

MIL-C-1690D

10 December 1970

SUPERSEDING

MIL-C-1690C

7 June 1966

MILITARY SPECIFICATION

CASE, SHOTGUN AMMUNITION, COTTON DUCK

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

1. SCOPE

1.1 This specification covers one type and size shotgun ammunition case, made of cotton duck, with compartments for 12 shotgun shells. Loops are provided for attachment to a belt.

* 2. APPLICABLE DOCUMENTS

2.1 The following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of this specification to the extent specified herein.

SPECIFICATIONS

FEDERAL

V-T-285	- Thread, Polyester
UU-P-268	- Paper, Kraft, Untreated, Wrapping
CCC-C-419	- Cloth, Duck, Cotton, Unbleached, Plied-Yarns Army and Numbered
CCC-D-950	- Dyeing and Aftertreating Processes for Cotton Cloths
DDD-L-20	- Label; for Clothing, Equipage, and Tentage, (General Use)
PPP-B-636	- Box, Fiberboard

MILITARY

MIL-W-530	- Webbing, Textile, Cotton, General Purpose, Natural or in Colors
MIL-F-10884	- Fasteners, Snap

FSC 8465

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- MIL-E-20652 - Eyelets, Metallic, with Washers
- MIL-T-43566 - Tape, Textile, Cotton, General Purpose, Natural or in Colors

STANDARDS

FEDERAL

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

MILITARY

- MIL-STD-105 - Sampling Procedures and Tables for Inspections by Attributes
- MIL-STD-129 - Marking for Shipment and Storage
- MIL-STD-147 - Palletized and Containerized Unit Loads 40" x 48" Pallets, Skids, Runners, or Pallet-Type Base
- MS 27977 - Fasteners, Snap, Style 1 (Large Curtain Type)
- MS 63033 - Eyelets, Metallic, Rolled Deep Flange, with Washer, Style A

DRAWINGS

ARMY NATICK LABORATORIES

- 2-2-3 - Case, Shotgun Ammunition, Cotton Duck, O.D., 12 Compartment; Assembly, Details and Sections

(Figure 1 is a miniature reproduction of referenced drawing and is attached for information only.)

(Copies of specifications, standards, drawings, and other publications required by suppliers in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

- * 2.2 Other publications.- The following documents form a part of this specification to the extent specified herein. Unless otherwise indicated, the issue in effect on date of invitation for bids or request for proposal shall apply:

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NATIONAL MOTOR FREIGHT TRAFFIC ASSOCIATION, INC.

National Motor Freight Classification

(Application for copies should be addressed to American Trucking Associations, Attn: Tariff Order Section, 1616 P Street, N.W., Washington, D.C. 20036.)

UNIFORM CLASSIFICATION COMMITTEE

Uniform Freight Classification

(Application for copies should be addressed to the Uniform Classification Committee, Room 202 Union Station, 516 W. Jackson Blvd., Chicago, Illinois 60606.)

3. REQUIREMENTS

* 3.1 Samples.-

* 3.1.1 Guide samples.- Guide samples of the end item, when furnished, are solely for guidance and information to the supplier (see 6.3). Variation from this specification may appear in the sample, in which case this specification shall govern.

* 3.1.2 First article.- This specification contains provisions for first article inspection and approval (see 4.2, 6.2 and 6.4).

3.2 Materials.-

3.2.1 Cloth, duck, cotton.- The cotton duck shall be, before finishing, No. 8, hard texture conforming to type I of CCC-C-419.

3.2.1.1 Color and treatment.- The color of the cloth shall be Olive Drab 7 and shall match the standard shade sample (see 6.3). The finished cloth shall conform to type I, class B of CCC-D-950.

3.2.2 Webbing, cotton.- The webbing shall be dyed Olive Drab 7 to match the standard shade sample (see 6.3) and shall conform to type IIb, class 4, 1 inch width of MIL-W-530.

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- * 3.2.3 Tape, cotton.-- The tape shall be dyed Olive Drab 7 to match the standard shade sample (see 6.3) and shall conform to type I, class 4, 1 inch and 3/4 inch width of MIL-T-43566.
- 3.2.4 Thread, polyester.-- The thread shall conform to type I, class 1, subclass B, of V-T-285. Thread size for all stitching, except binding and bartacking, shall be FF. For binding and bartacking, size E shall be used.
 - 3.2.4.1 Color.-- The thread shall match Olive Drab S-1 (C.A. 66022) and shall show fastness to chlorine bleaching equal to or better than the standard sample. When no standard sample is available, the thread shall show good fastness to chlorine bleaching.
- 3.2.5 Fasteners, snap.-- The snap fasteners shall conform to style 1, finish 2, of MIL-F-10884 and to Part Nos. MS-27977 - 1B, - 3B, - 8B, and - 10B of MS-27977.
- * 3.2.6 Eyelets, metallic, with washers.-- The eyelets with washers shall conform to style A of MIL-E-20652 and dash numbers 4094 and 4096 respectively of MS 63033.
- * 3.3 Construction.-- The construction shall conform in all respects to the drawing listed in 2.1 and be as specified herein.
 - 3.3.1 Stitches, seams, and stitchings.--
 - 3.3.1.1 Type of stitching.-- All stitches, seams and stitching, except bartacking, shall be performed using stitch type 301 with 6 to 8 stitches per inch and shall conform to FED-STD-751.
 - * 3.3.1.2 Automatic stitching.-- Any of the stitching operations cited in this specification may be performed with an automatic machine provided the requirements for stitch pattern, stitches per inch, size and types of thread are met; and at least three tying, overlapping or backstitches are used to secure the ends of stitching.
 - * 3.3.1.3 There shall be no lubrication of the thread prior to or during sewing (see 4.3.1.1).
 - 3.3.1.4 Type 301 stitching.-- Thread breaks in stitching shall be overstitched not less than 1 inch back of the break. Ends of stitching shall be backstitched or backtacked not less than 1/2 inch except where ends are caught in other seams and stitching. Thread tension shall be maintained so that there will be no loose or tight stitching and the lock will be imbedded in the materials sewed.

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3.3.1.5 Bartacking.- Bartacking shall be 1 inch \pm 1/16 inch long, 1/16 inch maximum wide and shall contain not less than 42 stitches. Bartacking shall be free of thread breaks and loose stitching.

3.3.1.6 All thread ends shall be trimmed.

3.3.2 Setting of snap fasteners.- The hole for the male part of the fastener shall be formed when the fastener is driven into the material. The hole punched before attaching the female part of the fastener shall be no larger than that made by a standard No. 10 round drive punch (5/16 inch diameter hole). The fasteners shall be securely clinched.

- * 3.3.3 Setting of eyelet.- Holes punched to receive the eyelets shall be smaller than the outside diameter of the eyelet barrel. The eyelets shall be securely clinched without cutting the material, and shall be clinched without splitting.
- * 3.4 Marking.- The identification marking shall be applied in the location shown on the drawing and shall conform to type IV, class 5 of DDD-L-20. The letters "US" shall be applied in the size characters and in the location shown on the drawing and shall conform to type IV, class 9 of DDD-L-20. Fastness of the class 9 marking shall be as specified for class 5 marking.
- * 3.5 Workmanship.- The finished case shall conform to the quality and grade of product established by this specification. 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 supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the supplier 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 the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.
- * 4.2 First article inspection.- When a preproduction sample is required (see 3.1.2), it shall be examined for defects listed in 4.3.3.1, 4.3.3.2, and 4.3.3.3.

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- * 4.3 Inspection.- Sampling for inspection shall be performed in accordance with MIL-STD-105, except where otherwise indicated hereinafter.

4.3.1 Component and material inspection.- In accordance with 4.1 above, components and materials shall be inspected and tested in accordance with all requirements of referenced specifications, drawings and standards unless otherwise excluded, amended, modified or qualified in this specification or applicable purchase documents.

- * 4.3.1.1 The supplier shall furnish a certificate of compliance for the requirement specified in 3.3.1.3.

4.3.2 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 requirements indicated on the drawing. Construction of sub-assemblies not in accordance with specified requirements shall be considered not acceptable.

- * 4.3.3 End item inspection.- The defects found during examination shall be classified in accordance with 4.3.3.1, 4.3.3.2, and 4.3.3.3. The sample unit for these examinations shall be one completely fabricated case. The inspection level and acceptable quality level shall be in accordance with 4.3.3.4.

- * 4.3.3.1 Visual examination.-

Examine	Defect	Classification	
		Major	Minor A B
Cloth	Any hole, cut or tear.	X	
	Any smash, weak place, broken or missing yarn, multiple floats, or open place, clearly visible at normal inspection distance (approximately 3 feet).	X	
	Shade bar, or fine or coarse filling bar.		X
Webbing and tape	Frayed or scalloped edges, not firmly or tightly woven.	X	

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Examine	Defect	Classification	
		Major	Minor A B
Hardware	Broken or malformed, failing to serve intended purpose, burrs, sharp edges, or corroded areas. Finish partly or totally omitted.	X	X
Seams and stitching:			
Open seam	1/2 inch or less. More than 1/2 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 stitches or runoffs occur.		
Runoff (see open seam)			
Raw edge (except on inside of case)	More than 1/2 inch when securely caught in stitching.		X
	NOTE: Raw edges not securely caught in stitching shall be classified as open seams.		
Bartacks (when applicable)	Not as specified.		X
Seam and stitch type	Wrong seam or stitch type.	X	
Stitch tension	Loose, resulting in loose bobbin or top thread; tight, resulting in tightness of fabric on seams.		X

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Examine	Defect	Classification	
		Major	Minor A B
Seams and stitching: (cont'd)			
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 operator's speeding up the machine and pulling the fabric in order to sew over heavy places, or in turning corners, shall be classified as follows:			
(a) Within the minor B defect - no defect.			
(b) Within the minor A defect - minor B defect.			
Stitching margin; stitching gage	Not as specified.		X
Stitching ends (not turned under in a hem or held down by other stitching)	Not backstitched or secured.	X	
	Backstitched less than 1/2 inch or not secured as specified (3 tying, overlapping or backstitches, when stitching is done on automatic machines).		X
Thread breaks	Overstitched less than 1/2 inch beyond each end of break.		X
NOTE: Thread breaks not overstitched shall be classified as open seams.			

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Examine	Defect	Classification	
		Major	Minor A B
Cleanness	Grease or oil stains clearly noticeable; thread ends not trimmed through-out.		X
Marking (identification and letters "U.S.")	Omitted, misplaced, illegible, incorrect, or size of characters not as specified.		X
Components and assembly	Any component or required operation omitted (unless otherwise classified herein).	X	
	Needle chew.	X	
	Mend, darn or patch.	X	
Binding	Improperly or loosely applied; badly puckered.		X
	Ends of front binding not caught in side closing seams.		X
Flap	Corners of flap irregularly shaped, or radius not uniform on both corners of flap.		X
Snap fasteners (two required)	Male or female parts misplaced, causing distortion of flap when closed.		X
	Either fastener fails to effect a smooth and secure closure.	X	
	Clinched excessively tight, cutting surrounding cloth.	X	
	Loosely clinched, permitting male part to rotate in hole in cloth.		X
Eyelet and washer	Not as specified.	X	
	Reversed, i.e., washer on outside of case.		X
	Insecurely clinched to a degree where eyelet may become detached from material; clinched excessively tight, cutting surrounding cloth.	X	
	Eyelet split, affecting serviceability.		X

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Examine	Defect	Classification	
		Major	Minor A B
Retainers (one front, one back)	Less than specified number of compartments in either retainer.	X	
	Ends of back retainer not stitched to body prior to closing body seams.		X
	Turned under ends of front retainer not caught in both rows of stitching attaching retainer to body.		X
Belt loops	Turned under portion of ends not caught in all required stitching.		X

4.3.3.2 Dimensional examination.-

Examine	Defect	Classification	
		Major	Minor
Overall dimensions	Smaller than nominal dimensions and applicable minus tolerance indicated on drawing, but not smaller than nominal dimensions and twice the applicable minus tolerance.		X
	Smaller than nominal dimensions and twice the applicable minus tolerance indicated on drawing.	X	
	Larger than nominal dimensions and applicable plus tolerance indicated on drawing.		X
Component and location dimensions:			
Belt loops	Under or over dimensions indicated on drawing by 1/4 inch or more.		X
	Set out of horizontal alignment by 1/4 inch or more, or not parallel with each other.		X
Front and back retainers	Under or over specified spacing by more than 1/16 inch.		X
	Stitching gauge not within specified tolerance.		X

* 4.3.3.3 Fit examination.-

<u>Examine</u>	<u>Defect</u>
Fit of gauges in case (Gauges are to simulate the size of 12 gauge shotgun shells)	Retainers within case or case too small, i.e., gauges fail to fit properly in retainers and case. Case body or flap too short, causing inability to securely close the snap fastener.

NOTE: Fit examination shall be performed with 12 gauges fabricated from hard wood. Each gauge shall be cylindrical in shape measuring $51/64 \pm 1/64$ inches in diameter and $2-13/32 \pm 1/32$ inches long. A gauge shall be fully inserted in each of the retainer loops without effort other than that necessary to overcome friction between the gauge and retainer loop. The flap snap fasteners shall be securely closed.

* 4.3.3.4 Inspection level and acceptable quality level (AQL).- The inspection levels and AQLs, expressed in defects per hundred units, shall be as follows:

<u>Examination</u>	<u>Inspection level</u>	<u>AQL</u>
For defects applicable to 4.3.3.1	II	2.5 major defects. 6.5 major and minor A defects combined. 15.0 total (major, minor A and B defects combined).
For defects applicable to 4.3.3.2	S-3	4.0 major defects. 10.0 total (major and minor defects combined).
For defects applicable to 4.3.3.3, fit examination	S-3	0.65 one class

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- * 4.3.4 Examination of preparation for delivery requirements.— An examination shall be made to determine that packaging, packing, and marking comply with the section 5 requirements. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully prepared for delivery except that it shall not be palletized and need not be sealed. Shipping containers fully prepared for delivery that have not been palletized shall be examined for defects of closure. The lot size shall be the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 and the AQL shall be 2.5 defects per hundred units.

Examine	Defect
Marking (exterior and interior)	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application.
Materials	Any component missing. Any component damaged.
Workmanship	Inadequate application of components, such as incomplete closure of container flaps, loose strapping or banding, improper taping, inadequate stapling. Bulged or distorted container.
Content	Number of bundles per container is more or less than required. Number of cases per bundle is more or less than required. <u>1/</u>

1/ For this defect, one bundle from each container in the sample shall be examined.

- * 4.3.5 Examination for palletization.— An examination shall be made to determine that palletization complies with the section 5 requirements. Defects shall be scored in accordance with the list below. The sample unit shall be one palletized unit load fully prepared for delivery. The lot size shall be the number of palletized unit loads in the end item inspection lot. The inspection level shall be S-1 and the AQL shall be 6.5 defects per hundred units.

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

5. PREPARATION FOR DELIVERY

5.1 Packaging.- Packaging shall be level A or C as specified (see 6.2).

5.1.1 Level A.- Each case shall have the flap snaps fastened. Ten cases shall be evenly stacked one on top of another to form a bundle. The cases shall be bundled with the "U.S." facing up and the flap alternated except that the top case shall be placed with the "U.S." facing down. Each bundle shall then be securely crosstied with cotton tape or twine.

5.1.2 Level C.- Cases shall be packaged to afford adequate protection against physical damage during shipment from the supply source to the first receiving activity. The supplier may use his standard practice when it meets this requirement.

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

- * 5.2.1 Level A.- One hundred and twenty cases, packaged as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC, grade V2s of PPP-B-636. Level A packages shall be packed flat, two in length, three in width and two in depth within a shipping container. Inside dimensions of each container shall approximate 14-1/2 inches in length, 12-3/4 inches in width, and 12-3/4 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 grade B of UU-P-268. Each shipping container shall be closed, waterproofed and reinforced in accordance with the appendix of the container specification.

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5.2.2 Level B.- One hundred and twenty cases, packaged as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC, type CF (variety SW) or SF, class domestic, grade 275 of PPP-B-636. Level A packages shall be packed flat, two in length, three in width and two in depth within a shipping container. Inside dimensions of each container shall approximate 14-1/2 inches in length, 12-3/4 inches in width, and 12-3/4 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 grade B of UU-P-268. Each shipping container shall be closed in accordance with method II as specified in the appendix of the container specification.

- * 5.2.2.1 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 the appendix of the container specification.

- * 5.2.3 Level C.- Cases, packaged as specified in 5.1, shall be packed in a manner to insure carrier acceptance and safe delivery at destination at the lowest transportation rate for such supplies. Containers shall be in accordance with Uniform Freight Classification Rules or National Motor Freight Classification Rules, as applicable.

- * 5.3 Palletization.- Unless otherwise specified (see 6.2), cases packed as specified in 5.2, shall be palletized in accordance with load type I of MIL-STD-147. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding means K and L. Pallet patterns shall be in accordance with the appendix of MIL-STD-147. Interlocking of loads shall be effected by reversing the pattern of each course. If the container is of a size which does not conform to any of the patterns specified in MIL-STD-147, the pallet pattern used shall first be approved by the contracting officer.

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

6. NOTES

6.1 Intended use.- The ammunition case is intended to carry ammunition for riot shotguns. The capacity of the pouch is twelve shotgun shells.

- * 6.2 Ordering data.- Procurement documents should specify the following:

- (a) Title, number and date of this specification.
- (b) First article (see 3.1.2, 4.2, and 6.4).

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- (c) Selection of applicable levels of packaging and packing (see 5.1 and 5.2).
- (d) When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).
- (e) When palletization is not required (see 5.3).

6.3 For access to samples, address the procuring office issuing the invitation for bids.

- * 6.4 First article.- The item covered by this specification requires first article inspection and approval under the appropriate provisions of paragraph 7-104.55 of the Armed Services Procurement Regulations. The first article should be a preproduction sample. The first article should consist of one case. The contracting officer should include specific instructions in all procurement instruments, regarding arrangements for examination, test and approval of the first article.

6.5 Marginal identification.- The margins of this specification 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 suppliers are cautioned to evaluate the requirements of this document based on the entire content, irrespective of the marginal notations and relationship to the last previous issue.

Custodians:

Army - GL
Air Force - 82

Preparing activity:

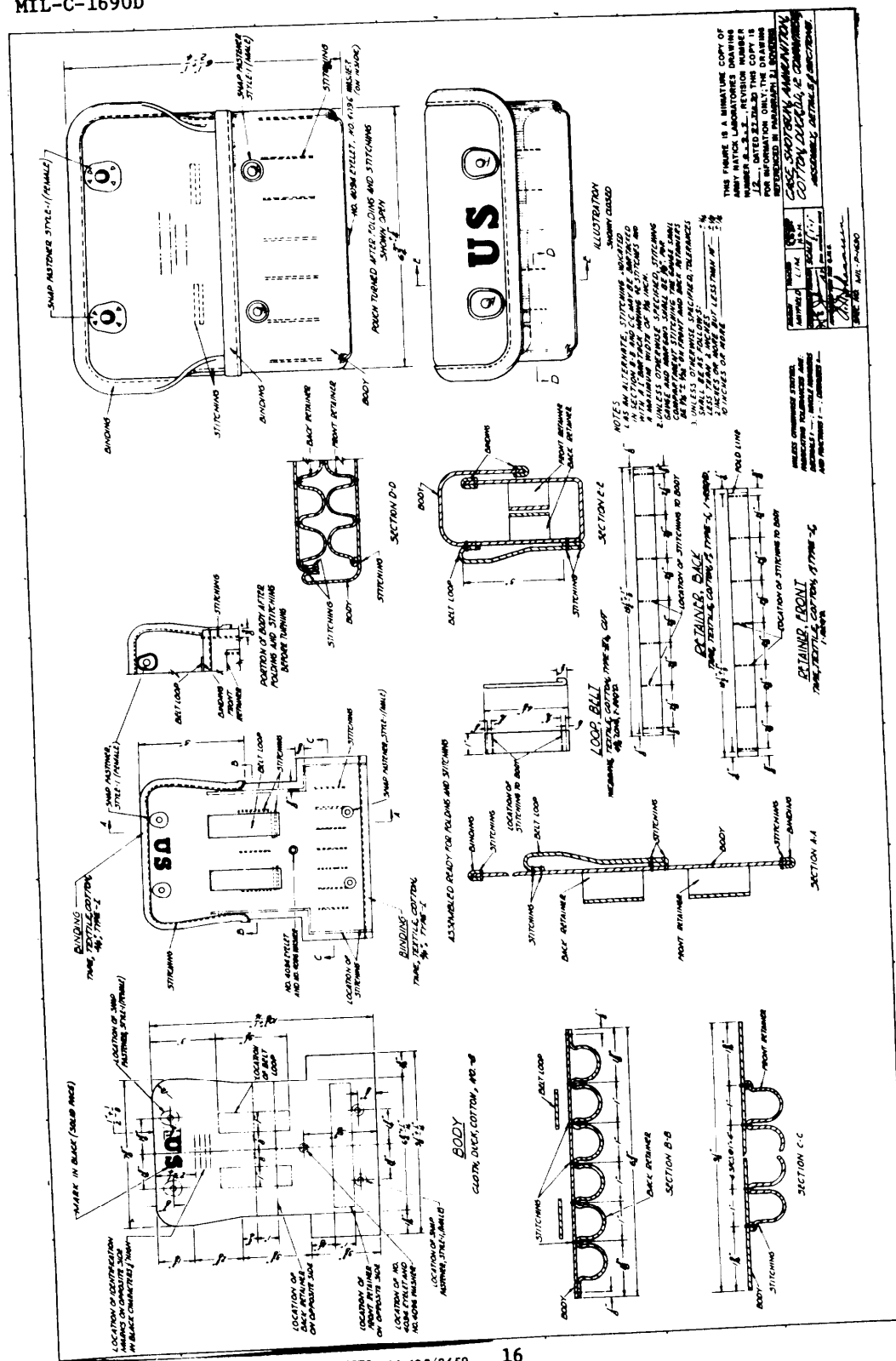
Army - GL

Project No. 8465-0407

User activity:

Army - MU

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SPECIFICATION ANALYSIS SHEET		Form Approved Budget Bureau No. 22-R255
<p>INSTRUCTIONS: This sheet is to be filled out by personnel, either Government or contractor, involved in the use of the specification in procurement of products for ultimate use by the Department of Defense. This sheet is provided for obtaining information on the use of this specification which will insure that suitable products can be procured with a minimum amount of delay and at the least cost. Comments and the return of this form will be appreciated. Fold on lines on reverse side, staple in corner, and send to preparing activity. Comments and suggestions submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or serve to amend contractual requirements.</p>		
SPECIFICATION CASE, SHOTGUN AMMUNITION, COTTON DUCK MIL-C-1690D		
ORGANIZATION		
CITY AND STATE		CONTRACT NUMBER
MATERIAL PROCURED UNDER A <input type="checkbox"/> DIRECT GOVERNMENT CONTRACT <input type="checkbox"/> SUBCONTRACT		
1. HAS ANY PART OF THE SPECIFICATION CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE? A. GIVE PARAGRAPH NUMBER AND WORDING.		
B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES		
2. COMMENTS ON ANY SPECIFICATION REQUIREMENT CONSIDERED TOO RIGID		
3. IS THE SPECIFICATION RESTRICTIVE? <input type="checkbox"/> YES <input type="checkbox"/> NO (If "yes", in what way?)		
4. REMARKS (Attach any pertinent data which may be of use in improving this specification. If there are additional papers, attach to form and place both in an envelope addressed to preparing activity)		
SUBMITTED BY (Printed or typed name and activity - Optional)		DATE

DD FORM 1426
1 JAN 66

REPLACES EDITION OF 1 OCT 64 WHICH MAY BE USED.

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