SUPPLEMENTARY QUALITY ASSURANCE PROVISIONS	SQAP	11697472
		Sheet 1 of 2
FOR Drive Assembly, Electric	DWG NO.	F11697472
USED ON Armament Subsystem, Helicopter, 7.62MM Machine Gun HI-Rate: XM27E1	DEPT OF THE ARMY ROCK ISLAND ARSENAL	
	CODE IDENT NO. 19204	

PART I - LIST OF APPLICABLE DOCUMENTS

NUMBER	NOMENCLATURE
F11697472	Drive Assembly, Electric
SQAP-APPENDIX-RIA	General Supplementary Quality Assurance Provisions

PART II - EXAMINATION PROVISIONS

CLASS	CHARACTERISTIC	AQL	INSPECTION METHOD
MAJOR			
101.	Torque, Speed and Ampere Test	1.0	STM-1
102.	Dielectric Voltage Test	1.0	STM-2
103.	Incorrect Assembly or Missing Parts	1.0	Visual
104.	.005 Diameter True Position of .265 Mounting Holes	1.0	SME
MINOR			
201.	Defective or Missing Protective Coating	2.5	Visual
202.	Incorrect or Missing Part Number	4.0	Visual
203.	Workmanship	4.0	Visual

PART III - CERTIFICATION PROVISIONS
(SEE SQAP-APPENDIX-RIA)

PART IV - TEST METHODS AND PROCEDURES
(REFERENCE STM-1 AND STM-2 PART II)

1. Using Standard Test Equipment, check for the following requirements at a temperature between 50 and 90° F. (The Data shall be taken in the first 10 seconds of motor operation)

(a) For Low speed, at a voltage of 25 ± .1 VDC, the motor shall produce a torque of 20 ± .25 IN-LBS at speeds between 1550 and 1875 RPM and a maximum operating current of 37 amperes.

(b) For High speed, at a voltage of 24 ± .1 VDC, the motor shall produce a torque of 25 ± IN-LBS at a speed between 3300 and 3750 RPM and a maximum operating current of 78 amperes.

NOR NO.	REVISION DATA			
	SQAP	REV	DWG	REV
	30 JUL 69	ORIG		
76G0203-4000	17 NOV 76	C	24 APR 69	E

PREPARED SARRI-LE-Q

SUBMITTED L. Spainhower

APPROVED W. M. Lowry

SARRI Form 623 1 AUG 75

ERR NO.	SQAP	REV	DWG	REV	ERR NO.	SQAP	REV	DWG	REV
	30 JUL 69	ORIG							
76G0203-									
4000	17 NOV 76	C	24 APR 69	E					

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DEPT OF THE ARMY ROCK ISLAND ARSENAL	
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2. Dielectric withstanding voltage test (High Potential); The motor shall show no evidence of breakdown when tested with a potential of 500 volts RMS A.C. applied between the case and winding at ambient temperature in accordance with MIL-STD-202, Method 301.