

1. SPEC MIL-W-13855 AND ANSI Y14.5M-82 APPLY.
2. WELD IN ACCORDANCE WITH CLASS 3, GMAW, MIL-STD-1261, USING FILLER METAL AWS A5.18 E70S77.
3. INTERPRETATION OF WELDING SYMBOLS SHALL BE IN ACCORDANCE WITH AWS A2.4-86.
4. 0.5 MAX WELD PROTRUSION PERMISSIBLE IN AREAS SPECIFIED. GRINDING PERMISSIBLE.
5. FINISH 3.2 MACHINE SURFACES EXCEPT AS NOTED.
6. EACH RECEIVER SHALL BE MAGNETIC PARTICLE INSPECTED AFTER FINAL GRINDING FOR CRACKS (NONE ALLOWED PER MIL-STD-1261), SEAMS AND OTHER INJURIOUS DEFECTS THAT COULD ADVERSELY AFFECT FUNCTION OF PART WITH A CURRENT OF 400 TO 600 AMPS WITH AC/DC FLUORESCENT SOLUTION.
7. PROTECTIVE FINISH:
APPLY MAGNETIC PARTICLE TEST MARK "M" AFTER MAGNETIC PARTICLE INSPECTION IN AREA SPECIFIED.
8. FINISH 5.3.1.2 OF MIL-STD-171.
9. CHECK FUNCTIONAL CONDITION WITH GAGE 9350156.
10. CHECK FUNCTIONAL CONDITION WITH GAGE 12923101.
11. CHECK FUNCTIONAL CONDITION WITH GAGE 12923171.

2-WASHER, FRONT SLING SWIVEL-12556994

BODY, RECEIVER-9348203

CONTACT WITH 9348203 & 9348212
APPLIES AT 26.970
APPLIES AT 23.373

2-BUSHING, FRONT SLING SWIVEL-12556993

266

22 AREA "M"

28.83

237.2

SUPPORT, GAS CYLINDER-9348205

BUSHING, FRONT 9348206

SUPPORT, BARREL-9348204

BLOCK, REAR-9348211

SLEEVE ASSEMBLY, MAGAZINE-9348212

GUIDE, SLIDE, LEFT - 9348209

GUIDE, SLIDE, RIGHT 9348210

GUIDE COCKING HANDLE 9348208

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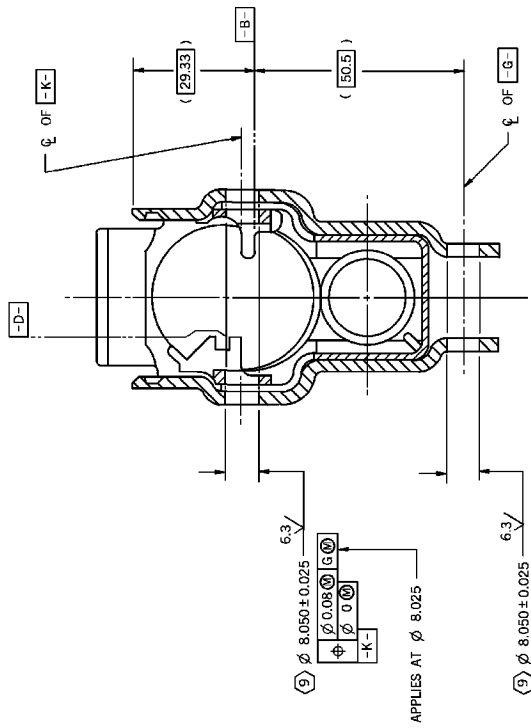
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BODY, RECEIVER-9348203

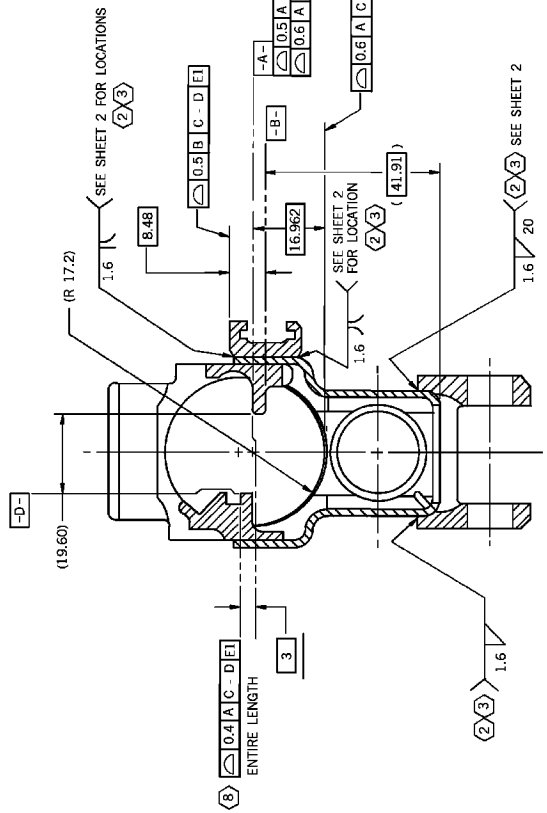
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SUPPORT, GAS CYLINDER-

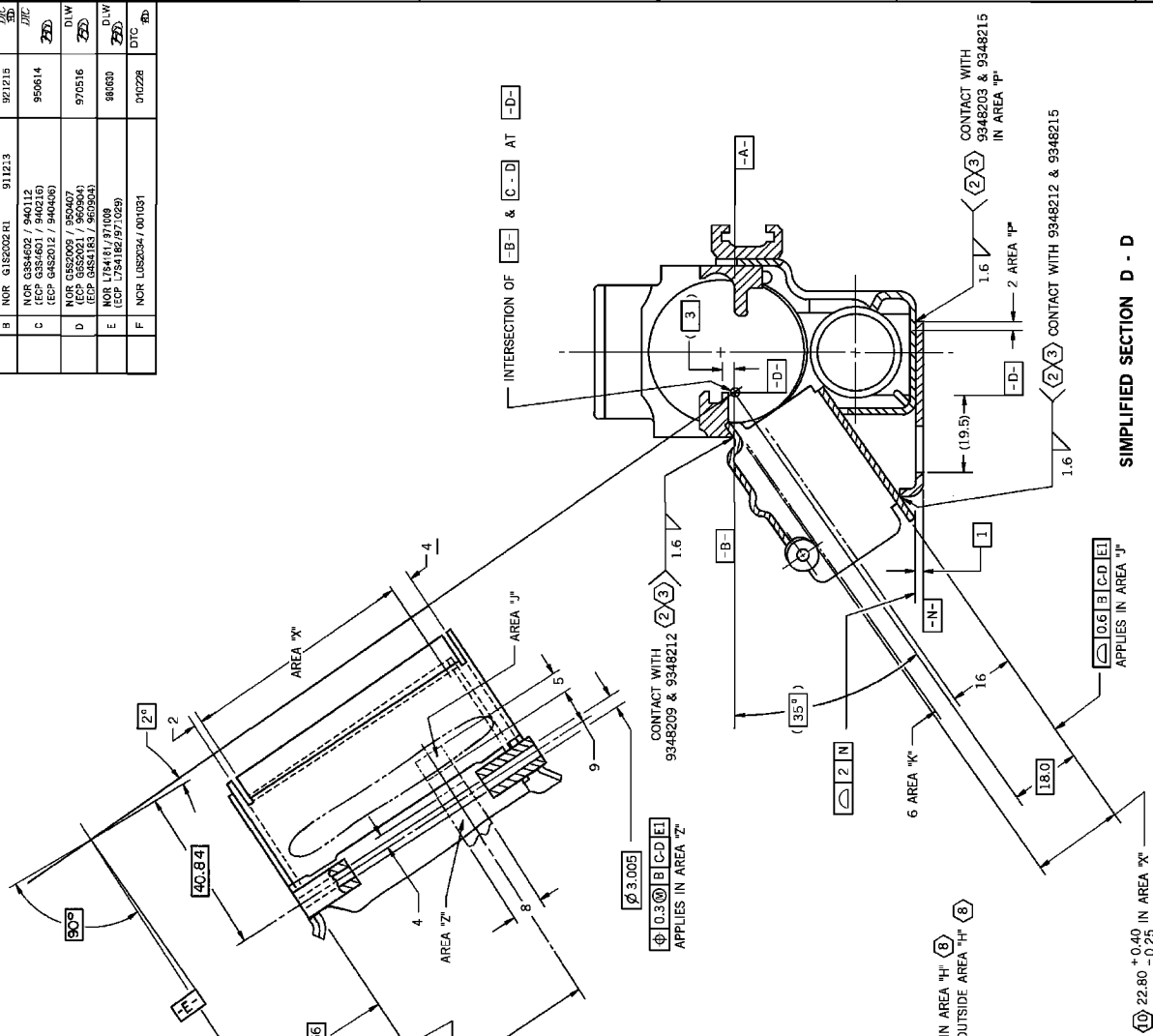
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	B	NOR GIS2002.R1 911213		9/21/15	SD
	C	NOR GIS4002 940112 (FCP GIS3401/940213) (FCP GIS3012/940406)		9/56/14	JWC
	D	NOR GIS5002/950407 (FCP GIS5002/950604) (FCP GIS5002/950604)		9/70/15	DLW
	E	NOR GIS4102/970504 (FCP GIS4102/970504)		980601	DLW
	F	NOR GIS6203/001001		01/02/98	OTC



SIMPLIFIED SECTION B - B



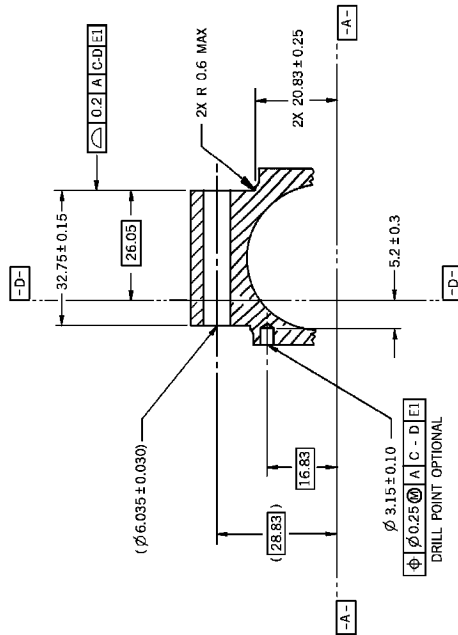
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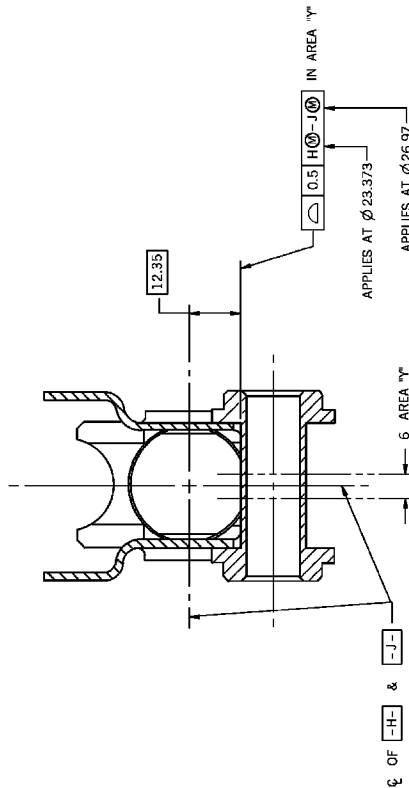
SIMPLIFIED SECTION D - D

PMIC	A	DO NOT SCALE DRAWING	CONTRACT NUMBER DDA005-BUC-0082	PART NO. 9348202		METRIC
				U.S. ARMY DESIGN ACTIVITY AMSCHEMANN AND ENGINEERING CENTER, PLANTING ARESNAL, NEW JERSEY 07065-5000		
MECHANICAL PROPERTIES		THESE DIMENSIONS ARE BASED ON TOLERANCE OF DIMENSIONAL TOLERANCE OF 2 PL-1 3 PL-1	CONTRACTOR F.N. MANUFACTURING, INC. DRAWN BY DATE / TYPED BY J. M. S. 10/10/82 CHECKED BY J. M. S.	RECEIVER		
TEMP		THIRD ANGLE PROJECTION 	DRAWING APPROVAL J. M. S. 10/10/82 DATE / TYPED BY J. M. S. 10/10/82	CASE CODE F 19200		9348202
PL-1				SCALE 2:1		SHEET 3 OF 6
PL-2				UNIT WT.		
PL-3				FINISH		
PL-4				APPLICATION		
PL-5				9348201		
PL-6				M249 M.G.		
PL-7				NEXT ASSY		
PL-8				USED ON		
PL-9						
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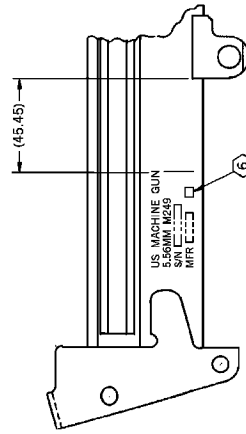
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					<i>INC</i>
				9/56/14	<i>SD</i>
					<i>DLW</i>
				9/705/16	<i>SD</i>
					<i>DLW</i>
				9/806/0	<i>SD</i>
					<i>DTC</i>
				01/02/26	



PARTIAL SECTION L-L
SCALE 2/1



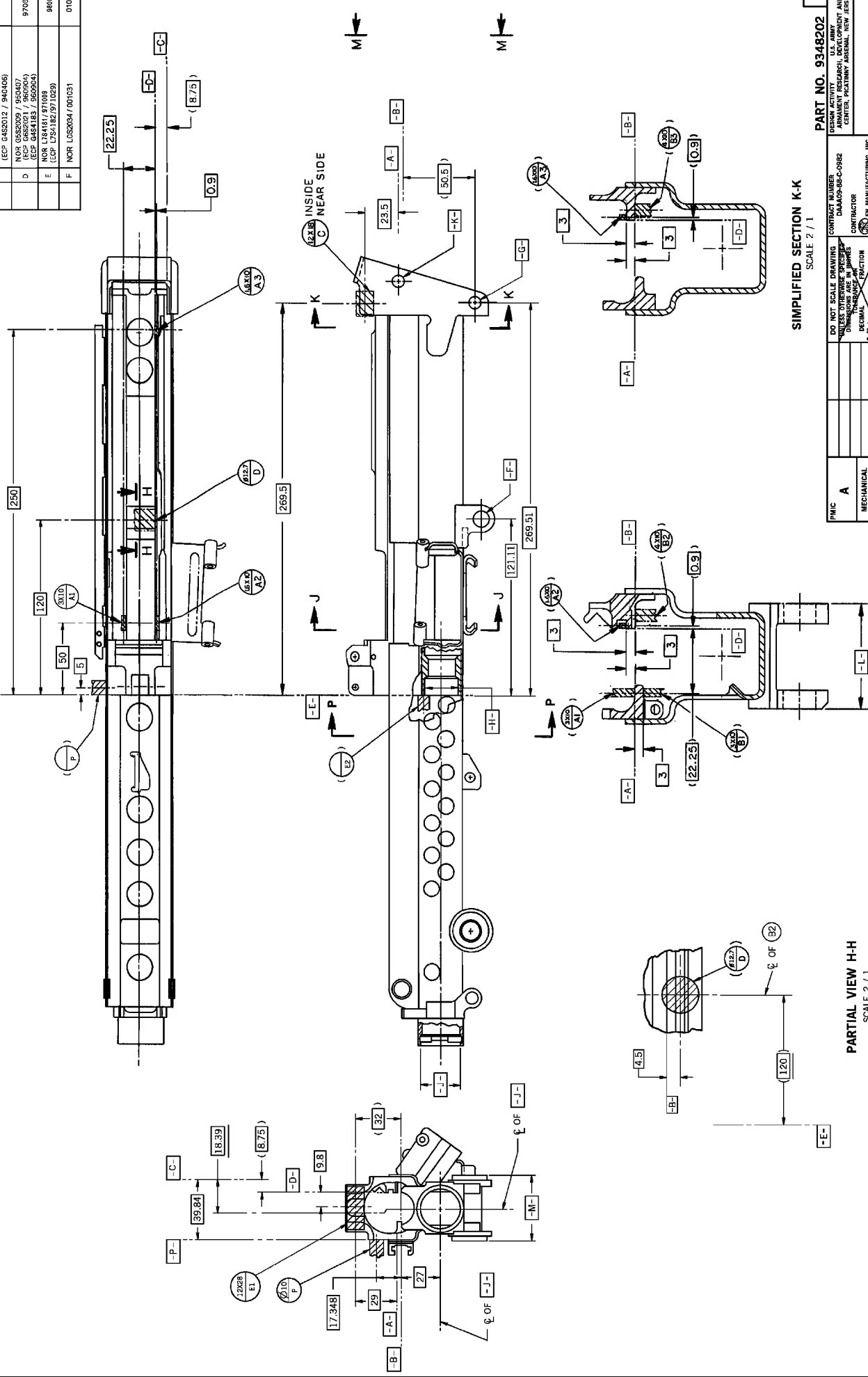
SECTION E-E
SCALE 2/1



PARTIAL VIEW F-F
WEAPON MARKING LOCATION

PMIC A MECHANICAL PARTS VP 15 BH RH	93482021 NEXT USED ON APPLICATION	9348202 PART NO.	9348202 PART NO.	U.S. ARMY MEDICAL CENTER, FORT MONMOUTH, NEW JERSEY 08060-5000	METRIC
	93482021 NEXT USED ON APPLICATION	9348202 PART NO.	9348202 PART NO.	U.S. ARMY MEDICAL CENTER, FORT MONMOUTH, NEW JERSEY 08060-5000	METRIC

2	1	REVISIONS	DATE
ZONE	LTR	DESCRIPTION	
B	NOR	G152002 RI	911213
C	NOR	G354602 / 940112 (ECF G354601 / 940216) (ECF G452012 / 940406)	
D	NOR	G32009 / 950407 (ECF G652021 / 960904) (ECF G654183 / 960904)	
E	NOR	L784181/971009 (ECF L759-182/971029)	
F	NOR	L052004 / 001031	



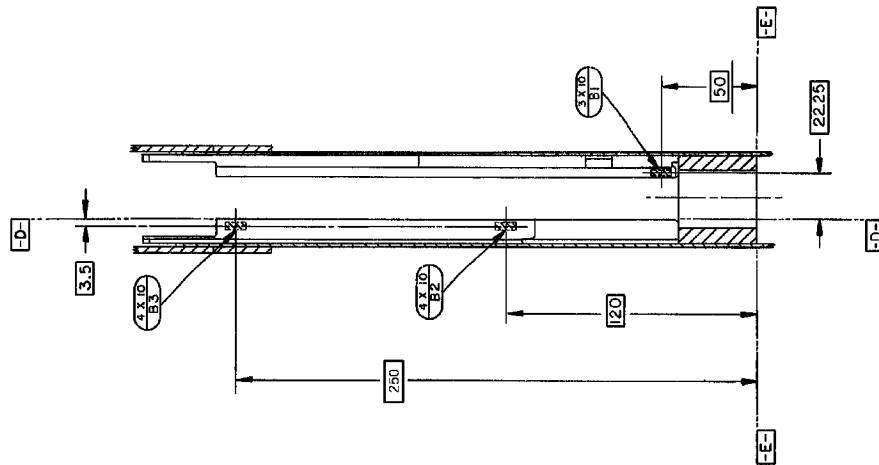
SIMPLIFIED SECTION K-K

SIMPLIFIED SECTION J-J

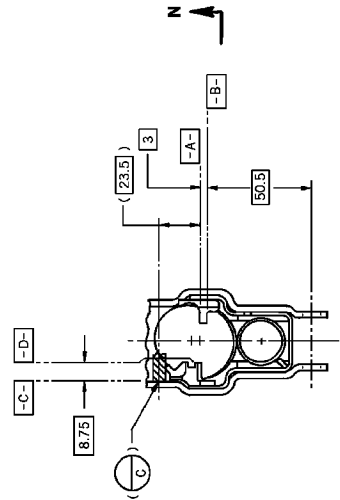
PARTIAL VIEW H-H

PMIC	A	DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS IN PARENT PARENTHESIS ARE IN INCHES		CONTRACT NUMBER DAA49-98-C-0982		DESIGN ACTIVITY U.S. ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER, PICTONNY AIRFIELD, NEW JERSEY 07956-5000		PART NO. 9348202		METRIC	
		DECIMAL FRACTION 1/8" = 1"		CONTRACTOR 		RESEARCH FBI		RECEIVER			
		THIRD ANGLE PROJECTION		DRAWN BY D.WILSON		DATE (MM/DD/YY) 8/30/98		CHECKED BY J. HARRIS			
				DESIGNED BY J. HARRIS		DATE (MM/DD/YY) 8/30/98		SCALE 1/1		SHEET 5 OF 6	
				9348201		M249 M.G.		F 1200		9348202	
				NEXT ASSY		USED ON		UNIT WH			
				APPLICATION		DESIGNED BY J. HARRIS		SCALE 1/1		SHEET 5 OF 6	

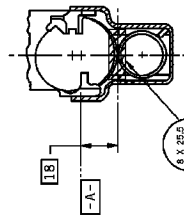
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B	NOR	Q152002R1	9/12/13	9/21/15	MC	MC
C	NOR	Q354600 / 9/30/12 NOR Q354601 / 9/42/16 (ECP 6/452012 / 9/40/06)	1	9/30/14	JMC	JMC
D	NOR	Q552009 / 9/50/47 ECP 6552001 / 9/60/04 ECP 6543183 / 9/50/41	1	9/03/16	DLW	DLW
E	NOR	Q718461 / 9/11/06 ECP 1751862/9/710269	1	9/03/10	DLW	DLW
F	NOR	Q1052034 / 00/01/31	1	01/02/28	CYC	CYC



SIMPLIFIED SECTION N - N



PARTIAL VIEW M - M

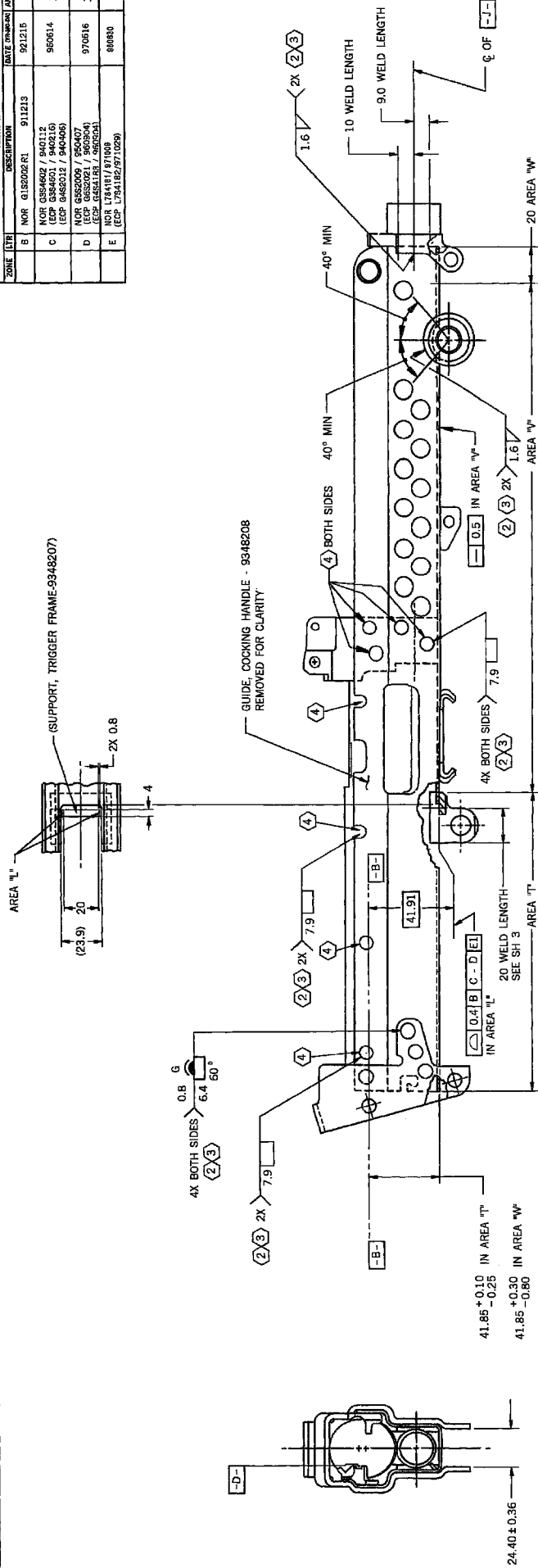


SIMPLIFIED SECTION P-P

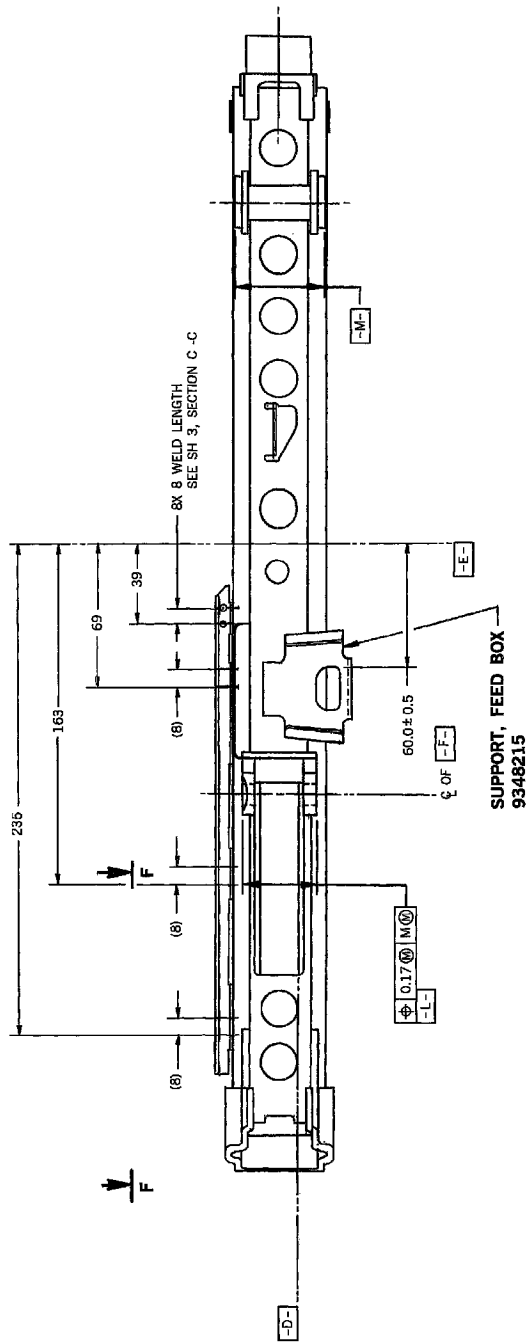
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NOTICE OF REVISION (NOR) This revision described below has been authorized for the document listed.		1. DATE (YTAIADD) 000731	Form Approved OMB NO. 0704-0188
Public reporting burden for this collection of information is estimated to average 2 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden to Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302 and to the Office of Management and Budget, Paperwork Reduction Project (0704-0188) Washington DC 20503.			2. PROCURING ACTIVITY NO. L0S2034
PLEASE DO NOT RETURN YOUR COMPLETED TO EITHER OF THESE ADDRESSES. RETURN COMPLETED FORM TO THE GOVERNMENT ISSUING CONTRACTING OFFICER FOR THE CONTRACT / PROCURING ACTIVITY NUMBER LISTED IN ITEM 2 OF THIS FORM.			3. DODACC
4. ORIGINATOR a. TYPED NAME (First, Middle Initial, Last) Brian Donovan	b. ADDRESS (Street, City, State, Zip Code) AMSTA-AR-CCL-A ARDEC Picatinny Arsenal, NJ 07806-5000	5. CAGE CODE 19200 7. CAGE CODE 19200	6. NOR NO. L0S2034 - F9348202 8. DOCUMENT NO. F 9348202
9. TITLE OF DOCUMENT RECEIVER		10. REVISION LETTER a. CURRENT E	11. ECP NO. 00SAW-002
12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES MACHINE GUN, 5.56MM; M249		NOR SH. 1 OF 1	
13. DESCRIPTION OF CHANGE: CHANGE: ON SHEET 1 IN NOTE 3: FROM: "AWS 2.4-86" TO: "AWS A2.4-86"			
UPDATE SHEETS 2-6 OF 6 TO THE NEXT REVISION LEVEL TO MAINTAIN CONTINUITY.			
14. THIS SECTION FOR GOVERNMENT USE ONLY			
a. (X) one ☐ (1) Existing document supplemented by this NOR may be used in manufacturing. ☐ (2) Revised document must be received before manufacturer may incorporate this change. ☐ (3) Custodian of master document shall make above revision and furnish revised document.			
b. ACTIVITY AUTHORIZED TO APPROVE CHANGE FOR GOVERNMENT TACOM-ARDEC, AMSTA-AR-CCL-F		c. TYPED NAME (First, Middle Initial, Last)	
d. TITLE Chief, CCAC Prod & Field Spt Team		e. SIGNATURE 	f. DATE SIGNED (YTAIADD) 20001031
15. a. ACTIVITY ACCOMPLISHING REVISION		b. REVISION COMPLETERS (SIGNATURE)	c. DATE SIGNED (YTAIADD)

ZONE	LFR	DESCRIPTION	BOULEVARD		DATE INVOICED	APPROVED
			IN	OUT		
B		NOR GIS2002-FI 911213			9/21/16	
		NOR GIS5402 / 940112 (ECP GIS5401 / 940216) (ECP GIS5401 / 940405)			9/50614	JTC ZD
D		NOR GIS2002 / 954047 (ECP GIS2001 / 950304) (ECP GIS2001 / 950504) (ECP GIS2101 / 950504)			9/70516	DLW ZD
E		NOR L754151 / 871005 (ECP L754182 / 971005)			9/80800	DLW ZD



SIMPLIFIED VIEW A - A

[illegible]

DRAWING SIZE F

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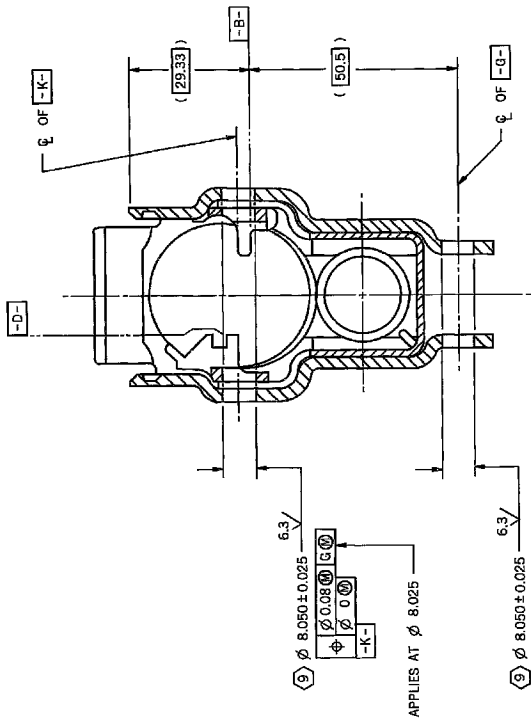
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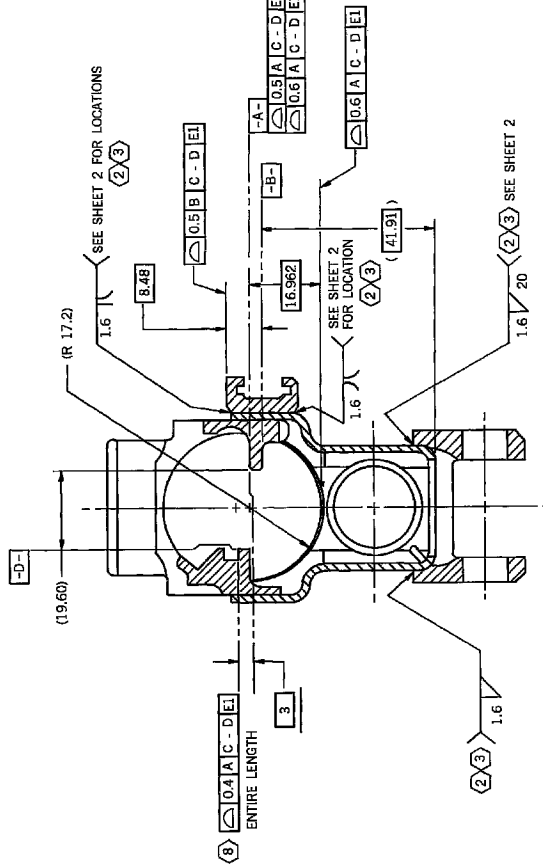
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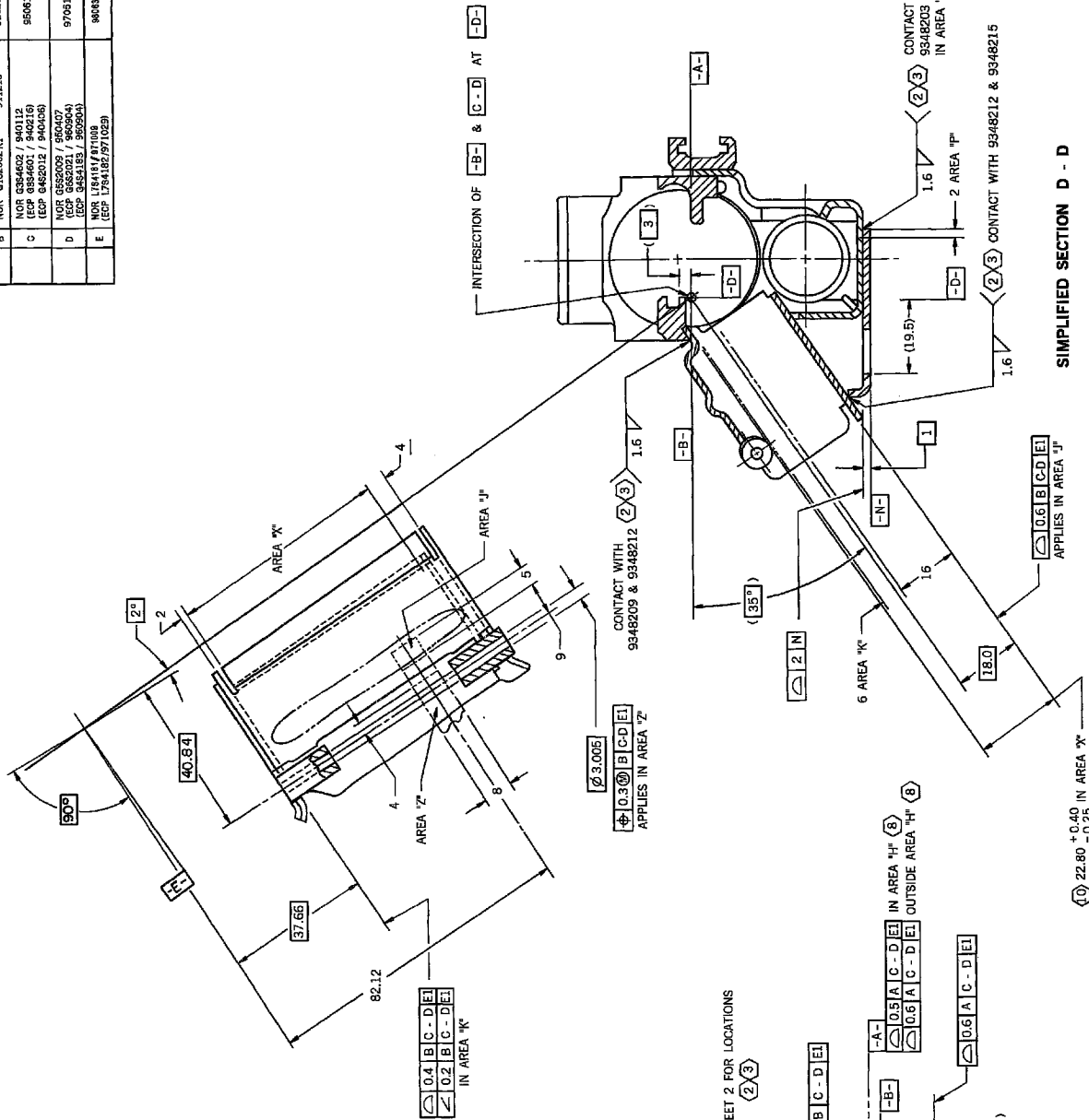
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C	NOR	0384602 / 940112 ECOP 0482012 / 940458 ECOP 0482012 / 940458	950614	JLC
D	NOR	03820202 / 950407 ECOP 03820201 / 960504 ECOP 0482012 / 960504	970616	DLW
E	NOR	1784181 / 971008 ECOP 1784182 / 971029	980830	DLW



SIMPLIFIED SECTION B - B



SIMPLIFIED SECTION C - C



SIMPLIFIED SECTION D - D

PART NO. 9348202		METRIC	
CONTRACT NUMBER		CONTRACTOR	
DAAU9-86-C-0982		DAVIDSON	
CONTRACTOR		DATE	
DAVIDSON		9/05/90	
DRAWN BY		CHECKED BY	
DAVIDSON		DAVIDSON	
DESIGNED BY		DATE	
DAVIDSON		9/05/90	
DRAWING APPROVAL		REVISION	
DAVIDSON		DAVIDSON	
DATE		DATE	
9/05/90		9/05/90	
REVISION		REVISION	
F 19200		9348202	
CASE CODE		RECEIVER	
F 19200		9348202	
SHEET 2 / 1		SHEET 3 OF 6	

DRAWING SIZE F

8

7

6

5

4

3

2

1

F

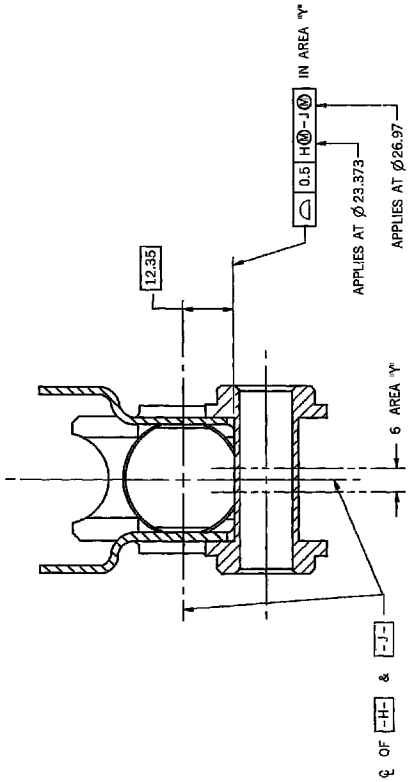
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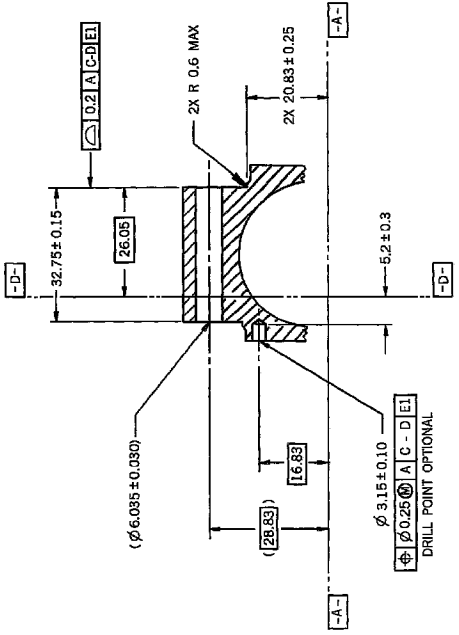
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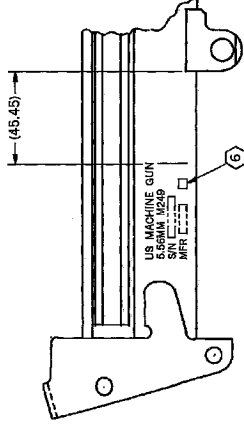
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SECTION E-E
SCALE 2/1



PARTIAL SECTION L-L
SCALE 2/1

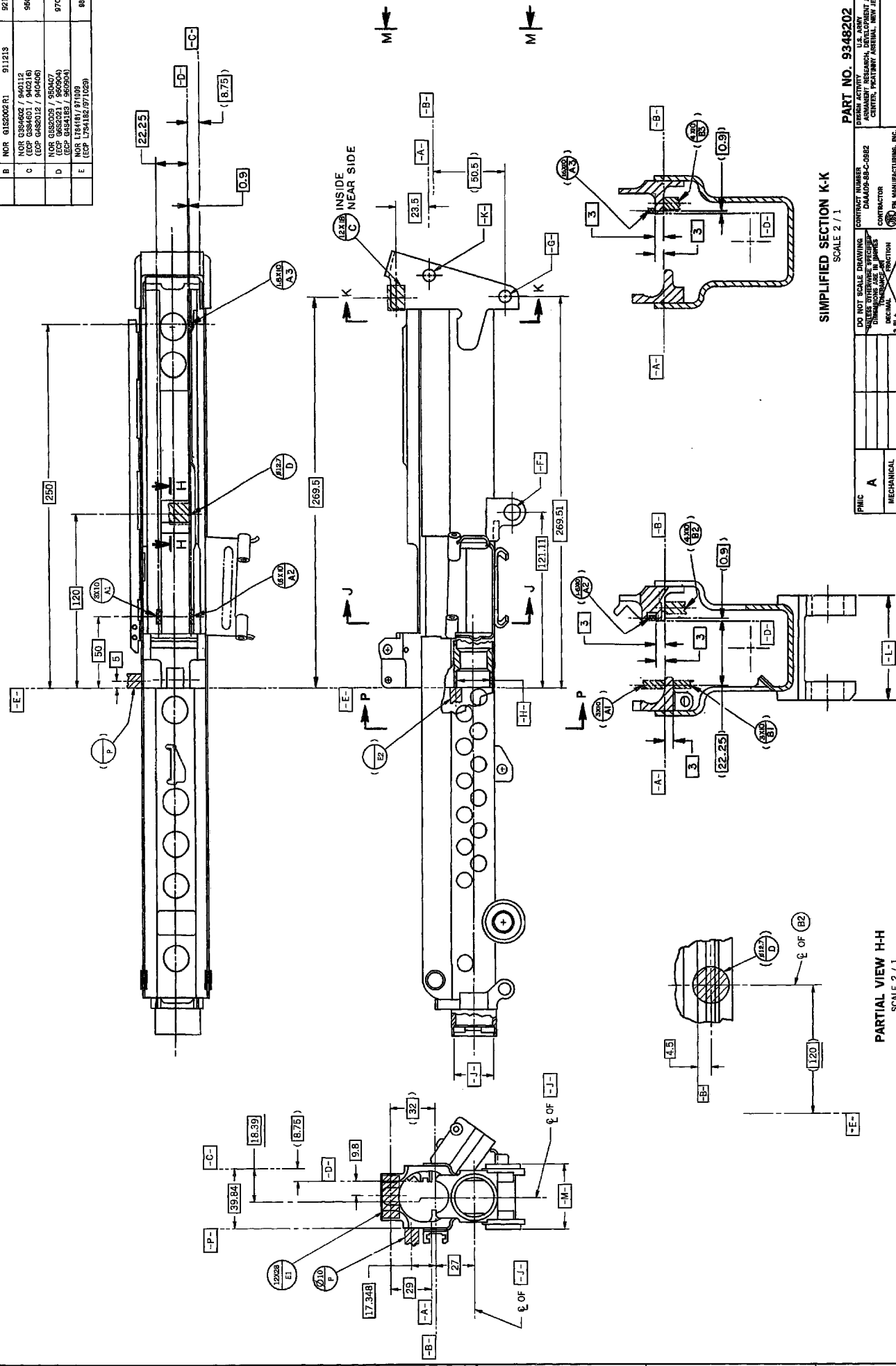


PARTIAL VIEW F-F
WEAPON MARKING LOCATION

ZONE	DATE	DESCRIPTION	APPROVED
B	911215	NOR 312002/11 911215	JTC
C	960614	NOR 0334602 / 940112 (ECP 0334601 / 940216) (ECP 042012 / 940405)	JTC
D	970616	NOR 055009 / 950407 (ECP 055008 / 950407) (ECP 0684183 / 950904)	DLW
E	970616	NOR 178418 / 810808 (ECP 1784182 / 971029)	DLW

PART NO. 9348202		METRIC	
DESIGN ACTIVITY		U.S. ARMY	
CONTRACT NUMBER		DAAAG-88-C-0982	
CONTRACTOR		DAVID THERDOTT	
DESIGNED BY		DAVID THERDOTT	
CHECKED BY		DAVID THERDOTT	
DRAWN BY		DAVID THERDOTT	
DATE		8/25/90	
SCALE		1/1	
UNIT		W.T.	
RECEIVER		9348202	
CASE CODE		F 19200	
SHEET 4 OF 6		SHEET 4 OF 6	

REVISIONS		DATE CHANGED	APPROVED
ZONE	LTR	DESCRIPTION	
B	NOR	6182002 R1 911213	<i>JWC</i> 2D
C	NOR	G3S4602 / 940112 (ECP G3S4601 / 940216) (ECP G4S0012 / 940406)	<i>JWC</i> 2D
D	NOR	G3S0205 / 950407 (ECP G6S5221 / 960504) (ECP G4S4189 / 960904)	<i>DLW</i> 2D
E	NOR	L764181 / 971009 (ECP L764182 / 971029)	<i>DLW</i> 2D



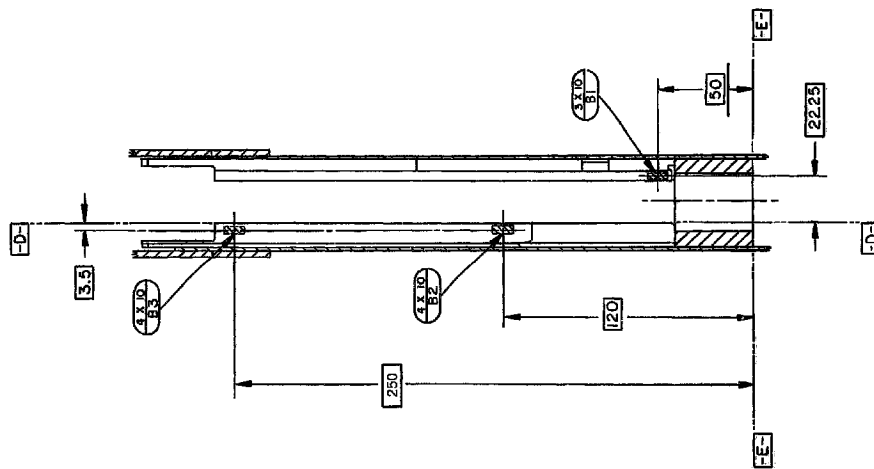
SIMPLIFIED SECTION K-K

SIMPLIFIED SECTION J-J

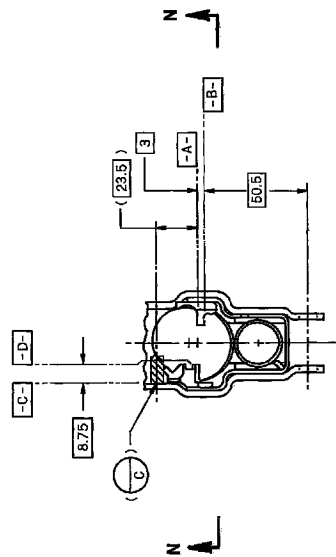
PARTIAL VIEW H-H
SCALE 2 / 1

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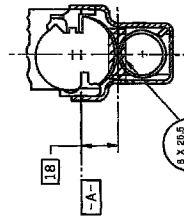
REVISIONS			DATE (mm-yy)	APPROVED
ZONE	LTN	DESCRIPTION		
B	NOR	GJ52002 R1	911213	911215
C	NOR	GJ54602 / 501112 (ECP 8452012 / 540498)	910614	910614
D	NOR	GJ52009 / 500407 (ECP 8452021 / 540304)	910616	910616
E	NOR	L784181 / 871008 (ECP L784182 / 871028)	910630	910630



SIMPLIFIED SECTION N - N



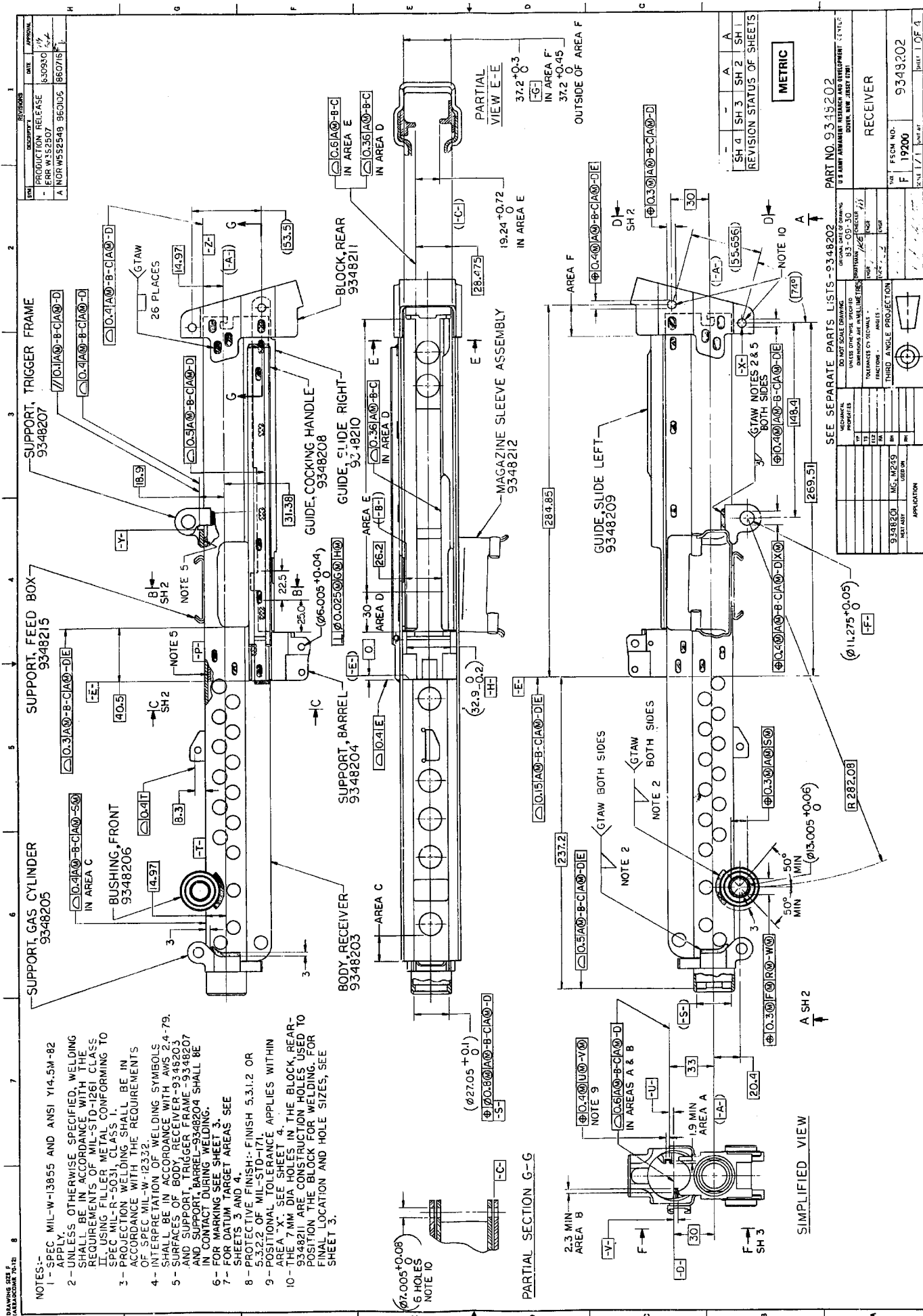
PARTIAL VIEW M - M



SIMPLIFIED SECTION P-P

PART NO. 9348202		METRIC	
DESIGN ACTIVITY		U.S. ARMY	
CONTRACT NUMBER		DAAAD-88-C-0812	
CONTRACTOR		FPI MANUFACTURING, INC.	
FORWARD BY		DATE (mm-yy)	
D. WILSON		8/5/93	
CHECKED BY		ENGINEER	
DRAWING APPROVAL		DESIGNED BY	
3348201		M249 M.L.B.	
NEXT ASSEMBLY		USED ON	
APPLICATION			
RECEIVER		9348202	
CASE CODE		F 19200	
FORM 1 / 1		BUREAU	
SHEET 5 OF 6			

- NOTES:-
- 1 - SPEC MIL-W-13855 AND ANSI Y14.5M-82 APPLY.
 - 2 - UNLESS OTHERWISE SPECIFIED, WELDING SHALL BE IN ACCORDANCE WITH THE REQUIREMENTS OF MIL-STD-1261 CLASS II, USING FILLER METAL CONFORMING TO SPEC MIL-R-5031, CLASS 1.
 - 3 - PROJECTION WELDING SHALL BE IN ACCORDANCE WITH THE REQUIREMENTS OF SPEC MIL-W-12332.
 - 4 - INTERPRETATION OF WELDING SYMBOLS SHALL BE IN ACCORDANCE WITH AWS 2.4-79.
 - 5 - SURFACES OF BODY, RECEIVER-9348203 AND SUPPORT, TRIGGER FRAME-9348207 IN CONTACT DURING WELDING.
 - 6 - FOR MARKING, SEE SHEET 13.
 - 7 - FOR DATUM TARGET AREAS SEE SHEET 3.
 - 8 - SHEET 3 MANUFACTURE FINISH 5.3.1.2 OR 5.3.2.5 OF MIL-STD-171.
 - 9 - POSITIONAL TOLERANCE APPLIES WITHIN AREA "X". SEE SHEET 4.
 - 10 - THE 7MM DIA HOLES IN THE BLOCK, REAR-9348211 ARE CONSTRUCTION HOLES USED TO POSITION THE BLOCK FOR WELDING. FOR FINAL LOCATION AND HOLE SIZES, SEE SHEET 3.



PARTIAL SECTION G-G

SIMPLIFIED VIEW

SH 4	SH 3	SH 2	SH 1

METRIC

SEE SEPARATE PARTS LISTS - 9348202

DO NOT SCALE DRAWING	ORIGINAL DATE OF DRAWING	93-09-30
UNLESS OTHERWISE SPECIFIED	UNLESS OTHERWISE SPECIFIED	UNLESS OTHERWISE SPECIFIED
TOLERANCES ARE IN INCHES	TOLERANCES ARE IN INCHES	TOLERANCES ARE IN INCHES
FUNCTIONS	FUNCTIONS	FUNCTIONS
THIRD ANGLE PROJECTION	THIRD ANGLE PROJECTION	THIRD ANGLE PROJECTION
9348202	9348202	9348202
REV 1	REV 1	REV 1
REV 2	REV 2	REV 2
REV 3	REV 3	REV 3
REV 4	REV 4	REV 4

PART NO. 9348202

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER, NEW JERSEY 07001

RECEIVER

REV 1

REV 2

REV 3

REV 4

REV 5

REV 6

REV 7

REV 8

REV 9

REV 10

REV 11

REV 12

REV 13

REV 14

REV 15

REV 16

REV 17

REV 18

REV 19

REV 20

REV 21

REV 22

REV 23

REV 24

REV 25

REV 26

REV 27

REV 28

REV 29

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REV 90

REV 91

REV 92

REV 93

REV 94

REV 95

REV 96

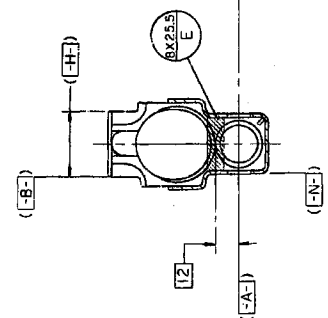
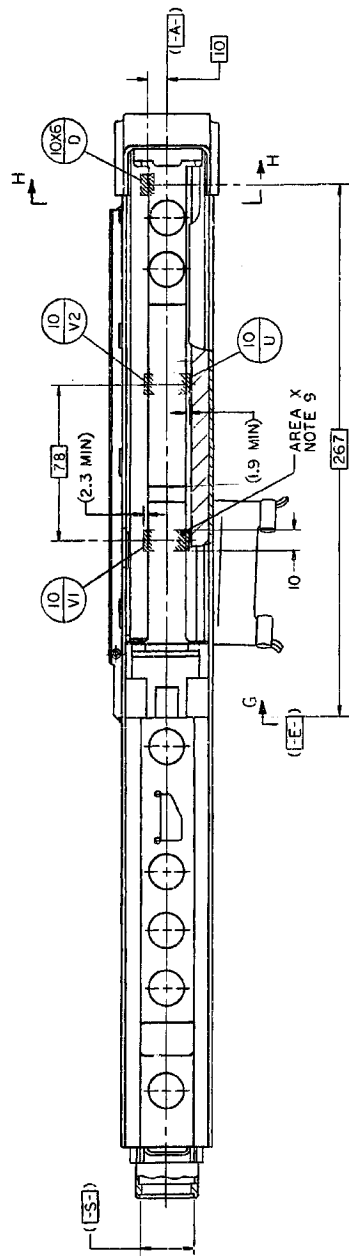
REV 97

REV 98

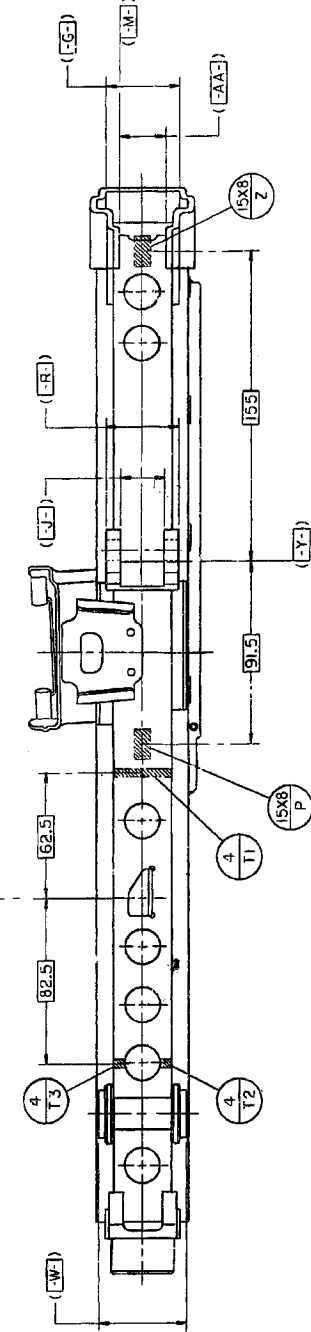
REV 99

REV 100

REVISIONS			
S/N	DESCRIPTION	DATE	APPROVAL
--	PRODUCTION RELEASE -- ERR W352507	830930	161 494



SIMPLIFIED SECTION G-G



PARTIAL SECTION H-H

METRIC

PART NO. 9348202

U S ARMY ARMBRIST RESEARCH AND DEVELOPMENT CENTER
DOWEL NEW JERSEY 07001

RECEIVER
(DATUM TARGET AREAS)

SIZE	FSCM NO.	9348202
F	19200	

SCALE	UNIT WT.	SHEET
-------	----------	-------

3612101013 REV 09/13-05-83

QUALITY ASSURANCE PROVISION (QAP)

(DARCOM - R 702 - 10)

1. COMMAND AGENCY

**U.S. ARMY ARMAMENT R, D & E CENTER
PICATINNY ARSENAL, N J 07806 - 5000**

2. THESE QAPS FORM PART OF DRAWING / SPECIFICATION

9348202

AS SPECIFIED IN THE CONTRACT.

INSPECTION SHALL BE CONDUCTED AS SPECIFIED HEREIN AND IN ACCORDANCE WITH REFERENCED DOCUMENTS.

UNLESS OTHERWISE SPECIFIED HEREIN OR IN THE CONTRACT , THE PROVISION OF MIL - W - 63150 SHALL APPLY AND ARE MADE A PART OF THIS DETAIL QAP.

PART I LIST OF APPLICABLE DOCUMENTS

LIST OF DRAWINGS

NOMENCLATURE

NUMBER

9348202	Receiver	(Inspection Position P)
9348203	Body, Receiver	(Inspection Position A)
9348204	Support, Barrel	(Inspection Position B)
9348205	Support, Gas Cylinder	(Investment Cast)
		(Inspection Position C)
9348206	Bushing, Front	(Inspection Position D)
9348207	Support, Trigger Frame	(Inspection Position E)
9348213	Body, Magazine Sleeve	(Inspection Position K)
9348214	Bushing, Magazine Sleeve	(Inspection Position L)
9348215	Support, Feed Box	(Inspection Position N)
9348208	Guide, Cocking Handle	(Inspection Position F)
9348209	Guide, Slide, Left	(Inspection Position G)
9348210	Guide, Slide, Right	(Inspection Position H)
9348211	Block, Rear	(Inspection Position J)
9348212	Sleeve Assembly, Magazine	(Inspection Position M)

DISTRIBUTION STATEMENT A , UNLIMITED

REVISIONS

4. RELEASE NUMBER	G1S2002R1	G5S2009	L7S4181												
5. DATE	921215	970516	980630												
4. RELEASE NUMBER															
5. DATE															
REVISION STATUS OF SHEETS	6. REVISION	F	F	F	F	F	F	F	F	F	F	F	F	F	F
	7. SHEET	1	2	3	4	5	6	7	8	9	10	11	12	13	14
	6. REVISION														
	7. SHEET														

8. QAP FOR:

RECEIVER : M249 M.G.

CAGE CODE

19200

9. SUBMITTED BY:

ARDEC - SMCAR - QAF - S (D)

10. QAP NO.

9348202

11. DATE

830930

12. APPROVED BY:

13. RELEASE NO

W3S2507

14. PAGE NO.

1

15. NO OF PAGES

14

QUALITY ASSURANCE PROVISION (QAP) – (CONTINUATION SHEET)
(DAR R 702 - 10)

LIST OF STANDARDS

<u>NUMBER</u>	<u>NOMENCLATURE</u>
MIL-STD-105	Sampling Procedures and Tables for Inspection by Attributes.
MIL-STD-1261	Welding Procedures for Constructional Steels
MIL-STD-2175	Casting Classification and Inspection of

LIST OF SPECIFICATIONS

<u>NUMBER</u>	<u>NOMENCLATURE</u>
QQ-C-320	Chromium Plating (Electrodeposited)
MIL-L-3150	Lubricating Oil, Preservative, Medium
MIL-C-16173	Corrosion Preventative Compound, Solvent Cutback, Cold-Application
DOD-P-16232	Phosphate coating, heavy, manganese or zinc base (for ferrous metals)
MIL-W-63150	Weapons and Support Materiel, Standard Quality Assurance Provisions for
DOD-P-63477/8-99P	Pin, Spring

LIST OF PUBLICATIONS

<u>NUMBER</u>	<u>NOMENCLATURE</u>
ASTM E 18	Standard Methods of Test for Rockwell Hardness and Rockwell Superficial Hardness of Material
ASTM B 117	Standard Method of Salt Spray (Fog) Testing
ASTM-E-1444	Standard Practice For Magnetic Particle Examination

						CAGE CODE 19200
76. REVISION SYMBOL AND DATE	C , 921215	D , 950614	E , 970516	F , 980630		10. QAP NO. 9348202
						14. PAGE NO. 2

QUALITY ASSURANCE PROVISION (QAP) - (CONTINUATION SHEET)
(DAR R 702 - 10)

PART II QUALITY PROVISIONS

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

2. First Article Inspection.
 - 2.1 Unless otherwise specified, a first article sampling consisting of five (5) items shall be submitted for inspection and approval in accordance with the terms of the contract. As determined by the Government, the sample items may be subjected to any or all of the examinations and tests specified in this QAP and be inspected for compliance with any of the requirements.

 - 2.2 Rejection. If any sample item fails to comply with any of the applicable requirements, the first article sample shall be rejected. The Government reserves the right to terminate inspection upon any failure to comply with any of the requirements.

3. Quality Conformance Inspection
 - 3.1 Quality Conformance Inspection shall consist of inspection of all characteristics contained in Part III "Inspection Requirements" and Part IV "Certification Provisions" of this QAP.
 - 3.1.1 All other quality characteristics not specifically listed herein are subject to inspection under the contractor's quality or inspection system.

					CAGE CODE 19200	
					10. QAP NO. 9348202	
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QUALITY ASSURANCE PROVISION (QAP) - (CONTINUATION SHEET)
(DAR R 702 - 10)

PART III INSPECTION REQUIREMENTS

TABLE I CLASSIFICATION OF QUALITY CONFORMANCE CHARACTERISTICS

100% examination shall be performed for critical characteristics unless otherwise stated. Examination for major and minor characteristics shall be performed in accordance with the classification of quality conformance characteristics contained herein. Inspection Level II shall be used and individual AQL's applied in accordance with MIL-STD-105.

<u>CLASS</u>	<u>CHARACTERISTICS</u>	<u>ZONE</u>	<u>AQL</u>	<u>INSPECTION METHOD</u>
--------------	------------------------	-------------	------------	--------------------------

INSPECTION POSITION A: BODY, RECEIVER - DWG - 9348203

CRITICAL: NONE

MAJOR:

101	Profile (0.4) of 37.94, 45 Degree	C-6	Sht.4 0.65	SMTE
102	Inside Width 26.75 , in area "X"	D-7	Sht.1 0.65	SMTE

MINOR:

201	Profile (0.3) of 68.25	B-4	Sht.3 1.5	SMTE
202	Profile (0.4) of 11.10	B-3	Sht.3 1.5	SMTE
203	Profile (0.4) of 239.15	B-3	Sht.3 1.5	SMTE
204	Profile (0.2) of 72.65	C-4	Sht.3 1.5	SMTE
205	Location (11.8 and 4.5) of Edge, Magazine Cutout	B-4, C-4	Sht.4 1.5	SMTE
206	Position (0.3) of 42.75	D-3	Sht.3 1.5	SMTE
207	Profile (0.4) of 249.3	F-8	Sht.3 1.5	SMTE
208	Profile (0.2) of 97.5	F-6, F-7	Sht.3 1.5	SMTE
209	All Markings Present and Proper		1.5	VISUAL
210	Profile (0.3) of 15.1	C-3	Sht.4 1.5	SMTE

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QUALITY ASSURANCE PROVISION (QAP) - (CONTINUATION SHEET)
(DAR R 702 - 10)

211	Profile (0.3) of 7.925, in Area "Z" 2 Places		B-7	Sht.1	1.5	SMTE
212	Profile (0.2) Inside Area "Y", 2 Places	A-6,	A-7	Sht.1	1.5	SMTE
213	Profile (0.43) of 48.185, 2 Places	C-7,	C-8	Sht.1	1.5	SMTE
214	Thickness (1.75) of Receiver in Area W		F-7	Sht.2	1.5	SMTE
215	Profile (0.2) of 36.96, 2 Places		NOTE 2			
216	Width 16.0		C-7	Sht.1	1.5	SMTE
217	Length 99.0	B-2,	B-3	Sht.1	1.5	SMTE
218	Profile (0.2) of 8.3	C-4,	C-5	Sht.1	1.5	SMTE
219	Position (0.1) of 23.9 Width	C-2,	C-3	Sht.1	1.5	SMTE
220	Straightness (0.12) , In Area U & V		C-8	Sht.2	1.5	SMTE
221	Length 20.00	E-1,	E-3	Sht.1		
222	Position (0.2) of Diameter 6.2 , (8.5)		C-3	Sht.1	1.5	SMTE
223	Length 24.0	C-4,	C-5	Sht.1	1.5	SMTE
224	Position (0.1) of 14.30 Width		D-4	Sht.1	1.5	SMTE
225	Height of 10.0		B-1	Sht.1	1.5	SMTE
226	Height of 5.5		C-1	Sht.2	1.5	SMTE
227	Width 6.0	C-2	Sht.2	1.5	SMTE	
228	Depth of 2.55	B-2,	B-3	Sht.2	1.5	SMTE
229	Workmanship (see MIL-W-63150)		C-1	Sht.1	1.5	SMTE
					2.5	VISUAL

INSPECTION POSITION B: SUPPORT, BARREL - DWG - 9348204

CRITICAL: NONE

MAJOR:

101	Diameter (23.50) of Gas Cylinder Hole		D-8	Sht.2	0.65	SMTE
102	Position of Gas Cylinder Hole		D-8	Sht.2	0.65	SMTE
103	Profile (0.2) of Radius 17.2		D-1	Sht.1	0.65	SMTE
104	Width (20.20)		B-2/3	Sht.1	0.65	SMTE
105	Position of 20.20 Width		B-2/3	Sht.1	0.65	SMTE
106	Diameter 5.035 of Barrel Latch Pivot Hole		D-5	Sht.1	0.65	SMTE
107	Position of 5.035 (5.95 & 45.85)	C-5,	D-5	Sht.1	0.65	SMTE
108	Length 26.05 , in Area "Z"		D-6	Sht.2	0.65	SMTE
109	Perpendicularity of Datum -C-		B-5	Sht.1	0.65	SMTE
110	Diameter 38.80 of Barrel Hole		F-8	Sht.2	0.65	SMTE
111	Position of Barrel Hole Diameter		F-8	Sht.2	0.65	SMTE

CAGE CODE
19200

16.
REVISION
SYMBOL
AND DATE

C , 921215

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QUALITY ASSURANCE PROVISION (QAP) - (CONTINUATION SHEET)
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MINOR:

201	Width 20.00	D-7	Sht.1	1.5	SMTE
202	Position of 20.0 Width	D-7	Sht.1	1.5	SMTE
203	Profile (0.4) of 25.25	B-3	Sht.2	1.5	SMTE
204	Profile (0.24) of 76.8	B-4	Sht.1	1.5	SMTE
205	Profile (0.23) of 33.0	C-2	Sht.2	1.5	SMTE
206	Width 26.45	B-5	Sht.2	1.5	SMTE
207	Diameter 3.15 of Pin Hole	C-1	Sht.1	1.5	SMTE
208	Position of 3.15 Diameter Pin Hole	C-1	Sht.1	1.5	SMTE
209	Profile (0.43) of 78.375	C-4	Sht.2	1.5	SMTE
210	Profile (0.23) of 31.5 , 2 Places	B-6	Sht.2	1.5	SMTE
211	Workmanship (see MIL-W-63150)			2.5	VISUAL

INSPECTION POSITION C: SUPPORT, GAS CYLINDER - DWG -9348205

CRITICAL: NONE

MAJOR:

101	Diameter 27.10 of Gas Cylinder Hole	D-4	Sht.2	0.65	SMTE
102	Position of 27.10 Diameter	D-4	Sht.2	0.65	SMTE
103	Outside Diameter 31.60 of Gas Cylinder Hole	E-6	Sht.1	0.65	SMTE

MINOR:

201	Profile (0.2) of 7.3	D-6	Sht.1	1.5	SMTE
202	Position of 31.60 , Outside Diameter of Gas Cylinder	E-6	Sht.1	1.5	SMTE
203	Min Wall Thickness (1.46) , in Area "Y"	E-4	Sht.2	1.5	SMTE
204	Width 3.93	E-4	Sht.2	1.5	SMTE
205	Length 17.78 from -D-	F-4	Sht.2	1.5	SMTE
206	Diameter 8.04 of Retaining Pin Hole	D-2	Sht.2	1.5	SMTE
207	Position of 8.04 Diameter, Retaining Pin Hole	D-2	Sht.2	1.5	SMTE
208	Width 24.10 of Flats	B-7	Sht.1	1.5	SMTE
209	Position of 24.10 Flats	B-7	Sht.1	1.5	SMTE
210	Width 33.57	B-7	Sht.1	1.5	SMTE
211	Surface Roughness	F-6	Sht.1	1.5	SMTE
212	Workmanship			2.5	VISUAL

						CAGE CODE 19200	
16. REVISION SYMBOL AND DATE	C , 921215	D , 950614	E , 970516	F , 980630		10. QAP NO: 9348202	
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QUALITY ASSURANCE PROVISION (QAP) - (CONTINUATION SHEET)
(DAR R 702 - 10)

INSPECTION POSITION D: BUSHING, FRONT - DWG 9348206

CRITICAL: NONE

MAJOR:

101	Diameter 13.035	C-1	0.65	SMTE
102	Diameter 23.88 , 2 Places	C-3	0.65	SMTE

MINOR:

201	Diameter 16.0	D-3	1.5	SMTE
202	Diameter 29.98	C-4	1.5	SMTE
203	Length 45.90	B-3	1.5	SMTE
204	Surface Roughness	C-1	1.5	SMTE
205	Workmanship (See MIL-W-63150)		2.5	VISUAL

INSPECTION POSITION E: SUPPORT, TRIGGER FRAME - DWG - 9348207

CRITICAL: NONE

MAJOR:

101	Diameter 11.3 of Holes , 2 Places	B-2	0.65	SMTE
102	Position of Holes , 2 Places	B-2	0.65	SMTE
103	Width 23.24 between Legs	B-8	0.65	SMTE

MINOR:

201	Thickness 3.93 of Cross Member	B-3	1.5	SMTE
202	Length 30.0	C-3	1.5	SMTE
203	Width 36.32	B-7	1.5	SMTE
204	Workmanship (See MIL-W-63150)		2.5	VISUAL

INSPECTION POSITION F: GUIDE, COCKING HANDLE - DWG - 9348208

CRITICAL: NONE

MAJOR: NONE

MINOR:

201	Diameter, (3.188) Pin Holes 2 Holes	E-6	Sht.1	1.5	SMTE
202	Position (0.07) of Pin Hole	E-6	Sht.1	1.5	SMTE
203	Profile (0.2) of 3.5	E-3	Sht.2	1.5	SMTE
204	Width 13.5	F-6	Sht.2	1.5	SMTE
205	Position (0.24) of 13.5 Width	F-6	Sht.2	1.5	9350154
206	Width 2.1	E-5	Sht.2	1.5	SMTE
207	Width 9.0	F-4	Sht.2	1.5	SMTE
208	Thickness 8.4 , 2 Places	D-3	Sht.2	1.5	SMTE
209	Surface Roughness, 1.6 , 2 Places	E-5	Sht.2	1.5	SMTE
210	Workmanship (See MIL-W-63150)			2.5	VISUAL

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INSPECTION POSITION G: GUIDE, SLIDE, LEFT - DWG - 9348209

CRITICAL: NONE

MAJOR:

101	Profile (0.24) of 2.98	C-5, C-6	Sht.2	0.65	SMTE
102	Chromium Plating Thickness (0.045) in area specified	Note 7A	Sht.1	0.65	SMTE
103	Diameter 5.025	C-2	Sht.2	0.65	SMTE
104	Position of 5.025 Diameter	C-2	Sht.2	0.65	SMTE
105	Profile (0.16) of 13.55	B-3	Sht.2	0.65	SMTE
106	Profile (0.2) of 1.55	D-4	Sht.2	0.65	SMTE
107	Profile (0.22) of 8.53	B-6	Sht.1	0.65	SMTE

MINOR:

201	Profile (0.26) of 7.28	C-6	Sht.2	1.5	SMTE
202	Profile (0.2) of 11.51	B-6, B-7	Sht.2	1.5	SMTE
203	Width 3.157	C-6	Sht.2	1.5	SMTE
204	Depth 8.52 of 5.025 Diameter	B-3	Sht.2	1.5	SMTE
205	Width 1.36 of Spring Slot	E-4	Sht.2	1.5	SMTE
206	Profile (0.24) of 16.58	E-4	Sht.2	1.5	SMTE
207	Profile (0.16) of 6.64	F-5	Sht.2	1.5	SMTE
208	Profile (0.3) of 237.6	D-3	Sht.1	1.5	SMTE
209	Profile 0.25 of Datum -B- (Unrestrained)	E-6	Sht.1	1.5	SMTE
210	Profile 0.25 of Datum -A- (Unrestrained)	C-6	Sht.1	1.5	SMTE
211	Workmanship (See MIL-W-63150)			2.5	VISUAL

INSPECTION POSITION H: GUIDE, SLIDE, RIGHT - DWG - 9348210

CRITICAL: NONE

MAJOR:

101	Profile (0.22) of 3.01	B-8	Sht.1	0.65	SMTE
102	Distance 8.53	E-5	Sht.1	0.65	SMTE
103	Chromium Plating Thickness (0.035)	Note 6A	Sht.1	0.65	SMTE

MINOR:

201	Profile (0.22) of 11.5	C-8	Sht.1	1.5	SMTE
202	Profile (0.36) of 11.0	C-8	Sht.1	1.5	SMTE
203	Profile (0.3) of 237.6	E-3	Sht.1	1.5	SMTE
204	Diameter 3.1 of Hinge Hole	C-1	Sht.1	1.5	SMTE
205	Position of 3.1 Diameter	C-1	Sht.1	1.5	SMTE
206	Profile (0.45) of 124.5	C-4	Sht.1	1.5	SMTE
207	Profile 0.25 of Datum -B- (Unrestrained)	D-3	Sht.1	1.5	SMTE
208	Profile 0.25 of Datum -A- (Unrestrained)	F-3	Sht.1	1.5	SMTE
209	Workmanship (See MIL-W-63150)			2.5	VISUAL

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INSPECTION POSITION J: BLOCK, REAR - DWG - 9348211

CRITICAL: NONE

MAJOR:

101	Diameter 6.35 of Weld Holes , 4 Holes	A-5	Sht.1	0.65	SMTE
102	Position of 6.35 Diameter Weld Holes, 4 Holes	A-5	Sht.1	0.65	SMTE
103	Diameter 6.35 of Weld Holes , 4 Holes	A-7	Sht.1	0.65	SMTE
104	Position of 6.35 Diameter , Weld Holes 4 Holes	A-7	Sht.1	0.65	SMTE
105	Profile (0.2) of 7.925	E-4	Sht.1	0.65	SMTE
106	Profile (0.2) of 7.925,	C-5	Sht.1	0.65	SMTE
107	Width 37.35 , Inside Area "Z"	E-4	Sht.1	0.65	SMTE
108	Profile (0.08) of 1.1 , 3.07, 12 Degrees , Both Sides	D-3,	F-4	Sht.2	0.65 SMTE

MINOR:

201	Distance 3.95 of Recess for Cover Latches, Both Sides	C-4,	E-3	Sht.2	1.5 SMTE
202	Depth 2.20 of Recess for Cover Latches, Both Sides	C-4,	E-4	Sht.2	1.5 SMTE
203	Thickness 2.97 of Legs	Note 2	Sht.1	1.5	SMTE
204	Profile (0.1) of 21.25 , 16 Degrees	E-8	Sht.1	1.5	SMTE
205	Workmanship (See MIL-W-63150)			2.5	VISUAL

INSPECTION POSITION K: BODY, MAGAZINE SLEEVE - DWG -9348213

CRITICAL: NONE

MAJOR:

101	Height 22.8 , Magazine Opening		E-5	Sht.1	0.65 SMTE
102	Length 64.76 , Magazine Opening	E-4,	E-5	Sht.1	0.65 SMTE
103	Length 60.6	F-4,	F-5	Sht.1	0.65 SMTE

MINOR:

201	Length 8.0 , Cutout for Bushing Both Sides	D-4,	D-6	Sht.1	1.5 SMTE
202	Profile (0.44) of 27.6	D-7,	D-8	Sht.2	1.5 SMTE
203	Height 4.7 of Offset Leg		B-4	Sht.1	1.5 SMTE
204	Workmanship (See MIL-W-63150)			2.5	VISUAL

INSPECTION POSITION L: BUSHING, MAGAZINE SLEEVE - DWG 9348214

CRITICAL: NONE

MAJOR: NONE

MINOR:

201	Outside Diameter 7.70	C-2		1.5	SMTE
202	Inside Diameter 3.10		B-2	1.5	SMTE
203	Length 15.75		B-3	1.5	SMTE
204	Workmanship (See MIL-W-63150)			2.5	VISUAL

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INSPECTION POSITION M: MAGAZINE SLEEVE ASSEMBLY - DWG - 9348212

CRITICAL: NONE

MAJOR:

All Components Present, Correct,
and Properly Assembled

0.65 VISUAL

MINOR:

201	Height 22.95 , 2 Places	B-6	1.5	SMTE
202	Location 12.75	C-5	1.5	SMTE
203	Width 39.40 Between Bushings	C-4, C-5	1.5	SMTE
204	Profile (0.45) to Datums	D-4	1.5	SMTE
205	Position of 3.1 Diameter	C-6	1.5	SMTE
206	Workmanship (See MIL-W-63150)		2.5	VISUAL

INSPECTION POSITION N: SUPPORT, FEED BOX - DWG - 9348215

CRITICAL: NONE

MAJOR: NONE

MINOR:

201	Profile (0.65) of 5.17 Height	D-3 Sht.1	1.5	SMTE
202	Angularity (0.1) of 4.0 , 45 Degrees 2 Places	B-3, D-3 Sht.2	1.5	SMTE
203	Length 7.95 of Legs , 2 Places	C-2, E-4 Sht.2	1.5	SMTE
204	Thickness 1.75	NOTE 2	1.5	SMTE
205	Workmanship (See MIL-W-63150)		2.5	VISUAL

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INSPECTION POSITION P: RECEIVER - DWG - 9348202

CRITICAL: NONE

MAJOR:

101	Profile (0.6) of 237.2	B-7	Sht.1	0.65	12923173
102	Width (19.6) Between Rails	E-2	Sht.1	0.65	9350156 / SMTE
103	Position (1.0) of Datum -J-, 18.39 , 27	B-7	Sht.1	0.65	12923173 / 12923088
104	Profile (0.46) of 28.225 in Area "S"	F-1	Sht.1	0.65	12923102
105	Position (0.4) of 121.11 , (Ø 11.3)	B-4	Sht.1	0.65	12923102
106	Functional Condition of Holes to Backface of Rear Block	NOTE 9		0.65	12923101
107	Diameter (8.050) thru, Lower Holes	D-8	Sht.3	0.65	SMTE
108	Position (Ø 0.4 , Ø 0) of Diameter 8.050 , Lower Holes	D-8	Sht.3	0.65	12923102 / SMTE
109	Diameter (8.050) thru, Upper Holes	E-8	Sht.3	0.65	SMTE
110	Profile (0.4) of 3.0 , Entire Length	B-8	Sht.3	0.65	12923166 / 9350156
111	Profile (0.5) of Datum -A-, in Area " H "	B-5	Sht.3	0.65	12923166 / 9350156
112	Position (0.3) of Diameter 3.005 , 40.84, in Area "Z"	C-4	Sht.3	0.65	12923102
113	Profile (0.5) of 12.35 , in Area "Y"	D-6	Sht.4	0.65	12923175
114	Profile (0.2) of 26.05	F-3	Sht.4	0.65	12923166
115	Profile (0.4) of 261.35 , 2 places	D-2	Sht.1	0.65	12923102
116	Functional Condition Between Guides	Note 8		0.65	9350156
117	Width 22.55 Min , in Area "X" of (22.80)	B-4	Sht.3	0.65	12923171
118	Profile (0.6) of 16.962	B-5	Sht.3	0.65	SMTE
119	Profile (0.4) of 41.91, in Area " L "	D-5	Sht.2	0.65	SMTE
120	Salt Spray				See 505
121	Coating Weight				See 506
123	Supplemental Oil				See 507
124	All Components Present & Properly Assembled			0.65	VISUAL

MINOR:

201	Position (0.3) of Diameter 13.035, R282.08	B-5	Sht.1	1.5	9350155
202	Diameter (6.035)	D-4	Sht.1	1.5	SMTE
203	Position (0.16) of Diameter 6.035, 26	C-5	Sht.1	1.5	12923166
204	Profile (0.6) of 26.33, in Area " M "2 Places	D-1	Sht.1	1.5	12923102
205	Profile (0.6) of 22.0	E-5	Sht.1	1.5	12923102
206	Width (24.40)	D-8	Sht.2	1.5	SMTE
207	Position (0.17) of Datum -L-	B-5	Sht.2	1.5	12923170
208	Position (Ø 0.08) of Diameter 8.050 , Upper Holes	E-8	Sht.3	1.5	12923168 / SMTE
209	Profile (0.6) of 18.0 , in Area " J "	B-3	Sht.2	1.5	12923102
210	Profile (0.4) of 37.66 , in Area " K "	D-5	Sht.3	1.5	12923102
211	Angularity (0.2) of 37.66 in Area " K "	D-5	Sht.3	1.5	SMTE
212	Profile (0.27) of 0.06 , in Area " N "	D-5	Sht.1	1.5	12923172
213	Width (32.75)	F-4	Sht.4	1.5	SMTE
214	Profile (0.6) of Datum -A-, Outside Area "H"	B-5	Sht 3	1.5	12923166
215	Protective Finish			1.5	VISUAL
216	Workmanship (See MIL-W-83150)			2.5	VISUAL

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TABLE II SPECIAL SAMPLING INSPECTION

Dimensional control of cast parts. In place of the normal sampling associated with the Classification of Defects, and with the approval of the Contracting Officer, a sample of at least ten (10) parts (as cast) from each cavity shall be dimensionally inspected to qualify a new or reworked cavity for use in production or as a control of the cavity during production. In addition, a random sample of five (5) parts from each cavity after production of 5,000 consecutive parts from each cavity shall be selected for dimensional inspection as a control of the cavity during production. Individual cavity identification shall be provided.

If any defective parts are found during qualification of the cavity, the cavity producing the defective part will not be used in production. If any defective parts are found when inspection is performed for control of the cavity, the cavity producing the defective part shall be removed from production. Further, that portion of production since the last control check shall be returned to the contractor for corrective action.

All cavities formerly removed from production because of some fault may, after reworking, be returned to production providing they pass the qualification test specified above. The contractor may request a change of inspection frequency providing he presents objective evidence to substantiate the request to the Contracting Officer.

NOTE: This casting inspection does not apply to characteristics which are defined as "Critical"; characteristics which are created by machining; characteristics which are visually inspected; and characteristics for surface finish.

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PART IV CERTIFICATION PROVISIONS

Certified test reports in accordance with the provisions of MIL-W-63150 are required for the following:

<u>NUMBER</u>	<u>CHARACTERISTIC</u>	<u>TEST DATA TO COMPLY WITH</u>
401	Material	9348203 9348204 9348205 9348206 9348207 9348208 9348209 9348210 9348211 9348213 9348214 9348215
402	Heat Treatment	9348204 9348205 9348209 9348210
403	Hardness	9348204 9348205 9348209 9348210
	Case Depth Hardness	9348204
404	Protective Finish	9348202
405	Magnetic Particle Inspection	9348202 / Note 6
406	Welding	9348202 and MIL-STD-1261 9348212 and MIL-STD-1261 9348213 and MIL-STD-1261
407	Investment Casting Inspection Class 2, Grade B	9348205/ MIL-STD-2175
408	Direction of Grain	9348203
409	Chromium Plating Adhesion	9348209 / QQ-C-320 9348210 / QQ-C-320
410	Pin, Spring	DOD-P-63477/8-99P/CTR

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PART V TEST METHODS AND PROCEDURES

501 Characteristics Major 101 through 113 of position '0' shall be inspected before painting.

502 The contractor shall perform the magnetic particle inspection after the product has been prepared according to MIL-I-6868.

503 **HARDNESS**

Five samples shall be selected from each heat treatment batch. Testing shall be in accordance with ASTM E18. Each heat treatment batch shall remain segregated until all tests are completed. If any sample fails to comply with the hardness requirements, it shall be classified as defective and the lot shall be rejected. A heat treatment batch is defined as parts that have been heat treated at the same time in the same furnace and quench bath for all phases of the heat treatment process.

504 **CASE DEPTH HARDNESS**

Three (3) samples shall be selected from each day's production from each carburizing furnace or salt pot used. Each sample shall be cut perpendicular to the cased surface and the cut surface shall then be prepared by grinding or rough polishing to remove the effects of the original cut. Etching will be done with a weak solution (1-10%) Nitric acid in alcohol and of sufficient time to develop a contrast in case and core structure. The depth of case shall be the total distance of penetration from the surface to the nearest point of uniform core structure as measured on a polished and etched specimen at a magnification not lower than 10 diameters. If any sample fails to comply with the specified requirements, it shall be classed defective and the lot shall be rejected.

505 **SALT SPRAY TEST**

Five (5) parts shall be selected from each lot. The test shall be performed as specified in DOD-P-16232 and ASTM B 117 without the supplemental oil. Test procedures and equipment shall have the prior approval of the Government. If any part shows evidence of corrosion, it shall be classified as defective and the entire lot shall be rejected.

506 **COATING WEIGHT**

Five (5) samples or five test panels shall be selected from each lot. The test shall be performed as specified in DOD-P-16232. Test procedures and equipment shall have the prior approval of the Government. If any sample does not meet the requirement of DOD-P-16232, it shall be classified as defective and the lot shall be rejected.

507 **SUPPLEMENTAL OIL TREATMENT SALT SPRAY**

The test shall be performed for first article and at least semi-monthly during production. Three test panels from each processing tank or dispenser shall be prepared and tested in accordance with MIL-L-3150 or MIL-C-16173 (as applicable) and ASTM B117 using a 5% salt solution. The test duration and accept/reject criteria shall be as specified in the applicable specification. If any test panel fails to meet the applicable requirement, all items processed since the last acceptable test shall be rejected.

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