installation/major assembly (42). For exception see (45). When applicable, specific characteristics to be inspected should reference the end item specification paragraph number in the characteristic column.

(45) Special Instructions: When it is essential to provide special instructions or information for the inspection of individual installations or assemblies, they shall be included immediately following the identification of the installation/major assembly (42).

Downloaded from http://www.everyspec.com

(46) Method of inspection - The method of inspection to be used (visual, functional, special equipment, etc.) shall be entered in the "Inspection method" column for each specific characteristic to be inspected (see (44) and (45)).

(47) Symbols - See item (39) for the symbols to be used to indicate that the characteristic inspected is acceptable or not. The appropriate symbol shall be entered in the "symbol" column.

(48) Inspector's initial - The manufacturer's inspector (29) who inspected the specific characteristic shall place his initials in the "Insp Initial" column.

(49) Recording inspection and test results - Where specific results of inspection or tests are required (e.g. acceleration, speed, backlash, etc.) a space for recording this information shall be provided following each special instruction (45).

5.4.1 Control tests - As specified in the vehicle/end item military specifications, all control tests shall be identified from section 4 of the specification and listed in the FIR. The frequency of inspections shall be as stated in the specification or as specified by the procuring activity. Control tests shall be assigned the last area number (41) to be used in this section of the FIR (see figure 4).

5.5 Deficiency sheet - A deficiency sheet shall be included as an integral part of each FIR. The purpose of the deficiency sheets is to provide a recorded description of all deficiencies noted and the corrective actions taken by the manufacturer during final inspection or after examinations and tests are completed on the end item. The deficiency sheet should include the following items (see figure 5).

(50) END ITEM NOMENCLATURE - Enter end item nomenclature e.g. Truck, Cargo 5 Ton, 6X6.

(51) INSPECTION DATE - Enter date of approval by Government Inspector (same as (33)).

(52) USA OR END ITEM SERIAL NUMBER - Enter serial number of end item, e.g. 05B1234.

(53) ITEM NUMBER - Use the same numbers as (43) whichever item has defects/deficiency.

(54) DESCRIPTION OF DEFICIENCY - Enter the brief description of deficiency e.g. Hood fits poorly to cab and fenders.

(55) INSPECTOR'S INITIALS - The manufacturer inspector's initials (same as (48)).

Downloaded from http://www.everyspec.com

(56) CORRECTIVE ACTION TAKEN - Enter the action taken by the manufacturer to correct the deficiency.

(57) INSPECTOR'S INITIALS - The Government inspector's initials who approved the corrective action (same as in (33)).

5.6 Waiver sheet - A waiver sheet may be included for prototype hardware inspected using a production FIR. The waiver sheet should be used when prototype hardware is fabricated and is not representative of production hardware. The waiver sheet should include the following items (see figure 6).

(58) COMPONENT OR ASSEMBLY NOMENCLATURE - Enter the name of items for which the waiver sheet has been prepared.

(59) PROTOTYPE RCSK NUMBER - Enter prototype part of Drawing Number.

(60) PRODUCTION PART NUMBER - Enter complete part number of the item.

(61) REMARKS - Enter differences between prototype and production hardware.

(62) ENGINEER'S INITIALS OR SIGNATURES - Enter both contractor's and Government engineers initials or signatures.

5.7 Preparation of final inspection record for kits - When kits such as personnel heater kit, winterization kit, or fire suppression kit are to be installed in a vehicle, they shall be considered an end item and as such, shall be handled as applicable by the preceding paragraphs.

5.8 Maintenance of FIRs. FIRs are to be maintained for each procurement ERR, and revised to support each procurement action.

Downloaded from http://www.everyspec.com

6. NOTES

(This section contains information of a general or explanatory nature that may be helpful, but is not mandatory.)

6.1 Intended use. This standard provides instructions for the preparation and maintenance of FIRs. It is intended for use by Government and contractor personnel for the preparation, maintenance and interpretation of FIRs.

6.2 Issue of DODISS. When this standard is used in acquisition, the applicable issue of the DODISS must be cited in the solicitation (see 2.1.1).

6.3 Data requirements. The following Data Item Descriptions (DIDs) must be listed, as applicable, on the Contract Data Requirement List (DD Form 1423). When this standard is applied on a contract, in order to obtain the data, except where DOD FAR supplement 27.475-1 exempts the requirement for a DD Form 1423.

Reference Paragraph	DID Number	DID Title	Suggested Tailoring
4.4		End Item Final Inspection Record (FIR)	-

The above DIDs were those cleared as of the date of this standard. The current issue of DOD 5010.12-L, Acquisition Management Systems and Data Requirements Control List (AMSDL), must be researched to ensure that only current, cleared DIDs are cited on the DD Form 1423.

6.4 Supersession data. This standard has been prepared from and upon approval supersedes the product assurance pamphlet, DRSTA-RP-702-100, May 1981: Preparation of Final Inspection Record (FIR).

6.5 Subject term (key word) listing.

Approval of FIR
Cover page
Deficiency sheets
Microfilm
Reproduction
Safety consideration
Specific inspection requirements
Title pages
Waiver sheets

Downloaded from http://www.everyspec.com

(1) FINAL INSPECTION RECORD (FIR) 12345678
US ARMY TANK-AUTOMOTIVE COMMAND
(TACOM)
ACCEPTANCE TESTS AND AREA INSPECTION REQUIREMENT SHEETS

VEHICLE DATA

(2) FIR FOR: Truck, 6 X 6 w/w (3) SERIES: M939

(4) END ITEM SPECIFICATION: ATPD-2056

(5) PROCESSING FOR STORAGE AND SHIPMENT SPECIFICATION: MIL-S-2345

(6)	(7)	(8)
SUBMITTED BY: ABC Corp.	APPROVED BY:	DATE: Rev Ø, 9-15-77

REVISION LETTER, DATE, DESCRIPTION, AUTHORITY AND APPROVAL WILL BE RECORDED BELOW. THE LATEST REVISION DATA WILL BE RECORDED ON AFFECTED PAGE.

(9) REVISION CONTROL

(10) REV.	(11) DATE	(12) CHANGE DESCRIPTION	(13) AUTHORITY	(14) APPROVED
A	9-15-77	Item "ROAD TEST"	ERR-XXXX	

(15) FIR: 12345678
(16) DATE: 9-15-77

FIGURE 1. Example of cover page.

Downloaded from http://www.everyspec.com

(17) FINAL INSPECTION RECORD (FIR)
US ARMY TANK-AUTOMOTIVE COMMAND
(TACOM)

(18) FIR FOR: TRUCK, 6 X 6 W/W, M939 SERIES

(19) ROAD TEST AND FINAL INSPECTION

VEHICLE DATA

(20) VEHICLE SERIAL NO. 1234 (21) MFG. VEHICLE NO. & MODEL M923

(22) ENGINE SERIAL NO. 12345 (23) TRANSMISSION SERIAL NO. 23456

(24) TRANSFER TRANSMISSION SERIAL NO. 34567

(25) MANUFACTURER ABC Corp. (26) CONTRACT NO. DAAK49-X-0001

(27) MILEAGE BEFORE TEST .6 (28) MILEAGE AFTER TEST 15.6

(29) MANUFACTURER'S INSPECTOR _____ (30) GOVERNMENT INSPECTOR _____

(31) SUBMITTED BY: ABC CORP. _____

(32) APPROVED BY GOVERNMENT INSPECTOR: _____ (33) DATE: _____

(34) INSTRUCTIONS TO INSPECTOR

AFTER THE VEHICLE HAS BEEN RELEASED FOR ROAD TEST AND FINAL INSPECTION, THE INSPECTOR SHALL DETERMINE ITS READINESS FOR INSPECTION BY PERFORMING THE FOLLOWING CHECKS:

		INSP. INITIAL
(35)	1. IN-PROCESS MANUFACTURING/ASSEMBLY RECORDS REVIEW	
	A. COMPLETE	_____
	B. IDENTIFIED DEFICIENCIES CORRECTED.	_____
(36)	2. SAFETY CHECK BEFORE ROAD TEST	
	A. ALL TIRES PROPERLY INFLATED AND FREE FROM DAMAGE	_____
	B. FUEL SYSTEM FILLED AND FREE FROM LEAKS.	_____
	C. ENGINE OIL LEVEL FULL AND FREE FROM LEAKS	_____
	D. TRANSMISSION OIL LEVEL FULL AND FREE FROM LEAKS	_____
	E. COOLANT LEVEL FULL AND SYSTEM FREE FROM LEAKS.	_____

Page _ of __ FIR: 12345678
DATE: 9-15-77

FIGURE 2. Example of title pages.

Downloaded from http://www.everyspec.com

	INSP. INITIAL
2. SAFETY CHECK BEFORE ROAD TEST (CONTINUED)	
F. WITH ENGINE RUNNING, VERIFY THAT THE TACHOMETER, OIL PRESSURE TEMPERATURE, AMMETER, AIR PRESSURE AND FUEL GAUGES ARE OPERATING PROPERLY BY VISUALLY INSPECTING EACH METER, AND NOTING THAT THE INDICATOR IS POINTING TO THE NORMAL OPERATING POSITION. SHUT ENGINE OFF AND AGAIN OBSERVE GAUGES TO ASSURE THEY ARE NOT STUCK BUT RETURN TO NONOPERATING POSITION. AIR PRESSURE GAUGE WILL REMAIN AT OPERATING POSITION. DO NOT ROAD TEST TRUCK IF ENGINE OIL TEMPERATURE OR AIR GAUGES ARE NOT OPERATING.	_____
G. VERIFY THAT ALL STEERING SYSTEM PARTS ARE TIGHT AND FUNCTIONING PROPERLY BY FIRST PHYSICALLY CHECKING STEERING WHEEL FOR SIDE AND END PLAY. NONE PERMITTED. THEN ROTATE THE STEERING WHEEL CLOCKWISE AND COUNTER-CLOCKWISE TO DETERMINE FREEPLAY. 10 PERMITTED. START ENGINE AND ROTATE STEERING WHEEL TO ITS MAXIMUM COUNTER-CLOCKWISE POSITION, ALLOWING VEHICLE TO CREEP SUFFICIENTLY TO REDUCE TIRE FRICTION. THE TURNING OPERATION MUST BE SMOOTH AND QUIET.	_____
H. VERIFY THAT BRAKES ARE OPERATING PROPERLY BY ALLOWING VEHICLE TO CREEP (2-3 MPH) AND APPLYING BRAKES. DO NOT ROAD TEST IF BRAKES ARE NOT FUNCTIONING.	_____
I. LIGHT OPERATION.	_____
J. TURN SIGNAL OPERATION.	_____
K. HORN OPERATION.	_____
L. WINDSHIELD WIPERS AND WASHERS OPERATION.	_____
36A	
3. SAFETY CHECK BEFORE ROAD TEST (TRACTOR-TRAILOR COMBINATION)	
A. TIRES PROPERLY INFLATED (TRACTOR-TRAILOR).	_____
B. SEMITRAILER SECURELY ATTACHED TO TOWING VEHICLE.	_____
C. INTERVEHICULAR HOSES CONNECTED.	_____

Page _ of __ FIR: 12345678
DATE: 9-15-77

FIGURE 2. Example of title pages - Continued.

Downloaded from http://www.everyspec.com

3. SAFETY CHECK BEFORE ROAD TEST (TRACTOR-TRAILER COMBINATION) (CONT.)

D. INTERVEHICULAR CABLE CONNECTED. _____

E. AIR SYSTEM FREE FROM LEAKS. _____

F. LANDING LEGS RAISED & SECURED. _____

G. DOORS CLOSED AND SECURED _____

H. BRAKE SYSTEM FREE OF LEAKS (AIR). _____

I. BRAKES FUNCTION PROPERLY. _____

J. ELECTRICAL SYSTEM FUNCTIONS WITH TOWING VEHICLE, TAILLIGHTS, STOP LIGHTS, DIRECTIONAL LIGHTS. _____

36B NOTE

DO NOT OPERATE VEHICLE IF ANY OF THE ABOVE SAFETY CHECKS ARE DEFECTIVE.

37 4. GENERAL INSPECTION REQUIREMENTS

THE FOLLOWING CHARACTERISTICS ARE COMMON TO MOST ITEMS AND ARE TO BE CONSIDERED AS PART OF EACH, WHERE APPLICABLE. THEY ARE DEFINED IN GENERAL TERMS IN THIS SECTION TO ELIMINATE THEIR REPETITION. HOWEVER, THEY MUST BE REVIEWED VISUALLY IN EACH ITEM AND REPORTED IF FOUND DISCREPANT.

A. CONDITION: ALL PARTS MUST EXHIBIT NO EVIDENCE OF DAMAGE, MUTILATION, OR POOR WORKMANSHIP OF CONSTRUCTION. THERE MUST BE NO PRESENCE OF SCRATCHES, BURRS, OR SHARP EDGES.

B. COMPLETENESS OF ASSEMBLY AND SECURED: ALL MOUNTING BRACKETS, BOLTS NUT, RIVETS, ETC., MUST BE COMPLETE AND SECURED. ANY EVIDENCE OF PARTS BEING INCOMPLETE AND IMPROPERLY SECURED WILL BE CAUSE FOR REJECTION. TORQUE FOR LOCK NUTS MUST BE PER CHART B #11608876 - UNLESS OTHERWISE SPECIFIED.

C. ROUTING, CLIPPING AND CLEARANCES: ALL WIRING HARNESSES, FUEL, HYDRAULIC AND AIR LINES MUST BE PROPERLY ROUTED AND CLIPPED PER THEIR RESPECTIVE INSTALLATION DRAWINGS. DESIGN CLEARANCES MUST BE MAINTAINED BETWEEN THESE LINES AND ADJACENT PARTS.

D. PAINTING: ALL PAINTED SURFACES SHALL BE INSPECTED FOR PROPER APPLICATION. PAINTED SURFACES SHALL BE FREE FROM RUNS, SAGS, SCRATCHES, THIN AREAS AND OBSERVED FOR APPLICABLE COLOR.

Page _ of __ FIR: 12345678
DATE: 9-15-77

FIGURE 2. Example of title pages - Continued.

Downloaded from http://www.everyspec.com

4. GENERAL INSPECTION REQUIREMENTS - (CONTINUED)

E. MARKING: ALL VEHICLE MARKINGS (CAUTIONARY, LIFTING POINTS, IDENTIFICATIONS) SHALL BE CHECKED FOR LEGIBILITY, PROPER LOCATION AND APPLICATION AS SPECIFIED IN AR 750-58.

F. ELECTRICAL SYSTEM: THE VEHICLE (24 VOLT) WIRING AND ELECTRICAL COMPONENTS SHALL BE INSPECTED FOR SECURED MOUNTING, PROPER ROUTING CONDUIT CONDITION (BRAKES, CUTS, CRACKS, KINKS, ETC.) AND CONNECTOR CONDITION.

G. LUBRICANTS: ENGINE OIL, TRANSMISSION OIL, GEAR BOXES, HOUSINGS AND CARRIERS MUST BE FILLED TO PROPER LEVEL. ALL LUBRICATION FITTINGS MUST SHOW EVIDENCE OF HAVING BEEN GREASED.

38

5. GENERAL INSPECTION SEQUENCE

A. THE PREINSPECTION SAFETY CHECK SHALL BE ACCOMPLISHED PRIOR TO VEHICLE ROAD TEST.

B. ROAD TEST AND FINAL INSPECTION DEFICIENCY SHEETS SHALL BE COMPLETED FOR EACH VEHICLE PRIOR TO RELEASE OF VEHICLE.

C. EACH CHARACTERISTIC LISTED SHALL BE INSPECTED TO DETERMINE CONFORMANCE WITH SPECIFICATION AND APPLICABLE DRAWING REQUIREMENTS. THE FOLLOWING SYMBOLS SHALL BE PLACED UNDER THE SYMBOL COLUMN AS APPLICABLE FOR EACH CHARACTERISTIC.

39

SYMBOL (✓)	ACCEPTABLE
SYMBOL (X)	REJECTION
SYMBOL (0)	NOT APPLICABLE

D. DEFICIENCIES AND ASSOCIATED ITEM NUMBERS SHALL BE ENTERED ON THE DEFICIENCY SHEET. THE DEFICIENCY SHALL INCLUDE A BRIEF DESCRIPTION AND CORRECTIVE ACTION TAKEN TO ELIMINATE THE DEFICIENCY. THE INSPECTOR SHALL INDICATE APPROVAL OF CORRECTIVE ACTION BY PLACING INITIALS UNDER CORRECTION APPROVED COLUMN. THE DEFICIENCY SHEET AND ANY APPLICABLE WRITTEN INSPECTION REPORTS SHALL BE MADE AN INTERGRAL PART OF THE INSPECTION RECORD.

E. FINAL ACCEPTANCE OF THE VEHICLE SHALL NOT BE ACCOMPLISHED UNTIL ALL DEFICIENCIES HAVE BEEN CORRECTED AND/OR APPROVED.

Page _ of __ FIR: 12345678
DATE: 9-15-77

FIGURE 2. Example of title pages - Continued.

Downloaded from http://www.everyspec.com

5. GENERAL INSPECTION SEQUENCE (CONTINUED)

40 F. THE FOLLOWING AREA INSPECTION HAS BEEN PREPARED TO PROVIDE A CONVENIENT AND UNIFORM SEQUENCE OF INSPECTION OF THE VEHICLE. HOWEVER, CHANGES MAY BE MADE TO FACILITATE THE INSPECTION PROGRAM.

1.	FRONT OF VEHICLE	PAGE NO. __
2.	ENGINE COMPARTMENT	PAGE NO. __
3.	CURB SIDE OF VEHICLE	PAGE NO. __
4.	ROAD TEST	PAGE NO. __
5.	CONTROL TESTS	PAGE NO. __

G. IN THE EVENT THAT THE PROCURING ACTIVITY REQUIRES THE INCLUSION OF INPROCESS MANUFACTURING/ASSEMBLY INSPECTION CHARACTERISTICS IN THE FINAL INSPECTION RECORD AS DESCRIBED IN ITEM 38 THE EXAMPLE IN FIGURE 4A MAY BE USED TO ASSIST IN PORTRAYING THOSE CHARACTERISTICS. THE FOLLOWING AREA INSPECTION HAS BEEN PREPARED TO PROVIDE A CONVENIENT AND UNIFORM SEQUENCE OF INSPECTION OF IN-PROCESS MANUFACTURING/ASSEMBLY CHARACTERISTICS.

1.	FRAME LINE	PAGE NO. __
2.	AXLE SET	PAGE NO. __
3.	ENGINE DRESS	PAGE NO. __
4.	CAB TRIM	PAGE NO. __
5.	CHASSIS	PAGE NO. __

Page _ of __

FIR: 12345678
DATE: 9-15-77

FIGURE 2. Example of title pages - Continued.

Downloaded from http://www.everyspec.com

ITEM NO.	CHARACTERISTIC	INSPECTION METHOD	SYMBOL	INSP INITIAL
	41			
43	42			
	44	46	47	48
	44	46	47	48
	44	46	47	48
43	42			
	45	46	47	48
	49			

FIGURE 3. Format for listing specific inspection requirements.

Downloaded from http://www.everyspec.com

ITEM NO.	CHARACTERISTIC	INSPECTION METHOD (46)	SYMBOL (47)	INSP INITIAL (48)
	(41) AREA NO. 1 FRONT OF VEHICLE			
(43) 101	(42) HOOD ASSEMBLY, EXTERNAL (DWG 12255776) INSTALLATION PER DWG 12256059			
	A. UNIFORM FIT TO FENDERS AND BODY (44) (COWL)	VISUAL	X	
	B. HOOD CATCH RIGHT & LEFT (DWG 12255897) MOUNTING - SCREW (44) (6) EACH - COMPLETE & SECURED	VISUAL	✓	
	OPERATION - CHECK OPERATION BY PULLING AND RELEASING	FUNCTIONAL	✓	
	C. WINDSHIELD CATCH (2) - MOUNTING-SECURED	VISUAL	✓	
	OPERATION - CHECK OPERATION BY PULLING AND RELEASING	FUNCTIONAL	✓	
	D. HOOD LATCH DECAL - CONDITION - NO PEELING, LEGIBLE, LOCATION	VISUAL	X	
	E. HOOD LATCH (DWG 12255910) INSTALLATION PER DWG 12256120 OPERATION - RELEASE AND LOCK	FUNCTIONAL	✓	
	F. GRAB HANDLE (DWG 12255910) MOUNTING - SECURED - CONDITION	VISUAL	✓	
	NO CRACKS, BENDS, BURRS, ETC.	VISUAL & TACTILE	✓	
	G. HEADLIGHTS RIGHT & LEFT INSTALLATION PER DWG 12256015 MOUNTING - SECURED	VISUAL	✓	
	WIRING - PROPERLY ROUTED	VISUAL	✓	
	LENS CONDITION - NO CRACKS, CHIPS, MOISTURE, ETC.	VISUAL	✓	

FIR: 12345678
DATE: 9-15-77

Page _ of __

FIGURE 4. Example of specific inspection requirements sheets.

Downloaded from http://www.everyspec.com

ITEM NO.	CHARACTERISTIC	INSPECTION METHOD	SYMBOL	INSP INITIAL
	H. BLACKOUT LIGHT			
	INSTALLATION PER DWG 12256015			
	MOUNTING - SECURED	VISUAL	✓	
	LENS CONDITION - NO CRACKS, CHIPS, MOISTURE, ETC.	VISUAL	✓	
	(41) AREA NO. 2			
	ENGINE COMPARTMENT			
(43) 201	(42) POWER PLANT ASSEMBLY (DWG 11669238) INSTALLATION PER DWG 12256021			
	A. LEAKS - NONE PERMITTED - OIL, FUEL, COOLANT, WINDSHIELD WASHER SOLVENT	VISUAL	✓	
	B. ENGINE OIL DIP STICK - MOUNTING - SECURED	VISUAL	✓	
	OIL LEVEL - MARKINGS MUST BE LEGIBLE	VISUAL	X	
	C. ELECTRICAL WIRING GENERAL - CLIPS & CONNECTORS - COMPLETE & SECURED	VISUAL	✓	
	PROPERLY ROUTED	VISUAL	✓	
	CONDITION - NO BARE WIRES, CRACKED INSULATION, ETC.	VISUAL	✓	
	D. DRIVE BELTS - PROPER TENSION	TACTILE	✓	
	CONDITION - NO CRACKS, SPLITS, FRAYS, ETC.	VISUAL	X	
	E. HOSES GENERAL - CLAMPS - COMPLETE AND SECURED	VISUAL	✓	
	PROPERLY ROUTED	VISUAL	✓	
	CONDITION - NO CRACKS, SPLITS, LEAKS, ETC.	VISUAL	✓	

FIR: 12345678
DATE: 9-15-77

Page _ of __

FIGURE 4. Example of specific inspection requirements sheets - Continued.

Downloaded from http://www.everyspec.com

ITEM NO.	CHARACTERISTIC	INSPECTION METHOD	SYMBOL	INSP INITIAL
	(41) AREA NO. 2			
	ENGINE COMPARTMENT - CONT.			
(43) 202	(42) RADIATOR ASSEMBLY (DWG 11669165) INSTALLATION PER DWG 12256021			
	A. TRUNNION MOUNT - SECURED	VISUAL	✓	
	B. HOSES & CLAMPS - COMPLETE & SECURED	VISUAL	✓	
	PROPERLY ROUTED	VISUAL	✓	
	CONDITION - NO CRACKS, SPLITS, KINKS, ETC.	VISUAL	X	
	C. FAN SHROUD (DWG 12256280) MOUNTING, BOLTS (8) - COMPLETE & SECURED	VISUAL	✓	
	CLEARANCE TO FAN	VISUAL	✓	
	D. LEAKS - NONE PERMITTED - COOLANT	VISUAL	✓	
	(41) AREA NO. 3			
	CURB SIDE VEHICLE			
(43) 301	(42) TIRES AND WHEELS (FRONT AND REAR) (DWG 7388820)			
	A. INFLATION VALVE AND CAP - PROPERLY ALIGNED	VISUAL	✓	
	LEAKS - NONE PERMITTED - AIR	AUDITORY	✓	
	CONDITION - NO CRACKS, SPLITS, ETC.	VISUAL	✓	
	B. TIRES - CONDITION - NO CRACKS, SPLITS	VISUAL	✓	

FIR: 12345678
DATE: 9-15-77

Page _ of __

FIGURE 4. Example of specific inspection requirements sheets - Continued.

Downloaded from http://www.everyspec.com

ITEM NO.	CHARACTERISTIC	INSPECTION METHOD	SYMBOL	INSP INITIAL
	(41) AREA NO. 3			
	CURB SIDE OF VEHICLE			
	C. TIRE PRESSURE - CHECK WITH AIR GAGE IN ACCORDANCE WITH VEHICLE DATA PLATE	TIRE GAGE	✓	
	D. TORQUE - LUG NUTS (10) EACH OUTSIDE WHEEL - COMPLETE & TORQUED TO 425 LBS. FT.	VISUAL & TORQUE WRENCH	✓	
	E. AXLE FLANGE BOLTS (10) EACH AXLE - COMPLETE & TORQUED TO 81 - 104 LBS. FT.	VISUAL & TORQUE WRENCH	✓	
(43) 302	(42) CAB EXTERIOR INSTALLATION PER DWG 12256119			
	A. FRESH AIR VENT DOOR (DWG 7529312) UNIFORM FIT - SECURED	VISUAL	X	
	CONDITION OF DOOR - NO DENTS, KINKS, ETC.	VISUAL	✓	
	RUBBER SEAL - SECURED	VISUAL	✓	
	CONDITION OF SEAL - NO CRACKS, SPLITS, ETC.	VISUAL	✓	
	B. MACHINE GUN BRACKET (OPEN CAB DOOR) MOUNTING, BOLTS (4) - COMPLETE & SECURED	VISUAL	✓	
	C. REAR VIEW MIRROR INSTALLATION PER DWG 12255993 MOUNTING, BOLTS (3) - COMPLETE & SECURED	VISUAL	✓	
	CONDITION OF MIRROR - NO CRACKS, CHIPS, ETC.	VISUAL	✓	

FIR: 12345678
DATE: 9-15-77

Page _ of __

FIGURE 4. Example of specific inspection requirements sheets - Continued.

Downloaded from http://www.everyspec.com

ITEM NO.	CHARACTERISTIC	INSPECTION METHOD	SYMBOL	INSP INITIAL
43 302	42 CAB EXTERIOR INSTALLATION PER DWG 12256119			
	D. PASSENGER DOOR (DWG 7373294) UNIFORM FIT TO CAB	VISUAL	✓	
	DOOR HANDLE OPERATION - OPEN & SHUT DOOR - NO BINDING OR INTERFERENCE	FUNCTIONAL	✓	
	AREA NO. 4			
	ROAD TEST			
	45 ROAD TEST: EACH VEHICLE OF EACH MODEL SHALL BE ROAD TESTED FOR NOT LESS THAN 15 MILES. THE CARGO VEHICLE AND TRUCK TRACTOR SHALL BE TESTED OVER PAVED SURFACED ROADS. FAILURE OF THE VEHICLE TO MEET REQUIREMENTS OF VISUAL EXAMINATIONS AND ROAD TESTS LISTED BELOW SHALL BE CAUSE FOR REJECTION. ACCEPTANCE OF THE VEHICLE FOR GOVERNMENT TESTING SHALL DISCONTINUE UNTIL CORRECTIVE ACTION HAS BEEN TAKEN TO ELIMINATE THE DEFICIENCY/DEFICIENCIES.			
	NOTE: ALL SAFETY CHECKS LISTED UNDER "INSTRUCTIONS TO INSPECTOR" MUST BE SATISFACTORILY COMPLETED PRIOR TO ROAD TEST.			
43 1001	42 AIR SYSTEM			
	A. AIR PRESSURE WARNING BUZZER, BUZZER CUT-OUT AT 60 + PSI, OPERATE SYSTEM AT 60 - 120 PSI	FUNCTIONAL	✓	

FIR: 12345678
DATE: 9-15-77

Page _ of __

FIGURE 4. Example of specific inspection requirements sheets - Continued.

Downloaded from http://www.everyspec.com

ITEM NO.	CHARACTERISTIC	INSPECTION METHOD	SYMBOL	INSP INITIAL
	AREA NO. 4			
	ROAD TEST			
	B. AIR LEAK TEST WITH AIR PRESSURE AT 100 PSI, PRESSURE DROP NOT TO EXCEED 2 LBS. PER MINUTE	CERTIFIED CALIBRATED AIR GAGE	✓	
43 1002	42 INSTRUMENT PANEL			
	A. GAGE OPERATION			
	(1) PREHEAT PRIMER PRESSURE	VISUAL & FUNCTIONAL	✓	
	(2) OIL PRESSURE 0 TO 60 PSI	VISUAL & FUNCTIONAL	✓	
	(3) SPEEDOMETER	VISUAL & FUNCTIONAL	✓	
	(4) TACHOMETER	VISUAL & FUNCTIONAL	✓	
	(5) FUEL	VISUAL & FUNCTIONAL	✓	
43 1010	42 TRANSFER CASE OPERATION			
	SHIFT CONTROL - EASE OF SHIFTING	FUNCTIONAL	✓	
	HI	FUNCTIONAL	✓	
	LO	FUNCTIONAL	✓	

FIR: 12345678
DATE: 9-15-77

Page _ of __

FIGURE 4. Example of specific inspection requirements sheets - Continued.

Downloaded from http://www.everyspec.com

ITEM NO.	CHARACTERISTIC	INSPECTION METHOD	SYMBOL	INSP INITIAL
43 1011	42 HAND PARKING BRAKE TEST 45 APPLICATION OF THE HAND BRAKE SHALL HOLD VEHICLE MOTIONLESS ON A DRY CONCRETE 40 PERCENT GRADE, HEADED UP AND DOWN GRADE.	FUNCTIONAL	✓	
43	42 SERVICE BRAKES TEST 45 THE TRUCK TRACTOR WITH A SEMITRAILER COMBINATION AND CARGO TRUCK SERVICE BRAKES, SHALL CONTROL, DECELERATE AND STOP THE VEHICLE COMBINATION OR CARGO VEHICLE WITHIN A MEASURED BRAKING DISTANCE OF 30 FEET FROM A SPEED OF 20 MPH ON DRY, LEVEL AND HARD SURFACED ROAD.	FUNCTIONAL	✓	
	49 RESULTS:			
43	42 HIGH SPEED OPERATION 45 THE CARGO VEHICLE AND TRACTOR WITH SEMI-TRAILER COMBINATION SHALL OPERATE AT A SUSTAINED HIGH SPEED OF NOT LESS THAN 50 MILES PER HOUR.	FUNCTIONAL	✓	
	49 RESULTS:			
43 1014	42 LOW SPEED OPERATION			

FIR: 12345678
DATE: 9-15-77

Page _ of __

FIGURE 4. Example of specific inspection requirements sheets - Continued.

Downloaded from http://www.everyspec.com

ITEM NO.	CHARACTERISTIC	INSPECTION METHOD	SYMBOL	INSP INITIAL
	(45) WITH THE ENGINE OPERATING IN THE SPEED RANGE WHICH DELIVERS MAXIMUM TORQUE, THE VEHICLE SHALL OPERATE AT A SUSTAINED LOW SPEED OF NOT MORE THAN 2-1/2 MILES PER HOUR WITHOUT DAMAGE TO VEHICLE.	FUNCTIONAL	✓	
	(49) RESULTS:			
	AREA NO. 5			
	CONTROL TESTS			
1101	SOFT TOP CHECK (4.X.X.X)			
	THE VEHICLE SHALL HAVE THE COMPLETE SOFT TOP INSTALLED, AND THE TOP CHECKED FOR PROPER INSTALLATION, COMPLETENESS, AND FOR FUNCTIONAL REQUIREMENTS.	VISUAL & FUNCTIONAL	✓	
1102	LEVEL ROAD AND GRADE SPEED TESTS (4.X.X.X)			
	TO DETERMINE CONFORMANCE TO 3.X.X & 3.X.X.X, THE VEHICLE SHALL BE OPERATED AS SPECIFIED AND VEHICLE OBSERVED FOR PERFORMANCE AND SPEED REQUIREMENTS.	VISUAL & FUNCTIONAL	✓	

FIR: 12345678
DATE: 9-15-77

Page _ of __

FIGURE 4. Example of specific inspection requirements sheets - Continued.

Downloaded from http://www.everyspec.com

ITEM NO.	CHARACTERISTIC	INSPECTION METHOD (46)	SYMBOL (47)	INSP INITIAL (48)
	(41) AREA NO. 1 FRAME LINE			
(43) 101	(42) U-BOLT (SHIPPING TIE DOWN) (DWG 10883223) CURBSIDE INSTALLATION PER DWG 12256416A & 12256206A			
	CARGO (DWG 8750151A) (5), W/W (DWG 8750152A) (6) LWB CARGO (DWG 8750155A) (7), W/W (DWG 8750156A) (8) DUMP (DWG 8750157A) (5), W/W (DWG 8750158A) (6) TRACTOR (DWG 8750159A) (5), W/W (DWG 8750160A) (6) WRECKER (DWG 8750163A) (6)			
	A. MOUNTING - COMPLETE & SECURED (44) CONDITION - NO BENDS, CRACKS, KINKS, ETC.	VISUAL VISUAL	✓ ✓	
102	U-BOLT (SHIPPING TIE DOWN) (DWG 10883223) ROADSIDE INSTALLATION PER DWG 12256416A & 12256206A			
	CARGO (DWG 8750151A) (6), W/W (DWG 8750152A) (7) LWB CARGO (DWG 8750155A) (8), W/W (DWG 8750156A) (9) DUMP (DWG 8750157A) (6), W/W (DWG 8750158A) (7) TRACTOR (DWG 8750159A) (6), W/W (DWG 8750160A) (7) WRECKER (DWG 8750163A) (6)			
	A. MOUNTING - COMPLETE & SECURED (44) CONDITION - NO BENDS, CRACKS, KINKS, ETC.	VISUAL VISUAL	✓ ✓	

FIR: 12345678
DATE: 9-15-77

Page _ of __

FIGURE 4A. Example of in-process inspection requirements sheets

Downloaded from http://www.everyspec.com

ITEM NO.	CHARACTERISTIC	INSPECTION METHOD (46)	SYMBOL (47)	INSP INITIAL (48)
103	FRONT SHOCK ABSORBER BRACKETS CURBSIDE, ROADSIDE INSTALLATION PER DWG 11664506A			
	A. MOUNTING BRACKETS & NUTS (2) EACH - COMPLETE & SECURED	VISUAL	✓	
	CONDITION OF BRACKETS - NO CRACKS	VISUAL	✓	
104	REAR SHACKLES RIGHT & LEFT (DWG 7409523) INSTALLATION PER DWG 12256206			
	A. MOUNTING SCREWS & NUTS (3) EACH - COMPLETE & SECURED	VISUAL	✓	
	B. LIFT RING:			
	MOUNTED - SECURED	VISUAL	✓	
	OPERATION - MUST MOVE FREELY	FUNCTIONAL	✓	
	C. RETAINER PIN & CHAIN - COMPLETE & SECURED	VISUAL	✓	
	(41) AREA NO. 2 AXLE SET			
(43) 201	(42) REAR SUSPENSION INSTALLATION PER DWG 10883209A			
	A. TORQUE RODS (6):			
	(44) MOUNTING NUTS (2) & COTTER PINS (2) EACH - COMPLETE & SECURED	VISUAL	✓	
	RUBBER BONDING, MOUNTING - SECURED	VISUAL	✓	
	CONDITION OF BOND - NO CRACKS, SPLITS, ETC.	VISUAL	✓	
	B. SPRING ASSEMBLY RIGHT & LEFT:			
	(44) MOUNTING U-BOLTS (2) & NUTS (2) EACH - COMPLETE & SECURE	VISUAL	✓	

FIR: 12345678
DATE: 9-15-77

Page _ of __

FIGURE 4A. Example of in-process inspection requirements sheets - Continued.

Downloaded from http://www.everyspec.com

ITEM NO.	CHARACTERISTIC	INSPECTION METHOD (46)	SYMBOL (47)	INSP INITIAL (48)
	SPRING CLAMPS (4) EACH - COMPLETE & SECURED	VISUAL	✓	
	RUBBER BUMPER PADS (4) - COMPLETE & SECURED	VISUAL	✓	
	BOGIE GREASE FITTINGS (2) - ACCESSIBLE, SECURED & GREASED	VISUAL	✓	
202	REAR SUSPENSION INSTALLATION PER DWG 10871257A WRECKER ONLY (DWG 8750163A)			
	A. TORQUE RODS (6):			
	MOUNTING NUTS (2) & COTTER PINS (2) EACH - COMPLETE & SECURED	VISUAL	✓	
	RUBBER BONDING, MOUNTING - SECURED	VISUAL	✓	
	CONDITION OF BOND, NO CRACKS, SPLITS, ETC.	VISUAL	✓	
	B. SPRING ASSEMBLY RIGHT & LEFT:			
	MOUNTING U-BOLTS (2) & NUTS (2) EACH - COMPLETE & SECURED	VISUAL	✓	
	RUBBER BUMPER PADS (4) - COMPLETE & SECURED	VISUAL	✓	
	BOGIE GREASE FITTINGS (2) - ACCESSIBLE, SECURED & GREASED	VISUAL	✓	
203	REAR AXLE (INTERMEDIATE & REAR) INSTALLATION PER DWG 10883209A			
	A. CARRIER ASSEMBLIES (2):			
	RETAINER CAP, MOUNTING, NUTS (18) EACH - COMPLETE & SECURED	VISUAL	✓	
	B. FILL PLUGS (2) & DRAIN PLUGS (2):			
	MOUNTING - SECURED	VISUAL	✓	
	C. BREATHERS (2):			
	MOUNTING - SECURED	VISUAL	✓	
	CONDITION OF BREATHER - OPEN, NO OBSTRUCTIONS	FUNCTIONAL	✓	

FIR: 12345678
DATE: 9-15-77

Page _ of __

FIGURE 4A. Example of in-process inspection requirements sheets - Continued.

Downloaded from http://www.everyspec.com

ITEM NO.	CHARACTERISTIC	INSPECTION METHOD (46)	SYMBOL (47)	INSP INITIAL (48)
	(41) AREA NO. 3 ENGINE DRESS			
(43) 301	(42) POWER PLANT ASSEMBLY (DWG 12277399A-1) INSTALLATION PER DWG 12256012A			
	A. ENGINE OIL DIPSTICK:			
	(44) MOUNTING - SECURED	VISUAL	✓	
	OIL LEVEL MARKING - MARKINGS MUST LEGIBLE	VISUAL	✓	
	B. OIL PAN:			
	(44) MOUNTING BOLTS (21) - COMPLETE & SECURED	VISUAL	✓	
	DRAIN PLUG (1), MOUNTING - SECURED	VISUAL	✓	
	CONDITION OF PAN - NO DENTS, HOLES, ETC.	VISUAL	✓	
	C. PRIMER PUMP (DWG 11593218): INSTALLATION PER DWGS 12256601 & 12256174			
	MOUNTED - SECURED	VISUAL	✓	
	RUBBER DUST BOOT - SECURED	VISUAL	✓	
	D. ELECTRICAL WIRING GENERAL	VISUAL	✓	
	CONNECTORS - COMPLETE & SECURED			
	WIRING - PROPERLY WIRED	VISUAL	✓	
	CONDITION - NO BARE WIRES, CRACKED INSULATION, ETC.	VISUAL	✓	

FIR: 12345678
DATE: 9-15-77

Page _ of __

FIGURE 4A. Example of in-process inspection requirements sheets - Continued.

Downloaded from http://www.everyspec.com

ITEM NO.	CHARACTERISTIC	INSPECTION METHOD (46)	SYMBOL (47)	INSP INITIAL (48)
302	TRANSMISSION ASSEMBLY (DWG 11669085A) INSTALLATION PER DWG 12256012A			
	A. OIL PAN:			
	MOUNTING BOLTS (21) - COMPLETE & SECURED	VISUAL	✓	
	DRAIN PLUG (1), MOUNTING - SECURED	VISUAL	✓	
	CONDITION OF PAN - NO DENTS, CRACKS, HOLES, ETC.	VISUAL	✓	
	B. FILLER TUBE:			
	MOUNTING - SECURED	VISUAL	✓	
	CONDITION OF TUBE - NO CRACKS, DENTS, ETC.	VISUAL	✓	
	C. MODULATOR VALVE & LINE:			
	MOUNTING - SECURED	VISUAL	✓	
303	PTO ASSEMBLY INSTALLATION PER DWG 12256012A			
	A. MOUNTING SCREWS (4), STUDS (2) & NUTS (2) - COMPLETE & SECURED	VISUAL	✓	
	LINKAGE, MOUNTING - SECURED	VISUAL	✓	
	(41) AREA NO. 4 <u>CAB TRIM</u>			
(43) 401	(42) BATTERY BOX & COVER (DWG 12255881) INSTALLATION PER DWG 12256204			

FIR: 12345678
DATE: 9-15-77

Page _ of __

FIGURE 4A. <u>Example of in-process inspection requirements sheets</u> - Continued.

Downloaded from http://www.everyspec.com

ITEM NO.	CHARACTERISTIC	INSPECTION METHOD (46)	SYMBOL (47)	INSP INITIAL (48)
	A. BATTERY BOX COVER:			
	(44) MOUNTING, UNIFORM FIT, LATCHES (2), HINGE - COMPLETE & SECURED	VISUAL	✓	
	BATTERY BOX COVER OPERATION - OPEN & CLOSE, MUST MOVE FREELY	VISUAL	✓	
	RUBBER SEAL, MOUNTING - SECURED	VISUAL	✓	
	RUBBER SEAL CONDITION - NO CRACKS, TEARS, ETC.	VISUAL	✓	
	OPEN POSITION ROD, MOUNTING - SECURED	VISUAL	✓	
	ROD OPERATION - SWIVEL, MUST OPERATE FREELY	FUNCTIONAL	✓	
402	CAB INTERIOR INSTALLATION PER DWG 12256119A			
	A. SLAVE RECEPTACLE:			
	MOUNTING - COMPLETE & SECURED	VISUAL	✓	
	CONDITION OF TUBE - NO CRACKS, RIPS, ETC.	VISUAL	✓	
	B. VENT, BATTERY BOX (NOT BOTTOM):			
	MOUNTING - SECURED	VISUAL	✓	
	CONDITION OF TUBE - NO CRACKS, DENTS, ETC.	VISUAL	✓	
	C. BATTERY BOX:			
	MOUNTING - SECURED	VISUAL	✓	
	COATING, PLASTISOL - UNIFORM COVERAGE, NO CORROSION, NO EXPOSED METAL, ETC.	VISUAL	✓	

FIR: 12345678
DATE: 9-15-77

Page _ of __

FIGURE 4A. Example of in-process inspection requirements sheets - Continued.

Downloaded from http://www.everyspec.com

ITEM NO.	CHARACTERISTIC	INSPECTION METHOD (46)	SYMBOL (47)	INSP INITIAL (48)
	CONDITION OF BATTERY BOX - NO DENTS, CRACKS, ETC.	VISUAL	✓	
	D. HOSE:			
	MOUNTING CLAMPS (2) - COMPLETE & SECURED	VISUAL	✓	
	CONDITION OF HOSE - NO CRACKS, SPLITS, ETC.	VISUAL	✓	
403	COMPANION SEAT (DWG 12255961) INSTALLATION PER DWG 12256204			
	A. MOUNTING - UNIFORM FIT, COMPLETE & SECURED	VISUAL	✓	
	HINGE & SPRINGS, MOUNTING - COMPLETE & SECURED	VISUAL	✓	
	SEAT BACK OPERATION - FOLD DOWN & UP, MUST OPERATE FREELY	FUNCTIONAL	✓	
	CONDITION OF SEAT - NO RIPS, HOLES, ETC.	VISUAL	✓	
	(41) AREA NO. 5 <u>CHASSIS</u>			
(43) 501	(42) FRONT WINCH INSTALLATION PER DWG 12255933A CARGO W/W (DWG 8750152A)			
	A. CABLE & CHAIN:			
	(44) COILED EVENLY ON DRUM	VISUAL	✓	
	MOUNTING - COMPLETE & SECURED	VISUAL	✓	
	CONDITION - NO KINKS OR FRAYING OF CABLE, NO CRACKS OR SEPARATION OF CHAIN LINKS, NO DEFORMATION OF CHAIN LINKS OR GRAB HOOK, CABLE GREASED	VISUAL	✓	

FIR: 12345678
DATE: 9-15-77

Page _ of __

FIGURE 4A. <u>Example of in-process inspection requirements sheets</u> - Continued.

Downloaded from http://www.everyspec.com

ITEM NO.	CHARACTERISTIC	INSPECTION METHOD (46)	SYMBOL (47)	INSP INITIAL (48)
	B. FRONT ROLLER:			
(44)	MOUNTING - SECURED	VISUAL	✓	
	OPERATION - MUST ROTATE FREELY	FUNCTIONAL	✓	
	CONDITION - NO GROOVES, CRACKS, ETC.	VISUAL & TACTILE	✓	
	C. DRUM CLUTCH LOCK:			
	MOUNTING - SECURED	VISUAL	✓	
	CONDITION - NO GROOVES, CRACKS, ETC.	VISUAL	✓	
	OPERATION - MUST MOVE IN & OUT FREELY	FUNCTIONAL	✓	
	D. HYDRAULIC MOTOR:			
	MOUNTING SCREWS & NUTS (10) EACH - COMPLETE & SECURED	VISUAL	✓	
	CONDITION - NO CRACKS, LEAKS, ETC	VISUAL	✓	
	E. WINCH MOUNTING BRACKETS RIGHT & LEFT (2) EACH:			
	MOUNTING SCREWS & NUTS (10) EACH - COMPLETE & SECURED	VISUAL	✓	
502	POWER STEERING PUMP (DWG 20510093) INSTALLATION PER DWG 12256021A & 11664516-1			
	A. HYDRAULIC LINES:			
	MOUNTING - COMPLETE & SECURED	VISUAL	✓	
	CONDITION - NO CRACKS, SPLITS, ETC	VISUAL	✓	
503	FRONT CAB MOUNTING RIGHT & LEFT			
	A. MOUNT:			
	MOUNTING SCREWS (2), NUT (2) & INSULATOR (2) - COMPLETE & SECURED	VISUAL	✓	
	CAB HEIGHT ADJUSTING WASHERS (2) - COMPLETE & SECURED	VISUAL	✓	

FIR: 12345678
DATE: 9-15-77

Page _ of __

FIGURE 4A. Example of in-process inspection requirements sheets - Continued.

Downloaded from http://www.everyspec.com

(50) (51)

END ITEM NOMENCLATURE Truck, Cargo 5 Ton, 6 X 6	INSP. DATE
USA OR END ITEM SERIAL NO. (52) 05B1234	

ITEM NO. (53)	DESCRIPTION OF DEFICIENCY (54)	INSP. INIT. (55)	CORRECTIVE ACTION TAKEN (56)	INSP INIT (57)
101 A	Hood fits poorly to cab & fenders		See waiver sheet	
101 D	Hood Latch Decal is missing		Installed	
201 B	Engine oil level markings have not been added to engine oil dip stick		Corrected, added marks	
201 D	Engine drive belt is frayed		Replaced	
202 B	Lower radiator hose is kinked		See waiver sheet	
	Upper & lower hose are 2 piece which does not agree to print.			
302 A	Fresh air vent doors fits poorly to cowl - curbside		Reworked	

FIGURE 5. Example of deficiency sheet.

Downloaded from http://www.everyspec.com

THE FOLLOWING ITEMS ARE LISTED TO INDICATE COMPONENTS THAT WERE FABRICATED OR PROTOTYPE BUILD-UP ONLY AND DO NOT REPRESENT PRODUCTION. PRODUCTION COMPONENTS WILL DIFFER WHEN PRODUCTION TOOLING IS AVAILABLE.

58 COMPONENT OR ASSEMBLY NOMENCLATURE	59 PROTOTYPE RCSK #	60 PRODUCTION NUMBER	61 REMARKS:
Hood Assembly	8734	12255776	Hood fits poorly to cab and fenders. Will be corrected when production tooling is used.
		62	Engr. Initials:
Radiator Assembly	9165	11669165	Upper and lower hoses are two pieces which does not agree to print. Will be corrected in production.
			Engr. Initials:
			Engr. Initials:
			Engr. Initials:

FIGURE 6. Example of waiver sheet.

Downloaded from http://www.everyspec.com

Custodian:
Army - AT

Preparing activity:
Army - AT

(Project QCIC-A127)

Downloaded from http://www.everyspec.com

FOLD

U.S. ARMY TANK - AUTOMOTIVE COMMAND
ATTN: AMSTA-GDS
WARREN, MICHIGAN 48397-5000

OFFICIAL BUSINESS
PENALTY FOR PRIVATE USE $300

POSTAGE AND FEES PAID

U.S.MAIL

Commander
U.S. Army Tank-Automotive
Command
ATTN: AMSTA-GDS
Warren, MI 48397-5000

FOLD

Downloaded from http://www.everyspec.com

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

INSTRUCTIONS: This form is provided to solicit beneficial comments which may improve this document and enhance its use. DoD contractors, government activities, manufacturers, vendors, or other prospective users of the document are invited to submit comments to the government. Fold on lines on reverse side, staple in corner, and send to preparing activity. Attach any pertinent data which may be of use in improving this document. If there are additional papers, attach to form and place both in an envelope addressed to preparing activity. A response will be provided to the submitter, when name and address is provided, within 30 days indicating that the 1426 was received and when any appropriate action on it will be completed.

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. AREA QCIC

DOCUMENT IDENTIFIER *(Number)* AND TITLE Preparation of Final Inspection Record (FIR)

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)*

TELEPHONE NO.

DATE

DD FORM 1 OCT 76 1426 EDITION OF 1 JAN 72 WILL BE USED UNTIL EXHAUSTED.