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INCH-POUND

MIL-B-1963J
AMENDMENT 1
1 August 1990

MILITARY SPECIFICATION

BUCKLES; AND CLIPS, END, STRAP (FOR BELT, TROUSERS)

This amendment forms a part of Military Specification MIL-B-1963J, dated 29 July 1988, and is approved for use by all Departments and Agencies of the Department of Defense.

PAGE 2

1.2, under Type III, Class 1: Add "Sub-Class C - Chromium plated".

PAGE 5

3.3, last sentence: Delete and substitute: "The buckle clamps, rollers, and tongues shall not pull free from belt webbing at or below 35 pounds when pull tested as specified in 4.4.5."

PAGE 6

3.4, at end: Add the following: "Use of prepolished nickel silver is acceptable for clips. Use of prepolished nickel silver is prohibited for buckles."

3.4.1.2, at end of second sentence: Add "or chromate treated zinc plate conforming to type II (with a thickness of 8 micrometers) of ASTM B 633,"

PAGE 7

Add new paragraph:

"3.4.3.1.3 Sub-class C (chromium plated). All outside surfaces shall be given a mirror like polish finish. The clip shall be nickel plated in accordance with class 1, grade G of QQ-N-290 followed by chrome plating in accordance with class 1, type I of QQ-C-320, except the thickness shall be 0.000015 inch minimum."

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PAGE 15

4.5.3, line 4: Before "machine clamps": add "3-inch".

Line 6: Before "machine clamps": add "3-inch".

After last line: Add "If any part of the buckle is distorted during the test, the distorted buckle shall be retested and considered passing if the webbing does not pull free from the buckle at or below a load of 35 pounds. If a Constant Rate of Extension (CRE) Tensile Tester is utilized, set the maximum load crosshead stop setting slightly lower than the 35 pounds to compensate for the crosshead speed override. The machine should be tested for correct load setting before testing buckles. A Constant Rate of Traverse (CRT) Tensile Tester will not require pretesting. The pulling speed of the test machine shall be set to 12 inches per minute."

PAGE 18

5.3, line 6: Delete "K and L or film bonding means O or P" and substitute "C and D or film bonding means F or G.".

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(Project 8315-0348)