

# SUPPLEMENTARY QUALITY ASSURANCE PROVISIONS

FOR CARRIER, PRIMARY PLANETARY

USED ON M107, M110, M578, M110A1, M110A2

**SQAP**

11675342

Sheet 1 of 2

DWG NO. F11675342

DEPT OF THE ARMY  
U.S. ARMY ARMAMENT RESEARCH  
AND DEVELOPMENT COMMAND

CODE IDENT NO. 19207

## PART I - LIST OF APPLICABLE DOCUMENTS

CURRENT FSCM 19200

NUMBER	NOMENCLATURE
F11675342 MIL-W-63150	Carrier, Primary Planetary Weapons and Support Materiel Standard Quality Assurance Provisions For

## PART II - EXAMINATION PROVISIONS

CLASS	CHARACTERISTIC	ZONE	AQL	INSPECTION METHOD
<u>CRITICAL</u>	None			
<u>MAJOR</u>				
101	.003 Position location of (6) .7494 diameter holes to pitch diameter of spline	E5	1.0	CI1691958
102	.005 Runout of face of 3.88 diameter to pitch diameter of spline	H4	1.0	SMTE
103	28 Tooth, 10/20 pitch, .1571 minimum effective space width	A5	1.0	CI1836594
104	28 Tooth, 10/20 pitch, .1604 maximum actual space width	A5	1.0	CI1836615
105	2.7000 Minor diameter of spline	G3	1.0	SMTE
106	.7494 Diameter hole, 2 holes in line (3 places)	E5	1.0	SMTE
<u>MINOR</u>				
201	2.375 Dimension over flanges (3 places)	H4	2.5	SMTE
202	1.625 Dimension between flanges (3 places)	H4	2.5	SMTE
203	.375 Flange thickness (3 pl)	H4	2.5	SMTE

ERR NO.	REVISION DATA				PREPARED
	SQAP	REV	DWG	REV	
PCF-F7211-2	730820	ORIG	730507	ORIG	SUBMITTED <i>na Jordan</i>
W3A2111 (PCF-G8638)	790912	F	790912	E	
W3A2013 (PCF-H4766)	830524	G	*		
					APPROVED <i>De Cooper</i>

ERR NO.	REVISION DATA				SQAP	11675342
	SQAP	REV	DWG	REV		Sheet 2 of 2
PCF-F7211-2	730820	ORIG	730507	ORIG	DEPT OF THE ARMY U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND	CODE IDENT NO. 19207
PA2111 (PCF-G8638)	790912	F	790912	E		
BA2013 (PCF-H4766)	830524	G	*			

CURRENT FSC# 19200

PART II - EXAMINATION PROVISIONS (CONTINUED)

204	.015 Position location of (3) .141 diameter holes to .7494 diameter hole	D5	2.5	SMTE
205	.020 Position location of .370 diameter hole to pitch diameter of spline, center line of tooth space and face of 3.88 diameter	F4	2.5	SMTE
206	Incorrect, missing or improperly placed part number	C8,G6	4.0	Visual
207	Workmanship	-	4.0	Visual

"First Article Approval" - Three (3) or more items are to be packaged, packed and submitted for first article approval as prescribed in the contract or purchase order.

PART III - CERTIFICATION PROVISIONS

None

PART IV - TEST METHODS AND PROCEDURES

None