

**INCH POUND**

**MIL-DTL-82288C**

**26 June 2000**

**SUPERSEDING**

**MIL-T-82288B**

**23 January 1981**

## **DETAILED SPECIFICATION**

### **TARPAULIN: LAMINATED, VINYL-NYLON OR VINYL-POLYESTER, FLEXIBLE**

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 requirements for tarpaulins fabricated of flexible, vinyl-nylon or vinyl polyester, laminated cloth.

\*1.2 Classification. (See 6.2):

Type I - 16 ft. X 100 ft.

Type II - 14 ft. X 12 ft.

#### **2. APPLICABLE DOCUMENTS**

\*2.1 General. The documents listed in this section are specified in sections 3 and 4 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 and 4 of this specification, whether or not they are listed.

2.2 Government documents.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Defense Supply Center Philadelphia, Clothing and Textiles Directorate, Attn: DSCP-CNR, 700 Robbins Avenue, Building 6D, Philadelphia, PA 19111-5094, by using the Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

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2.2.1 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 issue 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).

## **SPECIFICATIONS**

### **FEDERAL**

- |           |   |
|-----------|---|
| V-T-285   | - Thread, Polyester   |
| DDD-L-20  | - Label, for Clothing, Equipage and Tentage, (General Use)                                |
| A-A-55308 | - Cloth and Strip, Laminated or Coated, Vinyl Nylon or Polyester, High Strength, Flexible |

## **STANDARDS**

### **FEDERAL**

- |             |   |
|-------------|---|
| FED-STD-595 | - Colors Used in Government Procurement |
|-------------|---|

\*(Unless otherwise indicated, copies of federal and military specifications, standards and handbooks are available from the Document Automation And Production Service, Bldg. 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.)

\*2.2 Non-Government publications. The following document(s) 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 this 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).

### **AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.**

NASM16491 – Grommet, Metallic, General Specification For

\*(Copies may be obtained from the Aerospace Industries Association Of America, Inc. 1250 Eye Street, N.W., Washington, DC 20005).

### **AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)**

D5034 - Breaking Force and Elongation of Textile Fabrics  
D6193 - Seams, Stitching and Sewing

(Copies may be obtained from the American Society for testing and Materials, 100 Barr Harbor Drive, West Conshohocken, PA 19428.)

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\*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 specification, 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 (see 4.2 and 6.2).

\*3.2 Materials and components. Materials and components shall be as specified herein and in referenced documents and drawings. Materials not definitely specified shall be of the quality normally used by the manufacturer provided the complete item complies with all provisions of this document. It is encouraged that recycled material be used when practical as long as it meets the requirements of this document.

\*3.2.1 Base fabric. The base fabric for the Type I Tarpaulin shall conform to Type I, Class 1, 2 or 3, form 1 or Type II, Class 2, Form 1 as specified (see 6.2) of A-A-55308. The base fabric for the Type II Tarpaulin shall conform to Type II, Class 2, Form 1 of A-A-55308. The smooth side of the fabric shall be the face of the finished tarpaulin.

3.2.2 Color. The color or color combinations for the Type I and Type II tarpaulins shall be as specified (see 6.2) and shall conform to FED-STD-595.

\*3.2.3 Grommets. The grommets shall be in accordance with NASM16491.

3.2.4 Thread, polyester. The thread used for all stitching shall conform to Type I, Class 1, subclass B, size FF of V-T-285. The thread may be colored or natural. When colored thread is used, the thread shall approximately match the color specified for the base fabric. Requirements for colorfastness shall not apply.

3.2.5 Adhesive. Adhesive used to cement the seams and hems shall be of a type compatible with the coated fabric and shall be capable of producing seams to meet the requirements of 3.4.2.3. All cemented areas shall be thoroughly dried and talced if necessary.

### 3.3 Design.

3.3.1 Type I Tarpaulin. The size of the Type I tarpaulin shall be as specified in 1.2. It shall be fabricated from lengths of the specified base fabric, joined by heat-sealed seams along their lengthwise edges and be furnished with a plain edge and without grommets.

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3.3.2 Type II Tarpaulin. The size of the Type II tarpaulin shall be as specified in 1.2. The design of the Type II tarpaulin shall be in accordance with figure 1. The tarpaulin shall be fabricated from lengths of the specified base fabric with heat-sealed or cemented seams. The tarpaulin shall have a turn under hem and be furnished with grommets as specified in 3.2.3 and attached as in figure 2.

3.4 Construction. The construction of the tarpaulins shall conform to figures 1 and 2 and the requirements herein.

3.4.1 Type I, Tarpaulin.

3.4.1.1 Width. The type I tarpaulin shall be made of four (4) widths of material specified in 3.3.1 and shall be constructed by heat sealing along their warpwise edges so that the overall width shall measure 16 feet (+5 inches - 1 inch).

3.4.1.2 Length. The finished length of the type I Tarpaulin shall be 100 feet (+3 ft.-0 ft.). The parallel outer edges of the tarpaulin shall measure within 2 feet of each other.

3.4.1.3 Splices. Each width of basecloth heat sealed together shall consist of not more than two (2) unbroken continuous lengths, heat sealed together in the same manner as the long sides and as specified in 3.4.1.4. None of the pieces so spliced shall be less than seven (7) yards in length. Splices shall be so staggered that on adjacent widths the splices are not less than 18 inches apart.

\*3.4.1.4 Seams. Type I Tarpaulin seams shall be constructed by the use of a heat sealing apparatus or machine. The fused zone shall be not less than  $\frac{3}{4}$  inch wide and shall be uniform in appearance. The seam shall extend along the entire length of the tarpaulin. The excess material along the edge of the seam on both face and back shall not exceed  $\frac{1}{4}$  inch and shall not contain any brittle or excess materials. The strength of the seam shall not be less than 150 pounds per inch when Type I, Class 2, Form 1 of A-A-55308 is used and not less than 70 pounds per inch when Type II, Class 2, Form 1 fabric of A-A-55308 is used. If the seam strength is not measurable because the base fabric itself is breaking while the heat sealed seam remains intact, the seam strength shall be considered acceptable, provided the base fabric itself meets the break strength requirement of A-A-55308. Testing shall be as specified in 4.5. Heat sealed seams shall be smooth, fully adhered throughout their lengths and shall be free of puckers, air pockets or tunnels. As an alternate to heat sealing, any other suitable method except stitching may be used provided the above requirements are met.

3.4.1.5 Heat sealed sheet.

3.4.1.5.1 Area. The area of each heat sealed sheet shall be computed individually and recorded on its shipping container in square feet. When the unit of purchase is a square foot, the computed area shall be the basis for invoicing. The formula below shall be used to compute the area of each sheet (reported to the nearest square foot):

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3.4.1.5.2 Length. Each heat sealed sheet shall be pre-measured before further processing.

$$\frac{\begin{array}{l} \text{Length of the shorter of the two sides in inches} \\ \text{X } 192 \text{ (in nom. Width)} \end{array}}{144 \text{ (inches in a square foot)}} = \text{sq. feet}$$

3.4.1.6 Cleanliness. Type I tarpaulins when procured in yellow shade 23655 of FED-STD 595 are applicable to a critical end use and shall be completely free and clean from all defects which could cause contamination in that use.

3.4.2 Type II Tarpaulin. The tarpaulin shall be made as shown in figure 1. The finished tarpaulin shall be made of not more than three (3) panels of the material specified in 3.2.1. Seams shall be either heat-sealed or cemented with a suitable adhesive (see 3.2.5).

3.4.2.1 Dimensions. Measurements shall be 14 feet ( $\pm 2$  inches) in length and 12 feet ( $\pm 2$  inches) in width.

\*3.4.2.2 Splices. No more than one lengthwise panel in a tarpaulin may have one widthwise splice. The splice may be no closer than 3 feet from the end of the tarpaulin. The seams shall be spliced in accordance with 3.4.1.4.

3.4.2.3 Seams. The seams shall be full length and shall be parallel to the lengthwise direction of the tarpaulin. Seams may be either heat sealed or cemented. The strength of the seam shall be not less than 70 pounds per inch when tested as specified in 4.5. All seams shall be smooth and fully adhered throughout their lengths and shall be free of puckers, air pockets or tunnels. As an alternate to heat sealing or cementing, any other suitable method except stitching may be used provided the above requirements are met.

3.4.2.4 Hems. The type II, tarpaulin shall have a two-inch, double turn under hem either cemented, with a suitable adhesive (see 3.2.5) heat sealed or stitched as shown in figure 1.

3.4.2.4.1 Stitching. All stitching shall conform to stitch type 301 or 401 of ASTM-D 6193 , 7 to 9 stitches per inch. Stitching type for the hem shall be in accordance with figure 1. Thread breaks in stitching shall be overstitched not less than 1 inch at each break, except where ends are turned under in a hem and held down by the other stitching. Thread breaks of 401 stitch type shall be repaired using 301 stitch type. The addition of any lubricant to the polyester thread prior to or during the sewing operation is prohibited.

3.4.2.5 Attaching of grommets. Grommets, as specified in 3.2.3, shall be attached in accordance with figure 1. Holes punched to receive grommets shall be smaller than the outside diameter of the grommet barrel so that the grommet must be forced through the hole. Grommets shall be securely clinched without cutting the material.

3.4.3 Patches. The application of repair patches to the surface of the laminated cloth and over welded seams shall be permitted on either face or back of the sheets. Patches shall be made of the specified basecloth and the surface grain shall run in the same direction, and shall be facing

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up or down in the same manner as the basecloth to which they are attached. Patches over a single ply of the basecloth shall not exceed two (2) inches in their longest dimension. They shall be rounded all along their circumference and the edges shall be smooth and free from protrusions. Patches shall be either welded or cemented to the laminated cloth to adhere firmly and completely. There shall be no loose areas nor shall any portion of a patch come loose when the cloth is flexed or patches are probed manually. There shall be no more than six patches on either face or back of any heat sealed sheet. Patches over the fused zone shall be heat sealed completely and fused to the area to which they are attached. They shall be completely aligned with the weld and trimmed as specified. Only one side of a fused zone may be patched (face or back) along any given length. There shall be no more than 18 inches of patching on either face or back of the heat sealed sheet, continuously or intermittently, over any one of the lengthwise seams and there shall be no patch over any transverse seam.

3.5 Marking. All marking shall conform to requirements specified in DDD-L-20 and shall be on the face side of the base fabric.

3.5.1 US marking. Tarpaulin shall have the letters "US". The marking shall conform to Type IV, class 9 of DDD-L-20, and shall show good colorfastness to accelerated weathering. The lettering for Type I tarpaulin shall be  $\frac{3}{4}$  inch block letter and shall appear on the face side, one in each square yard approximately. The lettering for Type I tarpaulin shall be in accordance with Figure I.

3.5.2 Identification marking. Marking for the Type II tarpaulin shall conform to Type IV, class 8 of DDD-L-20. Location of markings shall be as shown on figure 1 and shall include the following: Item description, Contract No., Federal Stock No., Size, and Contractor's name.

\*3.6 Workmanship. The finished tarpaulins shall conform to the quality of product established by this specification.

#### 4. VERIFICATION

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

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

4.2 First article inspection. When a first article is required (see 6.2) it shall be examined for the defects listed in 4.4.3.

4.3 Conformance inspection. Sampling for inspection shall be as specified in the contract or purchase order.

4.3.1 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.

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4.3.1.1 Examination of length of the laminated cloth. In addition to the examination and tests required by the applicable specification, the laminated cloth shall be examined during the measuring operation to verify accuracy of length. Pre-measured lengths shall be suitable for further processing if all tolerances are met for the finished, heat sealed sheets.

4.3.2 In-process inspection. Inspection shall be made at any point or during any phase of the manufacturing process to determine whether operations or assemblies are carried out as specified. The Government reserves the right to exclude from consideration for acceptance any material or service for which in-process inspection has indicated nonconformance.

4.3.3 Examination of the end item. Defects found during the examination of the end item shall be classified in accordance with 4.3.4 and 4.3.4.1. The sample unit shall be one completely fabricated tarpaulin. The lot size shall be expressed in units of all completely fabricated tarpaulins offered for inspection at one time.

4.3.3.1 Responsibility for dimensional requirements. Unless otherwise specified in the contract or purchase order, the contractor is responsible for ensuring that all specified dimensions in the applicable drawing has 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.

4.3.4 End item visual examination. Visual examination of the face and back of the completely fabricated tarpaulins shall be made for the defects outlined in Table I.

Table I – Classification of Defects

Examine	Defect	Classification	
		Major	Minor
Material	Hole, cut, tear, blistered, abrasion		
	coating missing	101	
	Not the specified color	102	
	Color off-shade, mottled or shaded		201
	Any fabric defect (A-A-55308)		
Patches	not repaired or not completely repaired		
	by patches	103	
	Delamination	104	
	Fabric other than base fabric being		
	repaired	105	
	Not facing to same side as base fabric		
	(face or back)		202
	Not aligned in same direction as		
	surface grain of base fabric		203
	More than 2 inches long		204
	Edges not rounded		205

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Table I. End item visual examination. (cont'd)

Examine	Defect	Classification	
		Major	Minor
Seams	Edges not smooth and free from protrusions		206
	Not completely and firmly attached	106	
	Edge coming loose when flexed manually	107	
	More than six patches on either face or back of sheet	108	
	Not completely aligned with weld		207
	Not completely fused	109	
	Same weld area patched on both sides		208
	Any transverse seam patched	110	
	More than 18 inches of seam patched either side		209
	Less than $\frac{3}{4}$ inch wide (Type I)	111	
	Any open area, puckered, delaminated area, or not completely fused	112	
	Any burn out or blister	113	
	Seam not forming straight line	114	
	Not uniform in appearance, distortions		210
	Cemented seam not talced if necessary		211
	Flashing (excess on edges) more than $\frac{1}{4}$ inch wide	115	
	More than three parallel lengthwise seams (Type I)	116	
	Any double seam	117	
Workmanship	Any excess material or brittle areas in the seams subject to cracking or flaking off	118	
	More than two continuous (unbroken) pieces in any component width (Type I)	119	
	More than one splice per tarpaulin (Type II)	120	
	Any piece less than three feet (Type II)	121	
	Any piece less than seven yards long		212
	Transverse splices in adjacent component widths less than 18 inches apart	122	
	More than 3 panels (Type II)	123	
	Any required component or operation omitted	124	
	Wrong side of fabric used as face side	125	
	Open hem (on stitched hems):		
Hems Type II stitches	- 1 inch or less		213
	- more than 1 inch	126	
	Run offs (see open hem)		214



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Table I. End item visual examination. (cont'd)

Examine	Defect	Classification	
		Major	Minor
NOTE: A hem shall be classified as open when one or more stitches joining a hem are broken, or when two or more continuous skipped stitches or run-offs occur, and are not overstitched.			
	Thread breaks:		
	- overstitches less than 1 inch		215
NOTE: Thread breaks not overstitched shall be classified as an open hem.			
Hem and stitch type	Cemented hem not talced if necessary		216
	Needle chews	127	
	Wrong hem or stitch type	128	
Stitch tension	Loose, resulting in a loosely exposed		
	bobbin or top thread		217
	Tight, resulting in excessive tightness or puckering of fabric	129	
Stitches per inch	One stitch less than minimum specified		218
	Two or more stitches less than minimum specified	130	
	One or more stitches in excess of maximum specified		219
Stitching margin	Larger than specified:		
	- by more than 3/16 inch for more than 4 inches		220
Stitching gage	Not as specified		221
Stitching ends	Overstitched less than one inch (except where ends are held down by other stitching or turned under in a hem)		222
Hems: Type II	Badly pleated, puckered, or twisted		223
Heat sealed or cemented	Any hem area open, any channel	131	
Grommets	Not properly cemented or heat sealed	132	
	Improperly set:		
	- excessively loose, allowing grommets to rotate in hole		224
	- excessively tight, cutting surrounding fabric	133	
Marking	Omitted, incorrect, illegible, or misplaced		225

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Table I. End item visual examination. (cont'd)

Examine	Defect	Classification	
		Major	Minor
Cleanness <u>1/</u>	Any surface dust		226
	Any stain or foreign matter, clearly visible at 6' distance		227
	Overall uncleanness		228
"US" marking	Omitted, illegible, or not on face of sheet		
	Wipes off or smears when rubbed with finger		229
	Lettering not specified size		230
	Marking not applied as specified (Type I)		231

1/ Any surface dust, stain, foreign matter or overall uncleanness on either side of Type I tarpaulin made in the yellow shade 23655, shall cause a rejection of the lot presented.

4.3.4.1 Dimensional examination. Any dimension not within the specified tolerances shall be classified as a defect.

\*4.3.5 Inspection levels. The inspection levels shall be as follows:

	Inspection <u>Level</u>
For defects applicable to 4.4.4 (Type I)	I
For defects applicable to 4.4.4 (Type II)	II
For defects applicable to 4.4.4.1	S-3

4.4 Testing of the end item. The finished heat sealed sheets shall be tested for strength of seams (see 4.41). In lieu of the actual end items, sample units for testing shall be prepared by cutting one linear yard in half in warp direction and by heat sealing the two pieces together warpwise along their two uncut edges, using the same apparatus, temperature and sealing time as would be used during the actual production of the sheets. Three such sample units shall be prepared for each lot. For each sample unit, a different roll of laminated fabric shall be used and the roll number shall be marked on the sample unit. The lot shall be unacceptable if one or more sample units fail to meet the requirement for strength of seam.

4.4.1 Testing of seams. The seam strength shall be tested in accordance with ASTM-D 5034 (G-E or G-T) with the following modifications:

The test specimen shall be a rectangle of cloth measuring 4 inches by a minimum of 6 inches, with the welded seam in the middle of the rectangular strip. The short dimension of the specimen shall be parallel to the welded seam. Five (5), specimens prepared as indicated above shall be tested from each unit of product and the average shall be reported as the strength of seam of a sample unit. NOTE: If the seam strength is not measurable because the base fabric itself is breaking while the heat sealed seams remain intact, the seam strength shall be considered acceptable, provided the base fabric itself meets the break strength in A-A-55308.

## 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

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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 type I tarpaulin is intended for use in "clean rooms", gun covers and protective covers for equipment used by the military services. They may be used in one piece or cut to required dimensions as needed. The Type II tarpaulin is intended for use as a light duty general tarpaulin.

\*6.2 Acquisition requirements. Acquisition documents should 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).
- c. When first article inspection is required, (see 3.1).  
The item will be tested and should be a first article sample.  
The contracting officer should include specific instructions in acquisition documents regarding arrangement for examinations, quantity, and testing and approval.
- d. Packaging and preservation requirements (see 5.1).
- e. Type and class of base fabric required (see 3.2.1).
- f. Type of tarpaulin (see 1.2).

\*6.3 Sample. For access to standard sample, address the contracting activity issuing the invitation for bids.

\*6.4 Changes from previous issue. The margins of this specification are marked with asterisks (\*) to indicate where changes from the previous issue were made. 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 and relationship to the last previous issue.

\*6.5 Subject term (key word) listing.

Cover  
Clean rooms  
Gun covers  
Protective covers

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MILITARY INTERESTS:

Custodians:

Navy – NU  
Air Force - 99

Preparing activity:  
DLA - CT

Review activities:

Air Force – 11.6, 82

(Project 8340-0577)

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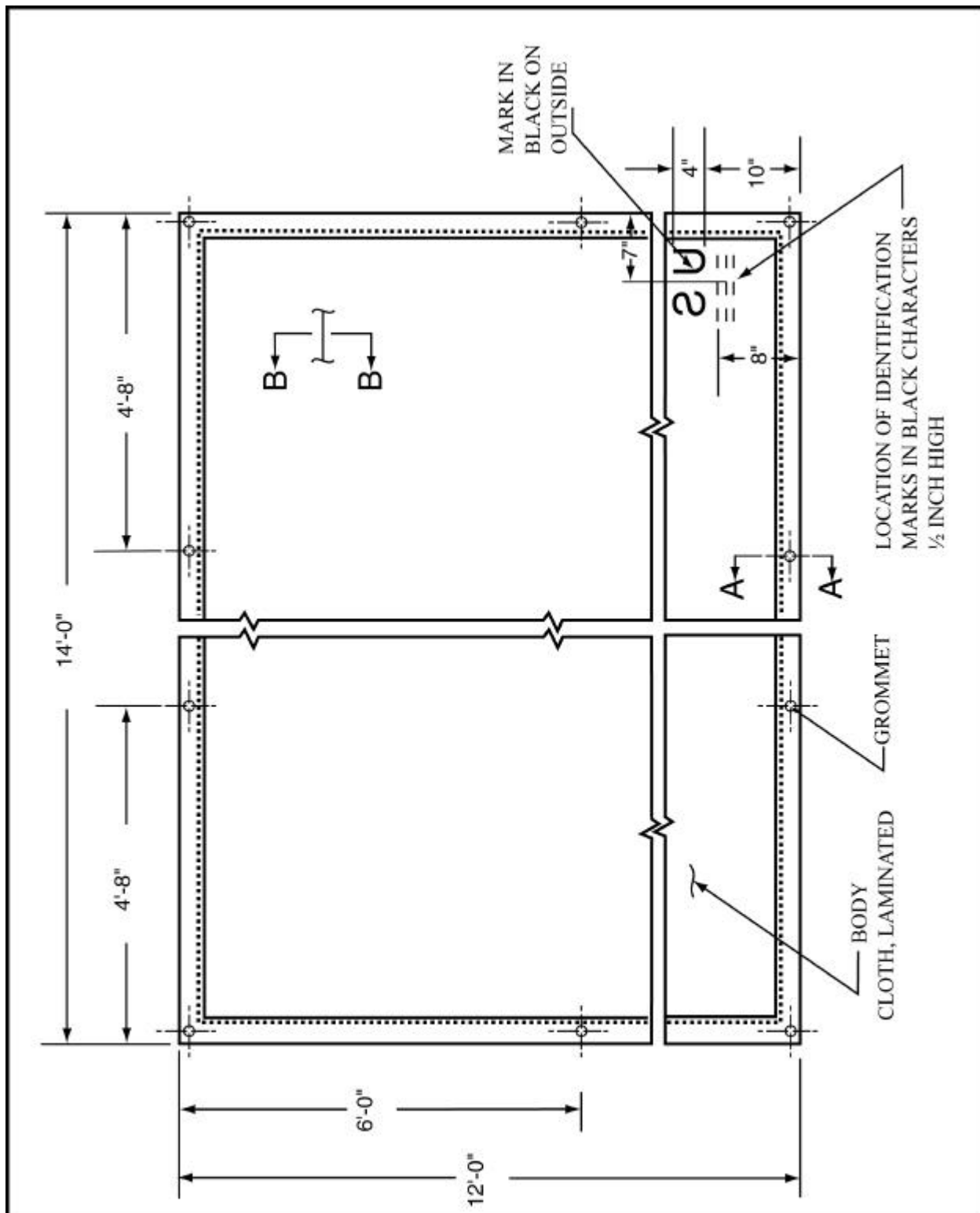


FIGURE 1. INSIDE VIEW OF TYPE II TARPAULIN

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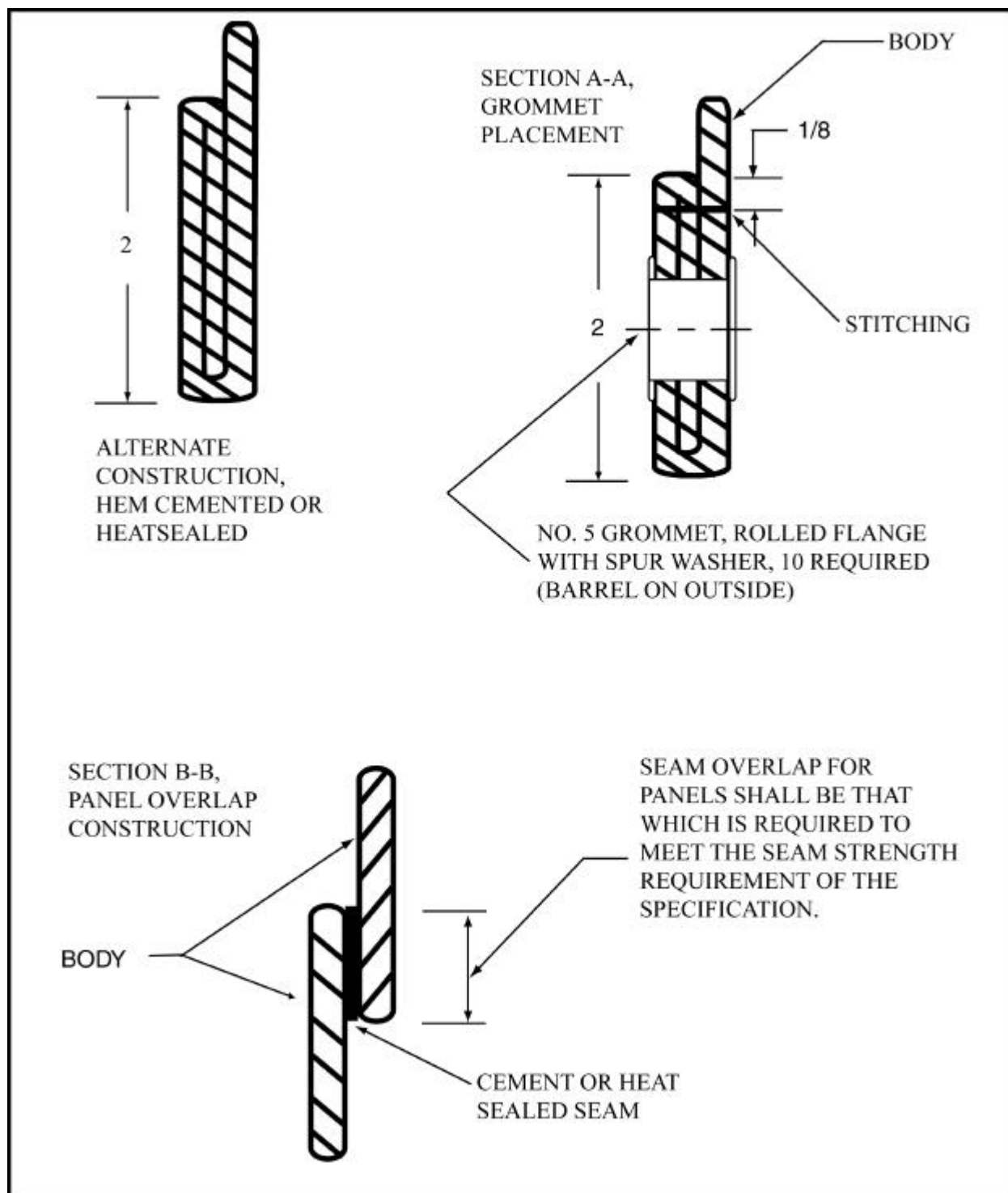


FIGURE 2. SECTIONAL VIEWS OF TARPAULIN

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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 and send to preparing activity.
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-82288C

#### 2. DOCUMENT DATE (YYYYMMDD)

20000626

### 3. DOCUMENT TITLE

TARPAULIN: LAMINATED, VINYL-NYLON OR VINYL-POLYESTER, FLEXIBLE

### 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) DSN

*(If applicable)*7. DATE SUBMITTED  
(YYYYMMDD)

### 8. PREPARING ACTIVITY

a. NAME

DEFENSE SUPPLY CENTER PHILADELPHIA  
DSCP-CNRPb. TELEPHONE *(Include Area Code)*

(1) Commercial

(2) DSN

(215) 737-5653

444-5653

c. ADDRESS *(Include Zip Code)*700 Robbins Ave (Bldg 6, C&T)  
PHILADELPHIA, PA 19111-5092

#### IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT:

Defense Standardization Program Office (DLSC-LM)  
8725 John J. Kingman Road, Suite 2533  
Fort Belvoir, Virginia 22060-6221  
Telephone (703) 767-6888 DSN 427-6888

DD Form 1426, FEB 1999 (EG)

WHS/DIOR, Feb 99

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