

MILITARY SPECIFICATION
BAND, HANDLING, MK 84 MOD 0
(FOR AQM-37A TARGET)

This specification has been approved by the Bureau
of Naval Weapons, Department of the Navy

1. SCOPE

1.1 **Scope** - This specification covers the requirements for the procurement of one type of Handling Band for attachment to the AQM-37A Target to facilitate handling, and for shipment within a container.

2. APPLICABLE DOCUMENTS

2.1 The following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of the specification to the extent specified herein.

SPECIFICATIONS

FEDERAL

PPP-T-60	Tape, Pressure Sensitive Adhesive, Waterproof - for Packaging and Sealing.
PPP-B-621	Boxes, Wood, Nailed and Lock-Corner.

MILITARY

MIL-P-116	Preservation, Methods of
MIL-B-121	Barrier Material, Greaseproofed, Waterproofed, Flexible.
MIL-G-3278	Grease, Aircraft and Instrument for Low and High Temperatures.
MIL-C-16173	Corrosion Preventive Compound, Solvent Cutback, Cold-Application.

STANDARDS

MIL-STD-105 Sampling Procedure and Tables for
Inspection by Attributes.
MIL-STD-129 Marking for Shipment and Storage.

DRAWING AND LISTS (LD's)

BUREAU OF NAVAL WEAPONS

LD 477247 Band, Handling, Mk 84 Mod 0
(for AQM-37A Target).

(And all drawings referenced thereon)

PUBLICATIONS

BUREAU OF NAVAL WEAPONS

CLASSIFICATION OF DEFECTS (NAVWEPS CD's)

CD 1453449 Band, Handling, Mk 84 Mod 0
(for AQM-37A Target)

(And all NAVWEPS CD's listed thereon)

(Copies of specifications, standards, drawings, and publications required by suppliers in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

3. REQUIREMENTS

3.1 General requirements

3.1.1 Construction - The Handling Band Mk 84 Mod 0 shall be manufactured in strict accordance with Bureau of Naval Weapons List of Drawings LD 477247 and all documents referenced thereon.

3.1.2 Precedence - In the event of any conflict between applicable documents, the following order of precedence shall be observed:

- (a) Contract or Purchase Order.
- (b) This specification.
- (c) Applicable drawings of LD 477247.
- (d) Referenced documents of LD 477247.
- (e) Other applicable documents as referenced in paragraph 2,1 of this specification.

3.1.3 Preproduction samples - Unless otherwise specified in the contract or order (see 6.2), preproduction samples of the Handling Band shall be manufactured using the methods and procedures proposed for production. The sample will be tested as specified in Section 4 herein and is for the purpose of determining that, prior to starting production, the contractor's production methods are capable of yielding items that comply with the technical requirements of the documents noted in 3.1.2.

3.2 Performance requirements and product characteristics - Handling Bands covered by this specification shall be capable of meeting the following performance requirements and product characteristics:

3.2.1 Static load requirements

3.2.1.1 Handling Band structure - There shall be no evidence of structural failure, visible damage, or permanent deformation when a load of 7,000 pounds is placed on the Handling Band as described in 4.4.1.

3.2.1.2 Lifting holes - There shall be no evidence of structural failure, visible damage, or permanent deformation when the Handling Band has been secured to a mandrel 13 inches in diameter and a load of 4,500 pounds is applied through the lifting holes (one-half the load to each hole, simultaneously) and maintained for one (1) minute (see 4.4.2).

3.3 No data is required by this specification, or by documents referenced in Section 2, unless specified in the contract or order (see 6.2).

3.4 Workmanship - Workmanship in the fabrication and assembly of the Handling Bands shall be of sufficiently high quality to assure that completed equipment will comply with all requirements of this specification. Particular attention shall be paid to plating, painting, marking, and freedom of parts from burrs and sharp edges. The assembled Handling Bands shall be thoroughly clean of all dirt, chips, and other foreign matter. The standards of workmanship exhibited in any preproduction sample, subject to any qualification stated in the Government's notice of approval, shall be determinative of the requirements of the contract relative to workmanship insofar as not specifically covered by applicable specifications.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection - Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified, the supplier may utilize his own facilities or any commercial laboratory acceptable to the Government. The Government reserves the right to perform any of the inspections set forth in the specifications where such inspections are deemed necessary to assure that supplies and services conform to prescribed requirements.

4.2 Classification of inspections - Inspection of the Handling Band shall be classified as follows:

- (a) Preproduction inspection (see 4.4).
- (b) Quality conformance inspection (see 4.5).

4.3 Sampling

4.3.1 Preproduction sample - A preproduction sample of two (2) Handling Bands, manufactured in accordance with 3.1.1 and 3.1.3, shall be subjected to the preproduction tests detailed in 4.4. Acceptance of the preproduction sample shall be based on no defects in the sample. Further production of the Handling Band by the supplier, prior to the approval of the preproduction sample, shall be at the supplier's risk.

4.3.2 Quality conformance inspection sampling - The sampling plans and procedures set forth in Standard MIL-STD-105 shall be used in the determination of acceptability of the Handling Bands inspected as specified in 4.5.

4.3.3 Inspection lot - The number of units in an inspection lot shall be, where practicable, 100 Handling Bands. In no event will an inspection lot exceed 100 units.

4.4 Preproduction inspection - The preproduction samples, after satisfactorily passing the Quality Conformance Inspections detailed in 4.5, shall be subjected to the following tests and examination. Certified inspection data covering the results of preproduction inspections shall be forwarded to the Bureau of Naval Weapons if required (see 6.2).

4.4.1 Handling Band structure test - Each of two preproduction samples shall be oriented vertically and attached to a mandrel 13 inches in diameter. One nut on the end of the cable assembly shall be turned until approximately two and one-half threads protrude through the nut. The nut on the other end shall be torqued to 40 foot-pounds. An equally distributed load of 7,000 pounds \pm 350 pounds shall be placed on the upper surface of the Handling Band and allowed to remain for 12 hours (minimum). The load and mandrel shall then be removed and the samples closely examined. Any evidence of structural failure, visible damage, or permanent deformation shall be cause for rejection of the preproduction samples.

4.4.2 Lifting hole test - Each preproduction sample shall, in turn, be attached to a mandrel 13 inches in diameter and the cable assembly torqued as required by 4.4.1. The mandrel shall be secured in such a manner that the mandrel and Handling Band will not move when a vertical pull of 4,500 pounds \pm 225 pounds is applied through the lifting holes (one on each side of the Handling Band directly below the cable assembly) in the Handling Band. The vertical load shall be maintained for one (1) minute (minimum). The mandrel shall be removed and the Handling Band closely examined. Any evidence of structural failure, visible damage, or permanent deformation shall be cause for rejection of the preproduction sample.

4.5 Quality conformance inspection

4.5.1 Samples shall be selected using the plans and procedures set forth in Standard MIL-STD-105, Inspection Level II. Each Handling Band in the sample shall be examined as required by 4.5.2. An AQL of 2.5 percent for MAJOR Defects and 6.5 percent for MINOR Defects shall be used.

4.5.2 Examination - The minimum of examinations to be performed by the supplier for acceptance shall be those set forth in CD 1453449 Band, Handling, Mk 84 Mod 0 (for AQM-37A Target).

5. PREPARATION FOR DELIVERY

5.1 Preservation and packaging - Preservation and packaging shall be Level A.

5.1.1 Level A

5.1.1.1 Cleaning - Handling Bands shall be cleaned in accordance with Specification MIL-P-116, Process C-1.

5.1.1.2 Drying - After cleaning, the Handling Bands shall be dried in accordance with Specification MIL-P-1116, Procedure D-1 or D-4 or a combination of both.

5.1.1.3 Preservative application

5.1.1.3.1 Unpainted metal bearing surfaces - All unpainted metal bearing surfaces shall be coated with grease conforming to Specification MIL-G-3278.

5.1.1.3.2 Unpainted non-bearing metal surfaces - All unpainted non-bearing metal surfaces shall be coated with preservative compound conforming to Specification MIL-C-16173, Grade 1.

5.1.1.4 Unit packaging - Wrap each Handling Band with grease-proof barrier material conforming to Specification MIL-B-121, Type II, Grade A, Class 2, and secure in place with tape conforming to Specification PPP-T-60.

5.2 Packing - Packing shall be Level A or C as specified (see 6.2).

5.2.1 Level A - Handling Bands, preserved and packaged as specified in 5.1, shall be packed in wood boxes conforming to Specification PPP-B-621, Style 4.

5.2.2 Level C - Handling Bands, preserved and packaged as specified in 5.1, shall be packed for shipment in a manner acceptable to common carriers for safe transportation to point destination at the lowest transportation rate for the commodity. This level is intended to provide adequate protection for immediate use domestic shipments, from supply source to the first receiving activity.

5.3 Marking - In addition to any special marking required by the contract or order, packages and packs shall be marked in accordance with Standard MIL-STD-129.

6. NOTES

6.1 Intended use - Handling Bands supplied under this specification are intended for use in the handling and shipment of the AQM-37A Target. Two (2) Handling Bands are required to ship an AQM-37A Target Body in Container Mk 311 Mod 0.

6.2 Ordering data - Procurement documents shall specify:

- (a) Title, number, and date of this specification.
- (b) Preproduction sample size, if different (see 4.3.1).
- (c) Activity designated to perform preproduction testing (see 4.1).
- (d) Desired level of packing (see 5 and 6.3).
- (e) Preproduction inspection data, if required (see 3.3 and 4.4).

6.3 The attention of the contracting officer is invited to the following criteria for selection of the proper level of packing.

For Level A - This level shall be used for those items which are to be shipped to indeterminate destinations or stored under indeterminate conditions for world-wide redistribution.

For Level C - This level shall be used only when it is definitely known that the items are to be shipped to domestic installations for immediate use at the first receiving activity.