

NOTICE OF
CHANGE

INCH-POUND

MIL-STD-644A
NOTICE 5
1 May 1992

MILITARY SPECIFICATION
VISUAL INSPECTION STANDARDS AND INSPECTION PROCEDURES
FOR INSPECTION OF
PACKAGING, PACKING AND MARKING OF SMALL ARMS AMMUNITION

TO ALL HOLDERS OF MIL-STD-644A:

1. The following pages of MIL-STD-644A have been revised and supersede the pages listed:

<u>New Page</u>	<u>Date</u>	<u>Superseded</u>	<u>Date</u>
5	1 May 1992	5	10 January 1991
6	3 December 1962	6	Reprinted without change

2. Retain this notice page and insert before the table of contents.

3. Holders of MIL-STD-644A will verify that page changes and additions indicated above have been entered. This notice page will be retained as a check sheet. This issuance, together with appended pages, is a separate publication. Each notice is to be retained by stocking points until the military standard is completely revised or canceled.

Custodians:
Army-AR
Navy-OS
Air Force-70

Preparing activity:
Army-AR
(Project 1305-0E12)

AMSC N/A

FSC 1305

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5.2.2.1.1 Tap water at ambient temperature shall be used in the bell jar for the box leak test (fig.2).

5.2.2.1.2 Each box of the inspection sample shall be submerged under water in the bell jar with the cover of the box toward the inspector. The bell jar shall be closed and a pressure differential, as specified for the particular box packed, established. The cable attached to the lid shall be snapped to release trapped air bubbles on the box. When turbulence in the water has ceased, the box shall be observed for a period of 15 seconds.

5.2.2.1.3 Any escape of air from the interior of a box under the conditions of paragraph 5.2.2.1.2 constitutes a leaker. However, for the purpose of acceptance inspection, a leaker is one which permits the escape of a total of five or more bubbles from one or more leaking areas during the observation time of 15 seconds.

5.2.2.1.4 The location of the leak(s) (cover, bottom, side, side seam, or gasket), shall be reported.

5.2.2.2 The acceptable quality levels for gasket sealed ammunition box defects shall be as follows:

Physical characteristics, paint and markings:

	Percent
Major-----	1.00
Minor-----	2.5
Gasket sealing	
Major.....	1.0

5.2.2.3 Classification of defects. Gasket sealed ammunition box defects.

	Major	Minor
<i>Physical characteristics</i>		
1. Incorrectly closed and secured box	x	—
2. Severe dents, buckles, or other damage	—	X
3. Scratches or abrasions exposing bare metal.	—	X
<i>Markings</i>		
4. Incorrect, illegible, or missing ammunition lot number.	x	—
5. Other markings, incorrect, missing, or illegible.	x	—
6. Incorrect pain or ink-----	x	—
<i>Gasket sealing</i>		
7. Leaker as defined-----	x	—

5.3 Overpacks and overpack contents. Phase III.

5.3.1 Wirebound/wooden boxes.

5.3.1.1 Bar coding shall be applied to the wirebound/wooden box in accordance with MIL-STD-129 or the applicable marking drawing. The bar code must be machine readable.

5.3.1.2 The acceptable quality levels for wirebound/wooden box defects shall be as follows:

	Percent
Major-----	1.00
Minor-----	2.5
5.3.1.3 Classification of defects.	
Wirebound/wooden box defects.	

	Major	Minor
<i>Assembly and Seal</i>		
1. Unfastened outside binding wire	x	---
2. Unfastened inside binding wire	---	x
3. Missing end	x	---
4. Side, top or bottom extending beyond end cleat more than 1/8 in. End cleat extending beyond side, top or bottom more than 1/8 in.	---	x
6. Gap larger than 1/4 in. between end of batten and cleat.	---	X
7. Gap larger than 1/4 in. between side of batten and cleat.	---	x
8. Gap larger than 1/4 in. between diagonal ends of more than one pair of cleats per box	---	x
9. reversed or inverted end.	---	x
10. Missing or incorrectly attached seal (Box contents removable).	x	---
11. Incorrectly attached seal. (Box contents not removable).	---	x
12. Exposed sharp edge or sliver, outside surface.	x	---
13. FSN, DOD or LOT-all missing or illegible or any incorrect.	x	---
14. DOD or LOT—one missing or illegible	---	x
15. Markings other than above incorrect, missing or illegible.	---	x
16. Marking touched up or repaired with non-permissible material (crayon, chalk, etc.)	---	x
<i>Box contents</i>		
17. Missing separator	x	---
18. Incorrect, missing or illegible ammunition lot number.	x	---
19. Improper packing other than 17 and 18	---	X
20. Packed ammunition not in accordance with FSN.	X	---
21. Bar ding is missing or not readable.	X	---

5.3.2 Metal boxes.

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5.3.2.1 The acceptable quality levels for metal box defects shall be as follows:

	<i>Percent</i>
Major	1.00
Minor	2.5

5.3.2.2 Classification of defects.

<i>Metal box defects</i>			
<i>Marking</i>	<i>Major</i>	<i>Minor</i>	
1. FSN, DOD or Lot—all missing or illegible or any incorrect.	X		
2. DOD or Lot—one missing or illegible		X	
3. Markings other than above incorrect, missing or illegible.		X	
4. Marking touched up or repaired with nonpermissible material (crayon, chalk, etc.).	--	X	
<i>Workmanship and assembly</i>			
5. Box not properly closed and secured	X		
6. Severe dents, buckles or other damage	--	X	
<i>Box contents*</i>			
7. Missing separator	X		
8. Incorrect, missing or illegible ammunition lot number.	X		
9. Improper packing other than 7 and 8	--	X	
10. Packed ammunition not in accordance with FSN.	X		

* When the metal box is the packaged and sealed container as well as the overpack, inspection of box contents shall be in accordance with the applicable contents of container paragraph outlined herein.

6. NOTICES

6.1 Interpretation. Any doubt as to the meaning of the provisions contained in this inspection document or any obscurity in its wording will be explained. All directions and explanations, necessary or proper to make definite and certain any procedure and give them due effect, will be given by the contracting officer.

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Preparing Activity:
 Army—MU

Custodians:
 Army—MU
 Navy—Wep
 Air Force—OOAMA

10. APPENDIX

10.1 Visual inspection standards. This appendix forms an integral part of MIL-STD-644 to the extent specified therein. The illustrations shown are common packaging defects found during normal inspection of container contents, Phase I. Each defect illustrated has a legend which defines the degree or extent of the nonconformance and also whether it is acceptable or unacceptable.

10.2 Cross reference listing. Any packaging defect may be readily associated with the pertinent "Classification of Defects" or illustration by checking the following listing.

20. CARTON PACKAGE

20.1 Defect #5. Missing label or improperly sealed carton, including label printed in wrong position on carton (referenced on page 3).

- | | |
|---------------------------|------------|
| (a) Misplaced label | Figure 3-4 |
| (b) Not securely fastened | Figure 5 |
| (c) Improper sealing | Figure 5 |
| (d) Improper closure | Figure 6 |

20.2 Defect #6. Torn or ripped carton or label (referenced on page 3).

- | | |
|-----------------|-------------|
| (a) Torn label | Figure 7-8 |
| (b) Torn carton | Figure 9-10 |