

MIL-E-24142B(SH)
 25 January 1984
SUPERSEDING
 MIL-E-24142A(SHIPS)
 31 July 1975
 (See 6.5)

MILITARY SPECIFICATION

ENCLOSURES FOR ELECTRICAL FITTINGS AND FIXTURES, GENERAL SPECIFICATION FOR

This specification is approved for use by the Naval Sea Systems Command, Department of the Navy, and is available for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification covers the general requirements for enclosures for electrical fittings and fixtures used on Naval ships.

1.2 Classification. Enclosures shall be of the submersible or totally enclosed types, and of the sizes as specified on the individual specification sheet (see 6.2.1).

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications and standards. Unless otherwise specified, the following specifications and standards of the issue listed in that issue of the Department of Defense Index of Specifications and Standards (DoDISS) specified in the solicitation form a part of this specification to the extent specified herein.

SPECIFICATIONS

MILITARY

- | | |
|-----------|--|
| MIL-M-14 | - Molding Plastics and Molded Plastic Parts, Thermosetting. |
| MIL-S-901 | - Shock Tests, H.I. (High-Impact); Shipboard Machinery, Equipment and Systems, Requirements for. |
| MIL-E-917 | - Electric Power Equipment, Basic Requirements (Naval Shipboard Use). |

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Commander, Naval Sea Systems Command, SEA 5523, Department of the Navy, Washington, DC 20362 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

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MILITARY (continued)

- MIL-P-15024 - Plates, Tags and Bands for Identification of Equipment.
- MIL-P-15024/5 - Plates, Identification.
- MIL-E-17555 - Electronic and Electrical Equipment, Accessories, and Repair Parts; Packaging and Packing of.

STANDARDS

MILITARY

- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes.
- MIL-STD-108 - Definitions of and Basic Requirements for Enclosures for Electric and Electronic Equipment.
- MIL-STD-167-1 - Mechanical Vibrations of Shipboard Equipment (Type I - Environmental and Type II - Internally Excited).

See Supplement 1 for list of applicable specification sheets.

FEDERAL

- FED-STD-H28 - Screw-Thread Standards for Federal Services.
- FED-STD-H28/2 - Screws, Nuts, Tapped Holes and General Applications Unified Thread Form and Thread Series for Bolts.

(Copies of specifications and standards required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting officer.)

2.2 Other publications. The following documents form a part of this specification to the extent specified herein. The issues of the documents which are indicated as DoD adopted shall be the issue listed in the current DoDISS and the supplement thereto, if applicable.

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

- B 36 - Brass Plate, Sheet, Strip and Rolled Bar. (DoD adopted)
- B 121 - Leaded Brass Plate, Sheet, Strip and Rolled Bar. (DoD adopted)
- B 209 - Aluminum and Aluminum Alloy Sheet and Plate (Alloy 5052). (DoD adopted)
- A 366 - Steel, Carbon, Cold-Rolled Sheet, Commercial Quality. (DoD adopted)
- A 569 - Steel, Carbon (0.15 Maximum Percent) Hot-Rolled Sheet and Strip, Commercial Quality. (DoD adopted)

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.)

(Industry association specifications and standards are generally available for reference from libraries. They are also distributed among technical groups and using Federal agencies.)

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 shall take precedence.

3. REQUIREMENTS

3.1 Specification sheets. The individual enclosure requirements shall be as specified herein and in accordance with the applicable specification sheets. In the event of any conflict between the requirements of this specification and the specification sheets, the latter shall govern.

3.2 First article inspection. When specified, a sample enclosure shall be subjected to first article inspection (see 4.3 and 6.3).

3.3 Definitions. The definitions as specified in MIL-STD-108 shall apply.

3.4 Material. The enclosures and related parts shall be fabricated brass (ASTM B 36, ASTM B 121), steel (ASTM A 366, ASTM A 569), aluminum (ASTM B 209) or plastic (MIL-M-14) as specified in the individual specification sheet.

3.4.1 Recovered materials. Unless otherwise specified herein, all equipment, material, and articles incorporated in the products covered by this specification shall be new and shall be fabricated using materials produced from recovered materials to the maximum extent practicable without jeopardizing the intended use. The term "recovered materials" means materials which have been collected or recovered from solid waste and reprocessed to become a source of raw materials, as opposed to virgin raw materials. None of the above shall be interpreted to mean that the use of used or rebuilt products are allowed under this specification unless otherwise specifically specified.

3.5 Design and construction. Enclosures shall be of the design, construction and physical dimensions as specified in the applicable specification sheet.

3.5.1 Components. When specified in the specification sheet, the components shall be as shown on figures 1 through 21 herein. Unless otherwise specified, tolerances are plus or minus 1/64 inch for fractions and plus or minus 0.005 for decimals.

3.5.2 Threaded parts. Threads shall be in accordance with requirements of FED-STD-H28 and FED-STD-H28/2. Following cleaning in accordance with 3.5.5, thread pitch diameters shall not exceed the requirements in accordance with FED-STD-H28 and FED-STD-H28/2 by more than 1-1/2 percent.

3.5.3 Welding, brazing and similar processes. Welding, brazing and similar processes used in manufacture of enclosures shall be performed so as to withstand all required tests.

3.5.3.1 In lieu of continuous brazing specified in individual specification sheets, enclosures 6 by 9 and larger shall have each component fastened by intermittent localized brazing in such a manner as to insure that each enclosure assembly will not be completely soft-annealed and will not distort or leak when subjected to prescribed impact (see 4.6.1.2).

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3.5.4 Stress relief. Metals used in the manufacture and assembly shall be treated or heat-treated to prevent deterioration or failure due to stresses or other conditions resulting from working, forming, welding and similar processes, during the fabrication of these enclosures.

3.5.4.1 The words "stress relieved" shall be on the outside bottom of each complete unit in 1/4 inch high letters with ink of a grade similar or equal to "clear print opaque" manufactured by Phillips Process Co., Inc., Rochester, NY.

3.5.5 Brass enclosures. Enclosures shall be furnished thoroughly cleaned of all soldering flux and other corrosive agents. Cleaning agent shall be neutralized after cleaning. Cleaning shall be in accordance with MIL-E-917. Brass enclosures shall be furnished neither primed nor painted.

3.5.5.1 Steel and aluminum enclosures. Enclosures shall be pretreated and given one coat of primer in accordance with MIL-E-917.

3.5.6 Screws and washers. Unless otherwise specified in the specification sheet or in the contract (see 6.2.1), screws and washers shall be brass for brass, steel and plastic enclosures and corrosion-resisting steel (CRES) for aluminum enclosures.

3.6 Shock. Enclosures shall withstand the shock test specified in 4.6.1.2.

3.7 Vibration. Enclosures shall withstand the vibration test specified in 4.6.1.3.

3.8 Cover sealing gasket. Cover sealing gasket when required shall be furnished with each enclosure.

3.9 Marking. Marking shall appear on the exterior of the cover of the enclosure in the form of either manufacturer's initials or monogram. The applicable military part number shall appear on the interior of the cover. Marking shall be depressed or embossed in the metal to provide permanent identification.

3.10 Identification plates. Plates for identification of equipment and for information shall be in accordance with MIL-P-15024 and MIL-P-15024/5. These plates, when used with units that will be exposed to the weather, shall be type A, B or C. Material for these plates shall be as follows:

- (a) Brass, steel and plastic enclosures. Brass.
- (b) Aluminum enclosures. CRES or aluminum.

3.11 Workmanship. External projecting edges and sharp corners normally exposed, or to be painted, shall be free from sharp edges, burrs or slivers.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified

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herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.1.1 Inspection system. The contractor shall provide and maintain an inspection system in accordance with the data ordering documents included in the contract (see 6.2.2).

4.2 Classification of inspection. Examination and testing of the enclosure shall consist of the following:

- (a) First article inspection (see 4.3).
- (b) Quality conformance inspection (see 4.4).

4.3 First article inspection. First article inspection shall be conducted on a sample enclosure and shall consist of the examination and all tests specified in 4.5 through 4.6.3 (see appendix A and 6.2.2).

4.4 Quality conformance inspection.

4.4.1 Lot. A lot shall consist of all enclosures of one type and size offered for delivery at one time.

4.4.2 Sampling for quality conformance inspection. Sample enclosures shall be selected at random from each lot in accordance with MIL-STD-105 at inspection level II for the examination and tests specified in 4.5 and 4.6.3. The acceptable quality level (AQL) shall be 1.5 percent defective. Any enclosure in the sample containing one or more defects shall not be offered for delivery, and if the number of defective units in any sample exceeds the acceptance number for that sample, the lot represented by the sample shall be cause for rejection.

4.5 Visual and dimensional examination. The enclosures shall be subjected to a thorough examination to determine that the materials, design and construction are in accordance with the requirements of this specification.

4.6 Tests.

4.6.1 Shock and vibration tests.

4.6.1.1 Brass and plastic submersible enclosures shall be tested as specified in 4.6.1.2 and 4.6.1.3 with a dummy weight bolted to the bottom of a box on pads 1-inch high. A minimum space of 1/2-inch all around between edge of weight and side wall of box shall be maintained. Amount of weight is determined by inside dimensions of box (area of bottom). The weight for boxes up to and including size 4 by 7 shall be 0.4 pounds per square inch (lb/in²) attached to a maximum of three pads. For boxes size 6 by 9 and larger, 0.25 lb/in² of weight shall be provided, and attached to a maximum of eight pads 3/4-inch diameter, located 1-3/4 inches from side walls of the box. Boxes need not be retested with a dummy weight provided that they have been previously tested with an interior fitting of equal or greater weight. Steel and aluminum NWT enclosures shall be tested as part of the applicable fuse box "Symbol NO" principal unit or with a dummy interior fitting of equivalent distributed weight.

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4.6.1.2 Shock test. The enclosure shall be subjected to the high-impact (H.I.) shock tests in accordance with MIL-S-901 for grade A, class I, type A equipment. The number of enclosures to be shock-tested and disposal of shock-tested boxes shall be as specified (see 6.2.1).

4.6.1.2.1 Definition of failure to perform principal functions shall be as follows:

- (a) Breakage of any parts, including mounting bolts.
- (b) Distortion of sides, bottom or cover of box.
- (c) Failure to meet the applicable tests as specified in MIL-STD-108 after completion of class H.I. shock tests.

4.6.1.3 Vibration test. Vibration tests shall be conducted in accordance with type I of MIL-STD-167-1. No resilient mounting shall be used.

4.6.2 Surface roughness. The depth of score marks and height of waviness shall not exceed 125 microinches.

4.6.3 Effectiveness of enclosure tightness. Examination and testing shall be conducted, to determine the effectiveness of enclosure tightness, in accordance with MIL-STD-108.

4.7 Inspection of packaging. Sample packages and packs, and the inspection of the preservation-packaging, packing and marking for shipment and storage shall be in accordance with the requirements of section 5 and the documents specified therein.

5. PACKAGING

(The preparation for delivery requirements specified herein apply only for direct Government acquisition. For the extent of applicability of the preparation for delivery requirements of referenced documents listed in section 2, see 6.4.)

5.1 Preservation-packaging, packing and marking. Enclosures shall be preserved-packaged level A or C, packed level A, B or C and marked in accordance with MIL-E-17555, as specified (see 6.2.1).

6. NOTES

6.1 Intended use. Enclosures covered by this specification are intended for use for electrical fittings and fixtures on Naval ships.

6.2 Ordering data.

6.2.1 Acquisition requirements. Acquisition documents should specify the following:

- (a) Title, number, and date of this specification and applicable specification sheet.
- (b) Type and size required (see 1.2).
- (c) Material for screws and washers, if other than brass (see 3.5.6).

- (d) Number of boxes to be shock-tested and disposal of shock-tested boxes (see 4.6.1.2).
- (e) Levels of preservation, packaging, packing and marking requirements (see 5.1).

6.2.2 Data requirements. When this specification is used in an acquisition which incorporates a DD Form 1423, Contract Data Requirements List (CDRL), the data requirements identified below shall be developed as specified by an approved Data Item Description (DD Form 1664) and delivered in accordance with the approved CDRL incorporated into the contract. When the provisions of DAR 7-104.9 (n)(2) are invoked and the DD Form 1423 is not used, the data specified below shall be delivered by the contractor in accordance with the contract or purchase order requirements. Deliverable data required by this specification is cited in the following paragraph.

<u>Paragraph no.</u>	<u>Data requirement title</u>	<u>Applicable DID no.</u>	<u>Option</u>
4.1.1	Inspection system program plan	DI-R-4803	---
4.3	First article inspection report	DI-T-4902	---

(Data item descriptions related to this specification, and identified in section 6 will be approved and listed as such in DoD 5000.19L., Vol. II, AMSDL. Copies of data item descriptions required by the contractors in connection with specific acquisition functions should be obtained from the Naval Publications and Forms Center or as directed by the contracting officer.)

6.2.2.1 The data requirements of 6.2.2 and any task in sections 3, 4, or 5 of this specification required to be performed to meet a data requirement may be waived by the contracting/acquisition activity upon certification by the offeror that identical data were submitted by the offeror and accepted by the Government under a previous contract for identical item acquired to this specification. This does not apply to specific data which may be required for each contract regardless of whether an identical item has been supplied previously (for example, test reports).

6.3 First article inspection. Invitations for bids should provide that the Government reserves the right to waive the requirement for samples for first article inspection as to those bidders offering a product which has been previously acquired or tested by the Government, and that bidders offering such products, who wish to rely on such production or test, must furnish evidence with the bid that prior Government approval is presently appropriate for the pending contract. (See Appendix A.)

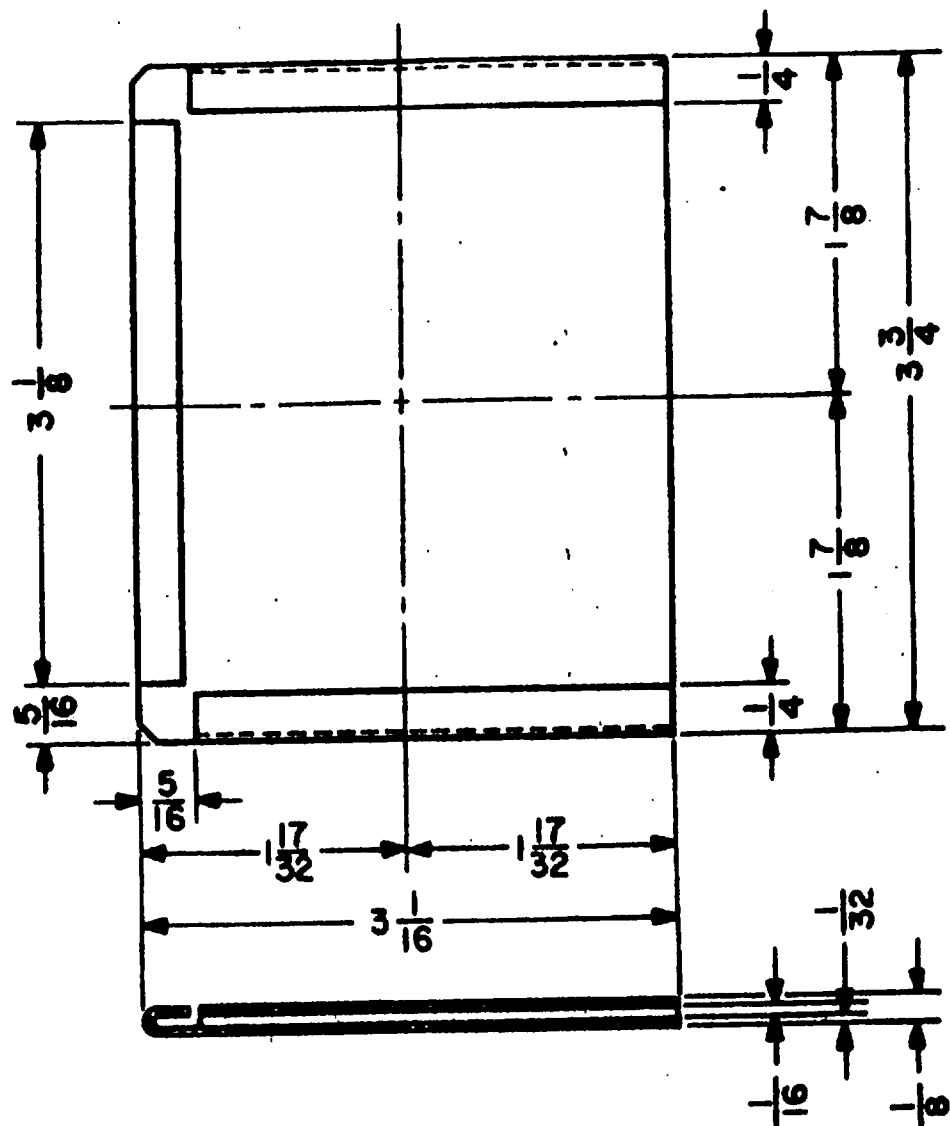
6.4 Sub-contracted material and parts. The preparation for delivery requirements of referenced documents listed in section 2 do not apply when material and parts are acquired by the contractor for incorporation into the equipment and lose their separate identity when the equipment is shipped.

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6.5 Changes from previous issue. Asterisks are not used in this revision to identify changes with respect to the previous issue, due to the extensiveness of the changes.

Preparing activity:
Navy - SH
(Project 5975-N571)

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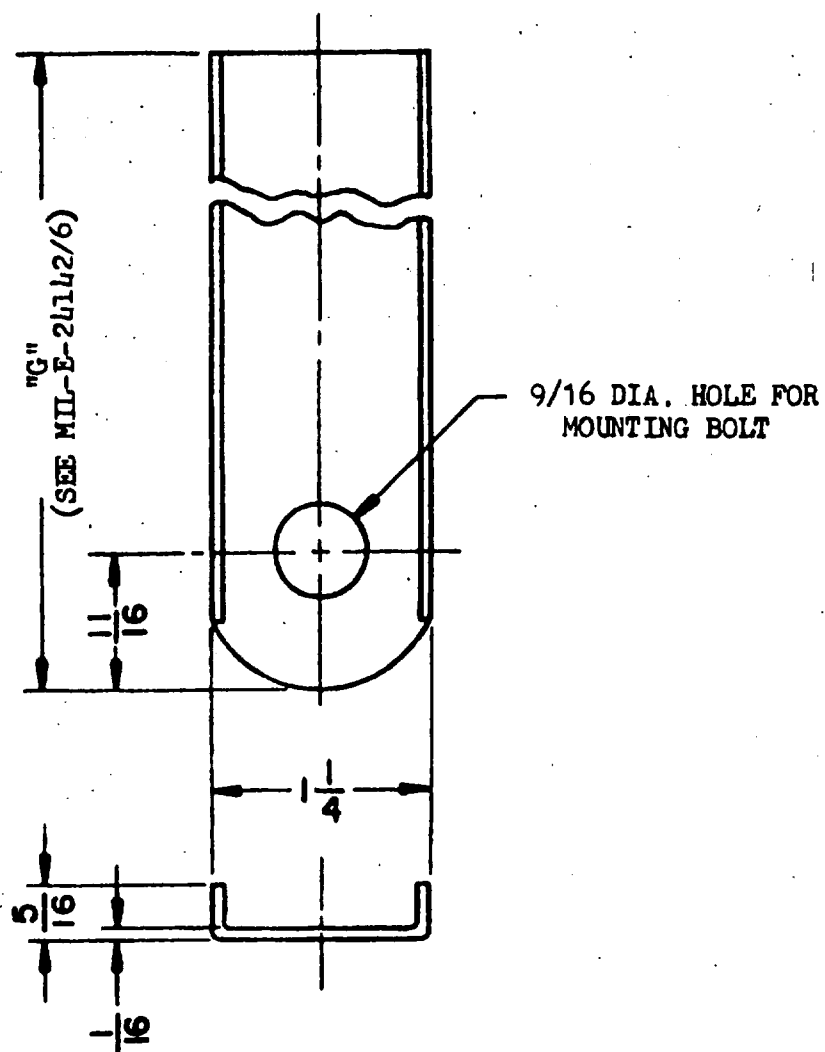


NOTE: OVERALL DIMENSIONS
MAY BE CHANGED IF
NECESSARY TO MEET
REQUIREMENTS.

SH 8533

FIGURE 1. Wiring diagram holder.

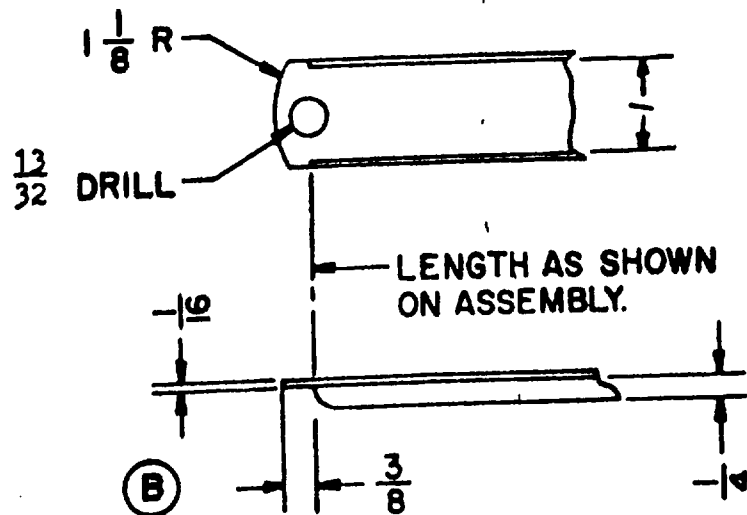
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SH 8534

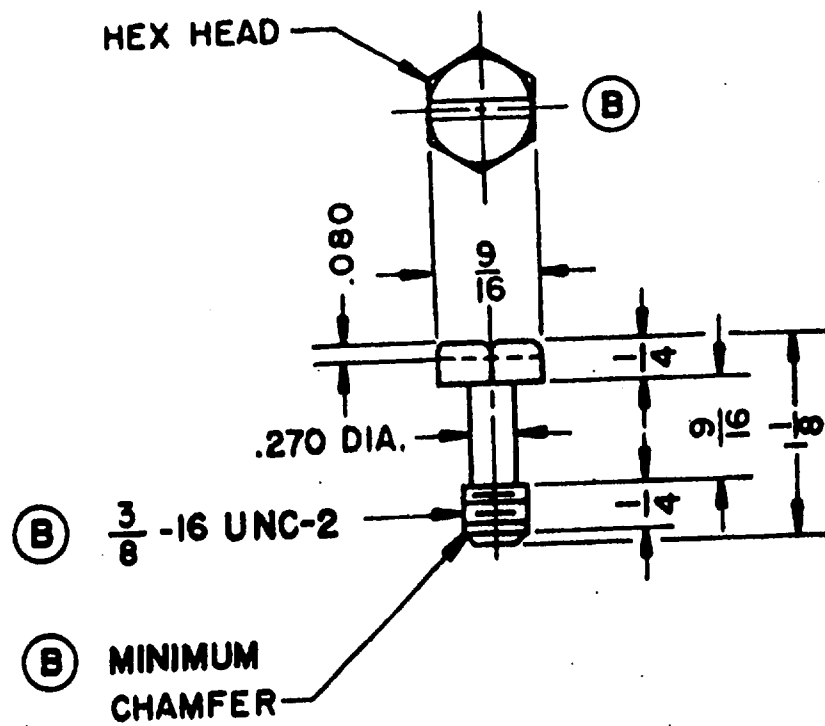
FIGURE 2. Mounting channel.

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SH 8535

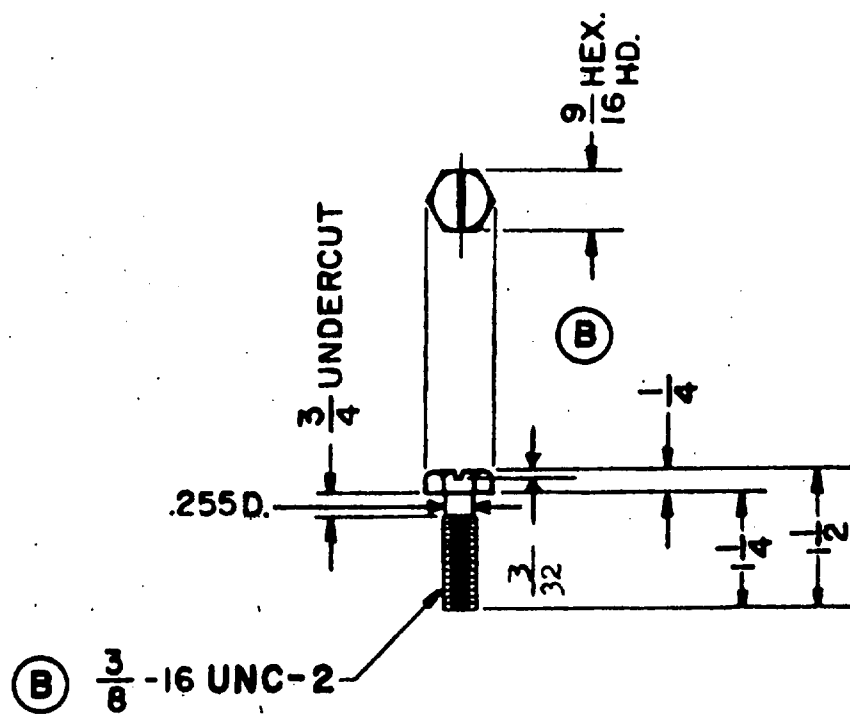
FIGURE 3. Mounting channel.



SH 8536

FIGURE 4. Cover bolt.

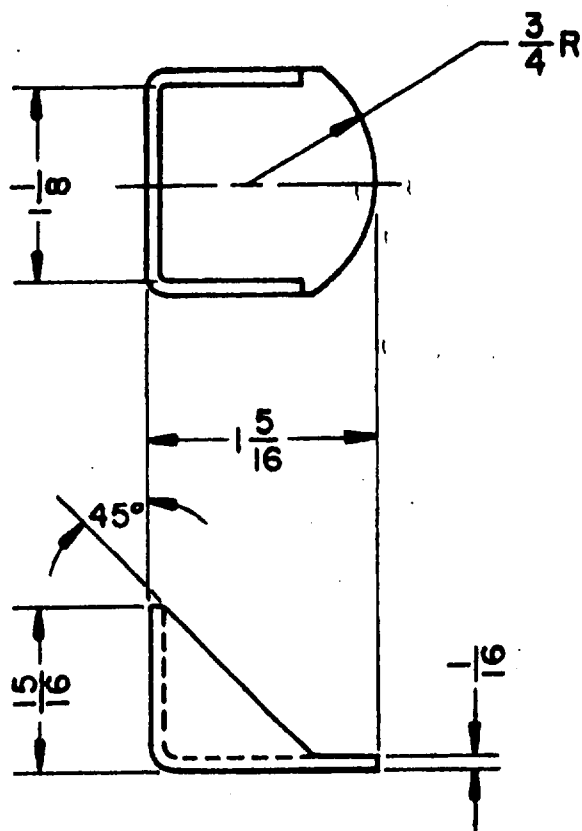
MIL-E-24142B(SH)



SH 8537

FIGURE 5. Cover bolt.

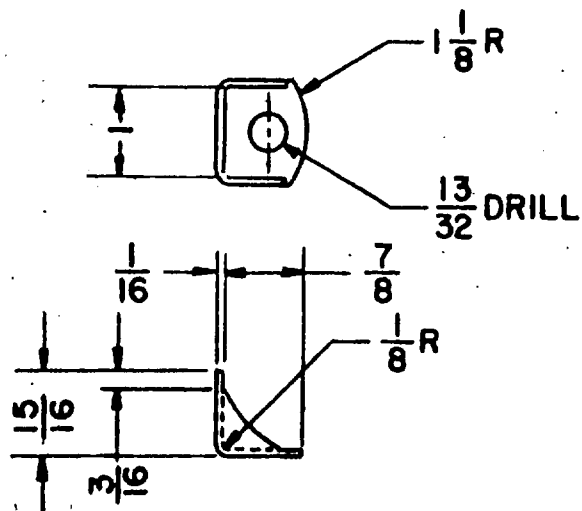
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SH 8538

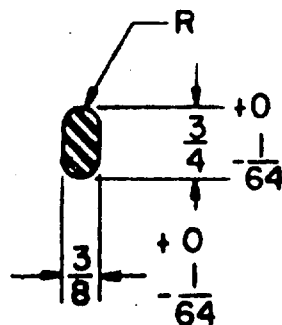
FIGURE 6. Mounting bracket.

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SH 8539

FIGURE 7. Mounting bracket.



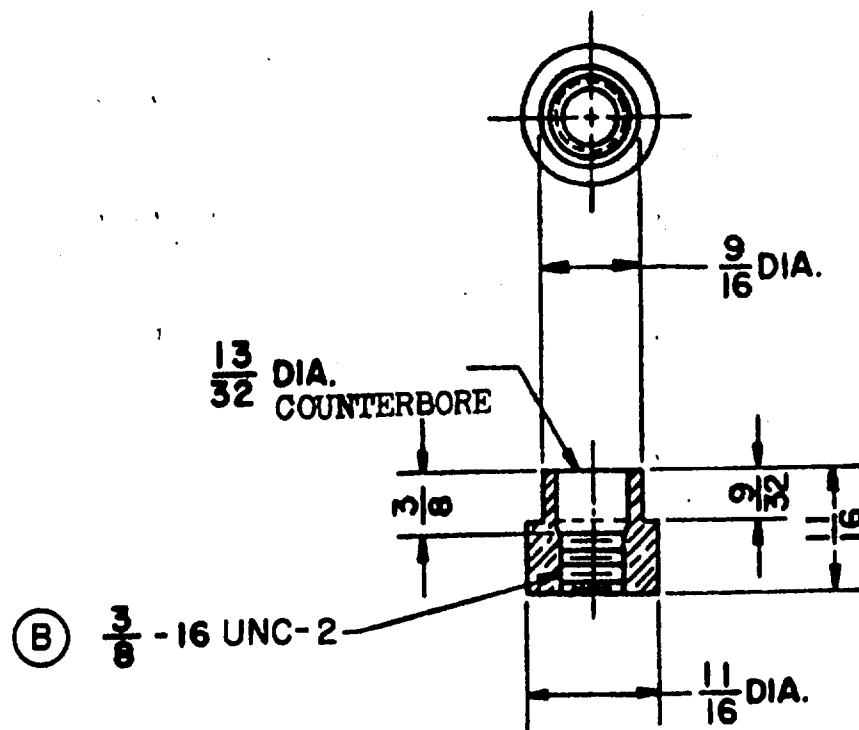
CROSS SECTION

NOTE: GASKET IN ACCORDANCE WITH MIL-R-6855, CLASS I, DUROMETER 65 ± 5 , MUST BE MOLDED IN ONE PIECE TO DIMENSION AND CONTOUR TO SUIT APPLICABLE GASKET GROOVE.

SH 8540

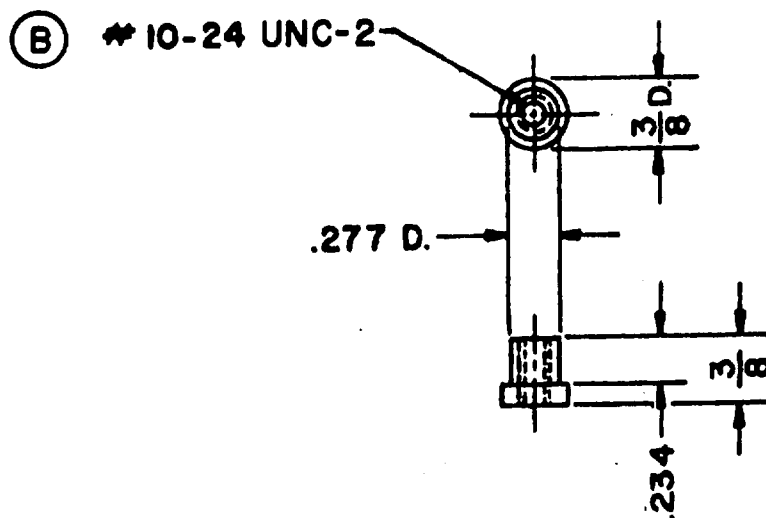
FIGURE 8. Gasket.

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SH 8541

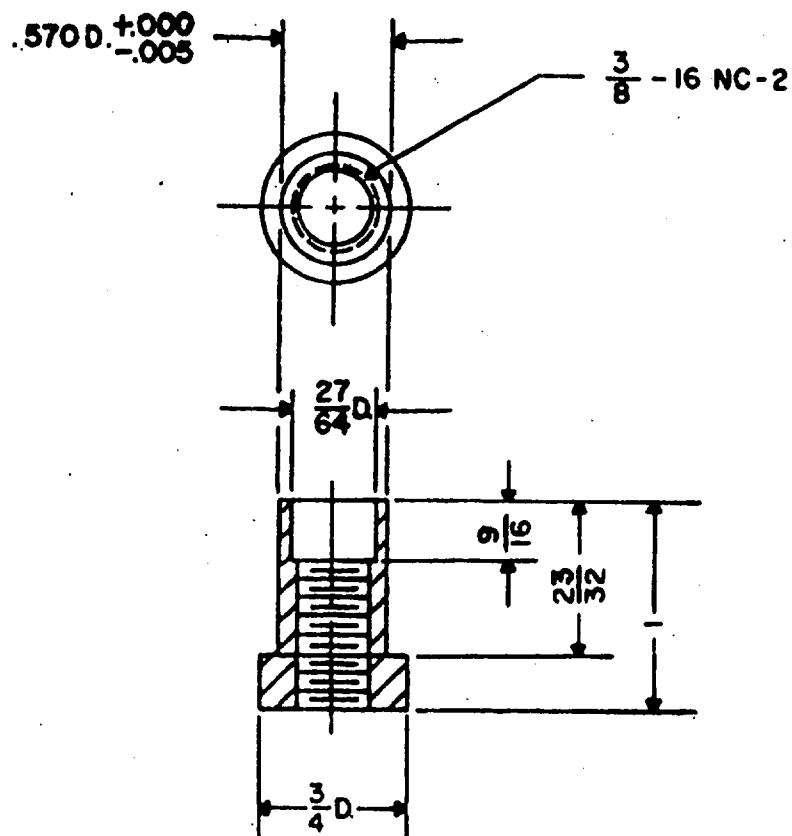
FIGURE 9. Weld nut.



SH 8542

FIGURE 10. Weld nut.

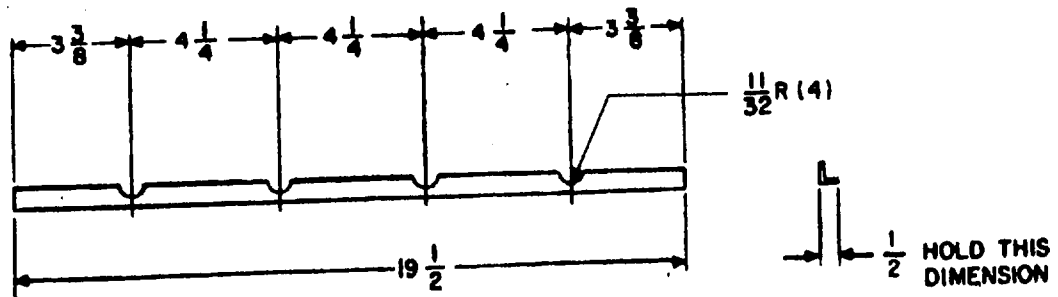
MIL-E-24142B(SH)



SH 8543

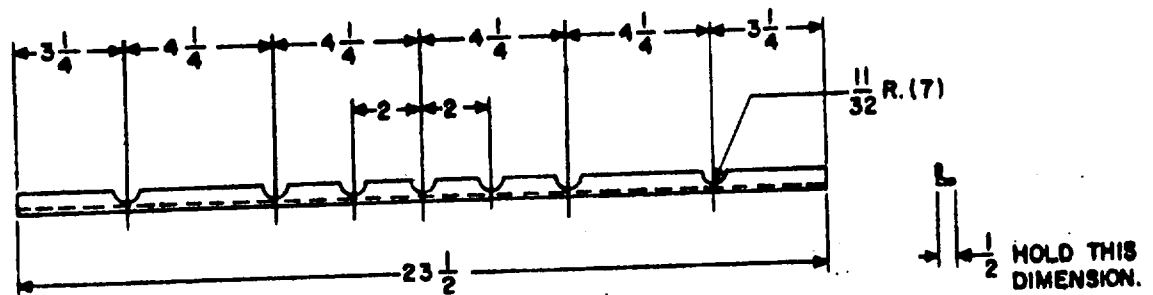
FIGURE 11. Weld nut.

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4 REQ'D - 2 NOTCHED AS SHOWN
 - 2 PLAIN
 MAT'L - 19-1/2 x 27/32 x 1/16 BRASS

SH 9055

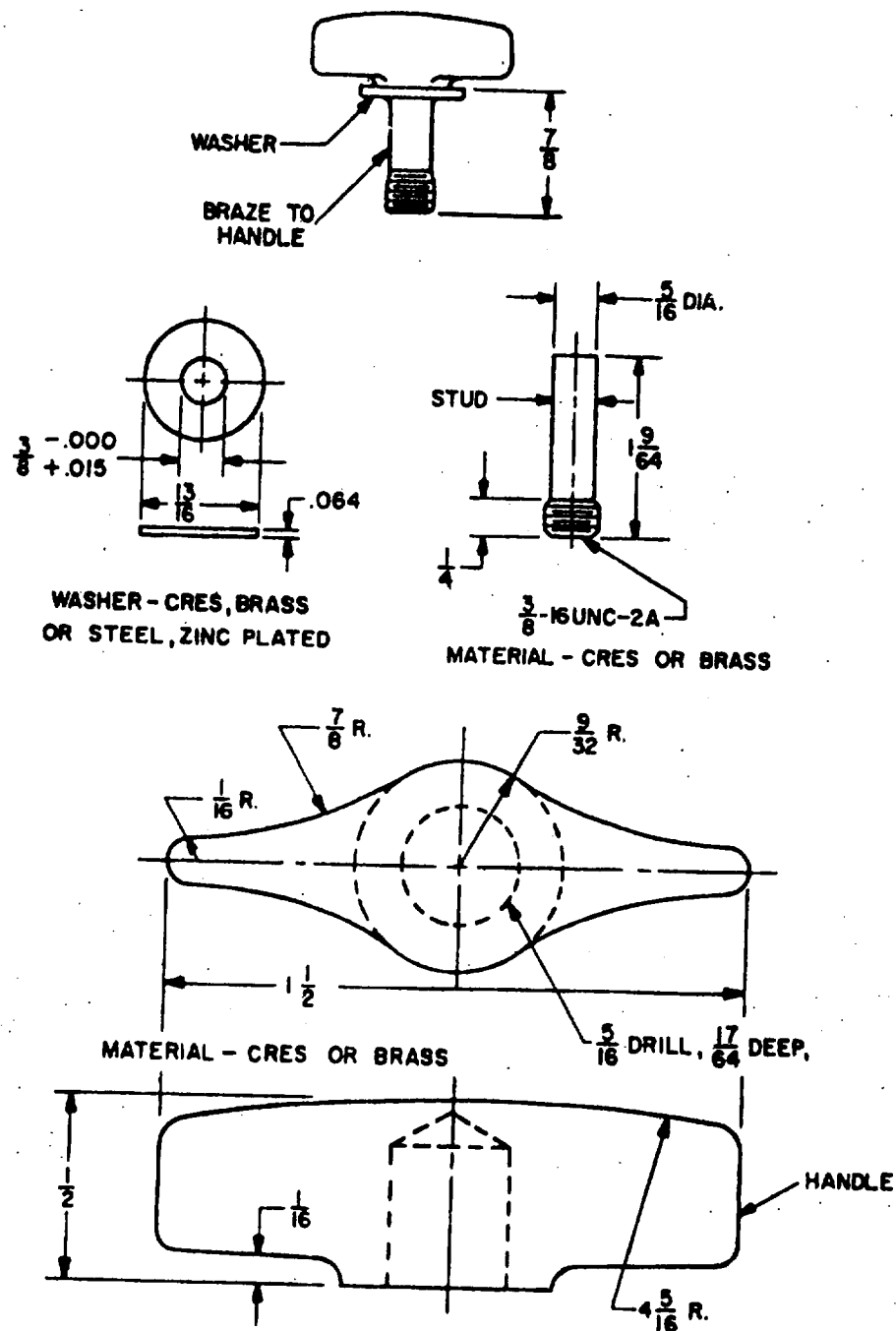
FIGURE 12. Gasket angle (long).

4 REQ'D - 2 NOTCHED AS SHOWN
 - 2 PLAIN
 MAT'L - 23-1/2 x 27/32 x 1/16 BRASS

SH 9056

FIGURE 13. Gasket angle (short).

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SH 10812

FIGURE 14. Thumb screw assembly 8 details.

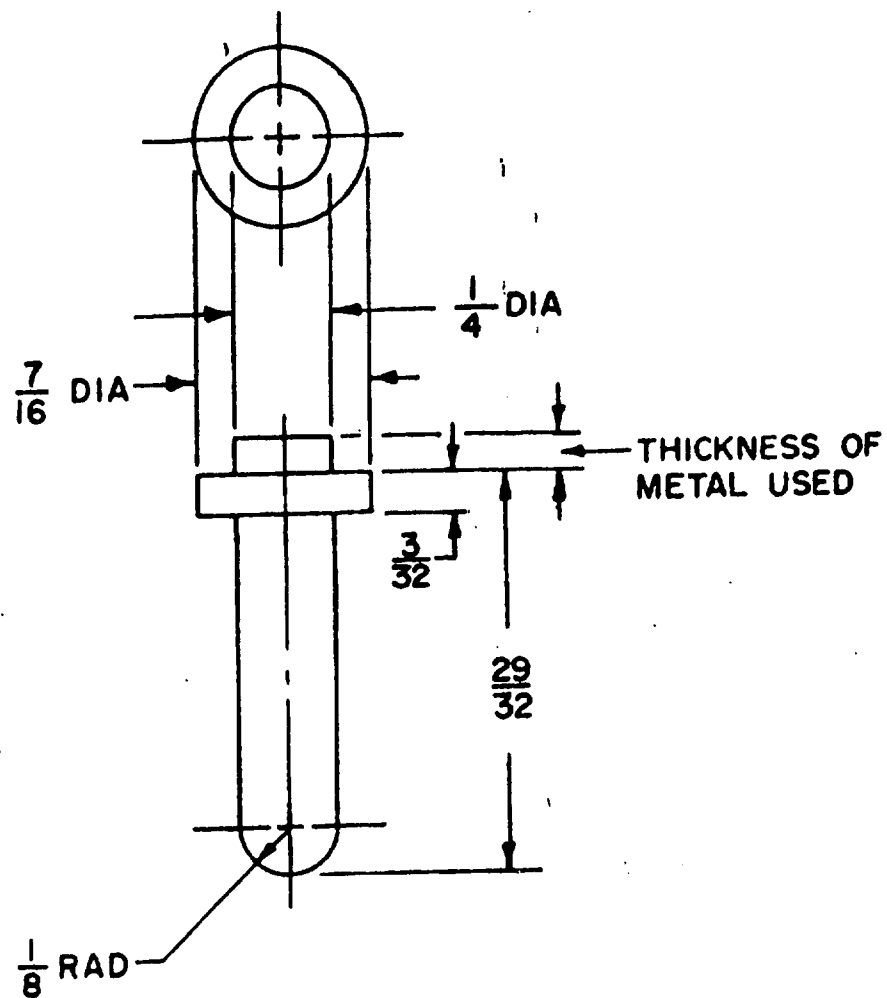
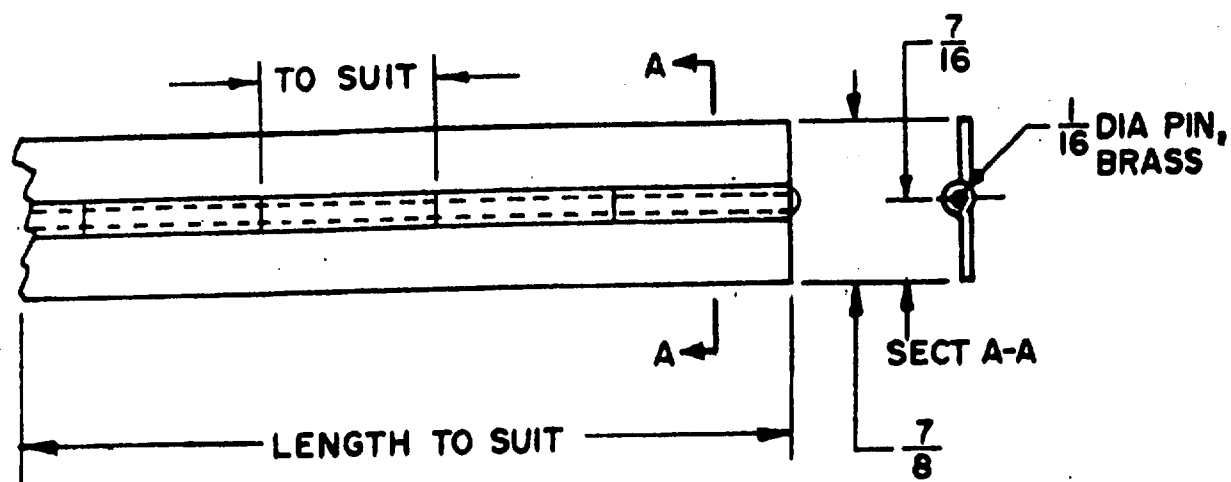
**SH 10813**

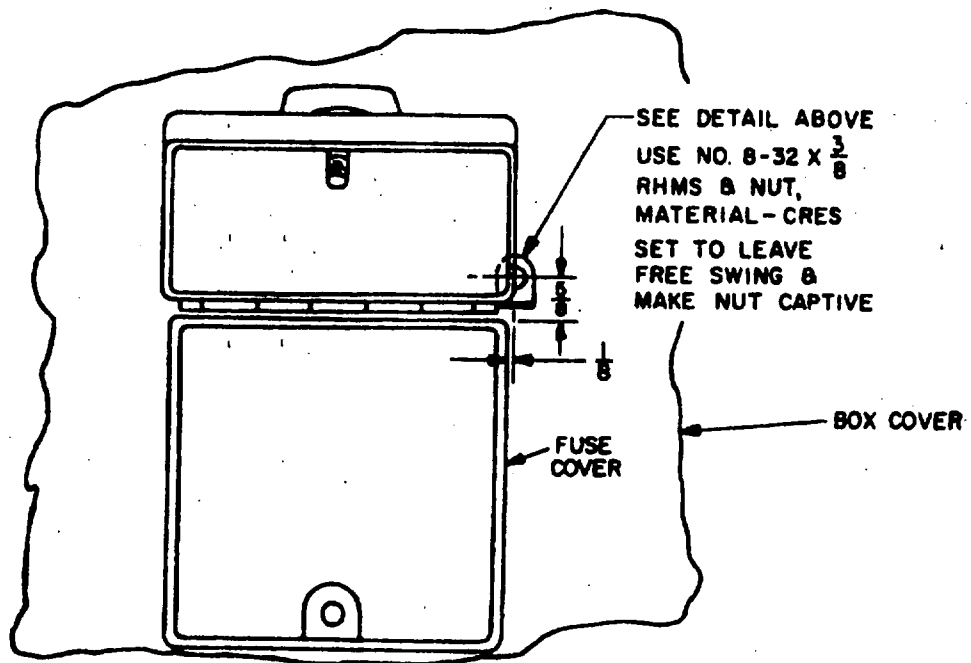
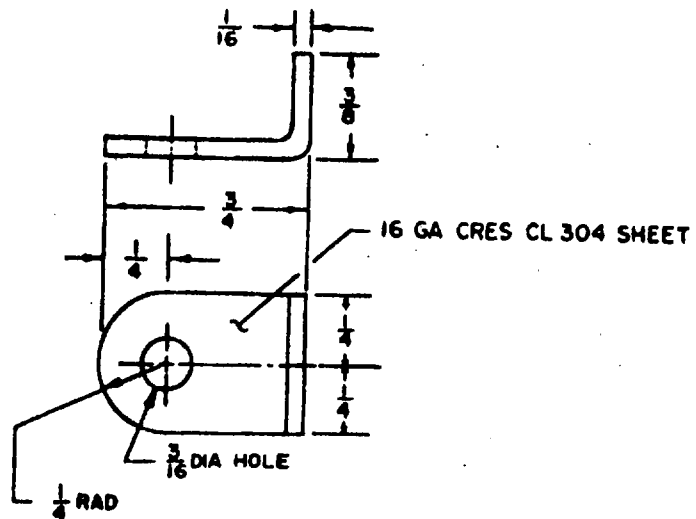
FIGURE 15. Dowel pin.



SH 10814

FIGURE 16. Hinge.

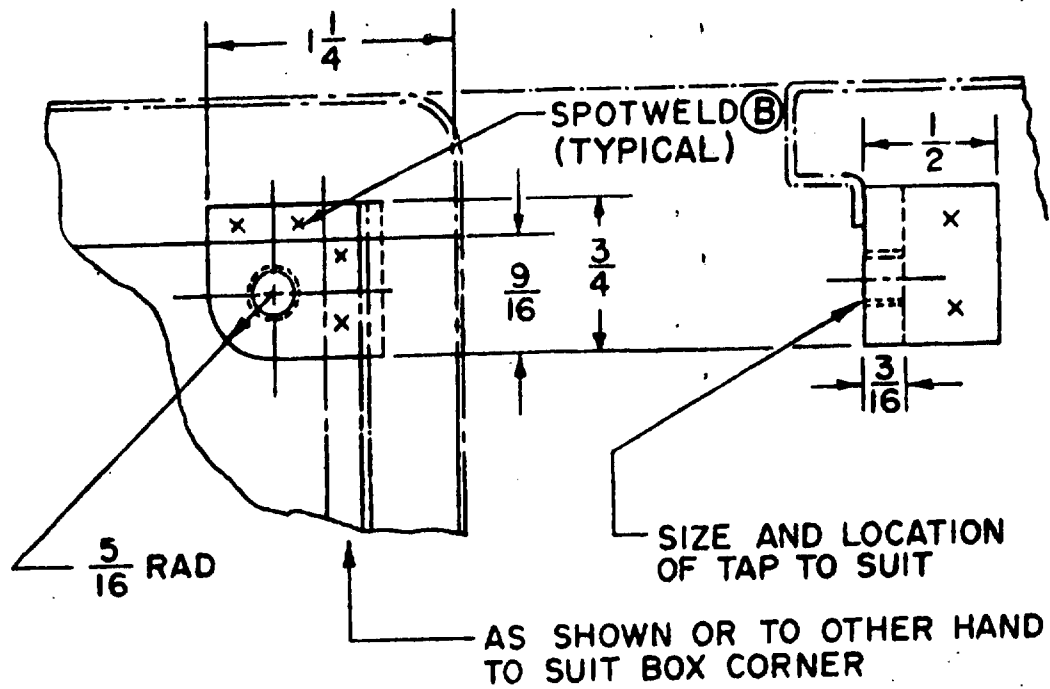
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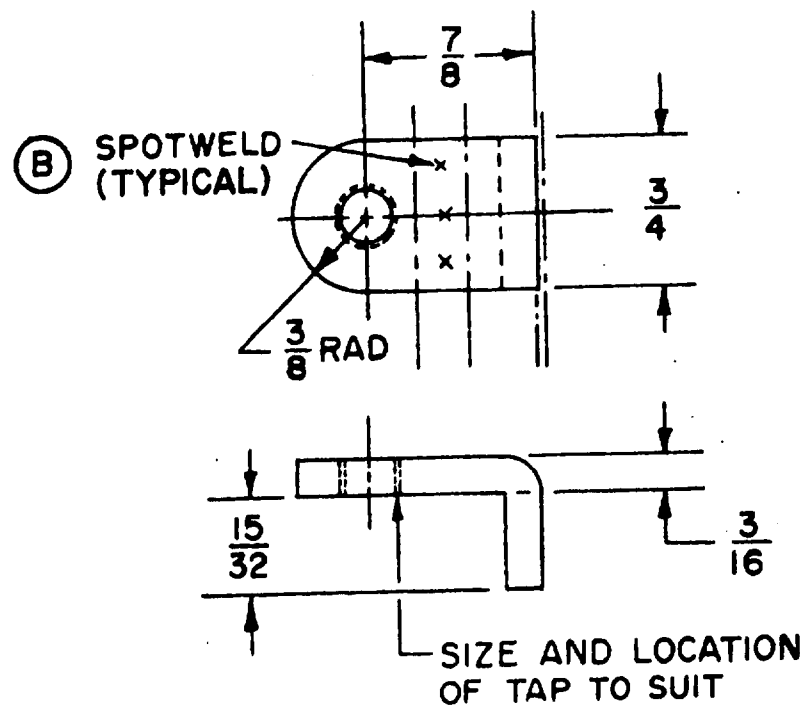
SH 10815

FIGURE 17. Latch for hinged fuse cover.

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SH 10816

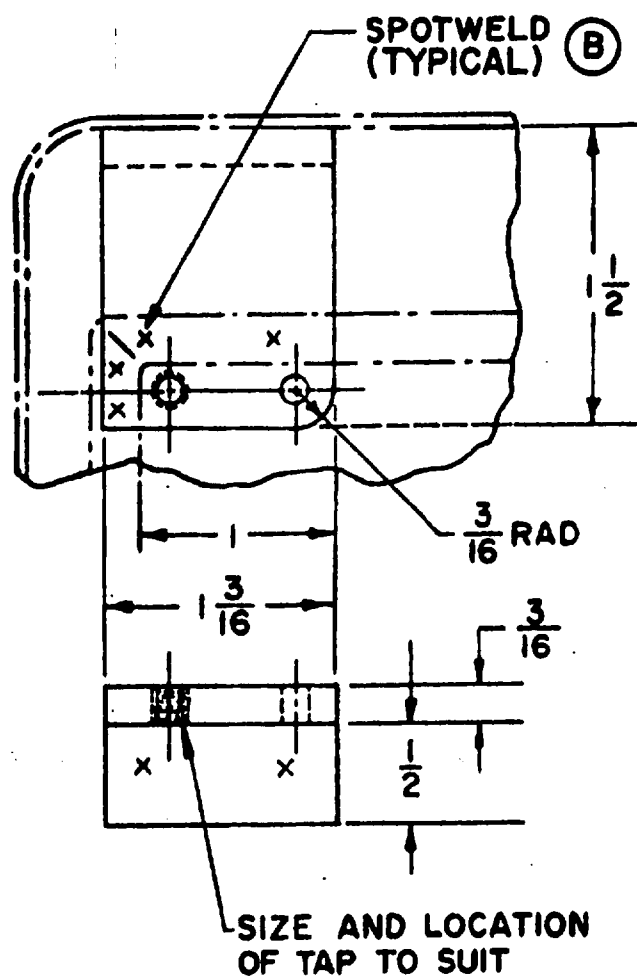
FIGURE 18. Cover securing pad.

SH 10817

FIGURE 19. Cover securing pad - intermediate.

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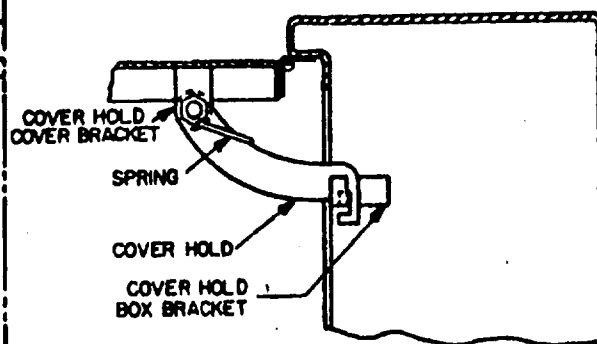
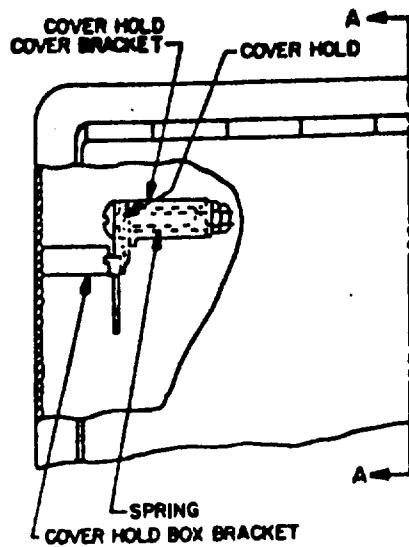
AS SHOWN OR TO OTHER HAND
TO SUIT BOX CORNER



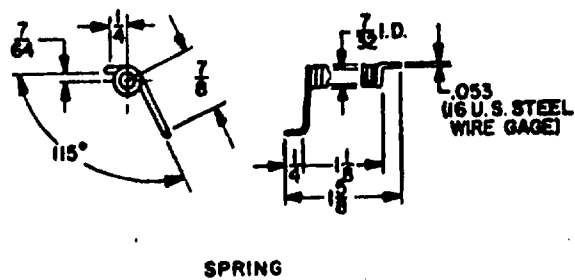
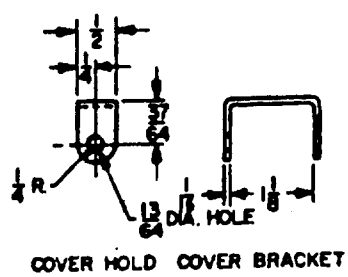
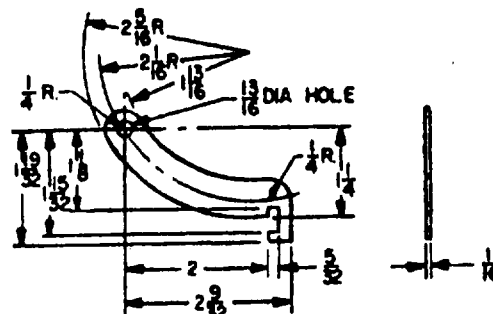
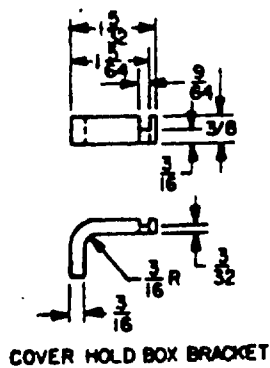
SH 10818

FIGURE 20. Dowel pad.

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SECTION AT A-A IN OPEN POSITION



SH 10819

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APPENDIX A

PROCEDURE FOR FIRST ARTICLE INSPECTION APPROVAL EXTENSION

10. SCOPE

10.1 This appendix details the procedure for the extension of first article approval to other similar families of enclosures covered by this specification. The approval extension is based upon the similarity of the design, the size of the enclosure, tooling and fabrication methods and techniques used in the production of the enclosures.

20. APPLICABLE DOCUMENTS. This section is not applicable to this appendix.

30. FAMILY GROUPINGS

30.1 Group I - Brass, rectangular, drawn, 15 feet SEM sizes up to 9 inches long.

30.1.1 Family coverage:

24142/1	size 4 x 4
/2	size 3 x 5
/3	size 6 x 9
/4	size 4 x 7
/9	size 2-1/8 x 3
/10	size 2-1/8 x 4

30.1.2 Approval extension:

<u>Approval of</u>	<u>Extends approval to size</u>
Size 6 x 9	All others
Size 4 x 7	All others except 6 x 9
Size 4 x 4	3 x 5, 2-1/8 x 3, 2-1/8 x 4
Size 3 x 5	4 x 4, 2-1/8 x 3, 2-1/8 x 4
Size 2-1/8 x 4	2-1/8 x 3
Size 2-1/8 x 3	-----

30.2 Group II - Brass, round, drawn 15 feet SEM.

30.2.1 Family coverage:

24142/5 size 3R, 4R and 5R

30.2.2 Approval extension:

<u>Approval of</u>	<u>Extends approval to size</u>
Size 5R	3R and 4R
Size 4R	3R
Size 3R	-----

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APPENDIX A

30.3 Group III - Brass, rectangular, drawn 15 feet SEM sizes up to 14 x 26.

30.3.1 Family coverage:

24142/6 size 8 x 10 through 14 x 26

30.3.2 Approval extension:

<u>Approval of</u>	<u>Extends approval to size</u>
-014	All others
-013	All others except -014 ¹
-012	All others except -013 and -014 (See note 1)

30.4 Group IV - Brass, rectangular, fabricated 15 feet SEM sizes up to 20 x 24 inches.

30.4.1 Family coverage:

24142/7 size 20 x 24 inches

30.4.2 Approval extension:

None

30.5 Group V - Aluminum, special shapes, totally enclosed NWT.

30.5.1 Family coverage:

24142/8 - 2-1/4 x 2-7/8 octagon shape
cast or drawn

30.5.2 Approval extension:

None

30.6 Group VI - Plastic, round, molded 15 feet SEM.

30.6.1 Family coverage:

24142/11	3 and 4 inches grounded
24142/12	3 inches grounded
24142/13	4 inches grounded

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APPENDIX A

30.6.2 Approval extension:

<u>Approval of</u>	<u>Extends approval to</u>
24142/13	24142/12, 24142/11-001 and -002
24142/12	24142/11-001
24142/11-002	24142/11-001, 24142/12
24142/11-001	24142/12

30.7 Group VII - Steel, rectangular, fabricated, totally enclosed, NWT, single hinged cover.

30.7.1 Family coverage:

24142/14	10 x 10 through 12 x 12
24142/16	10 x 14 through 12 x 20
24142/18	10 x 20 through 18 x 22

30.7.2 Approval extension:

<u>Approval of</u>	<u>Extends approval to</u>
24142/18-007	All dash numbers for /14, /16, /18
24142/18-006	All dash numbers for /14, /16 and /18 except /18-007 (See note 1)

30.8 Group VIII - Steel, rectangular, fabricated, totally enclosed, NWT, with fuse cover.

30.8.1 Family coverage:

24142/15	10 x 10 through 12 x 12
24142/17	10 x 14 through 12 x 20
24142/19	10 x 20 through 12 x 22
24142/20	10 x 20 through 12 x 22

30.8.2 Approval extension:

<u>Approval</u>	<u>Extends approval to</u>
24142/19-004	All dash numbers for /15, /17, /19, /20
24142/20-004	All dash number for /15, /17, /19, /20
24142/19-003	All dash numbers for /15, /17, /19 and /20 except /19-004 and /20-004 (See note 1)

MIL-E-24142B(SH)

APPENDIX A

NOTE 1: Any first article acceptance for a given size within a family group may be used as evidence of acceptance of a smaller size within the same family group. In case of any question the size having the larger area is to be considered the larger size.

The above extensions in no way change the quality conformance inspection in accordance with 4.4, requirements for lots in accordance with 4.4.1 or sampling in accordance with 4.4.2 for each type and size.

INSTRUCTIONS: In a continuing effort to make our standardization documents better, the DoD provides this form for use in submitting comments and suggestions for improvements. All users of military standardization documents are invited to provide suggestions. This form may be detached, folded along the lines indicated, taped along the loose edge (**DO NOT STAPLE**), and mailed. In block 5, be as specific as possible about particular problem areas such as wording which required interpretation, was too rigid, restrictive, loose, ambiguous, or was incompatible, and give proposed wording changes which would alleviate the problems. Enter in block 6 any remarks not related to a specific paragraph of the document. If block 7 is filled out, an acknowledgement will be mailed to you within 30 days to let you know that your comments were received and are being considered.

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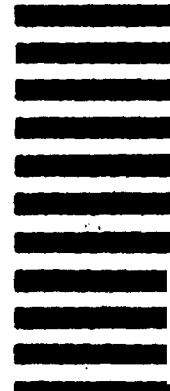
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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL*(See Instructions - Reverse Side)***1. DOCUMENT NUMBER**
MIL-E-24142B(SH)**2. DOCUMENT TITLE** ENCLOSURES FOR ELECTRICAL FITTINGS AND FIXTURES,
GENERAL SPECIFICATION FOR**3a. NAME OF SUBMITTING ORGANIZATION****4. TYPE OF ORGANIZATION (Mark one)**☐ VENDOR☐ USER☐ MANUFACTURER☐ OTHER (Specify): _____**3b. ADDRESS (Street, City, State, ZIP Code)****5. PROBLEM AREAS****a. Paragraph Number and Wording:****b. Recommended Wording:****c. Reason/Rationale for Recommendation:****6. REMARKS****7a. NAME OF SUBMITTER (Last, First, MI) - Optional****7b. WORK TELEPHONE NUMBER (Include Area Code) - Optional****8. MAILING ADDRESS (Street, City, State, ZIP Code) - Optional****9. DATE OF SUBMISSION (YYMMDD)**