

MIL-F-22735C
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SUPERSEDING
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MILITARY SPECIFICATION

FILM, ELASTOMERIC, FLUORESCENT, FOR WEAPONS SYSTEMS

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

1. SCOPE

1.1 This specification covers a high visibility, durable, exterior elastomeric fluorescent film precoated on the back with a pressure-sensitive adhesive.

2. APPLICABLE DOCUMENTS

2.1 Issues of documents. The following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of this specification to the extent specified herein:

SPECIFICATIONS

FEDERAL

QQ-A-250/5	-Aluminum Alloy Alclad 2024, Plate and Sheet
TT-T-291	-Thinner, Paint, Mineral Spirits, Regular and Odorless
TT-X-916	-Xylene (for Use in Organic Coatings)
PPP-T-680	-Tape, Pressure-Sensitive Adhesive: Packaging and Packing of

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Engineering Specifications and Standards Department (Code 93), Naval Air Engineering Center, Lakehurst, NJ 08733, by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

NO INFORMATION REQUIREMENTS

FSC 9330

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MIL-C-5541	-Chemical Conversion Coatings on Aluminum and Aluminum Alloys
MIL-P-7962	-Primer Coating, Cellulose-Nitrate Modified Alkyd Type, Corrosion-Inhibiting, Fast Drying (for Spray Application Over Pretreatment Coating)
MIL-A-8625	-Anodic Coatings, for Aluminum and Aluminum Alloys
MIL-C-81706	-Chemical Conversion Materials for Coating Aluminum and Aluminum Alloys
MIL-P-23377	-Primer Coating, Epoxy Polyamide, Chemical and Solvent Resistant
MIL-C-83286	-Coating, Urethane, Aliphatic Isocyanate, for Aerospace Applications

STANDARDS

FEDERAL

FED-STD-141	-Paint, Varnish, Lacquer, and Related Materials; Methods of Inspection, Sampling, and Testing
FED-STD-595	-Colors

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MIL-STD-105	-Sampling Procedures and Tables for Inspection by Attributes
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(Copies of specifications, standards, drawings, and publications required by contractors in connection with specific acquisition functions should be obtained from the acquiring 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. Unless otherwise indicated, the issue in effect on date of invitation for bids or request for proposal shall apply, except for the specific issue adopted by the Department of Defense as listed in the current Department of Defense Index of Specifications and Standards.

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AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM D 523	-Specular Gloss, Test for
ASTM D 1006	-Exterior Exposure Tests of Paints on Wood, Rec. Practice for Conducting
ASTM D 1308	-Effect of Household Chemicals on Clear and Pigmented Organic Finishes, Test for
ASTM D 2244	-Color Differences of Opaque Materials, Instrumental Evaluation of

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

MASSACHUSETTS INSTITUTE OF TECHNOLOGY, COLOR MEASUREMENT LABORATORY

Handbook of Colorimetry - Arthur C. Hardy (1936)

(Application for copies should be addressed to the Massachusetts Institute of Technology, Cambridge, MA 02139.)

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

3. REQUIREMENTS

3.1 Materials. The ingredient materials used in the manufacture of the film shall be of high quality, suitable for the purpose intended and shall conform to the applicable specification specified herein. The elastomeric film shall have a pressure-sensitive adhesive applied to one side as an integral part of the film. The pressure-sensitive adhesive shall require no solvent, heat, or any other preparation prior to application. The adhesive shall be protected by a carrier sheet which may be paper, and shall be removable from the carrier sheet without the use of water or other solvents. A sufficient quantity of edge sealer, clear in color, shall be furnished with each elastomeric film procurement. It shall be suitable for the purpose intended.

3.2 Design and size. The design (type of print) and size shall be as specified by the acquiring activity. If size is not specified, rolls 24 inches minimum width and 50 yards in length shall be furnished (see 6.2).

3.2.1 Film thickness. The adhesive-coated elastomeric fluorescent film, upon removal of the carrier sheet, shall not exceed 0.011 inch in thickness. (see 4.5.2)

3.3 Application to surface. The elastomeric film, applied in accordance with the manufacturer's instructions, shall not separate from the prescribed surface at any point nor show any surface irregularities, such as wrinkling, and bubbling, for any paint system that it is applied to.

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3.4 Color. The fluorescent film shall be furnished in fluorescent red-orange (FED-STD-595 No. 28913) or fluorescent yellow-orange (FED-STD-595 No. 28915), as specified (see 6.2). The color shall conform to requirements of table I when tested as specified in 4.5.11.

3.4.1 Specular gloss. The specular gloss of the elastomeric film shall be not less than 25 when tested as specified in 4.5.3.

3.4.2 Hiding power. The minimum contrast ratio shall be 0.92 when tested as specified in 4.5.10.

3.5 Performance.

3.5.1 Adhesion. The adhesive-coated elastomeric film shall have an average adhesion over bare and painted metal surfaces of not less than 45 ounces per inch of width when tested as specified in 4.6.4 at a temperature of $77^{\circ} \pm 5^{\circ}\text{F}$ ($25^{\circ} \pm 2^{\circ}\text{C}$). The film shall not break during test (see 4.5.4).

3.5.2 Film integrity. The elastomeric film shall exhibit no evidence of delamination of film or color overlays when tested as specified in 4.5.5.

3.5.3 Dimensional stability. The elastomeric film shall not shrink more than 2 percent from any edge (see 4.5.6).

3.5.4 Removability. The elastomeric film shall be removable from the painted surface without tearing, crumbling, or delaminating when tested as specified in 4.5.7. No adhesive shall remain on the bare or painted test panels after removal. The appearance of cracks in the film during removal is permissible.

3.6 Resistance properties.

3.6.1 Water resistance. The elastomeric film shall withstand immersion in water for 8 hours at room temperature. Immediately after removal, the immersed portion shall be equal in all respects to the film on the emerged portion (see 4.5.8).

3.6.2 Fuel resistance. The elastomeric film shall withstand immersion in a mixture consisting of 85 percent by weight mineral spirits conforming to TT-T-291 and 15 percent xylene conforming to TT-X-916, for one (1) hour at room temperature. Twenty-four hours after removal, the immersed portion of the film shall be equal in all respects to the film on the emerged portion. A slight leaching of the adhesive shall be disregarded (see 4.5.9).

3.6.3 Storage stability. After 12 months' storage under warehouse conditions (see 4.4.7), the elastomeric film shall be capable of passing the quality conformance tests of Table II.

3.6.4 Weather resistance. Test panels of the elastomeric film, prepared as specified in 4.3, shall be capable of conforming to the requirements of table I and show no significant deterioration in film properties, such as cracking, flaking, delamination, embrittlement, or peeling after exposure for one (1) year in the vicinity of Miami, Florida. After exposure, the film shall be easily removable by peeling without damage to the undercoat. The film shall remain

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intact during removal. No adhesive shall remain on the bare or painted test panels after removal of the film (see 4.5.13).

3.6.5 Accelerated weather resistance. Test panels of elastomeric film, prepared as specified in section 4 and exposed in a weatherometer for 500 hours, shall conform to table I and show no significant deterioration such as cracking, flaking, delamination, embrittlement, or peeling. After exposure, the film shall be easily removable by peeling, without damage to the undercoat. The film shall remain intact during removal. No adhesive shall remain on the test panel after removal of the film (see 4.5.12).

TABLE I. Color limits before and after weathering.

Exposure	Dominant wave length (millimicrons) (μ m)		Excitation purity (percent min)		Luminance factor (percent)		Peak "reflectance" compared to MgCO ₃ (percent min)	
	Red-orange	Yellow-orange	Red-orange	Yellow-orange	Red-orange	Yellow-orange	Red-orange	Yellow-orange
Before exposure	min max	min max			min	min		
	609 615	602 610	82	84	20	38	115	100
Florida exposure one year	580 615	585 605	72	77	max 40	max 50	80	80

3.7 Instructions. Complete and detailed instructions for applying the elastomeric film on aircraft or other surfaces shall be furnished with each package. In addition, the instructions shall include the following:

"Not to be used on supersonic aircraft of any type.
Laps should be in opposite direction to slipstream.
All exposed edges shall be sealed after overnight set."

3.8 Workmanship. Finished elastomeric film in sheets, strips, or rolls shall be manufactured in accordance with high-grade commercial practice. The material shall be free from blisters, cracks, foreign matter, or any other defects.

4. QUALITY ASSURANCE PROVISIONS

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

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the performance of the inspection requirements specified, 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.

4.2 Classification of inspection. The inspection requirements specified herein are classified as quality conformance inspection (see 4.4).

4.3 Panels. Unless otherwise specified, when testing the elastomeric film on bare metal, it shall be applied to panels made from aluminum-clad aluminum alloy conforming to QQ-A-250/5. The panels shall be 0.020 by 3 by 6 inches in size. For testing on coated metal, the elastomeric film shall be applied to panels made from aluminum-clad aluminum alloy conforming to QQ-A-250/5. The panels to be coated shall be anodized in accordance with MIL-A-8625 and finished as follows: One coat of epoxy primer conforming to MIL-P-23377, dried 60 minutes, 0.0006 to 0.0009 inch thick; and two coats of polyurethane topcoat conforming to MIL-C-83286. The panels shall be allowed to air dry for 24 hours. The panels shall be cooled before the film is applied. Elastomeric fluorescent film shall be applied as follows:

Remove carrier sheet from adhesive, align sample, press one edge to panel and with a plastic squeegee or roller press firmly across entire sample. Otherwise, panels shall be laboratory aged 48 hours before testing. NOTE: For testing as specified in 4.6.6, the film shall be applied to the entire surface of the panel and trimmed with a sharp blade so that the film extends to all edges of the panel.

4.4 Quality conformance inspections. Quality conformance inspection shall be as specified in table II.

TABLE II. Quality conformance inspections.

Inspection	Requirement paragraph	Test method paragraph
Film thickness	3.2.1	4.5.2
Specular gloss	3.4.1	4.5.3
Adhesion	3.5.1	4.5.4
Film integrity	3.5.2	4.5.5
Dimensional stability	3.5.3	4.5.6
Removability	3.5.4	4.5.7
Water resistance	3.6.1	4.5.8
Fuel resistance	3.6.2	4.5.9
Hiding power	3.4.2	4.5.10
Color	3.4	4.5.11

4.4.1 Quality conformance inspection. Quality conformance inspection shall consist of all tests and examinations of this specification, except the tests for storage stability (3.6.3), weather resistance (3.6.4), and accelerated weather resistance (3.6.5) (see Table II).

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4.4.2 Additional tests. The Government reserves the right to rerun any or all tests of this specification at any time within 1 year from the date of manufacture of the elastomeric film, as attested by the date appearing on the package label. Samples for these retests shall be taken from a previously unopened package. Should the results of the retest be unsatisfactory, the contracting officer shall be so informed, and may require the contractor to remove the entire lot and supply conforming material to replace it.

4.4.3 Sampling for tests. A sufficient quantity of elastomeric film of each color shall be selected at random from each lot. When film size permits, test samples shall consist of three samples of each color, 24 inches wide (minimum) and 2 yards long. Testing shall be conducted as specified in the contract.

4.4.4. Sampling for visual and dimensional examination. A random sample of film shall be selected from each inspection lot in accordance with MIL-STD-105, inspection level I, and acceptable quality level (AQL) of 2.5 percent defective to verify compliance with this specification regarding packaging, packing, marking, dimensions, and other requirements not involving physical tests. Any film specimen in the sample having one or more defects shall be rejected, and if the number of defective specimens in any sample exceeds the acceptance number for the specified sampling plan of MIL-STD-105, the lot represented by the sample shall be rejected.

4.4.5 Rejection criteria for tests. Failure of any specimen to conform to the tests specified herein shall be cause for rejection of the lot.

4.4.6 Resubmitted inspection lots. MIL-STD-105 shall apply for resubmitted lots, except that a resubmitted inspection lot shall be inspected by the contractor, using tightened inspection. Before an inspection lot is resubmitted, full particulars concerning the cause of previous rejection and the action taken to correct the defects found in the inspection lot shall be furnished the procuring activity.

4.4.7 Certification of tests. The manufacturer shall submit a notarized certification signed by a responsible official of its management, attesting that the elastomeric film will meet (a) the accelerated weather resistance test, and (b) the storage stability (3.6.3) and weather resistance (3.6.4) requirements of this specification for a period of one year.

4.5 Test methods. The tests of this specification shall be conducted in accordance with table III and the panels used prepared as specified in 4.3. The laboratory testing conditions shall be in accordance with the applicable test method described herein. Unless otherwise specified, the applied elastomeric film shall be allowed to stand 72 hours at standard temperature and humidity prior to testing.

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TABLE III. Test methods.

Requirement paragraph	Test	FED-STD-141 method	ASTM method
3.4	Color		D 2244
3.4.2	Hiding power		D 2244
3.5.2	Film integrity	6051, 6034	-
3.6.1	Water resistance		D 1308
3.6.2	Fuel resistance		D 1308
3.6.4	Weather resistance		D 1106

4.5.1 Examination of product. Elastomeric film shall be examined to determine conformance with this specification with respect to material and workmanship.

4.5.2 Film thickness. The carrier backing shall be removed, and the elastomeric film applied to strips of aluminum foil approximately 0.001 inch thick and rolled down. The thickness of the aluminum foil shall have been previously measured by a micrometer. Four micrometer readings shall be taken at random places on each elastomeric film. All the measurements shall fall below the value of 0.011 inch after subtracting the thickness of the aluminum foil.

4.5.3 Specular gloss. Two 10-inch by 10-inch samples shall be tested in accordance with ASTM D 523 and checked for conformance with 3.5.1.

4.5.4 Adhesion. Five elastomeric film strips, each 1 by 8 inches, shall be applied separately over 2- by 4-inch bare and coated aluminum panels, as specified in 4.3 (with one end of the film strip flush to one end of the panel) so that a 1- by 3-inch area of the panel shall be adhered to the elastomeric film. The free end of the elastomeric film shall be doubled back at 180 degrees. The bare end of the aluminum panel shall be clamped in the lower jaw of the tensile testing machine, and the free end of the elastomeric film shall be clamped in the upper jaw. Adhesion shall be determined on a dead weight pendulum or cross-head type testing machine. Conditions at time of test shall be 72° to 77°F (22.2° to 24.4°C) and 50 ± 4 percent humidity. The film shall be pulled back from the test panel at a constant rate of head travel of 12 inches per minute. After the first inch is removed, the tension required to remove the next inch shall be determined. If the film breaks at any point during removal, the test shall be terminated and the film considered unsatisfactory. An average value of the five test samples shall be determined. If any value of any one sample is less than 35 ounces, the film shall be considered unsatisfactory (see 3.5.1).

4.5.5 Film integrity. Four 3-inch by 6-inch, alclad aluminum-alloy panels conforming to QQ-A-250/5 shall be cleaned and treated with materials meeting MIL-C-81706 to produce coatings conforming to MIL-C-5541. The elastomeric film shall then be applied in accordance with 4.3. The panels shall be immersed in water in a glass container for 24 hours, in accordance with method 6051 of FED-STD-141. Two panels shall then be removed and wiped dry with a soft cloth. Immediately thereafter, both the immersed and emersed film shall be cut

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with a knife in the manner specified by method 6304 of FED-STD-141. The film shall be examined for evidence of delamination of film and color overlays. The remaining two panels shall then be removed and wiped dry with a soft cloth. Immediately thereafter, two parallel scratches, 1 inch apart and penetrating to the metal, shall be made with a stylus on the previously immersed portion of each panel. Within 50 ± 5 seconds after removal of the panels from the water, a 1-inch wide strip of fresh Minnesota Mining Company, Code No. 250 masking tape, or equal, shall be applied adhesive side down across each set of scratches. The tape shall be pressed down with two passes of a 4-1/2 pound rubber-covered roller approximately 3-1/2 inches in diameter and 1-3/4 inches in width. The surface of the roller shall have a durometer hardness value within the range of 70-80. Immediately after application of the roller, the tape shall be removed in one abrupt motion and each panel examined for conformance to 3.5.2.

4.5.6 Dimensional stability. The elastomeric film, applied to bare panels as specified in 4.3, shall be subjected to 150°F (65.5°C) for 48 hours. The film shall be examined immediately upon cooling to room temperature. Shrinkage from any one edge shall not exceed 2 percent (see 3.5.3).

4.5.7 Removability. Five elastomeric film strips, each 1 by 8 inches, shall be applied separately over 2- by 4-inch bare and coated panels as specified in 4.3 (with one end of the film strip flush at one end of the panel) so that a 1- by 3-inch area of the panel shall be adhered to the elastomeric film. The sample shall then be oven aged at 150°F (65.5°C) for 24 hours. The panel shall be removed from the oven and allowed to cool. The free end of the film shall be doubled back at 180 degrees. The bare end of the aluminum panel shall be clamped in the lower jaw of a cross-head type tensile machine, and the free end of the film shall be clamped in the upper jaw. The film shall be pulled back from the test panel at a constant rate of head travel of 12 inches per minute (see 3.5.4).

4.5.8 Water resistance. The elastomeric film shall be applied to bare panels as specified in 4.3 and tested in accordance with ASTM D 1308. The container shall be glass. The panels shall be immersed to half their width in water for 8 hours. The elastomeric film shall then be removed and examined, 5 minutes after removal and 24 hours after removal, for conformance with 3.6.1.

4.5.9 Fuel resistance. The elastomeric film shall be applied to bare panels as specified in 4.3 and tested in accordance with ASTM D 1308. The panels shall be immersed in a glass container to half their width in a mixture consisting of 85 percent, by weight, of mineral spirits conforming to TT-T-291 and 15 percent xylene conforming to TT-X-916, for 1 hour. The elastomeric film shall be examined after 24 hours air drying for conformance with 3.6.2.

4.5.10 Hiding power. Hiding power of the elastomeric film shall be determined with a colorimeter in accordance with ASTM D 2244. Using the XYZ color space, the contrast ratio shall be defined as the ratio of the Y reflectance of the film over a black hiding power chart to the Y reflectance over a white hiding power chart. The test may be conducted immediately after application of the film (see 3.4.2).

4.5.11 Color (spectrophotometric). The method of examination for determining color shall be as follows:

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- a. The painted specimen, prepared as specified in 4.3, shall be tested using a suitable spectrophotometer 1/. The angle of incidence/reflectance shall be 0°/5°. A barium sulfate block shall be used as a reference standard. Both the dominant wavelength and the peak reflectance shall be determined in accordance with standard practice.
- b. The trichromatic coefficients (X, Y and Z) and the chromaticity coordinates (x, y and z) shall be determined using a suitable colorimeter 2/ in accordance with ASTM D 2244. Illuminant "C" shall be employed. The excitation purity shall be determined from diagrams listed in the Handbook of Colorimetry (1936) by A.C. Hardy, Color Measurement Laboratory, Massachusetts Institute of Technology. The luminance factor shall be the Y coefficient.
- c. An alternative method of calculating the dominant wavelength and peak reflectance using the data obtained in (b) is as follows:

$$\text{Dominant wavelength} = \frac{x}{X + Y + Z}$$

$$\text{Peak reflectance} = \frac{y}{X + Y + Z}$$

1/ Beckman DK-2 spectrophotometer or equivalent.

2/ Macbeth MC-1010S colorimeter or equivalent.

4.5.12 Accelerated weather resistance. The elastomeric film, applied as specified in 4.3 on bare and painted surfaces, shall be exposed for 500 hours in a 6000 watt xenon-arc weatherometer 1/ that is cycling between 102 minutes of light only and 18 minutes of light and waterspray. The following conditions shall apply:

- (a) Black body temperature in cabinet: 60 ±3°C (140° ±5°F)
- (b) Relative humidity in cabinet: 50 ±5%
- (c) Intensity of xenon-arc: 0.5 to 0.6 watts/sq. meter at 340 mm wavelength.

At the completion of this test, the specular gloss and ambient flexibility of the specimens shall be determined in accordance with ASTM D 523; and the results shall be compared to the requirements of 3.6.5.

After exposure, the film shall be examined for conformance to Table I.

1/ Atlas Electric Devices Company or equivalent.

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4.5.13 Weather resistance. The elastomeric film, applied on bare and painted surfaces as specified in 4.3, shall be exposed in accordance with ASTM D 1006 and shall be examined for conformance to 3.6.4.

4.5.14 Storage stability. The elastomeric film shall be stored under warehouse conditions at a temperature of 70° to 90°F (21° to 32°C) for 12 months (see 3.6.3). The film shall then be tested for conformance with the quality conformance inspection (see 4.4.1).

4.6 Packaging, packing, and marking. Preparation for delivery shall be examined for conformance to section 5.

5. PACKAGING

5.1 Packaging. The packaging, packing, and marking of this material shall be in accordance with the requirements of PPP-T-680 as specified for the applicable levels (see 6.2).

5.1.1 Marking. In addition to the marking specified in PPP-T-680, and any special marking required by the contract or order, unit and exterior containers shall be durably and legibly marked with the following information:

National Stock No.
Type
Width
Length of film
Contract or order
Date of manufacture (month and year)
Manufacturer's name and address

6. NOTES

6.1 Intended use. The elastomeric fluorescent film is intended for use as a durable, easily removable, high visibility fluorescent film system for aircraft markings or other usage. It is not recommended for use on supersonic aircraft of any type.

6.2 Ordering data. Acquisition documents should specify the following:

- a. Title, number, and date of this specification.
- b. Color number and name, design, size, and quantity of elastomeric film desired (see 3.2 and 3.4).
- c. Level of packaging and packing desired (see section 5)

6.3 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.

Custodians:
Navy - AS
Air Force - 11

Preparing activity:
Navy - AS
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Review activities:
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