

6

T-R-605B  
 AMENDMENT-3  
April 17, 1973  
 SUPERSEDING  
 Amendment-2  
 January 18, 1967

FEDERAL SPECIFICATION  
 ROPE, MANILA AND SISAL

This amendment, which forms part of Federal Specification T-R-605B, dated December 13, 1963, was approved by the Commissioner, Federal Supply Service, General Services Administration, for the use of all Federal agencies.

Page 1

Section 2: Delete heading and substitute:

"APPLICABLE DOCUMENTS".

Page 2

Paragraph 3.2.1.1; Delete and substitute:

"3.2.1.1 Class 1. Type M, class 1 rope shall have a "Becker" value of not less than 16 for all sizes of rope."

Page 3

Table I, column 8 under "Breaking strength (minimum)"; Delete and substitute:

Manila
Pounds
405
540
900
1215
1575
2185
3105
3960
4860
5850
6930
8100
9450
10,800
12,150
13,500
16,650
20,250
23,850
27,900
36,900
46,800
57,600
69,300
81,900
94,500

THE MARGINS OF THIS SPECIFICATION ARE MARKED "\*" TO INDICATE WHERE CHANGES (ADDITIONS, MODIFICATIONS, CORRECTIONS, DELETIONS) FROM THE PREVIOUS ISSUE HAVE BEEN MADE. THIS WAS DONE AS A CONVENIENCE ONLY AND THE GOVERNMENT ASSUMES NO LIABILITY WHATSOEVER FOR ANY INACCURACIES IN THESE NOTATIONS. BIDDERS AND CONTRACTORS ARE CAUTIONED TO EVALUATE THE REQUIREMENTS OF THIS DOCUMENT BASED ON THE ENTIRE CONTENT IRRESPECTIVE OF THE MARGINAL NOTATIONS AND RELATIONSHIP TO THE LAST PREVIOUS ISSUE.

T-R-605B  
AMENDMENT-3

Page 4

Paragraph 3.7; Delete and substitute:

"3.7 Cordage oil. The cordage oil shall be of suitable cordage quality, and the percent extractable matter based on the dry weight or the finished rope shall be not less than 11.5 nor more than 16.5 percent, when tested as specified in 4.2.5."

Page 5

Paragraph 3.11; Delete and substitute:

"3.11 Basis of purchase. Rope shall be purchased on a price-per-pound basis, gross weight. Tare shall not exceed the tolerances specified for the following gross weights of coils:

Tare allowance

Gross weight of coil	Uncovered	Covered
	Percent	Percent
Up to 50 pounds	2-1/2	3
51 to 100 pounds	2	2-1/2
101 pounds and over	1-1/2	2

Section 4; Delete heading and substitute:

"QUALITY ASSURANCE PROVISIONS".

Paragraph 4.1; Delete and substitute:

"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 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."

Page 6

Paragraph 4.2.3; Delete and substitute:

"4.2.3 Examination for length, winding, and tare. The sample unit for this examination shall be one coil. The inspection level shall be level S-3, and the acceptable quality level (PQL), shall be 4.0 percent defective. For lots consisting of 500 or fewer units, the sample size shall be 10, and the acceptance number 1. The lot size shall be the number of units in the inspection lot. Defects shall be as listed in 4.2.3.1, 4.2.3.2, and 4.2.3.3."

Following paragraph 4.2.3.2 insert the following new paragraphs:

"4.2.3.3 Tare. All bands, lashings, and coverings shall be removed from each coil in the sample, and the aggregate accurately weighed.

"4.2.3.3.1 Tare per individual holder. A defect shall be considered to exist if the tare of any one holder exceeds the applicable requirement specified in 3.11.

"4.2.3.3.2 Average tare. A lot shall be unacceptable if the average tare of the specimens examined exceeds the requirements in 3.11."

Page 7

Paragraph 4.2.4, last sentence: Delete "14" and substitute "5-2".

Table VIII, column 5: Delete: "Avg. of 2 deter. to nearest 1 percent of specified requirement" and substitute "3/".

T-R-605B  
AMENDMENT-3

Page 8

Table VIII, column 3: Delete the word "Commercial" in last two lines and substitute "4/".

Table VIII: Add the following footnotes:

- 3/ Average of 2 determinations to nearest 0.1 foot for rope 1-1/2 inches in nominal circumference and under; average of 2 determinations to nearest 0.01 foot for rope over 1-1/2 up to 5-1/2 inches in nominal circumference; average of 2 determinations to nearest 0.001 foot for rope over 5-1/2 inches in nominal circumference.
- 4/ Certificates showing conformance with this specification shall be made available to the inspector for each lot of rope. Certification shall contain actual test, examination, or other verifiable quality data.

Table IX, column 2: After "(minimum)" add "feet".

**Custodians:**

Army - GL  
Navy - SH  
Air Force - 82

**Review activities:**

Army - GL, WC  
Navy - SH  
Air Force - 82  
DSA - IS

**User activities:**

Army - EL  
Navy - MC, YD

**Preparing activity:**

Navy - SH  
(Project 4020-0241)