

INCH-POUND

MIL-DTL-7560D

20 June 1997

SUPERSEDING

MIL-C-7560C

23 January 1991

DETAIL SPECIFICATION

VALVE ASSEMBLY, OXYGEN CYLINDER, BAILOUT

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

1. SCOPE

1.1 Scope. This specification covers manually operated, oxygen cylinder bailout valve assemblies.

1.2 Classification. The valve assembly is classified according to the hose length and the actuating cable as designated by the applicable Part or Identifying Number (PIN) of MIL-DTL-7560/1.

2. APPLICABLE DOCUMENTS

2.1 General. The documents listed in this section are needed to meet the requirements specified in sections 3, 4, and 5 of this specification. This section does not include documents cited in other sections of this specification or recommended for additional information or as examples. While every effort has been made to ensure the completeness of this list, document users are cautioned that they must meet all specified requirements documents cited in sections 3, 4, and 5 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 for Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

SPECIFICATIONS

DEPARTMENT OF DEFENSE

MIL-DTL-7560/1	Valve Assembly, Oxygen Cylinder, Bailout
MIL-O-27210	Oxygen, Aviator's Breathing, Liquid and Gas
MIL-G-27617	Grease, Aircraft And Instrument, Fuel And Oxidizer Resistant
MIL-T-27730	Tape, Antiseize, Polytetrafluoroethylene, with Dispenser

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Technology & Industrial Services Division, OC-ALC/TICLA, Tinker AFB, OK 73145-3037 by using the Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 1660

DISTRIBUTION STATEMENT A: Approved for public release; distribution is unlimited.

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STANDARDS

DEPARTMENT OF DEFENSE

MIL-STD-130	Identification Marking Of US Military Property
MIL-STD-1359	Cleaning Methods And Procedures For Breathing Oxygen Equipment
MS26545	Cylinder, Steel, Compressed Gas, Non-Shatterable Seamless, 1800 And 2000 PSI

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

2.3 Order of precedence. In the event of a conflict between the text of this document and the references cited herein, (except for related associated detail specifications, specification sheets, or MS standards), 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 Specification sheet. The individual item requirements shall be as specified herein and in accordance with the specification sheet. In the event of any conflict between the requirements of this specification and the specification sheet, the latter shall govern.

3.2 Qualification. The valve assemblies, flow controller, and break-off nipple furnished under this specification shall be products which are authorized by the qualifying activity for listing on the applicable Qualified Products list at the time of award of contract (see 4.2 and 6.3).

3.3 Materials. Materials shall conform to applicable specifications and shall be as specified herein and on applicable drawings. Materials which are not covered by specifications, or which are not specifically described herein, shall be of the best quality, of the lightest practicable weight, and suitable for the purpose intended. Reclaimed materials shall be utilized to the maximum extent possible within the quality limits required by this document.

3.3.1 Age. Elastomer components, other than components made from silicone, shall not be more than 12 months old from the date of delivery of the valve to any Government service, or to an airframe or accessory manufacturer.

3.3.2 Protective treatment. When materials are used in the construction of the valves that are subject to deterioration when exposed to environmental conditions likely to occur during service usage, they shall be protected against such deterioration in a manner that will in no way prevent compliance with the performance requirements of this specification. Protective coating which might crack, chip, or scale during normal service life or under extremes of environmental conditions shall not be used.

3.4 Design and construction. The valve assembly shall be designed and constructed in accordance with the applicable dash number of MIL-DTL-7560/1.

3.4.1 Flow controller. The flow controller shall be designed and constructed in accordance with MIL-DTL-7560/1 and shall contain a filter (see 6.5) that will filter all oxygen passing through the valve.

3.4.2 Break-off nipple. The break-off nipple shall be designed and constructed in accordance with MIL-DTL-7560/1.

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3.4.3 Antiseize. Antiseize tape conforming to MIL-T-27730 or thread compound conforming to MIL-G-27617 shall be used on all male pipe thread fittings. The tape or compound shall not be used on flared tube fittings, straight threads, coupling sleeves, or on the outside of the tube flares. None of the tape or compound shall be allowed to enter the inside of a fitting. The tape shall be applied in accordance with instructions specified in MIL-T-27730. The compound shall be applied to the first three threads and the end of the fitting wiped clean.

3.4.4 Cleaning. All parts of the valve assemblies or flow controller, except the hose, shall be cleaned in accordance with MIL-STD-1359.

3.5 Performance.

3.5.1 Valve Assemblies.

3.5.1.1 Leakage. The valve assemblies shall show no indications of leakage when tested as specified (see 4.6.1.1).

3.5.1.2 Retaining pin removal force. The force required to remove the retaining pin shall be 15 ± 5 pounds as specified (see 4.6.1.2).

3.5.1.3 Fill and operation. When the valve assemblies are tested as specified (see 4.6.1.3), the force required to discharge the gas shall not be less than 10 nor more than 20 pounds.

3.5.1.4 Actuating cable housing retainer. The actuating cable housing retainer shall not become detached from the valve when subjected to the test specified (see 4.6.1.4).

3.5.1.5 Actuating cable assembly. The actuating cable assembly shall withstand a pull of 30 pounds when tested as specified (see 4.6.1.5).

3.5.1.6 Operation at high and low temperature. The valve assemblies shall pass the high temperature (160° F) and the low temperature (-65° F) tests specified (see 4.6.1.6).

3.5.1.7 Vibration. The valve assemblies shall pass the vibration test specified (see 4.6.1.7). No screws or other parts shall become loose. The tests (see 4.6.1.1 and 4.6.1.3) shall be performed after the vibration tests.

3.5.1.8 Hose fitting to hose attachment. The hose fitting shall not separate from the hose at a force of less than 25 pounds when tested as specified (see 4.6.1.8).

3.5.2 Flow controller.

3.5.2.1 Total flow. When the controller is tested as specified (see 4.6.2.1), a flow of gas shall be maintained for 10 minutes. The flow during the first minute shall be 11 ± 1 liters and at least 1 liter for the tenth minute.

3.5.2.2 Flow at high and low temperature. The flow controller shall pass the high (160° F) and low (-65° F) temperature flow test specified (see 4.6.2.2) when the gas flow is maintained for 10 minutes. The flow during the first minute shall be 16 liters maximum for the high temperature test and 8 liters minimum for the low temperature test.

3.5.2.3 Vibration. The flow controller shall pass the vibration test specified (see 4.6.2.3).

3.5.3 Break-off nipple.

3.5.3.1 Leakage. The nipple shall pass the leakage test specified (see 4.6.3.1).

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3.5.3.2 Fracture force. When tested as specified (see 4.6.3.2), the force required to break the nipple shall not be less than 10 nor more than 20 pounds.

3.6 Identification marking. The valve assembly, flow controller, and break-off nipple shall be marked for identification in accordance with MIL-STD-130 except the Federal Stock number shall be omitted.

3.7 Workmanship. The valve assemblies shall be uniform in quality and shall be free from irregularities or defects which could adversely affect performance, reliability, or durability. The assemblies shall be free of oil, grease, fuel, water, dust, dirt, or any other foreign matter.

3.8 Recycled and reclaimed materials. Recycled and reclaimed materials shall be encouraged to the maximum extent possible.

4. VERIFICATION

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

- a. Qualifications inspections (see 4.2).
- b. Conformance inspection (see 4.3).

4.2 Qualification inspection.

4.2.1 Valve assembly. Qualification inspection of the valve assembly shall consist of performing the examinations and tests specified (see 4.5.1, 4.5.2, 4.6.1.1, 4.6.1.2, 4.6.1.3, 4.6.1.4, 4.6.1.5, 4.6.1.6, 4.6.1.7, and 4.6.1.8).

4.2.2 Flow controller. Qualification inspection of the flow controller shall consist of performing examinations and tests specified (see 4.5.1, 4.5.2, 4.6.2.1, 4.6.2.2 and 4.6.2.3).

4.2.3 Break-off nipple. Qualification of the break-off nipple shall consist of performing the examinations and tests specified (see 4.5.1, 4.5.2, 4.6.3.1 and 4.6.3.2).

4.2.4 Qualification samples. Qualification samples shall consist of 2 valve assemblies or 2 peripheral components of each specification sheet PIN for which qualification is desired, 2 flow controllers, or 12 break-off nipples or 6 connectors are required if qualified individually. Other component parts of the valve can not be qualified unless the valve assembly is qualified (see 6.3).

4.3 Conformance inspection. Quality conformance inspection shall consist of performing the examinations and tests listed in table I for valve assemblies, table II for flow controllers, or table III for break-off nipples.

4.3.1 Sampling inspection.

4.3.1.1 Procedure. The lot size for sampling plan inspection shall be 50 units. That is, 50 valve assemblies, 50 flow controllers or 50 break-off nipples that have been manufactured under essentially the same conditions using the same facilities, equipment and processes shall be one lot. Continuous production is not required. Components parts and materials need not be delivered from the same batch or lot. One unit from each lot shall be randomly selected for sampling inspection. The size of the order or delivery shall not affect the sampling procedure. Production records would be used to assure that one out of every 50 units produced is subjected to sampling inspection.

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4.3.1.2 Rejection and retest. If one or more items selected from a lot fail to meet the specification, acceptance of all items in the lot shall be withheld until the extent and cause of failure have been determined. The contractor shall explain fully to the Government representative and notify the procuring activity in writing the cause of failure, the action taken to preclude recurrence, and the impact this failure might have on scheduled deliveries. After correction, all of the sampling inspection shall be repeated.

4.3.1.3 Continuation of inspection. For production reasons, individual inspection or other sampling plans may be continued pending the investigation of a sampling inspection failure. Final acceptance of the entire lot or lots produced later shall not be made until it is determined that all items meet all the requirements of this specification.

4.3.1.4 Defects in items already accepted. The investigation of a test failure could indicate that defects might exist in items already accepted. If so, the contractor shall fully advise the procuring activity of all defects likely to be found and the method of correcting them.

4.4 Inspection conditions. Unless otherwise specified, all inspections shall be performed in accordance with the test conditions specified in this specification.

4.4.1 Gas. The gas used in performing the tests shall be oxygen conforming to type I of MIL-O-27210.

4.4.2 Temperature and pressure. Unless otherwise specified, tests shall be conducted at local ambient temperature and barometric pressure. Corrections shall be made to provide agreement with the temperature and pressure calibration of the instruments. Inspection data provided by any instruments not calibrated to normal temperature and pressure (NTP) conditions shall be corrected to determine NTP requirements. NTP conditions are 29.92 inches of mercury and 70° F.

4.4.3 Fixtures.

4.4.3.1 Valve. Valves used in testing the flow controller and break-off nipple shall conform to MIL-DTL-7560/1 (dash number optional), except the hose need not contain the connector and shall have a minimum length of 1 foot.

4.4.3.2 Cylinders. Cylinders used in performing the tests shall be MS26545A2X0022 cylinders.

4.5 Methods of inspection.

4.5.1 Examination of product. The valve assembly, flow controller, or break-off nipple, shall be examined to determine compliance with this specification and applicable specification sheet and to determine the existence of any defects listed in table IV.

4.5.2 Examination of dimensions. The valve assembly, flow controller, or break-off nipple shall be examined to determine if dimensions are as specified. The depth of the centerline hole of the break-off nipple is a critical dimension and each break-off nipple manufactured shall be checked. Any dimension not within tolerance shall be considered a defect.

4.6 Test methods.

4.6.1 Valve assembly.

4.6.1.1 Leakage. A leakage test shall be performed on the valve assembly with the pressure gage, flow controller, break-off nipple, and section of hose, and the nipple bushing installed. The starting torque for the pressure gage is 40 inch-pounds with a maximum torque of 250 inch-pounds. The valve and hose assembly shall be pressurized to a minimum gaseous pressure of 2,500 psig and submerged in water for at least 5 minutes. The

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entire hose and valve, except the pressure gage, shall be completely submerged. The valve shall be positioned during submersion to prevent water entering the pressure gage case. The minimum pressure shall be maintained while the valve is submerged. A release of air bubbles from any portion of the hose or valve assembly after 1 minute shall be cause for rejection (see 3.5.1.1).

4.6.1.2 Retaining pin removal force. The retaining pin shall be pulled and the force required to pull the pin shall be measured. The force required shall be as specified (see 3.5.1.2).

4.6.1.3 Fill and operation. The valve assembly shall be installed on an MS26545A2X022 cylinder with a starting torque of 100 inch-pounds and a maximum torque of 400 inch-pounds. The cylinder shall be filled to a minimum pressure of 2,100 psig through the fill connection of valve. The instrumentation required to measure the force applied to the actuating cable and the gas flow through the hose shall be connected to the valve assembly. A steadily increasing force shall be applied to the ball of the actuating cable in a direction away from the valve until the gas is discharged. The force required on the actuating cable to discharge the gas through the hose shall be as specified (see 3.5.1.3). The rate of gas flow through the hose shall be as specified (see 3.5.2.1 or 3.5.2.2) as appropriate for the temperature conditions.

4.6.1.4 Actuating cable housing attachment. A minimum static force of 35 pounds shall be applied to the actuating cable housing for at least 2 minutes. The force shall be applied in a manner to attempt separation of the cable housing from the cable housing retainer. The cable housing shall not be deflected more than 10 degrees during the test. Any indication of the cable housing separating from the retainer shall be cause for rejection (see 3.5.1.4).

4.6.1.5 Actuating cable assembly attachment. The valve assembly shall be securely anchored, the safety pin installed, and a force as specified (see 3.5.1.5) applied to the actuating cable ball in a direction away from the valve. With the force continuously applied, the ball shall be moved in a circle so that the path of the cable will be conical about the normal position of the cable. During the circular movement, the displacement angle of the cable from the normal position shall be at least 60 degrees. The ball shall be moved under this condition in one direction for five complete circles. After exposure to this force and movement, the ball and cable assembly and the attaching bracket shall not exhibit any indications of failure.

4.6.1.6 Operation at high and low temperatures. With the valve assembly installed on a cylinder as specified (see 4.6.1.3) and the cylinder charged to 2,100 psig oxygen, the assembly shall be exposed to a temperature of 160° F or higher for 3 hours. After this conditioning period and while at this temperature, the valve shall be subjected to and pass the operation part of the test specified (see 4.6.1.3). After passing the 160° F test, the assembly shall be recharged to 2,100 psig oxygen and exposed to a temperature of -65° F or lower for 3 hours. After this conditioning period and while at this temperature, the valve shall be subjected to and pass the operation part of the test specified (see 4.6.1.3).

4.6.1.7 Vibration. The valve assembly shall be vibrated for a minimum of 8 hours at a frequency varying from 500 to 2,500 cycles per minute in a vertical plane at a double amplitude of not less than 0.018 nor more than 0.020 inch. The valve assembly shall be pressurized at a minimum pressure of 2,100 psig during the vibration. After vibration, the valve shall be subjected to and pass the test specified (see 4.6.1.1 and 4.6.1.3).

4.6.1.8 Hose fitting to hose attachment. The hose shall be secured and a slowly increasing force shall be applied to the hose fitting in a manner to attempt separation of the hose from the fitting. The force shall be increased at the rate of approximately one pound per second. The hose and fitting shall have been assembled not less than 72 hours prior to the test. The attachment shall meet the requirements specified (see 3.5.1.8).

4.6.2 Flow controller.

4.6.2.1 Total flow. The flow controller shall be installed in the valve assembly and subjected to and pass the fill and operation test specified (see 4.6.1.3), except the actuating force need not be measured.

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4.6.2.2 Flow at high (160° F) and low (-65° F) temperatures. The flow controller shall be installed in a valve assembly and subjected to and pass the operation at high and low temperature test specified (see 4.6.1.6). The actuating force need not be measured.

4.6.2.3 Vibration. After the flow controller has passed the test specified (see 4.6.2.2), the controller shall be subjected to and pass the vibration test specified (see 4.6.1.7) while installed in a valve assembly.

4.6.3 Break-off nipple.

4.6.3.1 Leakage. The nipple shall be installed in a valve conforming to MIL-DTL-7560/1 and subjected to and pass the test specified (see 4.6.1.1).

4.6.3.2 Fracture force. After passing the leakage test, the nipple shall be installed in a valve conforming to MIL-DTL-7560/1. The valve shall be pressurized through the inlet end with a minimum pressure of 2,100 psig. With the safety pin removed, steadily increasing force shall be applied to the ball in a direction away from the valve until the gas is discharged. The applied force shall be measured and the force required to break the nipple shall be as specified (see 3.5.3.2).

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' 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.

6.1.1 Valve assembly. The valve assembly is intended as a component of a bailout cylinder assembly. The valve provides a method of releasing and controlling the flow of oxygen from the cylinder. Refer to T.O. 15X1-4-2-12 for assembly instructions.

6.2 Acquisition requirements. Acquisition documents must specify the following:

- a. Title, number, and date of the specification.
- b. Issue of DODISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.1).
- c. Level of preservation, packaging, and packing required (see 5.1).
- d. Samples subjected to the fracture test (see 4.6.3.2) are not to be considered or shipped as part of the contract or order.
- e. PIN of valve assembly, flow controller, or break-off nipple desired (see 1.2, 3.4 and specification sheet).

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6.3 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 contractors 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 they may be eligible to be awarded contracts or orders for the products covered by this specification. The activity responsible for the Qualified Products List is OC-ALC/TICLA Tinker AFB, OK 73145-3037, and information pertaining to qualification of products may be obtained from that activity.

6.4 Definition.

6.4.1 Flow control. The flow controller is intended as a component of the MIL-DTL-7560/1 valve assembly. The controller limits the flow of oxygen through the valve.

6.4.2 Break-off nipple. The break-off nipple is intended as a component of the MIL-DTL-7560/1 valve assembly. The nipple provides a method of opening the passage through the valve.

6.5 Filter. The source for the filter in the past has been a Porex No. 2 manufactured by the Moraine Products Division, General Motors Corporation, Dayton, Ohio.

6.6 Subject term (key word) listing.

Bailout bottle
Break-off nipple
Breathing oxygen
Flow controller
Hose
Survival System

6.7 International standardization. Certain provisions of this specification are the subject of international standardization agreement ASCC Air Standard 15/14. When amendment, revision, or cancellation of this specification is proposed which affects or violates the international agreement concerned, the preparing activity will take appropriate reconciliation action through international standardization channels including departmental standardization offices, if required.

6.7 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.

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TABLE I. Valve Assembly - quality conformance inspection, sampling, and acceptance criteria

Inspection	Method	Sample size	Acceptance criteria
Visual examination see table IV		Each valve	Reject all defective valves
Examination of dimensions	4.5.2	4.3.1	Acceptance number - 0 Rejection number - 1
Leakage	4.6.1.1	Each valve	Acceptance number - 0 Rejection number - 1
Retaining pin removal force	4.6.1.2	4.3.1	Acceptance number - 0 Rejection number - 1
Fill and operation	4.6.1.3	4.3.1	Acceptance number - 0 Rejection number - 1
Actuating cable housing attachment	4.6.1.4	4.3.1	Acceptance number - 0 Rejection number - 1
Actuating cable assembly attachment	4.6.1.5	4.3.1	Acceptance number - 0 Rejection number - 1
Operation at high and low temperature	4.6.1.6	4.3.1	Acceptance number - 0 Rejection number - 1
Hose fitting to hose attachment	4.6.1.8	4.3.1	Acceptance number - 0 Rejection number - 1

TABLE II. Flow controller - Quality conformance inspection, sampling, and acceptance criteria

Inspection	Method	Sample size	Acceptance criteria
Visual examination	Table IV	Each flow controller	Reject all defective flow controllers
Examination of dimensions	4.5.2	4.3.1	Acceptance number - 0 Rejection number - 1
Total flow	4.6.2.1	4.3.1	Acceptance number - 0 Rejection number - 1
Flow at high and low temperatures	4.6.2.2	4.3.1	Acceptance number - 0 Rejection number - 1

TABLE III. Break-off nipple, conformance inspection, sampling, and acceptance criteria

Inspection	Method	Sample size	Acceptance criteria
Visual examination	Table IV	Each nipple	Reject all defective nipples
Examination of dimensions	4.5.2	4.3.1	Acceptance number - 0 Rejection number - 1
Leakage	4.6.3.1	Each nipple	Reject all defective nipples
Fracture	4.6.3.1	4.3.1	Acceptance number - 0 Rejection number - 1

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TABLE IV. Visual examination of the valve assembly, flow controller, or break-off nipple

1. Material imperfections - foreign matter embedded.
2. Surface - unclean, aligned, or containing cracks.
3. Any component missing, malformed, fractured, or otherwise damaged.
4. Any component loose or otherwise not securely retained..
5. Incorrect assembling or improper positioning of components

Custodians:
Army - AV
Navy - AS
Air Force - 99

Preparing Activity:
Air Force - 71

Agent:
Air Force - 99

Reviewing Activity:
Air Force - 11
DCSC/SSM - CS

(Project 1660-0647)

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 waiver any portion of the referenced document(s) or to amend contractual requirements.

I RECOMMEND A CHANGE:

1. DOCUMENT NUMBER
MIL-DTL-7560D

2. DOCUMENT DATE (YYMMDD)
97/06/20

3. DOCUMENT TITLE

VALVE ASSEMBLY,OXYGEN CYLINDER,BAILOUT

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)*

e. DATE SUBMITTED
(YYMMDD)

(1) Commercial
(2) AUTOVON
(If applicable)

8. PREPARING ACTIVITY

a. NAME

OC-ALC/LIRRC

b. TELEPHONE *(Include Area Code)*

(1) Commercial (405) 736-5960 (2) AUTOVON 336-5960

c. ADDRESS *(Include Zip Code)*

3001 STAFF DRIVE
TINKER AFB, OK 73145-5990

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