

MIL-A-43326A  
5 December 1983  
SUPERSEDING  
MIL-A-43326  
7 April 1965

## MILITARY SPECIFICATION

### ALTAR, PORTABLE

This specification is approved for use by all Departments and Agencies of the Department of Defense.

#### 1. SCOPE

1.1 Scope. This document covers portable altar with carrying case and altar cloths.

\* 1.2 Classification. The portable altars shall be of the following class as specified (see 6.1):

- Class 1 - Altar with a red and gold antependium (see 3.3.1)
- Class 2 - Deleted (see 6.6)

#### 2. APPLICABLE DOCUMENTS

\* 2.1 Government documents. Unless otherwise specified, the following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of this document to the extent specified herein.

#### SPECIFICATIONS

##### FEDERAL

- V-T-276 - Thread, Cotton
- QQ-A-250/2 - Aluminum Alloy 3003, Plate and Sheet

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: U.S. Army Natick Research and Development Center, Natick, MA 01760 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

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- WW-T-700/2 - Tube, Aluminum Alloy, Round, Square, Rectangular and Other Shapes, Drawn, Seamless 3003
- WW-T-700/6 - Tube, Aluminum Alloy, Round, Square, Rectangular and Other Shapes, Drawn, Seamless 6061 and 6062
- ZZ-T-351 - Tips, Rubber and Synthetic Rubber, for Crutches, Furniture, etc.
- CCC-C-419 - Cloth, Cotton, Duck, Unbleached, Plied-Yarns, (Army and Numbered)
- CCC-C-950 - Dyeing and After-Treating Processes for Cotton Fabrics
- PPP-B-601 - Boxes, Wood, Cleated Plywood
- PPP-B-621 - Box, Wood, Nailed and Lock-Corner
- PPP-B-636 - Boxes, Shipping, Fiberboard

## MILITARY

- MIL-W-530 - Webbing, Textile, Cotton, General Purposes, Natural or in Colors
- MIL-C-5541 - Chemical Films and Chemical Film Materials for Aluminum and Aluminum Alloys
- MIL-A-8625 - Anodic Coatings, for Aluminum and Aluminum Alloys
- MIL-F-10884 - Fasteners, Snap
- MIL-P-15328 - Primer Pretreatment (Formula No. 117 for Metals)
- MIL-T-43566 - Tape, Textile, Cotton, General Purpose, Natural or in Colors

## STANDARDS

## FEDERAL

- FED-STD-191 - Textile Test Methods
- Fed-STD-751 - Stitches, Seams and Stitching

## MILITARY

- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
- MIL-STD-129 - Marking for Shipment and Storage

## DRAWINGS

## U.S. ARMY NATICK RESEARCH AND DEVELOPMENT CENTER

- 14-1-5 - Altar, Portable; Assembly Complete
- 14-1-11 - Altar, Portable; Carrying Case Assembly
- 14-1-12 - Altar, Portable, Antependium; Case Assembly
- 14-1-13 - Altar, Portable; Antependium Assembly Class 1

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(Copies of documents required by manufacturers in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting officer.)

2.2 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 shall take precedence.

## 3. REQUIREMENTS

\* 3.1 First article. When specified, a sample shall be subjected to first article inspection (see 4.3, 6.2 and 6.4).

\* 3.2 Materials (see 6.5) and components. Materials and components shall be as specified on the applicable drawings and as specified herein. If the contractor proposes to use an item considered to be equal to the material or component specified, prior to its use, the contractor shall furnish a sample of the material or component, with supporting data, to the contracting officer for subsequent evaluation by the responsible military agency.

3.2.1 Aluminum.

3.2.1.1 Sheet and strip. Sheet and strip aluminum shall conform to temper H-14 of QQ-A-250/2.

\* 3.2.1.2 Tubing. Aluminum tubing shall conform to temper H-14 of WW-T-700/2, or temper 6 of WW-T-700/6.

3.2.2 Cotton.

3.2.2.1 Duck. The cotton duck shall conform to type I, No. 6 hard texture of CCC-C-419. The cotton duck shall be dyed Olive Drab 7, in accordance with type I, class C of CCC-D-950, except that the requirements for fastness to laundering, crocking and accelerated weathering shall not apply.

\* 3.2.2.2 Webbing. The cotton webbing shall be Olive Drab 7, conforming to either type II or IIa, as required, class 4 of MIL-W-530.

\* 3.2.2.3 Tape. The cotton tape shall be Olive Drab 7 and conform to type I, class 4, of MIL-T-43566.

3.2.2.4 Thread. The cotton thread shall conform to either type IA3, ticket 12, 4 ply; or type 1C2, ticket 00 or A, as applicable, of V-T-276. The color of the thread shall be a good match to the color of the materials to be sewn.

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\* 3.2.3 Brocade. The brocade for the class 1 portable altar shall be red on red (Cable No. 65006), 150 plus or minus 8 denier bright acetate warp, two ply 20s combed cotton filling, not less than 132 by 48 thread count per square inch, and a minimum weight of 5.7 ounces per square yard. The design shall conform to Holiday #225, Olympia Fabrics Corporation, or equal.

\* 3.2.4 Polyester cloth. The cloth for the altar and the antependium shall be a white, plain weave, polyester cloth having a finish weight of not less than 4.5 ounces per square yard and a thread count of not less than 90 per square inch.

3.2.5 Banding. The banding for the class 1 portable altar shall be made from orphreyed materials of beige gold with a red design, Allen Silk Company, Pattern Number 5200, or equal, and shall have a tarnish proof satin finish.

3.2.6 Fasteners, snap. The snap fasteners shall conform to style 2, finish 3 of MIL-F-10884. The female component shall be button 24 line, and socket; the male component shall be eyelet size 1 and stud.

### 3.3 Components of portable altars.

3.3.1 Components of class 1 portable altars. The components of class 1 portable altars shall be one altar; one red and gold brocade antependium; one antependium case dyed Olive Drab 7; one carrying case dyed Olive Drab 7; and two altar cloths.

3.4 Details of components. Details of components shall be as specified herein and on the drawings specified in 2.1. Tolerances for dimensions on fabric components shall be in accordance with the manufacturer's standard practice unless otherwise specified herein.

\* 3.4.1 Altar. The altar shall consist of two hinged top sections with two sets of attached folding legs and four extension legs. A locking device shall be provided to lock the legs of the altar open and to unlock the legs for closing. The overall dimensions of the altar shall be 60 inches long, by 24 inches deep, 39 inches high when extension legs are attached. The tolerance on the overall dimension shall be plus or minus 1/4 inch. The altar shall fold, and when folded, shall be a maximum of 30-1/8 inches by 24-1/4 inches by 3 inches. The altar shall weigh not more than 19 pounds. The altar shall not deflect more than 1 inch, shall show no deformation of the leg braces, shall not rock, and shall have the top remain flat within 1/4 inch when tested for resistance to static load as specified in 4.4.4.

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- \* 3.4.1.1 Top sections. The top section shall be fabricated of aluminum specified in 3.2.1.1. At the option of the contractor, the flange may be folded back against the undersurface of the web. The edge of the top section shall be formed into channels having a 1-3/8 inch web and a 1/2 inch flange below the top surface. Each top section shall have three male snap fasteners as specified in 3.2.6, attached to the centerline of the web and located to match the location of the female snap fasteners of the antependium (see Drawing 14-1-13). A 5-inch carrying handle shall be centered and riveted or bolted to the centerline of the web of one of the top sections. When the two top sections are assembled in the open position, all six male snap fasteners and the carrying handle shall be in a line. Either spring clips or cotton webbing specified in 3.2.2.2 shall be attached to the underside of the top sections for securing each of the four extension legs. A 2-1/2 inch long tab, 1 inch wide, made of a double thickness of the cotton webbing specified in 3.2.2.2, shall be riveted to the web of one of the top sections. The tab shall have a female snap fastener, located to engage a male snap fastener attached to the web of the other top section. The tab shall be located at the end of the top section to secure the top sections in the folded position.
- \* 3.4.1.2 Folding legs. The folding legs shall be fabricated of the aluminum tubing specified in 3.2.1.2 and shall have a wall thickness of not less than 0.049 inch. Each set of folding legs shall consist of two legs. One set of folding legs shall be located at each end of the altar. Each set of legs shall have two steel braces not less than 0.119 inch thick. The braces shall be of the manual folding type and shall have positive acting locking devices to lock the legs when in the open position. Each set of legs shall be braced by a crossmember, or V-brace, or a combination of crossmember and V-brace.
- 3.4.1.3 Extension legs. The extension legs shall be fabricated of the aluminum tubing specified in 3.2.1.2 and shall have a wall thickness of not less than 0.049 inch. One end of the extension legs shall be designed to lock into the folding legs and the other end shall be plugged and shall be provided with a rubber tip conforming to ZZ-T-351. Each extension leg shall be not more than 18 inches long. The attached folding leg and the extension leg shall be of a length to allow the altar to attain the height of 39 inches plus or minus 1/4 inch as specified in 3.4.1.
- \* 3.4.2 Antependium. The antependium shall conform to the requirements specified herein and on Drawing 14-1-13. The top pieces shall be made of the polyester cloth specified in 3.2.4. The webbing shall conform to type IIa specified in 3.2.2.2. The cotton tie tape shall be made of the material specified in 3.2.2.3. The thread used in construction shall be type 1C2 as specified in 3.2.2.4. The snap fasteners shall be the female component as specified in 3.2.6. Stitching shall conform to the requirements specified in 3.5 and shall be 10 to 19 stitches per inch.

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- \* 3.4.2.1 Antependium, class 1 portable altar. The antependium for the class 1 portable altar shall be constructed of a top piece and a frontal. The frontal shall be made of the brocade specified in 3.2.3 and shall have an orphreyed banding specified in 3.2.5.

3.4.3 Cases. The antependium cases and the altar carrying cases shall be made of the cotton duck specified in 3.2.2.1. Cases for class 1 portable altars shall be dyed Olive Drab 7, matching the standard shade sample (see 6.3). The cases shall be bound with cotton tape, 3/4 inch wide as specified in 3.2.2.3, of a color matching the material bound. Thread used in construction shall conform to type 1A3 as specified in 3.2.2.4. Stitching shall conform to the requirements specified in 3.5 and shall be 6 to 8 stitches per inch. Snap fasteners specified in 3.2.6, reinforced by 1/16-inch leather disks placed between the snap fasteners and the cotton duck, shall be provided to close the cases.

3.4.3.1 Case, antependium. The antependium case shall conform to the requirements specified on Drawing 14-1-12.

3.4.3.2 Case, altar carrying. The altar carrying case shall conform to the requirements specified on Drawing 14-1-11.

- \* 3.4.4 Cloth, altar. The altar cloth shall be made of polyester cloth specified in 3.2.4. The thread used in construction shall conform to type 1C2 as specified in 3.2.2.4. Stitching shall conform to the requirements specified in 3.5 and shall be 10 to 14 stitches per inch. The finished size shall be 138 inches by 24 inches. The hem shall be approximately 2 inches, with mitred corners and a diagonal underseam to be machine stitched to secure each mitred corner. The altar cloth shall be folded.

- \* 3.5 Types of stitching. Stitching shall conform to FED-STD-751, type 301. Thread tension shall be maintained so that there will be no loose or tight stitching. All thread ends shall be trimmed. Seam allowances shall be maintained with seams properly sewn so that no runoffs, twists, pleats, puckers or open seams shall result. Thread breaks in stitching shall be overstitched not less than 1/2 inch at each break. Stitching shall be overstitched not less than 1/2 inch at the ends, except where the ends of stitching are caught in other seams or stitching.

### 3.6 Finish.

3.6.1 Aluminum components. All aluminum components of the altar assembly shall be anodized in accordance with type II of MIL-A-8625, except that the 5 percent dichromate pH 5.0-6.0 shall be omitted in the post anodic process; or pretreated in accordance with MIL-P-15328, given a chemical film in accordance with MIL-C-5541, and given a gray, baked enamel finish in accordance with the manufacturer's standard commercial practice.

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3.6.2 Steel components. All steel components shall be cadmium plated in accordance with the manufacturer's standard commercial practice.

3.7 Marking. The contractor shall permanently and legibly affix his name or trademark of such known character easily identified with said manufacturer on the underside of each altar.

3.8 Workmanship. The finished altars shall conform to the quality of product established by this document.

3.8.1 Sheet metal fabrication. Sheet metal used in the fabrication of equipment shall have no kinks or sharp bends. The straightening of material shall be done by methods that will not cause injury to the metal. Shearing shall be done neatly and accurately. Corners shall be square and true. All bends of a major character shall be made with metal dies or fixtures in order to insure uniformity of size and shape.

3.8.2 Bolted connections. Boltholes shall be accurately punched or drilled and shall have burrs removed. Washers or lockwashers shall be provided in accordance with commercial practice, and all bolts, nuts, and screws shall be tight.

3.8.3 Riveted connections. Rivet holes shall be accurately punched or drilled and shall have the burrs removed. Rivets shall be driven with pressure tools, and shall completely fill the holes. Rivet heads shall be full, neatly made, concentric with the rivet holes, and in full contact with the surface of the member.

3.8.4 Welding and brazing. All surfaces of parts to be welded or brazed shall be clean. Welding and brazing shall be accomplished in a manner which will prevent the occurrence of burn holes, cracks, fractures or incomplete fusion. All scale or flux deposits shall be removed from finished welds.

\* 3.8.5 Application of finish. The finish applied to the end item shall be continuous, smooth, adherent, without discoloration or foreign material imbedded, and contain no sags, runs, drips, creeps, laps, bubbles, streaks, wrinkles, blisters, cracks, scratches, pores, pits, lumps, flux or orange peel. No rust, rough grinds or tool marks shall show through the finished coating.

#### 4. QUALITY ASSURANCE PROVISIONS

\* 4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or purchase order, the contractor 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 document where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.



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- \* 4.1.1 Certificate of compliance. When certificates of compliance are submitted, the Government reserves the right to check test such items to determine validity of the certification.
- \* 4.2 Classification of inspection. The inspection requirements specified herein are classified as follows:
  - a. First article inspection (see 4.3).
  - b. Quality conformance inspection (see 4.4).
- \* 4.3 First article inspection. When a first article is required (see 6.2), it shall be examined for the defects specified in 4.4.2 and 4.4.3 and tested for the characteristics specified in 4.4.4 and for conformance to the weight requirement in 3.4.1. The presence of any defect, failure of any tests, or nonconformance to the weight requirement shall be cause for rejection of the first article.
- \* 4.4 Quality conformance inspection. Unless otherwise specified, sampling for inspection shall be performed in accordance with MIL-STD-105.
- \* 4.4.1 Component and material inspection. In accordance with 4.1, components and materials shall be inspected in accordance with all the requirements of referenced documents unless otherwise excluded, amended, modified or qualified in this document or applicable purchase document.
- \* 4.4.1.1 Certification. Materials listed below shall be accepted on the basis of a contractor's certificate of compliance with the indicated requirements.

<u>Material</u>	<u>Requirement paragraph</u>
Brocade	3.2.3
Polyester cloth	3.2.4

- \* 4.4.2 End item visual examination. The end item shall be examined for the defects listed in table I. The lot size shall be expressed in units of portable altars. The sample unit shall be one portable altar. The inspection level shall be II and the acceptable quality level (AQL) shall be 2.5 major defects and 6.5 total defects expressed in terms of defects per hundred units.



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TABLE I. End item visual defects

Examine	Defect	Classification	
		Major	Minor
Fabric	Cut, tear or hole:		
	-greater than 1/8 inch in length or diameter:		
	-on case	X	
	-on antependium		X
	-more than five holes not greater than 1/8 inch on case or anteperidium		X
	Broken or missing yarn; multiple floats clearly visible at normal inspection distance (approximately 3 feet)		X
Webbing, tie tapes	Edge frayed or scalloped		X
Hardware	Broken	X	
	Malformed:		
	-fails to perform intended function	X	
	-but will perform intended function		X
	Corroded area		X
	Burr or sharp edge which may cause injury in handling or damage to fabric	X	
Snap fasteners	Female components used on location where male components are required; fasteners fail to snap in a closed position or to remain firmly closed		X
Seams and stitching	Open seams or stitch type 301:		
	-for more than 1/4 inch but not more than 1 inch		X
	-for more than 1 inch	X	

NOTE: A seam shall be classified as open when one or more stitches joining a seam are broken, or when one or more skipped or run-off stitches occur. On double-stitched seams, a seam shall be classified as open when either one or both sides of a seam are open.

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TABLE I. End item visual defects (cont'd)

Examine	Defect	Classification	
		Major	Minor
Seams and stitching (cont'd)	Raw edges caught in stitching: -more than 1/2 inch but not more than 1 inch	X	X
	-more than 1 inch		
	Thread breaks: -overstitched less than 1/2 inch on stitch type 301		X
	NOTE: Thread breaks not overstitched shall be classified as open seams.		
	Skipped stitches overstitched less than 1/2 inch on stitch type 301 (when two or more skipped stitches occur consecutively)		X
	NOTE: Skipped stitches not overstitched shall be classified as open seams.		
	Needle chew resulting in cut, tear or hole (see cut, tear or hole)		
Stitching ends	Overstitched less than 1/2 inch on stitch type 301 (except where ends are held down by other stitching, turned under in a hem, or where stitching is performed automatically)		X
Seams	Seam twisted or pleated		X
Seam type	Wrong seam type	X	
Stitch type	Wrong stitch type	X	
Stitch tension	Loose, resulting in an exposed bobbin or top thread, for more than 3 inches		X
	Tight, as evidenced by puckering on fabric, for more than 3 inches		X
Stitches per inch	Less than minimum specified: -one stitch	X	X
	-two or more stitches		
	More than maximum specified: -one stitch	X	X
	-two or more stitches		

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TABLE I. End item visual defects (cont'd)

Examine	Defect	Classification	
		Major	Minor
Stitches per inch (cont'd)	NOTE: Variation in the number of stitches per inch caused by the operator speeding up the machine and pulling the fabric in order to sew over heavy places or heavy seams or in turning corners, shall be classified as follows:  a. Within the minor defect classification - no defect b. Within the major defect classification - minor defect		
Stitching gage	Not as specified		X
Components and assembly	Any component part not fabricated of applicable referenced material		X
	Any component missing	X	
Hems	Construction with partial turnunder when double turnunder is required		X
	Twisted or pleated		X
Reinforcements	Improperly applied causing excessive fullness on reinforcement or reinforced part		X
Binding	Improperly, or loosely applied, ends not finished as specified		X
Construction and workmanship, general (applicable to altar)	Part missing or not as specified type	X	
	Sharp burr, sliver or splinter	X	
Welding and brazing	Missing, incomplete, burnholes, cracked, fractured, or otherwise not fused	X	
	Slag inclusion, slight undercut, not smooth and uniform, scale or flux deposits not removed		X
Bolts, nuts, screws, studs and other types of threaded fasteners	Missing, broken, stripped, fractured, or loose		X
Marking for identification	Missing, incomplete, not legible		X

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- \* 4.4.3 End item dimensional examination. The end item shall be examined for conformance to the dimensions specified on the drawings. Any dimension not within the specified tolerance shall be classified as a defect. The lot size shall be expressed in units of portable altars. The sample unit shall be one portable altar. The inspection level shall be S-2 and the AQL, expressed in terms of defects per hundred units, shall be 4.0.
- \* 4.4.4 End item testing. The end item shall be tested as specified in 4.5.1 for conformance to the resistance to static load requirement specified in 3.4.1. The lot size shall be expressed in units of portable altars. The sample unit shall be one portable altar. The inspection level shall be S-4 and the AQL, expressed in terms of defects per hundred units, shall be 1.5.
- \* 4.4.5 Packaging inspection. An examination will be made to determine that preservation, packing and marking comply with section 5 requirements. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully packaged with the exception that it need not be closed. The lot size shall be the number of containers in the inspection lot. The inspection level shall be S-2 and the AQL, expressed in terms of defects per hundred units, shall be 4.0.

<u>Examine</u>	<u>Defect</u>
Marking (exterior)	Omitted; incorrect; illegible, of improper size location, sequence, or method of application
Materials	Any component missing, damaged, or not as specified

- \* 4.5 Methods of inspection.
- \* 4.5.1 Static load test. The altar shall be erected and the legs locked in the open position. A weight of 175 pounds shall be applied at the top center of the altar over an area of 18 inches by 18 inches for a period of 4 hours. The deflection of the top shall be measured and the leg braces shall be examined. The weight shall be removed and the altar shall be placed on a level surface and examined for rocking. A straightedge shall be placed diagonally across the altar surface between two corners and the gap between the straightedge and the altar surface shall be measured. The measurement shall be repeated for the diagonal between the other two corners. Any failure to conform to the requirements specified in 3.4.1 shall be reported as a defect.

## 5. PACKAGING

- 5.1 Preservation. Preservation shall be level A.

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5.1.1 Level A. The altar cloths antependium shall be neatly and compactly folded and placed within the antependium canvas case, with the case cover closed with means provided. The altar extension legs shall be secured to the altar by means provided. The antependium case shall be placed inside the altar and the altar secured closed with strap provided. The altar shall then be placed within the altar canvas case and the case closed with means provided.

5.2 Packing. Packing shall be level A or B as specified (see 6.2).

- \* 5.2.1 Level A packing. Twelve altars, preserved as specified in 5.1, shall be packed in a close-fitting plywood box conforming to overseas type, style optional of PPP-B-601, or nailed and locked corner wood box, class 2, style optional conforming to PPP-B-621. Each box, with a skid base, shall be closed and strapped in accordance with the box specification.
- \* 5.2.2 Level B packing. Each altar, preserved as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC, type CF (variety SW) or SF, class domestic of PPP-B-636. Each shipping container shall be closed in accordance with method II as specified in the appendix of PPP-B-636.
- \* 5.2.2.1 Weather-resistant fiberboard container. When specified (see 6.2), the shipping container shall be grade V3c, V3s, or V4s fiberboard box fabricated in accordance with PPP-B-636 and closed in accordance with method III as specified in the appendix of the container specification.

5.3 Marking. In addition to any special marking required by the contract or purchase order, shipping containers shall be marked in accordance with MIL-STD-129.

## 6. NOTES

6.1 Intended use. The portable altar is intended for field use by Military Chaplains. The class 1 altar is intended for use by the Army and Navy.

- \* 6.2 Ordering data. Acquisition documents should specify the following:
  - a. Title, number and date of this document.
  - b. When first article is required (see 3.1).
  - c. Selection of applicable level of packing (see 5.2).
  - d. When weather-resistant containers are required for level B shipments (see 5.2.2.1).

6.3 Standard sample. For access to standard shade samples for cotton webbing and tape, address the contracting office issuing the invitation for bids.

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- \* 6.4 First article. When a first article sample is required, it shall be inspected and approved under the appropriate provisions of DAR 7-104.55. The first article should be a preproduction sample consisting of one complete altar. The contracting officer should include specific instructions in all acquisition documents regarding arrangements for inspection and approval of the first article.
- \* 6.5 Recycled material. It is encouraged that recycled material be used when practical as long as it meets the requirements of the document (see 3.2).
- \* 6.6 Supersession data. This class is no longer required and declared as a terminal item.

6.7 Changes from previous issue. The margins of this document are marked with an asterisk to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were 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.

## Custodians:

Army - GL  
Navy - PE  
Air Force - 28

## Preparing activity:

Army - GL  
Project No. 9925-0211

## Review activities:

DLA - GS  
Armed Forces Chaplains Board

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