

MIL-B-829M
16 May 1988

SUPERSEDING
MIL-B-829L
15 November 1984

MILITARY SPECIFICATION

BAG, DUFFEL

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

1. SCOPE

1.1 Scope. This document covers nylon duck, Olive Green 106, duffel bag, 12-1/2 inches diameter by 37 inches deep, having one handle and two straps.

1.2 Classification. The duffel bag shall be of one type and size.

2. APPLICABLE DOCUMENTS

• 2.1 Government documents.

- 2.1.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of these documents shall be those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation.

SPECIFICATIONS

FEDERAL

A-A-203	- Paper, Kraft, Untreated
V-T-285	- Thread, Polyester
QQ-W-321	- Wire, Copper Alloy
QQ-W-461	- Wire, Steel, Carbon (Round, Bare, and Coated)
TT-E-529	- Enamel, Alkyd, Semigloss

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, Development, and Engineering Center, Natick, MA 01760-5014 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8465

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

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- DDD-L-20 - Label: For Clothing, Equipage, and Tentage,
(General Use)
- PPP-B-636 - Boxes, Shipping, Fiberboard

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- MIL-F-495 - Finish, Chemical, Black, For Copper Alloys
- MIL-W-4088 - Webbing, Textile, Woven Nylon
- MIL-F-10884 - Fasteners, Snap
- MIL-G-16491 - Grommet, Metallic
- MIL-W-27265 - Webbing, Textile, Woven Nylon Impregnated
- MIL-L-35078 - Loads, Unit: Preparation of Semiperishable
Subsistence Items; Clothing, Personal Equipment
and Equipage; General Specification For
- MIL-C-43204 - Cloth, Spacer (Olefin)
- MIL-A-43671 - Adapter, Reversible, Quick-Fit, 1-3/4 Inch
- MIL-C-43734 - Cloth, Duck, Textured Nylon
- MIL-S-43770 - Snap Hooks, General Specification For

STANDARDS

FEDERAL

- FED-STD-751 - Stitches, Seams and Stitchings

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- MIL-STD-105 - Sampling Procedures and Tables for Inspection
by Attributes
- MIL-STD-129 - Marking for Shipment and Storage
- MIL-STD-147 - Palletized Unit Loads
- MIL-STD-731 - Quality of Wood Members for Containers and Pallets

(Copies of specifications, standards, and handbooks required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting activity.)

- * 2.1.2 Other Government documents, drawings, and publications. The following other Government documents, drawings, and publications form a part of this specification to the extent specified herein. Unless otherwise specified, the issues shall be those in effect on the date of the solicitation.

DRAWINGS

U.S. ARMY NATICK RESEARCH, DEVELOPMENT, AND ENGINEERING CENTER

- 2-3-299 - Bag, Duffel; Assembly and Sections
- 2-3-300 - Bag, Duffel; Sections and Details
- 2-3-301 - Bag, Duffel; Details

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(Copies of drawings, publications, and other Government documents required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting activity.)

- * 2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of the documents which are DOD adopted shall be those listed in the issue of the DODISS specified in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS shall be the issues of the nongovernment documents which are current on the date of the solicitation.

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

B 633 - Electrodeposited Coatings of Zinc on Iron and Steel
D 3951 - Standard Practice for Commercial Packaging

(Copies should be obtained from the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103-1187.)

(Nongovernment standards and other publications are normally available from the organizations which prepare or which distribute the documents. These documents also may be available in or through libraries or other informational services.)

- * 2.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein, the text of this specification shall take precedence. Nothing in this specification, however, shall supersede applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 Guide samples. Samples, when furnished, are solely for guidance and information to the contractor (see 6.3). Variation from this document may appear in the sample, in which case this document shall govern.

3.2 First article. When specified in the contract or purchase order, a sample shall be subjected to first article inspection (see 4.3, 6.2, and 6.4).

3.3 Materials (see 6.5).

- * 3.3.1 Cloth, duck, nylon. The cloth for the duffel bag shall be 11 ounce minimum nylon duck, conforming to class 3 of MIL-C-43734.

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3.3.2 Webbing.

3.3.2.1 Nylon webbing. The nylon webbing shall be 1-23/32 inch width, type VIII, Olive Drab 7 conforming to MIL-W-4088 and shall be resin treated conforming to class R of MIL-W-27265.

3.3.3 Thread, polyester. The thread shall conform to type I or type II, class 1, sub-class B of V-T-285. Thread sizes shall be as follows:

Size FF - For all stitching except the handle, closing strap, shoulder straps, and handle and shoulder strap reinforcements to the body of the duffel bag; and the optional stitching indicated by "Z" on drawings.

Size 3 - For stitching the handle, closing strap, shoulder straps, and the handle and shoulder strap reinforcements to the body of the duffel bag.

Size FF - For needle. For optional method of stitching.

Size F - For looper indicated by "Z" on drawings.

3.3.3.1 Color. The thread shall be dyed Olive Drab S-1 (C.A. 66022) and shall show fastness to weathering equal to or better than the standard shade sample (see 6.3). If no standard sample is available, the thread shall show good fastness to weathering.

3.3.4 Grommets. The grommets shall conform to type I, class 3, size No. 5 of MIL-G-16491.

3.3.5 Keeper, steel or brass. The keeper shall be either steel or brass. Steel keepers shall be fabricated from 0.1483 inch nominal diameter, 1015 or 1020, finish 1, steel wire conforming to QQ-W-461. The finish of the steel keeper shall consist of a phosphate-treated zinc plate conforming to type IV, SC3 (severe) of ASTM B 633, followed by baked enameling. The enamel shall be black and shall conform to type II of TT-E-529. The coating shall level out to a uniform continuous dry film of uniform black color with no objectionable orange peel, wrinkles, drops, streaks, or areas of thin or no film. Brass keepers shall be fabricated from half-hard brass wire, 0.1443 inch nominal diameter, alloy number 260 or 270 conforming to QQ-W-321. Brass keepers shall be given a black chemical finish conforming to MIL-F-495.

3.3.6 Snaphook, 1-1/8 inch fixed loop, with spring closure. The snaphook with spring closure shall conform to part number M43770/1-SWZE5 of MIL-S-43770.

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3.3.7 Fastener, snap. The snap fastener shall conform to style 2, size 1 or 2, finish 2 of MIL-F-10884.

3.3.8 Spacer cloth. The spacer cloth shall conform to type II or III of MIL-C-43204, color optional.

3.3.9 Adapter. The adapter shall be reversible, quick fit, 250 lbs., 1-3/4 inches, conforming to MIL-A-43671.

3.4 Construction. The construction shall conform in all respects to Drawings 2-3-299, 2-3-300, and 2-3-301 and shall be as specified herein. Seam allowances shall be maintained with seams properly sewn so that no raw edges, run-offs, twists, pleats, puckers, or open seams shall result.

3.4.1 Stitches, seams, and stitchings. All seams and stitching shall conform to FED-STD-751 as follows:

For all stitching, except the optional method of stitching indicated by "Z" on drawings. - Type 301, 6 to 8 stitches per inch.

For optional method of stitching indicated by "Z" on drawings. - Type 401, 6 to 8 stitches per inch. The chain portion of the stitching shall not appear on the outside of the duffel bag.

3.4.1.1 Type 301 stitching. Ends of all stitching shall be backstitched or overstitched 1/2 inch except when caught in other stitching or turned under in a hem. Thread tension shall be maintained so that there will be no loose or excessively tight stitching resulting in puckering of the materials sewn. The lock shall be embedded in the materials sewn.

3.4.1.1.1 Repairs of type 301 stitching. Repairs of type 301 stitching shall be as follows:

a. When thread breaks, skipped, or run-off stitches or bobbin run-outs occur during sewing, the stitching shall be repaired by restarting the stitching a minimum of 1/2 inch back of the end of stitching.

b. Thread breaks or two or more consecutive skipped or run-off stitches noted during inspection of the item (in-process or end item) shall be repaired by overstitching. The stitching shall start a minimum 1/2 inch in back of the defective area, continue over the defective area, and continue a minimum of 1/2 inch beyond the defective area onto existing stitching. Loose or excessively tight stitching shall be repaired by removing the defective stitching, without damaging the materials, and restitching in the required manner.

(When making the above repairs in a. and b. above, the ends of stitching are not required to be backstitched.)

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3.4.1.2 Type 401 stitching. Thread tension shall be maintained so that there will be no loose stitching. All repairs shall be in accordance with 3.4.1.1.1a and 3.4.1.1.1b. Repairs to stitch type 401 may be accomplished by use of stitch type 301. Both ends of all seams and stitching produced with the 401 stitch type when not caught in other seams or stitching shall have a 1/2 inch minimum chain extending beyond each end.

3.4.1.3 Automatic stitching. Automatic machines may be used to perform any of the required stitch patterns provided the requirements of the stitch pattern, stitches per inch, size and type of thread are met; and at least three tying, overlapping or backstitches are used to secure the ends of the stitching.

3.4.1.4 Thread ends. All thread ends that are visible on the finished item shall be trimmed to a length of not more than 1/4 inch.

3.4.1.5 Lubrication of thread. There shall be no lubrication of the thread by any means prior to or during sewing (see 4.4.1.2).

- * 3.4.2 Setting of grommets. Holes punched to receive the grommets shall be smaller than the outside diameter of the grommet barrel so that the barrel must be forced through the hole. The grommets shall be securely clinched without cutting the materials. All grommet washers shall be on the outside of the bag. Roll of the clinched grommet shall not contain more than three scores (splits) and no scores (splits) shall exceed 1/16 inch in length.

3.4.3 Setting of the metallic snap fastener. A hole shall be prepunched through the material before inserting the stud eyelet tube or the socket eyelet tube. The hole shall be smaller than the outside diameter of the applicable eyelet tube, so that the tube must be forced through the hole. Prepunched holes shall not be accomplished by using stud or socket eyelet tubes (as applicable). The fastener components shall be securely clinched without cutting the surrounding material. Roll of the clinched eyelet of the assembled fastener component shall not possess more than three scores (splits).

3.4.4 Fusing. Cut ends of nylon webbing shall be seared smooth.

3.4.5 Repairs. Repairs such as mends, darns, patches or splices are not permitted on the duffel bag.

- * 3.4.6 Location marks. Location marks shall not be drilled. Printed location marks shall not be more than 1/32 inch in width.

3.5 Marking. The identification marking shall conform to type IV, class 5 of DDD-L-20 in the location shown on the drawing. The "US" marking shall be applied in the size and location indicated on the drawing and shall conform to type IV, class 9 of DDD-L-20. Fastness of class 9 markings shall be as specified for class 5 labels.

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3.6 Workmanship. The duffel bags shall conform to the quality of product established by this document and the occurrence of defects shall not exceed the applicable acceptable quality levels.

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 this document where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

* 4.1.1 Responsibility for compliance. All items must meet all requirements of sections 3 and 5. The inspection set forth in this document shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirement in the document shall not relieve the contractor of the responsibility of assuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling in quality conformance does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to acceptance of defective material.

* 4.1.2 Responsibility for dimensional requirements. Unless otherwise specified in the contract or purchase order, the contractor is responsible for assuring that all specified dimensions have been met. When dimensions cannot be examined on the end item, inspection shall be made at any point, or at all points in the manufacturing process necessary to assure compliance with all dimensional requirements.

4.1.3 Certificates of compliance. When certificates of compliance are submitted, the Government reserves the right to inspect such items to determine the validity of the certification.

4.2 Classification of inspections. 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 4.4.3 and 4.4.4. The presence of any defect 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.

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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.

4.4.1.2 Certification. The contractor shall furnish a certificate of compliance for the requirement specified in 3.4.1.5.

4.4.2 In-process inspection. Inspection of sub-assemblies shall be made to ascertain that construction details which cannot be examined in the finished product are in accordance with specified requirements. The Government reserves the right to exclude from consideration for acceptance any material or service for which in-process inspection has indicated nonconformance.

- * 4.4.3 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 bags. The sample unit shall be one bag. The inspection level shall be II and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 2.5 for major defects and 15.0 for total (major and minor combined) defects.

TABLE I. End item visual defects

Examine	Defect	Classification	
		<u>Major</u>	<u>Minor</u>
Cloth	Hole, cut, or tear; any smash, weak place, broken or missing yarn, multiple floats, or open place, clearly visible	X	
	Shade bar		X
	Coated side of cloth tacky	X	
Webbing	Any hole, cut, tear, or smash	X	
	Not firmly and tightly woven, edges frayed or scalloped	X	
	Cut ends of nylon webbing not fused		X
Hardware	Broken or malformed, finish omitted, burrs, sharp edges, corroded areas	X	

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TABLE I. End item visual defects - Continued

Examine	Defect	Classification	
		<u>Major</u>	<u>Minor</u>
Finish of hardware components	Area of thin film or no film, i.e., bare metal exposed:		
	-on steel components	X	
	-on brass or aluminum components		X
	Enamel finish (where applicable) is not uniform and adherent, i.e., objectionable orange peel, wrinkles, drops, or streaks		X
Open seam	One inch or less		X
	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 two or more continuous skipped or runoff stitches occur. On double-stitched seams, a seam shall be considered open when either one or both sides of the seam are open.		
Raw edges (on edge required to be finished)	More than 1/2 inch securely caught in stitching		X
	NOTE: Raw edge not securely caught in stitching shall be classified as an open seam.		
Runoff.	(See open seam.)		
Seam and stitch type	Wrong seam or stitch type	X	
Stitching margins or gage of stitching	Not as specified		X

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TABLE I. End item visual defects - Continued

Examine	Defect	Classification	
		<u>Major</u>	<u>Minor</u>
Stitch tension	Loose tension, resulting in a loosely secured seam		X
	Tight tension (stitches break when normal strain is applied to seam or stitching)		X
	NOTE: Puckering is evidence of tight tension. When puckering is evident, seam shall be tested by exerting normal pull in length-wise direction of seam.		
Stitches per inch	One stitch less than minimum specified		X
	Two or more stitches less than minimum specified	X	
	One or more stitches in excess of maximum specified		X
	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 a minor defect classification - no defect.		
	b. Within a major defect classification - minor defect.		
Stitching ends	Ends of seams produced with 301 stitch type when not caught in other seams or stitching, backstitched less than 1/2 inch		X

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TABLE I. End item visual defects - Continued

Examine	Defect	Classification	
		<u>Major</u>	<u>Minor</u>
Stitching ends - continued	Ends of all seams produced with 401 stitch type when not caught in other seams or stitching, having chain extending less than 1/2 inch		X
	Ends of seams produced with 401 stitch type when not caught in other seams or stitching, not having chain extending beyond each end	X	
Thread breaks	Overstitched less than 1/2 inch on stitch types 301 or 401		X
	Overstitched less than 1/2 inch on W, W-W, box, or X-box stitching		X
NOTE: Thread break not overstitched shall be classified as open seam.			
Stitching indicated by "Z" on drawings	Chain portion of stitching shown on outside of bag	X	
Stitching rows	One or more required rows of stitching omitted	X	
W, W-W, box and X-box stitching	Dimensions less than specified by more than 1/8 inch		X
	Misplaced: -1/2 inch or more	X	
	-less than 1/2 inch		X
Components and assembly	Any component omitted, misplaced, or not as specified (unless other- wise classified herein)	X	
	Uncoated side of cloth not facing out	X	
	Any operation omitted or not as specified (unless otherwise classified herein)	X	

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TABLE I. End item visual defects - Continued

Examine	Defect	Classification	
		<u>Major</u>	<u>Minor</u>
Components and assembly - continued	Needle chews	X	
	Seams pleated or badly puckered		X
	Bottom of bag not set to body as specified, i.e., center of bottom not aligned with center of handle and carrying strap assembly		X
	Any mend, darn, patch, or splice	X	
	Any drill hole in fabric	X	
Hems	Less than specified width by more than 1/4 inch		X
	Twisted or pleated		X
Reinforcements	Not stitched to reinforced parts as specified		X
Handle	Any part of stitching attaching handle and handle reinforcements to body not stitched through body reinforcement	X	
	Edges of grip section overlapped; edges not folded or stitched as indicated on drawing		X
	Ends of carrying strap not finished as specified		X
Pocket and pocket flap	Not attached to body of bag as specified	X	
	Snap fastener components misplaced or not properly aligned failing to effect a smooth and secure closure		X
Closing strap	Ends of strap not finished as specified		X

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TABLE I. End item visual defects - Continued

Examine	Defect	Classification	
		Major	Minor
Shoulder strap assembly	Any part of stitching requiring attaching nylon webbing to body of bag not stitched through body and body reinforcement	X	
Shoulder adjustment strap	Not caught in between bottom and body	X	
Adapter	Improperly set or fails to function properly	X	
Grommets	Improperly set with washer on inside of bag		X
	Fails to accommodate keeper	X	
	Clinched excessively tight cutting fabric or insecurely clinched; i.e., grommet or washer becomes disengaged	X	
	Clinched loosely, allowing grommet to rotate in hole		X
	Roll of grommet contains more than three scores (splits)		X
	Not completely surrounded by grommet reinforcement patch		X
	Set off center of hem by more than 1/4 inch		X
	Any score (splits) exceeding 1/16 inch in length	X	
NOTE: The keeper shall be inserted through the hole of each grommet to determine whether the grommets provide clearance for the keeper.			
Keeper	Improperly set or located; fails to function or engage with snaphook	X	
Snaphook	Fails to function or to engage keeper	X	

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TABLE I. End item visual defects - Continued

Examine	Defect	Classification	
		Major	Minor
Snap fastener	Any fastener not functioning properly, i.e., fails to snap closed, provide a secure closure, or open freely	X	
	Improper or insecure clinching	X	
	Clinched excessively tight, cutting adjacent material	X	
	Clinched loosely, permitting components to rotate freely in the hole of the material	X	
	Incorrect style	X	
	Roll of clinched eyelet fastener assembly contains more than three scores (splits)		X
	NOTE: a. Incomplete roll of end of the socket eyelet or stud eyelet tube is evidence of improper and insecure clinching. Fasteners evidencing incomplete roll will separate in use.		
	b. The fasteners shall be snapped and unsnapped twice to determine whether parts of fastener separate freely and also effect a secure closure.		
Marking	Omitted, incorrect, illegible, misplaced, or size characters not as specified		X
Cleanness	Grease or oil stains, thread ends not trimmed to 1/4 inch maximum length		X

* 4.4.4 End item dimensional examination. Examination shall be made of the bag for conformance to the dimensions annotated with an asterisk on Drawings 2-3-299 and 2-3-301. Any dimension not within the specified tolerance shall be classified as a defect. The lot size shall be expressed in units of bags. The sample unit shall be one bag. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 2.5 for major defects and 6.5 for total (major and minor combined) defects.

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TABLE II. End item dimensional defects

Examine	Defect	Classification	
		<u>Major</u>	<u>Minor</u>
Overall dimensions	Smaller than nominal dimensions less applicable minus tolerance indicated on drawings, but not smaller than nominal dimensions less twice the applicable minus tolerance		X
	Smaller than nominal dimensions less twice the applicable minus tolerance indicated on drawings	X	
	Larger than nominal dimensions and applicable plus tolerance indicated on drawings		X
Component and location dimensions	Not within specified tolerance		X
Finished length of closing strap (Drawing 2-3-301)	Larger than nominal dimension and applicable plus tolerance		X
	Smaller than nominal dimension and applicable minus tolerance	X	

4.4.5 Packaging examination. The fully packaged end items shall be examined for the defects listed below. The lot size shall be expressed in units of shipping containers. The sample unit shall be one shipping container fully packaged. The inspection level shall be S-2 and the AQL, expressed in terms of defects per hundred units, shall be 2.5.

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

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Workmanship	Inadequate application of components, such as incomplete sealing or closure of flap, improper taping, loose strapping, or inadequate stapling Bulged or distorted container
Content	Number per container is more or less than required

4.4.6 Palletization examination. The fully packaged and palletized end items shall be examined for the defects listed below. The lot size shall be expressed in units of palletized unit loads. The sample unit shall be one palletized unit load, fully packaged. The inspection level shall be S-1 and the AQL, expressed in terms of defects per hundred units, shall be 6.5.

<u>Examine</u>	<u>Defect</u>
Finished dimensions	Length, width, or height exceeds specified maximum requirement
Palletization	Pallet pattern not as specified Interlocking of loads not as specified Load not bonded as specified
Weight	Exceeds maximum load limits
Marking	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application

5. PACKAGING

5.1 Preservation. Preservation shall be level A or Commercial as specified (see 6.2).

5.1.1 Level A. Each duffel bag, with the flap inside, the keeper laid flat, bottom flattened, and the snaphook positioned against the handle, shall be laid flat with the handle side and carrying straps facing up. The body seam on the underside shall be approximately centered. The shoulder straps with adapters shall be folded back and placed flat under the flattened bottom. The shoulder adjustment straps shall be laid flat fully extended. The flattened bottom shall be folded in approximately 11 inches. The top shall be folded down approximately 9 inches. The completely folded bag shall measure 23-1/2 inches by 14-3/4 inches.

5.1.2 Commercial. Duffel bags shall be preserved in accordance with ASTM D 3951.

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

- * 5.2.1 Level A packing. Twenty duffel bags, preserved as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC-L, grade V2s of PPP-B-636. The inside of each shipping container shall be fitted with a box liner conforming to type CF, class weather-resistant, variety DW, grade V15c of PPP-B-636. Duffel bags, folded as specified in 5.1.1, shall be packed flat, alternated end for end, twenty in depth within a shipping container. Inside dimensions of each shipping container shall approximate 23-1/2 inches in length, 15 inches in width, and 13 inches in depth. Approximate dimensions are furnished as a guide only. Each container shall have the contents completely covered on the top and bottom with a sheet of 30 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, except that the inspection shall be in accordance with 4.4.5. Shipping containers shall be arranged in unit loads in accordance with MIL-L-35078 for the type and class of load specified (see 6.2). When unit loads are strapped, strapping shall be limited to nonmetallic strapping, except for type II, class F loads.

- * 5.2.2 Level B packing. Twenty duffel bags, preserved as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC-L, type CF (variety SW) or SF, class domestic, grade 275 of PPP-B-636. The inside of each shipping container shall be fitted with a box liner conforming to type CF, class domestic, variety DW, grade 275 of PPP-B-636. Duffel bags, folded as specified in 5.1.1, shall be packed flat, alternated end for end, twenty in depth, within a shipping container. Inside dimensions of each shipping container shall approximate 23-1/2 inches in length, 15 inches in width, and 13 inches in depth. Approximate dimensions are furnished as a guide only. Each container shall have the contents completely covered on top and bottom with a sheet of 30 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, except that the inspection shall be in accordance with 4.4.5.

5.2.2.1 Weather-resistant containers. When specified (see 6.2), the shipping container shall be a 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 PPP-B-636, except that the inspection shall be in accordance with 4.4.5.

5.2.3 Commercial packing. Duffel bags, preserved as specified in 5.1, shall be packed in accordance with ASTM D 3951.

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* 5.3 Palletization. When specified (see 6.2), duffel bags, packed as specified in 5.2.2 and 5.2.3, shall be palletized on a 4-way entry pallet in accordance with load type Ia of MIL-STD-147. Pallet type shall be type I (4-way entry), type IV or type V in accordance with MIL-STD-147. Pallets shall be fabricated from wood groups I, II, III, or IV of MIL-STD-731. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding means K and L or film bonding means O or P. Pallet pattern shall be number 3 in accordance with the appendix of MIL-STD-147. Interlocking of loads shall be effected by reversing the pattern of each course.

5.4 Marking. In addition to any special marking required by the contract or purchase order, shipping containers and palletized unit loads shall be marked in accordance with MIL-STD-129 or ASTM D 3951, as applicable.

6. NOTES

6.1 Intended use. The duffel bag is intended for use by members of the Department of Defense. The bag is designed to hold individual clothing and equipment allowance. The bag is closed by inserting a keeper through the grommets located around the top, and can be securely locked with a padlock if desired. A handle and strap arrangement are attached to provide means for either hand or shoulder carrying. A pocket is attached to accommodate shipping documents.

6.2 Ordering data. Acquisition documents should specify the following:

- a. Title, number, and date of this document.
- b. When a first article is required (see 3.2, 4.3, and 6.4).
- c. Selection of applicable levels of preservation and packing (see 5.1 and 5.2).
- d. Type and class of unit load required (see 5.2.1).
- e. When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).
- f. When palletization is required (see 5.3).

6.3 Standard sample. For access to samples, address the contracting activity issuing the invitation for bids.

6.4 First article. When a first article is required, it shall be inspected and approved under the appropriate provisions of FAR 52.209. The first article should be a preproduction sample. The contracting officer should specify the appropriate type of first article and the number of units to be furnished. The contracting officer should include specific instructions in all acquisition instruments regarding arrangements for selection, inspection, and approval of the first article.

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6.5 Recycled material. It is encouraged that recycled material be used when practical as long as it meets the requirements of this document (see 3.3).

* 6.6 Subject term (key word) listing.

Bag, duffel
Equipage

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, as written, irrespective of the marginal notations and relationship to the last previous issue.

Custodians:

Army - GL
Navy - NU
Air Force - 99

Preparing activity:

Army - GL
Project No. 8465-0984

Review activities:

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

User activity:

Air Force - 45

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

1. DOCUMENT NUMBER

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2. DOCUMENT TITLE

Bag, Duffel

3a. NAME OF SUBMITTING ORGANIZATION

4. TYPE OF ORGANIZATION (Mark one)

☐

VENDOR

☐

USER

☐

MANUFACTURER

☐

OTHER (Specify): _____

b. ADDRESS (Street, City, State, ZIP Code)

5. PROBLEM AREAS

a. Paragraph Number and Wording:

b. Recommended Wording:

c. Reason/Rationale for Recommendation:

6. REMARKS

7a. NAME OF SUBMITTER (Last, First, MI) - Optional

b. WORK TELEPHONE NUMBER (Include Area Code) - Optional

c. MAILING ADDRESS (Street, City, State, ZIP Code) - Optional

8. DATE OF SUBMISSION (YYMMDD)