

INCH-POUND

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DEPARTMENT OF DEFENSE

DETAIL SPECIFICATION



PARACHUTES, PERSONNEL, GENERAL SPECIFICATION FOR

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AMSC N/A

FSC 1670

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DEPARTMENT OF DEFENSE DETAIL SPECIFICATION

PARACHUTES, PERSONNEL, GENERAL SPECIFICATION FOR

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

1. SCOPE

1.1 Scope.

This specification covers the general and specific requirements for personnel parachutes and components thereof, as well as specific manufacturing instructions.

1.2 Classification.

The classification of parachute assemblies, defined as part numbers, is as specified in the Qualified Products List, QPL-6645 (see 6.2).

2. APPLICABLE DOCUMENTS

2.1 General.

The documents listed in this section are cited in sections 3 and 4 of this specification. These lists do not include documents cited in other sections of this specification or those recommended for additional information or as examples. While every effort has been made to ensure the completeness of these lists, document users are cautioned that they must meet all specified requirements documents cited in sections 3 and 4 of this specification, whether or not they are listed.

2.2 Government documents.

2.2.1 Specifications and standards.

The following specifications and standards 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).

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SPECIFICATIONS

FEDERAL

- A-A-59291 - Ink, Marking (For Parachutes and Other Textile Items)
- DDD-L-20 - Label; for Clothing, Equipage and Tentage

DEPARTMENT OF DEFENSE

- MIL-P-7567 - Parachutes, Personnel, Detail Manufacturing Instructions for

STANDARDS

DEPARTMENT OF DEFENSE

- MIL-STD-849 - Inspection Requirements, Definitions and Classification of Defects for Parachutes

HANDBOOKS

DEPARTMENT OF DEFENSE

- MIL-HDBK-831 - Preparation of Test Reports

2.3 Other Government documents.

The following other Government document forms a part of this document to the extent specified herein. Unless otherwise specified, the issue is that issue cited in the solicitation.

SD-1 - Standardization Directory

(Copies of the SD-1 are available from the Standardization Document Order Desk, 700 Robbins Avenue Building 4D, Philadelphia, PA 19111-5094)

2.4 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 that 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.

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM D 737 – Test Method for Air Permeability of Textile Fabrics

(Application for copies should be addressed to the American Society for Testing and Materials, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.)

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PARACHUTE INDUSTRY ASSOCIATION

PIA-C-5040 – Cord, Fibrous and Nylon

(Application for copies should be addressed to the Parachute Industry Association, 3833 West Oakton Street, Skokie, IL 60076.)

2.5 Order of precedence.

In the event of a conflict between the text of this document and the references cited herein (except for related associated specifications or specification sheets), 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 a first article inspection in accordance with 4.2.

3.2 Qualification requirements.

3.2.1 Qualification.

Parachute assemblies and/or components thereof furnished under this specification shall be products that are authorized by the qualifying activity for listing on the Qualified Products List (QPL) before contract award (see 4.3 and 6.4).

3.2.2 Submittal of inspection samples.

Contractors shall submit products to the appropriate qualifying activity for evaluation. For specific information regarding points of contact and products qualified, contact Air Force – Standardization Management Activity Code 11 (see SD-1, Standardization Directory, for FSC 1670 items).

3.2.3 Qualification inspection samples.

The qualification inspection sample shall comply with all of the requirements specified herein and shall consist of two complete parachute 1/ assemblies or components (if qualification is desired for a component only). The qualification sample shall be accompanied by the following items with affidavits of the source of supply of each item: 5 yards of each color and type of fabric; 1/2 pound spool, cone, or tube of each type of thread; 30 yards of each type of cord, webbing, and tape; and two sets of each type of hardware used in the construction and components of the parachute assembly. The samples shall comply in all respects with the requirements specified herein. Samples shall be forwarded as directed by the activity responsible for qualification.

1/At their option, a qualifying activity might only request one parachute assembly.

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3.2.4 Identification of samples.

Each sample shall be plainly identified by a securely attached, durable tag marked with the following information:

- a. Sample for qualification inspection
- b. Name of product (parachute assembly or components)
- c. Manufacturer's designation or number
- d. Name of manufacturer
- e. Submitted by (name and date) for qualification inspection with the requirements of MIL-DTL-6645 under authorization (reference authorizing letter)

3.2.5 Qualification tests.

Qualification tests shall consist of all tests and examinations necessary to assure products submitted conform to the Technical Data Package (TDP) for the associated item.

3.2.6 Plant inspections.

The qualification activity reserves the right to conduct plant inspections during the qualification process or at anytime after a manufacturer is listed on the QPL. A minimum of five days notice must be given to a manufacturer to conduct an inspection. ISO standards or pre-award surveys may or may not be accepted in lieu of an actual inspection. The inspections are intended and designed to help the qualification activity determine if a contractor is capable of manufacturing QPL items in a production environment. The qualification activity shall have at its disposal, and available to contractors, the inspection requirements. Failing a plant inspection shall be cause for a contractor to not be included on, or to be removed from, the QPL.

3.2.7 Subcontracting.

Prime contractors may not subcontract the fabrication of any parachute components unless the subcontractor is qualified to do so by the qualifying activity. Qualification times may take as long as 6 months (see 3.2.8). Parachute subassemblies (components without a part number designation) must be individually qualified (the same as a part number) by contractors which have multiple plants. Qualifying activities shall file with the preparing activity of the QPL a list of subassemblies which have been qualified.

3.2.8 Qualification notifications.

The preparing activity of the QPL (see 3.2.2) shall notify contractors of the results of qualification testing within 45 days after the qualifying activity has completed the qualification examination. Contractors shall allow the qualifying activity 6 months to complete an initial qualification examination.

3.3 Materials.

Materials shall conform to the requirements of the TDP for the associated item, to subsidiary specifications and standards applicable thereto, and as specified herein.

3.3.1 Recycled, recovered, or environmentally preferable materials.

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

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3.3.2 Textiles.

Textile materials that are more than 3.5 years old (as evidenced by the date of manufacture marked on the rolls or containers--see 3.3.2.1) shall not be used in the fabrication of parachute assemblies. The Government reserves the right to examine the contractor's records to validate the age of textile materials and to reject assemblies which use noncompliant materials.

3.3.2.1 Date of manufacture, textile.

The date of manufacture is defined as the last date which the textile materials have undergone a manufacturing operation. To properly identify the age of textile materials for government use, the textile manufacturer shall place a tag on the finished goods identifying the specification to which the material is manufactured, the roll number from the lot, the lot number, and the date of manufacture.

3.3.3 Marking ink.

The ink for marking textile parachute assemblies shall be in accordance with A-A-59291 or as specified in the TDP for the associated item. Colors and types shall be specified in the TDP for the associated item. If a shade of a color is not specified in the TDP, the contractor may use any color shade as long as the nomenclature is legible.

3.3.4 Hardware.

Hardware parts utilized in the construction of the parachute assemblies and components shall conform to the TDP for the associated item.

3.4 Construction.

Details of construction shall be in accordance with MIL-P-7567, manufacturing specifications supplied by the procuring activity, the TDP for the associated item, and the additional requirements specified herein (see 3.5).

3.4.1 Assembly aids.

Drilling, notches, stapling, basting or any other such techniques used as aids in the manufacturing process of parachutes shall be kept to a minimum, and the use thereof shall be restricted to the same limitations as marking (see 3.4.2). All assembly aids, such as staples, shall be removed during or after assembly. For Navy and Air Force procurements, hot glues are not authorized as an assembly aid.

3.4.1.1 Basting.

Basting requirements shall be as specified in the TDP for the associated item or be in accordance with common industry practices. Basting stitches shall not be seen in the finished seam or assembly. Contractors unfamiliar with commercial practices shall contact the contracting officer for specific details prior to assembly of the item.

3.4.2 Assembly markings.

Markings of pack, canopy, harness, riser, and other components as an aid to assembly, and to indicate stitching patterns, shall be accomplished in a manner that will not adversely affect the utility, strength, or appearance of the parachute.

3.5 Other details of construction.

Specified below are other details of construction for canopy, harness, pack and container:

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3.5.1 Canopy.**3.5.1.1 Suspension lines.**

Suspension lines shall be continuous and without splices or knots for each length specified by the TDP for the associated item. All lines for one canopy shall be made from the same continuous length of cord. Lines damaged during the process of canopy manufacture shall be replaced with lines fabricated by the same line manufacturer. Lines being tensioned on multiple pulley systems shall be measured and marked as one continuous length for the entire canopy and shall not be anchored at any intermediate points between the ends of the lines.

3.5.1.1.1 Tensioning of suspension cord line.

The following suspension lines shall be marked under the specified tension unless otherwise specified in the TDP for the associated item:

<u>Line</u>	<u>Conforming To</u>	<u>Tension</u>
Nylon Cord	PIA-C-5040, Type III	20 \pm 1 pound
Nylon Cord	PIA-C-5040, Type II	10 \pm 1/2 pound

3.5.1.1.2 Checking of pulley systems.

Pulley systems used for tensioning lines during marking shall be checked each day to maintain specified tension of each line.

3.5.1.1.3 Marking of suspension lines.

Marking shall be done in a manner that ensures the final dimensions of the assembly or component meet the TDP for the associated item when measured within 30 \pm 5 seconds after the tension is applied.

3.5.1.2 Air permeability.

When tested in accordance with 4.7, complete canopies or pilot chutes shall have an average permeability of not more than 10 percent over the top limit or 10 percent below the lower limit of the fabric specification. The average air permeability reading for any one gore or cell shall not exceed the upper limit nor be less than the lower limit of the fabric specification by over 20 percent.

3.5.2 Harness, pack, and container.**3.5.2.1 Pull of ripcord.**

The force required to operate the manual ripcord system of a packed parachute to cause positive opening of the parachute pack or container shall not exceed 27 pounds, or the requirements as established by the procuring activity and/or applicable technical documents, when tested in accordance with 4.7. This requirement is applicable to all ripcord-actuated parachute types. (When stated limits are exceeded for Navy assemblies, the Naval Air Warfare Center, Code 46000D, China Lake, CA facility shall be notified in addition to those agencies required by the contracting authority.)

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3.5.2.2 Parachute packs, container.

For packs or containers using the pack cone and grommet closure system, the system shall have sufficient clearance when the pack or container is closed so that the ripcord pins may be inserted without scoring or binding the grommets.

3.5.2.3 Parachute packs, containers.

For packs or containers that are closed by the method of lacing a pack-closed cord through grommets, the grommets shall be free of broken and sharp edges which tend to cut or abrade the lacing cord.

3.6 Identification of product.

Equipment, assemblies, and components shall be marked for identification in accordance with the TDP for the associated item or as specified in the following subparagraphs. In addition, the date of manufacture, providing the month and year of delivery to the procuring activity, shall be shown on each fabric component (see 1/). The markings shall show the exact nomenclature followed by a space and the detailed information. Serial numbers for canopies and packs or deployment containers shall be furnished by the procuring activity (see 6.2).

1/ Army procurements require identification marking(s) only as specified in the TDP.

3.6.1 Pack or container.

When complete parachutes are procured, the contractor shall mark the pack or container in accordance with the TDP for the associated item.

3.6.2 Harness.

Except as otherwise specified, a label conforming to type VI, class 11, of DDD-L-20, shall be affixed to each harness. The manner of application, size, and location of the label shall be as specified in the TDP for the associated item. The label shall contain the part number, contract number, manufacturer's code, and date of manufacture. Space shall be provided for entering the date placed in service (this will be filled in by the using service).

3.6.3 Riser.

The requirements of 3.6.2 shall apply to each riser of parachute assemblies which is not designed with the risers as an integral part of the harness.

3.6.4 Identification marking.

Each round canopy shall be marked for identification in accordance with figure 1, unless otherwise stated in the TDP for the associated item. The characters shall be not less than 1/2 inch high. The type designation, if applicable and as specified in the TDP for the associated item, shall precede the drawing number. The using service will insert the date the canopy is placed in service.

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3.7 Workmanship.

The parachute assemblies and components shall conform to the quality of product established by the specification and documents referenced herein.

4. VERIFICATION**4.1 Classification of inspections.**

The inspection requirements specified herein are classified as follows:

- a. First article inspection (see 4.2)
- b. Qualification inspection (see 4.3)
- c. Conformance inspection (see 4.4)

4.2 First article inspection.

First article inspection shall be performed on one complete parachute assembly, unless otherwise stated in the contract, when a first article sample is specified (see 3.1). The inspection shall include the tests and examinations of 4.4.1, 4.4.2, 4.5, and 4.6. Any defect or nonconformance shall be cause for rejection of the first article.

4.3 Qualification inspection.

Assemblies submitted for qualification shall be inspected to verify the requirements of the TDP for the associated item. Any defects, major or minor, as specified in MIL-STD-849, unacceptable workmanship, or other nonconformance shall be cause for rejection of the qualification sample.

4.4 Conformance inspection.

Conformance inspections shall include the examination of 4.4.1, 4.4.2, and 4.5, and the tests of 4.6 (as required, see 6.2). Sampling plans and acceptance/rejection criteria for the inspections of 4.4.2, 4.5 and 4.6 shall be as specified in the contract or purchase order. Parachute assemblies which fail the acceptance criteria shall be cause for rejection of the lot.

4.4.1 Component and material inspection.

Components and materials shall be inspected in accordance with all of the requirements of referenced documents unless otherwise excluded, amended, modified, or qualified in this specification or applicable purchase document.

4.4.2 In-process inspection.

Inspection of subassemblies shall be made to ascertain that construction details and dimensional requirements which cannot be examined in the finished product are in accordance with specified requirements. The Government reserves the right to exclude from consideration of acceptance any material or service for which in-process inspection has indicated nonconformance.

4.5 Examinations.

The parachute assemblies shall conform to the visual and dimensional examinations as specified in the TDP for the associated item. Deviations from the TDP shall be classified in accordance with MIL-STD-849.

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4.6 Tests**4.6.1 Air permeability.**

Canopies and pilot chutes shall be subjected to the applicable air permeability test in accordance with 4.7 when specified in the contract or purchase order (see 6.2). Specific instructions shall be provided for pilot chute porosity testing if required (see 4.7.1).

4.6.2 Ripcord pull.

Parachute assemblies shall be subjected to the applicable pull test in accordance with 4.7 when specified in the contract or purchase order (see 6.2).

4.7 Test methods.

Unless otherwise specified, the testing shall be as follows:

4.7.1 Air permeability, round.

The cloth of completed parachute canopy assemblies shall be tested for air permeability to determine compliance with the requirements of 3.5.1.2. The test shall be performed in accordance with ASTM D 737, making five permeability readings (a minimum of one reading per section excluding the top) in every fourth gore starting with gore number 1; that is, gore numbers 1, 5, 9, etc. The pilot chutes procured as separate items or as part of the parachute canopies or assemblies shall be subject to this permeability testing requirement, except that the number and locations of the readings shall be as specified by the procuring activity.

4.7.1.1 Air permeability, gliding.

The cloth of completed gliding type canopy assemblies shall be tested for air permeability requirements of 3.5.1.2. The test shall be performed in accordance with ASTM D 737. Readings shall be randomly taken on the top and bottom panels of each cell-- two readings per top and bottom panel (see figure 2).

4.7.2 Ripcord pull.

Parachute assemblies (or pack/container assemblies when procured separately) shall be tested for compliance with the requirements of 3.5.2.1. Prior to commencing the tests for parachutes equipped with an elastic or spring ripcord grip pocket, the ripcord grip shall be inserted in the elastic ripcord grip pocket and withdrawn with a twisting motion five times to flex the pocket. Items selected for testing shall be packed, as for service, strictly in accordance with instructions furnished by the procuring activity (see 6.2 and 6.5).

4.7.2.1 Chest-style or type parachute.

Except that a rigger's seal shall not be affixed, the parachute shall be packed in accordance with the applicable packing instructions. The parachute shall be placed in a test fixture to hold it securely in a position with the mouth of the ripcord pocket facing downward (along the vertical axis). Unless otherwise specified by the procuring activity, a 27-pound weight attached to the ripcord grip shall readily activate the parachute by withdrawing the ripcord pins from the locking cones.

CARE SHALL BE EXERCISED TO CENTER THE WEIGHT ON THE GRIP AND NOT TO IMPOSE AN IMPACT LOAD.

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4.7.2.2 Back and seat style or type parachute.

The parachute shall be packed in accordance with the applicable packing instructions and placed in a test fixture or anthropometric device (torso) simulating the 5 to 95 percentile male or live subject to hold it securely in a position with the mouth of the pocket or ripcord guide facing downward (along the vertical axis). The ripcord cable shall be secured so that the ripcord pins will not be withdrawn when the weight is applied. A 20-pound weight attached to the ripcord grip (care shall be exercised not to impose an impact load) shall readily withdraw the ripcord from the pocket or the guide. The parachute shall then be rotated so that the open end of the ripcord housing will be facing downward with the ripcord cable in a vertical position. A 27 pound-weight shall be attached to the ripcord grip, which has been removed from the ripcord pocket or guide. The safety on the ripcord cable shall be removed and the weight shall readily activate the parachute by withdrawing the ripcord pins from the locking loops of the locking cones' webbing.

4.7.2.3 Metal grip socket or clips.

Parachutes with mechanical grip sockets shall be tested as specified in 4.6.2. However, insertion and withdrawal of the grip (five times) prior to test is not required.

4.7.2.4 Manual system actuation.

When the manual system of a parachute assembly is actuated during a test, the procuring activity may specify a follow-on required function of the system after the manual function (i.e., complete separation of the grommets from the cones or the pilot chute spring extended, after a ripcord pin pull).

5. PACKAGING**5.1 Packaging.**

For acquisition purposes, the packaging requirements shall be as specified in the contract or order (see 6.2). When actual packaging of materiel is to be performed by DoD personnel, these personnel need to contact the responsible packaging activity to ascertain requisite packaging requirements. Packaging requirements are maintained by the Inventory Control Point's packaging activity within the Military Department or Defense Agency, or within the Military Department's System Command. 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 parachute assemblies and components covered by this specification are intended for use by personnel making premeditated jumps or for emergency escape from airborne vehicles. Assemblies tethered or controlled from the ground or water surface, and used as ground/air training simulators, are included within the scope of this document.

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6.2 Acquisition requirements.

Acquisition documents should specify the following:

- a. Title, number, and date of this specification
- b. Part number (see 1.2)
- c. Issue of DoDISS to be cited in the solicitation and if required, the specification of individual documents referenced (see 2.2.1)
- d. When a first article is required (see 3.1)
- e. Serial numbers, if required (see 3.6)
- f. Sampling plan (see 4.4)
- g. Air permeability test, if required (see 4.6.1, 4.7.1, 4.7.1.1)
- h. Ripcord pull test, if required (see 4.6.2, 4.7.2)
- i. Packing instructions, if required (see 4.7.2, 4.7.2.1, 4.7.2.2, 4.7.2.3, and 4.7.2.4)
- j. Packaging requirements (see 5.1)

6.3 Drop test.

Parachute assemblies with defects of a nature which, in the judgement of the qualifying activity, could result in a malfunction may, at the option of the procuring activity, be subjected to a typical drop test. An example would be:

Torso dummy weight - 250 pounds

Altitude 1/ - 1,500 feet above certain terrain 2/

Packing - Standard, as for service use, per applicable packing instructions

Airspeed - 170 knots indicated airspeed

1/ Parachute should be fully deployed within the first 200 feet.

2/ Pressure altitude should not exceed 5,000 feet.

6.4 Qualification.

With respect to products requiring qualification, awards will be made only for products which are, at the time set for opening of bids, qualified for inclusion in the applicable Qualified Products List, whether or not such products have actually been so listed by that date. The attention of the suppliers is called to this requirement, and manufacturers are urged to arrange to have the products that they propose to offer to the Federal Government tested for qualification in order that the manufacturers may be eligible to be awarded contracts or orders for the products covered by this specification.

6.4.1 Qualification test report.

Upon application for qualification, applicants will be requested to provide a test report that includes details indicating compliance or noncompliance with each requirement of this specification by paragraph and the applicable TDP for the associated item. MIL-HDBK-831 may be used as guidance in preparing the test report.

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6.5 Ripcord pull.

Requirements for ripcord pull tests covered by this specification should be specified by the procuring activity (see 6.2).

6.6 Automatic openers.

Automatic openers are not covered under this specification.

6.7 Subject term (keyword) listing.

Aerodynamic
Canopy
Drag producing devices
Decelerators

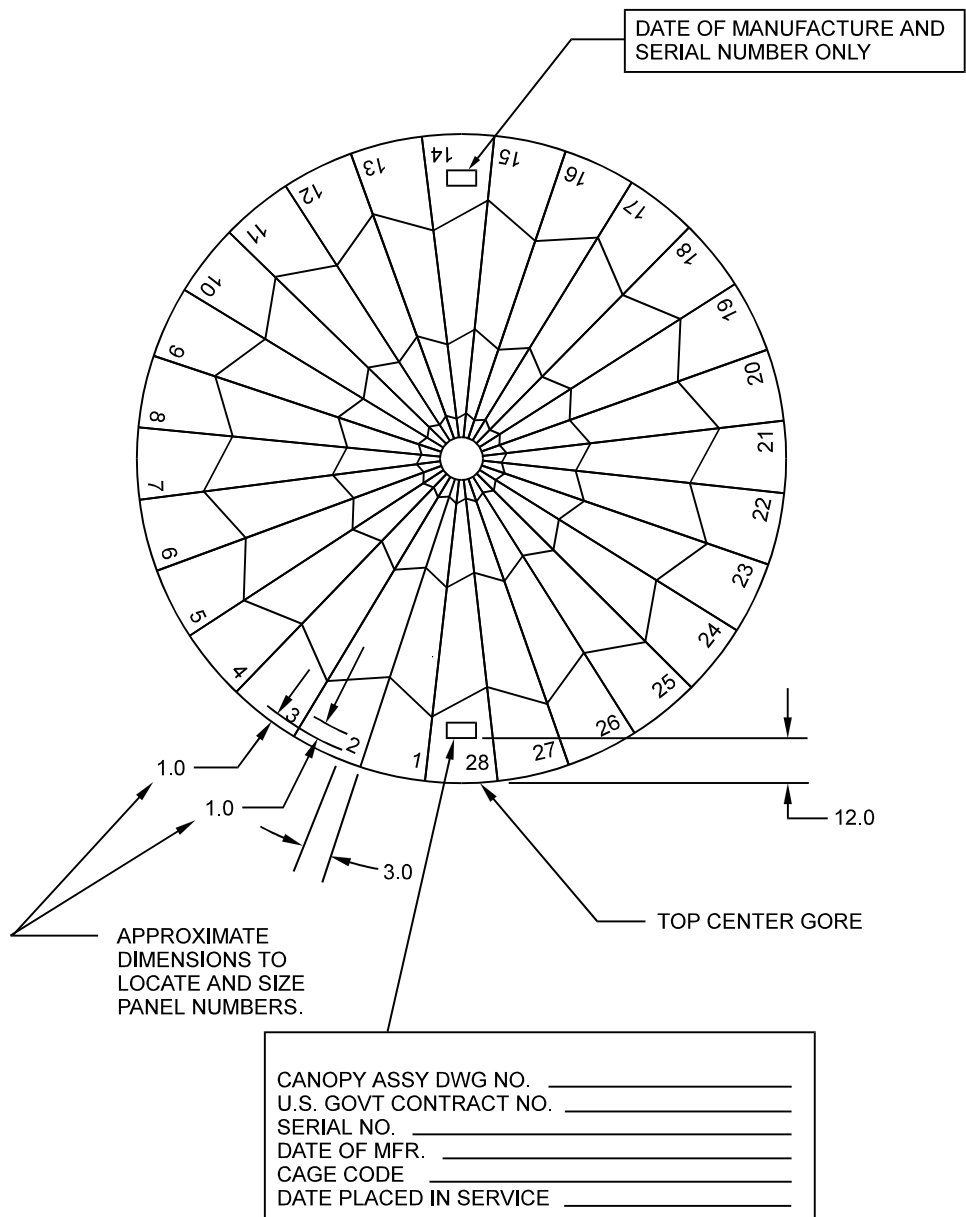
6.8 Changes from previous issue.

Marginal notations are not used in this version to identify changes with respect to the previous issues due to the extent of the changes.

Custodians:
Army - GL
Navy - AS
Air Force - 11

Preparing Activity:
Air Force - 11
(Project 1670-1002)

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NOTE: CANOPY DIAGRAM IS FOR REFERENCE ONLY, SHOWING MANNER IN WHICH CANOPY IS MARKED. CANOPY SHAPE AND NUMBER OF GORES MAY VARY ACCORDING TO THE SPECIFIC MANUFACTURING SPECIFICATIONS.

DIMENSIONS IN INCHES.

FIGURE 1. Parachute identification marking requirements.

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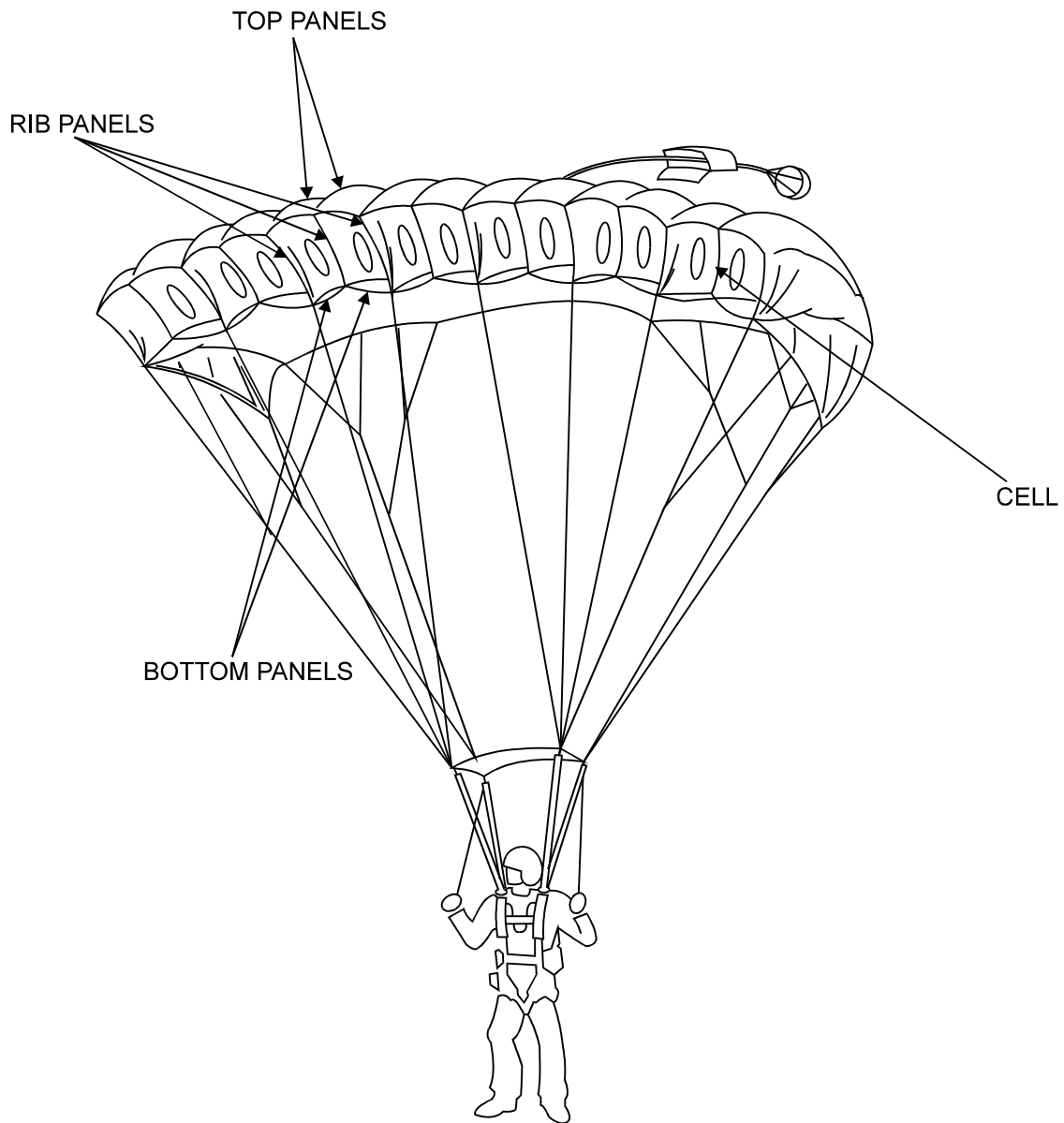


FIGURE 2. Pictorial view of a gliding canopy (7 cell).

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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.

I RECOMMEND A CHANGE:	1. DOCUMENT NUMBER MIL-DTL-6645J	2. DOCUMENT DATE (YYMMDD) 31 August 2001
3. DOCUMENT TITLE Parachutes, Personnel, General Specification for		
4. NATURE OF CHANGE <i>(Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)</i>		
5. REASON FOR RECOMMENDATION		
6. SUBMITTER		
a. NAME <i>(Last, First, Middle Initial)</i>		b. Organization
c. ADDRESS <i>(Include zip code)</i>	d. TELEPHONE <i>(Include Area Code)</i> (1) Commercial (2) DSN <i>(if applicable)</i>	7. DATE SUBMITTED (YYMMDD)
8. PREPARING ACTIVITY		
a. NAME ASC/ENOI, BLDG 560		b. TELEPHONE <i>(Include Area Code)</i> (1) Commercial (2) DSN 937-255-6282 785-6282
c. ADDRESS <i>(Include Zip Code)</i> 2530 Loop Road West Wright-Patterson AFB, OH 45433-7101		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 DSN 289-2340