

**CONFIGURATION CONTROL BOARD DIRECTIVE (CONTINUED)**

**10. REMARKS (CONT)**

- a. **CCB BOARD RECOMMENDATION W/RATIONALE:** Approve as modified. This engineering change proposal (ECP) is a follow-up to ECP L3S3124. This action affects four drawings (D12524488, SQ12524488, D12524489, and SQ12524489) in which the Nitride Zone was incorrectly stated as 38.3 MIN when it should have been 38.3 MAX. This change does not affect the form, fit, or function of the M242 25mm Automatic Gun.
- b. **MODIFICATIONS/CORRECTIONS:** The 45.5 dimension was changed to a reference dimension on all NOR's.
- c. **QAP CHANGES NEEDED/INCLUDED:** None
- d. **TMs AFFECTED** None
- e. **OTHER SYSTEMS AFFECTED** None
- f. **FINANCIAL REQUIREMENTS:** \$                      **EXPLAIN:** None
- g. **SCHEDULE IMPACT:** None
- h. **CONTRACTS AFFECTED:** None
- i. **IMPLEMENTATION INSTRUCTIONS:** The approved ECP shall be sent to the drawing custodian (Picatinny-Building 12) for incorporation.
  - OPTIONAL**
  - MANDATORY**
    - WITHOUT**    **WITH OBSOLESCENCE**
    - NO COST**    **COST NTE \$**
  - FIRST ARTICLE TEST/INSPECTION RECOMMENDED**
- j. **READINESS IMPACT:** None
- k. **EOD IMPACT:** None
- l. **VE SAVINGS:** None
- m. **RATIONALE/CALCULATION FOR COST CONCESSION (RFW) OR CONTRACTUAL COST ADJUSTMENT (RFD, ECP, VECP):**  
**TOTAL \$            +            %    EXPLAIN:** None
- n. **OZONE DEPLETING SUBSTANCE ELIMINATED:** YES  NO
- o. **MTCR RELEASIBILITY IMPACTED:** YES  NO  IF YES, EXPLAIN:
- p. **ENGINEERING MODELS / SIMULATIONS AFFECTED?** YES  NO  IF YES, EXPLAIN:

*Attached doc*

## Affected Drawings

<b>Drawing Number</b>	<b>Drawing Name</b>	<b>Drawing Revision</b>	<b>NOR</b>
D12524488	Bridge, Lower Link Stripper	D	001
SQ12524488	Quality Assurance Requirement Bridge, Lower Link Stripper	B	002
D12524489	Bridge, Upper Link Stripper	D	003
SQ12524489	Quality Assurance Requirement Bridge, Upper Link Stripper	B	004

**All Drawings have ECP L3S3124 Outstanding**

**CONFIGURATION CONTROL BOARD DIRECTIVE (CONTINUED)**

Page 2 of 2

CONTROL NO.  
**L3S3124****10. REMARKS (CONT)**

- a. **CCB BOARD RECOMMENDATION W/RATIONALE:** Approve as Modified. See Attached Rationale
- b. **MODIFICATIONS/CORRECTIONS:** Block Six of all the NOR's are to be labeled in a numeric sequence as shown. NOR number 4 block twelve is to be changed from "1 of 1" to "5 of 5". Nor 1 and NOR 2 dimension 38.3 MAX should be changed to 38.3 MIN per the enclosed email from Catherine Macey. Nor 4 should have the corrections numbered from 1, 2, 3, ..., 5 instead of 6, 7, 8, ..., 10. NOR 3 and 4 change one should be changed from "1. Revise Sheet 1: Delete: MIL-STD-171" to "1. Revise Sheet 1: Delete: MIL-STD-171, Replace with MIL-L-3150". All NOR's are changed in the surface hardness for Heat Treatment to be in the range of Rockwell C40-C46 rather than the C40 MIN that was previously called out. All changes have been made to the respective NOR's.
- c. **QAP CHANGES NEEDED/INCLUDED:** SQ12524488 and SQ12524489 -
- d. **TMs AFFECTED** None
- e. **OTHER SYSTEMS AFFECTED** None
- f. **FINANCIAL REQUIREMENTS:** \$      **EXPLAIN:** None
- g. **SCHEDULE IMPACT:** None
- h. **CONTRACTS AFFECTED:** N/A
- i. **IMPLEMENTATION INSTRUCTIONS:** The approved ECP shall be sent to the drawing custodian (Picatinny-Building 12) for incorporation.
- OPTIONAL**
- MANDATORY**
- WITHOUT**     **WITH OBSOLESCENCE**
- NO COST**     **COST NTE \$**
- FIRST ARTICLE TEST/INSPECTION RECOMMENDED**
- j. **READINESS IMPACT:** None
- k. **EOD IMPACT:** None
- l. **VE SAVINGS:** None
- m. **RATIONALE/CALCULATION FOR COST CONCESSION (RFW) OR CONTRACTUAL COST ADJUSTMENT (RFD, ECP, VECP):**
- TOTAL \$      %    EXPLAIN:**
- n. **OZONE DEPLETING SUBSTANCE ELIMINATED:** YES  NO
- o. **MTCR RELEASIBILITY IMPACTED:** YES  NO  IF YES, EXPLAIN:
- p. **ENGINEERING MODELS / SIMULATIONS AFFECTED?** YES  NO  IF YES, EXPLAIN:

CCL-PM

<b>ENGINEERING CHANGE PROPOSAL</b> <b>(SHORT FORM)</b>  <i>(See MIL-STD-481 for instructions)</i>	DATE (YYYYMMDD) 20030826	Form Approved OMB No. 0704-0188
	<b>PROCURING ACTIVITY NUMBER</b>  L3S3124	

The public burden for this collection of information is estimated to average 2 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing the burden, to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports (5704-0188), 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302. Respondents should be aware that notwithstanding any other provision of law, no person shall be subject to any penalty for failing to comply with a collection of information if it does not display a currently valid OMB control number. PLEASE DO NOT RETURN YOUR FORM TO THIS ADDRESS.

<b>1. ORIGINATOR NAME AND ADDRESS</b> Catherine D. Macey TACOM, AMSTA-LC-CSA-L 1 Rock Island Arsenal Rock Island, IL 61298-7630	<b>2. CONTRACT NUMBER AND LINE ITEM</b>
	<b>3. PROCURING CONTRACTING OFFICER</b>  CODE _____ TEL _____

<b>4. TITLE OF CHANGE</b> Redefine Nitride Zone on M242 Feeder Bridges	<b>5. ECP NUMBER</b> CSAL03-01	<b>6. REV</b>	<b>7. AMEND</b>	<b>8. CAGE CODE</b> 18200	<b>9. CLASS OF ECP</b> II	<b>10. JUST CODE</b> O	<b>11. PRIORITY</b> R
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10. SPECIFICATIONS AFFECTED			11. DRAWINGS AFFECTED		
CAGE CODE	SPECIFICATION / DOCUMENT NO.	REV	CAGE CODE	NUMBER	REV
			18200	D12824488	D
			18200	D12824489	D
			18200	QC12824488	B
			18200	QC12824489	B

<b>12. CONFIGURATION ITEM NOMENCLATURE / TYPE DESIGNATION / WEAPON SYSTEM CODE</b> M242 25 mm Automatic Cannon	<b>13. IN PRODUCTION</b>  <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
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<b>14. LOWEST ASSEMBLY AFFECTED</b> NOMENCLATURE Feeder Assembly	PART NO. 12824100	NSN 1005-01-105-0191
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<b>15. DESCRIPTION OF CHANGE</b> <ol style="list-style-type: none"> <li>To reduce Nitride hardening zone to 45.5 mm minimum area that contacts the ammunition link during firing.</li> <li>Heat treatment specification MIL-H-6875 has been cancelled and superseded by SAE AMS-H-6875.</li> <li>Specification MIL-S-29843 has been cancelled and superseded by SAE AMS 5528.</li> <li>To update Quality Assurance Requirements to reflect proper inspection requirements.</li> </ol>	90 JUN 2003 6-27-03
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<b>16. NEED FOR CHANGE</b> Change is required to allow maximum flexibility in the manufacturing techniques necessary to produce these components to drawings requirements, while maintaining warping and distortion.
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<b>17. EFFECT ON ASSOCIATED EQUIPMENT</b> None
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<b>18. PRODUCTION EFFECTIVITY BY SERIAL NUMBER</b> None	<b>19. EFFECT ON PRODUCTION DELIVERY SCHEDULE</b> None
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<b>20. RECOMMENDED RETROFIT EFFECTIVITY</b> None	<b>21. ESTIMATED KIT DELIVERY SCHEDULE</b> None	<b>22. ESTIMATED COST/SAVINGS</b> None
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<b>23. SUBMITTING ACTIVITY AUTHORIZING SIGNATURE</b> 	<b>23.a. TITLE</b> General Engineer
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<b>24. APPROVAL/DISAPPROVAL</b> <input checked="" type="checkbox"/> APPROVED <input type="checkbox"/> DISAPPROVED	<b>25. GOVERNMENT ACTIVITY</b> TACOM-ARDEC, AMSTA-AR-OCLF	<b>SIGNATURE</b>  Ronald E. Ego Chief, CCAC Prod & Flow Opt Team	<b>DATE (YYYYMMDD)</b> 20030908
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NOTICE OF REVISION (NOR)		1. DATE (YYMMDD)	Form Approved OMB No. 0704-0188
THIS REVISION DESCRIBED BELOW HAS BEEN AUTHORIZED FOR THE DOCUMENT LISTED.		030528	2. PROCURING ACTIVITY NUMBER L353124
Public reporting burden for this collection of information is estimated to average 2 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden to Department of Defense, Washington Headquarters Services Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302 and to the Office of Management and Budget, Paperwork Reduction Project (0704-0188) Washington, DC 20503. PLEASE DO NOT RETURN YOUR COMPLETED FORM TO EITHER OF THESE ADDRESSES. RETURN COMPLETED FORM TO THE GOVERNMENT ISSUES CONTRACTING OFFICER FOR THE CONTRACT / PROCURING ACTIVITY NUMBER LISTED IN ITEM 2 OF THIS FORM.		3. DODAAC	
4. ORGANIZATION	5. ADDRESS (Street, City, State, Zip Code)	5. CASE CODE	6. NOR NO.
a. TYPED NAME (First, Middle Initial, Last) Catherine D. Macey	TACOM, AMSTA-LC-CBA-L 1 Rock Island Arsenal Rock Island, IL 61299-7630	7. CASE CODE 19200	8. DOCUMENT NO. D12824488
9. TITLE OF DOCUMENT BRIDGE, LOWER LINK STRIPPER	10. REVISION LETTER a. CURRENT D	b. NEW E	11. ECP NO. CSAL03-01
12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES M242 25 mm AUTOMATIC CANNON			Sheet of 2 of 5
13. DESCRIPTION OF REVISION			
1. Change note 9			
Is: <input checked="" type="checkbox"/> NITRIDE HARDEN PER DWG NO 12524650, CASE DEPTH 0.15 TO 2.0 (0.006 TO 0.008 INCHES). CASE HARDNESS 15N 92 MIN (ROCKWELL C85). APPLIES TO 45.5 MIN THIS SIDE. ALL OTHER SURFACES OPTIONAL.			
was: 9. NITRIDE HARDEN PER DWG NO 12524650, CASE DEPTH 0.15 TO 2.0 (0.006 TO 0.008 INCHES). CASE HARDNESS 15N 92 MIN (ROCKWELL C85).			
2. Change note 3			
Is: ALTERNATIVE MATL: 17-7 PH CRES SHEET OR STRIP PER AMS 5528 (Rockwell C40-C46 Per AMS 2759/30)			
a. HEAT TREAT AFTER FORMING TO CONDITION TH1050 OR RH1050 PER SAE AMS-H-6875 (Rockwell C40 MIN).			
was: ALTERNATIVE MATL: 17-7 PH CRES SHEET OR STRIP PER MIL-8-25043			
A. HEAT TREAT AFTER FORMING TO CONDITION TH1050 OR RH1050 PER MIL-H-6875 (ROCKWELL C40 MIN).			
3. REVISE PRINT ZONE 4G AS FOLLOWS:			
4. CHANGE NOTE 2 was: ... TO CONDITION TH1050 OR RH1050 PER MIL-H-6875 (Rockwell C40 MIN). 15: ... TO CONDITION TH1050 OR RH1050 PER SAE AMS-H-6875 (ROCKWELL C40-C46 PER AMS 2759/30)			
14. THIS SECTION FOR GOVERNMENT USE ONLY			
a. (X one)	<input checked="" type="checkbox"/>	(1) Existing document supplemented by this NOR may be used in manufacture.	
	<input type="checkbox"/>	(2) Revised document must be received before manufacture may incorporate this change.	
	<input type="checkbox"/>	(3) Custodian of master document shall make above revision and furnish revised document.	
b. ACTIVITY AUTHORIZED TO APPROVE CHANGE FOR GOVERNMENT TACOM-ARDEC, AMSTA-AR-CCL-F		c. TYPED NAME (First, Middle Initial, Last)	
Richard E. Elbe Chief, CCAC Prod & Field Spt Team		[Signature]	
15a. ACTIVITY ACCOMPLISHING REVISION		b. REVISION COMPLETED (Signature)	f. DATE SIGNED 20030908

NOTICE OF REVISION (NOR)		1. DATE (YYMMDD)	Form Approved OMB No. 0704-0188
THIS REVISION DESCRIBED BELOW HAS BEEN AUTHORIZED FOR THE DOCUMENT LISTED.		030025	2. PROCURING ACTIVITY NUMBER <b>L3S3124</b>
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4. ORIGINATOR		5. CAGE CODE	6. NOR NO.
a. TYPED NAME (First, Middle Initial, Last)	b. ADDRESS (Street, City, State, Zip Code)	7. CAGE CODE	8. DOCUMENT NO.
Catherine D. Macey	TACOM, AMSTA-LC-CSA-L 1 Rock Island Arsenal Rock Island, IL 61290-7830	18200	D12924488
9. TITLE OF DOCUMENT	10. REVISION LETTER		11. BCP NO.
BRIDGE, UPPER LINK STRIPPER	a. CURRENT D	b. NEW E	CSAL03-01
12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH BCP APPLIES			Sheet of 3 of 5
M242 25 mm AUTOMATIC CANNON			
13. DESCRIPTION OF REVISION			
3. Change note 9			
is: <b>9</b> NITRIDE HARDEN PER DWG NO 12524580, CASE DEPTH 0.15 TO 2.0 (0.006 TO 0.008 INCHES). CASE HARDNESS 15N 92 MIN (ROCKWELL C85). APPLIES TO 45.5 MIN THIS SIDE. ALL OTHER SURFACES OPTIONAL.			
was: 9. NITRIDE HARDEN PER DWG NO 12524580, CASE DEPTH 0.15 TO 2.0 (0.006 TO 0.008 INCHES). CASE HARDNESS 15N 92 MIN (ROCKWELL C85).			
4. Change note 3			
is: ALTERNATIVE MATL: 17-7 PH CRES SHEET OR STRIP PER AMS 5528 (ROCKWELL C40-C46 PER AMS 2759(3C)).			
a. HEAT TREAT AFTER FORMING TO CONDITION TH1050 OR RH1050 PER SAE AMS-H-6875 (ROCKWELL C40 MIN).			
was: ALTERNATIVE MATL: 17-7 PH CRES SHEET OR STRIP PER MIL-S-28043			
A. HEAT TREAT AFTER FORMING TO CONDITION TH1050 OR RH1050 PER MIL-H-6875 (ROCKWELL C40 MIN).			
3. REVISE PRINT ZONE 4G AS FOLLOWS:			
4. CHANGE NOTE 2 was: 2. TO CONDITION TH1050 OR RH1050 PER MIL-H-6875 (ROCKWELL C40 MIN). is: 2. TO CONDITION TH1050 OR RH1050 PER SAE AMS-H-6875 (ROCKWELL C40-C46 PER AMS 2759(3C)).			
14. THIS SECTION FOR GOVERNMENT USE ONLY			
a. (X one)	(1) Existing document supplemented by this NOR may be used in manufacture.		
	(2) Revised document must be received before manufacture may incorporate this change.		
	(3) Custodian of master document shall make above revision and furnish revised document.		
b. ACTIVITY AUTHORIZED TO APPROVE CHANGE FOR GOVERNMENT		c. TYPED NAME (First, Middle Initial, Last)	
TACOM-ARDEC, AMSTA-AR-CCL-F			
d. SIGNATURE Ronald E. Elbe Chief, CCAC Prod & Field Spt Team		f. DATE SIGNED 2003 09 08	
15a. ACTIVITY ACCOMPLISHING REVISION		g. DATE SIGNED	
b. REVISION COMPLETED (Signature)			

<b>THIS SECTION FOR GOVERNMENT USE ONLY</b> Public reporting burden for this collection of information is estimated to average 2 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302 and to the Office of Management and Budget, Paperwork Reduction Project (8704-0188) Washington, DC 20503. <b>PLEASE DO NOT RETURN YOUR COMPLETED FORM TO EITHER OF THESE ADDRESSES. RETURN COMPLETED FORM TO THE GOVERNMENT ISSUES CONTRACTING OFFICER FOR THE CONTRACT / PROCURING ACTIVITY NUMBER LISTED IN ITEM 2 OF THIS FORM.</b>		1. DATE (YYMMDD) 030826	Form Approved OMB No. 8704-0188
2. PROCURING ACTIVITY NUMBER <b>L3S3124</b>		3. DODAAC	
4. CONTRACTOR	5. CAGE CODE	6. NOR NO.	
a. TYPED NAME (First, Middle Initial, Last) Catherine D. Macey	b. ADDRESS (Street, City, State, Zip Code) TACOM, AMSTA-LC-CSA-L 1 Rock Island Arsenal Rock Island, IL 61288-7830	3	
7. CAGE CODE 18200		8. DOCUMENT NO. 8Q12824488	
9. TITLE OF DOCUMENT QUALITY ASSURANCE REQUIREMENT - BRIDGE, LOWER LINK STRIPPER	10. REVISION LETTER		11. ICP NO. CSAL03-01
a. CURRENT B		b. NEW C	
12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES M242 28 mm AUTOMATIC CANNON			Sheet of 4 of 5
13. DESCRIPTION OF REVISION			
1. Revise Sheet 1: Delete MIL-STD-171, <b>REPLACE WITH MIL-L-3160</b>			
2. Revise Sheet 1: Is: SAE AMS-H-6875 Was: MIL-H-6875			
3. Revise Sheet 3 CHARACTERISTIC: Is: HARDNESS AFTER FORMING HEAT TREAT TO CONDITION TH1050 OR RH1050 PER SAE AMS-H-6875 <del>(ROCKWELL C40 MIN)</del> (ROCKWELL C40-C44 PER AMS 2759/3C). Was: HARDNESS AFTER FORMING HEAT TREAT TO CONDITION TH1000 PER MIL-H-6875 (ROCKWELL C44 MIN)			
4. Revise Sheet 4 Note: Is: 301. RC 40 min <sup>RC40-RC46</sup> Was: HARDNESS TH1000 (RC 44 min)			
5. Add drawing to Sheet 4 as follows: <b>302. HARDNESS TEST RC 65 MIN</b>			
14. THIS SECTION FOR GOVERNMENT USE ONLY			
a. (X one)	<input checked="" type="checkbox"/>	(1) Existing document supplemented by this NCR may be used in manufacture.	
	<input type="checkbox"/>	(2) Revised document must be received before manufacture may incorporate this change.	
	<input type="checkbox"/>	(3) Custodian of master document shall make above revision and furnish revised document.	
b. ACTIVITY AUTHORIZED TO APPROVE CHANGE FOR GOVERNMENT TACOM-ARDEC, AMS1A-AR-CCL-F		c. TYPED NAME (First, Middle Initial, Last)	
d. TITLE Ronald E. Etbe Chief, CCAC Prod & Field Spt Team	e. SIGNATURE 	f. DATE SIGNED 2003 09 08	
15a. ACTIVITY ACCOMPLISHING REVISION	b. REVISION COMPLETED (Signature)	c. DATE SIGNED	

NOTICE OF REVISION (NOR)		1. DATE (YYMMDD)	Form Approved OMB No. 0704-0188
<b>THIS REVISION DESCRIBED BELOW HAS BEEN AUTHORIZED FOR THE DOCUMENT LISTED.</b>		030625	
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PLEASE DO NOT RETURN YOUR COMPLETED FORM TO EITHER OF THESE ADDRESSES. RETURN COMPLETED FORM TO THE GOVERNMENT ISSUING CONTRACTING OFFICER FOR THE CONTRACT / PROCURING ACTIVITY NUMBER LISTED IN ITEM 2 OF THIS FORM.		3. <b>DODAAC</b>	
4. <b>ORIGINATOR</b>		6. <b>NOR NO.</b>	
a. <b>TYPED NAME (First, Middle Initial, Last)</b> Catherine D. Macey	b. <b>ADDRESS (Street, City, State, Zip Code)</b> TACOM, AMSTA-LC-CSA-L 1 Rock Island Arsenal Rock Island, IL 61299-7630	4	
		7. <b>CAGE CODE</b> 18200	
8. <b>TITLE OF DOCUMENT</b> QUALITY ASSURANCE REQUIREMENT - BRIDGE, UPPER LINK STRUPPER		8. <b>DOCUMENT NO.</b> SQ12524488	
9. <b>REVISION LETTER</b>		11. <b>ECP NO.</b>	
a. <b>CURRENT</b> B		b. <b>NEW</b> C	
		CSAL03-01	
12. <b>CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES</b> M242 25 mm AUTOMATIC CANNON			Sheet of 5 of 5
13. <b>DESCRIPTION OF REVISION</b>			
1. <b>Revise Sheet 1:</b> Deletes MIL-STD-171, REPLACE WITH MIL-L-3150			
2. <b>Revise Sheet 1:</b> Is: SAE AMS-H-6875 Was: MIL-H-6875			
3. <b>Revise Sheet 3 CHARACTERISTIC:</b> Is: <b>HARDNESS AFTER FORMING HEAT TREAT TO CONDITION TH1050 OR RH1050 PER SAE AMS-H-6875 (ROCKWELL C40 MIN) (ROCKWELL C40-C46 PER AMS 2759/3C).</b> Was: <b>HARDNESS AFTER FORMING HEAT TREAT TO CONDITION TH1000 PER MIL-H-6875 (ROCKWELL C44 MIN)</b>			
4. <b>Revise Sheet 4 Note:</b> Is: 301. <b>HARDNESS TH1050 or RH1050 (RC 40 min) (RC 40 - RC 46)</b> Was: <b>HARDNESS TH1000 (RC 44 min)</b>			
5. <b>Add drawing to Sheet 4 as follows:</b> 302. <b>HARDNESS TEST RC 65 MIN</b>			
14. <b>THIS SECTION FOR GOVERNMENT USE ONLY</b>			
a. (X one)	%	(1.) Existing document supplemented by this NOR may be used in manufacture.	
		(2.) Revised document must be received before manufacture may incorporate this change.	
		(3.) Custodian of master document shall make above revision and furnish revised document.	
b. <b>ACTIVITY AUTHORIZED TO APPROVE CHANGE FOR GOVERNMENT</b> TACOM-ARDEC, AMSTA-AR-CCL-F		c. <b>TYPED NAME (First, Middle Initial, Last)</b>	
d. <b>TITLE</b> Ronald E. Elbe Chief, CCAC Prod & Field Spt Team		e. <b>SIGNATURE</b> 	f. <b>DATE SIGNED</b> 20030908
15a. <b>ACTIVITY ACCOMPLISHING REVISION</b>		b. <b>REVISION COMPLETED (Signature)</b>	c. <b>DATE SIGNED</b>

## Technical Evaluation

**Nor 1:**

Document Number: D12524488

Evaluation:

1. This change does not affect the Nitriding Process instead it is changing the required areas for Nitriding. By reducing the required Nitriding Zone to only the 45.5 MIN area it will allow the producer flexibility in their process while still assuring that the area that contacts the ammunition link is still surface hardened.
2. MIL-H-6875 is currently superceded by SAE-AMS-6875.
3. The modifications in this change address the manufactureability issues posed with the current Nitriding process. This drawing calls-out the possible areas of Nitriding with the only required Nitriding area associated with the 38.3 MIN dimension and note 9. This change also cleans up the drawing.

**Nor 2:**

Document Number: D12524489

Evaluation: See NOR 1

**Nor 3:**

Document Number: SQ12524488

Evaluation:

1. This change involves deleting MIL-STD-171 from this QAP. MIL-STD-171 is not utilized anywhere else in this QAP nor is it utilized on drawing 12524488.
2. MIL-H-6875 is superceded by AMS-H-6875.
3. MIL-H-6875 is superceded by AMS-H-6875 also the steel is to be tempered to conditions TH1050 and RH1050 hardness Rockwell C40. These changes reflect what is stated on drawing 12524488.
4. This change deletes the characteristic call-out and replaces it with the characteristic number that is referenced on page three.
5. The added drawing spells out in detail the required areas for Nitriding.

**Nor 4:**

Document Number: SQ12524488

Evaluation:

1. See NOR 3
2. See NOR 3
3. See NOR 3
4. See NOR 3
5. See NOR 3