

MIL-B-1667F  
AMENDMENT-1  
3 October 1980

## MILITARY SPECIFICATION

### BRAID, TEXTILE CORD-EDGE

This amendment forms a part of Military Specification MIL-B-1667F, dated 12 July 1977, and is approved for use by all Departments and Agencies of the Department of Defense.

#### PAGE 1

1.2, class 4: Delete "(alternate allowed)".

#### PAGE 3

3.2.2 Delete and substitute: "3.2.2 Silver color material. The silver color material used in braiding the cord covers for classes 5 and 6 shall be silver foil polyester laminate thread, or equal; 0.02 inch (0.5 mm) wide for class 5 and 0.03 inch (0.8 mm) wide for class 6 exhibiting a breaking strength of not less than 0.50 pounds (2.2 N) when tested as specified in 4.3.1."

3.2.3 Delete and substitute:

"3.2.3 Gold color material. The gold color material used in braiding the cord covers for classes 1 and 2 shall be gold foil polyester laminate thread, or equal; 0.02 inch (0.5 mm) wide for class 1 and 0.03 inch (0.8 mm) for class 2 exhibiting a breaking strength of not less than 0.50 pounds (2.2 N) when tested as specified in 4.3.1."

#### PAGE 4

3.2.4 Delete and substitute:

"3.2.4 Polyester yarn. The polyester yarn used in braiding the cord covers for classes 2, 3, 4, 6 and 7 and for the flat braid sections of all classes shall be nominal 150 denier (17 tex) heat set, texturized, semi-dull multifilament when tested as specified in 4.3.1."

3.3, lines 3 and 4: Delete "Goldenlite 17425 (see 6.3.1)".

Table I, classes 1 and 2: Delete "Goldenlite, Cable No. 17425" and substitute "Gold foil polyester laminate thread or equal".

Table I, classes 5 and 6: Delete "Laminated silver color metallic thread" and substitute "Silver foil polyester laminate thread or equal".

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3.4.1.2.1 through 3.4.1.2.5. Delete and substitute:

"3.4.1.2.1 Class 1. The cord cover shall be braided using the gold foil polyester laminate thread or equal.

3.4.1.2.2 Classes 4 and 7. The cord cover shall be braided with one color (see table I) of polyester yarn.

3.4.1.2.3 Class 2. The cord cover shall be braided using 14 carriers of black polyester yarn and 5 carriers of gold foil polyester laminate thread equally spaced around the cord. It is preferred that the direction of the gold yarn in this cord be from lower left to upper right, when held in a horizontal position.

3.4.1.2.4 Class 3. The cord cover shall be braided using 14 carriers of black polyester yarn and 5 carriers of silver grey polyester yarn equally spaced around the cord.

3.4.1.2.5 Class 5. The cord cover shall be braided using silver foil polyester laminate thread or equal.

3.4.1.2.6 Class 6. The cord cover shall be braided 14-2 ends up carriers of Carbon Blue, Cable No. 16563 polyester yarn and 5-1 ends up carriers of silver foil polyester laminate thread or equal."

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Table II Delete and substitute new table:

"TABLE II. Cord cover requirements

Class	1	2	3	4 & 7	5	6
Number of carriers (min)	19	19	19	19	19	19
Ends per carrier (min)		14-2 ends up	14-4 ends up Black 5-4 ends up Grey	19-4 ends up		14-2 ends up
Polyester yarn 150 denier (17 tex)						
Silver foil polyester laminate thread or equal				19-1 ends up		5-1 ends up
Gold foil polyester laminate thread or equal	19-1 ends up	5-1 ends up				
Picks per inch (cm) (min)						
Polyester yarn 150 denier (17 tex)	26 (10)	26 (10)	26 (10)	26 (10)	26 (10)	26 (10)
Braiding type	Over 2, Under 2	Over 2, Under 2	Over 2, Under 2	Over 2, Under 2	Over 2, Under 2	Over 2, Under 2

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PAGE 5 (cont'd)

3.4.2 Delete and substitute:

"3.4.2 Flat braid section. Flat braid section for all classes shall be braided over 2, under 2 with polyester yarn conforming to the requirements of 3.2.4 and table III."

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Table III Delete and substitute new table:

"TABLE III. Flat braid section requirements

Flat braid section	Classes	
	1, 3, 4, 5 and 7	Classes 2 and 6
Width in inches (mm)	1/4 min - 5/16 max (6 min - 7 max)	1/4 min - 5/16 max (6 min - 7 max)
Number of carriers	25	25
Ends per carrier	3	2
Picks per inch, (cm) (min)	26 (10)	26 (10)
Warp ends for 25 carrier braider	11-2 ends up	11-2 ends up
Lines for 25 carrier braider	6	6

3.5 Delete and substitute:

"3.5 Weight. The finished cord-edge braid shall weigh not less than 22.0 ounces per (gross) yard (624 grams per 32 meters) for classes 1, 3, 4, 5 and 7 and not less than 20.0 ounces per 144 (gross) yards (567 grams per 32 meters) for classes 2 and 6, when tested as specified in 4.4".

PAGE 9

Table IV, first column, line 7: Delete "Laminated silver color metallic thread" and substitute: "Silver foil polyester laminate thread or equal."

lines 10 through 13: Delete and substitute the following in their respective columns:

"Gold foil polyester laminate thread or equal

Identification	3.2.3
Breaking strength	3.2.3

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6.3.1 Delete.

Custodians:

Army - GL  
Air Force - 11

Preparing activity:

Army - GL

Project No. 8315-0273

Review activities:

Army - MD  
Air Force - 99  
DLA - CT