

INCH-POUND

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SUPERSEDING  
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## MILITARY SPECIFICATION

CASE, SMALL ARMS AMMUNITION, 30-ROUND MAGAZINE (M-16 RIFLE), LC-1

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

### 1. SCOPE

1.1 Scope. This specification covers one type and size of ammunition case, fabricated from Olive Green nylon duck, webbing, and tape, with miscellaneous metallic hardware and plastic flap closure.

### 2. APPLICABLE DOCUMENTS

#### 2.1 Government documents.

2.1.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: U.S. Army Natick Research, Development, and Engineering Center, Natick, MA 01760-5014 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8465

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## SPECIFICATIONS

## FEDERAL

- A-A-203 - Paper, Kraft, Untreated
- L-P-390 - Plastic, Molding and Extrusion Material, Polyethylene and Copolymers (Low, Medium, and High Density)
- V-T-285 - Thread, Polyester
- DDD-L-20 - Label: For Clothing, Equipage, and Tentage (General Use)
- PPP-B-636 - Boxes, Shipping, Fiberboard

## MILITARY

- MIL-W-4088 - Webbing, Textile, Woven Nylon
- MIL-T-5038 - Tape, Textile and Webbing, Textile, Reinforcing, Nylon
- MIL-W-5625 - Webbing, Textile, Nylon, Tubular
- MIL-H-9890 - Hardware, Individual Load Carrying Equipment: and Hardware, Miscellaneous
- MIL-F-10884 - Fasteners, Snap
- MIL-E-20652/1 - Eyelets, Metallic, Rolled Flange Type; and Eyelet Washer
- MIL-E-20652/3 - Eyelets, Metallic, Telescopic Type
- MIL-W-27265 - Webbing, Textile, Woven Nylon Impregnated
- MIL-L-35078 - Loads, Unit: Preparation of Semiperishable Subsistence Items; Clothing, Personal Equipment and Equipage; General Specification For
- MIL-C-43375 - Cloth, Duck, Nylon, 12.5 Ounce
- MIL-F-43514 - Fastener, Plastic, for Equipage Items

## STANDARDS

## FEDERAL

- 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
- MIL-STD-130 - Identification Marking of U.S. Military Property
- MIL-STD-147 - Palletized Unit Loads
- MIL-STD-731 - Quality of Wood Members for Containers and Pallets

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(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from the Standardization Documents Order Desk, Bldg. 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.)

2.1.2 Other Government documents, drawings, and publications. The following other Government documents, drawings, and publications form a part of this document to the extent specified herein. Unless otherwise specified, the issues are those cited in the solicitation.

## DRAWINGS

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

- |         |   |  |
|---------|---|--|
| 2-2-306 | - | Case, Small Arms Ammunition, 30-Round Magazine M-16 Rifle, LC-1 Assembly                     |
| 2-2-307 | - | Case, Small Arms Ammunition, 30-Round Magazine M-16 Rifle, LC-1; Sub-Assemblies and Sections |
| 2-2-308 | - | Case, Small Arms Ammunition, 30-Round Magazine M-16 Rifle, LC-1; Patterns                    |

(Copies of drawings are available from the U.S. Army Natick Research, Development, and Engineering Center, ATTN: STRNC-EMSS, Natick, MA 01760-5014.)

2.2 Non-Government publications. The following documents form a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DOD adopted are those listed in the issue of the DODISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of the documents cited in the solicitation (see 6.2).

## AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

## D 3951 - Standard Practice for Commercial Packaging

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103-1187.)

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

2.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein the text of this specification takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

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## 3. REQUIREMENTS

3.1 First article. When specified (see 6.2), a sample shall be subjected to first article inspection (see 6.3), in accordance with 4.3.

3.2 Samples. Samples of the end item, when furnished, are solely for guidance and information to the contractor (see 6.4). Variations from this specification may appear in the sample, in which case this specification shall govern.

3.3 Material. It is encouraged that recycled material be used when practical as long as it meets the requirements of this specification.

3.3.1 Cloth, duck, nylon. The 12.5 ounce nylon duck cloth shall be dyed Olive Green 106, and shall conform to class 2 of MIL-C-43375, except that the dimensional stability requirement shall be 3.5 maximum and the air permeability requirement shall be 4.0 maximum (see 6.6).

3.3.2 Tape, nylon. The nylon tape shall be dyed Olive Drab 7 and shall conform to type III, 1 inch wide of MIL-T-5038.

3.3.3 Webbing, woven nylon. The 9/16 inch, type I; the 3/4 inch, type Ia; and the 2-1/4 inch, type VIIIC webbing shall conform to the requirements of MIL-W-4088. The type VIIIC webbing shall be class 2. The webbings shall be dyed Olive Drab 7 to match the standard sample (see 6.4).

3.3.3.1 Resin treatment. The 9/16, 3/4, and 2-1/4 inch webbing shall be resin impregnated to conform to class R of MIL-W-27265.

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

For all stitching except overedging,  
bartacking, binding, and zig zag - Size F

For overedging, bartacking, binding,  
and zig zag - Size E

3.3.4.1 Color. The thread shall be dyed Olive Drab S-1 (C.A. 66022) and shall show fastness to weathering equal to or better than the standard sample (see 6.4). When no standard sample is available, the thread shall show "good" fastness to weathering.

3.3.5 Keeper with slide. The keeper shall be steel, black, and shall conform to type X of MIL-H-9890.

3.3.6 Eyelets, aluminum, black. The black enameled aluminum eyelets shall conform to Dash No. ABE 131 of MIL-E-20652/1.

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3.3.7 Fastener, snap. The snap fastener shall conform to style 2A, finish 2 of MIL-F-10884. The male component shall consist of a stud and size 1 eyelet and the female component shall consist of a size 1 button and socket.

3.3.8 Eyelet and washer. The eyelet and washer shall conform to dash numbers BBE 117 and BBW 101, respectively, of MIL-E-20652/1; or as an alternate, eyelet and washer conforming to dash numbers BBT 307 and BBT 308, respectively, of MIL-E-20652/3 may be used.

3.3.9 Fastener, plastic. The plastic fastener shall be black and shall conform to MIL-F-43514.

3.3.10 Polyethylene stiffener. The stiffener shall be made from 0.040 + 0.007 inch thick, high density virgin polyethylene of natural color conforming to type I, class H, grade 3 of L-P-390 except the melt index shall be 0.10 to 1.0 inclusive. The stiffener may be fabricated from sheet stock or molded to size with its edges finished smooth. The stiffeners fabricated from sheet stock shall be produced in such a manner that the long edges of the pieces shall be parallel with the direction of extrusion (the long edges) of the roll of material from which they are fabricated. The edges shall be smooth and free from cracks and sharp corners.

3.3.11 Webbing, textile, nylon, tubular. The 3/4 inch tubular nylon webbing shall be used in the alternate method of constructing the support strap. The webbing shall conform to the requirements of MIL-W-5625 and shall be dyed olive drab to match the standard sample (see 6.4). The webbing shall be resin impregnated to conform to class R of MIL-W-27265.

3.4 Construction. The construction shall conform in all respects to the drawings listed in section 2 and shall be as specified herein.

3.4.1 Patterns. Standard patterns for textile components other than tape or webbing are shown full scale on drawings and provide allowances for all seams. The standard patterns shall be used as a guide for cutting working patterns. The standard patterns shall not be altered in any way.

3.4.2 Cutting of components. Components covered by a pattern including lengths of fastener tape and webbing components for which the lengths are defined by location marks on the applicable pattern, shall be cut within -0, + 1/8 inch of the applicable pattern, except the cut length of the reinforcement tapes under the front stiffener shall be cut long enough to allow for stitching take-up.

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

For all stitching except  
overedge stitching and  
zig zag stitching

Stitch type 301, 8 to 10  
stitches per inch

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For overedge stitching

Stitch type 503 or 504,  
8 to 10 stitches per  
inch with 3/16 minimum  
gage

For zig zag stitching

Stitch type 304, 3/16  
inch minimum gage with  
10 to 12 stitches per  
inch determined by  
counting points on both  
sides of row of  
stitching

3.4.3.1 Type 301 stitching. Ends of stitching shall be backstitched or overstitched 1 inch minimum except when caught in other stitching or turned under in a hem. Thread tension shall be maintained so that there will be no loose stitching resulting in loose bobbin or top thread or excessively tight stitching resulting in puckering of the materials sewn. The lock shall be imbedded in the materials sewed.

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

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

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

1/ When making the above repairs, the ends of the stitching are not required to be backstitched.

3.4.3.2 Types 503 and 504 overedge stitching. Thread tension shall be maintained so that there will be no loose stitching. All repairs shall be in accordance with 3.4.3.1.1a and 3.4.3.1.1b except substitute 3/4 inch for 1 inch wherever 1 inch appears.

3.4.3.3 Type 304 zig zag stitching. Thread tension shall be maintained so that there will be no loose or excessively tight stitching. Repairs shall be in accordance with 3.4.3.1.1a and 3.4.3.1.1b except the stitching shall overstretch the defective stitching area a minimum of three stitches onto the existing stitching.

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

3.4.3.5 Lubrication of thread. There shall be no lubrication of the thread prior to or during sewing (see 4.4.1.1).

3.4.3.6 Bartacks. Unless otherwise specified, bartacks shall be as specified on the applicable drawing and as follows:

<u>Length</u>	<u>Width</u>	<u>Stitches per bartack</u>
1/2 inch $\pm$ 1/16	1/8 inch $\pm$ 1/32	28
3/4 inch $\pm$ 1/16	1/8 inch $\pm$ 1/32	42

Bartacks shall be free from thread breaks and loose stitching.

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

3.4.4 Fusing of ends of synthetic tape and webbing. All cut ends of synthetic tape and webbing shall be fused. The apparatus used to fuse the tape and webbing ends shall be capable of providing sufficient heat to provide a smooth edge and with the cut ends of the tape yarns all fused together.

3.4.5 Setting of eyelets. Holes shall be prepunched to receive the eyelets. Holes prepunched to receive the eyelets shall be smaller than the outside diameter of the eyelet barrel so that the barrel must be forced through the hole.

3.4.5.1 Eyelets with washer, brass. The brass eyelets with washer specified in 3.3.8 shall be securely clinched in a manner that will prevent detachment from or cutting of the surrounding material. The eyelets shall be clinched without splitting.

3.4.5.2 Eyelets, aluminum. The aluminum eyelets specified in 3.3.6 shall be installed using score setting dies conforming to J.C. Rhodes, part number 1-KW-1KL and 101Y-Klom or Stimpson Co. part number A2744-7 or equal (see 6.5). The eyelet shall be securely set in a manner that will prevent detachment from, or cutting of, the adjacent material. The clinched portion of the eyelet shall be on the inside of the case.

3.4.6 Setting of snap fasteners. A hole shall be prepunched to receive the button and eyelet components of the snap fasteners. The hole shall be smaller than the outside diameter of the button and eyelet barrels so that the barrel must be forced through the hole. The hole shall not be punched in the setting

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operation with the button or eyelet barrel. The fasteners shall be securely clinched without cutting the adjacent materials and no more than three splits shall occur in the button or eyelet barrels.

3.4.7 Setting of plastic fastener. Holes for assembling the fastener components shall be prepunched or predrilled. For setting the female fastener the holes shall be smaller than the diameter of the posts of the latch receptacle so that the posts must be forced through the holes. For setting the male fastener the size of the holes through the fabric and plastic stiffeners shall be of minimum size in order to assure a snug fit with the latch post. Surfaces around the hole edge shall be free of uncut thread ends when prepunched and shall be free of melted residue when predrilled. The posts shall be securely set to provide a tight clinch of the assembled components.

3.5 Marking. The back stiffener shall be permanently and legibly marked with the manufacturer's identification and year of manufacture in accordance with MIL-STD-130 in the location as shown on Drawing 2-2-308. The letters "US" shall be applied in the size characters and in the location indicated on the applicable drawing and shall conform to type IV, class 9 of DDD-L-20. Fastness of class 9 marking shall be as specified for class 5 marking.

3.5.1 Location marks. Location marks shall not be drilled except for locating snap fasteners. Printed markings for component location shall not be more than 1/32 inch wide.

3.6 Repairs. Repairs such as mends, darns, patches, or splices are not permitted on the case.

3.7 Replacement of defective components. During the spreading, cutting, and manufacturing process, components having material defects or damages that are classified as defects in 4.4.3, shall be removed from production and replaced with nondefective and properly matched components.

3.8 Workmanship. The finished and assembled case shall conform to the quality of product established by this specification.

#### 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 (examinations and tests) as specified herein. Except as otherwise specified in the contract or purchase order, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in this specification where such inspections are deemed necessary to ensure supplies and services conform to prescribed requirements.



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4.1.1 Responsibility for compliance. All items shall meet all requirements of sections 3 and 5. The inspection set forth in this specification shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the contractor of the responsibility of ensuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations, is an acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to accept defective material.

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

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

4.2 Classification of inspections. The inspection requirements specified herein are classified as follows:

- a. First article inspection (see 4.3)
- b. Quality conformance inspection (see 4.4)

4.3 First article inspection. When a first article is required (see 3.1 and 6.2), it shall be examined for the defects specified in 4.4.3, 4.4.4, and 4.4.5. Any nonconformance 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.

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 specification or applicable purchase document.

4.4.1.1 Component and material certification. A certificate of compliance may be acceptable as evidence that the case conforms to the requirement specified in 3.4.3.5.

4.4.2 In-process inspection. Inspection shall be made at any point or during any phase of the manufacturing process to determine whether fusing of ends of nylon tape and webbing cut lengths, cut parts, markings for location of components, and location of assembled component parts are in accordance with

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specified requirements. In addition, inspection shall be made to ensure that the working patterns conform to the Government patterns in all respects and that the prepunched holes for receiving eyelets and snap fasteners are as specified in 3.4.5 and 3.4.6. Whenever nonconformance is noted, corrections shall be made to the parts affected and lot in process. Parts which cannot be corrected shall be removed from production.

4.4.3 End item visual examination. The end items shall be examined for the defects listed in table I. The lot size shall be expressed in units of cases. The sample unit shall be one case. 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 10 for total (major and minor combined) defects.

TABLE I. End item visual defects

Examine	Defect	Classification	
		Major	Minor
Fabric	Hole, cut, tear, smash, broken or missing yarn, or open place clearly visible at normal inspection distance (approximately 3 feet)	101	
	Shade bar, abrasion mark		201
Tape and webbing	Not firmly and tightly woven, edges frayed or scalloped	102	
	Multiple floats		202
	Any cut, hole, tear, or smash	103	
	Abrasion mark, slub, broken end or pick		203
	Exposed ends of tape and webbing not fused as specified		204
Metal hardware (general)	Broken or malformed failing to serve intended purpose, corroded area, burr, or sharp edge	104	
	Finish omitted, partially omitted or not as specified:		
	-On brass or aluminum components		205
	-On steel components	105	
	Not assembled as specified (unless otherwise classified herein)	106	
	Not specified type, size, or style	107	

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TABLE I. End item visual defects (cont'd)

Examine	Defect	Classification	
		Major	Minor
Eyelet with washer	Clinched excessively tight, cutting adjacent material	108	
	Insecurely clinched to a degree that eyelet may be detached from material	109	
	Loosely clinched, permitting eyelet to rotate freely within the hole		206
	Washer omitted	110	
Eyelet without washer	Insecurely clinched or clinched excessively tight, cutting fabric	111	
	Installed with scored side on outside of case		207
	Not set with a scored setting		208
Keeper, slide	Slide component of keeper jams in open, partly closed or closed position	112	
	NOTE: Check operation of keeper(s) by fully opening and closing.		
	Not inserted through channels in keeper retainer as indicated on drawing		209
Snap fastener(s)	Any fastener not functioning properly, i.e., fails to snap closed, provide a secure closure, or to open freely	113	
	NOTE: The fastener shall be snapped and unsnapped twice to determine whether parts of fastener separate freely and also effect a secure closure.		
	Clinched excessively tight, cutting adjacent material	114	
	Clinched loosely, permitting any component to rotate freely but not to the degree that any component can be expected to become detached during use		210
	Clinched loosely to the degree that components can be expected to become detached during use	115	

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TABLE I. End item visual defects (cont'd)

Examine	Defect	Classification	
		Major	Minor
	NOTE: Incomplete roll of end of button or eyelet barrel is evidence of improper and insecure clinching.		
	Incorrect style	116	
	More than three splits in eyelet or button barrels		211
Plastic fastener	Not as specified	117	
	Broken, cracked, chipped, or malformed, failing to serve intended purpose; burr, sharp edge, or flash	118	
	Color and finish not as specified		212
	Not functioning properly, failing to effect a secure closure or open freely	119	
	Improperly or insecurely clinched	120	
	Locking clip or female fastener not set within cut-out of front stiffener	121	
Polyethylene stiffener	Sharp corners, edges not smooth		213
	Cracked		214
Open seam	1/2 inch or less		215
	More than 1/2 inch	122	
	NOTE: A seam shall be classified as open when one or more stitches joining a seam are broken, or when two or more consecutive skipped or runoff stitches occur.		
Raw edge (on edge required to be finished)	More than 1/2 inch in length when securely caught in stitching	123	
	NOTE: Raw edge not securely caught in stitching shall be classified as an open seam.		

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TABLE I. End item visual defects (cont'd)

Examine	Defect	Classification	
		Major	Minor
Runoff (see open seam)			
Seam and stitch type	Wrong seam or stitch type	124	
Bartacks	One or more bartacks omitted	125	
	Any bartack not as specified or not in specified location		216
	Loose stitching, incomplete or broken		217
Stitch tension	Loose, resulting in a loose bobbin or top thread		218
	Excessively tight, resulting in puckering of material		219
Stitches per inch	One stitch less than minimum specified		220
	Two or more stitches less than minimum specified	126	
	One or more stitches in excess of maximum specified		221
NOTE: Variation in the number of stitches per inch caused by the operator speeding up the machine and pulling the materials in order to sew over heavy places or heavy seams, or in turning corners shall be classified as follows: (a) Within the minor defect classification - no defect (b) Within the major defect classification - minor defect			
Thread breaks, skipped stitches, runoffs	Not overstitched as specified		222

NOTE: Thread breaks or two or more consecutive skipped or runoff stitches not overstitched shall be classified as open seams.

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TABLE I. End item visual defects (cont'd)

Examine	Defect	Classification	
		Major	Minor
Ends of stitching	Not secured as specified		223
Rows of stitching	Any row missing except on hanger webbing	127	
	On hanger webbing stitch patterns: (applicable each pattern)		224
	- One row of stitching omitted - Two or more rows of stitching omitted	128	
Components and assembly	Any component part omitted or not as specified or any required operation omitted (unless otherwise classified herein)	129	
	Needle chews	130	
	Any mend, darn, patch, or splice	131	
Binding	Loosely applied but not exposing raw edge of material		225
	Loosely applied exposing raw edge of material	132	
Marking	Omitted, illegible, incorrect, or misplaced		226
Location markings	Drilled	133	
	Printed marking more than 1/32 inch in width		227
Cleanness	Any spot or stain clearly noticeable		228
Thread ends	Not trimmed to 1/4 inch maximum length		229

4.4.4 Fit examination. The end items shall be examined for the defects listed below. The lot size shall be expressed in units of cases. The sample unit shall be one case. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 0.65.

<u>Examine</u>	<u>Defect</u>
Fit of magazines into case and closure of flap	Case too small, i.e., magazines fail to fit properly within the case.

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NOTE: The magazines shall be inserted into the case with each magazine separated by the spacer straps. The open ends of the magazines shall face up with the outline of the ammunition at the open end pointing towards the front of the case. It shall be possible to insert the magazine within the case without effort other than that necessary to overcome friction between the magazines and the case. A defect shall be scored if any magazine must be forced into the case.

ExamineDefect

Fit of magazines into case and closure of flap (cont'd)

Case body or flap too short, causing inability to secure fastener without applying excessive force.

NOTE: With the three magazines in the case the case flap shall be closed and the fastener shall be secured. It shall be possible to secure the fastener without effort other than that necessary to insert the latch into the latch receptacle. A defect shall be scored if it is necessary to force the flap down in order to secure the fastener.

Fit of grenade into grenade pocket(s)

Grenade pocket(s) too small, i.e., grenade fails to fit properly within pocket.

NOTE: The grenade fit examination shall be performed with a dummy wooden grenade to be furnished by the contracting activity (see 6.4). The examination shall be performed with the three magazines properly installed in the case and with the flap closed. Insert the grenade into the pocket with the safety pin on top and the release handle positioned adjacent to one of the pocket-to-case joining seams. It shall be possible to insert the grenade fully within each pocket without effort other than that necessary to overcome friction between the grenade and the pocket(s). A defect shall be scored if the grenade must be forced into the pocket(s).

Grenade retaining strap too short, causing inability to secure snap fastener without applying excessive force.

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NOTE: With the grenade in the pocket(s) it shall be possible to secure the grenade retaining strap without having to put excessive force on the strap to the degree that the strap is under tension after being secured.

4.4.5 End item dimensional examination. The end items shall be examined for conformance to the dimensions specified on Drawings 2-2-306 and 2-2-307. Only those dimensions that can be evaluated without damaging or disassembling the end items shall be examined. Any dimension not within the specified tolerance shall be classified as a defect. The lot size shall be expressed in units of cases. The sample unit shall be one case. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 10.

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

<u>Examine</u>	<u>Defect</u>
Marking (exterior and interior)	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application
Materials	Any component missing, damaged, or not as specified
Workmanship	Inadequate application of components, such as: incomplete sealing or closure of flap, improper taping, loose strapping, or inadequate stapling Bulged or distorted container
Content	Number per container is more or less than required

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

<u>Examine</u>	<u>Defect</u>
Finished dimensions	Length, width, or height exceeds specified maximum requirement



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Palletization	Pallet pattern not as specified Interlocking of loads not as specified Load not bonded as specified
Weight	Exceeds maximum load limits
Marking	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application

## 5. PACKAGING

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

5.1.1 Level A preservation. Each case shall have all fasteners and keepers closed. Ten cases, each alternately reversed top to bottom, shall be evenly stacked and securely crosstied with cotton tape or twine to form a bundle measuring approximately 12-1/2 by 8 by 5 inches.

5.1.2 Commercial preservation. The cases shall be preserved in accordance with ASTM D 3951.

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

5.2.1 Level A packing. One hundred and twenty cases, preserved as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC-L, grade V2s of PPP-B-636. The inside of each fiberboard container shall be fitted with a box liner conforming to type CF, class weather resistant, variety DW, grade V15c of PPP-B-636. Level A unit packs shall be packed upright, four in length, three in width, and one in depth within a shipping container. Inside dimensions of each shipping container shall approximate 24-1/2 inches in length, 20-1/2 inches in width, and 12-1/2 inches in depth. Approximate dimensions are furnished as a guide only. Each container shall have the contents completely covered on the top and bottom with a sheet of 30-pound minimum basis weight kraft paper conforming to A-A-203. Each shipping container shall be closed with method III, waterproofed with method V, and reinforced as specified in the appendix of PPP-B-636 except the inspection shall be in accordance with 4.4.6. Shipping containers shall be arranged in unit loads in accordance with MIL-L-35078 for the type and class of load specified (see 6.2). Strapping shall be limited to nonmetallilc strapping, except for type II, class F loads.

5.2.2 Level B packing. One hundred and twenty cases, preserved as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC-L, type CF, (variety SW) or SF, class domestic, grade 275 of PPP-B-636. The inside of each fiberboard container shall be fitted with a box liner conforming to type CF, class domestic, variety DW, grade 275 of PPP-B-636. Level A unit packs shall be packed upright, four in length, three in width, and one in depth

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within a shipping container. Inside dimensions of each shipping container shall approximate 24-1/2 inches in length, 20-1/2 inches in width, and 12-1/2 inches in depth. Approximate dimensions are furnished as a guide only. Each container shall have the contents completely covered on the top and bottom with a sheet of 30-pound minimum basis weight kraft paper conforming to A-A-203. Each shipping container shall be closed in accordance with method II as specified in the appendix of PPP-B-636, except the inspection shall be in accordance with 4.4.6.

5.2.2.1 Weather-resistant fiberboard containers. When specified (see 6.2), the shipping container shall be a grade V3c, V3s, or V4s fiberboard box fabricated in accordance with PPP-B-636 and closed in accordance with method III as specified in the appendix of PPP-B-636, except the inspection shall be in accordance with 4.4.6.

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

5.3 Palletization. When specified (see 6.2), cases packed as specified in 5.2.2 or 5.2.3, shall be palletized on a 4-way entry pallet in accordance with load type Ia of MIL-STD-147. Pallet types shall be type I (4-way entry), type IV, or type V in accordance with MIL-STD-147. Pallets shall be fabricated from wood groups I, II, III, or IV of MIL-STD-731. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding means C and D or film bonding means F or G. Pallet pattern shall be No. 90 in accordance with appendix of MIL-STD-147. Interlocking of loads shall be effected by reversing the pattern of each course.

5.4 Marking. In addition to any special marking required by the contract or purchase order, unit packs, shipping containers, and palletized unit loads shall be marked in accordance with MIL-STD-129 or ASTM D 3951, as applicable. Each unit pack shall have attached a manila colored paper shipping tag for the identification information.

## 6. NOTES

(This section contains information of a general or explanatory nature that may be helpful, but is not mandatory.)

6.1 Intended use. The case is designed to accommodate three 30-round ammunition magazines for the M-16 rifle. Magazine spacer straps are provided for separating individual magazines, and grenade pockets with retainer straps are provided for carrying grenades. The case is provided with a support strap for attachment to the suspender snaphook and two keepers with slide for attaching to the belt, individual equipment.

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6.2 Acquisition requirements. Acquisition documents must specify the following:

- a. Title, number, and date of this specification.
- b. Issue of DODISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.1.1 and 2.2).
- c. When first article is required (see 3.1, 4.3, and 6.3).
- d. Levels of preservation and packing (see 5.1 and 5.2).
- e. Type and class of unit load (see 5.2.1).
- f. When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).
- g. When palletization is required (see 5.3).

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

6.4 Samples. For access to samples magazines and the dummy grenade required for the fit examination in 4.4.4, address the contracting activity issuing the invitation for bids.

6.5 Die, eyelet, score setting. Sources of supply for the score setting eyelet die specified in 3.4.5.2 are, J. C. Rhodes and Company, Box B-962, New Bedford, MA 02745 or Stimpson Co., Bayport, NY 11705.

6.6 Nylon cloth cut edges. The cut edges of the nylon cloth specified in 3.3.1 are subject to fraying during the process of handling the cut parts during fabrication of the case. It has been found that fusing of the cut edges of the cloth will prevent fraying.

6.7 International standardization agreements. Certain provisions of this document are the subject of international standardization agreement number STANAG 2311. When amendment, revision, or cancellation of this document is proposed which will effect or violate the international agreement concerned, the preparing activity will take appropriate reconciliation action through international standardization channels including departmental standardization offices, if required.

6.8 Subject term (key word) listing.

Belt  
Grenade carrier  
Individual equipment  
Suspenders

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6.9 Changes from previous issue. Marginal notations are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.

Custodians:

Army - GL  
Navy - NU  
Air Force - 99

Preparing activity:

Army - GL  
(Project 8465-0031)

Review activities:

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

User activity:

Navy - YD

# STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

## INSTRUCTIONS

1. The preparing activity must complete blocks 1, 2, 3, and 8. In block 1, both the document number and revision letter should be given.
2. The submitter of this form must complete blocks 4, 5, 6, and 7.
3. The preparing activity must provide a reply within 30 days from receipt of the form.

NOTE: This form may not be used to request copies of documents, nor to request waivers, or clarification of requirements on current contracts. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements.

<b>I RECOMMEND A CHANGE:</b>		1. DOCUMENT NUMBER MIL-C-43827D	2. DOCUMENT DATE (YYMMDD) 90/03/30
3. DOCUMENT TITLE CASE, SMALL ARMS AMMUNITION, 30-ROUND MAGAZINE (M-16 RIFLE), LC-1			
4. NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)			
5. REASON FOR RECOMMENDATION			
6. SUBMITTER			
a. NAME (Last, First, Middle Initial)		b. ORGANIZATION	
c. ADDRESS (Include Zip Code)		d. TELEPHONE (Include Area Code) (1) Commercial (2) AUTOVON (if applicable)	7. DATE SUBMITTED (YYMMDD)
8. PREPARING ACTIVITY			
a. NAME U.S. Army Natick Research, Development, and Engineering Center ATTN: STRNC-ES		b. TELEPHONE (Include Area Code) (1) Commercial (508)651-5221 (2) AUTOVON 8-256-5221	
c. ADDRESS (Include Zip Code) Kansas Street Natick, MA 01760-5014		IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT: Defense Quality and Standardization Office 5203 Leesburg Pike, Suite 1403, Falls Church, VA 22041-3466 Telephone (703) 756-2340 AUTOVON 289-2340	