

[INCH-POUND]**A-A-55077A****January 5, 2000****SUPERSEDING****A-A-55077****September 2, 1992**

COMMERCIAL ITEM DESCRIPTION

BAG, DUFFEL

The General Services Administration has authorized the use of this commercial item description for all Federal agencies.

1. **SCOPE.** This document covers a nylon duck, Camouflage Green 483 (see paragraph 6.4) duffel bag measuring 12-1/2 inches in diameter by 37 inches deep, having one handle, one closing strap with snap hook, and shoulder straps. The modified commercial type bag is designed to hold individual clothing and equipage allowance and is intended for use by members of the Department of Defense.

2. **SALIENT CHARACTERISTICS.**

2.1 **Description.** The bag is tubular in shape, constructed with a sewn on bottom piece and open top with a single ply flap, attached to the body of the bag as shown in figure 2. The bag is closed by inserting a keeper through the grommets located around the top, and can be securely locked with the attached closing strap with snap hook or a padlock if desired. The keeper is held in place by the turn-down self facing at the top of bag, as shown in figure 1. A webbing handle and shoulder straps are attached to provide means for either hand or shoulder carrying. The shoulder straps shall each have an adapter for adjustment and shall be padded: the pad shall finish approximately 2-1/4 inches wide and 14 inches in length and shall be covered with nylon duck cloth and stitched securely to the shoulder strap webbing. The handle and shoulder straps are reinforced with webbing stitched to the body of the bag. A pocket with a snap closure on the flap is attached to accommodate shipping documents.

2.2 **Manufacturing requirements.** The construction of the duffel bag shall conform in all respects to Figures 1-4 and shall be as specified herein. The body joining seam shall be ASTM-D6193 seam type LSc-2, stitch type 401; all other seams shall be stitch type 301. All thread ends that are visible on the item shall be trimmed to a length of not more than 1/4 inch. Cut ends of nylon webbing shall be seared smooth. Repairs such as mends, darns, patches or splices are not permitted on the duffel bag. Location marks shall not be drilled. Printed location marks shall not be more than 1/32 inch in width. After completion, the finished bag shall be thoroughly cleaned, and all loose thread, lint, and foreign matter removed.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Defense Supply Center Philadelphia, Clothing and Textiles Directorate, Attn: DSCP-CRFD, 700 Robbins Avenue, Bldg 6, Area D, Philadelphia, PA 19111-5092.

A-A-55077A

2.2.1 Attachment of grommets and fasteners. Holes punched to receive the grommets shall be smaller than the outside diameter of the grommet barrel so that the barrel must be forced through the hole. The grommets shall be securely clinched without cutting the materials. All grommet washers shall be on the outside of the bag. Roll of the clinched grommet shall not contain more than three scores (splits) and no scores (splits) shall exceed 1/16 inch in length. A hole shall be prepunched through the material before inserting the stud eyelet tube or the socket eyelet tube. The hole shall be smaller than the outside diameter of the applicable eyelet tube, so that the tube must be forced through the hole. Prepunched holes shall not be accomplished by using stud or socket eyelet tubes (as applicable). The fastener components shall be securely clinched without cutting the surrounding material. Roll of the clinched eyelet of the assembled fastener component shall not possess more than three scores (splits). All grommets shall be reinforced with a piece of nylon duck measuring approximately 3 inches square, placed inside the turn-down facing. The grommets shall be placed as shown in figures 1 through 3, evenly spaced and approximately 12 inches apart.

2.2.2 Identification marking. The "US" marking shall be applied in the size and location indicated on figure 2, and shall be black in color, made by marking, direct printing, stamping, or stenciling. The identification marking shall be made up of characters approximately 1/4-inch in height, black in color, made by marking, direct printing, stamping, or stenciling on the inside of the top hem of the duffel bag. The marking legibility shall last the expected life of the bag. The identification marking shall include the following information:

Contract Number:
National Stock Number (NSN):
Contractor's Name:

2.3 Materials.

2.3.1 Cloth, duck, nylon. The cloth for the duffel bag shall be nylon duck, plain weave, dyed Camouflage Green 483, water repellent treated and coated on the back with a suitable clear polyurethane coating compound. If plasticizers are used in the coating, only phosphate or phthalate ester type plasticizers shall be used. The color of the dyed cloth shall match the standard sample when viewed under filtered tungsten lamps that approximate artificial daylight and that have a correlated color temperature of 7500 ± 200 K, with illumination of 100 ± 20 foot candles, and shall be a good match to the standard sample under incandescent lamplight at 2300 ± 200 K. The finished cloth shall not present a dermal health hazard when used as intended (see paragraph 2.3.1.1), and shall conform to the requirements in Table I.

TABLE I. Physical requirements for nylon duck.

Characteristic	Requirement	Test Method
Weight (oz./sq. yd.)	11.0 – 12.0	ASTM-D3776 Option C
Yarns per inch (min.)		ASTM-D3775
Warp	35	
Filling	28	
Breaking strength (lbs., min.)		ASTM-D5034
Warp	500	
Filling	300	

A-A-55077A

TABLE I. Physical requirements for nylon duck, cont'd.

Characteristic	Requirement	Test Method
Colorfastness to: Accelerated weathering Crocking	(minimum) "good" 3.5 <u>2</u> /	AATCC-111A <u>1</u> / AATCC-8
Spray rating (min.) Initially After 1 laundering	100, 100, 90 90,90,80	AATCC-22 AATCC-96 Test VI,A and AATCC-22
Hydrostatic resistance	no leakage	ASTM-D751 <u>3</u> /
pH	4.5 – 8.5	AATCC-81
Dimensional stability (min.) Warp Filling	3.5 2.5	AATCC-96 Test VI,A

1/ The time of exposure shall be 40 hours.

2/ Minimum acceptable rating based on the AATCC Chromatic Transference Scale.

3/ Procedure B, Procedure 1: The finished cloth shall show no leakage below a hydrostatic height of 35 centimeters. Leakage is defined as the appearance of water at three or more different places within the 4-1/2 inch diameter test area. The uncoated side of the coated cloth shall contact the water.

2.3.1.1 Toxicity assessment. The finished product must be composed of materials, which have been safely used commercially during prolonged, direct skin contact. Test methods for toxicity are: Primary dermal irritation study in laboratory animals (see paragraph 6.1, Acute Dermal Toxicity 870.1200) and a repeated insult human patch test (Modified Draize Procedure) (see paragraph 6.2, Principles and Methods of Toxicology). The latter must be conducted under the supervision of a qualified dermatologist using at least 100 free living individuals.

2.3.2 Nylon webbing. The woven nylon webbing for the shoulder strap, closing strap, handle and reinforcements shall be 1-23/32 inches wide, Camouflage Green 483, and shall be resin impregnated for strength. The untreated weight shall be 1.60 ounces per linear yard maximum. The weight after webbing is resin impregnated shall be the untreated weight plus a maximum of ten percent. The cut ends of the nylon webbing shall be fused so they are seared smooth.

2.3.3 Thread, polyester. The thread shall be polyester, Camouflage Green 483, constructed of twisted soft multiple cord or twisted bonded multiple cord, with a nonwicking finish, 4 ply, with a minimum breaking strength of 10.6 lbs. when tested as specified in ASTM D-2256 (testing speed shall be 12 ± 0.5 in./min. and a 10 inch gauge length shall be used). There shall be no lubrication of the thread by any means prior to or during sewing.

2.3.4 Grommets. The duffel bag shall have 4 plain grommets with plain washers. The grommets and washers shall be brass with a black chemical finish, size number 5.

2.3.5 Keeper, steel or brass. The keeper shall be either steel or brass. Steel keepers shall be fabricated from 0.1483 inch nominal diameter, carbon steel wire. The finish of the steel keeper shall consist of phosphate-treated zinc plate conforming to Type IV, SC3 (severe) of ASTM B633, followed by baked enameling. The enamel shall be black. The coating shall level out to a uniform continuous dry film of uniform black color with no objectionable orange peel, wrinkles, drops, streaks, or areas of thin or no film. Brass keepers shall be fabricated from half-hard brass wire, 0.1443 inch nominal diameter. Brass keepers shall be given a black chemical finish.

A-A-55077A

2.3.6 Snap hook, 1-1/8 inch fixed loop, with spring closure. The snap hook with spring closure shall have a steel wire body conforming to ITW Waterbury Buckle Co., style no. 00833-23-21883 or equal (see paragraphs 4.1.1 and 6.3). The finish of the steel keeper shall consist of phosphate-treated zinc plate conforming to type IV, SC3 (severe) of ASTM B633, followed by baked enameling. The enamel shall be black.

2.3.7 Fastener, snap. The snap fastener shall be brass, with a regular wire spring clamp, black in color with a commercial dark oxide finish.

2.3.8 Shoulder pad cushion. The shoulder pad cushions shall be olefin, with a minimum weight of 8.25 ounces per square yard and a maximum weight of 19.5 ounces per square yard, color optional. As an alternate, 1/4 inch thick closed-cell soft cellular rubber may be used. The size of the pad shall be 14 inches by 2-1/4 inches (\pm 1/4 inch).

2.3.9 Adapter. The shoulder strap adapters shall be reversible, quick fit, 250 lbs., 1-3/4 inches, or Waterbury Buckle Co. part no. 10741-21-21820, 1-3/4 inch, or equal (see paragraphs 4.1.1 and 6.3). The color shall be Black.

2.4 Label/tag. Each item shall be individually bar-coded with a paper tag for personal clothing items. The paper tag shall be standard bleached sulfate having a basis weight of 100 pounds. The paper used for the tags shall have a smooth finish to accept thermal transfer and direct printing. The tags shall have a hole and shall be attached to each item by a fastener, clearly legible and readable by a scanner. The bar coding element shall be a 13 digit national stock number (NSN). The bar code type shall be a medium to high code density and shall be located so that it is completely visible on the item when it is folded and/or packaged as specified and so that it causes no damage to the item.

3. REGULATORY REQUIREMENTS.

3.1 Recycled, recovered, or environmentally preferable materials. Recycled, recovered, or environmentally preferable materials should be used to the maximum extent possible provided that the material meets or exceeds the operational and maintenance requirements, and promotes economically advantageous life cycle costs.

4. QUALITY ASSURANCE PROVISIONS.

4.1 Product conformance. The products provided shall meet the salient characteristics of this commercial item description, and shall conform to the producer's own higher level quality standards and quality assurance practices. The Government reserves the right to require proof of such conformance.

4.1.1 Equal items. Prior to the use of an "or equal" item, the supplier shall submit the item with supporting data to the contracting officer for subsequent approval or disapproval by the responsible military agency.

4.2 Visual examination. Each duffel bag shall be examined for the defects listed below.

4.2.1 Manufacturing defects. Any hole, cut, or tear; color not as specified, any part shaded, any spot or stain (outside). Any material defects clearly visible: any smash, weak place, broken or missing yarn, multiple floats, or open place, shade bar; coated side of cloth tacky, uncoated side of cloth not facing out. Raw edges (on edge required to be finished), open seams, thread ends not trimmed to 1/4 inch maximum length, distorted parts, more than 1/2 inch securely caught in stitching, needle chews, seams pleated or badly puckered, runoff, loose tension resulting in a loosely secured seam; tight tension (stitches break when normal strain is applied to seam or stitching). Measurement and dimensions of item not as specified, any component omitted, misplaced, or not as specified, bottom of bag not set to body as specified, i.e. center of bottom not aligned with center of handle and carrying strap assembly.

A-A-55077A

Any mend, darn, patch, or splice, any drill hole in fabric, hems twisted or pleated, any part of stitching attaching handle and handle reinforcements to body not stitched through body reinforcement. Edges of grip section overlapped, ends of carrying strap not finished as specified, pocket and pocket flap not attached to body of bag as specified, snap fastener components misplaced or not properly aligned failing to effect a smooth and secure closure. Ends of strap not finished as specified; any part of stitching requiring attaching nylon webbing to body of bag not stitched through body and reinforcement, shoulder adjustment strap not caught in between bottom and body, finished length of closing strap is longer or shorter than specified dimension and applicable plus or minus tolerance.

4.2.2 Attachment of grommets and fasteners defects. Adapter improperly set or fails to function properly; grommets improperly set with washer on inside of bag; holes not punched to receive grommets or fasteners; grommet fails to accommodate keeper; clinched excessively tight cutting fabric or insecurely clinched, i.e., grommet or washer becomes disengaged; clinched loosely, allowing grommet to rotate in hole; roll of grommet contains more than three scores (splits); grommet not completely surrounded by grommet reinforcement patch; grommet set off center of hem by more than ¼ inch; any score (splits) exceeding 1/16 inch in length; keeper improperly set or located; snap fastener has improper or insecure clinching; clinched excessively tight, cutting adjacent material; clinched loosely, permitting components to rotate freely in the hole of the material; incorrect style of snap fastener; roll of clinched eyelet fastener assembly contains more than three scores (splits).

4.2.3 Label and marking defects. Bar code omitted or not readable by scanner; human-readable interpretation (HRI) omitted or illegible; bar code not visible on folded, packaged item; bar code causes damage to the item. Marking omitted, incorrect, illegible, misplaced, or size of characters not as specified.

4.2.4 Webbing defects. Any hole, cut, tear or smash in webbing, webbing not firmly and tightly woven, edges frayed or scalloped; cut ends of nylon webbing not fused.

4.2.5 Hardware defects. Hardware broken or malformed, finish omitted, burrs, sharp edges, corroded areas; area of thin or no film, i.e., bare metal exposed; enamel finish (where applicable) is not uniform and adherent, i.e., objectionable orange peel, wrinkles, drops or streaks. Keeper fails to function or engage with snap hook; any fastener not functioning properly, i.e., fails to snap closed, provide a secure closure, or open freely.

4.2.6 Packaging defects. Any containers not packaged as specified and in accordance with the contract or purchase order.

4.3 Acceptance criteria. Acceptance criteria shall be as specified in the contract or purchase order.

5. PACKAGING

5.1 Preservation, packing, and marking. Preservation, packing, and marking shall be as specified in the contract or order.

6. NOTES.

6.1 Source of Government documents. Copies of military and Federal documents are available from:

Standardization Documents Order Desk
Bldg. 4D
700 Robbins Avenue
Philadelphia, PA 19111-5094

A-A-55077A

Environmental Protection Agency
Office of Prevention, Pesticides and Toxic Substances
870.1200 (Acute Dermal Toxicity)

(Copies may be obtained from the U.S. Government Printing Office, Washington, DC 20402, or from the Environmental Protection Agency at 800 490-9198.)

6.2 Source of non-Government documents

ASTM B-633 - Standard Specification for Electrodeposited Coatings of Zinc on Iron and Steel
ASTM D-751 - Standard Test Methods for Coated Fabrics
ASTM D-2256 - Tensile Properties of Yarns by the Single-Strand Method
ASTM D-3775 - Standard Test Method for Fabric Count of Woven Fabric
ASTM D-3776 - Standard Test Method for Mass Per Unit Area (Weight) of Fabric
ASTM D-5034 - Breaking Force and Elongation of Textile Fabrics (Grab Test)
ASTM D-6193 - Standard Practice for Stitches and Seams

(Applications for copies should be addressed to American Society for Testing and Materials, 100 Barr Harbor Drive, West Conshohocken, PA 19428.)

AATCC 8 - Colorfastness to Crocking: AATCC Crockmeter Method
AATCC 22 - Water Repellency: Spray Test
AATCC 81 - pH of the Water-Extract from Wet Processed Textiles
AATCC 96 - Dimensional Changes in Commercial Laundering of Woven and Knitted Fabrics Except Wool
AATCC 111A - Weather Resistance: Exposure to Natural Light and Weather
AATCC Chromatic Transference Scale

(Applications for copies should be addressed to American Association of Textile Chemists and Colorists (AATCC), P.O. Box 12215, Research Triangle Park, NC 27709-2215.)

Principles and Methods of Toxicology, A. Wallace Hayes (editor), 1989, pp. 394-396.

(Applications for copies should be addressed to Raven Press, 1185 Avenue of the Americas, New York, NY 10036.)

6.3 Source for snap hook and adapter. Waterbury Buckle Company, 952-T South Main St., Waterbury, CT 06720. Phone (203) 753-1161.

6.4 Source for standard samples. Contact the contracting agency for information on obtaining a standard sample for Camouflage Green 483.

A-A-55077A

MILITARY INTERESTS:

Custodians:

Army-GL
Navy-NU
Air Force-99

Review Activities

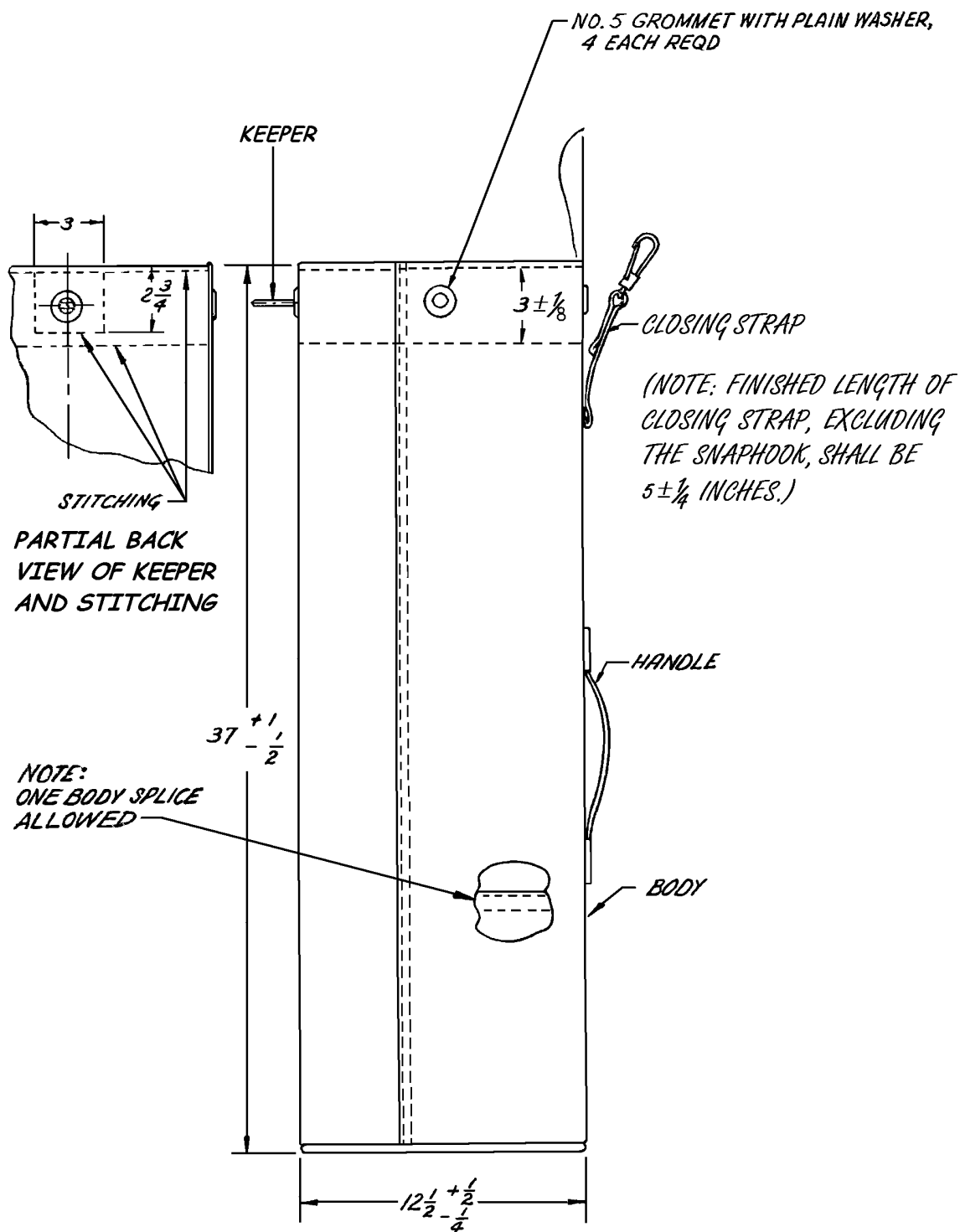
Navy-MC
Air Force-82, 45

CIVIL AGENCY COORDINATING
ACTIVITY:
GSA – FSS

PREPARING ACTIVITY:
DLA - CT

Project No. 8465-0289

A-A-55077A

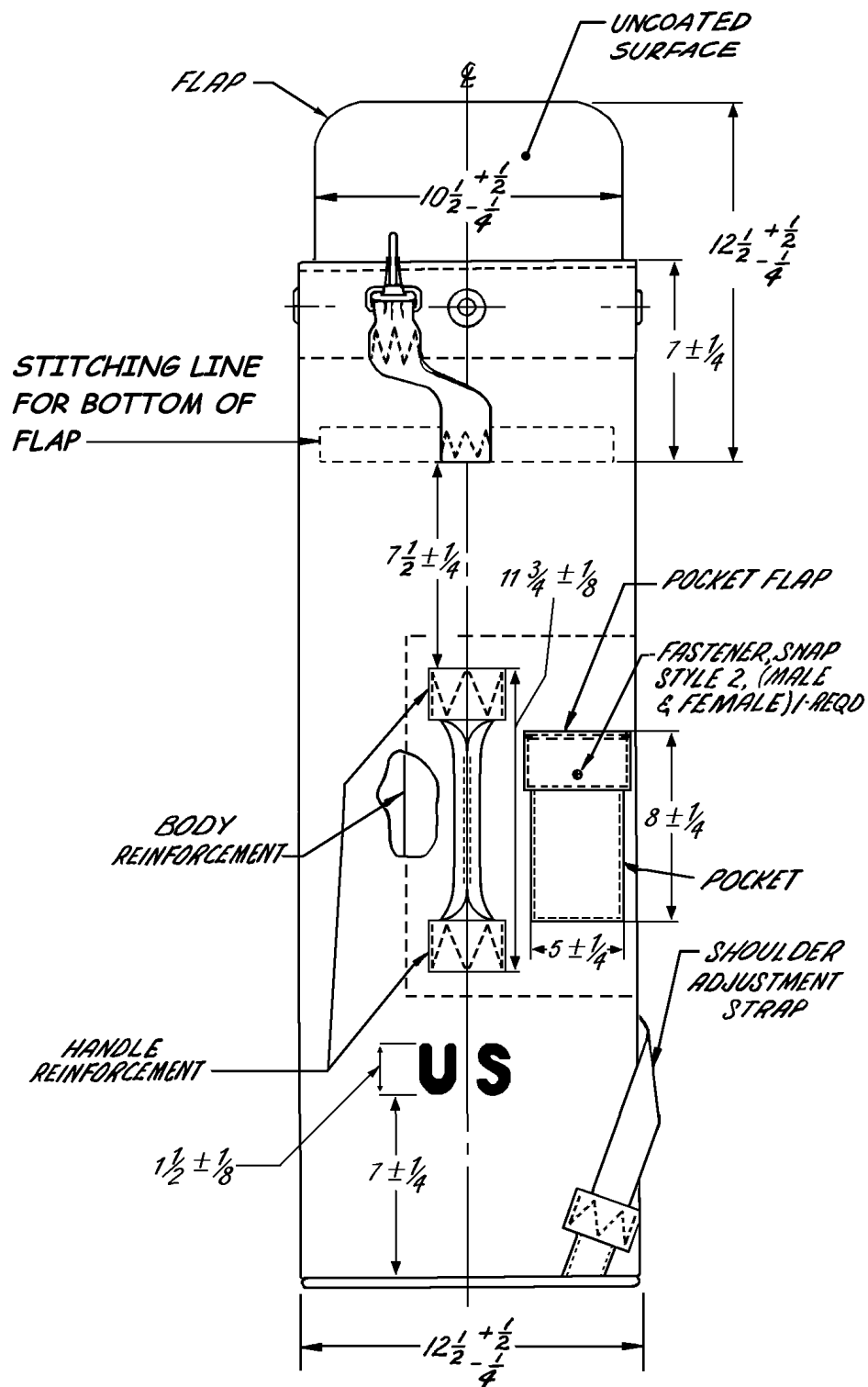


LEFT SIDE VIEW
(DIMENSIONS ARE IN INCHES)

Figure 1. Bag, Duffel

A-A-55077A

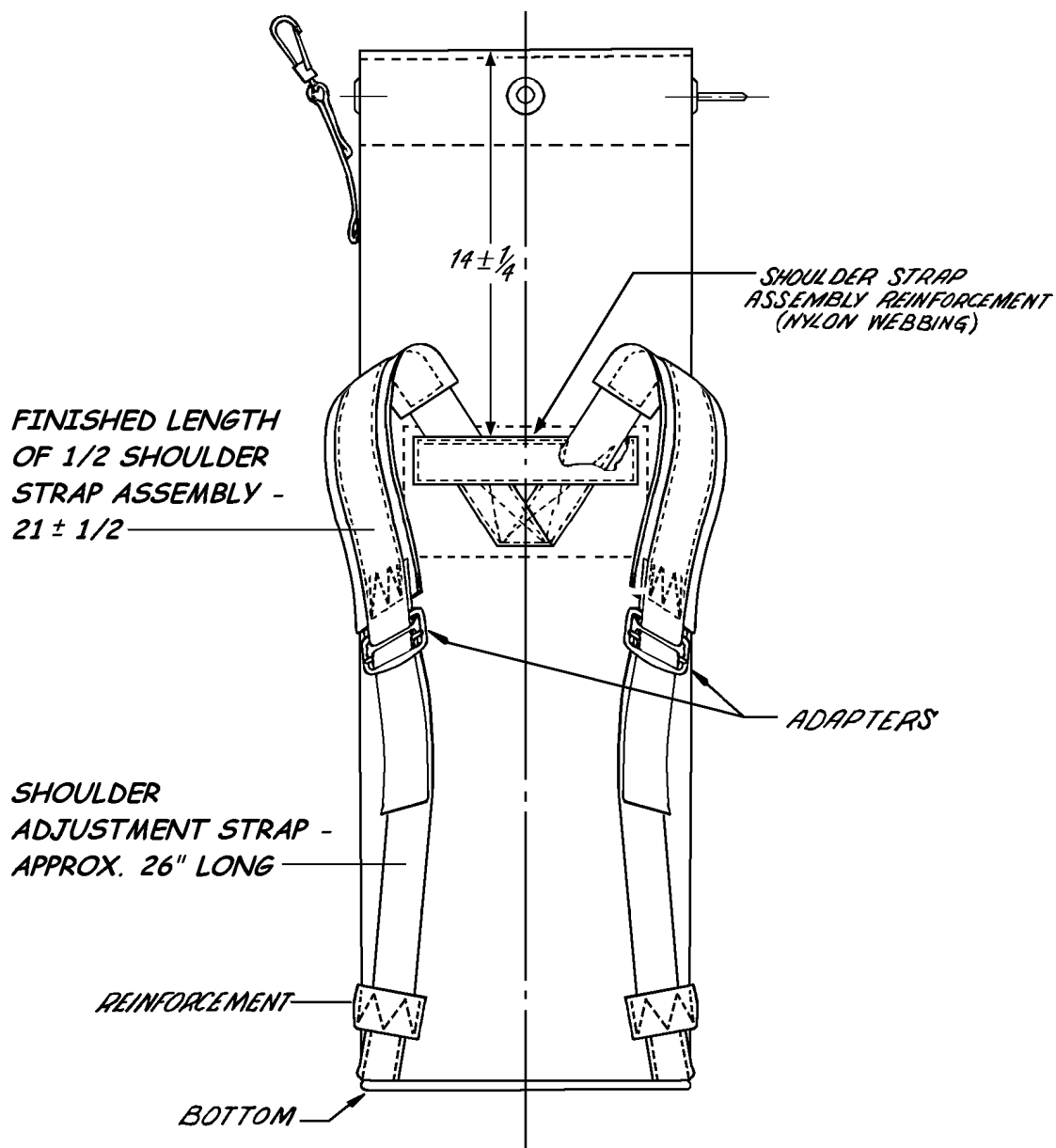
(DIMENSIONS ARE IN INCHES)



FRONT VIEW

Figure 2. Bag, Duffel

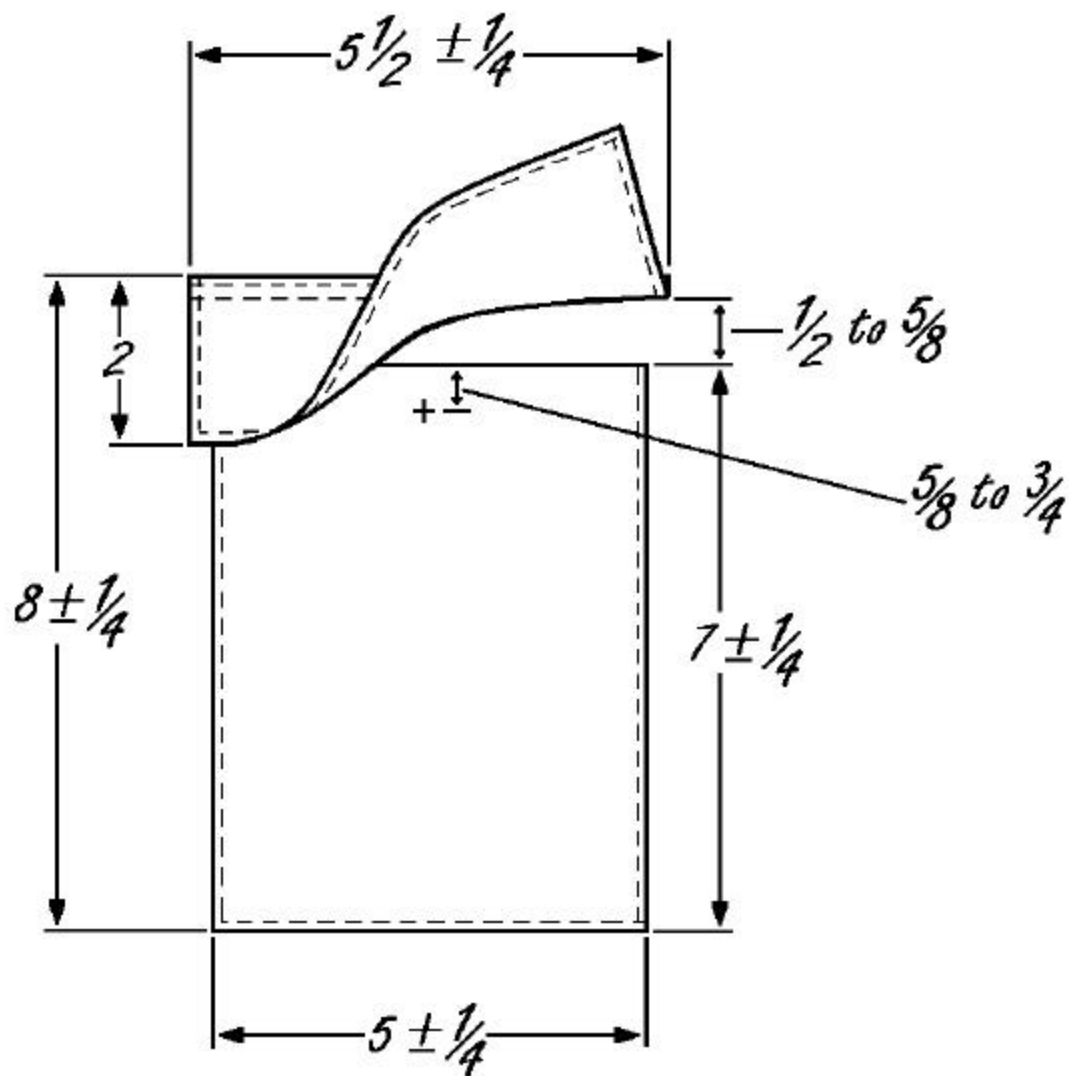
A-A-55077A



RIGHT SIDE VIEW
(DIMENSIONS ARE IN INCHES)

Figure 3. Bag, Duffel

A-A-55077A

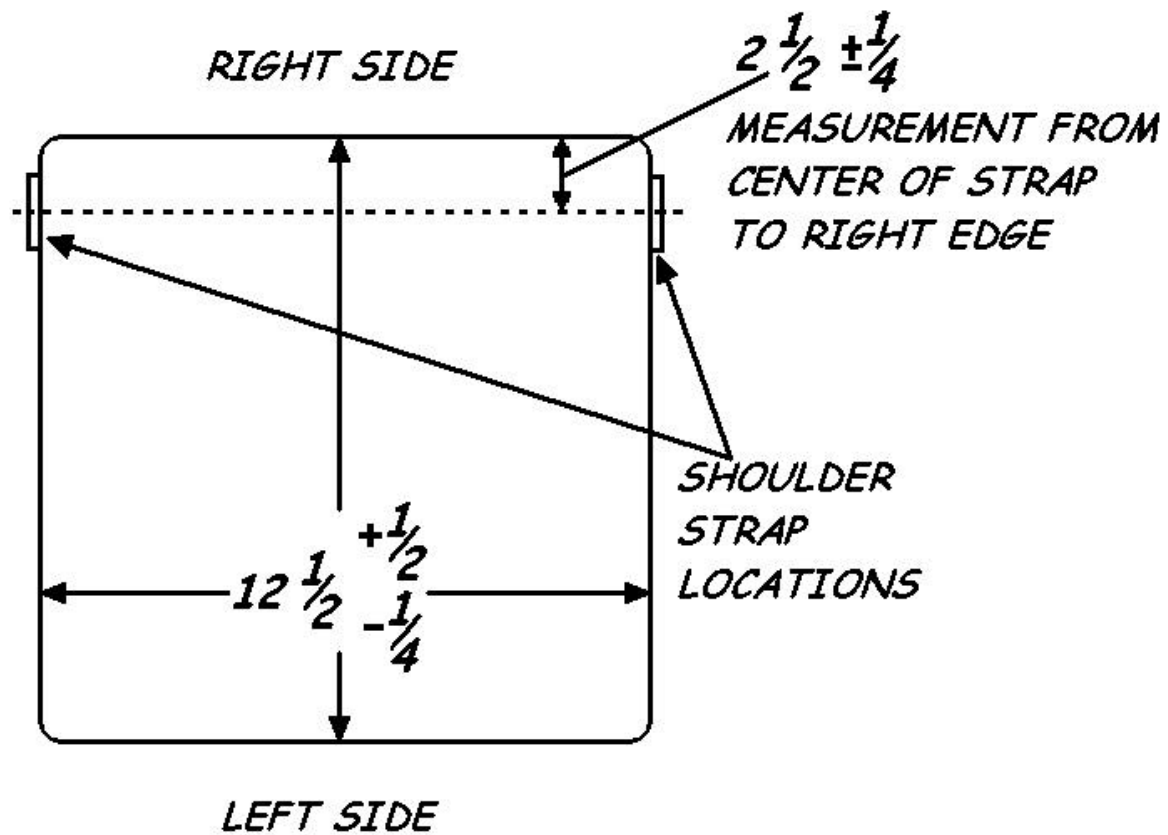


POCKET ENLARGEMENT - FINISHED MEASUREMENTS

(DIMENSIONS ARE IN INCHES)

Figure 4. Bag, Duffel

A-A-55077A



BOTTOM VIEW
(DIMENSIONS ARE IN INCHES)

Figure 5. Bag, Duffel