

INCH-POUND

MIL-B-52489E
AMENDMENT 1
26 May 1995

MILITARY SPECIFICATION
BARBED TAPE, CONCERTINA

This amendment forms a part of Military Specification MIL-B-52489E, dated 26 March 1987, and is approved for use by all Departments and Agencies of the Department of Defense.

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2.1.1.: Under SPECIFICATIONS, FEDERAL, delete:
"QQ-S-781 - Strapping, Steel, and Seals
QQ-W-461 - Wire, Steel, Carbon, (Round, Bare and
Coated)"

Beneficial comments, delete in its entirety and substitute the following:

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Commander, US Army Aviation and Troop Command, ATTN: AMSAT-R-EDS, 4300 Goodfellow Boulevard, St Louis, MO 63120-1798 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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2.1.1: Under SPECIFICATIONS, MILITARY, delete: "MILITARY" and "MIL-T-704 - Treatment and Painting of Materiel."

2.1.1: Under STANDARDS, FEDERAL, delete: "FEDERAL" and "MIL-STD-595 - Colors."

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2.2.: Under AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM),
delete: "ASTM D 522 - Elongation of Attached Organic Coatings with
Conical Mandrel Apparatus
ASTM D 523 - Specular Gloss
ASTM D 2092- Preparation of Zinc-Coated Steel Surfaces
for Painting
ASTM D 3359- Measuring Adhesion by Test Tape"

add: "ASTM A 641 - Zinc-Coated (Galvanized) Carbon Steel Wire
ASTM A 777 - Galvanized Round Steel Tying Wire
ASTM B 633 - Standard Specification for Electrodeposited
Coatings of Zinc on Iron and Steel"

PAGE 3

3.3.1.1, lines 4 thru 9, delete: "The barbed tape shall be
phosphatized in accordance with commercially available
phosphatizing processes for zinc phosphate conversion coatings and
shall be compatible with galvanized surfaces. The treatment for
conversion to zinc phosphate coatings shall be in accordance with
ASTM D 2092. The minimum zinc phosphate coating weight shall be
150 mg/sq ft for spray processes and 300 mg/sq ft for immersion
processes."

lines 9 and 10, change to "Coat may be applied before all
machining, brazing, and forming."

3.3.1.2, lines 3 thru 8, delete: "The clips or strips shall be
phosphatized in accordance with commercially available
phosphatizing processes for zinc phosphate conversion coatings.
The treatment for conversion to zinc phosphate coatings shall be in
accordance with ASTM D 2092. The minimum zinc phosphate coating
weight shall be 150 mg/sq ft for spray processes and 300 mg/sq ft
for immersion processes", and substitute: "The clips or strips
shall be zinc coated 0.0002 inch minimum each side and shall then
have a supplementary chromate treatment complying with ASTM B633,
Type III, with applicable test thereof."

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3.3.1.3, delete in its entirety.

3.3.3.1 and 3.3.3.2, line 2, delete: "QQ-W-461, steel no. 1010,
finish 5, soft, class 1", and substitute: "ASTM A 641, class 1
coating, soft temper."

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3.5 thru 3.5.2, delete in its entirety.

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3.5.3 thru 3.5.3.5, delete in its entirety.

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4.4.1.3, line 1, delete: "Sampling" and substitute "Sample size".

4.4.2.3, delete last sentence and substitute: "Presence of one or more defects shall be cause for rejection".

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4.4.3.2, delete in its entirety.

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4.5.1.3, under Major, delete: "120. Color not as specified" and "121. Treatment and painting not as specified".

4.5.1.3.1, 4.5.2.2, 4.5.2.3, and 4.5.2.4, delete in its entirety.

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4.5.2.5., delete in its entirety.

4.5.2.6, change to: "Salt spray. Using a specimen not less than 6 inches long, taken from the barbed tape concertina, subject the specimen to continuous salt spray test in accordance with ASTM B117, for not less than 120 hours. The specimen shall show no blistering nor white corrosion or base metal corrosion products. The appearance of corrosion products visible to the unaided eye at normal reading distance shall be cause for rejection, except those white corrosion products at the edge of the specimens shall not constitute failure."

4.6.2.3, line 2, delete: "The AQL shall be 1.0 percent defective" and substitute: "Presence of one or more defects shall be cause for rejection".

5.2, line 3, delete: "QQ-S-781, class 2, type V, finish B, size 9", and substitute "ASTM A 777, class II, size 9 (0.148 inch nominal diameter), regular coating."

Custodian:
Army - AV

Preparing activity:
Army - AV

Review Activity:
DLA - CS

Agent:
DLA - CS

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