

NOTICE OF
CHANGE

INCH-POUND

MIL-STD-636
NOTICE 4
7 October 1996

MILITARY STANDARD

VISUAL INSPECTION STANDARDS FOR SMALL ARMS AMMUNITION
THROUGH CALIBER .50

TO ALL HOLDERS OF MIL-STD-636:

1. THE FOLLOWING PAGES OF MIL-STD-636 HAVE BEEN REVISED AND
SUPERSEDE THE PAGES LISTED:

NEW PAGE	DATE	SUPERSEDED PAGE	DATE
1	5 JUNE 1958	1	7 October 1996
2	5 JUNE 1958	2	Reprinted without change
13	5 JUNE 1958	13	Reprinted without change
14	5 JUNE 1958	14	7 October 1996
25	5 JUNE 1958	25	7 October 1996
26	5 JUNE 1958	26	Reprinted without change
33	5 JUNE 1958	33	7 October 1996
34	5 JUNE 1958	34	Reprinted without change
39	5 JUNE 1958	39	Reprinted without change
40	5 JUNE 1958	40	7 October 1996
63	5 JUNE 1958	63	7 October 1996
64	5 JUNE 1958	64	Reprinted without change

2. RETAIN THIS NOTICE AND INSERT BEFORE TABLE OF CONTENTS.

3. Holders of MIL-STD-636 will verify that page changes and additions indicated above have been entered. This notice page will be retained as a check sheet. This issuance, together with appended pages, is a separate publication. Each notice is to be retained by stocking points until the standard is completely revised or canceled.

Custodians:
Army - AR
Navy - OS

Preparing Activity:
Army - AR

(Project 1305-0167)

AMSC N/A

FSC 1305

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

MIL-STD-636

1. SCOPE AND PURPOSE

1.1 Scope. This standard provides procedures for determining and evaluating defects in small arms ammunition up to and including caliber .50, and the standard shall be used as a supplement to pertinent specifications.

1.2 Purpose. The purpose of this standard is to -

- (a) Provide a standard basis for the inspection of small arms ammunition at the various manufacturing facilities.
- (b) Serve as an instruction manual in the training of personnel engaged in the manufacture and inspection of small arms ammunition.

2. REFERENCED DOCUMENTS

2.1 Standards.

MIL-STD-105--Sampling Procedures and Tables for Inspection by Attributes.

2.2 Specifications.

MIL-A-48078--Ammunition, Standard Quality Assurance Provisions, General Specification for.

3. DEFINITIONS

3.1 General. Definitions of Standard MIL-STD-105 are applicable.

3.2 Specific. For the purpose of this standard the following definitions shall apply:

3.2.1 Permissible defect. A condition which, though not desirable from an appearance standpoint, may be permitted for reasons of economy.

3.2.2 Special defect. See MIL-A-48078.

4. GENERAL REQUIREMENTS

4.1 General. The description and definitions of defects established in this standard are those commonly occurring. Any other defects not listed, present in the lot, shall be reported. If, in the opinion of the Government inspector, the other defects be serious, complete information, recommendations and request for disposition shall be submitted through proper channels.

5. DETAIL REQUIREMENTS

5.1 Defect grouping. For convenience in referencing, the defect lists and defect photographs are grouped as follows:

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NATO Caliber 7.62mm List of Defects	16
NATO Caliber 7.62mm Defect Photographs	17
Caliber .30 Carbine List of Defects	27
Caliber .30 Carbine Defect Photographs	28
Caliber .45 List of Defects	34
Caliber .45 Defect Photographs	35
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Caliber .22 Long Rifle (Commercial) List of Defects	65
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12 Gauge Shotgun Shells (Commercial) List of Defects	69
12 Gauge Shotgun Shells (Commercial) Defect Photographs	70

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LIST OF DEFECTS

CALIBER .30

CARTRIDGE

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2. Corroded or Stained	3
3. Mixed Ammunition Types	3

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7. Perforated Case	5
8. Draw Scratch	6
9. Scratch (case)	6
10. Beveled Underside of Head	6
11. Case Mouth not Crimped in Cannelure	7
12. Scaly Metal (case)	8
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14. Fold	9
15. Wrinkle	9
16. Buckle	9
17. Bulge	10
18. Illegible or Missing Head Stamp	10, 11
19. Defective Head	11
20. Defective Mouth	11
21. No Visible Evidence of Mouth Anneal	12

BULLET

22. Dent (bullet)	12
23. Scratch (bullet)	12
24. Split Bullet Jacket	12
25. Loose Bullet	12
26. Missing Cannelure	12
27. Scaly Metal (bullet)	13
28. Upset (crooked) Point	13
29. Exposed Steel (clad jacket)	13
30. Blunt Point	13
31. Defective Cannelure	14

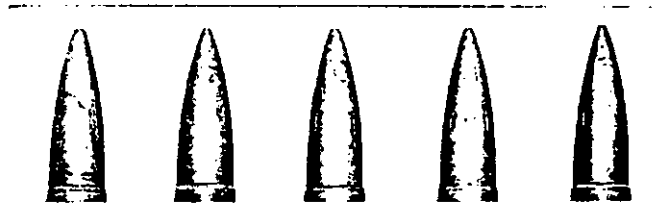
PRIMER

32. No Primer	14
33. Cocked Primer	14
34. Inverted Primer	14
35. Loose Primer	15
36. Nicked or Dented Primer	15
37. No Waterproofing (Primer pocket loose)	15
38. Defective Crimp	15

LIST OF DEFECTS

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[Major] [— Minor —] [— Permissible —]

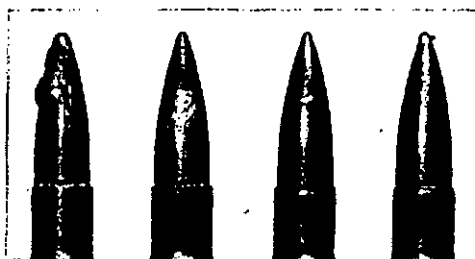
No. 27. Scaly Metal (bullet)

In classifying scaly metal cartridges, due consideration must be given to the depth as well as the area of the scale.



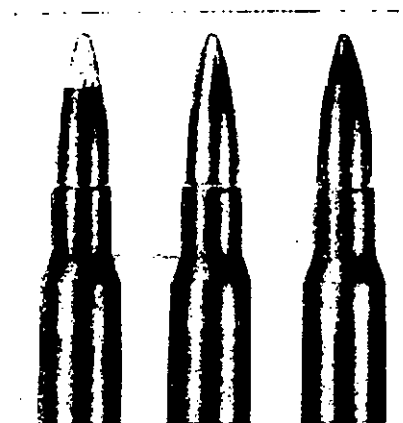
[— Minor —] [— Permissible —]

No. 28. Upset (crooked) Point



[— Minor —]

No. 29. Exposed Steel (clad jacket)

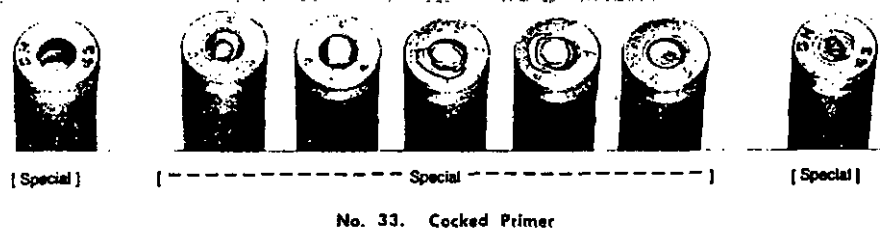
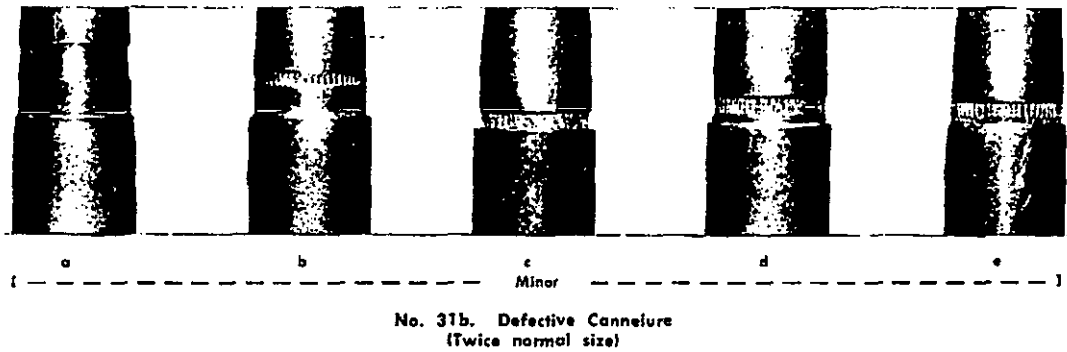
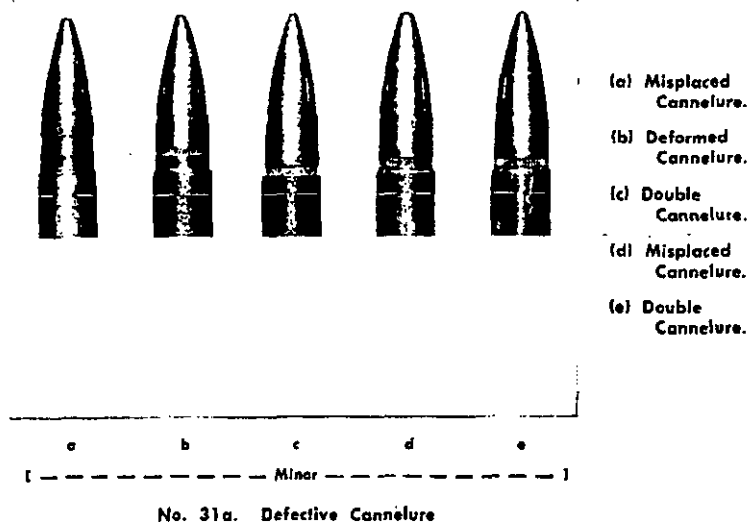


[— Permissible —]

No. 30. Blunt Point

A cartridge is to be counted as a minor defective if point bluntness or flatness exceeds that shown.

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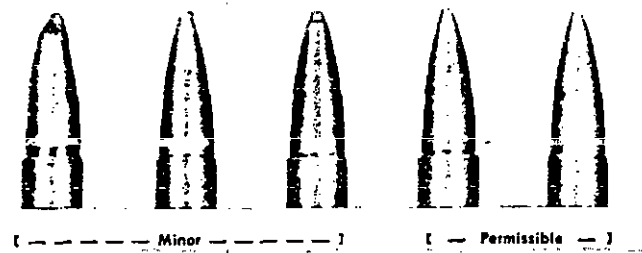


No. 32
 No Primer

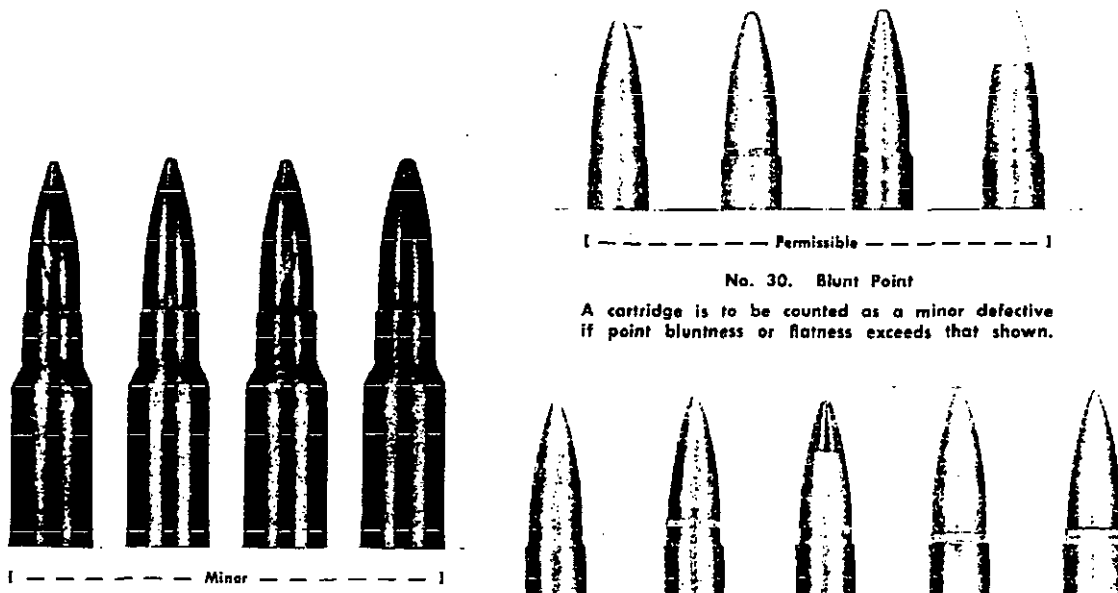
No. 34
 Inverted Primer

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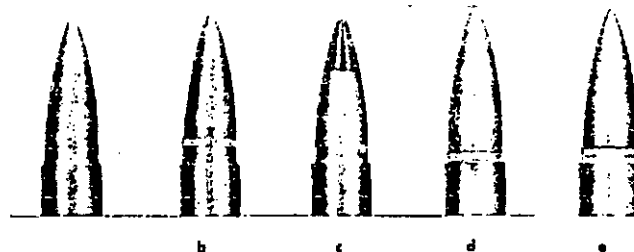
No. 28. Upset (crooked) Point



No. 30. Blunt Point

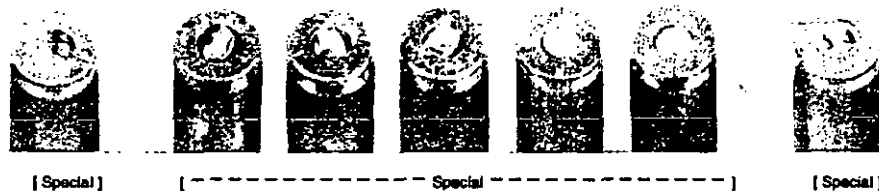
A cartridge is to be counted as a minor defective if point bluntness or flatness exceeds that shown.

No. 29. Exposed Steel (clad jacket)



No. 31. Defective Cannellure

- (a) Misplaced Cannellure
- (b) Deformed Cannellure
- (c) Eccentric and Misplaced Cannellure
- (d) Misplaced Cannellure
- (e) Double Cannellure



No. 32.
No Primer

No. 33. Cocked Primer

No. 34.
Inverted
Primer

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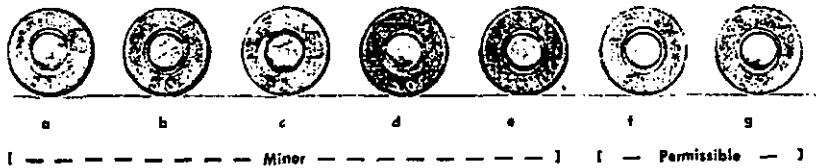
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No. 35. Loose Primer

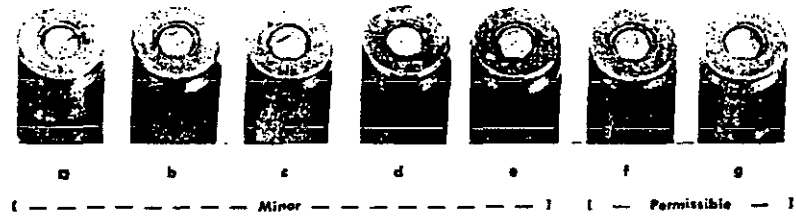
(Not illustrated)

Major

A cartridge is to be counted as a defective because of a loose primer if the primer can be moved within the primer pocket or if the primer can be shaken or jarred from the pocket.



No. 36a. Nicked or Dented Primer



No. 36b. Nicked or Dented Primer

- | | |
|---|-----------------------|
| (a) Deformed Primer | (d) } Nicks in Center |
| (b) Deformed Primer | (e) } of Primer |
| (c) Nicks, Extending to
Edge of Primer Cup | (f) } Small Nicks |
| | (g) } and Dents |



No. 37

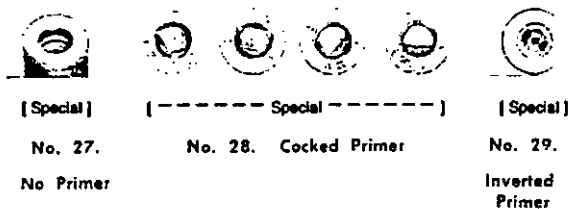
No Waterproofing
 (Primer pocket joint)



No. 38. Defective Crimp

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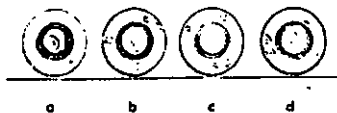
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No. 30. Loose Primer (Not illustrated)
 Major

A cartridge is to be counted as a defective because of a loose primer if the primer can be moved within the primer pocket or if the primer can be shaken or jarred from the pocket.

- (a) Dented Primer.
- (b) Nick Extending to Edge of Primer Cup.
- (c) Deformed Primer Cup.
- (d) Small Nicks.

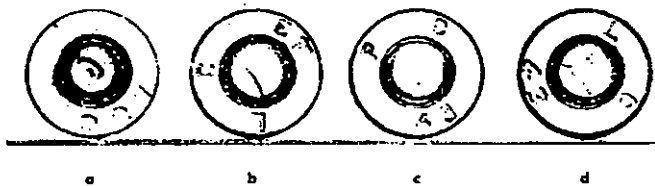


[— Minor —] [— Permissible —]

No. 31a. Nicked or Dented Primer



No. 32. No Waterproofing (Primer pocket joint)



[----- Minor -----] [----- Permissible -----]

No. 31b. Nicked or Dented Primer
 (Twice normal size)

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CALIBER .45

CARTRIDGE

No.	Page
1. Discolored; Dirty, Oily, Smeared (waterproofing) _ _ _ _ _	35
2. Corroded or Stained _ _ _ _ _	35
3. Mixed Ammunition Types _ _ _ _ _	35

CASE

4. Round Head _ _ _ _ _	35
5. Dent (case) _ _ _ _ _	35
6. Split Case _ _ _ _ _	36
7. Perforated Case _ _ _ _ _	36
8. Draw Scratch _ _ _ _ _	36
9. Scratch (case) _ _ _ _ _	36
10. Beveled Underside of Head _ _ _ _ _	36
11. Scaly Metal (case) _ _ _ _ _	36
12. No Chamfer on Head (rim) _ _ _ _ _	36
13. Wrinkle _ _ _ _ _	37
14. Bulge _ _ _ _ _	37
15. Illegible or Missing Head Stamp _ _ _ _ _	37
16. Defective Head _ _ _ _ _	37
17. Defective Mouth _ _ _ _ _	37
17A. Defective Protective Finish _ _ _ _ _	37, 38

BULLET

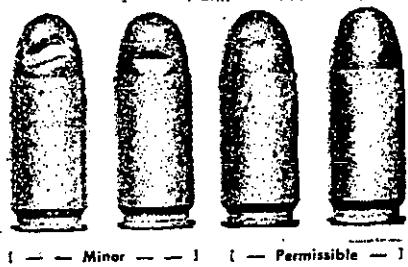
18. Dent (bullet) _ _ _ _ _	39
19. Scratch (bullet) _ _ _ _ _	39
20. Split Bullet Jacket _ _ _ _ _	39
21. Loose Bullet _ _ _ _ _	39
22. Scaly Metal (bullet) _ _ _ _ _	39
23. Upset (crooked) Point _ _ _ _ _	39
24. Exposed Steel (clad jacket) _ _ _ _ _	39
25. Flat Point _ _ _ _ _	39

PRIMER

26. No Primer _ _ _ _ _	40
27. Cocked Primer _ _ _ _ _	40
28. Inverted Primer _ _ _ _ _	40
29. Loose Primer _ _ _ _ _	40
30. Nicked or Dented Primer _ _ _ _ _	40
31. No Waterproofing (Primer pocket loose) _ _ _ _ _	40
32. Defective Crimp _ _ _ _ _	40

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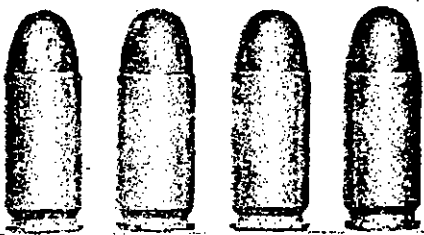
No. 18. Dent (bullet)



[Major]

No. 20. Split Bullet Jacket

A cartridge is to be counted as a defective because of a split bullet jacket if the jacket shows a definite separation of the metal so as to expose the slug.



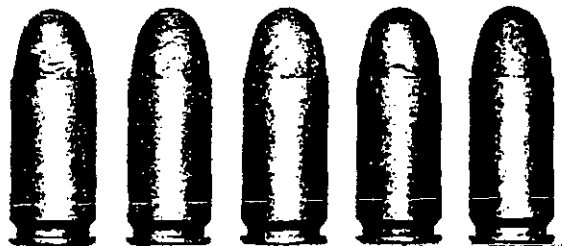
[— Minor —] [Permissible]

No. 19. Scratch (bullet)

No. 21. Loose Bullet (Not illustrated)

Major

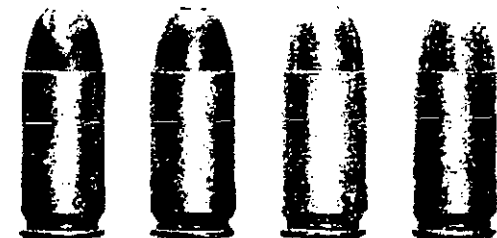
A cartridge is to be counted as a defective because of a loose bullet if the bullet can be moved relative to the case by twisting, pushing or pulling while the cartridge is held in the hands.



[— Major —] [— Minor —] [Permissible]

No. 22. Scaly Metal (bullet)

In classifying scaly metal cartridges, due consideration must be given to the depth as well as the area of the scale.



[— Minor —] [— Permissible —]

No. 23a. Upset (crooked) Point
(Normal size)

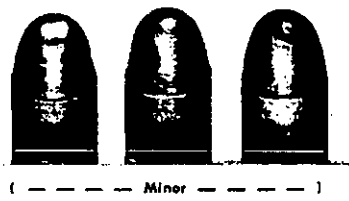


[— Minor —] [— Permissible —]

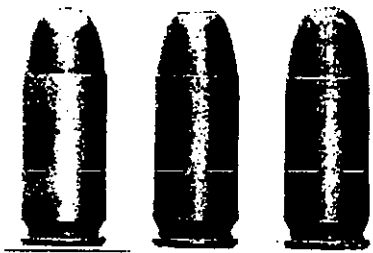
No. 23b. Upset (crooked) Point
(Normal size, inclined view)

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No. 24. Exposed Steel (clad jacket)



[— — Minor — —] [Permissible]

No. 25a. Flat Point
(Normal size)



[— — Minor — —] [Permissible]

No. 25b. Flat Point
(Normal size, inclined view)



[Special]
No. 26.
No Primer

[— — — — — Special — — — — —]
No. 27. Cocked Primer

[Special]
No. 28.
Inverted Primer

No. 29. Loose Primer (Not illustrated)

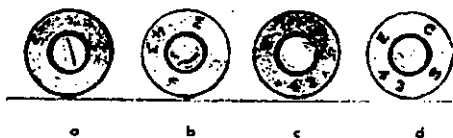
Major

A cartridge is to be counted as a defective because of a loose primer if the primer can be moved within the primer pocket or if the primer can be shaken or jarred from the pocket.



[Minor] [— — Permissible — —]

No. 31. No Waterproofing
(Primer pocket joint)

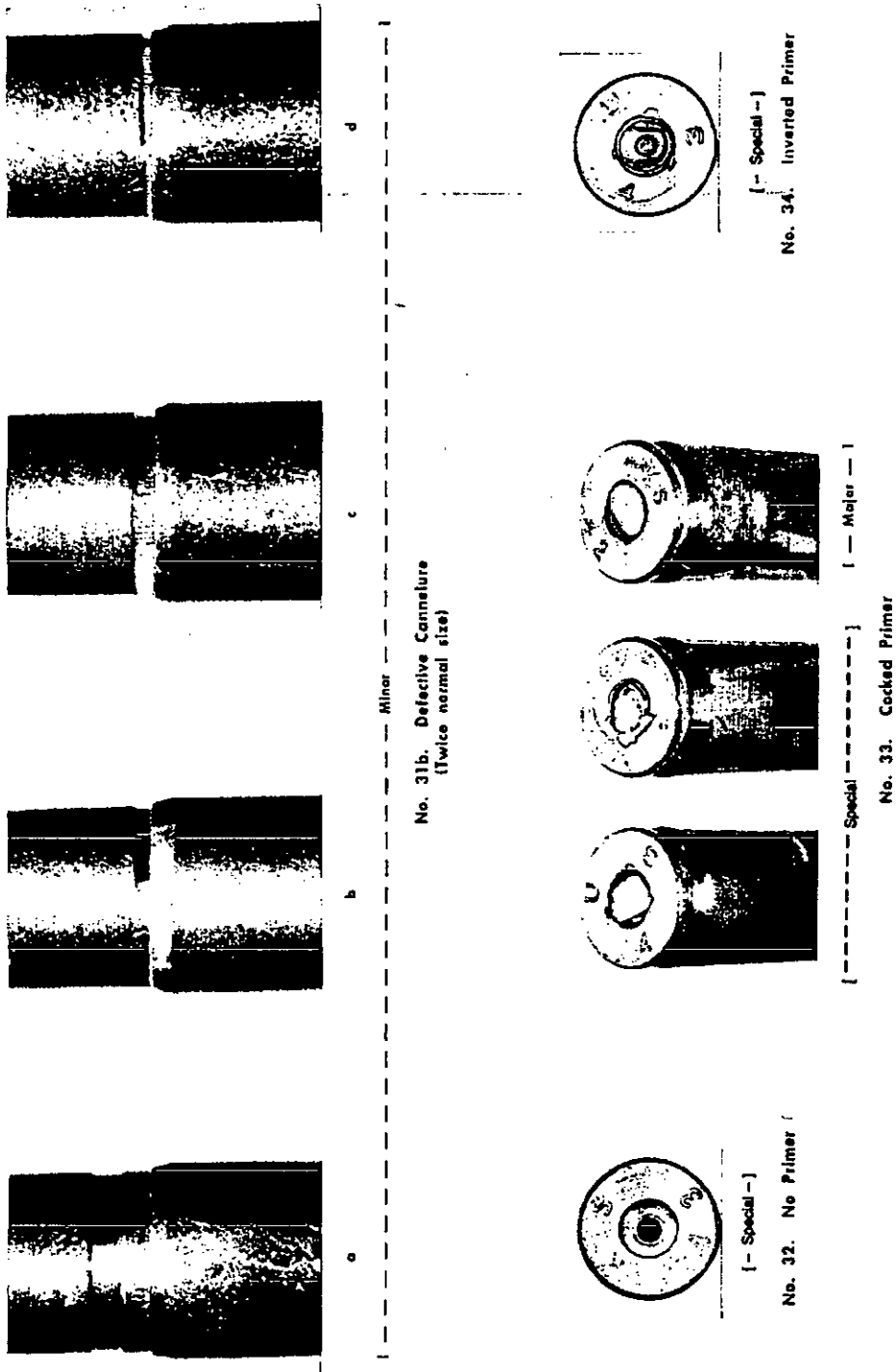


[— — — — — Minor — — — — —] [Permissible]

No. 30. Nicked or Dented Primer

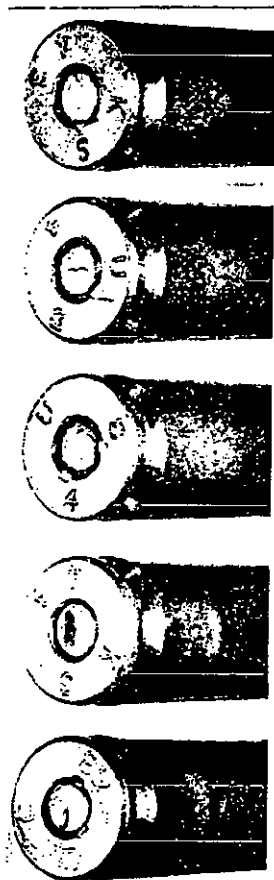
- (a) Deep Nick in Primer Cup.
- (b) Nick extending to edge of Primer Cup.
- (c) Small Nicks and Dents.
- (d)

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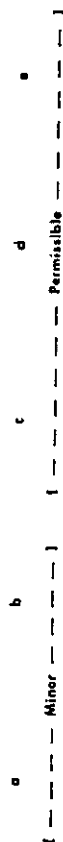
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No. 35. Loose Primer (Not illustrated)

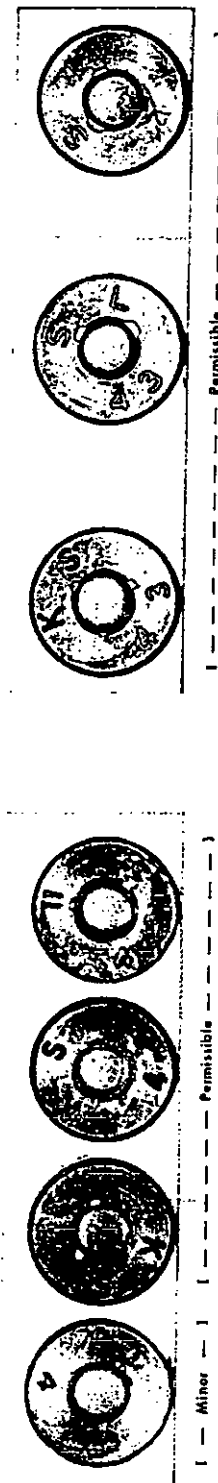
Major

A cartridge is to be counted as a defective because of a loose primer if the primer can be moved within the primer pocket or if the primer can be shaken or jarred from the pocket.



No. 36. Nicked or Dented Primer

- (a) Nick extending to edge of primer cup.
- (b) Deformed primer cup.
- (c) Small nicks and dents.
- (d)
- (e)



No. 37. No Waterproofing
(Primer pocket joint)

No. 38. Defective Crimp

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