

INCH-POUND

A-A-55183

8 March 1993

COMMERCIAL ITEM DESCRIPTION

Cloth, Netting, Parachute Skirt Extension, Nylon, Raschel Knit

The General Services Administration has authorized the use of this Commercial Item Description in preference to MIL-C-43805.

Abstract. This Commercial Item Description covers requirements for one type of raschel knitted nylon mesh net cloth intended for use as a parachute skirt extension.

Salient Characteristics.

Description. The netting shall be a mesh type knitted on a single needle bar raschel machine. The mesh size in the finished cloth netting shall be 3-3/4 by 3-3/4 inches (inside measurements) The cross section of the mesh leg (pillar) shall consist of 5 ends of 840 denier yarn (Total nominal denier of 4200). The joining of the pillars (chain stitch) shall be accomplished by a single crossover of yarns during the knitting operation. The width of the netting shall be cut to produce square meshes when the netting is hung in the lengthwise direction. The overall width of the finished netting shall be 18 inches +/- 1 inch with five repeats. One edge of the netting

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Defense Personnel Support Center, Clothing and Textiles Directorate, Attn: DPSC-FSSC, 2800 South 20th Street, Philadelphia, PA 19101-8419, by using the Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8305

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shall be either have a knitted selvage, or the edge shall be sewn (overedged) so that there shall be no loose ends along the full length. The color of the netting shall be natural unless otherwise specified in the procurement documents.

Material.

Yarns

The nylon yarns used in the manufacture of the netting shall be a bright, high tenacity, light and heat resistant polyamide prepared from hexamethylene and adipic acid or its derivatives. The yarn or the cloth netting shall not be bleached in any manner or process unless specified in the procurement document. The finished netting shall conform to the requirements listed in Table I.

Table I Physical Requirements

| Characteristic | Requirement | Test method |
|---------------------------|----------------|--------------------|
| Yarn | see above para | 1/ |
| Luster | . | 1/ |
| Heat and light resistance | . | 1/ |
| denier | 840 | 1/ |
| Melting point | 254° = 10° | 1/ /2 1534 |
| Bleaching | none | 1/ |
| light | 4 | /3 AATCC-16A-1990A |
| Dry cleaning | 4 | AATCC-132-1985 |
| Laundrying | 4 | AATCC-61-1989 |

1/ A supplier's certificate of compliance shall be submitted and will be acceptable for the requirements.

2/ Refers to test method of Fed. Std. No. 191.

3/ The time of exposure shall be 20 standard fading hours and the test specimen shall be 4 to 5 grams of the cloth net material.

Width. The overall width of the finished netting shall be 18 inches \pm 1 inch when measured from sewn edge to sewn edge, with netting straightened by using slight tension prior to measuring, or measurements can be made over a measuring clock under normal winding tension. In preparation of this width the netting shall be cut so as to produce square meshes when the netting is hung in the lengthwise direction. One edge of this netting shall have either a knitted selvage or the edge shall be sewn so that there shall be no loose ends along the full length of the edge of the netting.

Mending and joining. Damages in the netting shall be mended by

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the patch method. The damaged portion of the netting shall be cut out and replaced with a piece of undamaged netting. For mending and joinings, a full leg (one side of square mesh) shall be overlapped with a full leg of the main piece of the cloth netting and secured with a zig zag stitch using a single 840 denier nylon yarn.

Regulatory Requirements. The offeror/contractor is encouraged to use recovered materials in accordance with Public Law 94-580 to the maximum extent practicable.

Quality Assurance

Certification. The contractor shall certify that the product offered meets the salient characteristics of this description and that the product conforms to the producer's own drawings, specifications, standards and quality assurance practices. The government reserves the right to require proof of such conformance prior to the first delivery and thereafter as may be otherwise provided for, under the provisions of the contract. Reliance on contractor QA systems shall not relieve the contractor of the responsibility of ensuring that all products or supplies submitted to the government for acceptance comply with all requirements of the contract.

Examination. Cloth netting lots shall be inspected in accordance with "Sampling Procedures and Tables for Inspection by Attributes", ANSI/ASQC Z1.4, published by the American Society for Quality Control.

Yard by yard examination. The required yardage of each roll shall be visually inspected for defects as defined in MIL-STD-1491 and as listed herein. All defects shall be counted regardless of their proximity, one to another, except where two or more defects represent a single local condition of the netting, in which case only one defect shall be counted. a continuous defect shall be counted as one defect for each lengthwise three feet (1 yd.) of fraction there of in which it occurs. the sample unit for this examination shall be three feet (1 yd.) The sample size shall be in accordance with inspection level II of MIL-STD-105. The AQL shall be 2.5 defects per 100 units (3 feet per yard.) The lot size shall be expressed in units of 3 feet each (1 yd). An approximate equal number of feet shall be examined from each roll selected. The number of rolls over which the sample yardage shall be distributed shall be in accordance with table II.

Packaging Examination. Packaging examination shall be in accordance with PPP-P-1133

Defects The cloth netting shall be examined for the following defects: cut, break or tear; knot; sharp glob resulting from improper "hot knife" cutting; thick or thin place; Abrasion mark;

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drop ply or drop stitch; loose or tight knitting; mixed yarn; float, kink, or miss knit; 1/ Meshes not within specified tolerance; 2/ incorrect number of mesh repeats in the finished width; width not with specified tolerance; 3/ thick or thin place - less than half or more than twice the nominal thickness of the yarn; Selvage edge cut or torn.

1/ Determination of mesh size. The mesh size shall be determined by hand measuring the lengths of the four sides of the pillars (chain stitches) that constitute mesh. Slight tension should be applied to the pillars (chain stitch) while measuring each length of the mesh size.

2/ Determination of overall width of netting. One continuous length of pillars (chain stitches) extending from the sewn edge selvaged edge to the opposite edge of the completed net shall be measured by hand. Slight tension shall be applied while measuring the width of the net.

3/ Sections mended in accordance with "Mending and Joining" shall not be classified as defects.

Overall examination. The sample unit for this examination shall be one roll or carton. The sample size (number of rolls selected as sample) and the acceptance number is shown on table II. The rolls selected for the yard by yard examination shall be used for this examination. Each of the following defects shall be counted not more than once in each roll or carton examined: length of netting not within tolerances 1/; selvaged edge not knitted or sewn as required; more than 10 mends and joins (total per roll of netting; color not as specified; overall uncleanness.

1/ Length of net. The length shall be measured along the sewn edge and the edge shall be straightened by slight tension prior to measuring or measurements shall be made over a measuring clock under normal winding tension.

Table II

| <u>Lot Size in Yards (3 feet)</u> | <u>Sample Size in rolls or cartons</u> | <u>Acceptance No.</u> |
|------------------------------------|--|-----------------------|
| 1200 or less | 3 | 0 |
| 1201 up to & including 3200 | 5 | 0 |
| 3201 up to & including 10,000 | 8 | 0 |
| 10,001 up to and including 35,000 | 13 | 0 |
| 35,001 up to and including 150,000 | 20 | 1 |
| 150,001 and over | 32 | 2 |

1/ If a lot contains fewer than 3 rolls, each roll shall be examined

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Packaging, Packing, Marking, and Palletization

Put-up. Unless otherwise specified in the procurement documents the cloth netting shall be furnished on individual rolls in 500 feet - 5 + 25 feet lengths. There shall be more than 10 joinings or mends (total) on each individual roll of netting. Unless otherwise specified, the weight of each roll shall not exceed 125 pounds, except when the weight of the specified yardage in one continuous piece exceeds 125 pounds.

Packaging. Cloth shall be rolled on a convolute or spiral wound chipboard tube. The tube shall have a smooth finish that will prevent the fibers of the chipboard from transferring to the cloth. Each roll of cloth, put up as specified, shall be wrapped with a 70-pound minimum basis weight kraft paper. The roll shall be wrapped so that the paper encircles the roll at least once with a minimum overlap of 3 inches, and the width of the paper shall be sufficient to fold over and protect the ends of the roll. Gummed paper tape, with a minimum width 2-1/2 inches shall be applied to the overlap seam the full length of the roll across each end.

Packing. Rolls of fabric shall be packed in a snug-fitting double-wall fiberboard container known as a double cover and shall consist of a body, or joined liner and two covers and shall conform to type CF, class domestic, variety DW, minimum grade 500. The depth of the cover shall be not less than 6 inches. Containers shall be strapped with three flat metallic straps not less than 1/2 by 0.020 inches. Containers exceeding 24 inches in length shall have an additional strap applied girthwise. The net weight of contents in all fiberboard containers shall not exceed 325 pounds. No packing is required when individual rolls are alternately packed within a double-wall (2 ply) 50 pounds per ream, paper tube or bag or polyethylene wrap or tube with a minimum thickness of 0.004 inches.

Marking. In addition to any special marking required by the contract or purchase order, rolls shall be marked in accordance with MIL-STD-129. Each roll shall have a piece ticket (identification tag) affixed with a 5-ply minimum cotton string or a plastic tag hanger. The tag shall have a reinforced eyelet and shall be legibly printed, using water insoluble ink, with the following information:

| | |
|-----------------------|----------------------------|
| Procurement agency | Contract or purchase order |
| National Stock number | Finish or Greige mill |
| Item description | Roll number |
| Contractor | Lot number |
| Width | Piece number |
| Fiber Content | Yardage |

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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

Sources of Nongovernment Documents.

ANSI/ASQC Z1.4 - Sampling Procedures and Tables For Inspection
By Attributes

(Applications for copies should be addressed to American
National Standards Institute, 1430 Broadway, New York, NY 10018-
3308.)

(Applications for copies should be addressed to American
Society For Testing and Materials, 1916 Race Street,
Philadelphia, PA 19103)

Custodian:
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Project No. 8305-0481

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

INSTRUCTIONS

- 1 The preparing activity must complete blocks 1, 2, 3, and 8. In block 1, both the document number and revision letter should be given.
- 2 The submitter of this form must complete blocks 4, 5, 6, and 7.
- 3 The preparing activity must provide a reply within 30 days from receipt of the form.

NOTE: This form may not be used to request copies of documents, nor to request waivers, or clarification of requirements on current contracts. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements.

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| 1 RECOMMEND A CHANGE: | | 1 DOCUMENT NUMBER A-A-55183 | 2 DOCUMENT DATE (YYMMDD) 08 March 1993 |
| 3. DOCUMENT TITLE Cloth, Netting, Parachute Skirt Extension, Nylon Rashel Knit | | | |
| 4 NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.) | | | |
| 5. REASON FOR RECOMMENDATION | | | |
| 6. SUBMITTER | | | |
| a. NAME (Last, First, Middle Initial) | | b. ORGANIZATION | |
| c. ADDRESS (include Zip Code) | | d. TELEPHONE (include Area Code) (1) Commercial (2) AUTOVON (if applicable) | 7. DATE SUBMITTED (YYMMDD) |
| 8. PREPARING ACTIVITY | | | |
| a. NAME DEFENSE PERSONNEL SUPPORT CENTER ATTN: DPSC-FSSD (12-3-D) | | b. TELEPHONE (include Area Code) (1) Commercial 215-737-8105 | (2) AUTOVON 444-8105 |
| ADDRESS (include Zip Code) 2800 SOUTH 20th STREET PHILADELPHIA, PA 19101-8419 | | IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT Defense Quality and Standardization Office 5203 Leesburg Pike, Suite 1403 Falls Church, VA 22041-3456 Telephone (703) 756 2340 AUTOVON 289 2340 | |