

MIL-C-43086C
28 September 1983
SUPERSEDING
MIL-C-43086B
18 March 1971

MILITARY SPECIFICATION
CLOTH, COATED, NYLON, VINYL COATED
(FOR AIR SUPPORTED SHELTERS)

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

1. SCOPE

1.1 Scope. This document covers the requirements for vinyl coated cloth to be used in the fabrication of air supported shelters (see 6.1).

2. APPLICABLE DOCUMENTS

- * 2.1 Government documents. Unless otherwise specified, the following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of this document to the extent specified herein.

SPECIFICATIONS

FEDERAL

PPP-P-1136 - Packaging of Coated (Plastic; Rubber) and Laminated Fabrics

MILITARY

MIL-L-6082 - Lubricating Oil; Aircraft Reciprocating Engine (Piston)

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

FSC 8305

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STANDARDS

FEDERAL

- FED-STD-191 - Textile Test Methods
- FED-STD-406 - Plastics; Methods of Testing
- FED-STD-595 - Colors
- FED-STD-601 - Rubber; Sampling and Testing

MILITARY

- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
- MIL-STD-1487 - Glossary of Cloth Coating Imperfections

(Copies of documents required by manufacturers in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting officer.)

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

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

D 471 - Rubber Property - Effect of Liquids

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.)

(Technical society and technical association documents are generally available for reference from libraries. They are also distributed among technical groups and using Federal agencies.)

- * 2.3 Order of precedence. In the event of a conflict between the text of this document and the references cited herein, the text of this document shall take precedence.

- * 3. REQUIREMENTS

3.1 Samples.

3.1.1 Laboratory report approval. Unless otherwise specified (see 6.2), at the time of submission of a bid, the bidder shall submit to the contracting officer a certified copy of a recent laboratory report covering material which he proposes to deliver. Unless otherwise specified by the contracting officer, the bidder shall

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certify that the coated cloth was manufactured in a plant where the coating will be performed if a contract is awarded. This laboratory report shall contain test data which demonstrates that the finished product which the bidder proposes to deliver has been tested in conformance with and found to comply with the requirements of this document. Any one of the following types of reports will be satisfactory from the standpoint of this requirement:

- (a) An independent or commercial laboratory report.
- (b) The prospective contractor's own laboratory report.
- (c) A governmental laboratory report from a contract within 6 months of date of submission of bid.

The purpose of the above requirement is to assist the Government to determine the capability of bidders to manufacture a coated cloth meeting all the requirements of this document. The submission of an acceptable report under this requirement shall not be construed as relieving a contractor from subsequently meeting all requirements of the document on all deliveries.

- * 3.1.2 First article. When specified, a sample shall be subjected to first article inspection (see 4.3, 6.2 and 6.3).

3.2 Materials.

3.2.1 Base cloth. The base cloth shall be either of the two types specified in 3.2.1.1 and 3.2.1.2 and shall conform to the requirements in table I. The fiber shall be continuous multifilament bright high tenacity nylon. Testing shall be as specified in 4.4.1.

3.2.1.1 Type I. The type I base cloth shall be a 2-2 basket weave. The yarns for both warp and filling shall be 840 + 20 denier.

- * 3.2.1.2 Type II. The type II base cloth shall be a modified oxford weave in which two ends weaving as one, alternate across the warp with two ends weaving plain. The warp yarns shall be 840 + 20 denier and the filling yarns shall be 1680 + 80 denier.

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TABLE I. Physical requirements of base cloths

Characteristic	Requirement	
	Min	Max
Weight, oz/sq yd	5.5	6.0
Yarns per inch		
Warp (types I and II)	24	-
Filling (type I)	26	-
Filling (type II)	13	-
Breaking strength, lbs.		
Warp	275	-
Filling	275	-
pH	5.0	8.5

* 3.2.2 Coating compound. The coating compound shall be suitable compounded virgin vinyl chloride or vinyl chloride - acetate copolymer plasticized with phthalate or phosphate ester plasticizers exclusively and pigmented to meet the requirements stated herein (see 4.4.1).

* 3.3 Coated cloth. The base cloth shall be coated on both sides with the coating compound specified in 3.2.2. The face of the cloth shall be coated with 8.0 to 9.0 ounces per square yard of the coating, and the back shall be coated with 5.0 to 6.0 ounces per square yard of the coating (see 4.4.1). The finished coated cloth shall be white in color to match color 17855 of FED-STD-595 and shall conform to all the requirements of table II.

* TABLE II. Physical requirements of coated cloth

Characteristic	Minimum	Maximum
Weight, oz/sq yd	18.5	21.0
Breaking strength, pounds:		
Initial:		
Warp	300	
Filling	300	
After accelerated weathering:		
Warp	240	
Filling	240	
Elongation at 20 pounds load, percent:		
Warp		1.5
Filling		3.5

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* TABLE II. Physical requirements of coated cloth (cont'd)

Characteristic	Minimum	Maximum
Elongation at breaking point, percent:		
Warp		35.0
Filling		45.0
Tearing strength, pounds:		
Warp	100	
Filling	100	
Adhesion, pounds per 2-inch width:		
Dry	10.0	
Wet	8.0	
Blocking, scale rating		(3)
Hydrostatic resistance, p.s.i.	300	
Flame resistance		
After flame, seconds		5

- * 3.3.1 Resistance to cold crack at -10°F. The coated cloth shall show no cracking, flaking or separation of coating from the cloth when exposed at -10°F, when tested as specified in 4.4.3.
- * 3.3.2 Oil resistance. The coated cloth shall show no evidence of seepage of oil through the material when tested as specified in 4.4.3.
- * 3.3.3 Resistance to aromatic hydrocarbons. The coated cloth shall not crack when tested as specified in 4.4.3.
- * 3.3.4 Cracking resistance after accelerated weathering. After weatherometer exposure, the coated cloth shall show no cracking or crazing when folded sharply on itself. Testing shall be as specified in 4.4.3.
- * 3.3.5 Color change after accelerated weathering. The color of the coated cloth shall not be changed by exposure to accelerated weathering when tested as specified in 4.4.3.

3.4 Width (applicable only when purchased by the government). The width shall be as specified in the contract or purchase order (see 6.2), and shall be the minimum width.

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* 3.5 Length and put-up (applicable only when purchased by the government). The coated cloth shall be put-up in rolls as specified in PPP-P-1136 in lengths of 60 to 75 yards. No individual roll shall contain more than three pieces and no individual piece shall be less than 20 yards in length. The ends of the pieces shall be overlapped and not joined by a seam.

* 3.5.1 Marking. The heavily coated side of the cloth (face) shall be clearly marked at both the beginning and the end of the roll.

* 3.6 Odor. The coated cloth shall be free from any objectionable odor. Characteristic odor of coating is not considered objectionable.

3.7 Workmanship. The finished coated cloth shall conform to the quality of product established by this document. 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 the document where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.1.1 Certificate of compliance. Where certificates of compliance are submitted, the Government reserves the right to check test such items to determine the validity of the certification.

* 4.2 Classification of inspection. 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 4.4.2.1 and tested for the characteristics specified in table V. The presence of any defect or failure of any test 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. In addition, testing shall be performed for the characteristics specified in table III. All test reports shall contain the individual values used in expressing the final results. The sample unit for the base cloth shall be 1 yard full width. The lot size shall be expressed in units of 1 yard and the sample size shall be as specified below. The lot shall be unacceptable if one or more sample units fail to meet any requirement specified.

<u>Lot size (yards)</u>	<u>Sample size (number of sample units)</u>
800 or less	2
801 up to and including 22,000	3
22,001 and over	5

* TABLE III. Component tests

<u>Characteristic</u>	<u>Requirement reference</u>	<u>FED-STD-191 test method</u>
Base cloth		
Material identification	3.2.1	<u>1/</u>
Weave	3.2.1	Visual
Yarn denier (warp and filling)	3.2.1	4021
Fiber identification	3.2.1	<u>1/</u>
Weight, oz/sq yd	3.2.1	5041
Yarns per inch	3.2.1	5050
Breaking strength	3.2.2	5100
pH	3.2.1	2811
Coating compound:		
Composition	3.2.2	<u>2/</u>
Distribution	3.3	<u>1/</u>

1/ Unless otherwise specified, a certificate of compliance shall be submitted and will be acceptable for the stated requirement.

2/ A certificate of compliance shall be furnished with each shipment or lot specifying that the coating formulation is compounded as specified.

4.4.2 End item examination.

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- * 4.4.2.1 Yard-by-yard examination. The required yardage of each roll in the sample shall be examined on one side only; however, the sample shall be so alternated that on one out of every three pieces in the sample the required yardage is examined on the more lightly coated side. Visual defects shall be as listed below. The same yardage shall be given a through-light inspection for pinholes only. The through-lighting inspection shall be performed in accordance with MIL-STD-1487. The defects found shall be counted regardless of their proximity to each other, except where two or more defects represent a single local condition of the cloth, in which case only the more serious defect shall be counted. A continuous defect shall be counted as one defect for each warpwise yard or fraction thereof in which it occurs. The lot size shall be expressed in units of yards. The sample unit shall be 1 linear yard. 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 6.5 for total (major and minor combined) defects. The number of rolls from which the sample is to be selected shall be in accordance with table IV. An approximately equal number of yards shall be examined in each roll sampled.

Defect	Classification	
	Major	Minor
Any cut, hole, tear, scratch, or abrasion mark that results in baring the base cloth.	X	
Any pinhole.	X	
Any surface scratch or abrasion mark that does not result in baring the base cloth.		X
Any uncoated area.	X	
Any pit, blister, tunnel, or delamination of coating.	X	
Any lump or heavily coated area.		X
Any crease or wrinkle resulting in doubling or adhesion of surfaces that cannot be corrected by manual pressure.	X	
Uneven coating, thin area where coating is missing or noticeably thinner.	X	
Coating not heavier on face side.	X	
Any separation of coating from base cloth.	X	
Any light area or window (resulting from improper distribution of pigment).		X
Any foreign matter, which on removal leaves an uncoated or poorly coated area.	X	
Any foreign matter resulting in unsightly appearance.		X
Edges not straight and uniform.		X
Edges heavily beaded cannot be rolled in uniform layers.		X
Cloth edges rolled, curled, folded, doubled or scalloped precluding a flat lay of the cloth.	X	

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Defect	Classification	
	Major	Minor
Baggy, wavy or puckered, will not stay flat upon normal pressure.		X
Heavier coated side (face) not identified on each end of roll.	X	
Any spot, stain, or streak more than 1 inch in combined directions. <u>1/</u>	X	
Width (overall) less than minimum specified.	X	
Any objectionable odor. <u>2/</u>		X
Color not as specified, off shade, uneven, mottled, or spotted.		X
Any tackiness (coating will adhere and not unroll readily). Not clean.	X	X
Raised, corded or wavy selvage, resulting in rolls noticeably firmer or thicker in diameter on the outside than in the center.		X

1/ Clearly visible at normal inspection distance (approximately 3 feet).

2/ Odors of chemicals commonly used in coating compounds shall not be regarded as objectionable.

TABLE IV. Sample size and acceptance criteria

Lot size (yards)	Sample size (rolls)	Maximum number of defects acceptable in sample <u>2/</u>
Up to 1200 inclusive <u>1/</u>	3	0
1201 up to and including 3200	5	0
3201 up to and including 10,000	8	0
10,001 up to and including 35,000	13	0
35,001 up to and including 150,000	20	1
150,001 and over	32	2

1/ If lot contains fewer than three rolls, each roll in the lot shall be examined.

2/ Applicable to length examination only (see 4.4.2.2.1).

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4.4.2.2 Length examination.

4.4.2.2.1 Examination for length in individual roll. Each roll selected for yard-by-yard examination shall be examined for the defects listed below. If the total number of defects in the sample rolls exceed the maximum number specified in table IV, the lot shall be rejected.

Any roll with a total length of less than 60 yards or more than 75 yards.

Any roll containing more than three pieces.

Any piece in roll less than 20 yards in length.

Any roll with a total length more than 2 yards less than that marked on ticket.

End of pieces in roll not overlapped.

End of pieces in roll joined by a seam.

* 4.4.2.2.2 Total yardage in sample. The rolls examined shall be those selected for examination of individual rolls as specified in 4.4.2.2.1. The lot shall be unacceptable if the total of the gross lengths of the rolls in the sample is less than the total of the gross lengths marked on the tickets.

* 4.4.3 End item testing. The coated cloth shall be tested for the characteristics listed in table V. The methods of testing specified in FED-STD-191, whenever applicable and as listed in table V, shall be followed. The physical values specified in section 3 apply to the average of determinations made on a sample unit for test purposes as specified in the applicable test method. The sample unit for testing shall be 5 continuous yards full width of the coated cloth. The lot size shall be expressed in units of 1 linear yard and the sample size (number of sample units) shall be as specified below. The lot shall be unacceptable if any sample unit fails to meet any requirement specified. For those characteristics where test results are reported as "pass" or "fail", each determination made shall be reported and there shall be no evidence of failure of any test specimen to meet the requirements as specified. All test reports shall contain the individual values used in expressing the final results.

<u>Lot size (yards)</u>	<u>Sample size (number of sample units)</u>
800 or less	2
801 to 22,000	3
22,001 and over	5

4.4.3.1 Standard test conditions. Results of physical tests obtained under testing conditions defined in FED-STD-191, FED-STD-406 or FED-STD-601 will be acceptable except in case of dispute. In disputed cases, tests shall be conducted with both the specimen and test apparatus under standard conditions as defined in FED-STD-191.

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* TABLE V. End item tests

Characteristic	Requirement paragraph	Test method
Weight	3.3	5041
Breaking strength:		
Initial	3.3	5102
After accelerated weathering	3.3	4.5.5
Elongation:		
At 20 pounds load	3.3	5102
At breaking point	3.3	5102
Tearing strength	3.3	5134
Adhesion of coating	3.3	5970 <u>1/</u>
Blocking	3.3	5872 <u>2/</u>
Hydrostatic resistance	3.3	5512 <u>3/</u>
Flame resistance:		
After flame	3.3	5903 <u>4/</u>
Resistance to cold crack at -10°F	3.3.1	4.5.1
Oil resistance	3.3.2	4.5.2
Resistance to aromatic hydrocarbon	3.3.3	4.5.3
Cracking resistance after accelerated weathering	3.3.4	4.5.6
Color change after accelerated weathering	3.3.5	4.5.7

1/ Except that the length of the specimen shall be 10 inches. For dry adhesion, the test apparatus shall be stopped after a 3 inch separation and the results recorded. The specimen shall then be immersed in distilled water at room temperature for 24 hours, blotted dry, and wet adhesion shall then be determined on the remainder of the specimen.

2/ Except that the test specimens shall be exposed for 2 hours at 170° + 5°F.

3/ The lightly coated side of the fabric shall be in contact with the water.

4/ The long dimension of the specimen shall be parallel to the warp direction.

* 4.4.4 Preparation for delivery inspection. The inspection of preparation for delivery shall be in accordance with the quality assurance provisions of PPP-P-1136.

4.5 Methods of inspection.

4.5.1 Resistance to cold crack test.

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4.5.1.1 Apparatus and specimens.

- (a) Cold chamber.
- (b) Two glass plates 4 by 4 inches.
- (c) One 12-pound weight.
- (d) One test specimen 1 by 4 inches with long dimension in the direction of the warp.
- (e) One test specimen 1 by 4 inches with long dimension in the direction of the filling.

4.5.1.2 Procedure.

- (a) Reduce temperature in cold chamber to minus $10^{\circ} \pm 2^{\circ}\text{F}$.
- (b) Determine the coldest area in the chamber and locate test specimens, glass plates and weight in that area for a period of 4 hours.
- (c) Without removing from test chamber, fold test specimens back on themselves (180°) with the heavily coated side out. Place specimens between the two glass plates and place the weight on top of the plate in such a manner to evenly distribute the pressure at the fold.
- (d) Allow specimens to remain in the cold chamber for 30 or more minutes at minus $10^{\circ} \pm 2^{\circ}\text{F}$.
- (e) Remove specimens from chamber and visually examine for cracking, flaking or separation of coating.
- (f) Any indication of cracking, flaking or separation of coating from cloth shall be considered a test failure.

4.5.2 Oil resistance test. An 8 by 8-inch specimen of the coated cloth shall be placed on a wood frame. The inside dimension of the wood frame shall be 6 by 6 by 1 inches. The specimen shall be forced into the frame (heavily coated side up) by a wood block 5-3/4 by 5-3/4 inches (with rounded corners) to form a basin of uniform depth. The edges of the cloth shall be tacked to the frame and the block removed. Lubricating oil conforming to grade 1100 of MIL-L-6082 shall be rapidly poured into the basin to a 1/2-inch depth. After the oil has been in the basin for 1 hour, the bottom of the cloth specimen forming the basin shall be examined to determine if oil has permeated the coated cloth to cause leakage. Any indication of oil seepage through the material shall be considered a test failure.

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- * 4.5.3 Resistance to aromatic hydrocarbon fluid test. A 1 by 6-inch specimen with the long dimension parallel to the warp, shall be immersed for 5 minutes in aromatic hydrocarbon fluid conforming to Reference Fuel D of ASTM D 471. The specimen shall be allowed to dry at room temperature for 2 hours \pm 5 minutes and shall be creased sharply on itself, face outward. A similar cut specimen with the long dimension parallel to the filling shall be tested in the same manner. Any indication of cracking shall be considered a test failure.
- * 4.5.4 Accelerated weathering procedure. The accelerated weathering procedure shall be performed in accordance with Method 5804 of FED-STD-191. The specimens shall be exposed in the weatherometer with the long dimension in the vertical position and with the heavily coated side facing the filtered light source for a period of 150 hours.
- * 4.5.5 Breaking strength after accelerated weathering. Cloth specimens shall be cut as specified in Method 5102 of FED-STD-191 and exposed to accelerated weathering as specified in 4.5.4. After exposure in the weatherometer, the specimens shall be removed and exposed to a temperature of $180^{\circ} \pm 5^{\circ}\text{F}$ for 2 hours in a circulating air oven. The specimens shall then be brought to equilibrium with standard conditions and tested for breaking strength in accordance with Method 5102 of FED-STD-191.
- * 4.5.6 Cracking resistance after accelerated weathering. Two 4 by 6-inch minimum specimens shall be cut, one with warp in long dimension and the other with filling in long dimension. The specimens shall be exposed to accelerated weathering as specified in 4.5.4. After exposure, each specimen shall be folded by hand (face out) sharply upon itself and visually examined. Any indication of cracking or crazing shall be considered a test failure.
- * 4.5.7 Color change after accelerated weathering test. One 4 by 6-inch minimum specimen cut with the warp in the long dimension shall be exposed to accelerated weathering as specified in 4.5.4. After exposure, the specimen shall be wiped with a wet cloth and allowed to dry at room temperature. The dry specimen shall be compared with unexposed cloth from the same sample unit under artificial daylight having a color temperature of $7000 \pm 500 \text{ K}$. Any difference in color that is noticeable at first glance shall be considered a test failure.

5. PACKAGING

(Applicable only when purchased by the Government.)

5.1 Put-up and packaging. Put-up and packaging shall be level A or Commercial as specified (see 6.2).

5.1.1 Levels A and Commercial. The coated cloth, put-up as specified, shall be packaged in accordance with the applicable requirements of PPP-P-1136.

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

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5.2.1 Levels A, B and Commercial. The coated cloth shall be packed in accordance with the applicable requirements of PPP-P-1136.

5.3 Marking. In addition to any special marking required by the contract or purchase order, interior packages and shipping containers shall be marked in accordance with the applicable requirement of PPP-P-1136.

6. NOTES

6.1 Intended use. The coated cloth is intended for use in the fabrication of air supported shelters where intended use does not involve erecting and striking at temperatures below minus 10°F.

6.2 Ordering data. Acquisition documents should specify the following:

- a. Title, number and date of this document.
- b. Whether laboratory report is not required (see 3.1.1).
- c. When a first article is required (see 3.1.2, 4.3 and 6.3).
- d. Width required (see 3.3).
- e. Selection of applicable levels of put-up, packaging and packing (see 5.1 and 5.2).

* 6.3 First article. When a first article is required, it shall be inspected and approved under the appropriate provisions of DAR 7-104.55. The first article should be a reproduction sample consisting of 5 yards of the finished coated cloth. The contracting officer should include specific instructions in all acquisition documents regarding arrangements for inspection and approval of the first article.

6.4 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 irrespective of the marginal notations and relationship to the last previous issue.

Custodians:

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Preparing activity:

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Project No. 8305-0249

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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

1. DOCUMENT NUMBER MIL-C-43086C	2. DOCUMENT TITLE Cloth, Coated, Nylon, Vinyl Coated (For Air Supported Shelters)
3. NAME OF SUBMITTING ORGANIZATION	4. TYPE OF ORGANIZATION (Mark one) <input type="checkbox"/> VENDOR <input type="checkbox"/> USER <input type="checkbox"/> MANUFACTURER <input type="checkbox"/> OTHER (Specify) _____
5. 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)