

INCH-POUND

MIL-B-44053A

AMENDMENT 1

22 June 1990

MILITARY SPECIFICATION

BODY ARMOR, FRAGMENTATION PROTECTIVE VEST, GROUND TROOPS

This amendment forms a part of Military Specification MIL-B-44053A, dated 31 December 1986, and is approved for use by all Departments and Agencies of the Department of Defense

PAGE 1

1.1 Scope., at the end of paragraph: Add "This is a special purpose Life Support Clothing and Equipment (LSC&E) item. All government administrative and surveillance procedures applicable to LSC&E items shall be invoked in accordance with the contract or purchase order (see 6.2)."

PAGE 2

2.1.1, under "Military Specifications": Add "MIL-W-17337 - Webbing, Textile, Woven Nylon".

PAGE 5

3.2.11: Delete and substitute:

"3.2.11 Webbing, elastic, 1-inch and 1-1/2-inch wide. The 1 inch elastic webbing for the shoulder pad retainer straps shall conform to type II, class 1 of MIL-W-5664, and the 1 1/2 inch elastic webbing for the side closures shall conform to type II, class 1 of MIL-W-5664, except that it may be constructed by shuttleless loom with 2 picks per shed. The webbing shall be dyed Olive Green 106."

3.2.14, line 2: after "label" insert "(see 6.5)".

PAGE 12

3.7.1.7, lines 3 and 4: Delete and substitute:

"1 Strap, retainer, shoulder pad 4".

AMSC N/A

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PAGES 24 and 25

Table I, operation 22: Delete and substitute:

"22. Make collars (two required).

a. Each collar shall consist of a shell and ballistic insert. The insert shall consist of two wide plies and four narrow plies.

b. Evenly position the two halves of the collar shell with the camouflage sides facing each other. Stitch the shell plies together along the top (curved) edge starting and stopping at the bottom edge at each end. Stitch gauge for overedge stitching shall be $3/16$ to $1/4$ inch and the stitch margin for chain stitching shall be $3/8 \pm 1/16$ inch. Leave bottom edges open. Turn collar shell and work out edges. Omit operation e. 515, 516, or 519 SSa-2 6-10 B B

Option 1. Overedge around the top (curved) edge of each of the wide plies of the insert starting and stopping at the bottom edge at each end. Stitch gauge shall be $3/16$ inch wide, minimum. 502, 503, 504, or 505 Efd-1 6-10 B B

Option 2. Fuse the top (curved) edge of each shell part (see 3.4.4).

c. Overedge around the top (curved) edge of each of the wide plies of the insert starting and stopping at the bottom edge at each end. Stitch gauge shall be $3/16$ inch wide, minimum. 502, 503, 504, or 505 Efd-1 6-10 B B

d. Evenly position two narrow plies of the insert on top of each other and overedge the top (curved) edge starting and stopping at the bottom edge at each end. Stitch gauge shall be $3/16$ inch wide, minimum. Repeat this procedure with the remaining two narrow plies. 502, 503, 504, or 505 SSa-1 6-10 B B

e. (For options 1 and 2 of operation b. only). Evenly position two halves of the collar shell with the camouflage sides facing each other. Stitch the shell parts together with a row of stitching along the top (curved) edge starting and stopping at the bottom edge of each end. Stitch $3/8 \pm 1/16$ inch from the edge. Leave the bottom edge open. Turn collar shell and work out edges. 301 SSa-1 6-10 B B

f. Sandwich two of the overedge pairs of narrow insert plies between two wide insert plies. Evenly align at the top (curved) edges. Holding the six plies in this position, insert them into the collar shell until the filler fits snug at the top of shell without buckling. Stitch all eight plies with one row of stitching $1 \pm 1/16$ inch from the bottom edge. 301 SSa-1 6-10 B B

g. Overedge bottom edge of collar with stitch gauge $3/16$ to $1/4$ inch. 502, 503, 504, or 505 Efd-1 6-10 B B

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PAGE 25 and 26

Table I, operation 23: Delete and substitute:

"23. Attach collars to back and front outer shell assembly.

- a. On a line 1 1/2 inches up from the bottom, overlap the rear collars 1 inch horizontally and tack (holding stitch) with one tack.
- b. With the camouflage surface of the front and back outer shells facing down, align the raw edge 1 inch from the bottom edge of the collar (or the 1 inch stitch line, and stitch collar to outer shells from front notch to front notch as indicated on the patterns). Stitching shall be $3/8 \pm 1/16$ from raw edges. Attached collar shall finish 2-1/4 inches from attaching seam to outer edge when measured at the shoulder seam. 301 LSbj-1 8-10 E E".

PAGE 27

Table I, operation 24.e: Delete and substitute:

- "e. Make four shoulder pad retainer straps. Cut elastic straps from 1 inch elastic webbing in accordance with pattern. Cut reinforcement pieces $2 \frac{1}{4} \pm \frac{1}{8}$ inch long from 3/4 inch wide nylon webbing. Position reinforcement piece on the strap as indicated on the pattern. Fold the reinforcement end as indicated on the pattern over on itself so that the reinforcement piece is between the two layers of webbing. Install two female snap fastener buttons and sockets through the three layers in the locations indicated on the pattern. The buttons shall be on the top of the folded end of the webbing. Turn under raw end and fold the free end of the webbing over the buttons as indicated on the pattern. Stitch around the periphery of the folded webbing that covers the buttons $1/8$ to $1/16$ inch from webbing side edges and folds. 301 SSa-1 8-10 E E".

PAGE 29

Table I, operation 24.i, line 7, after "shells.": Insert "Bartack the retainer strap with two 1/2 inch horizontal bartacks centered on each side edge, equally extending beyond the side edges of the retainer strap. The bartacks are to be placed adjacent to the stitch line in the seam allowance."

PAGE 32

Table I, operation 27.c, line 17: Delete "vertical" and substitute "horizontal".

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Table I, operation 30, line 9, after "bartack": Insert "the 1/2 inch wide tab".

After "tab.": Line 11, insert "The 1-1/2 inch wide tabs shall be either bartacked through the filler with one continuous or two 3/4-inch successive horizontal bartacks or as an alternate method for the 1-1/2 inch tape only, stitch through the filler with two adjacent rows of stitching across each tab, located $1/8 + 1/16$ inch from the folded edge.
Bartack or 301 42 per tack or 8-10 B or E B or E".

PAGE 37

Table I, operation 33.b, line 2: Delete "1-3/4" and substitute "2-3/4".

PAGE 50

4.4.3, defects for cloth: Delete defects "a. thru f." and substitute:

Examine	Defect	Classification	
		Major	Minor
"Cloth	a. Any hole, cut, tear, smash, burn, drill hole, scorched area, multiple float, or open place.	X	
	b. Misweave, dyestreak, broken or missing yarn, visible mend, thin place, or shade bar greater than 1/4 inch		X
	c. Loose yarn or coarse yarn on outside		X
	d. Needle chew on outside (largest dimension in any direction):		
	1. Up to 1/2 inch inclusive		X
	2. More than 1/2 inch	X	
	e. Knot or slub outside		X
	f. No printed dye penetration:		
	1. Up to 1/4 inch inclusive		X
	2. More than 1/4 inch	X	
	g. Poor printed dye penetration:		
	1. More than 1/4 inch to 1/2 inch inclusive		X
	2. More than 1/2 inch	X	

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PAGE 50 (cont'd)

Examine	Defect.	Classification	
		Major	Minor
Cloth (cont'd)	h. Parts not cut properly with respect to material lines:		
	1. On vest inner and outer shell components	X	
	2. On collar, shoulder pad, pockets and pocket flaps and front closure flap		X
Cleanness	a. Spot or stain on outside, 1/4 inch or more (largest dimension in any direction)		X
	b. Five or more thread ends of more than 1/2 inch on the outside, or nine or more thread ends of more than 1/2 inch on the inside		X
	c. Two or more shade or size tickets not removed		X
	d. Any size or shade marking on outside 1/4 inch or more		X"

PAGE 57

General assembly defect "g.": Delete classification of defect as "Minor" and substitute "Major".

PAGES 60 and 61

5.1.1: Delete and substitute:

"5.1.1 Level A. Five body armor vests, of one size only, shall be packed in a fiberboard shipping container conforming to style RSC-L, grade V2s of PPP-B-636. The body armor vests shall be packed flat, five in depth, each alternately reversed top to bottom, within a shipping container. Inside dimensions of shipping containers shall be as specified in table III. Each shipping container shall have the contents completely covered on the top and bottom with a sheet of 40-pound minimum basis weight kraft paper conforming to A-A-203. Each shipping container shall be closed in accordance with method III, waterproofed in accordance with method V, and reinforced as specified in the appendix of PPP-B-636."

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PAGE 60 and 61 (cont'd)

Table III: Delete all dimensions and substitute respectively:

"25	20	8
26-1/2	23	8-1/2"

5.1.2: Delete and substitute:

"5.1.2 Level B. Five body armor vests of one size only, shall be packed in a fiberboard shipping container conforming to style RSC-L, type CP (variety SW) or SP, class domestic, grade 275 of PPP-B-636. The body armor vests shall be packed flat five in depth, each alternately reversed top to bottom, within a shipping container. Inside dimensions of shipping container shall be as specified in table III. Each shipping container shall have the contents completely covered on the top and bottom with a sheet of 45-pound minimum basis weight kraft paper conforming to A-A-203. Each shipping container shall be closed in accordance with method II as specified in the appendix of PPP-B-636."

5.1.2.1, line 4: after "636" delete the remainder of the paragraph.

5.2, line 6, after "bonding means": Delete the remainder of paragraph and substitute "C and D. Pallet patterns shall be number 1 for sizes X-small, small, and medium; and number 89 for sizes large and X-large, in accordance with the appendix of MIL-STD-147."

PAGE 62

5.3.1: Delete.

6.2: Add "h. Special provisions for verification inspection of Life Support Clothing and Equipment (see 1.1)."

PAGE 63

Add "6.11 Life support clothing and equipment. All Government administrative and surveillance and quality verification provisions applicable to LSC&E items shall be invoked for items purchased in accordance with this specification."

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Custodians:

Army - GL
Navy - NU
Air Force - 99

Review activities:

Army - MD
Navy - MC
Air Force - 82
DLA - CT

User activity:

Air Force - 45

Preparing activity:

Army - GL
(Project 8470-0138)