

GENERAL ELECTRIC

A 7819478

REV. NO. A	7819478	TITLE END ITEM SPECIFICATION	COUNT ON SHEET SH NO. 2
CONT ON SHEET SH NO. 2		FIRST MADE FOR	

END ITEM SPECIFICATION
FOR
CABLE ASSEMBLY

UNDERSEA ACOUSTICS SYSTEM ENGINEERING
HEAVY MILITARY ELECTRONICS DEPARTMENT
GENERAL ELECTRIC COMPANY
SYRACUSE, NEW YORK

REVISIONS	

B-11
2256/M
22A1
219C
B2
GR
G1
PHINTS TO

MADE BY <i>R. H. Dooly</i>	ISSUED <i>15 July 1965</i>	APPROVALS <i>R. W. Gardner</i>	DATE <i>9 July 65</i>	HME	OFF OR DEPT. SYRACUSE	LOCATION	CONT ON SHEET A 7819478	SH NO. 2
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FR 482-PA (12-62) PRINTED IN U.S.A. 75 36 CODE IDENT. NO. 03538

GENERAL ELECTRIC

A7819478

REV. NO. D	TITLE	SH. NO. 4																						
A7819478	END ITEM SPECIFICATION																							
SECTION		REVISIONS																						
<p>I. GENERAL INSTRUCTIONS, SPECIFICATIONS</p> <p>1.1 THE SUBCONTRACTOR SHALL BE REQUIRED TO FURNISH PARTS AS ITEMIZED IN SECTION 2 OF THIS SPECIFICATION WHEN SUCH REQUIREMENTS FOR PARTS ARE RELEASED. EACH REQUIRED PART SHALL BE ITEMIZED ON THE PURCHASE ORDER.</p> <p>1.2 THE DOCUMENTS LISTED BELOW IN EFFECT ON THE DATE OF INVITATION FOR BIDS, FORM A REQUIREMENT OF THIS SPECIFICATION. IN CASE OF CONFLICT BETWEEN THIS AND ANY OF THE DOCUMENTS LISTED BELOW AND/OR ANY OF THE MILITARY SPECIFICATIONS REFERENCED, THIS SPECIFICATION SHALL GOVERN.</p> <p>1.2.1 GENERAL ELECTRIC DOCUMENTS</p> <table border="0"> <tr> <td>7023846</td> <td>SPEC. FOR LABELS, PACKING LISTS AND EXTERIOR MARKING.</td> </tr> <tr> <td>7837655</td> <td>ENGINEERING DATA</td> </tr> <tr> <td>7836553</td> <td>ENGINEERING DATA</td> </tr> <tr> <td>7836347</td> <td>CHANGE CONTROL SPECIFICATION</td> </tr> <tr> <td>7837656</td> <td>CONFIGURATION STATUS</td> </tr> <tr> <td>7044074</td> <td>FCRMT FOR SUBCONTRACTORS TEST SPECIFICATION PLUS REQUIREMENT OF MIL-E-16400E PARA. 3.3.3</td> </tr> <tr> <td>770603108</td> <td>TRUNK CABLE OUTLINE DRAWING</td> </tr> <tr> <td>770603109</td> <td>ELEMENT CABLE OUTLINE DRAWING</td> </tr> <tr> <td>7240868</td> <td>COUPLING, CABLE CONNECTOR, MALE</td> </tr> <tr> <td>7240869</td> <td>COUPLING, CABLE CONNECTOR, FEMALE</td> </tr> <tr> <td>7241933</td> <td>DUMMY CONNECTOR, PLUG</td> </tr> </table> <p>1.2.2 APPLICABLE MILITARY SPECIFICATION NOT FURNISHED BY GENERAL ELECTRIC:</p> <p>1.2.2.1 BUSHIPS SPECIFICATION, ELECTRONIC GENERAL MIL-E-16400E AMENDMENT 4.</p> <p>1.3 <u>CHANGES TO PURCHASE SPECIFICATIONS</u></p> <p>1.3.1 THE RESPONSIBLE DESIGN ENGINEERING SECTION OF HME DEPARTMENT, GENERAL ELECTRIC COMPANY SHALL MAKE CHANGES TO THIS PURCHASE SPECIFICATION.</p>		7023846	SPEC. FOR LABELS, PACKING LISTS AND EXTERIOR MARKING.	7837655	ENGINEERING DATA	7836553	ENGINEERING DATA	7836347	CHANGE CONTROL SPECIFICATION	7837656	CONFIGURATION STATUS	7044074	FCRMT FOR SUBCONTRACTORS TEST SPECIFICATION PLUS REQUIREMENT OF MIL-E-16400E PARA. 3.3.3	770603108	TRUNK CABLE OUTLINE DRAWING	770603109	ELEMENT CABLE OUTLINE DRAWING	7240868	COUPLING, CABLE CONNECTOR, MALE	7240869	COUPLING, CABLE CONNECTOR, FEMALE	7241933	DUMMY CONNECTOR, PLUG	<p>REVISED AND RETIRED 36-8716</p> <p>2856M</p> <p>B71</p> <p>B3</p> <p>3GC48</p> <p>PRINTS TO</p>
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MADE BY R.J. DARBY 15082D	APPROVALS AM. CASHMAN 9 JULY 65	HME DEPT SYRACUSE LOCATION																						
5 Dec. 1966		A7819478																						
HME 6844	↑ 7S	3G																						
		CODE IDENT. NO. 03538																						

1.3.2 CHANGE PROCEDURE - EACH CHANGE TO THIS PURCHASE SPECIFICATION AND TO DRAWINGS SHALL BE MADE DIRECTLY. PRICE AND/OR SCHEDULE REVISIONS RESULTING FROM EACH AUTHORIZED CHANGE TO THIS PURCHASE SPECIFICATION MUST BE REFERRED BY THE SUBCONTRACTOR TO THE PURCHASING SECTION, HME DEPARTMENT, ELECTRONICS DIVISION, GENERAL ELECTRIC COMPANY, FOR FINAL DISPOSITION. EACH PRICE AND/OR SCHEDULE REVISION MUST BE SUBMITTED BY THE SUBCONTRACTOR WITHIN 15 DAYS AFTER RECEIPT OF AUTHORIZED CHANGE.

SECTION

2. DEFINITION OF MATERIAL BY PART NUMBERS

- PART 1. TRUNK CABLE ASSEMBLY (SEE OUTLINE DWG. 77D603108P1, FIG. 1)
- PART 2. ELEMENT CABLE ASSEMBLY (SEE OUTLINE DWG. 77D603109, FIG. 1)
- PART 3. ENGINEERING DATA IN ACCORDANCE WITH 7837655P3.
- PART 4. TEST SPECIFICATION IN ACCORDANCE WITH SECTION 5 OF THIS SPECIFICATION.
- PART 5. TEST DATA IN ACCORDANCE WITH SECTION 5 OF THIS SPECIFICATION FOR CABLE PART 1 OR PART 12 WHICHEVER APPLIES.
- PART 9. ENGINEERING DATA IN ACCORDANCE WITH 7837655P2, AND CONFIGURATION STATUS PER 7837656.
- PART 11. TEST DATA IN ACCORDANCE WITH SECTION 5 OF THIS SPECIFICATION FOR ELEMENT CABLE ASSEMBLY, PART 2.
- PART 12. TRUNK CABLE ASSY (SEE OUTLINE DWG. 77D603108P2, FIG. 1)

SECTION

3. GENERAL REQUIREMENTS

THIS SPECIFICATION GOVERNS THE ENGINEERING DESIGN AND PERFORMANCE OF THE PRODUCT (PART OR PARTS) TO BE MANUFACTURED FOR THE HEAVY MILITARY ELECTRONICS DEPARTMENT, GENERAL ELECTRIC COMPANY, SYRACUSE, NEW YORK.

	SIZE	CODE IDENT NO.	
	A	03538	7819478
ISSUED:	SCALE NONE	REV N	SHEET 5

HMEG 9148 P

26A/27A

27A/28A, 29

GENERAL ELECTRIC

A 7819478

KEY NO. A 7819478	TITLE END ITEM SPECIFICATION	CONT. ON SHEET 6	SH. NO. 6
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3.1 THE MATERIALS, PARTS AND PROCESSES EMPLOYED SHALL BE AS SPECIFIED HEREIN AND SHALL CONFORM TO THE REQUIREMENTS OF THIS SPECIFICATION.

3.1.1 THE ENGINEERING AND DESIGN OF THE PRODUCT SHALL BE THE VENDOR'S RESPONSIBILITY, BUT SHALL BE COORDINATED WITH THE SONAR PRODUCT DESIGN SECTION, HEAVY MILITARY ELECTRONICS DEPARTMENT, GENERAL ELECTRIC COMPANY, FARRELL ROAD PLANT, SYRACUSE, NEW YORK.

3.2 DESIGN CONCEPT APPROVAL - THE SUBCONTRACTOR SHALL SUBMIT CALCULATIONS (ANALYTICAL AND/OR GRAPHICAL) OF THE DESIGN CONCEPT AS WELL AS LAYOUT DRAWINGS FOR GENERAL ELECTRIC COMPANY APPROVAL. NO MANUFACTURING SHALL BE STARTED BY THE SUBCONTRACTOR, EXCEPT AT HIS OWN RISK, UNTIL WRITTEN APPROVAL OF DESIGN CONCEPT AND LAYOUTS HAS BEEN RECEIVED FROM THE GENERAL ELECTRIC COMPANY IN THE FORM OF PURCHASE ORDER CHANGE NOTICE. NO MODIFICATION OF THE APPROVED DESIGN CONCEPT AND LAYOUTS MAY BE MADE EXCEPT BY WRITTEN APPROVAL IN THE FORM OF A PURCHASE ORDER CHANGE NOTICE FROM THE GENERAL ELECTRIC COMPANY.

APPROVAL OF DESIGN CONCEPTS AND LAYOUTS FROM GENERAL ELECTRIC COMPANY IN NO WAY RELIEVES THE SUBCONTRACTOR OF HIS RESPONSIBILITY TO MEET THE DESIGN, RELIABILITY AND MAINTAINABILITY REQUIREMENTS OF THIS SPECIFICATION.

3.2.1 FINAL INTERPRETATION OF MILITARY AND GENERAL ELECTRIC SPECIFICATIONS SHALL BE THE PREROGATIVE OF THE SONAR PRODUCT DESIGN SECTION, HEAVY MILITARY ELECTRONICS DEPARTMENT, GENERAL ELECTRIC COMPANY, FARRELL ROAD PLANT, SYRACUSE, NEW YORK.

REVISIONS

84
2256M
2241
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PRINTS TO

MADE BY <i>R. J. Dwyer</i>	DATE <i>1 July 65</i>	REVISIONS <i>4th Edition</i>	HME	DIV OR DEPT. SYRACUSE	A 7819478	SH. NO. 6
ISSUED <i>4/2 July 65</i>		<i>7 July 65</i>		LOCATION	CONT. ON SHEET	SH. NO.

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GENERAL ELECTRIC

A 7819478

REV. NO. D	TITLE	CONT. ON SHEET	SH. NO. 7
A 7819478	END ITEM SPECIFICATION		
CONT. ON SHEET	SH. NO. 7	FIRST MADE FOR	

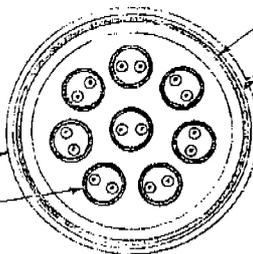
SECTION

4. DETAILED REQUIREMENTS - MAIN TRUNK CABLE (8 PAIR)

4.1 GENERAL CONSTRUCTION (MECH)

REINFORCED OUTER JACKET OF NEOPRENE, HYPALON, OR EQUIV. TO MEET WATER ABSORPTION REQ. PER ASTM D170 PAR. 34, 35 & 36 (MAX. 40 MG PER SQ. IN.). CABLE SHALL MEET 300 LB. PULL TEST WITHOUT DEGRADATION OF PHYSICAL OR ELECTRICAL SPECIFICATIONS. .050 MIN. THICKNESS INSIDE AND OUTSIDE OF REINFORCING.

TINNED COPPER METAL SHIELD SANDWICHED BETWEEN OUTER REINFORCED NEOPRENE JACKET AND THE INNER NEOPRENE JACKET.



TWISTED PAIR (8 PAIRS).
WATER BLOCKED CABLE TO MEET MIL-C-915 REQUIREMENTS (LATEST REV.)
OUTSIDE DIAMETER (SEE OUTLINE DWG. 770603108, FIG. 1)

4.1.1 GENERAL - THE DESIGN, (MECHANICAL), OF THE MAIN TRUNK CABLE SHALL MEET MIL-C-915 (LATEST REV.) IN ALL APPLICABLE RESPECTS INCLUDING MATERIALS, TESTS, ETC. REGARDING SS WATER BLOCKED SHIELDED CABLE FOR UNDERWATER USE, (EXAMPLE DSS-3 TYPE), PLUS ANY ADDITIONAL APPLICABLE REQUIREMENTS SPECIFIED IN MIL-E-16400E AMENDMENT 4 AND THIS SPECIFICATION.

4.1.2 THE CABLE SHALL CONSIST OF (16) SIXTEEN CONDUCTORS ARRANGED IN (8) EIGHT TWISTED PAIRS.

REVISIONS	
1	CHANGED PAR. 4.1 AND 4.1.1.5
2	3G-8/16-7/28/69
3	3G-8/16-7/28/69
4	3G-8/16-7/28/69
5	3G-8/16-7/28/69
6	3G-8/16-7/28/69
7	3G-8/16-7/28/69
8	3G-8/16-7/28/69
9	3G-8/16-7/28/69
10	3G-8/16-7/28/69
11	3G-8/16-7/28/69
12	3G-8/16-7/28/69
13	3G-8/16-7/28/69
14	3G-8/16-7/28/69
15	3G-8/16-7/28/69
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46	3G-8/16-7/28/69
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48	3G-8/16-7/28/69
49	3G-8/16-7/28/69
50	3G-8/16-7/28/69

A	CHASO C.D. 30. 9/2/69
B	3G-8/16-7/28/69
C	3G-8/16-7/28/69
D	3G-8/16-7/28/69
E	3G-8/16-7/28/69
F	3G-8/16-7/28/69
G	3G-8/16-7/28/69
H	3G-8/16-7/28/69
I	3G-8/16-7/28/69
J	3G-8/16-7/28/69
K	3G-8/16-7/28/69
L	3G-8/16-7/28/69
M	3G-8/16-7/28/69
N	3G-8/16-7/28/69
O	3G-8/16-7/28/69
P	3G-8/16-7/28/69
Q	3G-8/16-7/28/69
R	3G-8/16-7/28/69
S	3G-8/16-7/28/69
T	3G-8/16-7/28/69
U	3G-8/16-7/28/69
V	3G-8/16-7/28/69
W	3G-8/16-7/28/69
X	3G-8/16-7/28/69
Y	3G-8/16-7/28/69
Z	3G-8/16-7/28/69
AA	3G-8/16-7/28/69
AB	3G-8/16-7/28/69
AC	3G-8/16-7/28/69
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AE	3G-8/16-7/28/69
AF	3G-8/16-7/28/69
AG	3G-8/16-7/28/69
AH	3G-8/16-7/28/69
AI	3G-8/16-7/28/69
AJ	3G-8/16-7/28/69
AK	3G-8/16-7/28/69
AL	3G-8/16-7/28/69
AM	3G-8/16-7/28/69
AN	3G-8/16-7/28/69
AO	3G-8/16-7/28/69
AP	3G-8/16-7/28/69
AQ	3G-8/16-7/28/69
AR	3G-8/16-7/28/69
AS	3G-8/16-7/28/69
AT	3G-8/16-7/28/69
AU	3G-8/16-7/28/69
AV	3G-8/16-7/28/69
AW	3G-8/16-7/28/69
AX	3G-8/16-7/28/69
AY	3G-8/16-7/28/69
AZ	3G-8/16-7/28/69
BA	3G-8/16-7/28/69
BB	3G-8/16-7/28/69
BC	3G-8/16-7/28/69
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BE	3G-8/16-7/28/69
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BH	3G-8/16-7/28/69
BI	3G-8/16-7/28/69
BJ	3G-8/16-7/28/69
BK	3G-8/16-7/28/69
BL	3G-8/16-7/28/69
BM	3G-8/16-7/28/69
BN	3G-8/16-7/28/69
BO	3G-8/16-7/28/69
BP	3G-8/16-7/28/69
BQ	3G-8/16-7/28/69
BR	3G-8/16-7/28/69
BS	3G-8/16-7/28/69
BT	3G-8/16-7/28/69
BU	3G-8/16-7/28/69
BV	3G-8/16-7/28/69
BW	3G-8/16-7/28/69
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BY	3G-8/16-7/28/69
BZ	3G-8/16-7/28/69
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CE	3G-8/16-7/28/69
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CG	3G-8/16-7/28/69
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CN	3G-8/16-7/28/69
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CR	3G-8/16-7/28/69
CS	3G-8/16-7/28/69
CT	3G-8/16-7/28/69
CU	3G-8/16-7/28/69
CV	3G-8/16-7/28/69
CW	3G-8/16-7/28/69
CX	3G-8/16-7/28/69
CY	3G-8/16-7/28/69
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DG	3G-8/16-7/28/69
DH	3G-8/16-7/28/69
DI	3G-8/16-7/28/69
DJ	3G-8/16-7/28/69
DK	3G-8/16-7/28/69
DL	3G-8/16-7/28/69
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DZ	3G-8/16-7/28/69
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EC	3G-8/16-7/28/69
ED	3G-8/16-7/28/69
EE	3G-8/16-7/28/69
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EG	3G-8/16-7/28/69
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EI	3G-8/16-7/28/69
EJ	3G-8/16-7/28/69
EK	3G-8/16-7/28/69
EL	3G-8/16-7/28/69
EM	3G-8/16-7/28/69
EN	3G-8/16-7/28/69
EO	3G-8/16-7/28/69
EP	3G-8/16-7/28/69
EQ	3G-8/16-7/28/69
ER	3G-8/16-7/28/69
ES	3G-8/16-7/28/69
ET	3G-8/16-7/28/69
EU	3G-8/16-7/28/69
EV	3G-8/16-7/28/69
EW	3G-8/16-7/28/69
EX	3G-8/16-7/28/69
EY	3G-8/16-7/28/69
EZ	3G-8/16-7/28/69
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FB	3G-8/16-7/28/69
FC	3G-8/16-7/28/69
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FE	3G-8/16-7/28/69
FF	3G-8/16-7/28/69
FG	3G-8/16-7/28/69
FH	3G-8/16-7/28/69
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FJ	3G-8/16-7/28/69
FK	3G-8/16-7/28/69
FL	3G-8/16-7/28/69
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FN	3G-8/16-7/28/69
FO	3G-8/16-7/28/69
FP	3G-8/16-7/28/69
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FU	3G-8/16-7/28/69
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HI	3G-8/16-7/28/69
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HY	3G-8/16-7/28/69
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IA	3G-8/16-7/28/69
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JL	3G-8/16-7/28/69</

- 4.1.3 EACH PAIR SHALL BE COLOR CODED IN ACCORDANCE WITH MIL-C-915. IT WOULD BE PREFERABLE TO HAVE THE INSULATION COLORED, ONE WIRE EACH PAIR. COLOR CODING METHOD, ETC. SHALL BE RESOLVED BETWEEN GENERAL ELECTRIC AND SUBCONTRACTOR.
- 4.1.4 THE CONDUCTORS SHALL BE STRANDED COPPER WIRE TINNED - EQUIVALENT TO #16 SEVEN STRAND.
- 4.1.5 THE SHIELDING SHALL PROVIDE AT LEAST 88% COVERAGE AS SPECIFIED IN MIL-C-915.
- 4.1.6 ALL MATERIALS USED IN MAKING THE CABLE SHALL BE IN ACCORDANCE WITH MIL-E-16400E, MIL-C-915, THIS SPECIFICATION AND ANY APPLICABLE SPECIFICATION REFERENCED IN THE ABOVE MENTIONED SPECIFICATION. ANY DEVIATIONS TO THIS SPECIFICATION SHALL RECEIVE PRIOR APPROVAL, FROM G.E. CO., SYRACUSE, N.Y.
- 4.1.7 THE OUTER JACKET SHALL BE NEOPRENE, HYPALON, OR EQUIVALENT TO MEET MIL-C-915 AND WATER ABSORPTION REQUIRED PER ASTM D470 PAR. 34, 35, AND 36 (MAX. 40 MG PER SQ. IN.) THE JACKET SHALL BE SULPHUR FREE LOW WATER ABSORPTION MATERIAL, THAT IS, THERE SHALL BE NO SULPHUR OR WAX BLOOM FROM THE RUBBER. ANY SULPHUR USED IN COMPOUNDING MUST BE IN A STABLE CHEMICALLY COMBINED STATE.
- 4.1.8 WATER BLOCKING - THE ASSEMBLED COMPONENTS SHALL BE MOLDED TOGETHER COMPACTLY TO ENABLE THE COMPLETED CABLE TO MEET THE FOLLOWING HYDROSTATIC TEST. MIL-C-915B SECTION 4.8.31 AND APPENDIX I. MAXIMUM PERMISSIBLE LEAKAGE 1.0 CUBIC INCH DURING 2 HOURS AT 150 PSI.
- 4.1.9 THE INDIVIDUAL CONDUCTORS SHALL BE READILY SEPARABLE FROM FILLERS AND BINDERS WITHOUT DAMAGE TO THEIR INSULATION.
- 4.1.10 THE CABLES OF BOTH TYPES, SHALL BE UNDAMAGED AFTER TESTING BY BENDING TWO TURNS, AT MINUS 20 DEGREES CENTIGRADE, AROUND A MANDRELL 6 INCHES IN RADIUS.

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4.1.11 FLAMMABILITY - THE CABLE SHALL BE TESTED IN ACCORDANCE WITH MIL-C-915 TO DEMONSTRATE CONFORMANCE WITH IGNITION TIME OF 30 SECONDS MINIMUM, BURNING TIME 120 SECONDS MAXIMUM, WITH FLAME TRAVEL TWO (2) INCHES MAXIMUM.

4.1.12 THE CABLE SHALL BE DESIGNED TO OPERATE FOR A PERIOD OF 3 YEARS WITH NO DETRIMENTAL DEGRADATION OF ELECTRICAL AND PHYSICAL PROPERTIES.

4.2 ELECTRICAL REQUIREMENTS - THE SIXTEEN (16) CONDUCTOR CABLE SHALL MEET THE FOLLOWING ELECTRICAL REQUIREMENTS.

4.2.1 THE MAXIMUM D.C. RESISTANCE OF COPPER PER 1000 FT AT 25° CENTIGRADE ALLOWED IS 5.11 OHMS FOR EACH CONDUCTOR.

4.2.2 THE CAPACITIES OF THE VARIOUS CONDUCTOR TO CONDUCTOR AND/OR CONDUCTOR TO SHIELD COMBINATIONS MUST BE LIMITED TO MEET THE "CROSS-TALK" RATIOS LISTED BELOW WHEN MEASURED IN CIRCUITS A AND B BELOW FOR A COMPLETE CABLE ASSEMBLY.

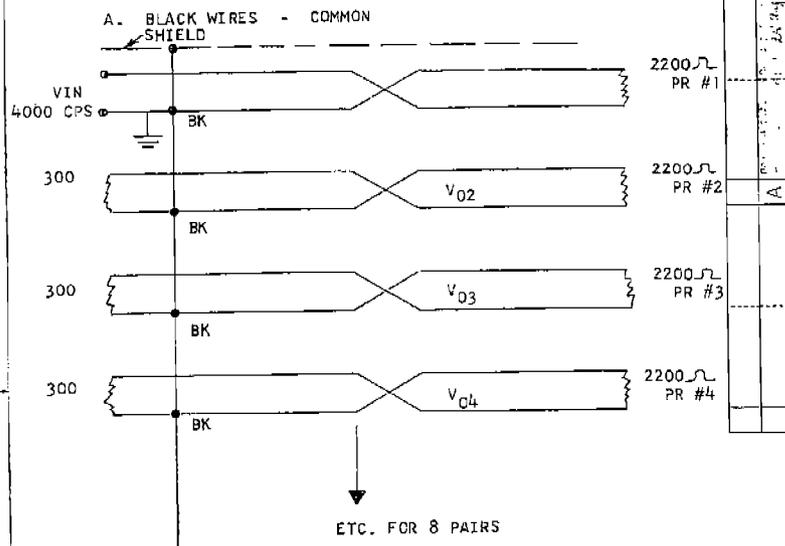
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4.2.2 (CONTINUED)



$\frac{V_{in}}{V_{02}}$ GREATER THAN 300
 $\frac{V_{in}}{V_{03}}$ GREATER THAN 300
 ETC. GREATER THAN 300 FOR ALL SEVEN CONDUCTORS

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MADE BY <i>R.H. Dandy</i>	ISSUED <i>16 July 1965</i>	APPROVAL <i>[Signature]</i>	HME	SYRACUSE	DW OR DEPT. A 7819478	SH. NO. 10
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REV. NO. A A 7819478 SH. NO. 11	TITLE END ITEM SPECIFICATION	
4.2.2 (CONTINUED) B. WHITE WIRES - COMMON SHIELD		
ETC. FOR B PAIRS $\frac{V_{in}}{V_{02}}$ GREATER THAN 300 $\frac{V_{in}}{V_{03}}$ GREATER THAN 300		
THE VALUES OF "CROSS-TALK" ARE PRIMARILY DETERMINED BY THE INSULATION THICKNESS AROUND EACH CONDUCTOR; THE DIELECTRIC OF THIS INSULATION AND FILLER BETWEEN CONDUCTOR AND CONDUCTORS TO SHIELD MUST BE SUCH THAT THE DISSIPATION FACTORS* OF THE CAPACITY BETWEEN ANY COMBINATION OF CONDUCTOR TO CONDUCTOR AND/OR CONDUCTORS TO SHIELD SHALL BE LESS THAN 0.05 WHEN MEASURED AT 4000 CPS.		
* THE DISSIPATION FACTOR IS THE RATIO OF THE SERIES RESISTANCE TO SERIES REACTANCE.		
SOME TYPICAL CAPACITIVE VALUES OF A 100 FOOT CABLE SIMILAR TO THAT SHOWN IN 4.1 ARE AS FOLLOWS WHEN ALL WIRES AND SHIELD ARE "FLOATING", I.E., NOT INTERCONNECTED.		
Btt PRINTS TO		
MADE BY RJD DARRY 1 JULY 65 ISSUED 13 JULY 1965	APPROVALS A.M. ANDERSON 9 JULY 65	HME DIV OR SYRACUSE DEPT LOCATION A 7819478 SH. NO. 11 CODE IDENT. NO. 03538

REVISIONS

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 125 TO 300 & 0.04 TO 0.05
 RECORD CORRECTION 25 MAY 1965

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4.2.6 NOISE LEVEL - THE CABLE SHALL BE DESIGNED TO MEET THE NOISE LEVEL OF DSS-3 TYPE CABLE AND TO OPERATE AT SIGNALS OF ONE (1) MICROVOLT INTO AN IMPEDANCE OF 200 OHMS WHILE OPERATING UNDER SHIPBOARD VIBRATION AS SPECIFIED BY MIL-E-16400E.

4.3 CABLE USED IN MAKING THE PART 2 PIGTAIL (4 FT) ASSY AND FOR THE 8 (18 INCH) LEADS SPLICED INTO THE MAIN TRUNK (PART 1 OR 12) ASSEMBLY SHALL BE NAVY APPROVED DSS-3 TYPE CABLE AND SHALL MEET MIL-C-915.

4.3.1 HIGH POTENTIAL TEST-ELEMENT CABLE (PART 2) CONDUCTOR TO CONDUCTOR AND EACH CONDUCTOR TO SHIELD AT 1500 VOLTS RMS AND AT 60 HZ FOR ONE MINUTE. TEST SHALL BE PERFORMED AFTER THE MOLDING OF THE FLANGE CONNECTOR AND PRIOR TO THE MOLDING OF THE CONNECTOR TERMINATION. THE VOLTAGE SHALL BE APPLIED PER 4.4.1. THIS TEST SHALL NOT BE PERFORMED UNDER HYDROSTATIC PRESSURE.

4.4 THE COMPLETE CABLE ASSEMBLY, (PART 1 OR 12 LEADS CONNECTED TO PART 2 ELEMENT CABLE ASSY), SHALL MEET THE FOLLOWING ELECTRICAL AND MECHANICAL SPECIFICATIONS WHILE THE MOLDED SPLICE JOINT AND ALL CONNECTORS ARE SUBMERGED UNDER A HYDROSTATIC PRESSURE OF 100 PSIG.

4.4.1 HIGH POTENTIAL TEST CONDUCTOR TO CONDUCTOR AND EACH CONDUCTOR TO SHIELD AT 1500 VOLTS RMS AND AT 60 HZ FOR ONE MINUTE. CONDUCTOR TO SHIELD TEST APPLIES TO THE MAIN CABLE (PART 1) ONLY. THE APPLIED VOLTAGE SHALL BE NOT INITIALLY GREATER THAN 600 VOLTS RMS, AND THE RATE OF INCREASE SHALL BE APPROXIMATELY UNIFORM AND NOT OVER 100 PERCENT IN 10 SECONDS, NOR LESS THAN 100 PERCENT IN 60 SECONDS. THE MOLDED FLANGE OF ELEMENT CABLE (PART 2) SHALL SHOW NO EVIDENCE OF TEAR OR POOR ADHESION FOLLOWING THE HYDROSTATIC PRESSURE TEST.

4.4.2 INSULATION RESISTANCE (MINIMUM AT 500 VOLTS).

4.4.2.1 100 MEGOHMS BETWEEN CONDUCTORS (PART 1 OR PART 12 AND PART 2) AND BETWEEN EACH CONDUCTOR TO SHIELD (MAIN TRUNK CABLE ASSEMBLY PART 1 OR PART 12 ONLY).

4.4.2.2 100 MEGOHMS FROM SHIELD TO WATER (MAIN CABLE PART 1 OR PART 12 ONLY).

4.4.2.3 100 MEGOHMS FROM EACH CONDUCTOR TO WATER (MAIN CABLE, PART 1 OR PART 12 AND ELEMENT CABLE, PART 2).

4.5 THE CABLE ASSEMBLY, (PART 1 OR PART 12 CONNECTED TO PART 2), SHALL BE DESIGNED TO OPERATE AT SIGNALS OF ONE (1) MICROVOLT INTO AN IMPEDANCE OF 200 OHMS WHILE OPERATING UNDER SHIPBOARD VIBRATIONS AS SPECIFIED IN MIL-E-16400E.

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4.6 SUCH ITEMS AS SOLDER JOINTS, CRIMP JOINTS, SOCKET CONTACTS AND RESISTANCE DROP ACROSS CONNECTORS SHALL BE DETERMINED WITH THE VENDOR.

4.7 MECHANICAL REQUIREMENTS

4.7.1 CABLE ASSEMBLIES, (PART 1 OR PART 12 AND PART 2) SHALL MEET THE REQUIREMENTS OF MIL-C-915, MIL-E-16400E AND THIS SPECIFICATION. ANY CONFLICTS REGARDING SPECIFICATIONS SHALL BE NEGOTIATED WITH GENERAL ELECTRIC COMPANY.

4.7.2 THE COMPLETE ASSEMBLY (A TRUNK CABLE, PART 1 OR PART 12 WITH ITS CONNECTOR JOINED TO THE CONNECTOR OF AN ELEMENT CABLE, PART 2, WITH THE COUPLINGS, 7240868P1 AND 7240869P1, IN PLACE OVER THE CONNECTORS) SHALL WITHSTAND A 25 POUND PULL WITHOUT THE CONNECTORS PULLING APART OR LOOSENING OR EFFECTING THEIR WATERTIGHT INTEGRITY. THE FORCE SHALL BE APPLIED LONGITUDINALLY, I.E., THE PULL SHALL BE APPLIED ON THE CABLE EACH SIDE OF THE CONNECTION. THE FORCE (25 LBS) SHALL BE APPLIED FOR A PERIOD OF ONE MINUTE FOR A TOTAL OF 5 TIMES. CABLE SHALL MEET TESTS IN 4.4 AFTER PULL TEST. CONTINUITY SHALL BE MAINTAINED DURING THIS TEST.

4.7.3 THE SUBCONTRACTOR SHALL SUBMIT TO THE GENERAL ELECTRIC COMPANY, PRE-PRODUCTION SAMPLES OF THE TRUNK CABLE ASSEMBLY PT 1 AND PART 12 AND THE ELEMENT CABLE ASSEMBLY PART 2 FOR TEST AND EVALUATION. SAMPLES OF EACH BATCH OF COMPOUND MATERIAL USED IN MOLDING CONNECTORS, FLANGES AND JUNCTION BLOCK SHALL BE SUBMITTED CONCURRENT WITH THE CABLE ASSEMBLIES FOR EVALUATION BY GENERAL ELECTRIC COMPANY.

THE SUBCONTRACTOR SHALL NOT PROCEED WITH MANUFACTURE OF CABLE ASSEMBLIES (EXCEPT AT HIS OWN RISK) UNTIL HE RECEIVES PREPRODUCTION APPROVAL FROM GENERAL ELECTRIC COMPANY PURCHASING DEPT. FOR THE SUBMITTED PREPRODUCTION SAMPLE.

4.7.4 THE CONNECTORS SHALL BE POLARIZED AS SHOWN ON OUTLINE DRAWINGS 77D603108 & 77D603109 WHICH SHALL BE CONSIDERED AS PART OF THIS SPECIFICATION.

4.7.5 CONNECTOR CONTACTS SHALL BE GOLD PLATED PER MIL-G-452048, TYPE II, GRADE C, CLASS 3 OVER COPPER PLATING IN ACCORDANCE WITH MIL-C-14550, .00005 THICKNESS (MIN). NO SILVER UNDERPLATING PERMITTED. BRASS QQ-B-626 COMP. 22 OR EQUIVALENT.

4.7.6 TEST SPECIMEN AND DATA OF NEOPRENE COMPOUND USED IN THE FLANGE OF PART 2 SHALL BE SUPPLIED TO THE GENERAL ELECTRIC COMPANY. TEST SPECIMEN AND DATA FROM NEOPRENE COMPOUND USED IN EVERY 300 PART 2 CABLE ASSEMBLIES SHALL ALSO BE SUBMITTED TO THE GENERAL ELECTRIC COMPANY.

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4.7.6.1 TEST SPECIMEN OF NEOPRENE MOLDING MATERIAL SHALL BE AS FOLLOWS: TWO BUTTONS - SIZE OF TEST SPECIMENS PER ASTM D-395 SPECIFICATION METHOD B. ONE MOLDED FLANGE ON 12 INCH PIECE OF CABLE. TWO TEST SLABS 6 X 6 X .075 PER ASTM D-395.

4.7.7 TEST SPECIMEN AND DATA OF NYLON OR EQUIVALENT MOLDING MATERIAL SHALL BE SUPPLIED TO THE GENERAL ELECTRIC COMPANY FOR EACH NEW BATCH OF MATERIAL.

4.7.7.1 TEST SPECIMENS OF THE NYLON MOLDING MATERIAL SHALL BE AS FOLLOWS: TWO COMPRESSION SET BUTTONS PER ASTM D-395 METHOD B. TWO TEST SLABS 6 X 6 X .075 PER ASTM D-395.

4.7.8 TEST SPECIMEN AND DATA OF ALL MOLDING MATERIALS, WITH A LETTER OF TRANSMITTAL, SHALL BE SHIPPED TO:

GENERAL ELECTRIC COMPANY
FARRELL ROAD PLANT NO. 2
SYRACUSE, NEW YORK

ATTENTION: MANAGER, PMQC

4.7.9 THE SERIALIZATION PER 7837656 IS NOT REQUIRED FOR TRUNK CABLE (77D603108) AND ELEMENT CABLE (77D602109).

4.8 ENVIRONMENTAL REQUIREMENTS

4.8.1 THE CABLE ASSEMBLIES, (PT 1 OR PT 12 AND PT 2, AS WELL AS COUPLINGS, 7240868P1 AND 7240869P1, AND THE DUMMY CONNECTOR 7241933P1) SHALL WITHSTAND STORAGE AND SHIPPING TEMPERATURE OF MINUS 25 DEGREES CENTIGRADE TO PLUS 75 DEGREES CENTIGRADE WITHOUT REDUCING THE PHYSICAL OR ELECTRICAL REQUIREMENTS OF THIS SPECIFICATION.

4.8.2 THE CABLE ASSEMBLIES (SEE PARAGRAPH 4.8.1) SHALL PERFORM SATISFACTORILY IN SEA WATER AT ANY TEMPERATURE FROM MINUS ONE (1) DEGREE CENTIGRADE TO PLUS (33°) THIRTY-THREE DEGREES CENTIGRADE.

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- 4.8.3 SHOCK AND VIBRATION - THE CABLE ASSEMBLY (INCLUDING PT 1, PT 12, PT 2, COUPLINGS 7240868P1 AND 7240869P1, AND DUMMY CONNECTOR, 7241933) SHALL WITHSTAND VIBRATION AND SHOCKS INCIDENTAL TO ITS INTENDED USE IN NAVAL SHIPS WITHOUT PHYSICAL, ELECTRICAL OR ACOUSTICAL DAMAGE, OR LEAKAGE OF SEA WATER INTO THE CABLE.
- 4.8.4 IMPULSE SHOCKS - THE TRANSDUCER CABLE ASSEMBLIES, (INCLUDING PT 1, PT 12, PT 2, COUPLINGS 7240868P1 AND 7240869P1, AND DUMMY CONNECTOR, 7241933) SHALL WITHSTAND REPEATED SUBJECTIONS TO MAXIMUM IMPULSE PRESSURES OF 3200 PSI OF 2.0 MILLISECOND DURATION AS CAUSED BY UNDERWATER EXPLOSIONS WITHOUT PHYSICAL, ELECTRICAL OR ACOUSTICAL DAMAGE, OR LEAKAGE OF SEA WATER INTO THE CABLE.
- 4.8.5 THE CABLE ASSEMBLIES (INCLUDING PT 1, PT 12, PT 2, COUPLINGS 7240868P1 AND 7240869P1, AND DUMMY CONNECTOR, 7241933) SHALL STAND A STORAGE OF 1 YEAR SHELF LIFE AND A USE OF 3 YEARS IN SEA-WATER WITHOUT REDUCING PHYSICAL OR ELECTRICAL REQUIREMENTS OF THIS SPECIFICATION.

4.9 VENDOR PRODUCTION TEST REQUIREMENTS

- 4.9.1 ON 5% OF THE TRUNK CABLES SELECTED ON A RANDOM BASIS TEST 4.7.4 SHALL BE PERFORMED AS FOLLOWS:

EACH LEAD OF THE TRUNK CABLE (PT 1) SHALL BE CONNECTED TO AN ELEMENT CABLE (PT 2) WITH COUPLINGS, 7240868P1 AND 7240869P1. WITH THE ELEMENT CABLE (PT 2) FLANGE CLAMPED RIGIDLY AND THE MAIN TRUNK FREE END WOUND FIVE TIMES AROUND A CYLINDER OF 6 INCHES RADIUS, A 25 POUND FORCE WHICH EXERTS AN EQUAL LOAD TO BOTH ENDS OF THE CYLINDERS SHALL BE APPLIED. A 25 POUND FORCE SHALL BE APPLIED AXIALLY FIVE TIMES TO EACH OF THE EIGHT ELEMENT CABLES FOR A PERIOD OF 1 MINUTE EACH TIME, AND SHALL MEET THE REQUIREMENTS IN 4.7.4.

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4.9.1.1 A CABLE ASSEMBLY FLEX TEST SHALL BE PERFORMED, WHICH ROTATES THE POTHEAD 90 DEGREES EACH SIDE OF THE CENTER OR START POSITION WHILE EXERTING A FIVE (5) POUND PULL ON EACH OF THE EIGHT (8) LEADS. ROTATE 90 DEGREES ONE WAY, BACK TO CENTER POSITION, 90 DEGREES IN THE OPPOSITE DIRECTION AND BACK TO CENTER WOULD CONSTITUTE ONE CYCLE. REPEAT FIVE (5) CYCLES. DURING THE FLEX OPERATION A CONTINUITY CHECK IS TO BE MADE AND THERE MUST BE NO INDICATION OF AN OPEN.

4.9.1.2 A CONNECTOR ASSEMBLY BEND TEST SHALL BE PERFORMED WITH A 90 DEGREES BEND FIRST IN ONE DIRECTION, THEN 90 DEGREES IN THE OTHER DIRECTION IN THE SAME PLANE AND BACK TO THE START POSITION. THIS CONSTITUTES ONE CYCLE. REPEAT FIVE (5) CYCLES. DURING THE BEND OPERATION A CONTINUITY CHECK IS TO BE MADE AND THERE MUST BE NO INDICATION OF AN OPEN.

4.9.1.3 TESTS 4.9.2 AND 4.9.3 SHOULD FOLLOW THESE TESTS.

4.9.2 EACH COMPLETE ASSEMBLY IS TO BE IMMersed AND HI-POT TESTED UNDER WATER AT 100 PSIG. A CABLE ASSEMBLY INCLUDES PART 1 OR PART 12 CONNECTED TO PART 2, WITH COUPLINGS 7240868P1 AND 7240869P1 AND SHALL MEET THE ELECTRICAL AND MECHANICAL REQUIREMENTS SET FORTH IN THE END ITEM SPECIFICATION.

4.9.3 ALL CABLE TO BE 100% TESTED AS DESCRIBED IN 4.4.1 AND 4.2.5.2.

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5.4 CORRECTIVE ACTION

5.4.1 THE SUBCONTRACTOR SHALL TAKE PROMPT ACTION TO CORRECT ASSIGNABLE CONDITIONS WHICH HAVE RESULTED OR COULD RESULT IN PRODUCTS WHICH DO NOT CONFORM TO INSPECTION AND TEST REQUIREMENT OF THIS SPECIFICATION.

5.5 DRAWINGS AND CHANGES

5.5.1 THE SUBCONTRACTOR INSPECTION SYSTEM SHALL PROVIDE FOR PROCEDURES WHICH WILL ASSURE THAT THE LATEST APPLICABLE DRAWINGS, SPECIFICATIONS AND INSTRUCTION REQUIRED BY THIS SPECIFICATION AS WELL AS AUTHORIZED CHANGES THERETO ARE USED FOR FABRICATION, ALL INSPECTIONS AND ALL TESTING.

5.6 MEASURING AND TEST EQUIPMENT

5.6.1 THE SUBCONTRACTOR SHALL PROVIDE AND MAINTAIN GAGES AND OTHER MEASURING AND TESTING DEVICES NECESSARY TO ASSURE THAT PROCURED SUPPLIES AND THE PRODUCT CONFORM TO THIS SPECIFICATION. IN ORDER TO ASSURE CONTINUED ACCURACY, THESE DEVICES SHALL BE CALIBRATED AT ESTABLISHED INTERVALS AGAINST CERTIFIED STANDARDS WHICH HAVE KNOWN RELATIONSHIP TO NATIONAL OR INTERNATIONAL STANDARDS. CALIBRATION OF THESE DEVICES SHALL BE IN ACCORDANCE WITH MIL-C-45662 LATEST ISSUE.

5.6.2 IF PRODUCTION TOOLING, SUCH AS JIGS, FIXTURES, TEMPLATES AND PATTERNS ARE USED AS A MEDIA OF INSPECTION, THEN SUCH DEVICES SHALL ALSO BE PROVIDED FOR ACCURACY AT ESTABLISHED INTERVALS.

5.6.3 WHEN REQUIRED, THE SUBCONTRACTORS MEASURING AND TESTING DEVICES SHALL BE MADE AVAILABLE FOR USE BY THE GENERAL ELECTRIC COMPANY REPRESENTATIVE TO DETERMINE CONFORMANCE OF PRODUCT WITH THIS SPECIFICATION. IN ADDITION, IF CONDITIONS WARRANT, THE SUBCONTRACTORS PERSONNEL SHALL BE MADE AVAILABLE FOR OPERATION OF SUCH DEVICES AND FOR VERIFICATION OF THEIR ACCURACY AND CONDITION.

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MADE BY <i>E. J. Daily</i>	DATE <i>July 65</i>	APPROVED <i>[Signature]</i>	DEPT. HME	DIV. OR DEPT. A	7819478
ISSUED <i>13 July 1965</i>		<i>19 July 65</i>	SYRACUSE	LOCATION	CONT. ON SHEET SH. NO. 20

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<p>5.9 <u>INDICATION OF INSPECTION STATUS</u></p> <p>5.9.1 THE SUBCONTRACTOR SHALL MAINTAIN A POSITIVE SYSTEM FOR IDENTIFYING THE INSPECTION STATUS OF PRODUCTS AND PROCURED SUPPLIES; IDENTIFICATION MAY BE ACCOMPLISHED BY MEANS OF STAMPS, TAGS, ROUTING CARDS, MOVE TICKETS, TOTE BOX CARDS, OR OTHER CONTROL DEVICES.</p>			<table border="1"> <tr><td>REVISIONS</td></tr> <tr><td> </td></tr> </table>	REVISIONS									
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5.10 SPECIAL PROCESSES

5.10.1 THE PLATING PROCESSES USED IN THE MANUFACTURE OF THIS PRODUCT SHALL BE CURRENTLY CERTIFIED TO THE APPLICABLE SPECIFICATION. IN ADDITION, THE PLATING PROCESSES SHALL BE ACCEPTABLE TO HME QUALITY CONTROL REPRESENTATIVE.

5.11 GENERAL ELECTRIC COMPANY INSPECTION AT SUBCONTRACTOR'S FACILITY

5.11.1 THE GENERAL ELECTRIC COMPANY RESERVES THE RIGHT TO INSPECT AT SOURCE THE PRODUCT(S) SUPPLIED AS PART OF THIS SPECIFICATION. SUCH INSPECTIONS SHALL NOT CONSTITUTE ACCEPTANCE NOR SHALL IT IN ANY WAY REPLACE SUBCONTRACTOR INSPECTION OR OTHERWISE RELIEVE THE SUBCONTRACTOR OF HIS RESPONSIBILITY TO FURNISH AN ACCEPTABLE PRODUCT.

5.11.2 THE GENERAL ELECTRIC COMPANY SHALL MONITOR THE SUBCONTRACTOR TO ASSURE COMPLIANCE WITH THE REQUIREMENT CONTAINED IN THIS SPECIFICATION

5.11.3 WHEN DIRECT SHIPMENT OF MATERIAL IS AUTHORIZED THE GENERAL ELECTRIC COMPANY SHALL EXAMINE AND ACCEPT THE PRODUCT BEFORE IT IS PRESENTED TO THE GOVERNMENT REPRESENTATIVE.

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MADE BY <i>R.D. Daily</i>	DATE <i>1 July 65</i>	APPROVED BY <i>J.M. Callahan</i>	DATE <i>9 July 65</i>	HME	REG. OR SHOP.	A 7819478	SR. NO. 23
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SECTION

6. PREPARATION FOR DELIVERY

- 6.1 PRESERVATION, PACKAGING AND PACKING - ALL PARTS SHALL BE PREPARED FOR DOMESTIC SHIPMENT.
- 6.2 SHIPPING - SHIPPING INSTRUCTIONS WILL BE FURNISHED TO THE SUBCONTRACTOR WITHIN THIRTY DAYS AFTER NOTIFICATION IN WRITING TO THE RESPONSIBLE BUYER, PURCHASING DEPT., HEAVY MILITARY ELECTRONICS DEPARTMENT, GENERAL ELECTRIC COMPANY, SYRACUSE, NEW YORK, THAT PART 1 AS WELL AS COUPLINGS, 7240868P1 AND 7240869P1, AND DUMMY CONNECTORS, 7241933P1, AS APPLICABLE, IS READY FOR SHIPMENT.
- 6.3 WHEN DIRECT SHIP IS AUTHORIZED PART 1, AS WELL AS COUPLINGS, 7240868P1 AND 7240869P1, AND DUMMY CONNECTORS 7241933P1, AS APPLICABLE, SHALL BE CLEANED, PRESERVED, PACKAGED BY LEVEL A, PACKED AND MARKED BY LEVEL B PER MIL-E-17555F DATED 26 JULY 1960 AND AMENDMENT 2 DATED 30 APRIL 1962.

SECTION

7. INSTALLED SPARE TRUNK CABLE

- 7.1 THIS CABLE SHALL BE IDENTICAL TO CABLE ASSEMBLY PART 1 AND IN ADDITION SHALL BE SUPPLIED WITH 8 COUPLINGS, 7240868P1, 8 COUPLINGS, 7240869P1, AND 8 DUMMY CONNECTORS, 7241933P1.

THE COUPLINGS AND DUMMY CONNECTORS, WHEN ASSEMBLED TO THE CABLE, SHALL PREVENT THE ENTRANCE OF WATER TO THE CONTACTS.

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