

INCH-POUND

MIL-PRF-18494F(AS)

31 May 2003

SUPERSEDING

MIL-PRF-18494E(AS)

27 July 1999

PERFORMANCE SPECIFICATION

LIFE RAFTS, INFLATABLE, MULTI-PLACE

This specification is approved for use by the Naval Air Systems Command, Department of the Navy, and is available for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification covers the requirements for inflatable life rafts of 8-man, 12-man, and 20-man capacity.

2. APPLICABLE DOCUMENTS

2.1 General. The documents listed in this section are specified in sections 3 and 4 of this specification. This section does not include documents cited in other sections of this specification or recommended for additional information or as examples. While every effort has been made to ensure the completeness of this list, document users are cautioned that they must meet all specified requirements documents cited in sections 3 and 4 of this specification, whether or not they are listed.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to:
Commander, Naval Air Warfare Center Aircraft Division, Code 414100B120-3,
Highway 547, Lakehurst, NJ 08733-5100, by using the Standardization Document
Improvement Proposal (DD Form 1426) appearing at the end of this document or by
letter.

AMSC N/A

FSC 4220

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2.2 Government documents.

2.2.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those listed in the issue of the Department of Defense Index of Specifications and Standards (DoDISS) and supplement thereto, cited in the solicitation (see 6.2).

STANDARDS

DEPARTMENT OF DEFENSE

MIL-STD-810 - Environmental Engineering Considerations
and Laboratory Tests.

(Unless otherwise indicated, copies of the above standard are available from the Standardization Document Order Desk, 700 Robbins Avenue, Building 4D, Philadelphia, PA 19111-5094 or www.dodssp.daps.mil.)

2.2.2 Other Government documents, drawings, and publications. The following other Government documents, drawings, and publications form a part of this document to the extent specified herein. Unless otherwise specified, the issues are those cited in the solicitation.

PUBLICATIONS

FEDERAL AVIATION ADMINISTRATION (FAA)

FAA TSO-C70a - Life Rafts (Reversible and Nonreversible).

(Copies of FAA publications are available from the Federal Aviation Administration, 800 Independence Avenue, S.W., Washington, D.C., 20591 or www.equipped.com/tsoc70a.htm.)

2.3 Order of precedence. In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

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3. REQUIREMENTS

3.1 General. The life raft assembly shall consist of the following components:

- a. A reduced volume packed life raft.
- b. An attached survival item/accessory container.
- c. A carrying case.

The rafts shall be constructed with heat sealed seams. The life raft shall be manufactured and designed to endure a 5-year repack cycle beginning from the date of initial packing (see 6.2). The life rafts shall meet the requirements of FAA TSO-C70a, be capable of FAA TSO-C70a certification, and meet all the requirements specified herein.

3.2 Qualification. Life rafts furnished under this specification shall be products that are authorized by the qualifying activity for listing on the applicable qualified products list before contract award (see 4.2 and 6.3).

3.3 Inflation system. The inflation system shall be a zero-leak system preventing any gas leaks before actuation. The inflation gas shall be contained in a non-shatterable vessel. The vessel shall have a 5-year service life from the date of life raft packing (see 6.2).

3.4 Self-erecting canopy. The life raft design shall incorporate a self-erecting inflatable canopy system to provide aircrew protection from sea spray, sun, and extreme weather conditions. Raft buoyancy shall not be affected by the integrity of the canopy system.

3.4.1 Rain water collection. A means shall be provided for the collection and retention of rain water from the external surface of the canopy.

3.4.2 Reflective strips. The exterior of the life raft and canopy shall incorporate removeable, flexible reflective external surfaces to enhance the effectiveness of search and rescue operations.

3.5 Floor insulation. The life raft floor shall be insulated.

3.6 Capacity. The rated and overload capacities of the life raft shall be based on the following usable sitting areas on the life raft deck:

- Rated capacity - 4.5 ft² per person
- Overload capacity - 3.0 ft² per person

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3.7 Buoyancy. Loaded to its rated capacity and using an average occupant weight of not less than 200 pounds, the life raft shall have a freeboard of at least 12 inches. The life raft loaded to its overload capacity shall have a freeboard of at least 6 inches.

3.8 Containers.

3.8.1 Reduced volume packed life raft. The life raft shall be reduced volume packed. The method of packing shall provide protection and preservation of the raft in an aircraft environment. The life raft packing shall also provide the capability of visually verifying raft integrity and a fully charged inflation system.

3.8.2 Survival item/accessory container. Each life raft assembly shall include a survival item/accessory container capable of holding all the aircrew items. Quantity, size, and weight for these survival items are listed in table I. The accessory container shall be securely attached to the life raft and shall remain attached after inflation. The container shall be designed to keep the survival items secure during raft deployment, and have the capability to tie down the radio, first aid kit, manual reverse osmosis device (MROD) and pump from table I. This container shall be easily accessible for maintenance inspection of time sensitive survival items without unpacking the life raft.

3.8.3 Carrying case. An outer carrying case shall be provided which properly fits the reduced volume packed life raft and accessory container. The life raft in its carrying case shall be capable of being properly stowed on the aircraft. Carrying case materials shall be flame resistant, fungus proof, and resistant to aircraft fuels and other fluids. The carrying case shall provide chafe protection to the life raft. The carrying case shall provide protection against fluid intrusion in an aircraft environment. Easily distinguishable handles shall be provided so that the raft can be carried by one person, carried by two persons in tandem, or moved by either end; none of these carrying operations shall tend to pull the carrying case open. Each handle shall be easily grasped, and their strength shall be at least four times the total weight of the life raft assembly. A remote actuation device shall be incorporated on the exterior of the carrying case. The maximum pull force required for remote actuation shall not exceed 32 lbs. The raft shall be protected against inadvertent actuation. Location of and instructions for use of the remote actuation device shall be clearly identified and marked on the carrying case surface.

3.9 Weight. The weight of the life raft assembly minus the accessory container items shall be not greater than the following:

8-man - 70 lbs.

12-man - 83 lbs.

20-man - 104 lbs.

3.10 Size. The life raft assemblies including table I items shall be deployable through a 22 x 22 inch escape hatch.

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TABLE I. Multi-place life raft survival items.

DESCRIPTION	DIMENSIONS <u>1/</u> <u>4/</u>	WEIGHT <u>2/</u> <u>4/</u>	QUANTITY		
			8-MAN	12-MAN	20-MAN
Seawater desalter kit	5 x 4 x 2	1.49	5	6	10
Sea dye marker	3 x 3.5 x 1.25	0.28	4	5	8
Distress signal	5.38 x 1.69 Dia	0.48	7	8	10
Water storage bag	1/8 x 20.5	0.21	3	4	7
Bagged drinking water	6 x 4.5 x 5	0.28	20	30	50
First aid kit	8 x 3.25 x 5	1.48	1	1	2
Manual reverse osmosis device (MROD)	23 x 5 x 6	8.60	1	1	1
Sunburn cream	1.75 Dia x 1	0.18	1	2	3
Life raft food packet	2 x 3.5 x 1	0.17	8	12	20
Bailing sponge	5.5 x 3.25 x .25	0.06	1	4	6
Combat blanket	8.50 x 6 x 2.50	0.70	1	2	3
Hand generated light	5 x 3 x 1	0.80	1	1	1
MK 79 flare gun, Mod 0	5 x 3 x .75	0.40	1	1	2
Strobe light	5 x 2.50 x 1	0.46	1	1	1
Chemical light	6 x .50 Dia	0.15	2	2	2
Signal mirror	3.75 x 2 x .25	0.35	1	1	1
Radio PRT-5	18 x 5.5 Dia	13.50	1	1	1
Radio PRC-90	7 x 3 x 1.75	1.32	1	1	1
Radio battery	1 Dia x 3.5	0.18	1	1	1
Type II whistle	2 x 1	0.06	1	1	1
Compass	1.75 Dia x 1	0.08	1	1	1
Pocket knife	1 x 5	0.21	1	1	1
Nylon cord, 50 ft.	2 x 6	0.05	1	1	1
Code card (plastic coated)	3 x 5	—	1	1	1
Commodity growth <u>3/</u>	+10% of total vol.				
		31.49 Total			

1/ All dimensions are in inches.

2/ Weight is in pounds for one of each item.

3/ Survival item container shall incorporate a 10 percent “growth” factor, total volume plus 10 percent.

4/ In cases where substitute items may be used, dimension/weight for larger item listed.

3.11 Function/operation. The life raft shall inflate at the required pull force for its design shape in not greater than 60 seconds when tested as specified in 4.9. During inflation the life raft shall be observed for impediment or blockage of gas flow, loss of gas to the ambient air, or

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restriction by any component or accessory. There shall be no evidence of structural or material failure in any respect. All the sealed areas, seams, seam tapes, and attachments shall remain intact and shall show no indication of separation. The floor shall not distort and remain level in relation to the sides of the raft. The raft shall be easily boarded by an aircrew member wearing standard aviation life support equipment including a flight suit, survival vest, inflated life preserver, and flight boots.

3.12 Environmental.

3.12.1 Temperature extremes.

3.12.1.1 Low temperature. The life raft shall inflate into a boardable shape within 3 minutes at 0 °F (-18 °C) when tested as specified in 4.10.1.1. Inflation shall be without any hindrance to the flow of gas or restriction by any component or accessory. All the seams, seam tapes, sealed areas and attachments shall remain perfectly intact and shall show no evidence of separation. There shall be no evidence of failure in any respect.

3.12.1.2 High temperature. The life raft shall inflate to boardable shape within 60 seconds at 160 °F (71 °C) when tested as specified in 4.10.1.2. Inflation shall be without any hindrance to the flow of gas or restriction by any component or accessory. All the seams, seam tapes, sealed areas and attachments shall remain perfectly intact and shall show no evidence of separation. There shall be no evidence of failure in any respect.

3.12.2 Low pressure (altitude). The packed life raft contained in its carrying case shall withstand a low pressure environment and rapid pressure changes when tested as specified in 4.10.2. The integrity of the life raft shall not be adversely affected. There shall be no leakage of the inflation system gas. The life raft shall meet the size and volume requirements as specified in 3.8.1 and 3.10.

3.12.3 Sand and dust. The packed life raft contained in its carrying case shall resist the effects of an airborne sand and dust environment when tested as specified in 4.10.3. The integrity of the life raft shall be not adversely affected.

3.12.4 Vibration. The packed life raft contained in its carrying case shall resist the effects of aircraft vibration when tested as specified in 4.10.4. The integrity of the life raft shall not be adversely affected.

3.13 Durability. The packed life raft contained in its carrying case shall withstand the effects of rough handling when tested as specified in 4.11. The integrity of the life raft shall not be adversely affected.

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3.14 Fleet in-service. The packed life raft and accessory container with survival items contained in its carrying case shall perform as intended when tested as specified in 4.12. The integrity of the life raft shall not be adversely affected.

3.15 Markings. Each life raft shall be identified by name of manufacturer, contract number, date of manufacture, and serial number. The serial number shall be assigned by the manufacturer and shall be a block of consecutive numbers to cover the entire acquisition quantity. All markings shall be legible, durable, permanent, and thoroughly dry prior to packaging.

4. VERIFICATION

4.1 Classification of inspections. The inspection requirements specified herein are classified as follows:

- a. Qualification inspection (see 4.2).
- b. Conformance inspection (see 4.3).

4.2 Qualification inspection. The qualification inspection of the life rafts shall consist of all the examinations and tests specified in table II. The examinations and tests shall be performed in the sequence listed.

TABLE II. Qualification examinations and tests.

Inspection	Requirement	Test Method
Weight	3.9	4.6
Size	3.8, 3.10	4.7
Actuation pull force test	3.8.3	4.8
Operational test	3.5, 3.7, 3.9, 3.11	4.9
Visual examination	3.3, 3.4, 3.13	4.5
Temperature extremes test	3.12.1	4.10.1
Low pressure (altitude) test	3.12.2	4.10.2
Sand and dust test	3.12.3	4.10.3
Vibration test	3.12.4	4.10.4
Durability test	3.13	4.11
Fleet in-service test	3.14	4.12

4.2.1 Qualification samples. The qualification samples shall consist of three rafts of each capacity. Samples shall be forwarded as specified in the correspondence authorizing submission of samples for qualification testing (see table II and 6.2). Additionally, each sample shall be plainly identified by securely attached tags containing the following information:

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Qualified Products List (QPL) Number
 Qualification Inspection Samples
 Life Raft Capacity
 Manufacturer's Designation
 Manufacturer's name and CAGE
 Serial Number
 Military Specification Number

4.3 Conformance inspection. Production lot testing shall be accomplished in accordance with the procurement contract. The conformance inspection shall consist of the tests and examinations specified in table III (see 6.2).

TABLE III. Conformance examinations and tests.

Inspection	Requirement	Test Method
Weight	3.19	4.6
Size	3.8, 3.10	4.7
Actuation pull force test <u>1/</u>	3.8.3	4.8
Operational test <u>1/</u>	3.5, 3.7, 3.9, 3.11	4.9
Visual examination	3.3, 3.4, 3.13	4.5
Temperature extremes test <u>1/</u>	3.12.1	4.10.1
Low pressure (altitude) test <u>1/</u>	3.12.2	4.10.2
Sand and dust test <u>1/</u>	3.12.3	4.10.3
Vibration test <u>1/</u>	3.12.4	4.10.4
Durability test <u>1/</u>	3.13	4.11
Fleet in-service test <u>1/</u>	3.14	4.12

1/ Examination/test shall be performed only when required by the contract.

4.4 Inspection conditions.

4.4.1 Atmospheric conditions. Unless otherwise specified in the contract, all inspections required by this specification shall be conducted at a barometric pressure of 28 to 32 inches of mercury and at a temperature of 77 ± 18 °F (25 ± 10 °C). If the final values of the ambient temperature or barometric pressure at the end of the four-hour air pressure inspection are different from the initial values recorded at the start of the inspection, the following corrections should be made to the final pressure readings in psig.

4.4.2 Temperature correction. For each degree Fahrenheit rise in temperature, 0.031 psig shall be subtracted from the final pressure reading. For each degree Fahrenheit drop in

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temperature, 0.031 psig shall be added to the final pressure reading. The corresponding correction per degree Celsius is 0.056 psig.

4.4.3 Barometric pressure correction. For each 0.1 inch of mercury rise in barometric pressure, 0.049 psig shall be added to the final temperature-corrected pressure reading. For each 0.1 inch of mercury drop in barometric pressure, 0.049 psig shall be subtracted from the final temperature-corrected pressure reading.

4.5 Visual examination. The visual examination shall be performed to verify conformance to the requirements specified in FAA TSO-C70a and section 3 of this specification. Table IV shall be used to classify and enumerate the defects.

TABLE IV. Classification of defects for visual examination of the life rafts.

Critical	Minor
1. Any hole, cut, tear, patch, or burn.	201. Any spot or stain. <u>1</u> /
2. Any fabric damaged, bruised, abraded, containing imperfections, or otherwise defective. <u>1</u> /	202. Any cut edge of uncoated nonfibrous material containing sharp edges.
3. Any stitching in the inflatable section of the life raft.	203. Any slide fastener improperly installed or inoperable.
4. Attachment of the floor or canopy to the inflatable tube not reinforced or not attached.	204. Stitching damaged or defective.
5. Inflation assembly or manifold stem assembly not in accordance with requirements, or inoperable.	205. Any pile or hook tape damaged or defective.
6. Any seam separating in the inflatable section.	206. Topping-off inflation assembly or components not as specified, topping-off valve not locked in the closed position.
7. An inflatable section seam construction which does not meet the specified minimum requirements.	207. Any required markings, illegible, incomplete, incorrect, or improperly located.

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TABLE IV. Classification of defects for visual examination of life rafts - Continued.

Critical	Minor
8. Any channels or voids in any seam on the inflatable section.	208. Color of any component, not as specified.
9. Topping-off valve damaged or in the open position.	209. Accessory or other container not closed.
10. Any metal component improperly finished or containing nicks, burrs, dents, sharp edges or rough surfaces. <u>1/</u>	210. Life raft improperly folded.
11. Any component, component part, or required operation omitted; or any operation improperly performed, not herein classified. <u>1/</u>	211. Any wrinkles, channels, or voids in any seam, patch or attachment on the inflatable section. <u>1/</u>
12. Any component not as specified, or any defect of a component or assembly not herein classified. <u>1/</u>	212. Cement on the cloth surfaces around patches or attachments.
	213. Any clot or mass of adhesive.
	214. Overlap of any seam tape in excess of requirements.
	215. Any seam tape, patch or attachment separating. <u>1/</u>

1/ The defect shall be classified Critical when it seriously affects serviceability or function; otherwise, it is to be classified Minor.

4.6 Weight. The weight of the life raft shall conform to the requirements of 3.9.

4.7 Size.

4.7.1 Life raft assembly. The life raft assembly including table I items shall be deployed through a 22 x 22 inch hatch to ensure conformity with 3.10.

4.7.2 Accessory container. The accessory container shall be packed with the survival items (see table I) and checked for its conformance to the requirements of 3.8.2.

4.7.3 Carrying case. The outer carrying case shall be checked for its conformance to the requirements of 3.8.3. Resistance to flame, fungus, aircraft fuels, and other fluids shall be verified by conformance to FAA TSO-C70a.

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4.8 Actuation pull force. The actuation pull force shall be checked for its conformance to the requirements of 3.8.3.

4.9 Operational tests. In either a controlled pool, fresh water, or at sea, the life raft operation shall be demonstrated as follows:

Both rated and overload capacities established in accordance with the requirements of 3.6 shall be demonstrated with inflation tubes at minimum operating pressure. The resultant freeboard shall meet the requirements of FAA TSO-C70a and 3.7. The required life raft equipment shall be aboard the life raft. The tie down capability shall be demonstrated with the four survival items (see 3.8.2). The life raft shall be evaluated for its conformance to the requirements of FAA TSO-C70a and as specified in section 3 of this specification.

4.10 Environmental tests.

4.10.1 Temperature extremes test.

4.10.1.1 Low temperature test. The life raft shall be exposed to 0 ± 2 °F (-18 ± 1 °C) for not less than 48 hours. The raft shall then be removed to the inspection area and placed on a table or on the floor. The inflation equipment shall be immediately actuated. The life raft shall be observed for conformance to the requirements of 3.12.1.1.

4.10.1.2 High temperature test. The test procedures set forth in 4.10.1.1 shall be repeated, except the raft shall be exposed to 160 ± 2 °F (71 ± 1 °C) for not less than 48 hours. The raft shall be observed for conformance to the requirements of 3.12.1.2.

4.10.2 Low pressure (altitude) test. The packed life raft contained in its carrying case shall be tested in a low pressure environment in accordance with MIL-STD-810, Method 500.4. At the completion of the test, the raft shall be removed from the low pressure environment and observed for its conformance to the requirements of 3.12.2.

4.10.3 Sand and dust test. The packed life raft contained in its carrying case shall be tested in an airborne sand and dust environment in accordance with MIL-STD-810, Method 510.4. At the completion of the test, the raft shall be removed from the airborne sand and dust environment and observed for its conformance to the requirements of 3.12.3.

4.10.4 Vibration test. The packed life raft contained in its carrying case shall be tested for its ability to withstand aircraft vibration in accordance with MIL-STD-810, Method 514.5. At the completion of the vibration test, the life raft shall be observed for its conformance to the requirements of 3.12.4.

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4.11 Durability test. The packed life raft contained in its carrying case shall be tested for its ability to withstand rough handling. The packed life raft shall be dragged approximately 50 ft over a non-skid surface 10 times, dropped a distance of 5 ft onto a hard surface 10 times, and tossed a horizontal distance of 3 feet onto a hard surface 10 times. At the completion of the durability test, the life raft shall be visually examined for its conformance to the requirements of 3.13.

4.12 Fleet in-service test. A packed life raft and accessory container with survival items contained in its carrying case shall be evaluated in the fleet for a period of 180 days. At the end of 180 days, the life raft shall be visually examined before, during, and after actuation for its conformance to the requirements of 3.14.

5. PACKAGING

5.1 Packaging. For acquisition purposes, the packaging requirements shall be as specified in the contract or order (see 6.2). When actual packaging of material is to be performed by DoD personnel, these personnel need to contact the responsible packaging activity to ascertain requisite packaging requirements. Packaging requirements are maintained by the Inventory Control Point's packaging activity within the Military Department or Defense Agency, or within the Military Department's System Command. Packaging data retrieval is available from the managing Military Department's or Defense Agency's automated packaging files, CD-ROM products, or by contacting the responsible packaging activity.

6. NOTES

(This section contains information of a general or explanatory nature which may be helpful, but is not mandatory.)

6.1 Intended use. The rafts are intended for use as emergency equipment by military aircrews forced down over water. Commercial life rafts do not meet the reduced volume packing and container requirements necessary for military aircraft use.

6.2 Acquisition requirements. Acquisition documents must specify the following:

- a. Title, number, and date of this specification.
- b. Issue of DoDISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.2).
- c. Certificate of compliance for the age of the materials and components (see 3.1 and 3.3).
- d. Qualification samples (see 4.2.1).

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- e. Name and address of the conformance verification inspection facility and the name and address of the Government activity responsible for conducting the conformance verification inspection program (see 4.3).
- f. Packaging requirements (see 5.1).

6.3 Qualification. With respect to products requiring qualification, awards will be made only for products which are, at the time of award of contract, qualified for inclusion in Qualified Products List QPL-18494 whether or not such products have actually been so listed by that date. The attention of the contractors is called to these requirements, and manufacturers are urged to arrange to have the products that they propose to offer to the Federal Government tested for Qualification in order that they may be eligible to be awarded contracts or purchase orders for the products covered by this specification. Information pertaining to qualification of products may be obtained from Commander, Naval Air Systems Command, Code 4.6.1.2, 48110 Shaw Road, Bldg. 2187, Patuxent River, MD 20670-5304.

6.4 Subject term (key word) listing.

Accessory container
Canopy
Ditching
Emergency
Heat sealed
Rescue

6.5 Changes from previous issue. Marginal notations are not used in this revision to identify changes with respect to the previous issue due to the extent of the changes.

CONCLUDING MATERIAL

Custodians:
Navy – AS

Preparing activity:
Navy – AS

(Project 4220-0457)

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, and send to preparing activity.
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.

I RECOMMEND A CHANGE:	1. DOCUMENT NUMBER MIL-PRF-18494F(AS)	2. DOCUMENT DATE (YYYYMMDD) 20030531
3. DOCUMENT TITLE LIFE RAFTS, INFLATABLE, MULTI-PLACE		
4. NATURE OF CHANGE <i>(Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)</i>		
5. REASON FOR RECOMMENDATION		
6. SUBMITTER		
a. NAME <i>(Last, First, Middle Initial)</i>	b. ORGANIZATION	
c. ADDRESS <i>(Include ZIP Code)</i>	d. TELEPHONE <i>(Include Area Code)</i> (1) Commercial (2) DSN <i>(If applicable)</i>	7. DATE SUBMITTED (YYYYMMDD)
8. PREPARING ACTIVITY		
a. NAME COMMANDER NAVAL AIR WARFARE CENTER AIRCRAFT DIVISION	b. TELEPHONE <i>(Include Area Code)</i> (1) Commercial (732) 323-2947	(2) DSN 624-2947
c. ADDRESS <i>(Include ZIP Code)</i> CODE 414100B120-3 HIGHWAY 547 LAKEHURST, NJ 08733-5100	IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT: Defense Standardization Program Office (DLSC-LM) 8725 John J. Kingman Road, Suite 2533 Fort Belvoir, Virginia 22060-6221 Telephone (703) 767-6888 DSN 427-6888	