

MIL-C-43469B

18 March 1975

SUPERSEDING

MIL-C-43469A

27 May 1969 and

MIL-C-43237B

22 June 1972

MILITARY SPECIFICATION

CHAPLAINS' KITS, CATHOLIC AND PROTESTANT

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

1. SCOPE

1.1 Scope. This specification covers two types of Chaplains' kits (see 6.1).

* 1.2 Classification. Chaplains' kits shall be of the following types as specified (see 6.2).

Type I - Catholic Chaplains' kit
Type II - Protestant Chaplains' kit

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-276 - Thread, Cotton.
V-T-295 - Thread, Nylon.
QQ-A-250/2 - Aluminum Alloy 3003, Plate and Sheet.
QQ-C-320 - Chromium Plating (Electrodeposited).
PPP-B-636 - Boxes, Shipping, Fiberboard.

MILITARY

MIL-C-5541 - Chemical Conversion Coatings on Aluminum and Aluminum Alloys.
MIL-P-15328 - Primer, (Wash) Pretreatment, Blue Formula No. 117B for Metals.

FSC 9925

L-C-43469B

- MIL-P-26514 - Polyurethane Foam, Rigid or Flexible for Packaging.
- MIL-C-40638 - Candles, Ecclesiastical (and Taper, Candlelighter).
- MIL-C-43382 - Cup, Communion, Plastic.
- MIL-C-43467 - Candle Burner, and Candlelighter and Snuffer.
- MIL-T-43548 - Thread, Polyester, Cotton Covered.
- MIL-T-43624 - Thread, Polyester, Spun.
- MIL-C-43863 - Cloth, Broadcloth, Polyester/Cotton Precured.

STANDARDS**FEDERAL**

- FED-STD-191 - Textile Test Methods.
- FED-STD-751 - Stitches, Seams, and Stitchings.

MILITARY

- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes.
- MIL-STD-129 - Marking for Shipment and Storage.

DRAWINGS**ARMY NATICK LABORATORIES**

- 14-1-26 - Chaplain's Kit, Protestant, for Field (Non-combat) Use; Assembly Complete.
- 14-1-27 - Chaplain's Kit, Protestant, For Field (Non-combat) Use; Cover, Lid and Altar.
- 14-1-28 - Chaplain's Kit, Protestant, For Field (Non-combat) Use; Communion Tray.
- 14-1-29 - Case Assembly and Body Details.
- 14-1-30 - Lid Assembly and Details.
- 14-1-31 - Altar Assembly and Details.
- 14-1-32 - Insert, Nesting; Type II Protestant Chaplains' Kit.
- 14-1-33 - Chalice.
- 14-1-34 - Cross - Crucifix.
- 14-1-36 - Chalice Insert.
- 14-1-37 - Paten.
- 14-1-38 - Cruet Tray.
- 14-1-39 - Host Box.
- 14-1-40 - Candlestick.
- 14-1-70 - Chaplain's Kit, Catholic; Assembly Complete.
- 14-1-73 - Insert, Nesting; Type I Catholic Chaplains' Kit.

MIL-C-43469B

14-1-75 - Ciborium.
 14-1-117 - Paten.
 14-1-128 - Stand, Bible and Missal.

(Miniature copies of Drawings 14-1-70, 14-1-26, 14-1-27, 14-1-28, identified as figures 1 thru 4 respectively, are attached for information purposes only.)

(Copies of specifications, standards and drawings 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 a specific issue is identified, the issue in effect on date of invitation for bids or request for proposal shall apply:

The Color Association of the United States Inc.

Department of Defense Standard Shades for Sewing Threads

(Application for copies should be addressed to the Color Association of the United States, Inc., 200 Madison Avenue, New York, NY 10016.)

National Motor Freight Traffic Association, Inc., Agent

National Motor Freight Classification

(Application for copies should be addressed to the American Trucking Associations, Inc., Tariff Order Section, 1616 P Street, N.W., Washington, DC 20036.)

Uniform Classification Committee, Agent

Uniform Freight Classification

(Application for copies should be addressed to the Uniform Classification Committee, Room 1106, 222 South Riverside Plaza, Chicago, IL 60606.)

3. REQUIREMENTS

- * 3.1 First article. The supplier shall furnish a sample for first article inspection and approval (see 4.2, 6.2 and 6.4).

MIL-C-43469B

3.2 Cloth design. The cloth components of the Chaplains' kits delivered under this specification shall be the manufacturer's standard design, except, for any changes necessary to comply with specification requirements.

- * 3.3 Materials. Materials shall conform to the applicable specifications and requirements specified herein. Materials not specifically defined shall be of the quality normally used for the purpose in commercial practice.

3.3.1 Brass. The brass shall be commercial grade used by the manufacturer in his current commercial practice for similar items.

3.3.2 Aluminum alloy sheet. Aluminum alloy sheet shall conform to QQ-A-250/2, temper H14.

- * 3.3.3 Broadcloth, polyester/cotton, precured. The cloth shall conform to MIL-C-43863, except that the color shall be white, and the requirements for colorfastness, soil release rating and non-fibrous materials do not apply.

3.3.4 Nylon cloth. The nylon cloth shall be 70, plus or minus 4 denier yarn warp and filling, 1.75 ounces to 1.85 ounces per square yard, having a minimum count of 100 per inch in the warp and 68 per inch in the filling. The color shall be as specified in 3.5.23.

- * 3.3.5 Cotton velour. The cotton velour shall have a weight of not less than 14.0 ounces per square yard with a warp pile thread count of not less than 40 per inch, a warp back yarn count of not less than 39 per inch, and a filling yarn count of not less than 34 per inch. The cotton velour shall be dyed Cable No. (C.A., DOD Standard Shades for Sewing Threads) 65010 (Ultra-Marine Blue) and shall match the standard shade sample. The dyed fabric shall show good fastness to wet drycleaning and light when tested as specified in 4.3.1.1.

- * 3.3.6 Cotton sateen. The cotton sateen shall have a weight of not less than 3.0 ounces per square yard, with a warp yarn count of not less than 84 per inch and a filling yarn count of not less than 130 per inch. The weave of the cotton sateen shall be a 1 up, 4 down construction. The cotton sateen shall be dyed C.A. 65010 (Ultra-Marine Blue) and shall match the standard shade sample. The cloth shall have a Schreiner finish. The dyed fabric shall show good fastness to wet drycleaning and light, when tested as specified in 4.3.1.1.

- * 3.3.7 Rayon fringe. The fringe shall be made of one end, 600 denier viscose rayon and shall have a firm, three-row heading of three end, 300 denier viscose rayon. The length and heading shall be as required in Drawing 14-1-27.

MIL-C-43409B

The weight shall be 1-1/4 ounces, plus or minus 1/4 ounce per linear yard. The fringe shall have not less than 18 strands per inch. The fringe shall have alternately, two strands of C.A. 65010 (Ultra-Marine Blue) and two strands of C.A. 65008 (Silver), matching the standard shade samples. The heading rows shall be C.A. 65010 (Ultra-Marine Blue) matching the standard shade sample. The dyed fringe shall show good fastness to wet drycleaning and light when tested as specified in 4.3.1.1.

- * 3.3.8 Thread, cotton. The cotton thread shall be type IC2, ticket No. 00 and A of V-T-276. Thread shall conform to ticket No. 00, except as specified on Drawing 14-1-27. The color of the thread shall be a good match to the color of the materials to be sewed.
- * 3.3.9 Polyester thread. The polyester thread shall be cotton covered polyester thread conforming to MIL-T-43548 or spun polyester thread conforming to class 1 or class 2 of MIL-T-43624, ticket No. 50, 3-ply, white color.
- * 3.3.10 Nylon thread. Nylon thread shall conform to size A, type I, class 1 of V-T-295. The color of the thread shall be U.S.A. shade AG, C.A. 66049 (white).
- * 3.3.11 Polyurethane foam. The polyurethane foam shall be black and shall conform to type I, class 2, molded of MIL-P-26514. The density shall be 4 pounds per cubic foot.
- * 3.4 Components. The components of the type I and type II kits shall conform to the quantities specified in table I.

TABLE I. Components

Item nomenclature	Quantity required per kit		Reference paragraph
	Type I	Type II	
Alb	1	-	3.5.14
Amice	2	-	3.5.15
Bottle plastic 8 oz	-	1	3.5.1
Bottle, plastic 2 oz	2	2	3.5.1
Box, host	1	1	3.5.2
Candle	2	2	3.5.3
Candlestick	2	2	3.5.4
Candle burner	2	2	3.5.5
Case carrying	1	1	3.5.6
Chalice	1	1	3.5.7
Chalice insert	1	1	3.5.7
Ciborium	1	-	3.5.8

MIL-C-43469B

TABLE I. Components (cont'd)

Item nomenclature	Quantity required per kit		Reference paragraph
	Type I	Type II	
Cincture	1	-	3.5.16
Cloth, altar	2	3	3.5.17
Corporal	3	-	3.5.18
Cover, lid and altar	-	1	3.5.19
Cross/crucifix	1	1	3.5.9
Cruet tray	1	1	3.5.10
Pall, chalice	2	-	3.5.20
Paten, chalice	1	1	3.5.11
Paten, communion	1	-	3.5.11
Purificator	4	3	3.5.21
Stand	-	1	3.5.12
Finger towel	4	-	3.5.22
Vestment set	1	-	3.5.23
Tray, communion	-	1	3.5.13
Cup, communion	-	20	3.5.13

3.5 Details of components. Details of components shall be as specified herein. Tolerance for overall dimensions on fabric components shall be in accordance with the manufacturer's commercial practice unless otherwise specified herein.

- * 3.5.1 Plastic bottle and caps. The plastic bottle shall be a commercial "Boston Round" plastic bottle, of a nominal capacity of 2 ounce and 8 ounce capacity with screw caps.
- * 3.5.2 Box, host. The host box shall be fabricated from the brass specified in 3.3.1 and conform to Drawing 14-1-39.
- * 3.5.3 Candles. The candles shall conform to type I, size 3 of MIL-C-40638.
- * 3.5.4 Candlesticks. The candlesticks shall be fabricated of brass specified in 3.3.1 and shall conform to Drawing 14-1-40.
- * 3.5.5 Candle burners. The candle burners shall conform to item 1 of MIL-C-43467.

14-1-40-68

- * 3.5.6 Carrying case. The carrying case shall conform to Drawing 14-1-29. The case shall be fabricated of the aluminum specified in 3.3.2 and finished as specified in 3.7.1. The case for the type I kit shall be provided with an insert conforming to Drawing 14-1-73. The case for the type II kit shall be provided with an insert conforming to Drawing 14-1-32. Inserts shall be fabricated of the polyurethane foam specified in 3.3.11. A pressure-sensitive adhesive label with the following washing instructions shall be attached to the inside of the lid assembly.

WASHING INSTRUCTIONS

FOR

ALTAR CLOTHS AND PURIFICATORS

1. For machine washing. Use wash and wear or durable press cycle. Wash with moderately hot water (140°F) using soap and mild detergent.
 2. For hand washing. Wash in moderately hot water as described above. DO NOT WRING OR TWIST.
 3. DO NOT BLEACH OR STARCH.
 4. Tumble dry at warm settings. Remove immediately after drying. Shape and hand.
 5. If touch up is required, iron at low (synthetic) temperature.
 6. May be drycleaned.
- * 3.5.7 Chalice and chalice insert. The chalice shall be fabricated from brass specified in 3.3.1 and shall conform to Drawing 14-1-33. The chalice insert shall be fabricated from brass specified in 3.3.1 and conform to Drawing 14-1-36. Gold plating shall be as specified in 3.7.3 except the inside surface of chalice insert shall have a satin finish.
- * 3.5.8 Ciborium. The ciborium shall be fabricated from brass specified in 3.3.1 and shall conform to Drawing 14-1-75.
- * 3.5.10 Cruet tray. The cruet tray shall be fabricated of brass specified in 3.3.1 and shall conform to Drawing 14-1-38.
- * 3.5.11 Patens. The patens shall be fabricated of the brass specified in 3.3.1. The chalice paten shall conform to Drawing 14-1-37. The communion paten shall conform to Drawing 14-1-117.

MIL-C-43469B

- * 3.5.12 Stand, missal. The missal stand shall conform to the design of Drawing 14-1-128. The material shall be the brass specified in 3.3.1.
- * 3.5.13 Communion tray and cups. The communion tray shall be fabricated from brass specified in 3.3.1 and shall conform to Drawing 14-1-28. The cups shall conform to MIL-C-43382.
- * 3.5.14 Alb. The alb shall be made from broadcloth specified in 3.3.3. The polyester thread specified in 3.3.9 shall be used in sewing the alb. The finished garment (measured flat) shall be a minimum of 60 inches long, including the neck band, and a minimum of 78 inches in circumference at the bottom. Sleeves shall be tapered from 14 inches at the armhole to 7 inches at the bottom cuff edge. The cuff shall be a double thickness of broadcloth, with a tapered width of 5 inches to 3 inches minimum. The bottom shall have a 2 inch hem. The neck band shall consist of one piece of fabric, folded in half along the length and stitched to the neck of the alb to form a tunnel. The top edge of the neck band shall be stitched 1/4 inch from the edge. Broadcloth tape, 1-1/2 yards long, shall be inserted as a drawstring. The front opening from the neck band down shall measure 14 inches and shall be finished with 1 inch facings tapering to a point at the bottom. The shoulder shall have a reinforced broadcloth patch from the neck band to the armhole seam, 7 inches by 2 inches minimum. A 3 inch piece of doubled, 3/4 inch broadcloth tape shall form a hanger and shall be sewed in the center insert of the neck band. The fullness at the collar shall be taken in by shirring.
- * 3.5.15 Amice. The amice shall be made from broadcloth specified in 3.3.3. The polyester thread specified in 3.3.9 shall be used in sewing the amice. The finished size shall be a minimum of 20 inches by 35 inches and shall have 1/2-inch hems. Centered along the 35-inch length, a 3/8-inch Greek Cross shall be embroidered in colorfast, red thread at least 2 inches from the hem. The cross shall be located on the front of the amice. Two yards of broadcloth tie tapes, 1/4 inch wide, shall be attached at each end of the top of the amice.
- * 3.5.16 Cincture. The cincture shall be a white cotton cord, 1/4 inch thick, with a flat tassel at each end. The minimum overall length shall be 152 inches. The flat tassel at each end shall be 8 inches long with 3 inch length of crochet work at the upper end.
- * 3.5.17 Altar cloth. The altar cloth shall be made of unlined broadcloth specified in 3.3.3. The polyester thread specified in 3.3.9 shall be used in sewing the altar cloth. The finished size shall be a minimum of 14 inches by 42 inches and shall have 1-inch hems. The corners shall be mitered and a diagonal underseam shall be stitched to secure each mitered corner. The altar cloth shall be pressed and carefully folded.

14-1-27-4673

- * 3.5.18 Corporal. The corporal shall be a minimum of 16 inches by 16 inches, made from broadcloth specified in 3.3.3, and shall have 1/2 inch hems. The polyester thread specified in 3.3.9 shall be used in sewing the corporal. A 3/8 inch Greek Cross shall be embroidered with colorfast red thread on the center line of one 16 inch dimension, 5 inches + 1 inch from the edge. The corporal shall be pressed and folded in three, beginning from the front edge to the back edge and folded again from side to side, forming nine squares.
- * 3.5.19 Cover, lid and altar. The lid and altar cover shall conform to the requirements specified herein and as shown on Drawing 14-1-27. The body and side pieces shall be made of the cotton velour specified in 3.3.5. The lining and back shall be made of the cotton sateen specified in 3.3.6. The top front of the lid part and the front of the altar part shall have the rayon fringe specified in 3.3.7.
- * 3.5.20 Pall. The pall shall be a minimum of 5 inches by 5 inches (finished size), made from broadcloth specified in 3.3.3. The polyester thread specified in 3.3.9 shall be used in sewing the pall. The pall shall be sewn on two sides to form an envelope and shall have a 1/4 inch hem at the open end. Centered on the pall shall be a 3/8 inch Greek Cross, embroidered in colorfast, red thread. A plastic liner, the size of the cloth, with rounded corners, shall be inserted in the open end.
- * 3.5.21 Purificator. The purificator shall be a minimum of 15 inches by 10 inches (finished size), made from broadcloth specified in 3.3.3. The polyester thread specified in 3.3.9 shall be used in sewing the purificator. The purificator shall have 1/4 inch hems. Centered in the cloth shall be a 3/8 inch Greek Cross embroidered in colorfast, red thread. The purificator shall be pressed and folded into three, beginning from the front edge to the back edge, and folded again from side to side.
- * 3.5.22 Finger towel. The finger towel shall be a minimum of 15 inches by 7 inches, made from the broadcloth specified in 3.3.3. The polyester thread specified in 3.3.9 shall be used in sewing the finger towel. The towel shall have 1/4 inch hems.
- * 3.5.23 Vestment set. The vestment set shall be reversible and shall consist of a chasuble, stole, and veil. Each vestment shall be white on one side and C.A. 65009 (Purple) matching the standard shade sample on the other side. The components of the vestment set shall be fabricated of the nylon specified in 3.3.4. Nylon thread specified in 3.3.10 shall be used in sewing the vestment set. Embroidery shall be done by machine, on both sides of the vestments, using colorfast rayon thread C.A. 65021 (Old Gold), matching the standard shade sample. The embroidered designs shall be similar to those shown in figure 5, as applicable.

MIL-C-43469B

3.5.23.1 Chasuble. The chasuble shall be a minimum of 39 inches long by 4 inches wide and of a similar design to the chasuble shown in figure 5.

3.5.23.2 Stole. The stole shall be a minimum of 78 inches long, joined at the center, tapering from a minimum of 5 inches wide at the end to a minimum of 2 inches wide at the center seam.

3.5.23.3 Veil. The veil shall be a minimum of 18 inches by 17 inches.

3.6 Seams and stitching. Seams shall be type SSc-1 and hems shall be type IFb-1 with raw edges turned in. Stitchings shall conform to type 201 of FED-STD-751, 10 to 14 stitches per inch. Thread breaks in stitching shall be overstitched not less than 1 inch at each break. Stitching shall be backtacked not less than 1/2 inch at the ends, except where the ends of stitching are caught in other seams of stitching. Ends of a continuous line of stitching shall overlap not less than 1/2 inch. Thread tension shall be maintained so that there shall be no loose or tight stitching. All thread ends shall be trimmed. Seam allowance shall be maintained with seams properly sewed so that no runoffs, twists, pleats, puckers, raw edges, or open seams shall result. Unless otherwise specified herein, the tolerance for hems shall be $\pm 1/8$ inch.

3.7 Finish.

3.7.1 Case. The interior and exterior of all aluminum parts of the case shall be prepared for finishing in accordance with MIL-C-5541. The prepared parts and hinges shall be pretreated in accordance with MIL-P-15328 and coated with a commercial black wrinkle enamel.

3.7.2 Chromium plate. The host box, candlesticks, candle burners; the exterior of the chalice and ciborium; the crucifix or cross-crucifix; cruet tray, missal stand, and communion tray, as applicable, shall be chromium plated in accordance with class 1, type I of QQ-C-320, except that the scroll and corpus of the crucifix specified in 3.5.17 shall be plated in accordance with class 1, type II of QQ-C-320.

3.7.3 Gold plate. The interior of the chalice and ciborium, as applicable, and the interior and exterior of the chalice insert and patens shall be plated with 24 carat gold to a minimum thickness of 0.0005 inch and shall be highly polished. The bottom surfaces of the patens shall be coated with a clear organic finish. There shall be no evidence of chemical reaction when tested as specified in 4.4.1.

122-0-434548

- * 1.2 Workmanship. Metallic and plastic components shall be free from sharp edges, burrs, and slivers. Plating and finishes, where required, shall be free from areas of no coverage. All solder joints shall be sound, and where exposed on the outside surface, shall be smoothly blended with surrounding area. Fabric components shall be free from spots, stains, wrinkles, and loose threads.

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, it shall be examined for the defects in table III and specified dimensions. The presence of any visual defect or any dimension not within the specified requirements shall be cause for rejection of the preproduction sample.

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, components and materials shall be inspected and tested in accordance with all the requirements of referenced specifications, drawings, and standards unless otherwise excluded, amended, modified, or qualified in this specification, or applicable purchase document.

- * 4.3.1.1 Testing of components. Testing shall be performed on the cloth materials listed in table II for the characteristics shown. Requirements are applicable to an individual sample unit. The sample unit shall be 1-1/2 yards full width. The inspection level shall be S-1 and the acceptable quality level (AQL) shall be 6.5 defects expressed in terms of defects per hundred units. The inspection lot shall consist of all finished material offered for inspection at one time.

MIL-C-43469B

TABLE II. Material tests

<u>Material</u>	<u>Characteristics</u>	<u>Test Method</u> FED-STD-191
Cotton velour, and cotton sateen	Material identification	1200 <u>1/</u>
	Weight	5040
	Texture (yarns per inch)	5050
	Colorfastness of cottons to:	
	Wet cleaning of textile material (associated with drycleaning)	5622
	Light	5660 <u>2/</u>
Rayon fringe	Material identification	1500 <u>1/</u>
	Weave	visual
	Weight	5041
	Fringe strands	visual
	Colorfastness to:	
	Wet cleaning of textile materials (associated with drycleaning)	5622
	Light	5660 <u>2/</u>

1/ A certificate of compliance shall be submitted and may be acceptable for the stated requirement.

2/ The time of exposure shall be 40 standard fading hours.

4.3.2 In-process inspection and testing.

4.3.2.1 In-process examination. Prior to application of the black wrinkle enamel, aluminum components shall be examined to determine compliance with finish preparation requirements in 3.7.1. Whenever noncompliance is noted, correction shall be made to affected items and process.

4.3.2.2 In-process testing. Prior to application of organic finish to gold plated surfaces (where required), components shall be tested as specified in 4.4.1 to determine compliance with 3.7.3. The lot shall be expressed in units of groups of gold plated components contained within one kit and submitted for inspection at one time. The sample unit shall be one group of gold plated components. The inspection level shall be S-1. Failure of one or more samples shall be cause for rejection of the lot.

4.3.3 End item inspection. A lot shall consist of all kits of one type offered for inspection at one time. The sample unit shall be one complete kit.

MIL-C-43469B

4.3.3.1 Visual examination. Examination shall be made of the kits for defects in table III. The inspection level shall be level II with an AQL of 2.5 for major defects and 6.5 for total defects, expressed in terms of defects per hundred units.

TABLE III. Visual examination of defects

Examine	Defect	Classification	
		Major	Minor
Cloth components			
Fabric	Holes, cuts, tears, any smash, weak place, broken or missing yarns, multiple floats or open place, clearly visible.	X	
	Shade bar, fine or coarse filling bar.		X
Raw edge	Any raw edge not permitted by drawings.		X
	NOTE: Raw edges not securely caught in stitching shall be classified as open seams.		
Seams and stitching			
Open seams	Up to 1/4 inch.		X
	More than 1/4 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 run-offs occur. On double-stitched seams, a seam shall be classified as open when either is open.		

MIL-C-43469B

TABLE III. Visual examination of defects (cont'd)

Examine	Defect	Classification	
		Major	Minor
Cloth components (cont'd)			
End of continuous line of stitching	Less than 1/2 inch.		X
Seams and stitch type	Wrong seam or stitch type (where specified).	X	
Stitch tension	Loose, resulting in a loosely exposed needle or bobbin thread; tight, resulting in excessive puckering, twisting or pleating of fabric on seams.		X
Stitches per inch	One stitch less than minimum specified.		X
	Two or more stitches less than minimum specified.	X	
	One stitch more than maximum specified.		X
	Two or more stitches in excess of maximum specified.	X	
	NOTE: To be scored when the condition exists on major portion of seam or stitching.		
Stitching ends	Back-tacked less than 1/2-inch (except where ends are held down by other seams or stitching).		X
Thread breaks	Overstitched less than 1 inch.		X
	Broken ends of stitching not caught in overstitching.		X
	NOTE: Thread breaks not overstitched shall be classified as an open seam.		

MIL-C-43469B

TABLE III. Visual examination of defects (cont'd)

Examine	Defect	Classification	
		Major	Minor
Cloth components (cont'd)			
Workmanship	Mends or darns.	X	
	Thread not good match with material.		X
	Needle chews.	X	
	Seams twisted or pleated.		X
	Not folded (when specified).		X
Cleanness	Any spot or stain; thread ends not trimmed throughout.		X
Hems	Twisted or pleated.		X
Assembly	Component missing or damaged.	X	
	Not as specified.		X
Embroidery	Not as specified.	X	
Metal components and case			
Finish	Not finish specified.	X	
	Area of no coverage.	X	
	Not highly polished (where required).	X	
	Not uniform or is dirty, stained, discolored, scratched, abraded, peeling, or any foreign matter imbedded in plating.	X	
Construction and workmanship	Any malformation.	X	
	Rough or sharp edges or burrs.	X	
	Loose parts.		X
	Soldering incomplete or missing.	X	
	Solder not flush on outside surfaces.	X	
	Latches and hinges do not operate freely.		X
	Washings instructions missing or incorrect.		X
Nest	Not as specified.	X	

MIL-C-43469B

4.3.3.2 Dimensional examination. Examination shall be made of the kit for defects in overall dimensions. Any dimension not within specification requirements shall be classified as a defect. The inspection level shall be S-3 with an AQL of 4.0 defects, expressed in terms of defects per hundred units.

4.3.4 Examination of preparation for delivery. An examination shall be made to determine that packaging, packing and marking as required by section 5 are complied with. Defects shall be as indicated in table IV. The sample unit shall be one shipping container fully prepared for delivery. The lot shall be the number of containers offered for inspection at one time. The inspection level shall be S-2 with an AQL of 4.0 defects, expressed in terms of defects per hundred units.

TABLE IV. Examination of preparation for delivery

Examine	Defect
Marking	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application.
Materials	Component missing or damaged.
Workmanship	Components not properly positioned.
Contents	Number per container is more or less than required.

4.3.4.1 Examination of shipping containers. When shipping containers are required to be in accordance with PPP-B-636, examination for defects in closure, and strapping shall be made in accordance with the appendix of that specification.

4.4 Test.

4.4.1 Gold plating test. Place several drops of a solution containing 50 percent by volume of nitric acid, specific gravity 1.42, and an equal quantity of distilled water at $65^{\circ}\text{F} \pm 2^{\circ}\text{F}$ on the gold plated surface to be tested, for 2 minutes. Visual evidence of chemical reaction shall constitute failure of this test.

5. PREPARATION FOR DELIVERY

5.1 Packaging. Packaging shall be level A.

MIL-C-43469B

- * 5.1.1 Level A. Cloth items shall be neatly folded and placed in a bag fabricated of minimum 0.001-inch thick polyethylene. Metal components of the kit shall be placed in a bag fabricated of minimum 0.001-inch thick polyethylene. Components shall be secured in appropriate compartment of the case as shown on Drawing 14-1-26 or 14-1-73, as applicable. The case shall be closed, secured with the bolts provided, and placed in a bag fabricated of minimum 0.001-inch thick polyethylene. The bag closure shall be effected by heat sealing or taping.

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

- * 5.2.1 Level A. Each kit, packaged as specified in 5.1, shall be packed flat in a snug-fitting corrugated fiberboard box conforming to style RSC, grade V2s, of PPP-B-636. Corrugated fiberboard pads, having a minimum strength of 175 pounds per square inch, shall be provided to fill voids caused by projections on the carrying case. Each shipping container shall be closed in accordance with method III, waterproofed in accordance with method V, and reinforced with strapping or tape banding in accordance with the appendix of PPP-B-636.
- * 5.2.2 Level B. Each kit packaged as specified in 5.1, shall be packed flat in a snug-fitting corrugated fiberboard box conforming to type CF, class domestic, variety SW, style RSC of PPP-B-636. Corrugated fiberboard pads of the same material as the container shall be provided to fill voids caused by projections on the carrying case. Closure shall be in accordance with method II of the appendix of PPP-B-636.
- * 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 appendix thereto.
- * 5.2.3 Level C. Kits, 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 Marking. In addition to any special marking required by the contract or order, shipping containers shall be marked in accordance with MIL-STD-129. Special handling marking requirements applicable to fragile items, arrows, and the words "THIS SIDE UP" shall apply.

MIL-C-43237B

6. NOTES

- * 6.1 Intended use. The Chaplains' kits covered by this specification are intended for field use under noncombat conditions. The type I kit is intended for use by Catholic Chaplains. The type II kit is intended for use by Protestant Chaplains.
- * 6.2 Ordering data. Procurement documents should specify the following:
 - (a) Title, number and date of this specification.
 - (b) Type required (see 1.2).
 - (c) When a first article is waived (see 3.1, 4.2, and 6.4).
 - (d) Selection of applicable level of packing (see 5.2).
 - (e) If weather-resistant fiberboard is required for level B pack (see 5.2.2.1).
- * 6.3 First article. The first article shall be inspected and approved under the provisions of ASPR 7-104.55 pertaining to Government inspections. The first article should be a preproduction sample. The first article shall consist of a complete unit. The contracting officer should make arrangements for inspection and approval of the first article with the Construction, Materiel and Supplies Advisory Group, Armed Forces Chaplain's Board, Washington, DC 20301 and the U.S. Army Natick Laboratories (GL), Natick, MA 01760.
- * 6.4 Supersession data. The Chaplains' kit covered by MIL-C-43237B has been included in this revision as type II.

6.5 The margins of this specification have been 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
 Navy - PE
 Air Force - 28

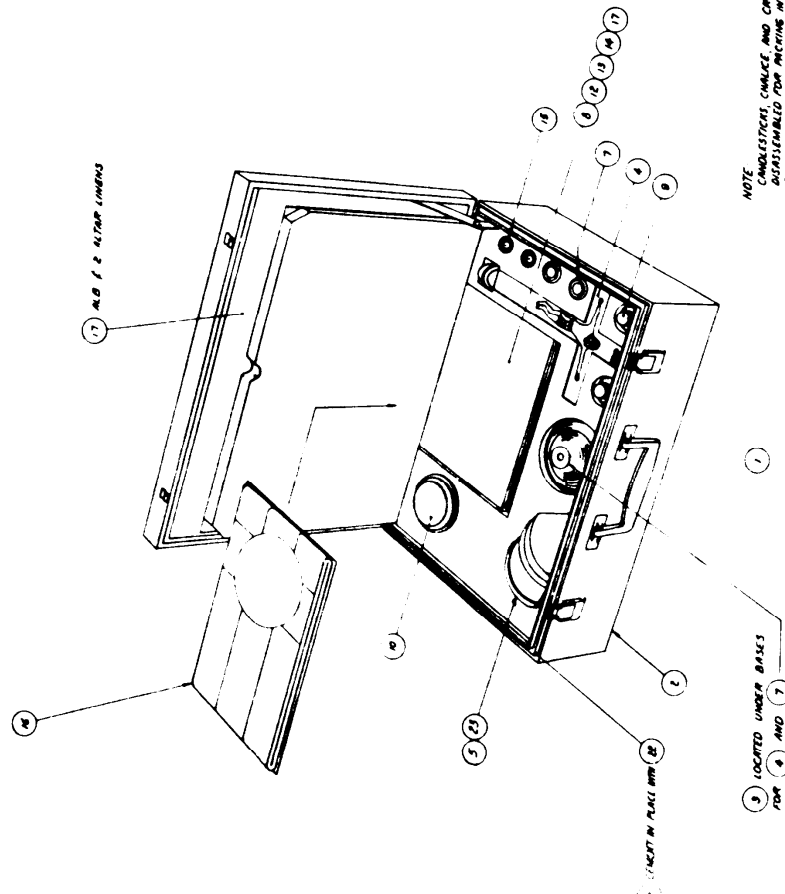
Preparing activity:

Army - GL
 Project No. 9925-0224

Review activities:

DSA-GS
 Armed Forces Chaplains Board

MIL-C-43469B



NOTE
CANDLES, CHANCE, AND CARDS: CANDLES
DISASSEMBLED FOR MOVING IN TRAVEL.
CHANCE BASE TO BE SCREWED ON TO THE
CHANCE CUP IN REVERSE POSITION AS SHOWN

ITEM NO.	DESCRIPTION	QTY	UNIT	DATE	BY	REMARKS
1	1/2" DIA. X 1/4" THICK	100	PCS	1-1-50		
2	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
3	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
4	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
5	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
6	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
7	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
8	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
9	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
10	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
11	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
12	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
13	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
14	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
15	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
16	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
17	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
18	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
19	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
20	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
21	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
22	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
23	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
24	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
25	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
26	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
27	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
28	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
29	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
30	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
31	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
32	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
33	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
34	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
35	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
36	1					

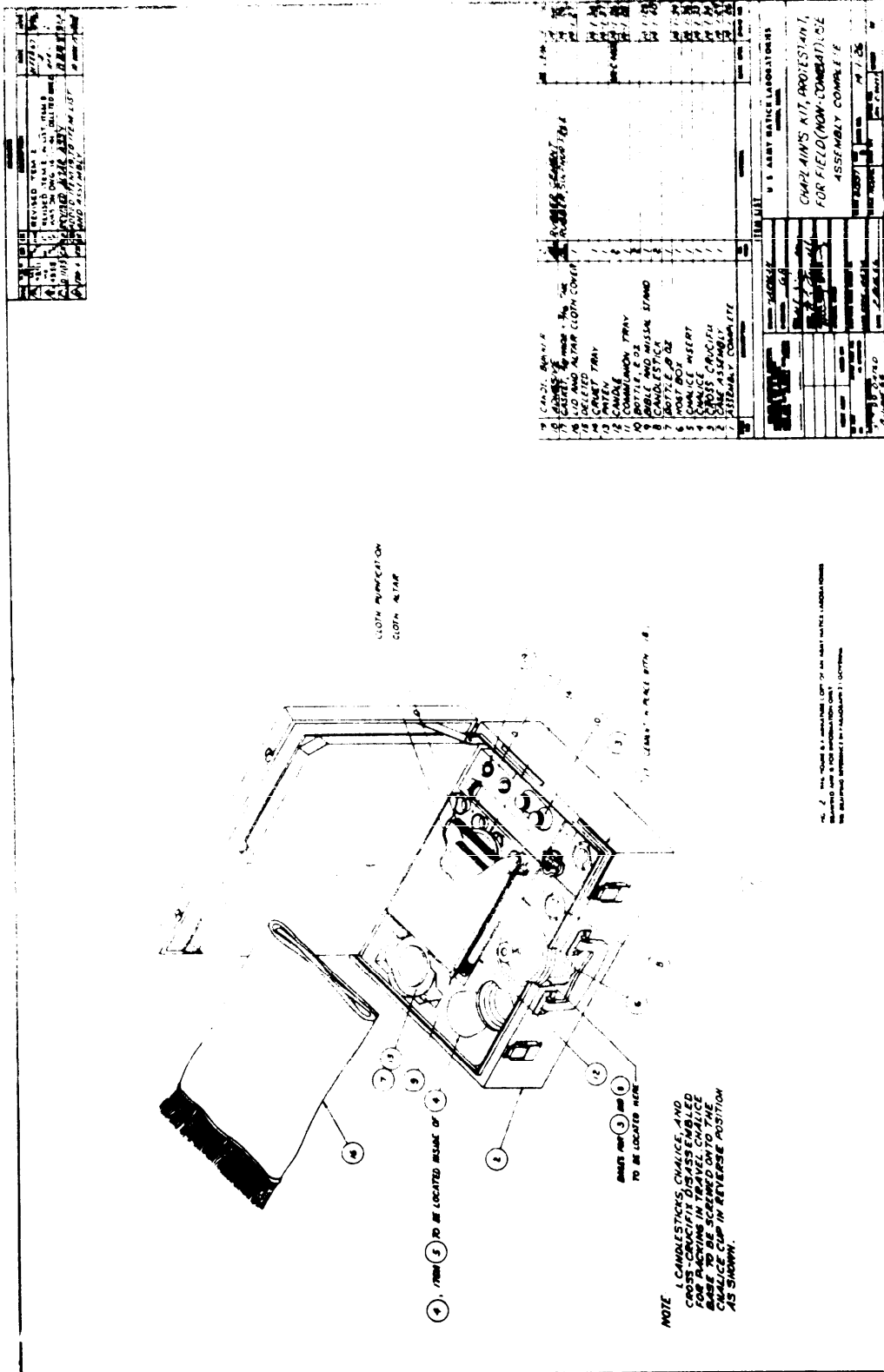
ITEM NO.	DESCRIPTION	QTY	UNIT	DATE	BY	REMARKS
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39	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
40	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
41	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
42	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
43	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
44	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
45	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
46	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
47	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
48	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
49	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
50	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
51	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
52	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
53	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
54	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
55	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
56	1					

ITEM NO.	DESCRIPTION	QTY	UNIT	DATE	BY	REMARKS
57	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
58	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
59	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
60	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
61	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
62	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
63	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
64	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
65	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
66	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
67	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
68	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
69	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
70	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
71	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
72	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
73	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
74	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
75	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
76	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
77	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
78	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
79	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
80	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
81	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
82	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
83	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
84	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
85	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
86	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
87	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
88	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
89	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
90	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
91	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
92	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
93	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
94	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
95	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
96	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
97	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
98	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
99	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
100	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		

ITEM NO.	DESCRIPTION	QTY	UNIT	DATE	BY	REMARKS
101	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
102	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
103	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
104	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
105	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
106	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
107	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
108	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
109	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
110	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
111	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
112	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
113	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
114	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
115	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
116	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
117	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
118	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
119	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
120	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
121	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
122	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
123	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
124	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
125	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
126	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
127	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
128	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
129	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
130	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
131	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
132	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
133	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
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138	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
139	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
140	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
141	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
142	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
143	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
144	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
145	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
146	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
147	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
148	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
149	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
150	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		

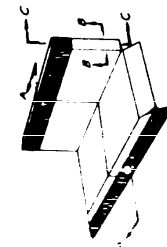
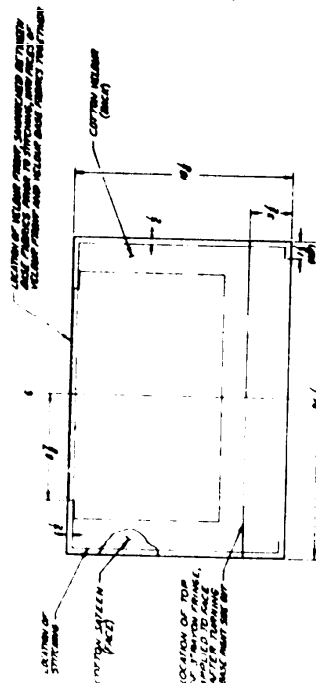
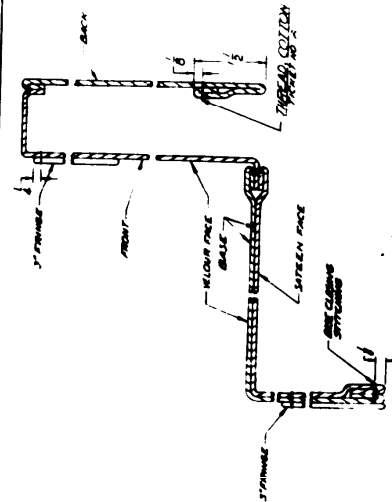
ITEM NO.	DESCRIPTION	QTY	UNIT	DATE	BY	REMARKS
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153	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
154	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
155	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
156	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
157	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
158	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
159	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
160	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
161	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
162	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
163	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
164	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
165	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
166	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
167	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
168	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
169	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
170	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
171	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
172	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
173	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
174	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
175	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
176	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
177	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
178	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
179	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
180	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
181	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
182	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
183	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
184	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
185	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
186	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
187	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
188	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
189	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
190	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		
191	1/4" DIA. X 1/4" THICK	100	PCS	1-1-50		

[illegible]



MIL-C-43469B

REVISIONS			
REV	DATE	BY	DESCRIPTION
1	10-11-11	1	ADDED APPROVED SIGNATURE, APPROVED DATE, AND DATE OF NEXT JO
2	10-11-11	2	REMOVED DATE, AND APPROVED DATE, APPROVED SIGNATURE



ILLUSTRATION

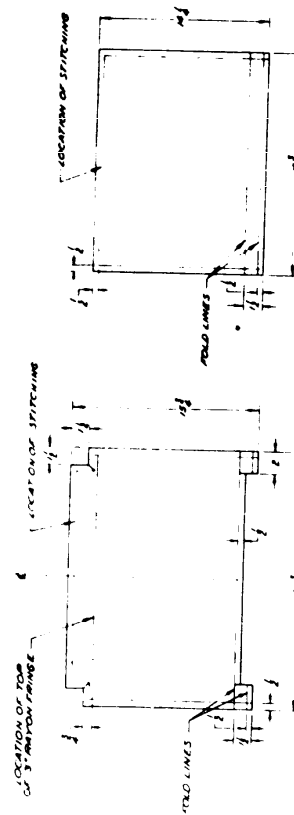
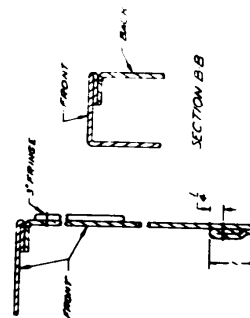
LESS OVERLAP VARIETY TOLERANCES

SMALLER AS FOLLOWS:

(1) 7-8 INCHES

(2) 9-10 INCHES BUT LESS THAN 10 INCHES

(3) 11-12 INCHES OR MORE

[illegible]

MIL-C-43469B

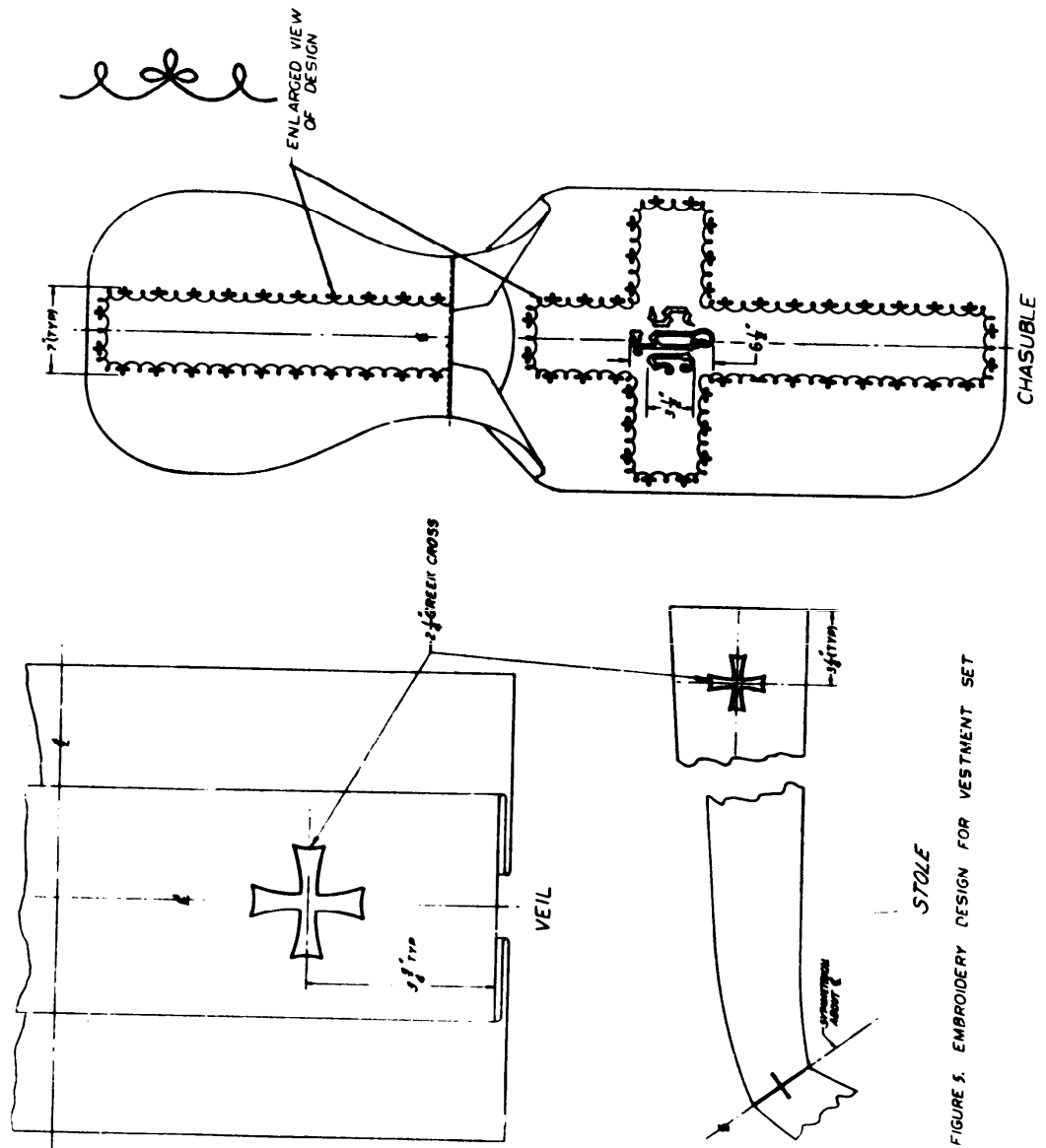


FIGURE 5. EMBROIDERY DESIGN FOR VESTMENT SET

FOLD

DEPARTMENT OF THE ARMY

US ARMY NATICK ~~XXXXXXXXXX~~ Development Center

NATICK, MA 01760

OFFICIAL BUSINESS

PENALTY FOR PRIVATE USE \$300

AMXNM-TDT

POSTAGE AND FEES PAID
DEPARTMENT OF THE ARMY

DOD - 314



Commander

US Army Natick ~~XXXXXXXXXX~~ Development Center

ATTN: STSNL-TDT

Natick, MA 01760

FOLD