

**QUALITY ASSURANCE PROVISIONS (QAP)
(DARCOM-R 702-10)**

COMMAND AGENCY:

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND, DOVER, NJ 07801

**THESE QAP'S FORM PART OF DRAWING/SPECIFICATION F11675343 AS SPECIFIED IN THE CONTRACT.
INSPECTION SHALL BE CONDUCTED AS SPECIFIED HEREIN AND IN ACCORDANCE WITH REFERENCED DOCUMENTS.**

PART I - LIST OF APPLICABLE DOCUMENTS

<u>NUMBER</u>	<u>NOMENCLATURE</u>
F11675343	SHAFT, PLANETARY CARRIER
MIL-W-63150	WEAPONS AND SUPPORT MATERIEL STANDARD QUALITY ASSURANCE PROVISIONS FOR

PART II - EXAMINATION PROVISIONS

<u>CLASS</u>	<u>CHARACTERISTIC</u>	<u>ZONE</u>	<u>AQL</u>	<u>INSPECTION METHOD</u>
<u>CRITICAL</u>	NONE			
<u>MAJOR</u>				
101	COMPOSITE CHECK, EXTERNAL SPUR GEAR (RUNOUT)		1.0	C10881060 C10881061 C10881053, STM-1
102	12 TEETH, 6/12 PITCH, .3241 MAXIMUM EFFECTIVE TOOTH THICKNESS	A5	1.0	C10881250 C10881251
103	12 TEETH, 6/12 PITCH, .3214 MINIMUM ACTUAL TOOTH THICKNESS	A5	1.0	C10928010
104	.002 RUNOUT OF 1.6535 DIAMETER TO DATUM-A-	G3	1.0	SMTE
105	.001 RUNOUT OF 1.000 DIAMETER TO DATUM-A-	G3	1.0	SMTE

REVISIONS

RELEASE NUMBER	W3A2013 (PCF-H4766)																		
DATE	830524																		
RELEASE NUMBER																			
DATE																			
REVISION STATUS OF SHEETS	REVISION	B	B	B															
	SHEET	1	2	3															
	REVISION																		
	SHEET																		

QAP FOR:	SHAFT, PLANETARY CARRIER	M107, M110, M110A1, M110A2, M578	CODE: CURRENT FSCM 19207 19200
SUBMITTED BY:	PACIFIC CAR AND FOUNDRY COMPANY <i>R. Jackson</i>		QAP NO.: 11675343
DATE:	APPROVED	RELEASE NO.	PAGE NO.:
730820	<i>J. Cooper</i>	PCF-F7211-2	1
			NO. OF PAGES: 3

QUALITY ASSURANCE PROVISIONS (QAP) (CONTINUATION SHEET)
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PART II - EXAMINATION PROVISIONS (CONTINUED)

106	.005 RUNOUT OF 1.755 DIAMETER TO DATUM-B-	G3	1.0	A10879520 B10927994
107	.005 RUNOUT OF SPLINE FACE TO DATUM-A-	E4	1.0	SMTE
108	28 TEETH, 10/20 PITCH, .1571 MAXIMUM EFFECTIVE TOOTH THICKNESS	C3	1.0	C11836619 C11836620
109	28 TEETH, 10/20 PITCH, .1538 MINIMUM ACTUAL TOOTH THICKNESS	C3	1.0	C11836622 C11836623
110	2.8818 MAJOR DIAMETER SPLINE	G7	1.5	SMTE
111	2.000 OUTSIDE DIAMETER	F2	1.5	SMTE
112	2.560 OUTSIDE DIAMETER	G2	1.5	SMTE
113	1.6535 INSIDE DIAMETER	G3	1.5	SMTE
114	.068 GROOVE WIDTH INTERNAL	G3	1.5	SMTE
115	.425 LOCATION, 1.6535 DIAMETER GROOVE	G3	1.5	C10927977

MINOR

201	1.755 GROOVE DIAMETER	F2	2.5	SMTE
202	.420 OUTSIDE GROOVE WIDTH	E3	2.5	SMTE
203	.020 DIAMETER TRUE POSITION LOCATION OF .420 WIDTH GROOVE TO PITCH DIAMETER OF SPLINE, END OF SHAFT, AND CENTERLINE OF SPLINE TOOTH	E4	2.5	SMTE
204	INCORRECT, MISSING OR IMPROPERLY PLACED PART NUMBER	C8	4.0	VISUAL
205	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

CURRENT FSCN 19200

CODE IDENT NO. 19207

REVISION SYMBOL AND DATE	B 830524					QAP NO. 11675343
						PAGE NO. 2

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PART IV - TEST METHODS AND PROCEDURES

(AS REFERENCED UNDER INSPECTION METHOD COLUMN; PART II)

1. **COMPOSITE CHECK:** ANALYTICAL INSPECTION SHALL BE PERFORMED ON TEN (10) GEARS TO ESTABLISH COMPLIANCE WITH DRAWING REQUIREMENTS. THE ALLOWABLE COMPOSITE VARIATION SHALL BE ESTABLISHED BY ROLLING THESE TEN (10) GEARS WITH MASTER GEAR-10881060. THE COMPONENT GEAR AND MASTER GEAR MUST BE MOUNTED ON A VARIABLE CENTER DISTANCE GEAR ROLLING MACHINE OR FIXTURE WITH INDICATING DEVICE OR RECORDER. THE ESTABLISHED CENTER DISTANCE VARIATION LIMIT WILL BE THE ACCEPTANCE CRITERIA FOR COMPOSITE INSPECTION.

WHEN COMPONENT GEARS EXCEED THE ESTABLISHED COMPOSITE VARIATION, ACCEPTANCE SHALL BE PREDICATED ON ANALYTICAL INSPECTION. ONLY COMPONENT GEARS ACCEPTED BY ANALYTICAL INSPECTION WILL BE USED TO RE-ESTABLISH LIMITS OF COMPOSITE VARIATION.

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