

INCH-POUND

MIL-DTL-62474F  
w/AMENDMENT 1  
21 May 2008  
SUPERSEDING  
MIL-DTL-62474F  
29 November 2007

## DETAIL SPECIFICATION

### LAMINATE: ARAMID-FABRIC-REINFORCED, PLASTIC

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

#### 1. SCOPE

1.1 Scope. This specification covers an aramid fabric-reinforced plastic laminate for use in composite armor systems.

1.2 Classification. Laminates will be of the type and class specified (see 6.2):

- |          |  |
|----------|--|
| Type 1   | - Flat.  |
| Type 2   | - Molded.  |
| Class A  | - Yarn used, nominal 1500 Denier, minimal 975 filaments. Basket weave  |
| Class B  | - Yarn used, nominal 3000 Denier, minimal 1300 filaments. Basket weave |
| Class C  | - Yarn used, nominal 3000 Denier, minimal 1300 filaments. Plain weave  |
| Class D* | - Yarn used, nominal 3000 Denier, minimal 1300 filaments. Plain weave  |
|          | *(low resin content variant)   |

Comments, suggestions, or questions on this document should be addressed to U.S. Army Tank-automotive and Armaments Command, ATTN: AMSRD-TAR-E/CM/DM/STND, MS# 268 Warren, MI 48397-5000 or emailed to [DAMI\\_STANDARDIZATION@conus.army.mil](mailto:DAMI_STANDARDIZATION@conus.army.mil). Since contact information can change, you may want to verify the currency of this address information using the ASSIST Online database at <http://assist.daps.dla.mil>.

AMSC N/A

FSC 9330

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2.3 Non-Government publications. The following documents form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those cited in the solicitation or contract.

ASTM INTERNATIONAL

- |            |   |  |
|------------|---|--|
| ASTM D123  | - | Standard Terminology Relating to Textiles (DoD Adopted)  |
| ASTM D629  | - | Standard Test Methods for Quantitative Analysis of Textiles (DoD Adopted)                                  |
| ASTM D2563 | - | Standard Practice for Classifying Visual Defects in Glass-Reinforced Plastic Laminate Parts (DoD Adopted). |
| ASTM D3775 | - | Standard Test Method for Warp (End) and Filling (Pick) Count of Woven Fabrics (DoD Adopted).               |
| ASTM D3776 | - | Standard Test Method for Mass Per Unit Area (Weight) of Fabric (DoD Adopted).                              |

(Copies of the above documents are available from ASTM International, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959 or through their website at <http://www.astm.org>)

SAE INTERNATIONAL

- |          |   |   |
|----------|---|---|
| AMS 3902 | - | Cloth, Organic Fiber (Para-Aramid), High Modulus for Structural Composites (DoD Adopted). |
|----------|---|---|

(Copies of the above documents are available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096 or through their website at <http://www.sae.org>)

2.4 Order of precedence. Unless otherwise noted herein or in the contract, in the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

### 3. REQUIREMENTS

3.1 First article. When specified (see 6.2), a sample shall be subjected to first article inspection in accordance with 4.2.

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3.2 Materials. Materials used shall be in accordance with the manufacturer's materials specifications for aramid fabrics. The materials shall be capable of meeting all the operational and environmental requirements specified herein (see 4.4).

3.2.1 Aramid fabrics.

3.2.1.1 Class A laminates. The aramid fabric reinforcement used in class A laminates shall be woven from an aramid yarn of nominal 1500 denier, minimal 975 filaments, 1 percent finish. All yarn shall be of the same production lot as defined in ASTM D123. The fabric construction shall be  $42 \pm 2$  ends per 25.4 mm by  $42 \pm 2$  picks per 25.4 mm in a 7 x 7 basket weave as determined by ASTM D3775. Yarns shall have zero twist (see 4.4).

3.2.1.2 Class B laminates. The aramid fabric reinforcement used in class B laminates shall be woven from an aramid yarn of nominal 3000 denier, minimal 1300 filaments, 1 percent finish. All yarn shall be of the same production lot as defined in ASTM D123. The fabric construction shall be  $21 \pm 1$  ends per 25.4 mm by  $21 \pm 1$  picks per 25.4 mm in a 4 x 4 or 2 x 2 basket weave as determined by ASTM D3775. Yarns shall have zero twist (see 4.4).

3.2.1.3 Class A and class B. The aramid fabrics described in 3.2.1.1 and 3.2.1.2, shall have a moisture-free weight of  $16.25 \pm 0.75$  ounces per square yard ( $\text{oz/yd}^2$ ) [ $551 \pm 25$  grams per square meter ( $\text{g/m}^2$ )] as determined by ASTM D3776 (option C) after drying in accordance with Section 9 of ASTM D629. The sample shall be dried until the loss in mass is minimal or when a constant mass has been reached. This constant mass shall be considered the moisture-free weight. If sizing is used in the weaving process, it shall be a water soluble polyvinyl alcohol. If sizing is used, the fabric shall be cleaned (scoured) to a maximum content of 0.5 weight percent of the moisture-free fabric weight. The maximum moisture content of the aramid fabric after weaving or weaving and scouring shall be five (5) percent by weight as determined by ASTM D629, Section 9. Fabric quality shall conform to paragraph 3.3 of AMS 3902. Selvages shall be woven or three-end leno. Tension in warp and fill shall be adequate to assure uniform fabric construction after resin coating/impregnation (see 4.4).

3.2.1.4 Class C and class D laminates. The aramid fabric reinforcement used in class C and D laminates shall be woven from an aramid yarn of nominal 3000 denier, minimal 1300 filaments, 1 percent finish. All yarn shall be of the same production lot as defined in ASTM D123. The fabric construction shall be  $17 \pm 1$  ends per 25.4 mm by  $17 \pm 1$  picks per 25.4 mm in a plain weave as determined by ASTM D3775. Yarns shall have zero twist (see 4.4).

3.2.1.5 Class C and class D. The aramid fabric described in 3.2.1.4, shall have a moisture-free weight of  $13.5 \pm 1.0$  ounces per square yard ( $\text{oz/yd}^2$ ) [ $450 \pm 30$  grams per square meter ( $\text{g/m}^2$ )] as determined by ASTM D3776 (option C) after drying in accordance with Section 9 of ASTM D629. The sample shall be dried until the loss in mass is minimal or when a constant mass has been reached. This constant mass shall be considered the moisture-free weight. If sizing is used in the weaving process, it shall be a water soluble polyvinyl alcohol. If

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sizing is used, the fabric shall be cleaned (scoured) to a maximum content of 0.5 weight percent of the moisture-free fabric weight. The maximum moisture content of the aramid fabric after weaving or weaving and scouring shall be five (5) percent by weight as determined by ASTM D629, Section 9. Fabric quality shall conform to paragraph 3.3 of AMS 3902. Selvages shall be woven or three-end leno. Tension in warp and fill shall be adequate to assure uniform fabric construction after resin coating/impregnation (see 4.4).

3.2.2 Laminating resin. The resin for coating and laminating the aramid fabric laminate shall be a catalyzed system composed of a mixture of phenol formaldehyde and polyvinyl butyral resins. Resin coating of the fabric shall be uniform and accomplished by continuous preimpregnation of the fabric. Moisture content of the aramid fabric shall be determined in accordance with Section 9 of ASTM D629. The sample shall be dried until the loss in mass is reduced to less than two (2) percent prior to resin coating. Resin content of class A, B and C aramid laminate after coating shall be 18 to 22 weight percent solids (volatile free) based on the weight of aramid fabric as determined by ASTM D3776 (option C) with moisture content reduced to less than 2 percent. Resin content of the class D aramid laminate after coating shall be 12 to 18 weight percent solids (volatile free) based on the weight of aramid fabric as determined by ASTM D3776 (option C) with moisture content reduced to less than 2 percent. NOTE: A sample of resin coated fabric that has been placed in a forced air circulating oven at  $330 \pm 10$  degrees Fahrenheit ( $^{\circ}\text{F}$ ) [ $154 \pm 6$  degrees Celsius ( $^{\circ}\text{C}$ )] for 60 minutes is considered to be volatile free (see 4.4).

3.2.3 Recycled, recovered, or environmentally preferable materials. Recycled, recovered, or environmentally preferable materials should be used to the maximum extent possible, provided that the material meets or exceeds the operational and maintenance requirements, and promotes economically advantageous life cycle costs.

### 3.3 Construction (fabrication).

3.3.1 Dimensions and structure. The plastic laminates shall be of the dimensions stated in the acquisition documents (see 6.2). The class A and B laminates shall consist of the specified number of plies of resin-coated aramid fabric reinforcement bonded together in a single molding step with heat and pressure. The laminates shall be built up from individual plies of fabric with no fabric gap or selvage in any individual ply (see 4.3.3 and 4.4). Class C and D laminates shall consist of whatever number of plies required for the specified areal density of the finished laminate.

3.3.1.1 Thickness and flatness variation. The thickness at any point more than one in. from an edge shall not vary from the nominal thickness of the panel by more than  $\pm 0.015$  in. (0.38 mm) for type I and  $\pm 0.030$  in. (0.76 mm) for type II. Variation from flatness for each finished panel shall not exceed 0.06 inch per foot (in/ft) (5.00 millimeters per meter (mm/m) (See 4.3.3 and 4.4).

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3.3.1.2 Weights. The unit weight or areal density of the finished class A or class B laminates shall fall within the ranges established by table I (see 4.3.4.1).

TABLE I. Finished laminate unit weights for Class A and Class B. 1/

Plies wt (lb/ft <sup>2</sup> )		Plies wt (lb/ft <sup>2</sup> )		Plies wt (lb/ft <sup>2</sup> )		Plies wt (lb/ft <sup>2</sup> )	
1	0.127-0.152	11	1.40-1.67	21	2.67-3.18	31	3.95-4.69
2	0.255-0.303	12	1.53-1.82	22	2.80-3.33	32	4.08-4.85
3	0.382-0.454	13	1.65-1.97	23	2.93-3.48	33	4.20-5.00
4	0.510-0.606	14	1.78-2.12	24	3.06-3.64	34	4.33-5.15
5	0.637-0.757	15	1.91-2.27	25	3.18-3.79	35	4.46-5.30
6	0.765-0.908	16	2.04-2.42	26	3.31-3.94	36	4.59-5.45
7	0.892-1.06	17	2.16-2.58	27	3.44-4.09	37	4.71-5.60
8	1.02-1.21	18	2.29-2.73	28	3.57-4.24	38	4.84-5.75
9	1.14-1.37	19	2.42-2.88	29	3.69-4.39	39	4.97-5.91
10	1.27-1.57	20	2.55-3.03	30	3.82-4.54	40	5.10-6.06

1/ pounds per square foot (lb/ft<sup>2</sup>)

TABLE Ia. Finished laminate unit weights for Class A and Class B. 1/

Plies wt (kg/m <sup>2</sup> )		Plies wt (kg/m <sup>2</sup> )		Plies wt (kg/m <sup>2</sup> )		Plies wt (kg/m <sup>2</sup> )	
1	0.62-0.74	11	6.84-8.15	21	13.04-15.53	31	19.29-22.90
2	1.25-1.48	12	7.47-8.89	22	13.67-16.26	32	19.92-23.68
3	1.87-2.22	13	8.06-9.62	23	14.31-16.99	33	20.51-24.41
4	2.49-2.96	14	8.69-10.35	24	14.94-17.77	34	21.14-25.15
5	3.11-3.70	15	9.33-11.08	25	15.53-18.51	35	21.78-25.88
6	3.74-4.43	16	9.96-11.82	26	16.16-19.24	36	22.41-26.61
7	4.36-5.18	17	10.55-12.60	27	16.80-19.97	37	23.00-27.34
8	4.98-5.91	18	11.18-13.33	28	17.43-20.70	38	23.63-28.08
9	5.57-6.69	19	11.82-14.06	29	18.02-21.44	39	24.27-28.86
10	6.20-7.42	20	12.45-14.80	30	18.65-22.17	40	24.90-29.59

1/ kilograms per square meter (kg/m<sup>2</sup>)

3.3.2 Lamination pressures and temperatures. The following conditions shall prevail during lamination processes (see 4.3.3):

- a. Type I and II.
  1. Type I (flat) laminates shall be press-molded at 250  $\pm$ 10 pounds per square inch (psi) [1725  $\pm$ 69 kilopascals (kPa)].
  2. Type II (molded) laminates shall be press-molded at 200  $\pm$ 10 psi (1380  $\pm$ 69 kPa) or may be autoclaved at 50 psi (345 kPa) minimum.

Pressures indicated above shall be maintained until the following stages have been completed.

- b. Type I and II (except autoclave).

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1. Press platen temperature increased to  $330 \pm 10^{\circ}\text{F}$  ( $166 \pm 6^{\circ}\text{C}$ ).
  2. Dwell in accordance with schedule of Table II (Class A and B) with platens at  $330 \pm 10^{\circ}\text{F}$  ( $166 \pm 6^{\circ}\text{C}$ ). Use Table IIa for dwell time based upon areal densities (AD) of the ply layup for class C and D laminates.
  3. Press platen temperature reduced to a maximum of  $180^{\circ}\text{F}$  ( $82^{\circ}\text{C}$ ) before laminate removal.
- c. Type II (autoclave)
1. Autoclave temperature increased to  $330 \pm 10^{\circ}\text{F}$  ( $166 \pm 6^{\circ}\text{C}$ ).
  2. Dwell in accordance with Table II (Class A and B) with autoclave at  $330 \pm 10^{\circ}\text{F}$  ( $166 \pm 6^{\circ}\text{C}$ ). Use Table IIa for dwell time based upon areal densities (AD) of the ply layup for class C and D laminates.
  3. Autoclave temperature reduced to a maximum of  $180^{\circ}\text{F}$  ( $82^{\circ}\text{C}$ ) before laminate removal.

TABLE II. Laminating dwell times for Class A and B.

Laminate plies (number)	Dwell time (minutes)
1-10	30
11-20	45
21-30	75
31-40	75

TABLE IIa. Laminating dwell times for Class C and D.

Laminate AD (psf)	Dwell time (minutes)
< 1.5	30
1.5 – 3.0	45
3.0 – 4.5	75
> 4.5	75

**3.3.3 Finished laminate.** The finished laminates shall consist of the specified number of plies (A and B) or areal density (C and D) sandwiched between single peel-ply which can be incorporated in the lamination process. Peel-ply coated with a release agent shall not transfer to the laminate surfaces. All cutting and machining of laminate panels shall be done with the peel-ply intact. Wet cutting and machining procedures shall be followed by a drying process. The drying process shall consist of drying the panel in a forced draft or convection type oven in a stream of ambient air heated to  $200 \pm 10^{\circ}\text{F}$  ( $93 \pm 6^{\circ}\text{C}$ ) for a period of not less than four hours. NOTE: This drying requirement shall be waived if an abrasive water-jet cutter is used. Any resulting moisture film remaining on cut surface shall be removed by local heat application (heater/blower) or by using clean, dry toweling. The finished laminate shall have an epoxy resin sealed surface on all cut, trimmed or drilled hole edges which is applied after any required drying

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process. The epoxy resin used shall have a service temperature of not less than 250°F (121°C) and meet the requirement of 3.4.2. Application of the resin shall not interfere with the peel-ply removal (see 4.3.3 and 4.3.4.1).

### 3.4 Performance.

3.4.1 Peel-ply removal. The peel-ply are intended to keep panel surfaces clean and shall be easily removable by hand, without requiring heat or solvents. Laborious or difficult removal shall be unacceptable (see 4.3.4).

3.4.2 Temperature resistance. The plastic laminates shall not show evidence of delamination following a two cycle exposure to a temperature range of -65°F to 250°F (-54°C to 121°C) (See 4.3.4 and 4.3.4.3).

3.4.3 Ballistic resistance. For class A and B laminates, the  $V_{50}$  protection ballistic limit as defined in MIL-STD-662 shall not be less than that indicated in Table III for the number of plies indicated when tested as specified in 4.3.5. For class C and D laminates, the  $V_{50}$  protection ballistic limit as defined in MIL-STD-662, the velocity at which the probability of penetration of an armor material is 50 percent shall not be less than 2600 ft/s (793 m/s) for a laminate of nominal areal density of 5.0 +/- 0.3 psf (24.4 +/- 1.5 Kg/m<sup>2</sup>).

TABLE III. Ballistic Requirements for Class A and B Laminates.

Minimum Required Ballistic Limits CAL 0.30 (44 Grains) Fragment Simulating Projectile (FSP) at 0° Obliquity			
Aramid (plies)	$V_{50}$ protection ballistic limit <u>1/</u>	Aramid (plies)	$V_{50}$ protection ballistic limit <u>1/</u>
17	1581	31	2336
18	1626	32	2401
19	1672	33	2468
20	1720	34	2537
21	1769	35	2607
22	1819	36	2679
23	1871	37	2754
24	1924	38	2830
25	1978	39	2908
26	2034	40	2988
27	2091	41	3071
28	2150	42	3155
29	2210	43	3242
30	2272	44	3331
31	2336	45	3423

1/ Average of two ballistic limits, each made on a separate specimen.



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3.5 Workmanship. The plastic laminates shall satisfy visual acceptance Level I of ASTM D2563 for the following defects:

- a. Blister
- b. Burned
- c. Cracked
- d. Crack, surface
- e. Crazing
- f. Delamination, edge
- g. Delamination, internal
- h. Dry spot
- i. Lack of fillout
- j. Wrinkles.

Fabric reinforcement layers shall not have pleats, wrinkles, or creases. Fabric layers shall be free of tears, reasonably straight, and perpendicular warp-to-fill. Edges of the finished laminate shall be free of frayed edges (see 4.3.4).

#### 4. VERIFICATION

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

- a. First article inspection (see 4.2).
- b. Conformance inspections (see 4.3).
  - 1. Conformance examination (see 4.3.2).
  - 2. In-process examination (see 4.3.3).
  - 3. Control test (see 4.3.4).

4.2 First article inspection. The contractor shall supply two samples for first article inspection. Two samples shall measure 20 in. by 20 in. (508 mm by 508 mm) by contract designated plies. All samples shall be produced with materials and processes proposed for use on production laminates. Inspection shall be carried out by the contractor under Government surveillance. Inspection shall consist of all quality conformance and control tests. Upon successful completion of the quality conformance and control test, the samples shall be forwarded to the test site identified by the procuring activity (see 6.2). The test samples shall be adequately identified as to the contractor, contract number, manufacturer, and date. The ballistic test samples will be tested by the Government for the requirements of 3.4.3 in accordance with 4.3.5.1, except that for each ballistic sample must meet the  $V_{50}$  protection ballistic limit. Any changes or deviations of production units from the first article sample shall be subject to the approval of the contracting officer.

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4.3 Conformance inspection. Conformance inspection shall include the examination of 4.3.2 & 4.3.3 and the control tests of 4.3.4 thru 4.3.4.3 and 4.3.5 (see table IV).

TABLE IV. Classification of inspections.

Title	Require- ment	Inspec- tion	First article	Conformance		
				Conform- ance exam	In- process exams	Control tests
Materials and design	3.2 thru	4.4.1	X			
Construction	3.3.1.1					
Dimension and structure	3.3.1	4.3.3	X		X	
Thickness and flatness	3.3.1.1	4.3.3	X		X	
Variation						
Weights	3.3.1.2	4.3.4.1	X		X	X
Lamination pressures	3.3.2	4.3.3	X		X	
and						
Temperatures						
Finished laminate	3.3.3	4.3.3.1	X		X	
Peel-ply removal	3.4.1	4.3.4.2				X
Ballistic resistance	3.4.3	4.3.5.1	X			X
Workmanship	3.5	4.3.5	X	X		X

4.3.1 Sampling.

4.3.1.1 Lot formation. An inspection lot shall consist of all the laminated assemblies of one type and part number, from an identifiable production period, from one manufacturer, submitted at one time for acceptance.

4.3.1.2 Sampling for examination. All laminates shall be examined.

4.3.2 Conformance examination. All laminates shall meet the visual criteria as specified in 3.5.

4.3.3 In-process examination. To determine conformance to 3.3.1 through 3.3.3, the contractor shall initiate, perform and document on an essentially continuous basis, an in-process procedure consisting of process controls and examination criteria satisfactory to the Government.

4.3.4 Control tests. The contractor shall supply two test samples, 20 in. x 20 in. (508 mm x 508 mm), for each month of laminate fabrication, for control testing. The samples shall have the contract designated plies or areal density and shall be produced with materials and processes used for production laminates. Testing shall be carried out by the contractor under Government surveillance and shall consist of tests to show conformance to 3.3.1.2, 3.4.1, 3.4.2, and 3.5.

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4.3.4.1 Determination of laminate unit weight. The unit weight or areal density of a finished laminate is determined as follows: Choose a square laminate of nominal size at least 20 in. by 20 in. (508 mm x 508 mm) and remove peel-ply (see 3.3.3). Dry the panel in a forced draft or convection type oven in a stream of ambient air heated to  $200 \pm 10^{\circ}\text{F}$  ( $93 \pm 5^{\circ}\text{C}$ ) until no further change of mass occurs when the panel is weighed with an error of less than 0.1% after cooling to room temperature in the standard atmosphere for testing textiles as defined in ASTM D123. Calculate the unit weight to three significant figures as follows:

$$\text{Unit Weight} = \frac{1000000 \text{ M}}{\text{LW}} \text{ Kg/m}^2$$

Where M is the dry panel weight in kilograms measured with an error of less than 0.1%, L is the length of the panel in millimeters measured to the nearest 2 millimeters and W is the width of the panel in millimeters measured to the nearest 2 millimeters (see table Ia.)

4.3.4.2 Peel-ply test. The peel-ply test shall consist of removing the peel-ply by hand.

4.3.4.3 Temperature resistance test. The temperature resistance test shall be performed as specified in MIL-STD-810, except the temperature extremes and number of cycles shall be as specified in 3.4.2.

4.3.4.4 Failure. Failure of the samples to meet the control test requirements shall be cause for the Government to refuse acceptance of quality conformance samples until the cause of failure(s) is identified, corrective action is taken by the contractor, and approved by the Government.

4.3.5 Ballistic control test. The contractor shall supply two test samples 20 in. by 20 in. (508 mm by 508 mm) by contract designated plies or areal density for each three months of test laminate fabrication for ballistic control testing at the facility identified by the procuring activity to show conformance to 3.4.3 (see 6.2). The test panels shall be adequately identified as to contractor, contract number, manufacturer, and date.

4.3.5.1 Ballistic test. The ballistic resistance test shall be conducted in accordance with MIL-STD-662. Test projectile shall be the caliber 0.30 (44 grain) fragment simulating projectile at  $0^{\circ}$  obliquity. The  $V_{50}$  protection ballistic limit reported shall be the average of two determinations made on separate laminates. Each determination shall be a six round  $V_{50}$  ballistic limit with a maximum velocity spread of 125 ft/sec.

4.3.5.2 Failure. Failure of the samples to meet the control test requirements shall be cause for the Government to stop acceptance of quality conformance samples until the cause of failure(s) is identified, corrective action is taken by the contractor, and approved by the Government.

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4.4 Materials, design and construction. To determine conformance to 3.2 thru 3.2.2 and 3.3 thru 3.3.1.1, inspection and material certification records shall be maintained by the contractor. Records shall be subject to review by the Government and shall be determined by inspection of contractor records providing proof or certification that materials conform to requirements. Applicable records shall include drawings, specifications, design data, receiving inspection records, processing and quality control standards, vendor catalogs and certifications, industry standards, test reports, and rating data.

## 5. PACKAGING

5.1 Packaging. For acquisition purposes, the packaging requirements shall be as specified in the contract or order (see 6.2). When packaging of materiel is to be performed by DoD or in-house contractor personnel, these personnel need to contact the responsible packaging activity to ascertain packaging requirements. Packaging requirements are maintained by the Inventory Control Point's packaging activities within the Military Service or Defense Agency, or within the military service's system commands. Packaging data retrieval is available from the managing Military Department's or Defense Agency's automated packaging files, CD-ROM products, or by contacting the responsible packaging activity.

## 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 laminates furnished under this specification are intended for use as a component of composite armor. Since these laminates must maintain a ballistic resistance sufficient to survive under extreme battlefield conditions, under which commercial alternatives characteristically fail, this item is military unique.

6.2 Acquisition requirements. Acquisition documents must specify the following:

- a. Title, number, and date of this specification.
- b. Type and class (see 1.2).
- c. When first article is required (see 3.1).
- d. Production component dimensions and ply count (see 3.3.1).
- e. Identify the test site by the procuring activity (see 4.2)
- f. If ballistic control test is required (see 4.3.5).
- g. Packaging requirements (see 5.1).
- h. Part or identifying number (PIN) (see 6.4).

6.3 Test samples. Ballistic test samples should be sent to: Commander, U.S. Army Aberdeen Test Center, 400 Collieran Road. Bldg. 358, ATTN: CSTE-DTC-AT-SL-V

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(D. Gessleman), Armor Acceptance – B690, Aberdeen Proving Ground, MD 21005-5059 (see 4.3.5).

6.4 Subject term (key word) listing.

Areal density (AD)  
Ballistic resistance  
Laminating resin  
Lamination pressures and temperatures  
Peel-ply  
Polyvinyl butryal  
Temperature resistance

6.5 Amendment notations. The margins of this specification are marked with vertical lines to indicate modifications generated by this amendment. 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.

Custodian:  
Army - AT  
Air Force - 11

Preparing Activity:  
Army - AT  
  
(Project 9330-2008-002)

Review Activities:  
Army - MR  
DLA - IS

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