

APPLICATION		REVISIONS				
NEXT ASSY	USED ON	SYM	DESCRIPTION	DATE	APPROVAL	
		-	PRODUCT BASELINE ERR M0Q2094 (ECP M0Q2095 90-11-19)	91-06-28	RR SE	
-	-	-	-	-	-	-
SHT 8	SHT 7	SHT 6	SHT 5	SHT 4	SHT 3	SHT 2
REVISION STATUS OF SHEET						
PART NO. 9280433						
ORIGINAL DATE OF DRAWING 91-06-21		DESIGN ACTIVITY U.S. ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER PICATINNY ARSENAL, NEW JERSEY 07806-5000				
DRAFTSMAN RCR	CHECKER	ENVELOPE DRAWING 105MM CARTRIDGE CASES ULTRASONIC INSPECTION				
ENGR	ENGR					
ENGR	ENGR L.T.					
<i>Syed Ali</i>		SIZE A	CAGE CODE. 19200	9280433		
<i>Dany Memie</i>		SCALE	UNIT WT	SHEET 1 OF 8		

BOOK FORM "A" SIZE

1. PURPOSES:

This envelope drawing is provided as guidance in the design, fabrication and use of ultrasonic equipment to inspect the body for the 105mm cartridge case.

2.0 APPLICABLE DRAWINGS:

Circumferential test standard for ultrasonic inspection of cartridge case. (9280435)

Longitudinal test standard for ultrasonic inspection of cartridge case. (9280434)

105mm cartridge case. (10522799)

2.1 APPLICABLE SPECIFICATIONS:

MIL-STD-454M Standard general requirements for electronic equipment.

MIL-A-70625A Automated Acceptance Inspection Equipment, Design, Testing and Approval of.

3.0 REQUIREMENTS:

3.1 The ultrasonic inspection system shall be designed to inspect the entire volume of the case shown on standard design. The notches in the standard represent the beginning and end of each inspection area. The notches provide a signal of consistent amplitude which is used to set the system's sensitivity. Any discontinuity that produces a signal larger than the level will be considered a reject.

3.2 The system shall comply with all plant, municipal, state, and national codes and safety regulations including OSHA regulations.

3.3 The system shall be able to inspect at a rate equivalent to that of the production line.

3.4 It is a design goal for the system to have a mean time between failures (MTBF) of not less than 24 hours operating time and a mean time to repair (MTTR) of not more than one hour when the system is located in the production environment.

3.5 It is a design requirement that the system be fail-safe: that is, failure of any electrical, mechanical, hydraulic or pneumatic system shall result in rejection of the item being inspected. The accept/reject mechanism should normally be in the "reject" position and require a definite "accept" signal to accept the body.

TITLE ENVELOPE DRAWING 105MM CARTRIDGE CASES ULTRASONIC INSPECTION	SIZE	CAGE CODE	DRAWING NO.	
	A	19200	9280433	
	SCALE	REVISION LEVEL	—	SHEET 2

SMCAR FORM 71, 1 JUL 87 (TEMP) REPLACES SMCAR FORM 71, 1 JUN 86(TEMP) WHICH IS OBSOLETE

BOOK FORM "A" SIZE

3.6 The inspection system shall have the capability of operating in either an automatic or manual mode. In the automatic mode the system shall automatically sequence through the complete inspection cycle which consists of loading the item into the test position, performing the inspection, unloading the test item and segregating acceptable and unacceptable items in a fail-safe manner. The accept/reject mechanism shall normally be in a reject position. To move the mechanism to the accept position an accept signal will be required at the end of the inspection cycle. In the automatic mode the system design will be such that once the inspection cycle is started, the operator will have no influence over the system operation. The emergency stop switch will be the only means of stopping the system immediately while the system is set in the automatic mode. If the emergency stop switch is activated or the machine stops due to system failure, the item(s) that have not completed the inspection cycle shall be rejected and may be retested after the cause of the stoppage has been corrected. A normal stop switch will be provided that will allow stoppage while in the automatic mode but only after all units in the system have completed the inspection cycle, regardless of when the normal stop switch is actuated the part being inspected will complete the inspection cycle. The system design shall provide for continuous operation while set in the automatic mode. That is, the system will continue to sequence through the inspection cycle provided that the next test item is in the loading position the system will complete the inspection cycle for all units in the system and will then hold until the next test item is in the loading position. When it is positioned for loading the sequencing shall automatically start again unless the stop switch has been actuated. When the system is set in the manual mode, sequencing through the inspection cycle will require switch actuation to load, inspect, unload and segregate. While in the manual mode the capability to stop the system anywhere in the inspection cycle shall be provided.

3.7 The system, while in the automatic mode, shall provide for automatic marking of the test item. The marking shall be accomplished in a fail-safe manner. While in the manual mode the system shall not provide for marking. A key switch to allow disabling of the marking device in the automatic mode shall be provided.

3.8 The system shall be designed to provide for an automated inspection cycle that, once started, will continue until the inspection is complete on an acceptable cartridge case. A selectable optional operating mode shall be provided which will automatically retest a part up to two times if a reject condition is detected during the initial inspection cycle. During the retest cycles, the part must be rejected when a defect signal is generated; the part shall be accepted if both retest cycles are free of any defect signals. If the part is to be accepted, a visual signal signifying acceptance shall be provided. If the part is to be rejected, a separated defect signal shall be provided to actuate both visual and audible alarms at the time the defect is encountered. All visual and audible alarms shall be automatically reset prior to inspection of a new body.

3.9 The inspection system shall have the capability to vary the transducer scanning speed and rotational speed. In establishing the limits for these two variables the standard notch design must be taken into consideration. The transducer scanning rate and test item rotational speed established for the inspection shall, as a minimum, provide for at least two full engagements of the sound beam with each notch during the inspection cycle. Also in the establishment of the test item rotational speed the pulse repetition rate (PRR) must be considered. The PRR selected must provide a pulse of sound at intervals of no more than .060 inches on the outer periphery of the test item. After establishment of the scanning speed, rotational speed and PRR they shall be automatically monitored during each inspection cycle.

TITLE ENVELOPE DRAWING 105MM CARTRIDGE CASES ULTRASONIC INSPECTION	SIZE A	CAGE CODE 19200	DRAWING NO. 9280433
	SCALE	REVISION LEVEL —	SHEET 3

SMCAR FORM 71, 1 JUL 87 (TEMP) REPLACES SMCAR FORM 71, 1 JUN 86(TEMP)
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BOOK FORM "A" SIZE

If during the inspection cycle the above parameters are not met, the system shall reject the item under test and indicate a system fault.

3.10 The system shall incorporate automatic verification:

3.10.1 The automatic verification system shall monitor the flaw detection loop which includes the transducer positioning and the pulser/receiver functioning. This system shall assure proper system calibration during each inspection cycle.

3.10.2 The following system characteristics shall be monitored and verified on each inspection cycle.

1. Position of the transducer
2. Signal amplitude
3. Location of the alarm gate
4. Alarm Level (Amplitude)

3.10.2.1 The location and alarm level of each gate shall be monitored and verified at the end of each inspection cycle or inspection area when programmable gain control is used. This shall be accomplished by the use of a microprocessor controlled signal generator. The signal generator shall send signals in accordance with 3.10.2.3 and the proper alarm response must be detected to verify proper system calibration.

3.10.3 The pulser/receiver shall be digitally compatible with the microprocessor.

3.10.4 Initiation of each successive inspection cycle shall depend on the receipt of proper system verification data.

3.11 The system shall use solid state circuitry throughout the system.

3.11.1 Precaution shall be taken to eliminate conditions that may contribute to the generation of false signals. This would include such features as electrical filtering to suppress spurious electrical signals, shielding to eliminate picking up radio frequency signals and design features that would minimize the adverse effects of the introduction of air into the water during the submersion of the test time.

3.11.2 All electrical panels used in the system shall be provided with a means to control the temperature so that the maximum rate temperature of the equipment is never exceeded. The air circulation system used to provide this control shall be equipped with a filter to remove any contaminants which may have an adverse effect on system reliability.

3.12 A locked cover which will allow visibility of the ultrasonic flaw detector controls, will be provided to prevent access by unauthorized personnel.

3.13 The following characteristics are recommended as a minimum for each required channel.

TITLE ENVELOPE DRAWING 105MM CARTRIDGE CASES ULTRASONIC INSPECTION	SIZE A	CAGE CODE 19200	DRAWING NO. 9280433	
	SCALE	REVISION LEVEL —	SHEET	4

SMCAR FORM 71, 1 JUL 87 (TEMP) REPLACES SMCAR FORM 71, 1 JUN 86(TEMP)
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BOOK FORM "A" SIZE

- 3.13.1 Testing frequency: Switchable - 2.25, 5 and 10 MHZ.
- 3.13.2 Receiver: Switchable, narrow or broadband.
(Broadband is recommended)
- 3.13.3 Gate: Position, length, and amplitude.
- 3.13.3.1 Dual gates as a minimum shall be provided.
- 3.13.4 Calibrated attenuator: 0 to 60 db in 1 db steps.
- 3.13.5 Pulse repetition rate: To have an adjustable capability with an upper limit of no less than 2000 pulses per second.
- 3.13.6 Linearity: Horizontal; 2%, vertical, 3%.
- 3.13.7 Testing range: To 24 inches steel, minimum.
- 3.13.8 Delay: .1 to 24 inches steel.
- 3.13.9 Scale expansion: From full testing range to .5 inches steel.
- 3.14. An ultrasonic test tank shall be provided that will:
 - 3.14.1 Be fabricated of corrosive resistant materials. Dissimilar metals should not be used due to possible electrochemical reactions.
 - 3.14.2 Be large enough to allow each insertion and removal of the part, contain the support fixture, the transducers with their manipulators and leave sufficient room for convenient adjustment of the transducers.
 - 3.14.3 Have water supply and drainage connections.
 - 3.14.4 Have filtration system of sufficient capacity to remove particles larger than 15 microns without aerating or inducing vapor into the water.
 - 3.14.5 Provide a temperature control to automatically maintain the water temperature at least 3 degrees celsius above the temperature of the test item.
 - 3.14.6 During inspection of the time it shall be submerged in water to which a suitable rust inhibitor, wetting agent and fungicide shall have been added. The water shall provide the means of transmitting the sound from the transducer to the test item. The test item shall be rotated during inspection.
 - 3.14.7 A means shall be provided to prevent or remove air bubbles form the face of the transducers and the outside surface of the test item if necessary.

TITLE	SIZE	CAGE CODE	DRAWING NO.
ENVELOPE DRAWING 105MM CARTRIDGE CASES ULTRASONIC INSPECTION	A	19200	9280433
	SCALE	REVISION LEVEL -	SHEET 5

SMCAR FORM 71, 1 JUL 87 (TEMP) REPLACES SMCAR FORM 71, 1 JUN 86(TEMP)
WHICH IS OBSOLETE

BOOK FORM "A" SIZE

3.15 The transducer shall be held in manipulators furnished with the following:

3.15.1 Corrosion resistance materials shall be used throughout.

3.15.2 Adjustments that will allow for all required transducer movements needed to position the transducers into the proper settings. Geared mechanisms shall be incorporated to facilitate precision adjustment.

3.15.3 A means of securing the transducer at the desired setting which will not impart any transducer movement during locking nor allow for any unwanted movement during the inspection cycle.

3.15.4 Graduations that will allow for visual indication of all manipulator settings.

3.15.5 A design that will minimize transducer vibrations throughout the range of operating speed.

3.15.6 To facilitate adjustment, it would be desirable to use a manipulator that is easily accessible when the part is in the tank.

3.15.7 Transducers will be pulsed in a manner that will not allow cross talk.

3.16 The following are requirements for the transducers:

3.16.1 For each transducer used in the inspection system at least one spare transducer shall be provided.

3.16.2 Transducers, fixed and scanning as required shall be chosen to optimize detection of natural continuities as represented by notches contained in the standard(s) referenced in paragraph 2.0.

3.16.2.1 For each transducer the following data shall be provided:

- A. Beam profile
- B. Real time wave form
- C. Frequency spectrum
- D. Beam focus information

3.16.3 If the inspection station uses one transducer to inspect in multiple areas (more than one standard notch), then the reflected signals from all notches that must be detected by any one transducer shall be of the same approximate amplitude. To achieve this, the system must be capable of automatically changing the acceptance level during the scan. It may be found that signals from the inside and outside notches may vary in such a way as a dual gate capability will be required, one for the inside and one for the outside notches. To assure complete coverage some overlapping will be required between the two gates. For any one gate a maximum difference of fifteen percent between maximum and

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	A	19200	9280433	
	SCALE	REVISION LEVEL	—	SHEET 6

SMCAR FORM 71, 1 JUL 87 (TEMP) REPLACES SMCAR FORM 71, 1 JUN 86(TEMP)
WHICH IS OBSOLETE

BOOK FORM "A" SIZE

minimum signals would be desirable goal.

4.0 Standards: Standard(s) made in accordance with the applicable drawings are required.

4.0.1 Measurement of the notches in each referenced standard is best accomplished by use of a replication technique and an optical comparator. One casting material found satisfactory for the replication is room temperature vulcanizing silicone rubber RTV-93-072 made by Dow Corning.

5.0 Acceptance Test: A dynamic test will be conducted after the system has been setup in accordance with the operating manual. The test will be conducted by the contractor to demonstrate the adequacy of the ultrasonic inspection system detection capabilities and to accept good product. A plan defining details of the test to demonstrate 99% reliability with a 90% confidence will be prepared by the test system contractor.

6.0 Government approval:

Government approval is required prior to fabrication or publication of the following:

- A. Inspection system design
- B. Test plan for test referenced in paragraph 5.0
- C. Specifications for commercial items
- D. Set up procedures
- E. Calibration procedures
- F. Operating instructions
- G. Maintenance and troubleshooting procedures
- H. Verification procedures

7.0 Use of inspection system: As a minimum the standard(s) will be inspected at the beginning and end of each shift to assure proper signal amplitude. If the signal amplitude is incorrect then the system must be adjusted to the proper levels before testing may continue. A log book shall be maintained by the operator of each system. A log book shall contain as a minimum documented use of the standards, number of items inspected, number of suspects and rejects by zone, changing of transducers, instrumentation repairs, reason for malfunctions, if any, and changing of qualified operators. The log book shall be made available when requested for government review.

TITLE ENVELOPE DRAWING 105MM CARTRIDGE CASES ULTRASONIC INSPECTION	SIZE A	CAGE CODE 19200	DRAWING NO. 9280433	
	SCALE	REVISION LEVEL	—	SHEET 7

SMCAR FORM 71, 1 JUL 87 (TEMP) REPLACES SMCAR FORM 71, 1 JUN 86(TEMP)
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BOOK FORM "A" SIZE

8.0 Suggested sources:

Qualcorp
Shelter Rock Rd.
Danbury, CT 06910

Industrial Metal Products Co.
3417 W. St. Joseph Street
Landing, MI 48901

Krautkramer Branson Int.
76 Progress Drive
Stamford, CT 06904

Magnaflux Corp
25 W. 43rd Street
New York, NY 10036

Intricate Machine Engineering, Inc.
16 Extension St.
Attlebor, MA 02703

General Test Instrument, Inc.
P.O. Box 171
Georgetown, CT 06829

QCS Industries, Inc.
1830 Vernon, Suite #6
Roseville, CA 95678

California Data Corp.
3475 Old Conejo Rd.
Suite C-10
Newbury Park, CA 92320

Rompas, N.D.E.
101 W. Briosa Drive
Cost Mesa, CA 92627

Sonic Instruments, Inc.
1018 Whitehead Rd., Ext.
Trenton, NJ 08638

Tektran Division of Arcair
P.O. Box 406
Lancaster, OH 43130

Testech
P.O. Box 163
Downingtown, PA 19335

Magnetic Analysis Corp.
535 South 4th Ave.
Mount Vernon, NY 10550

K.J. Law Engineers, Inc.
23660 Research Drive
Farmington Hills, MI 48024

Sigma Research Inc.
3200 George Washington Way
Richland, WA 99362

Stavelly NDT Technologies
P.O. Box 573
Yardley, PA 19067

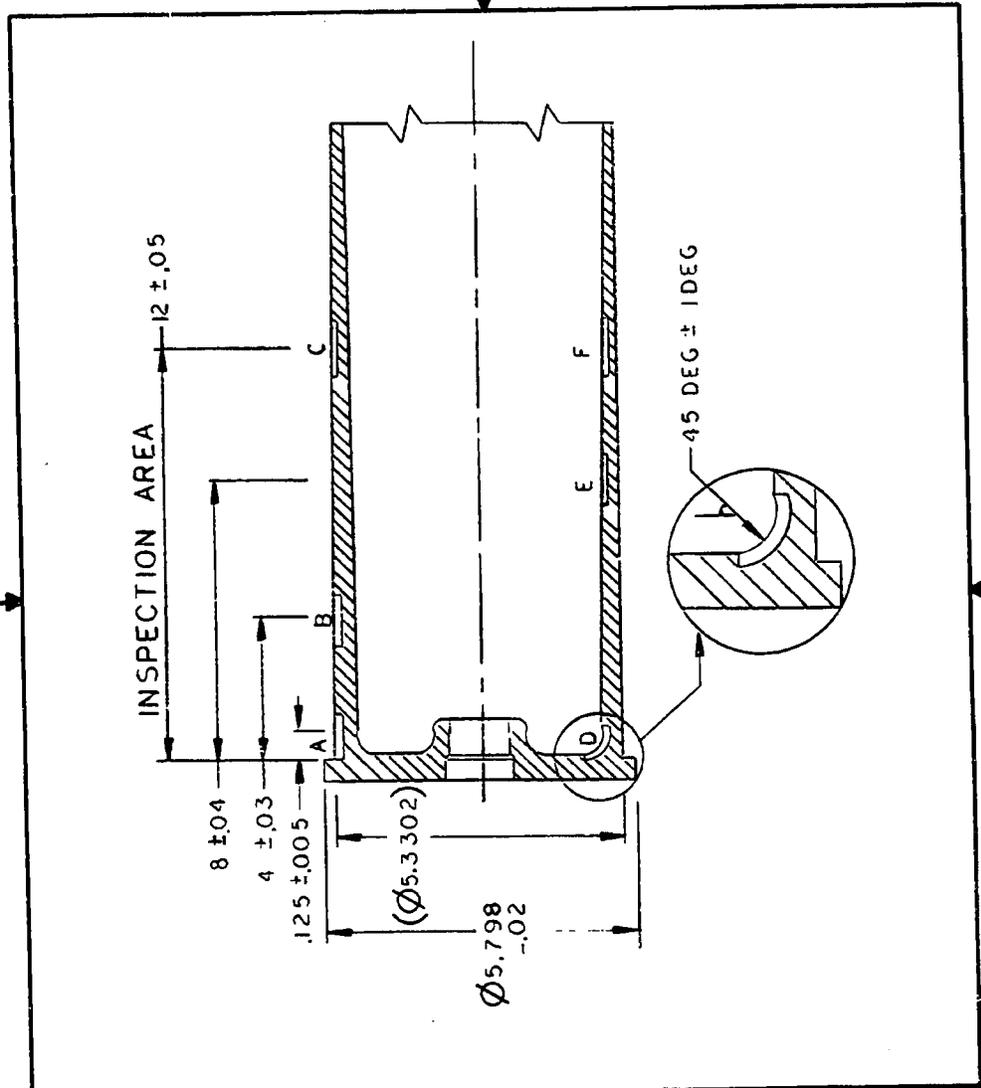
TITLE ENVELOPE DRAWING 105MM CARTRIDGE CASES ULTRASONIC INSPECTION	SIZE A	CAGE CODE 19200	DRAWING NO. 9280433	
	SCALE		REVISION LEVEL —	SHEET 8

SMCAR FORM 71, 1 JUL 87 (TEMP) REPLACES SMCAR FORM 71, 1 JUN 86(TEMP)
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APPLICATION		REVISIONS															
NEXT ASSY	USED ON	SYM	DESCRIPTION	DATE	APPROVAL												
		-	PRODUCT BASELINE ERR MOQ2094 (ECPMOQ2095 90-11-19)	91-06-28	RR SR												
<table border="1" style="margin: auto;"> <tr> <td style="width: 25%; text-align: center;">-</td> </tr> <tr> <td style="text-align: center;">SHT 4</td> <td style="text-align: center;">SHT 3</td> <td style="text-align: center;">SHT 2</td> <td style="text-align: center;">SHT 1</td> </tr> <tr> <td colspan="4" style="text-align: center;">REVISION STATUS OF SHEET</td> </tr> </table>						-	-	-	-	SHT 4	SHT 3	SHT 2	SHT 1	REVISION STATUS OF SHEET			
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SHT 4	SHT 3	SHT 2	SHT 1														
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PART NO. 9280434																	
ORIGINAL DATE OF DRAWING 91-06-21		DESIGN ACTIVITY U.S. ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER PICATINNY ARSENAL, NEW JERSEY 07806-5000															
DRAFTSMAN RCR	CHECKER	LONGITUDINAL CALIBRATION STANDARD 105mm CARTRIDGE CASE															
ENGR	ENGR																
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<i>Syed Ali</i>		SIZE A	CAGE CODE 19200	9280434													
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SMCAR FORM 65

BOOK FORM "A" SIZE



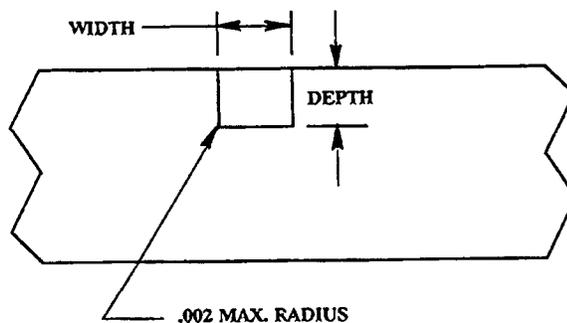
TITLE LONGITUDINAL CALIBRATION STANDARD 105 mm CARTRIDGE CASE	SIZE	CAGE CODE	DRAWING NO.
	A	19200	9280434
SCALE	REVISION LEVEL	SHEET	2

SMCAR FORM 71, 1 JUL 87(TEMP) REPLACES SMCAR FORM 71, 1 JUN 85(TEMP) WHICH IS OBSOLETE

BOOK FORM "A" SIZE

NOTCH #	LENGTH INCHES	DEPTH INCHES	WIDTH INCHES
A (OD)	.25 ± .01	.020 ± .001	.010 ± .002
B (OD)	.25 ± .01	.018 ± .001	.010 ± .002
C (OD)	.25 ± .01	.018 ± .001	.010 ± .002
D (ID)	.25 ± .01	.020 ± .001	.010 ± .002
E (ID)	.25 ± .01	.014 ± .001	.010 ± .002
F (ID)	.25 ± .01	.010 ± .001	.010 ± .002

TYPICAL CROSS SECTION OF EDM NOTCH



ALL NOTCHES ARE FLAT BOTTOM AND TO FOLLOW THE CONTOUR OF THE SURFACE

TITLE LONGITUDINAL CALIBRATION STANDARD 105mm CAR- TRIDGE CASE	SIZE A	CAGE CODE 19200	DRAWING NO. 9280434	
	SCALE	REVISION LEVEL —	SHEET	3

SMCAR FORM 71, 1 JUL 87 (TEMP) REPLACES SMCAR FORM 71, 1 JUN 86(TEMP) WHICH IS OBSOLETE

BOOK FORM "A" SIZE

NOTES:-

- 1-SPEC MIL-A-2550, ANSI Y14.5.-1973 AND ANSI-B46.1 APPLY.
- 2-MATERIAL: STANDARD CAN BE MADE FROM DEFECT FREE PRODUCTION PARTS OR ACOUSTIC EQUIVALENT
- 3-STANDARDS SHALL CONFORM TO DRAWING 10520214. SUITABLE STANDARDS USING ACTUAL DEFECT FREE PARTS (AN ULTRASONICALLY CLEAN PRODUCTION PART) SHALL BE PREPARED AS DEPICTED BELOW. THE STANDARDS MUST REFLECT THE METAL PART CONFIGURATION WHICH IS IN PRODUCTION AT THE TIME THE STANDARD IS USED.
- 4-STANDARD MAY BE MADE IN ONE OR TWO PIECES PROVIDED ORIGINAL DIMENSIONS FOR LENGTH, CONCENTRICITY, ETC. MEET TOLERANCES PRESCRIBED ON DRAWING 10520214. IF THE BODY IS SECTIONED TO FACILITATE MACHINING THEY SHALL BE JOINED WITH ADHESIVE (ARMSTRONG C-7/W EPOXY ADHESIVE: MIX RATIO 2/3 BY WEIGHT OR APPROVED EQUIVALENT). A GAP OF .002 MAXIMUM IS PERMISSIBLE.
- 5- VIBROPEEN "9280434 ULTRASONIC CALIBRATION STD" NEAR THE OPEN END.
- 6-AN ELECTRIC DISCHARGE MACHINE SHALL BE USED FOR CUTTING THE NOTCHES.
- 7-FILL NOTCHES AND HOLES WITH NONCORROSIVE CLEAR RTV SILICONE RUBBER (MIL-A-46146), GE RTV-162, OR APPROVED EQUIVALENT.
- 8- THE INTERIOR CAVITY SURFACE MUST BE PRIMED IAW FINISH NO. 24.6 OF MIL-STD-171 AFTER GROOVES AND HOLES ARE FILLED WITH SPECIFIED RTV.
- 9-ALL NOTCHES IN SIDEWALL TO BE WITHIN +5 DEGREES FROM PERPENDICULAR WITH CENTER.
- 10-THIS AREA BETWEEN NOTCHES IS TO BE SCREENED FOR LONGITUDINAL CRACKS.
- 11-STORAGE: FOR ANY SHORT TERM STORAGE OF THE STANDARD (1-7 DAYS) THE STANDARD MUST BE PACKED IN MIL-B-131F CLASS 1 MATERIAL WITH INSERTION OF A QUICK RELEASE VAPORIZING CORROSION INHIBITOR (VCI); FOR ANY LONG TERM STORAGE OF THE STANDARD (GREATER THAN ONE WEEK), THE STANDARD AND A CONVENTIONAL VCI MATERIAL MUST BE WRAPPED INTO MIL-B-131F CLASS 1 MATERIAL, HEAT SEALED, AND PLACED IN A PROTECTIVE PACKAGE THAT WILL PREVENT PUNCTURING OF THE HEAT SEALED PACKAGE.

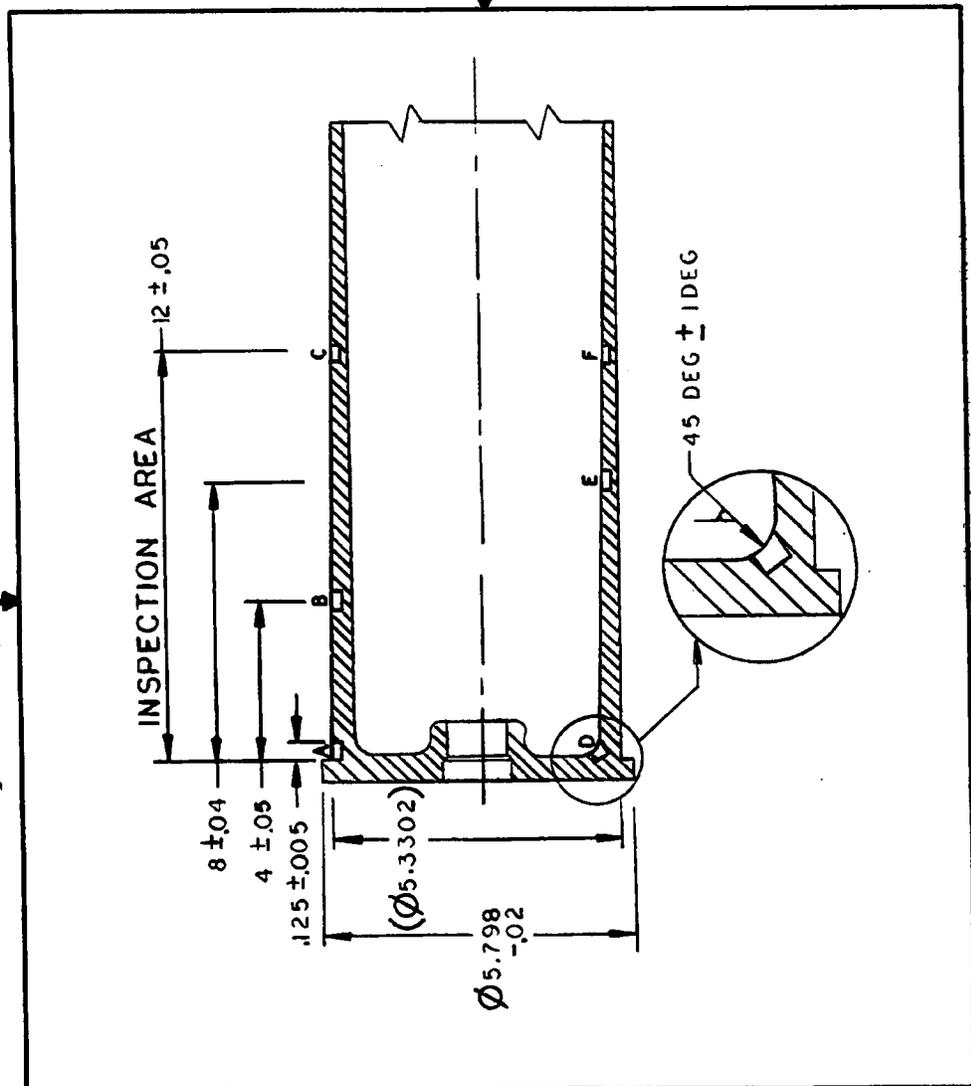
TITLE LONGITUDINAL CALIBRATION STANDARD 105mm CARTRIDGE CASE	SIZE	CAGE CODE	DRAWING NO.
	A	19200	9280434
SCALE		REVISION LEVEL	SHEET 4

SMCAR FORM 71, 1 JUL 87 (TEMP) REPLACES SMCAR FORM 71, 1 JUN 86(TEMP) WHICH IS OBSOLETE

APPLICATION		REVISIONS			
NEXT ASSY	USED ON	SYM	DESCRIPTION	DATE	APPROVAL
		-	PRODUCT BASELINE ERR M0Q2094 (ECPM0Q2095/90-11-19)	91-06-28	RR SR
-	-	-	-	-	-
SHT 4	SHT 3	SHT 2	SHT 1		
REVISION STATUS OF SHEET					
PART NO. 9280435					
ORIGINAL DATE OF DRAWING 91-06-21		DESIGN ACTIVITY U.S. ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER PICATINNY ARSENAL, NEW JERSEY 07806-5000			
DRAFTSMAN RCR	CHECKER	CIRCUMFERENTIAL CALIBRATION STANDARD 105mm CARTRIDGE CASE			
ENGR	ENGR				
ENGR	ENGR <i>[Signature]</i>				
<i>Syed Ali</i>		SIZE A	CAGE CODE 19200	9280435	
<i>Gary J. Romie</i>		SCALE	UNIT WT.	SHEET 1 OF 4	

SMCAR FORM 65

BOOK FORM "A" SIZE



TITLE
CIRCUMFERENTIAL
CALIBRATION STANDARD
105mm CARTRIDGE CASE

SIZE

A

CAGE CODE

19200

DRAWING NO.

9280435

SCALE

REVISION LEVEL

SHEET

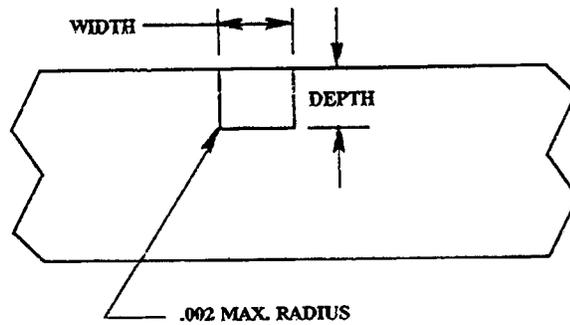
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SMCAR FORM 71, 1 JUL 87(TEMP) REPLACES SMCAR FORM 71, 1 JUN 86(TEMP) WHICH IS OBSOLETE

BOOK FORM "A" SIZE

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TYPICAL CROSS SECTION OF EDM NOTCH



ALL NOTCHES ARE FLAT BOTTOM AND TO FOLLOW THE CONTOUR OF THE SURFACE

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	SCALE	REVISION LEVEL —	SHEET	3

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BOOK FORM "A" SIZE

NOTES:-

- 1- SPEC MIL-A-2550, ANSI Y14.5,-1973 AND ANSI-B46.1 APPLY.
- 2- MATERIAL: STANDARD CAN BE MADE FROM DEFECT FREE PRODUCTION PARTS OR ACOUSTIC EQUIVALENT
- 3- STANDARDS SHALL CONFORM TO DRAWING 10520214. SUITABLE STANDARDS USING ACTUAL DEFECT FREE PARTS (AN ULTRASONICALLY CLEAN PRODUCTION PART) SHALL BE PREPARED AS DEPICTED BELOW. THE STANDARDS MUST REFLECT THE METAL PART CONFIGURATION WHICH IS IN PRODUCTION AT THE TIME THE STANDARD IS USED.
- 4- STANDARD MAY BE MADE IN ONE OR TWO PIECES PROVIDED ORIGINAL DIMENSIONS FOR LENGTH, CONCENTRICITY, ETC. MEET TOLERANCES PRESCRIBED ON DRAWING 10520214. IF THE BODY IS SECTIONED TO FACILITATE MACHINING THEY SHALL BE JOINED WITH ADHESIVE (ARMSTRONG C-7/W EPOXY ADHESIVE: MIX RATIO 2/3 BY WEIGHT OR APPROVED EQUIVALENT). A GAP OF .002 MAXIMUM IS PERMISSIBLE.
- 5- VIBROPEEN "9280435 ULTRASONIC CALIBRATION STD" NEAR THE OPEN END.
- 6- AN ELECTRIC DISCHARGE MACHINE SHALL BE USED FOR CUTTING THE NOTCHES.
- 7- FILL NOTCHES AND HOLES WITH NONCORROSIVE CLEAR RTV SILICONE RUBBER (MIL-A-46146), GE RTV-162, OR APPROVED EQUIVALENT.
- 8- THE INTERIOR CAVITY SURFACE MUST BE PRIMED IAW FINISH NO. 24.6 OF MIL-STD-171 AFTER GROOVES AND HOLES ARE FILLED WITH SPECIFIED RTV.
- 9- ALL NOTCHES IN SIDEWALL TO BE WITHIN +5 DEGREES FROM PERPENDICULAR WITH CENTER.
- 10- THIS AREA BETWEEN NOTCHES IS TO BE SCREENED FOR LONGITUDINAL CRACKS.
- 11- STORAGE: FOR ANY SHORT TERM STORAGE OF THE STANDARD (1-7 DAYS) THE STANDARD MUST BE PACKED IN MIL-B-131F, CLASS 1 MATERIAL WITH INSERTION OF A QUICK RELEASE VAPORIZING CORROSION INHIBITOR (VCI); FOR ANY LONG TERM STORAGE OF THE STANDARD (GREATER THAN ONE WEEK), THE STANDARD AND A CONVENTIONAL VCI MATERIAL MUST BE WRAPPED INTO MIL-B-131F, CLASS 1 MATERIAL, HEAT SEALED, AND PLACED IN A PROTECTIVE PACKAGE THAT WILL PREVENT PUNCTURING OF THE HEAT SEALED PACKAGE.

TITLE CIRCUMFERENTIAL CALIBRATION STANDARD 105mm CARTRIDGE CASE	SIZE	CAGE CODE	DRAWING NO.	
	A	19200	9280435	
SCALE		REVISION LEVEL	—	SHEET 4

SMCAR FORM 71, 1 JUL 87 (TEMP) REPLACES SMCAR FORM 71, 1 JUN 86(TEMP) WHICH IS OBSOLETE