

Bearings, Plain, Rod End, Self-Aligning, Self-Lubricating,
General Specification For (-65 to +325 °F)

RATIONALE

Changes to this document are the result of a five year review, updating supporting specifications called out within the document. Provisions for the CRES series have been added (AS81935/6, /7, 8/ and /9). Marking and Packing note updated (paragraph 5.2) to comply with changes made to MIL-DTL-197. Clarified QPL is now a QPD maintained on the ASSIST website.

1. SCOPE

This specification covers plain rod end bearings, corrosion resistant steel (CRES) or alloy steel, which are self-aligning and self-lubricating by incorporating polytetrafluoroethylene (PTFE) in a liner between the ball and race for use in the temperature range -65 to +325 °F (-54 to +163 °C).

1.1 Classification:

Bearings shall be of the following classes, as specified (see 3.5.4):

Class 1 - Externally threaded shank

Class 2 - Internally threaded shank

2. APPLICABLE DOCUMENTS

The following documents form a part of this document to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order. In the event of conflict between the text of this document and references cited herein (except for associated detail specifications, specification sheets or AS standards), the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

2.1 SAE Publications

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Telephone: 877-606-7323 (inside USA and Canada) or 724-776-4970 (outside USA), www.sae.org

AMS-QQ-P-416 Plating, Cadmium (Electrodeposited).

AMS2700 Passivation of Corrosion Resistant Steels

AMS2750 Pyrometry

AS14101 Bearing, Plain, Self-Lubricating, Self-Aligning, Low Speed, Narrow, Grooved Race, -65 to +325 °F.

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on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS81935C>**

AS14103	Bearing, Plain, Self-Lubricating, Self-Aligning, Low speed, Wide, Grooved Race, -65 to +325 °F.
AS8879	Screw Threads, Controlled Radius Root With Increased Minor Diameter, General Specification
AS81820	Bearing, Plain, Self-Aligning, Self-Lubricating, Low Speed Oscillation.
AS81935/1	Bearing, Plain, Rod End, Self-Aligning, Self-Lubricating, Wide, Externally Threaded, -65 to +325 °F.
AS81935/2	Bearing, Plain, Rod End, Self-Aligning, Self-Lubricating, Wide, Internally Threaded, -65 to +325 °F.
AS81935/3	Locking Device, Rod End.
AS81935/4	Bearing, Plain, Rod End, Self-Aligning, Self-Lubricating, Narrow, Externally Threaded, -65 to +325 °F.
AS81935/5	Bearing, Plain, Rod End, Self-Aligning, Self-Lubricating, Narrow, Internally Threaded, -65 to +325 °F.
AS81935/6	Bearing, Plain Rod End, Self Aligning, Self Lubricating, Wide, Externally Threaded, Steel, Corrosion Resistant (CRES), -65 to + 325 °F.
AS81935/7	Bearing, Plain Rod End, Self Aligning, Self Lubricating, Wide, Internally Threaded, Steel, Corrosion Resistant (CRES), -65 to + 325 °F.
AS81935/8	Bearing, Plain Rod End, Self Aligning, Self Lubricating, Narrow, Externally Threaded, Steel, Corrosion Resistant (CRES), -65 to + 325 °F.
AS81935/9	Bearing, Plain Rod End, Self Aligning, Self Lubricating, Narrow, Internally Threaded, Steel, Corrosion Resistant (CRES), -65 to + 325 °F.

2.2 ASQ Publications

Available from American Society for Quality, 600 North Plankinton Avenue, Milwaukee, WI 53203, Tel: 800-248-1946 (United States or Canada) or +1-414-272-8575 (International), www.asq.org.

ASQ Z1.4 Sampling Procedures and Tables for Inspection by Attributes

2.3 ASME Publications

Available from American Society of Mechanical Engineers, 22 Law Drive, P.O. Box 2900, Fairfield, NJ 07007-2900, Tel: 973-882-1170, www.asme.org

ASME B46.1 Surface Texture (Surface Roughness, Waviness and Lay)

ASME Y14.100 Engineering Drawing Practices

ASME Y14.24 Types and Applications of Engineering Drawings

ASME Y14.34 Associated Lists

ASME Y14.35M Revision of Engineering Drawings and Associated Documents

2.4 ASTM Publications

Available from the ASTM International,, 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959, Tel: 610-832-9585, www.astm.org.

ASTM D3951 Practice for Commercial Packaging

ASTM E1444 Inspection, Magnetic Particle

ASTM A967 Citric Acid Passivation

2.5 U.S Government Publications

Available from Document Automation and Production Service (DAPS), Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094, Tel: 215-697-6257, <https://assist.daps.dla.mil/quicksearch/>

MIL-STD-129 Military Marking for Shipment and Storage

MIL-STD-130 Identification Marking of U. S. Military Property

MIL-DTL-197 Packaging of Bearings, Anti-friction, Associated Parts and Subassemblies

MIL-HDBK-1599 Bearings, Control System Components and Associated Hardware Used in the Design and Construction of Aerospace Mechanical Systems and Subsystems.

2.6 Uniform Classification Committee

Application for copies should be addressed to the Uniform Classification Committee, 202 Chicago Union Station, Chicago, IL 60606

Uniform Classification Committee

Uniform Freight Classification Rules

3. REQUIREMENTS

3.1 Specification Sheets

The individual item requirements shall be as specified herein and in accordance with the applicable AS sheet. In the event of any conflict between the requirements of this specification and the AS sheet, the latter shall govern.

3.2 Qualification

Rod end bearings furnished under this specification shall be products which are authorized by the qualifying activity for listing on the applicable Qualified Products List at the time set for opening of bids (see 4.4, 6.3 and 6.3.1).

3.2.1 Product Design Change

Any change in product design, description, materials or processing procedures will require requalification of the product to an extent determined by the qualifying activity. For the purposes of this specification "change in processing procedures" means a change in any of the following: (1) the company performing rod end body machining, (2) the company performing rod end body heat treating, or (3) the company performing thread forming.

3.3 Bearing Cartridge

The bearing cartridge used in these rod ends shall be in accordance with AS14101 or AS14103, shall be qualified to AS81820 and shall have been subjected to and passed the Quality Conformance Tests of Section 4.4 of AS81820. If the bearing cartridge used in these rod ends was produced by another manufacturer, the Department of Defense regulations and policies regarding rebranding of products shall apply. These regulations state that when a company wishes to supply a qualified product carrying its own brand designations, but which is manufactured by another firm, the manufacturer shall be requested by the company to certify that the company is authorized to rebrand and distribute the product with its own brand designation. Additional information about these regulations may be obtained from Naval Air Systems Command, Code 435400A, 48110 Shaw Road Unit 5, Patuxent River, MD 20670-1906.

3.4 Materials

The rod end body materials shall be in accordance with the applicable AS sheet.

3.4.1 Cadmium Plating

The alloy steel rod end bodies (AS81935/1, AS81935/2, AS81935/4 or AS81935/5) shall be cadmium plated in accordance with AMS-QQ-P-416, Type II, Class 2. The plated bodies shall be heated to a temperature of 375 ± 25 °F within 4 hours after plating but before the chromate treatment and magnetic particle inspection, and held at this temperature for a minimum of 3 hours, after which the bodies shall be allowed to cool normally at room temperature.

3.4.2 Passivation

The corrosion resistant steel (CRES) rod end bodies (AS81935/6, AS81935/7, AS81935/8 or AS81935/9) shall be passivated in accordance with AMS2700, Method 1 (Nitric Acid) or Method 2 (Citric Acid) or passivate in accordance with ASTM A967, citric acid passivation, using CITRIC 1, CITRIC 2, or CITRIC 3 solutions. A permissible method for determining passivity is the copper sulfate test defined in ASTM A967 or AMS2700.

3.4.3 Lubrication

Initial grease or oil lubrication of the bearing cartridge will not be permitted. Use of anti-fretting material between the bearing cartridge and the rod end body is permitted.

3.5 Design and Construction

The design of the rod end bearing shall conform to the requirements of AS81935/1, AS81935/2, AS81935/4, AS81935/5, AS81935/6, AS81935/7, AS81935/8 or AS81935/9. Construction shall be such that all relative motion will be between the liner and ball. Except as otherwise specified, the details of the working parts shall be optional.

3.5.1 Dimensions and Tolerances

Dimensions and tolerances shall be as specified on the applicable AS sheet. Dimensions not shown shall be at the option of the manufacturer.

3.5.1.1 Alloy Steel Body

Rod end spherical head geometry shall conform to the dimensional requirements of AS81935/1, AS81935/2, AS81935/4 or AS81935/5. The manufacturer has the option of qualifying either a "Conical Head" or "Elliptical (Olive) Head" as referenced by Figure 1. The manufacturer shall utilize the head geometry used on the original qualification lot and shall not deviate without first obtaining approval from the Naval Air Systems Command, Code 435400A, 48110 Shaw Road, Unit 5, Patuxent River, MD 20670-1906.

3.5.1.2 Corrosion Resistant Steel (CRES) Body

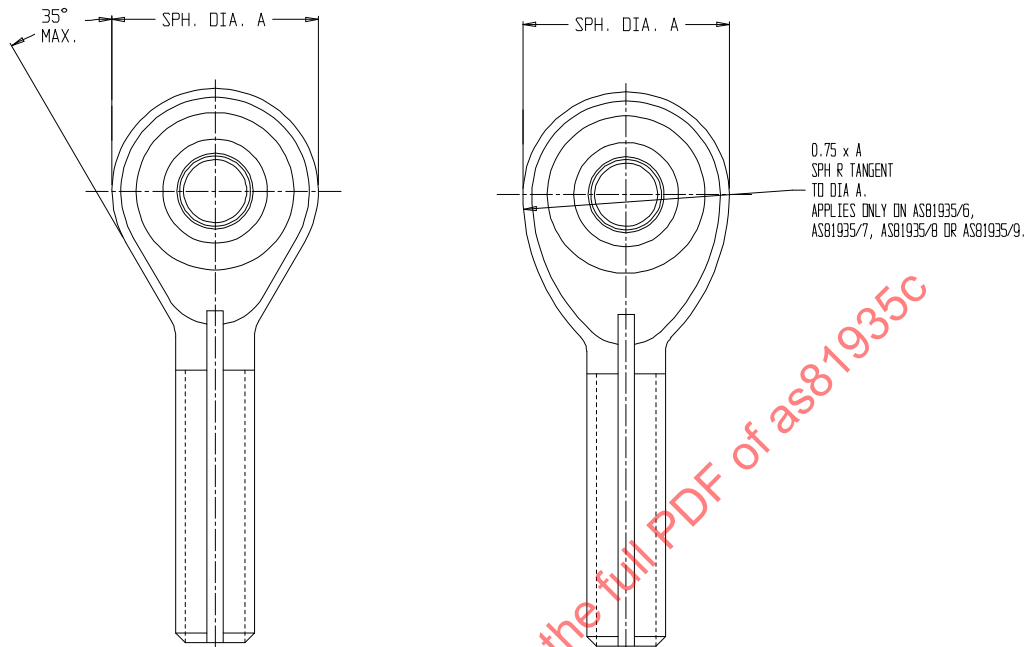
Rod end spherical head geometry shall conform to the dimensional requirements of AS81935/6, AS81935/7, AS81935/8 or AS81935/9. The head geometry is as specified in the applicable AS sheet.

3.5.2 Surface Texture

Surface textures shall be in accordance with the applicable AS sheet and ASME B46.1. Rod end bearings shall be free of any defects which may be detrimental to satisfactory installation, performance or bearing life, as defined by this specification.

3.5.3 Hardness

Each rod end body shall be tested for hardness as specified in 4.7.5. Alloy steel rod ends shall be tested after heat treatment but before plating, corrosion resistant steel (CRES) rod ends to be tested after heat treat. Only rod end bodies with Rockwell readings in the range allowed by the applicable AS sheet shall be acceptable.



Conical Head

Elliptical or Olive Head

FIGURE 1— HEAD GEOMETRY

3.5.3.1 Hardness Sampling

Rod end bodies, heat treated and tempered in furnaces qualified and maintained in accordance with AMS2750, may be sample hardness tested in accordance with ASQ Z1.4, General Inspection Level II, AQL 1.0, provided the ten (10) previous lots of each part number were found acceptable to 100% hardness testing.

3.5.4 Threads

3.5.4.1 Class 1 rod ends (External Thread)

Dimensions, form and contour shall conform to AS8879. Threads shall be rolled after heat treatment. Rerolling of threads to correct dimensional deficiencies shall not be permitted.

3.5.4.2 Class 2 rod ends (Internal Thread)

Threads shall conform to AS8879.

3.5.5 Magnetic Particle Inspection

All rod end bodies shall be examined by magnetic particle inspection as specified in 4.7.6.1. Any rod end bodies having discontinuities equal to or exceeding the limitations specified herein shall be rejected. Care must be exercised to avoid confusing cracks, as described herein, with other discontinuities.

3.5.5.1 Cracks

Rod end bodies shall be free of cracks in any direction or location. A crack is defined as a clean crystalline break passing through the grain or grain boundary without the inclusion of foreign elements.

3.5.5.2 Laps and Seams

Rod end bodies may possess laps and seams, except in locations specified in 3.5.5.4 and 3.5.5.5. Except as noted, the depths shall not exceed the amounts specified in Table 1. A lap is a surface defect appearing as a seam caused by folding over hot metal fins or sharp corners and then rolling or forging them into the surface, but not welding them. A seam is an unwelded fold or lap which appears as an opening in the raw material as received from the source.

TABLE 1 - DISCONTINUITY DEPTHS ^{1/}

Bearing Size	-04 and -05	-06	-07	-08 thru -16
Seam Depth (inch) (maximum)	0.005	0.006	0.007	0.008

^{1/} Depth of discontinuity shall be measured normal to the surface at the point of greatest penetration.

3.5.5.3 Inclusions

Rod end bodies shall show no evidence of surface or subsurface inclusions at the thread root, hoop-to-shank fillet or in the 3 to 6 to 9 o'clock positions of the hoop (see Figure 2) when inspected in accordance with 4.7.6. Small inclusions in other parts of the rod end body not indicative of unsatisfactory material quality, shall not be cause for rejection.

3.5.5.4 Hoop and Hoop-to-shank Fillet Discontinuities (seams and folds)

The rod end body shall not have seams or folds in the 3 to 6 to 9 o'clock positions of the hoop (see Figure 2) or in the hoop-to-shank fillet. Seams or folds in the 9 to 12 to 3 o'clock positions of the hoop not exceeding the limits of Table 1 shall not be cause for rejection.

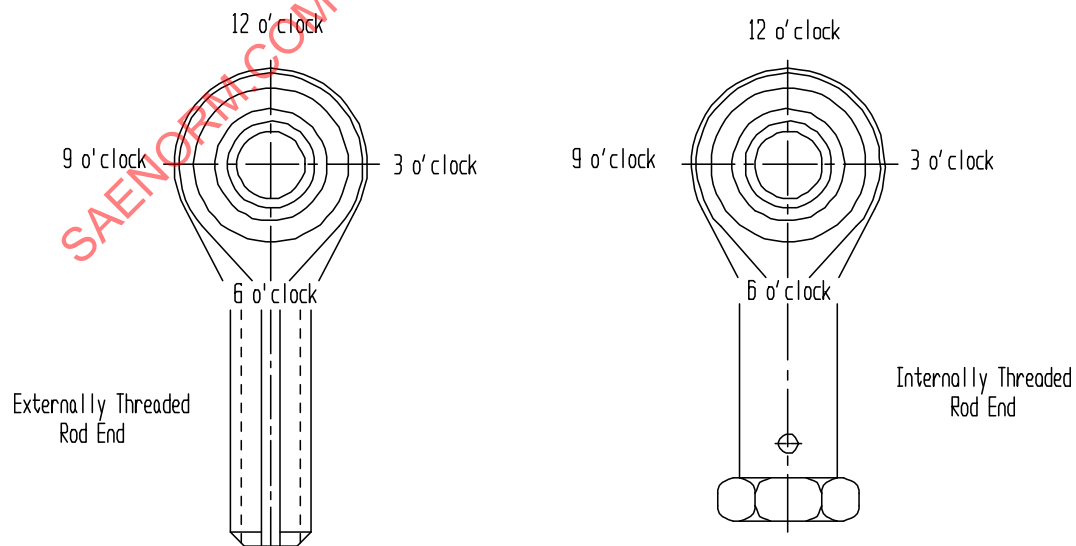
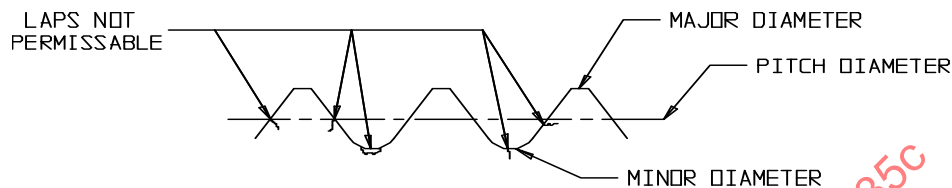


FIGURE 2 - HOOP POSITION DESIGNATIONS

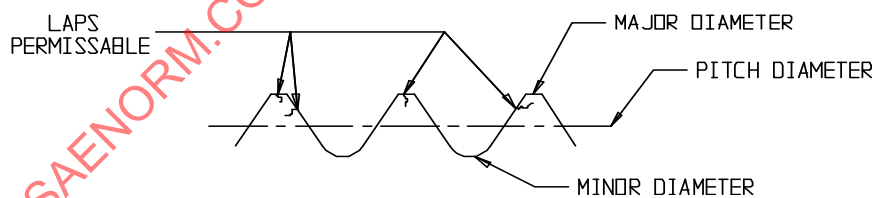
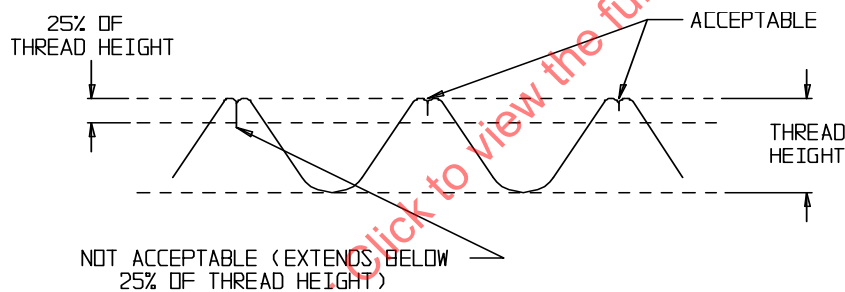
3.5.5.5 Thread Discontinuities (Laps, Seams and Surface Irregularities):

Threads shall have no multiple or single laps at the root or on the sides (Figure 3), except that laps are permissible at the crest which do not exceed 25% of basic thread depth, and on the sides outside the pitch diameter (see Figure 4). Deviation from the thread contour is permissible at the crest of the thread as shown in Figure 4. The incomplete thread at each end of the thread may also deviate from contour.



Note: For limits see 3.5.5.2 and 3.5.5.3.

FIGURE 3 - NONPERMISSIBLE LAPS, SEAMS AND INCLUSIONS



Note: For limits see 3.5.5.5.

FIGURE 4 - PERMISSIBLE LAPS, SEAMS AND INCLUSIONS

3.6 Performance

3.6.1 Ultimate Static Load

No fracture of the rod end body shall occur when the ultimate static load specified on the applicable AS sheet is applied in accordance with 4.7.1.

3.6.2 Axial Static Proof Load

No pushout of the bearing cartridge from the rod end body shall occur when the axial proof load on the applicable AS sheet is applied as specified in 4.7.2.

3.6.3 Fatigue Load

The rod end bearings shall be capable of withstanding a minimum of 50 000 cycles of loading when tested in accordance with 4.7.3.

3.6.4 Self-alignment

The rod end bearing shall be self-aligning and permit the angular displacement specified on the applicable AS sheet.

3.6.5 No-load Rotational Breakaway Torque

When tested in accordance with 4.7.4, the no-load breakaway torque shall be within the limits of the values specified on the applicable AS sheet.

3.7 Interchangeability

All parts having the same manufacturer's part number shall be directly and completely interchangeable with each other with respect to installation and performance. The drawing number requirements of ASME Y14.100 shall govern changes in the manufacturers' part numbers.

At the discretion of the end user, Type "A" bearings listed on the QPL, may be substituted for the same, Non-Type "A" bearings on the QPL. Non-Type "A" bearings shall not be substituted for Type "A" bearings.

3.8 Identification of Product

Each rod end bearing shall be permanently and legibly marked with the military identifying part number, the manufacturer's name or trademark, and manufacturer's part number. Where practicable, identification shall appear on the side face of the rod end body; otherwise identification shall appear on the periphery of the rod end body. Marking method in accordance with MIL-STD-130. Metal impression stamping is prohibited.

3.9 Workmanship

The rod end bearing shall be free of tool marks, chatter waves, rust, grinding scratches, pits, cracks or any other defects that may adversely affect their serviceability.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for Inspection

Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or purchase order, the supplier may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.1.1 Responsibility for Compliance

All items must meet all requirements of Sections 3 and 5. The inspection set forth in this specification shall become a part of the supplier's overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the supplier of the responsibility of assuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling in quality conformance does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to acceptance of defective material.

4.2 Qualification Test Records

The manufacturer shall maintain a record showing quantitative results for all tests required by this specification. This record shall be available to the purchaser and shall be signed by an authorized representative of the manufacturer or the testing laboratory, as applicable.

4.3 Classification of Inspection

The examination and testing of the rod end bearings shall be classified as:

- a. Qualification inspection (4.4).
- b. Quality conformance inspection (4.5).

4.4 Qualification Inspections

4.4.1 Sampling Instructions

Qualification inspection samples shall consist of three (3) untested rod end bearings of sizes -06, -08, -12 for each class (1 and 2) for which qualification is desired. The test rod end bearings shall be furnished by the manufacturer. The rod end bearings shall be identified and forwarded to the Naval Air Systems Command, Code 435400A, 48110 Shaw Road, Unit 5, Patuxent River, MD 20670-1906.

Approval of the rod end bearing sizes in Table 2 Column I will extend to approval of the corresponding sizes in Column II.

TABLE 2 - ORDER OF QUALIFYING ROD END BEARINGS

ALLOY STEEL ROD ENDS

Wide Series		Narrow Series	
I	II	I	II
M81935/1-06	M81935/1-03, -04, -05, -06	M81935/4-06	M81935/4-03, -04, -05, -06
M81935/1-08	M81935/1-07, -08, -10	M81935/4-08	M81935/4-07, -08, -10
M81935/1-12	M81935/1-12, -14, -16	M81935/4-12	M81935/4-12, -14, -16
M81935/2-06	M81935/2-03, -04, -05, -06	M81935/5-06	M81935/5-03, -04, -05, -06
M81935/2-08	M81935/2-07, -08, -10	M81935/5-08	M81935/5-07, -08, -10
M81935/2-12	M81935/2-12, -14, -16	M81935/5-12	M81935/5-12, -14, -16

CORROSION RESISTANT STEEL (CRES) ROD ENDS

Wide Series		Narrow Series	
I	II	I	II
M81935/6-06	M81935/6-03, -04, -05, -06	M81935/8-06	M81935/8-03, -04, -05, -06
M81935/6-08	M81935/6-07, -08, -10	M81935/8-08	M81935/8-07, -08, -10
M81935/6-12	M81935/6-12, -14, -16	M81935/8-12	M81935/8-12, -14, -16
M81935/7-06	M81935/7-03, -04, -05, -06	M81935/9-06	M81935/9-03, -04, -05, -06
M81935/7-08	M81935/7-07, -08, -10	M81935/9-08	M81935/9-07, -08, -10
M81935/7-12	M81935/7-12, -14, -16	M81935/9-12	M81935/9-12, -14, -16

4.4.2 Certified Test Report

The manufacturer shall furnish a certified test report showing the manufacturer's product satisfactorily conforms to this specification. The test report shall include, as a minimum, actual results of the tests specified herein. When the report is submitted, it shall be accompanied by a dated drawing which completely describes the manufacturer's product by specifying all dimensions and tolerances, the part number of the bearing cartridge, anti-fretting material if used, coating or plating, and heat treatment. The manufacturer's part number for each size shall be included on the drawing.

4.4.3 Inspections

Qualification inspections shall include all the examinations and tests of this specification. The minimum number of samples per test shall be in accordance with Table 3.

TABLE 3 - QUALIFICATION INSPECTION SAMPLES.

Examination and Test	Paragraph No.	Samples To Be Tested
Examination of product	4.6.1	5
Preparation for delivery	4.6.2	5
Ultimate static load	4.7.1	3
Axial static proof load *2/	4.7.2	3
Fatigue load	4.7.3	3

*2/ Satisfactory test results for Class 1 rod end bearings will apply toward qualification of Class 1 and Class 2.

4.4.4 Retention of Qualification

The retention of qualification shall consist of periodic verification and shall be by certification unless otherwise specified by the activity responsible for the Qualified Products List and shall be at intervals of not more than five years.

4.5 Quality Conformance Inspections

4.5.1 Bearing Cartridge Inspection

The bearing cartridge installed in the rod end body shall meet the requirements of paragraph 3.3. The bearing supplier shall maintain and supply to the purchaser upon demand:

- Certified copies of all records of quality conformance tests specified in paragraph 4.4 of AS81820.
- Certification that the materials and manufacturing procedures used in producing the bearing cartridge are the same as those of the bearings originally qualified.

4.5.2 Rod End Bearing Inspection

The rod end quality conformance inspections shall consist of the inspections listed in Table 4.

TABLE 4 - QUALITY CONFORMANCE INSPECTIONS

For Class 1 (External Thread) and Class 2 (Internal Thread) Rod Ends

Examination Or Test		Major Char.	Minor Char.	Special Insp. Plan	Requirement Paragraph	Test Paragraph
(a) Dimensions						
Bore	"B"	X			3.5.1	4.6.1
Outside Sph. Dia	"D"		X		3.5.1	4.6.1
Shank/Head Fillet Radius			X		3.5.1	4.6.1
35° Max. Angle			X		3.5.1	4.6.1
.06/.12 Radius	(2)		X		3.5.1	4.6.1
Min. Thread Length	"L" (2)		X		3.5.1	4.6.1
Thread Length	"L" (1)		X		3.5.1	4.6.1
Thread Size	"E"	X			3.5.1	4.6.1
C-Line Ball to End	"F"		X		3.5.1	4.6.1
C-Line Drill to End	"G" (2)		X		3.5.1	4.6.1
Ø .070 Witness Hole	(2)		X		3.5.1	4.6.1
Shank Dia.	"N" (2)		X		3.5.1	4.6.1
Ball Width	"W"	X			3.5.1	4.6.1
Body Width	"H"		X		3.5.1	4.6.1
Ball Shoulder Dia.	"A"		X		3.5.1	4.6.1
Max. Housing ID	"J"		X		3.5.1	4.6.1
Tap Drill Depth	"M" (2)		X		3.5.1	4.6.1
Ht Across Wrench Flat	"C" (2)		X		3.5.1	4.6.1
Width of Wrench Flat	"R" (2)		X		3.5.1	4.6.1
Ball Tilt Angle Min.	"Q"		X		3.5.1	4.6.1
Keyway Flat Depth	"P"		X		3.5.1	4.6.1
Keyway Width	"K"		X		3.5.1	4.6.1
Keyway Corner Radii			X		3.5.1	4.6.1
Keyway			X		3.5.1	4.6.1
Perpendicularity						
(b) Identification of Product			X		3.8	4.6.1
(c) Workmanship			X		3.9	4.6.1
(d) Preparation for Delivery			X			4.6.2
(e) Breakaway Torque				100%	3.5.1	4.6.1
(f) Mag. Part. Inspection				100%	3.5.5	4.7.6.1
(g) Hardness				3.5.3.1	3.5.1	4.7.5
(h) Cad. Plating (3)				Certification Only		
(i) Passivation (4)				Certification Only		

(1) Inspection required only on Class 1 (External Thread) Rod Ends.

(2) Inspection required only on Class 2 (Internal Thread) Rod Ends.

(3) Inspection shall consist of verification of plating certification from plating vender / source. Applies to AS81935/1, AS81935/2, AS81935/4 or AS81935/5 only.

(4) Inspection shall consist of verification of passivation certification from vendor/source. Applies to AS81935/6, AS81935/7, AS81935/8 or AS81935/9 only.

4.5.3 Inspection Lot

The inspection lot shall consist of finished rod end bearings, having a single part number, manufactured by the procedures established for the original qualified rod ends, which can be defined by means of in-house processing records.

4.5.4 Sampling

4.5.4.1 Sample for Quality Conformance Tests (a) through (d) (Table 4)

The sample rod ends shall be selected at random from each inspection lot in accordance with Table 5. If no defect is found in the sample, the lot shall be accepted for these tests. If any defects are found in the sample, the entire lot shall be inspected 100% for each defective characteristic found, and all defective parts shall be removed from the lot.

4.5.4.2 Sample for Qualification Conformance Tests (e) and (f)

Inspection shall be 100% of the lot. All defective parts shall be removed from the lot.

TABLE 5 - SAMPLING PLAN FOR QUALITY CONFORMANCE INSPECTIONS
ZERO-BASED ACCEPTANCE PLAN (C=0)

SAMPLE SIZE

Acceptance number in all cases is zero.

"A" indicates entire lot must be inspected.

LOT SIZE	Major Characteristic	Minor Characteristic
1-2	A	A
3-8	A	3
9-12	A	3
13-15	13	3
16-25	13	3
26-50	13	5
51-90	13	6
91-150	13	7
151-280	20	10
281-500	29	11
501-1200	34	15
1201-1249	42	18
1250-3200	42	18
3201-10 000	50	22

4.6 Examinations

4.6.1 Examination of Product

The rod end bearings shall be examined to determine conformance to the requirements of this specification and the applicable standard for material, plating, dimensions, finish, identification of product, workmanship and requirements not covered by tests.

4.6.2 Inspection of Preparation for Delivery

Preservation, packaging, packing and marking shall be inspected to determine conformance of Section 5.