

APPLICATION		REVISIONS				
NEXT ASSY	USED ON	MODEL REV	DRAWING REV	DESCRIPTION	DATE(YEAR-MO-DA)	APPROVED
	ACCESSORIES	B	B	REDRAWN WITH CHANGE NOR L05S3025 / 2005-06-13	2005-08-10	RJC
	AND COMPONENTS					
	WEAPON SYSTEM					

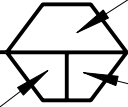
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REV STATUS OF SHEETS	REV	B	B	B	B	B
	SHEET	1	2	3	4	5
	REV	B	B	B	B	
	SHEET	6	7	8	9	

1. SPEC MIL-STD-1916 APPLIES.
2. QUALITY ASSURANCE PROVISIONS:
 - A. UNLESS OTHERWISE SPECIFIED IN THE CONTRACT THE CONTRACTOR IS RESPONSIBLE FOR THE PERFORMANCE OF ALL INSPECTION REQUIREMENTS SPECIFIED HEREIN AND APPLICABLE DRAWING(S).

B. CLASSIFICATION OF CHARACTERISTICS AND INSPECTION REQUIREMENTS ARE IDENTIFIED ON EACH PRODUCT DRAWING AS FOLLOWS:

REFERENCE TO GAGE P/N OR DESCRIPTION OF CHARACTERISTIC (WHEN REQUIRED)



- CHARACTERISTIC NUMBER
- 1 THRU 99 -CRITICAL
 - 101 THRU 199 -MAJOR
 - 201 THRU 299 -MINOR
 - 301 THRU 399 -SPECIAL SAMPLING REQUIREMENTS
 - 401 THRU 499 -CERTIFICATION REQUIREMENTS
 - 501 THRU 599 -TEST METHODS AND PROCEDURES

- METHOD OF INSPECTION
- C -STANDARD MEASUREMENT & TEST EQUIPMENT
 - S -SPECIAL TEST EQUIPMENT
 - V -VISUAL
 - W -CERTIFICATE OF COMPLIANCE
 - Y -CERTIFIED TEST REPORT
 - Z -TEST METHOD AND PROCEDURES

VERIFICATION LEVEL PER MIL-STD-1916 WHEN NO SAMPLING IS ALLOWED 100% INSPECTION IS PERFORMED AND THE VERIFICATION LEVEL IS INDICATED AS "0"

DISTRIBUTION STATEMENT A:
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PART NO. 12993884

DO NOT SCALE DRAWING	CONTRACT NUMBER		DESIGN ACTIVITY		
	CONTRACTOR		US ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER PICATINNY ARSENAL, NEW JERSEY 07806-5000		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCE ON ANGLES ± ° 2 PLACE DECIMALS ± 3 PLACE DECIMALS ±	DRAWN BY	DATE (YEAR-MO-DA)	GENERAL REQUIREMENTS FOR QUALITY ASSURANCE PROVISIONS (SMALL CALIBER WEAPON SYS)		
	N. PINEDA	2000-06-14			
CHECKER	ENGINEER				
L. CICHUKI					
THIRD ANGLE PROJECTION	ENGINEER	QUALITY ENGINEER	SIZE	CAGE CODE	DWG NO.
	L. CICHUKI	L. CICHUKI	A	19200	12993884
MATL ENGR	MODELED BY	DESIGN APPROVAL	SCALE	UNIT WT.	SHEET
	N. PINEDA	R. DELICKER			1 OF 9
		2001-02-07			

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- C. SAMPLING INSPECTION SHALL BE IN ACCORDANCE WITH MIL-STD-1916 UNLESS OTHERWISE SPECIFIED. ALTERNATIVE QUALITY CONFORMANCE PROVISIONS, SUCH AS STATISTICAL PROCESS CONTROL, VARIABLE OR CONTINUOUS SAMPLING PLANS, MAY BE USED BY THE CONTRACTOR IN LIEU OF THE INSPECTION PROVISIONS CONTAINED HEREIN WHEN SUCH ALTERNATIVE(S) PROVIDE AN EQUIVALENT OR BETTER LEVEL OF QUALITY ASSURANCE AND PROVIDED THEY HAVE BEEN APPROVED BY THE GOVERNMENT. ALL APPROVED ALTERNATIVE QUALITY CONFORMANCE PROVISIONS SHALL BE INCORPORATED INTO THE CONTRACTOR(S) QUALITY PROGRAM OR INSPECTION SYSTEM.
- D. A FIRST ARTICLE SAMPLE(S) IS REQUIRED UTILIZING FIVE (5) SAMPLES WHEN SPECIFIED IN THE CONTRACT. ACCEPTANCE WILL BE BASED ON CONFORMANCE TO THE REQUIREMENTS OF THIS DRAWING, AND APPLICABLE PRODUCT DRAWING(S).
- E. QUALITY CONFORMANCE INSPECTION SHALL CONSIST OF 100% INSPECTION OF THOSE CHARACTERISTICS CLASSIFIED AS CRITICAL. MAJOR, MINOR, CERTIFICATES OF CONFORMANCE (COC), CERTIFIED TEST REPORTS (CTR) AND TEST METHODS AND PROCEDURES ARE REQUIRED AS SPECIFIED ON EACH APPLICABLE DRAWING.
- F. ALL OTHER CHARACTERISTICS NOT SPECIFICALLY IDENTIFIED FOR INSPECTION ARE SUBJECT TO CONTROL UNDER THE CONTRACTORS QUALITY PROGRAM OR INSPECTION SYSTEM.

PART NO. 12993884

DESIGN ACTIVITY **US ARMY**
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GENERAL REQUIREMENTS
 FOR QUALITY ASSURANCE
 PROVISIONS (SMALL CALIBER WEAPON SYS)

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SIZE A	CAGE CODE 19200	DWG NO. 12993884
SCALE 1/1	UNIT WT.	SHEET 2 OF 9

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G. WORKMANSHIP:

IN ADDITION TO REQUIREMENTS OF APPLICABLE WEAPONS SPECIFICATION, PARTS, ASSEMBLIES, SUBSYSTEMS AND SYSTEMS SHALL BE VISUALLY EXAMINED TO DETERMINE COMPLIANCE WITH THE FOLLOWING REQUIREMENTS: THE QUALITY OF WORKMANSHIP SHALL NOT ADVERSELY AFFECT SAFETY, FUNCTION, PERFORMANCE, SERVICEABILITY, INTERCHANGEABILITY, AND APPEARANCE. COMPLETED PARTS AND ASSEMBLIES SHALL NOT EXHIBIT DEFECTIVE MATERIAL OR PROCESSING SUCH AS SEAMS, LAPS, LAMINATIONS, CRACKS, FINS, EXTRANEIOUS MATERIAL, VISIBLE STEPS OR IRREGULARITIES, SHARP EDGES, NICKS, SCRATCHES, BURRS, TOOL SCORES AND GOUGES, DEFORMATIONS, MISSION OPERATIONS, IMPROPER ASSEMBLY, MISSING PARTS, STAINS, CORROSION, NONSPECIFIED OXIDATION (RUST), UNAUTHORIZED SALVAGING OPERATIONS (I.E. HAMMERING TO SHAPE, REPAIR BY WELDING, STRAIGHTENING, BENDING, ETC.), UNLESS OTHERWISE SPECIFIED.

H. CERTIFICATION PROVISIONS:

IF REQUIRED ON THE PRODUCT DRAWING, CERTIFIED TEST REPORTS IN ACCORDANCE WITH PARAGRAPH 2.1 SHALL BE PROVIDED FOR THE FOLLOWING:

MATERIAL
HEAT TREATMENT
HARDNESS
PROTECTIVE FINISH
INVESTMENT CASTINGS
FORGINGS
WELDMENTS
PROOF FIRING
MAGNETIC PARTICLE INSPECTION

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I. CERTIFIED TEST REPORT (CTR): THE CONTRACTOR SHALL MAKE AVAILABLE TO THE GOVERNMENT A CTR FOR EACH LOT OF PARTS, ASSEMBLIES, SUBSYSTEMS AND SYSTEMS BY LOT NUMBER PRIOR TO ACCEPTANCE. THIS TEST REPORT IS IN ADDITION TO, AND NOT IN LIEU OF, ANY RIGHTS OF THE GOVERNMENT UNDER THIS CONTRACT OR LAW. A CTR MAY BE USED AS AN ELEMENT INCIDENT TO, BUT SHALL NOT BE USED AS THE SOLE BASIS FOR GOVERNMENT ACCEPTANCE OF THE CONTRACT ITEM(S) UNLESS SO INDICATED IN THE TECHNICAL DOCUMENTATION OR CONTRACT. AS A MINIMUM, THE REPORT SHALL CONTAIN THE FOLLOWING:

- 1) NAME OF COMPANY AND DATE.
- 2) CONTRACT NUMBER OR PURCHASE ORDER NUMBER, NATIONAL STOCK NUMBER, AND DRAWING NUMBER.
- 3) COMPLETE NOMENCLATURE OF SUPPLIES TOGETHER WITH LOT NUMBER OR OTHER IDENTIFICATION. THE QUANTITY IN EACH LOT OR SHIPMENT SHALL BE GIVEN.
- 4) ALL INSPECTIONS AND TESTS REQUIRED BY CONTRACT (I.E., MATERIAL, PROCESSES, PERFORMANCE, FUNCTIONAL, ETC.) SHALL BE RECORDED IN TEST REPORTS. THESE REPORTS SHALL IDENTIFY EACH LOT SUBMITTED FOR ACCEPTANCE BY LOT NUMBER. THE SPECIFICATION OR DRAWING, REVISION AND DATE, GRADE OR TYPE AS APPLICABLE, NUMBER OF SPECIMENS TESTED, SPECIFIED CHARACTERISTICS AND REQUIREMENTS, AND ACTUAL RESULTS OBTAINED.
- 5) REPORTS OR RAW MATERIAL PRODUCER'S CHEMICAL, MECHANICAL, AND PHYSICAL ANALYSES.
- 6) A STATEMENT AS FOLLOWS CERTIFYING THAT MATERIAL MEETS ALL REQUIREMENTS OF THE CONTRACT:
"THE UNDERSIGNED, INDIVIDUALLY, AND AS THE AUTHORIZED REPRESENTATIVE OF THE CONTRACTOR, WARRANTS AND REPRESENTS THAT ALL THE INFORMATION SUPPLIED ABOVE IS TRUE AND ACCURATE. THE MATERIAL COVERED BY THIS CERTIFICATE CONFORMS TO ALL CONTRACT REQUIREMENTS (INCLUDING BUT NOT LIMITED TO THE DRAWINGS AND SPECIFICATIONS): THE INSPECTION TEST RESULTS AND THE ANALYSES APPEARING HEREIN ARE TRUE AND ACCURATE; AND THIS CERTIFICATE IS MADE FOR THE PURPOSE OF INDUCING PAYMENT AND WITH KNOWLEDGE THAT THE INFORMATION AND CERTIFICATION MAY BE USED AS A BASIS FOR PAYMENT."
- 7) SIGNATURE AND TITLE OF CERTIFYING OFFICIAL.

PART NO. 12993884

DESIGN ACTIVITY US ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

GENERAL REQUIREMENTS
FOR QUALITY ASSURANCE
PROVISIONS (SMALL CALIBER WEAPON SYS)

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SIZE A	CAGE CODE 19200	DWG NO. 12993884
SCALE 1/1	UNIT WT.	SHEET 4 OF 9

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J. CERTIFICATE OF CONFORMANCE (COC): A CERTIFICATE OF CONFORMANCE IS REQUIRED FOR MILITARY STANDARD AND COMMERCIAL ITEMS, SUPPORTED BY INSPECTION AND TEST DATA, MATERIAL ANALYSIS, OR CERTIFICATION FROM THE RAW MATERIAL PRODUCER OR PROCESSOR, AND SHALL BE MADE AVAILABLE TO THE GOVERNMENT FOR SPECIFICATIONS COVERING RAW MATERIAL, PROCESSED MATERIAL, AND PROCESSES. THE CONTRACTOR SHALL MAKE THE COC AVAILABLE TO THE GOVERNMENT PRIOR TO OR WITH THE REQUEST TO PERFORM ACCEPTANCE INSPECTION APPROVAL BY THE GOVERNMENT. THIS IS IN ADDITION TO, AND NOT IN LIEU OF, ANY RIGHTS OF THE GOVERNMENT UNDER THIS CONTRACT OR LAW. A COC MAY USED AS AN ELEMENT INCIDENT TO, BUT SHALL NOT BE USED AS THE SOLE BASIS FOR, GOVERNMENT ACCEPTANCE OF CONTRACT ITEM(S) UNLESS SO INDICATED IN THE TECHNICAL DOCUMENTATION OR CONTRACT. AS A MINIMUM, THE COC SHALL CONTAIN THE FOLLOWING:

- 1) NAME OF COMPANY AND DATE.
- 2) CONTRACT NUMBER OR PURCHASE ORDER NUMBER, NATIONAL STOCK NUMBER AND DRAWING NUMBER.
- 3) COMPLETE NOMENCLATURE OF SUPPLIES TOGETHER WITH LOT NUMBER OR OTHER IDENTIFICATION. THE QUANTITY IN EACH LOT OR SHIPMENT SHALL BE GIVEN.
- 4) A STATEMENT, AS FOLLOWS, CERTIFYING THAT MATERIAL MEETS ALL REQUIREMENTS OF THE CONTRACT:
"THE UNDERSIGNED, INDIVIDUALLY, AND AS THE AUTHORIZED REPRESENTATIVE OF THE CONTRACTOR, WARRANTS AND REPRESENTS THAT: ALL THE INFORMATION SUPPLIED ABOVE IS TRUE AND ACCURATE; THE MATERIAL COVERED BY THIS CERTIFICATE CONFORMS TO ALL CONTRACT REQUIREMENTS (INCLUDING BUT NOT LIMITED TO THE DRAWINGS AND SPECIFICATIONS); THE ANALYSES APPEARING HEREIN ARE TRUE AND ACCURATE ANALYSES; AND THIS CERTIFICATE IS MADE FOR THE PURPOSE OF INDUCING PAYMENT AND WITH KNOWLEDGE THAT THE INFORMATION AND CERTIFICATION MY BE USED AS A BASIS FOR SUCH PAYMENT.
- 5) SIGNATURE AND TITLE OF CERTIFYING OFFICIAL.

K. WHERE SPECIAL TEST EQUIPMENT IS IDENTIFIED FOR A CHARACTERISTIC THE CONTRACTOR SHALL USE EQUIPMENT CONFORMING TO THAT LISTED UNLESS AN ALTERNATE IS APPROVED BY THE GOVERNMENT.

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GENERAL REQUIREMENTS
FOR QUALITY ASSURANCE
PROVISIONS (SMALL CALIBER WEAPON SYS)

SIZE A	CAGE CODE 19200	DWG NO. 12993884
SCALE 1/1	UNIT WT.	SHEET 5 OF 9

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L. SPECIAL TEST METHODS (STM) AND PROCEDURES. THE FOLLOWING TEST METHODS AND PROCEDURES APPLY IF REQUIRED ON THE APPLICABLE PRODUCT DRAWING:

- 501 - HARDNESS: FIVE (5) SAMPLES SHALL BE SELECTED FROM EACH HEAT TREAT 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 THE PHASES OF THE HEAT TREATMENT PROCESS.
- 502 - SALT SPRAY TEST: FIVE (5) PARTS SHALL BE SELECTED FROM EACH LOT. THE TEST SHALL BE PERFORMED AS SPECIFIED IN MIL-DTL-16232 OR MIL-A-8625, AS APPLICABLE AND ASTM B117 WITHOUT SUPPLEMENTARY OIL. PHOSPHATE 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.
- 503 - COATING WEIGHT: FIVE (5) SAMPLES OR FIVE (5) TEST PANELS SHALL BE SELECTED FROM EACH BATCH. THE TEST SHALL BE PERFORMED AS SPECIFIED IN MIL-DTL-16232 OR MIL-A-8625, AS APPLICABLE. PHOSPHATE TEST PROCEDURES AND EQUIPMENT SHALL HAVE THE PRIOR APPROVAL OF THE GOVERNMENT. IF ANY SAMPLE DOES NOT MEET THE REQUIREMENTS OF MIL-DTL-16232 OR MIL-A-8625, IT SHALL BE CLASSIFIED AS DEFECTIVE AND THE LOT SHALL BE REJECTED.
- 504 - SUPPLEMENTARY OIL TREATMENT, SALT SPRAY TEST: THE TEST SHALL BE PERFORMED FOR FIRST ARTICLE AND AT LEAST SEMI-MONTHLY DURING PRODUCTION. THREE (3) TEST PANELS FROM EACH PROCESSING TANK OR DISPENSER SHALL BE PREPARED AND TESTED IN ACCORDANCE WITH MIL-PRF-3150 OR MIL-PRF-16173 (AS APPLICABLE) AND ASTM B117 USING 5% SALT SOLUTION. THE 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.
- 505 - CASE DEPTH: 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% TO 10%) NITRIC ACID IN ALCOHOL AND SUFFICIENT TIME TO DEVELOP A CONTRAST IN CASE AND CORE STRUCTURE. UNLESS OTHERWISE SPECIFIED ON THE APPLICABLE PRODUCT DRAWING, "CASE DEPTH" IN ITS ENTIRETY SHALL REFER TO TOTAL CASE DEPTH. THE TOTAL CASE DEPTH 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 20 DIAMETERS (20X). THE EFFECTIVE CASE DEPTH, WHENEVER SPECIFIED, SHALL BE THE PERPENDICULAR DISTANCE FROM THE SURFACE TO A POINT WHERE THE HARDNESS IS EQUIVALENT TO ROCKWELL C 50 AS TESTED IN ACCORDANCE WITH ASTM E 384, CONVERTED FROM MICROHARDNESS SURVEY DATA. IF ANY SAMPLE FAILS TO COMPLY WITH THE SPECIFIED REQUIREMENTS, THEN IT SHALL BE CLASSIFIED DEFECTIVE, AND THE LOT SHALL BE REJECTED.

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GENERAL REQUIREMENTS
FOR QUALITY ASSURANCE
PROVISIONS (SMALL CALIBER WEAPON SYS)

SIZE A	CAGE CODE 19200	DWG NO. 12993884
SCALE 1/1	UNIT WT.	SHEET 6 OF 9

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L. SPECIAL TEST METHODS (STM) AND PROCEDURES. (CONT.)

- 506 - PRIMER DRY FILM THICKNESS: FOUR (4) ITEMS SELECTED RANDOMLY FROM EACH LOT SHALL BE TESTED IN ACCORDANCE WITH MIL-C-53072. SHOULD ANY ITEM FAIL TO MEET THE APPLICABLE REQUIREMENT, THE QUANTITY REPRESENTED BY THE SAMPLE SHALL BE REJECTED.
- 507 - PRIMER ADHESION: FOUR (4) ITEMS SELECTED RANDOMLY FROM EACH LOT SHALL BE TESTED IN ACCORDANCE WITH MIL-C-53072. SHOULD ANY ITEM FAIL TO MEET THE APPLICABLE REQUIREMENT, THE QUANTITY REPRESENTED BY THE SAMPLE SHALL BE REJECTED.
- 508 - CARC DRY FILM THICKNESS: FOUR (4) ITEMS SELECTED RANDOMLY FROM EACH LOT SHALL BE TESTED IN ACCORDANCE WITH MIL-C-53072. SHOULD ANY ITEM FAIL TO MEET THE APPLICABLE REQUIREMENT, THE QUANTITY REPRESENTED BY THE SAMPLE SHALL BE REJECTED.
- 509 - CARC SOLVENT WIPE: FOUR (4) ITEMS SELECTED RANDOMLY FROM EACH LOT SHALL BE TESTED IN ACCORDANCE WITH MIL-C-53072. SHOULD ANY ITEM FAIL TO MEET THE APPLICABLE REQUIREMENT, THE QUANTITY REPRESENTED BY THE SAMPLE SHALL BE REJECTED.
- 510 - CARC ADHESION: FOUR (4) ITEMS SELECTED RANDOMLY FROM EACH LOT SHALL BE TESTED IN ACCORDANCE WITH MIL-C-53072. SHOULD ANY ITEM FAIL TO MEET THE APPLICABLE REQUIREMENT, THE QUANTITY REPRESENTED BY THE SAMPLE SHALL BE REJECTED.
- 511 - CARC CORROSION RESISTANCE: FOUR (4) ITEMS SELECTED RANDOMLY FROM EACH LOT SHALL BE TESTED IN ACCORDANCE WITH MIL-C-53072 AND ASTM B117. SHOULD ANY ITEM FAIL TO MEET THE APPLICABLE REQUIREMENT, THE QUANTITY REPRESENTED BY THE SAMPLE SHALL BE REJECTED.
- 512 - PROTECTIVE COATING SUPPLEMENTAL OIL TREATMENT SALT SPRAY TEST: TESTING SHALL BE ACCOMPLISHED ON A PER LOT BASIS OR PER SHIFT, I.E. AT LEAST ONCE EVERY EIGHT HOURS. FOUR (4) SPECIMENS, DISTRIBUTED RANDOMLY AND PROCESSED CONCURRENTLY WITH THE ITEMS, OR FOUR (4) ITEMS RANDOMLY SELECTED SHALL BE TESTED IN ACCORDANCE WITH MIL-DTL-16232 AND ASTM B117. THE SPECIMENS SHALL CONFORM TO MIL-DTL-16232. IF ANY ITEM/SPECIMEN IN THE SAMPLE FAILS, THE QUANTITY REPRESENTED SHALL BE REJECTED.

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GENERAL REQUIREMENTS
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SCALE 1.000	UNIT WT.	SHEET 7 OF 9

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L. SPECIAL TEST METHODS (STM) AND PROCEDURES. (CONT.)

- 513 - STRESS & HYDROGEN EMBRITTLEMENT RELIEF TEST: ADEQUACY OF THE STRESS & HYDROGEN EMBRITTLEMENT RELIEF TREATMENT SHALL BE DEMONSTRATED ON A 120 DAY INTERVAL BY TESTING ONE (1) SPECIMEN. THE COATED CYLINDRICAL TEST SPECIMEN SHALL BE MADE IN ACCORDANCE WITH MIL-DTL-16232 AND FIGURE 8 OF ASTM E8 USING 4340 STEEL OF RC 51-55 HARDNESS. THE SUSTAINED TENSILE LOAD (75% OF THE ULTIMATE TENSILE STRENGTH) SHALL BE DETERMINED FOR THE COATED SPECIMEN BY TESTING AND AVERAGING THE ULTIMATE TENSILE STRENGTH RESULTS FROM THREE (3) NOTCHED AND UNCOATED SPECIMENS FROM THE HEAT BATCH THAT THE COATED SPECIMEN WAS MADE. THE LENGTH OF THE TEST SHALL BE 200 HOURS. AFTER COMPLETION OF THE TEST, THE COATED SPECIMEN SHALL SHOW NO EVIDENCE OF CRACKS AS SPECIFIED IN MIL-DTL-16232. IF THE SPECIMEN FAILS, THE QUANTITY REPRESENTED SHALL BE REJECTED.
- 514 - CASTING INSPECTION: SAMPLING SHALL BE AS SPECIFIED IN SAE AMS-STD-2175. SHOULD ANY ITEM FAIL TO MEET THE APPLICABLE REQUIREMENTS, THE QUANTITY REPRESENTED BY THE SAMPLE SHALL BE REJECTED.
- 515 - SMUT TEST: TESTING SHALL BE ACCOMPLISHED AS DESCRIBED IN MIL-DTL-13924, PARAGRAPH 4.4.1. IF THE SPECIMEN FAILS, THE QUANTITY REPRESENTED MAY BE CAUSE FOR REJECTION. A SLIGHT AMOUNT OF SMUT WHICH IS INHERENT IN THE PROCESS IS ACCEPTABLE FOR ALL CLASSES OF COATINGS AND SHALL NOT BE CAUSE FOR REJECTION.
- 516 - CADMIUM PLATING THICKNESS: TESTING SHALL BE ACCOMPLISHED ON A PER LOT BASIS OR PER SHIFT, I.E. AT LEAST ONCE EVERY EIGHT HOURS. FOUR (4) SPECIMENS, DISTRIBUTED RANDOMLY AND PROCESSED CONCURRENTLY WITH THE ITEMS, OR FOUR (4) ITEMS RANDOMLY SELECTED SHALL BE TESTED IN ACCORDANCE WITH AMS-QQ-P-416. THE SPECIMENS SHALL CONFORM TO AMS-QQ-P-416, PARAGRAPH 4.5. IF ANY ITEM/SPECIMEN IN THE SAMPLE FAILS, THE QUANTITY REPRESENTED SHALL BE REJECTED.
- 517 - CADMIUM PLATING ADHESION: TESTING SHALL BE ACCOMPLISHED ON A PER LOT BASIS OR PER SHIFT, I.E. AT LEAST ONCE EVERY EIGHT HOURS. FOUR (4) SPECIMENS, DISTRIBUTED RANDOMLY AND PROCESSED CONCURRENTLY WITH THE ITEMS, OR FOUR (4) ITEMS RANDOMLY SELECTED SHALL BE TESTED IN ACCORDANCE WITH AMS-QQ-P-416. THE SPECIMENS SHALL CONFORM TO AMS-QQ-P-416, PARAGRAPH 4.5.1. IF ANY ITEM/SPECIMEN IN THE SAMPLE FAILS, THE QUANTITY REPRESENTED SHALL BE REJECTED.
- 518 - CADMIUM PLATING CORROSION RESISTANCE: TESTING SHALL BE ACCOMPLISHED ON A PER LOT BASIS OR PER SHIFT, I.E. AT LEAST ONCE EVERY EIGHT HOURS. FOUR (4) SPECIMENS, DISTRIBUTED RANDOMLY AND PROCESSED CONCURRENTLY WITH THE ITEMS, OR FOUR (4) ITEMS RANDOMLY SELECTED SHALL BE TESTED IN ACCORDANCE WITH AMS-QQ-P-416. THE SPECIMENS SHALL CONFORM TO AMS-QQ-P-416, PARAGRAPH 4.5.2 AND ASTM B117. IF ANY ITEM/SPECIMEN IN THE SAMPLE FAILS, THE QUANTITY REPRESENTED SHALL BE REJECTED.

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GENERAL REQUIREMENTS
FOR QUALITY ASSURANCE
PROVISIONS (SMALL CALIBER WEAPON SYS)

SIZE A	CAGE CODE 19200	DWG NO. 12993884
SCALE 1.000	UNIT WT.	SHEET 8 OF 9

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B	B	REDRAWN WITH CHANGE NOR L05S3025 / 2005-06-13	2005-08-10	RJC

L. SPECIAL TEST METHODS (STM) AND PROCEDURES. (CONT.)

519 - CADMIUM PLATING EMBRITTLEMENT RELIEF TEST: THIS TEST SHALL BE CONDUCTED AT A FREQUENCY OF 120 DAYS MAXIMUM. THE COATED CYLINDRICAL TEST SPECIMEN SHALL BE MADE IN ACCORDANCE WITH AMS-QQ-P-416 PARAGRAPH 4.5.3 AND FIGURE 8 OF ASTM E8 USING 4340 STEEL OF RC 51-55 HARDNESS. THE SUSTAINED TENSILE LOAD (75% OF THE ULTIMATE TENSILE STRENGTH) SHALL BE DETERMINED FOR THE COATED SPECIMEN BY TESTING AND AVERAGING THE ULTIMATE TENSILE STRENGTH RESULTS FROM THREE (3) NOTCHED AND UNCOATED SPECIMENS FROM THE HEAT BATCH THAT THE COATED SPECIMEN WAS MADE. THE LENGTH OF THE TEST SHALL BE 200 HOURS. AFTER COMPLETION OF THE TEST, THE COATED SPECIMEN SHALL SHOW NO EVIDENCE OF CRACKS AS SPECIFIED IN AMS-QQ-P-416. IF THE SPECIMEN FAILS, THE QUANTITY REPRESENTED SHALL BE REJECTED.

520 - MAGNETIC PARTICLE INSPECTION: THIS TEST SHALL BE CONDUCTED IN ACCORDANCE WITH ASTM E1444.

PART NO. 12993884

DESIGN ACTIVITY US ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

GENERAL REQUIREMENTS
FOR QUALITY ASSURANCE
PROVISIONS (SMALL CALIBER WEAPON SYS)

SIZE A	CAGE CODE 19200	DWG NO. 12993884
SCALE 1.000	UNIT WT.	SHEET 9 OF 9

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