

MIL-A-2550B  
AMENDMENT 1  
24 April 1973

**MILITARY SPECIFICATION**  
**AMMUNITION, GENERAL SPECIFICATION FOR**

This Amendment forms a part of Military Specification MIL-A-2550B, dated 8 February 1973, and is mandatory for use by all Departments and Agencies of the Department of Defense.

To paragraph 2.1 on Page 1, under "STANDARDS, MILITARY", add:

"MIL-STD-1168 - Lot Numbering of Ammunition"

Paragraph 2.2 on Page 2, under USA STANDARDS, delete "ASA B 46.1" and substitute "USAS B 46.1".

Remove the original Page 3 and insert the corrected Page 3 attached.

**Custodians:**

Army - MU  
Navy - OS  
Air Force - 70

**Review Activities:**

Army - MI  
Navy - AS

**User Activities:**

Navy - MC

**Preparing Activity:**

Army - MU(PA)

Project Number: 1395-0-002

FSC: 1395

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3.3 Sub-Contracts.-The contractor shall be responsible for the compliance with all requirements of the contract, the drawings, and specifications on the part of his sub-contractors, including those who supply raw materials. Evidence of such compliance shall be supplied by the contractor.

3.4 Use of Government Drawings and Specifications.-The contractor shall work to the dimensions given on the drawings and the numerical values prescribed by the specifications. In no case shall the drawings be scaled. All toleranced drawing dimensions (other than reference dimensions) and the numerical values cited in the specification requirements are absolute and describe the extreme permissible limits. Unless otherwise specified in this or the detailed specification, the tolerances for untoleranced drawing dimensions shall be  $\pm 1/64$  when given in fractions,  $\pm .010$  when given in decimals and  $\pm 30$  minutes when expressed in degrees. Material deviating from prescribed limits will be considered defective without regard to the extent of the deviation.

3.5 Alternative Materials, Methods and Substitute Standard Designs.-When an alternative material or method is permitted by the drawing or specification, the contractor may select the material or method he will use unless otherwise provided by the Invitation for Bid or Request for Proposal. The contractor shall specify in his bid which alternative he proposes to use and, if for some reason he desires a change to another authorized alternative, prior approval shall be obtained from the procuring activity. Such approval shall be furnished the Government Quality Assurance Representative (QAR) each time a change is made. Designs described on Government drawings as "substitute standard" may not be used without prior approval by the procuring activity.

3.6 Dimensions on Protectively Treated Surfaces.-Except where otherwise specified, dimensional requirements and tolerances shall apply after plating or other surface treatment prescribed, except that when painting or other coating or painting preparative coating (e.g., phosphatizing) is prescribed, the dimensional requirements and tolerances shall apply before application of the primary coating.

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### 3.7 Condition of Materials, Parts and Assemblies.

3.7.1 Surface Finish.--Surfaces shall be finished to the requirements indicated by symbols on the drawing. Standards and classes of surface finish shall be in accordance with American Standard USAS-B46.1.

3.7.2 Intersection of Surfaces.--All intersections of surfaces shall be free of burrs, slivers or feather edges. Unless otherwise specified, intersections of surfaces shall be rounded as follows:

Fillets	.01 inch radius, maximum (max.)
Corners	.02 inch radius, max. or .02 inch by 45° chamfer, max.

3.7.3 Materials.--All materials shall be free from dirt, rust, corrosion, grease, chips or other foreign matter. Materials shall be free from extraneous porosity, cavitation, warp, laps, cracks, inclusions, pits, voids or other injurious defects.

3.7.4 Parts and Assemblies.--All parts and assemblies shall be sound, of uniform quality and condition and free from seams, cracks, nicks, warp, obstructions, inclusions, scratches, dents, scrapes, gouges, holes, voids, porous areas, distortion, laps, pits, rust, corrosion or other injurious defects or blemish. Cleaning shall be thorough to remove all dirt, chips, grease, oil, flux, residues, chemical deposits or other foreign matter; and shall not be injurious to any part, nor shall the parts be contaminated by the cleaning agents.

3.8 Threads.--Threads shall be in accordance with MIL-STD-9.

3.9 Drilled Holes.

3.9.1 Tolerance.--Where a drilled hole is shown on the drawing and is dimensioned only by drill or letter reference or by linear dimension without a stated tolerance, the tolerance shall be that listed in Table I.