

3.4 Mounting surface flatness. The maximum allowable deviation from flat on mounting surfaces shall not exceed .004 inch per inch TIR.

3.5 Surface roughness. Mounting surface roughness shall not exceed 63 microinches rms.

3.6 Marking. Marking shall be in accordance with method I of MIL-STD-1285 except that battery holders themselves shall not be marked; marking shall appear on the unit pack.

3.7 Workmanship. Battery holders shall be processed in such a manner as to be uniform in quality and shall be free from surface and finish flaws that will affect life and serviceability. Battery holders shall be finished smooth and shall have rounded edges with no evidence of chipping, cracking, deterioration, disintegration, or burrs.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in this drawing where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.1.1 Test equipment and inspection facilities. Test and measuring equipment and inspection facilities of sufficient accuracy, quality and quantity to permit performance of the required inspection shall be established and maintained by the contractor. The establishment and maintenance of a calibration system to control the accuracy of the measuring and test equipment shall be in accordance with MIL-C-45662.

4.2 Classification of inspections. The inspections specified herein are classified as follows:

- a. Materials and finishes inspection.
- b. Quality conformance inspection.

4.3 Materials and finishes inspection. Materials and finishes inspection shall consist of certification supported by verifying data that the materials and finishes listed in table I, used in fabricating and finishing the components, are in accordance with the applicable drawing or requirements prior to such fabrication.

TABLE I. Materials and finishes inspection.

Dash number or component	Material	Finish
01 (both halves)	.040 cold rolled steel	.0005 nickel over .0001 copper
02 (both halves)	.040 phosphor bronze	.0005 nickel
Spring	Beryllium copper	.0005 nickel
Insulator	Nylon	---
Rivet	Brass	.0003 nickel
Solder terminal	Brass	.0003 bright alloy

4.4 Inspection conditions. Unless otherwise specified herein, all inspections shall be performed in accordance with the test conditions specified in the "GENERAL REQUIREMENTS" of MIL-STD-202.

DEFENSE ELECTRONICS SUPPLY CENTER DAYTON, OHIO	SIZE A	CODE IDENT. NO. 14933	DWG NO. 84049
		REV	PAGE 3

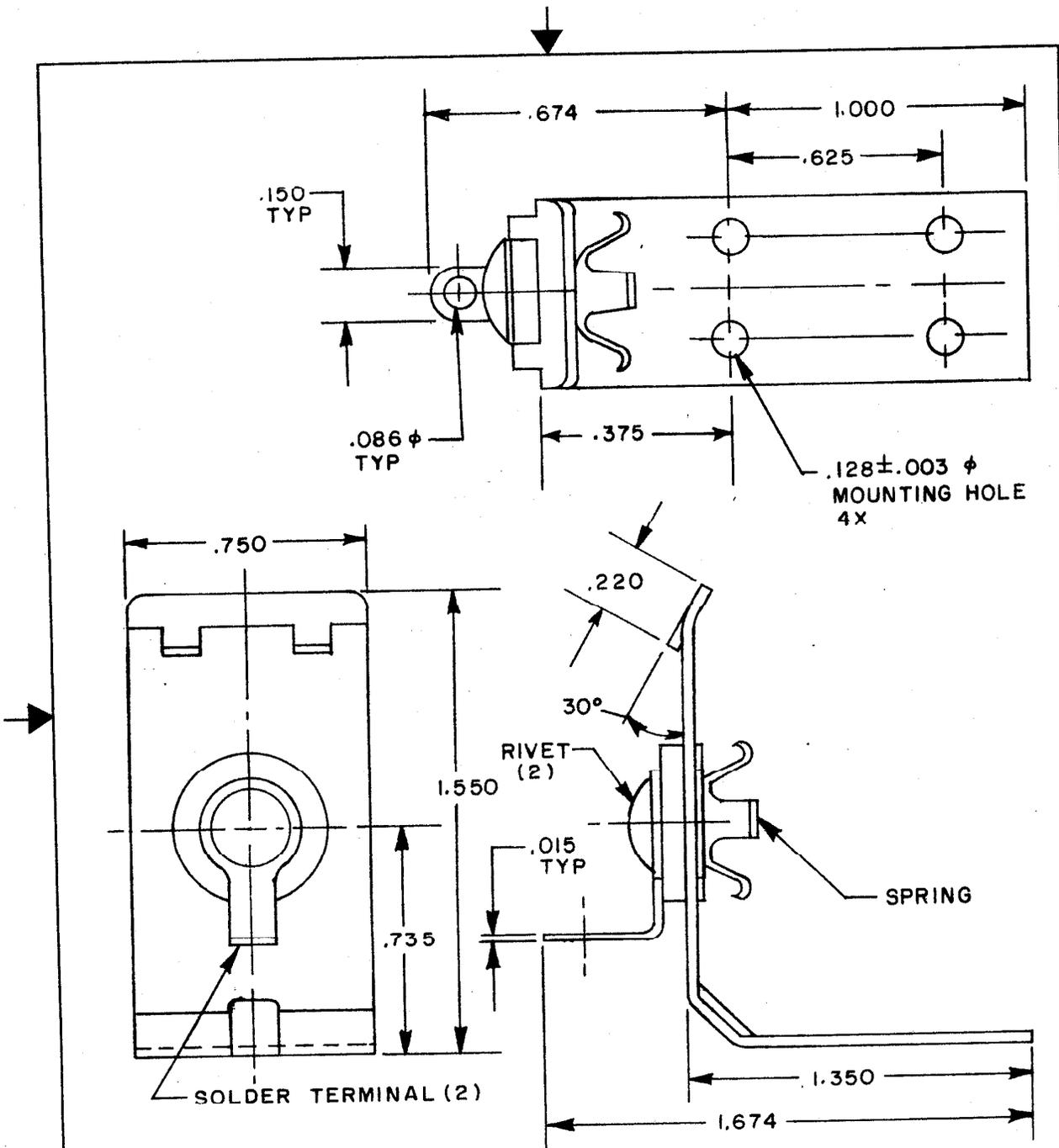


FIGURE 1. Configuration and dimensions for dash nos. -01 and -02.

DEFENSE ELECTRONICS SUPPLY CENTER DAYTON, OHIO	SIZE A	CODE IDENT. NO. 14933	DWG NO. 84049
		REV	PAGE 4

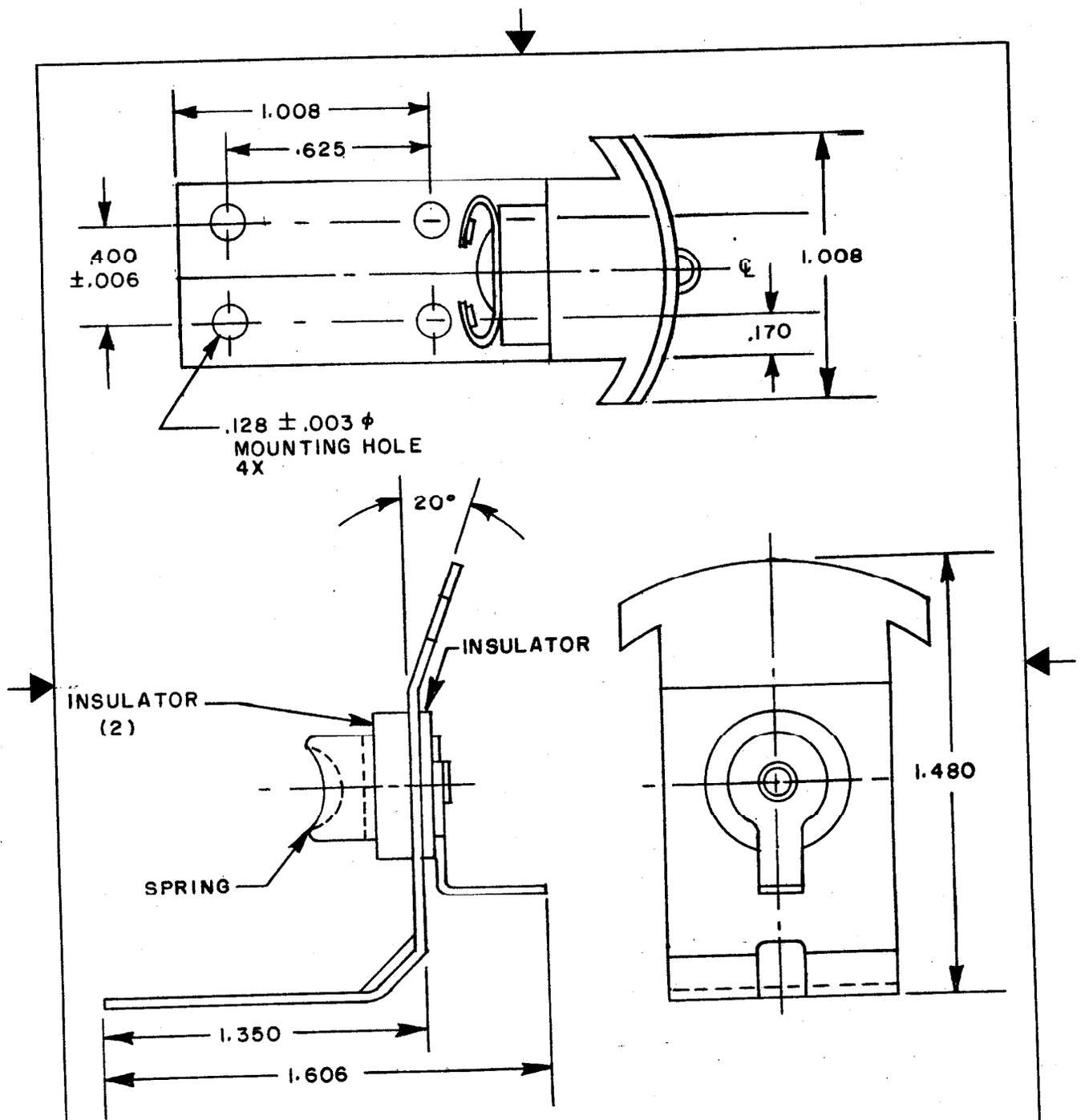


FIGURE 1. Configuration and dimensions for dash nos. -01 and -02 - Continued.

DEFENSE ELECTRONICS SUPPLY CENTER DAYTON, OHIO	SIZE A	CODE IDENT. NO. 14933	DWG NO. 84049
		REV	PAGE 5

INCHES	MM	INCHES	MM
.003	.076	.735	18.67
.006	.15	.750	19.05
.015	.381	1.000	25.40
.086	2.18	1.008	25.60
.128	3.25	1.350	34.29
.150	3.81	1.480	37.60
.170	4.32	1.550	39.37
.375	9.53	1.606	40.79
.400	10.16	1.674	42.52
.625	15.88		
.674	17.12		

NOTES:

1. Dimensions are in inches.
2. Metric equivalents are given for general information only.
3. Unless otherwise specified, tolerances shall be ± 0.005 .
4. Both halves of configuration are supplied for each dash number.

FIGURE 1. Configuration and dimensions for dash nos. -01 and -02 - Continued.

DEFENSE ELECTRONICS SUPPLY CENTER DAYTON, OHIO	SIZE A	CODE IDENT. NO. 14933	DWG NO. 84049
		REV	PAGE 6

4.5 Quality conformance inspection.

4.5.1 Inspection of product for delivery. Inspection of product for delivery shall consist of the group A inspection.

4.5.1.1 Group A inspection. Group A inspection shall consist of the inspections specified in table II in the order shown.

4.5.1.1.1 Sampling plan. Statistical sampling and inspection shall be in accordance with MIL-STD-105 for general inspection level II. The Acceptable Quality Level (AQL) shall be as specified in table I. Major and minor defects shall be as specified in MIL-STD-105.

4.6 Methods of inspection.

4.6.1 Visual and dimensional inspection. Battery holders shall be examined to verify that the design, construction, physical dimensions, marking, and workmanship are in accordance with the applicable requirements (see 3.1, 3.2, 3.3, 3.6, and 3.7).

4.6.2 Mounting surface flatness (see 3.4). Mounting surface flatness shall be measured in accordance with ANSI B46.1.

4.6.3 Surface roughness (see 3.5). Mounting surface roughness shall be measured in accordance with ANSI B46.1.

5. PACKAGING

5.1 Packaging requirements. Packaging shall be as commercial practice unless otherwise specified on the purchase order.

6. NOTES

6.1 Intended use. Devices conforming to this drawing are intended for use when military specifications do not exist and qualified military devices that will perform the required function are not available for OEM application.

6.2 Ordering data. The contract or purchase order should specify the following:

- a. Complete part number (see 1.2).
- b. Requirements for delivery of one copy of the quality conformance inspection data with each shipment of parts by the manufacturer (when applicable, see 4.1.2).
- c. Whether the manufacturer performs the group A inspection or provides a certificate of compliance with group A requirements.
- d. Requirements for notification of change in product to procuring activity, if applicable.

TABLE II. Group A inspection.

Inspection	Requirement paragraph	AQL (percent defective)	
		Major	Minor
Visual and mechanical examinations		1.0	4.0
Dimensions	3.2	"	"
Surface flatness	3.4 4.6.2	"	"
Surface roughness	3.5 4.6.3	"	"
Marking	3.6	"	"
Workmanship	3.7	"	"

DEFENSE ELECTRONICS SUPPLY CENTER DAYTON, OHIO	SIZE A	CODE IDENT. NO. 14933	DWG NO. 84049
		REV	PAGE 7

6.3 Replaceability. Replaceability is determined as follows:

Devices covered by this drawing will replace the same commercial device covered by contractor prepared specification or drawing.

6.4 Suggested source of supply. 1/

DESC drawing part number	Vendor FSCM and part number 2/
84049-01 -02	53373 94-400-1008-01-02-00

1/ Additional suggested sources of supply will be added as they become available. For assistance in the use of this drawing, contact DESC-E, 1507 Wilmington Pike, Dayton, OH 45444, or telephone (513) 296-6511.

2/ CAUTION. Do not use this number for item procurement and marking. The similar vendor type may not satisfy the requirements of this drawing.

Vendor FSCM

53373

Vendor

MIDLAND ROSS/CAMBION DIVISION

DEFENSE ELECTRONICS SUPPLY CENTER
DAYTON, OHIO

SIZE
A

CODE IDENT. NO.
14933

DWG NO.

84049

REV

PAGE 8