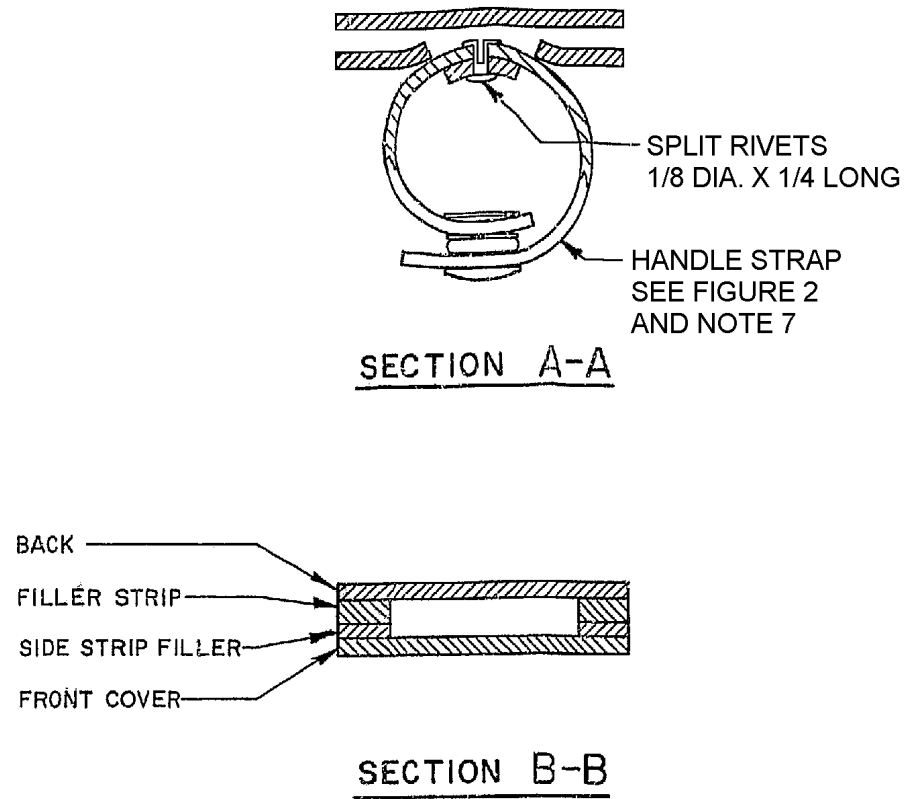


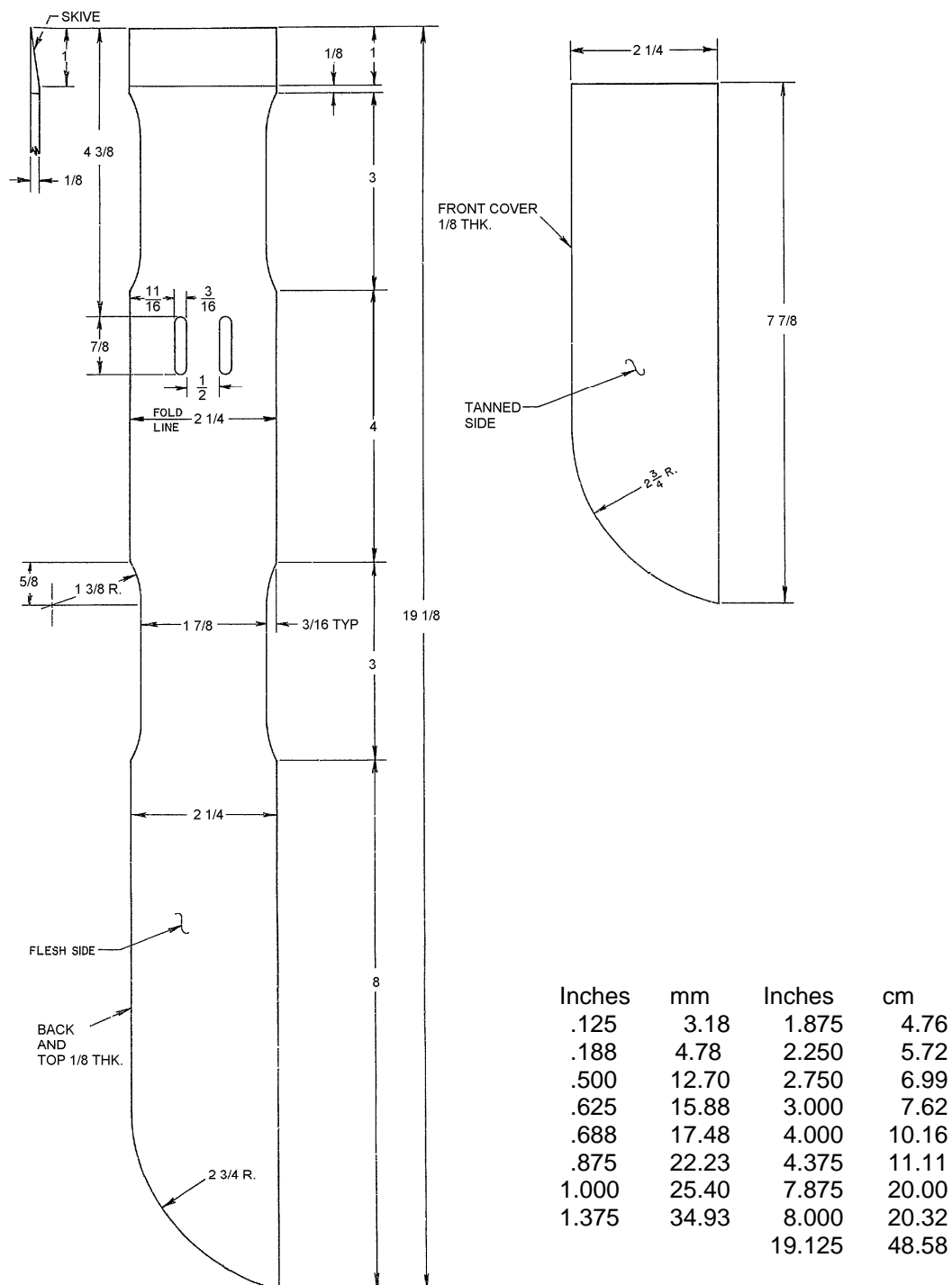
MIL-DTL-20277/2



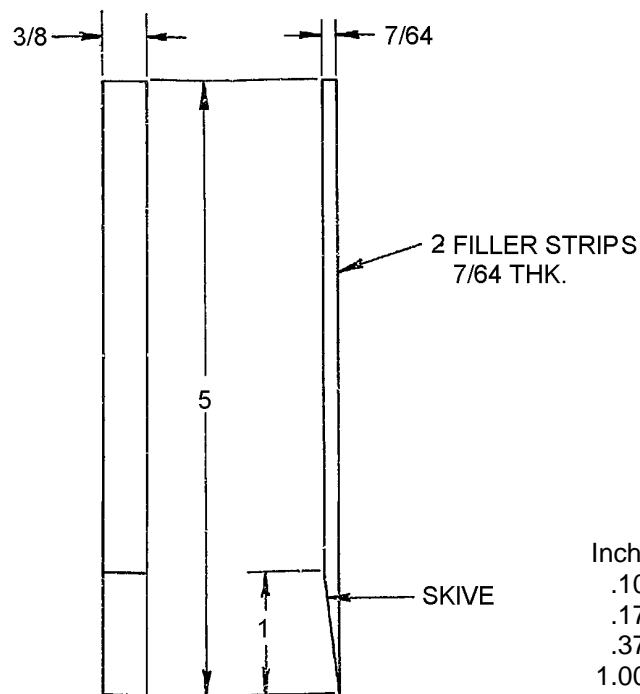
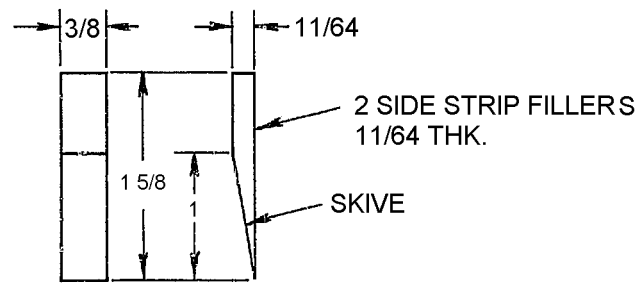
Inches	mm
.125	3.18
.250	6.35

FIGURE 1. Sheath dimensions and configuration - Continued.

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FIGURE 1. Sheath dimensions and configuration - Continued.

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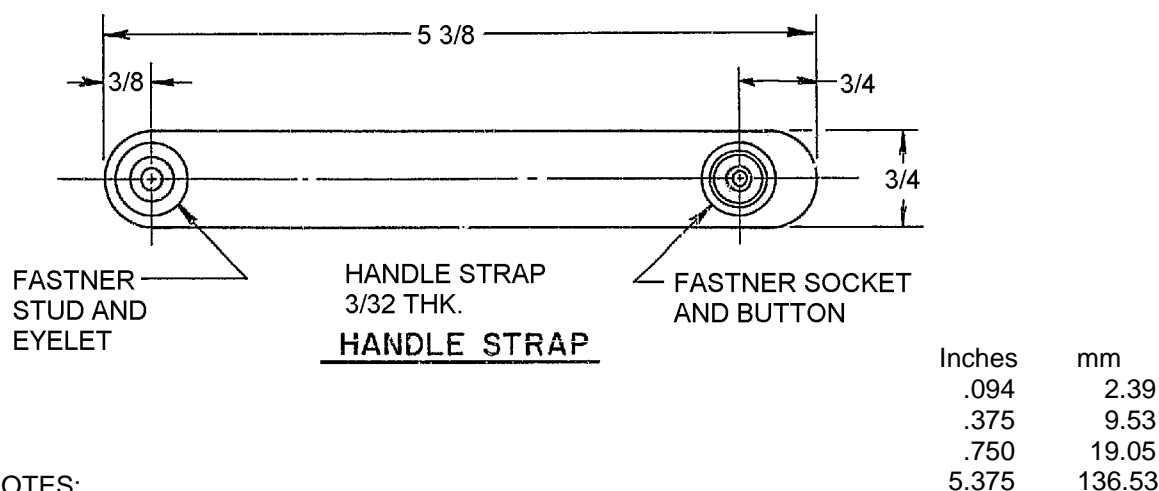
Inches	mm
.109	2.77
.172	4.37
.375	9.53
1.000	25.40
1.016	25.80
1.625	41.28
5.000	127.00

NOTES:

1. Dimensions are in inches.
2. Metric equivalents are given for information only.
3. Unless otherwise specified, tolerances are as follows: Fractions $\pm 1/64$ inch, three place decimals $\pm .005$ inch (0.13 mm).
4. Skived end of top to be firmly attached by stitches and rivets.
5. $3/16$ inch diameter hole shall be punched (not cut) after assembly of the sheath.
6. Rivet location approximately as shown.
7. The handle strap (see figure 2) for holding the knife handle shall be riveted to the sheath at its longitudinal center. The knife handle strap when closed shall prevent movement of the knife when the sheath is inverted or jarred.
8. All cut edges shall be colored to closely match the finished leather.

FIGURE 1. Sheath dimensions and configuration - Continued.

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NOTES:

1. Dimensions are in inches.
2. Metric equivalents are given for information only.
3. Unless otherwise specified, tolerances are as follows: Fractions $\pm 1/64$ inch.
4. All cut edges shall be colored to closely match the finished leather.

FIGURE 2. Handle strap dimensions and configuration

REQUIREMENTS:

Dimensions and configurations: The design, construction, and physical dimensions shall be in accordance with MIL-DTL-20277 and on figure 1 in case of conflict between this drawing and MIL-DTL-20277, this drawing shall govern.

Intended use. This sheath is intended for use with knives in accordance with MIL-DTL-20277/1.

Material:

Leather. Leather shall be in accordance with MIL-DTL-32068, type 2, class 1. Colorfastness not applicable.

Stud and socket fasteners. Stud and socket fasteners shall be in accordance with NASM27980, Part or Identifying Number (PIN) MS27980-1B (button), MS27980-6B (socket), MS27980-7B (stud), or MS27980-8B (eyelet) as applicable.

Rivets. Rivets shall be in accordance with MS35684-2 (1/8 dia. X 5/16 inch long), MS35684-3 (1/8 dia. X 3/8 inch long), and MS35684-5 (1/8 dia X 1/2 inch long).

Sewing thread. Nylon thread accordance with V-T-295, type I or II, class A, letter size F.

Sheath construction:

Sheath leather cuttings. The leather sheath shall consist of a one-piece back section and a one-piece front section forming a pocket for the knife blade in accordance with MIL-DTL-20277/1.

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The front welt and back sections shall be sewn and riveted together along the edges. Flesh side of leather to be on insides of assembled sheath.

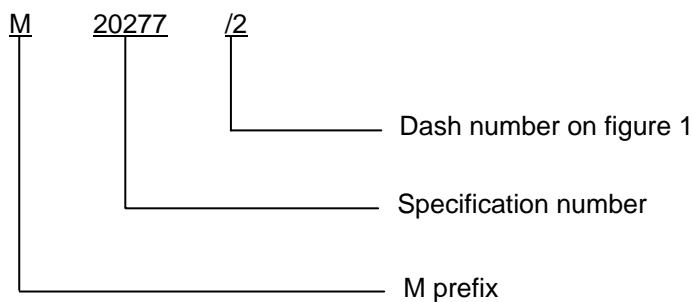
Sewing: Stitching: Stitching shall be in accordance with ASTM D6193, stitch type 301, five to seven stitches per inch (25.4 mm). The stitching shall be straight and parallel to the leather edge. The stitch shall not contain any thread breaks, skips, runoff, or needle chews. The thread ends shall be neatly trimmed.

Riveting: The sheath shall be riveted together. The head of the rivet shall be on the upper side of the sheath and the split portion shall be flat against the underside of the sheath. All sharp edges shall be removed or turned under. The rivets shall be securely set but shall not straddle or cut the stitching, or unduly cut into the leather.

After assembly, the sheath shall be trimmed to remove all loose ends, and rough edges shall be dyed to match the finished leather.

Color. Color shall be black in accordance with MIL-DTL-20277.

PIN example:



Referenced documents. In addition to MIL-DTL-20277, this document references the following:

MIL-DTL-20277/1	V-T-295
MIL-DTL-32068	ASTM D6193
NASM27980	

MIL-DTL-20277/2

CONCLUDING MATERIAL

Custodians:

Army - AR
Navy - SH
Air Force - 99
DLA - CC

Preparing activity:

DLA - CC

(Project 1095-2007-005)

Review activities:

Army - CR4, GL
Navy - CG, MC, SA

NOTE: The activities listed above were interested in this document as of the date of this document. Since organizations and responsibilities can change, you should verify the currency of the information above using the ASSIST Online database at <http://assist.daps.dla.mil>.