

MIL-C-10464F  
14 February 1990  
SUPERSEDING  
MIL-C-10464E  
6 June 1974

## MILITARY SPECIFICATION

CANS, HERMETIC SEALING, METAL, LIGHT GAGE,  
TEAR-STRIP TYPE

This specification is approved for use by all Departments and Agencies of the Department of Defense.

## 1. SCOPE

1.1 Scope. This specification covers the requirements and quality assurance provisions for the manufacture of integral tear strip, hermetically sealed, light gage metal cans for packing of ammunition and pyrotechnic items (see 6.1).

1.2 Classification. The metal cans shall be of the following types as specified (see 6.2):

Type I - Round  
Type II - Rectangular

## 2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications, standards and handbooks. The following specifications, standards and handbooks form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of these documents shall be those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Commander, U.S. Army Armament, Munitions, and Chemical Command, Attn. AMSMC-QA, Picatinny Arsenal, New Jersey 07806-5000 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8140

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

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## SPECIFICATIONS

## FEDERAL

- QQ-P-416 - Plating, Cadmium (Electrodeposited)
- QQ-S-571 - Solder; Tin Alloy, Lead-Tin Alloy, and Lead Alloy
- QQ-T-425 - Tinplate (Electrolytic)
- QQ-W-461 - Wire, Steel, Carbon, (Round, Bare and Coated)
- TT-E-516 - Enamel, Lusterless, Quick Drying Styrenated Alkyd Type
- PPP-B-636 - Box, Shipping, Fiberboard

## MILITARY

- MIL-P-11414 - Primer Coating, Lacquer, Rust Inhibiting
- MIL-F-14256 - Flux, Soldering, Liquid (Rosin-Base)
- MIL-P-19602 - Primer, Size Coating, Baking for Roller Coat Application
- MIL-E-19603 - Enamel, Baking for Roller Coat Application
- MIL-A-48078 - Ammunition, Standard Quality Assurance Provisions, General Specification for
- MIL-A-70625 - Automated Acceptance Inspection Equipment for Non-Electronic Components, Design, Testing and Approval of

## STANDARDS

## FEDERAL

- FED-STD-141 - Paint, Varnish, Lacquer and Related Materials; Method of Inspection, Sampling and Testing

## MILITARY

- MIL-STD-109 - Quality Assurance Terms and Definitions
- MIL-STD-129 - Marking for Shipment and Storage

(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from Military Specifications and Standards, Bldg. 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.)

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2.2 Non-government publications. The following document forms a part of this specification to the extent specified herein. Unless otherwise specified, the issues of the documents which are DoD adopted are those listed in the issue of the DODISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of the documents cited in the solicitation (see 6.2).

## AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM-B633-85

- Specification for Electrodeposited Coatings of Zinc on Iron and Steel

(Application for copies of ASTM publications should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.)

2.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein (except for related associated detail specifications, specification sheets or MS standards), the text of this specification shall take precedence. Nothing in this specification, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

## 3. REQUIREMENTS

3.1 Material.

3.1.1 Materials and parts. Materials and parts shall be in accordance with applicable drawings and specifications. When drawings are not available, dimensions shall be furnished as directed by the contract or purchase order in accordance with Figure 1 (see 6.2).

3.1.2 Lining compound. The lining compound shall be the type which provides an air tight seal for dry pack contents. The compound shall provide a seal which meets the air pressure test requirements of 3.7. The compound shall be uniformly applied to all sealing surfaces of the ends.

3.1.3 Soldering. The solder metal used to fabricate containers under this specification shall conform to the Sn compositions of QQ-S-571. With the approval of the procuring activity, other solder metal may be used.

3.1.3.1 Soldering flux. The flux used for soldering shall conform to MIL-F-14256, Type W. If other fluxes are needed to be compatible with the manufacturing process, they may be used with approval of the procuring activity.