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MIL-I-82265B(NU)
13 December 1979
SUPERSEDING
MIL-I-82265A(SA)
2 November 1971

MILITARY SPECIFICATION

INSECT BAR, COT TYPE, NYLON NETTING

This specification is approved for use by Navy Clothing & Textile Research Facility, 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 requirements for one type and size insect bar, fabricated from nylon cloth and nylon netting.

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

V-T-285 - Thread, Polyester
DDD-L-20 - Label; for Clothing, Equipage, and Tentage (General Use)

MILITARY

MIL-C-508 - Cloth, Oxford, Nylon, 3 Ounce
MIL-C-3395 - Cloth, Netting, Nylon
MIL-B-17757 - Box, Shipping, Fiberboard (Modular Sizes)

STANDARDS

FEDERAL

FED-STD-751 - Stitches, Seams, and Stitchings

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Navy Clothing and Textile Research Facility, Natick, MA 01760 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this Document or by letter.

FSC 7210

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MILITARY

MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
MIL-STD-129 - Marking for Shipment and Storage

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

LAW AND REGULATIONS

U.S. POSTAL SERVICE MANUAL

(Copies of regulations may be obtained from the Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402)

2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless otherwise indicated, the issues in effect on date of invitation for bids or request for proposal shall apply:

NATIONAL MOTOR FREIGHT TRAFFIC ASSOCIATION, INC., AGENT
National Motor Freight Classification

(Application for copies should be addressed to the American Trucking Associations, Inc., Traffic Department, 1616 P Street, N.W., Washington, D.C. 20036.)

UNIFORM CLASSIFICATION COMMITTEE, AGENT
Uniform Freight Classification

(Application for copies should be addressed to the Uniform Classification Committee, Room 1106, 222 Riverside Plaza, Chicago, Illinois 60606.)

3. REQUIREMENTS

3.1 Guide sample. Samples, when furnished, are solely for guidance and information to the contractor (see 6.3). Variations from this specification may appear in the sample, in which case this specification shall govern.

3.2 First article. When specified (See 6.2), the contractor shall furnish sample unit(s) for first article inspection and approval (See 4.2).

3.3 Materials.

* 3.3.1 Basic material. The basic material for the insect bar shall be nylon netting, conforming to type I or II of MIL-C-3395.

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* 3.3.2 Cloth, oxford, nylon. The material for the corner reinforcement pieces, extension pieces, and the tie tape reinforcement pieces shall be nylon oxford cloth, 3 ounce, olive green 106, conforming to type I, class 1, of MIL-C-508. The cut edges of the cloth used for the extension pieces and the reinforcement pieces shall be fused.

* 3.3.2.1 Tie tapes and binding. The tie tapes and binding for the seam shall be nylon oxford cloth specified in 3.3.2 and cut 3/4 (± 1/8) inch wide with fused edges or cut 1 (± 1/8) inch wide with edges turned under 1/8 inch, and stitched 1/16 inch from each folded edge.

* 3.3.3 Thread, Polyester. Thread shall conform to type I or II, class 1, size A or B, of V-T-285. The color shall approximate the color of the base material.

3.3.4 Identification label. Each insect bar shall have an identification label conforming to type II, class 5, of DDD-L-20. The printing shall show fastness to weathering and shall bear the following inscription:

INSECT BAR, COT TYPE, NYLON NETTING (100% nylon)
NAME OF CONTRACTOR:
CONTRACT NUMBER: DLA-000-00-0-0000 Example
STOCK NUMBER: 7210-00-000-0000 Example

3.4 Figure. The figure is furnished for information purposes only. To the extent of any inconsistencies between the written specification and the figure, the written specification shall govern.

3.5 Construction. The construction of the insect bar shall conform to the figure and the requirements specified herein.

3.5.1 Stitch, seam, and stitching types. All stitch, seam, and stitching types specified shall conform to FED-STD-751. Whenever two or more methods of seams or stitch types are given for the same operation any one may be used. Where stitch type 401 is used, the looper thread of the stitch shall be on the inside of the insect bar. Seam allowances shall be maintained with seams properly sewn so that no raw edges, runoffs, twists, pleats, puckers, or open seams will result. All edgestitching or outer rows of stitching shall be 1/16 to 1/8 inch from edge.

3.5.1.1 Thread breaks and ends of seams. Ends of all seams and stitching produced with stitch type 301, when not caught in other seams or stitching, shall be backtacked not less than 1/2 inch except for the vent opening hem where ends are turned under in a hem or held down by other stitching. Both ends of all seams and stitching produced with 401 stitch type, when not caught in other seams or stitching, shall have a 1/2 to 3/4 inch chain extending beyond each end. Thread breaks (all stitch types) shall be secured by stitching back of break not less than 1/2 inch. Skipped stitches or thread breaks (401 stitch type) may be repaired using 301 stitch type.

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3.5.1.2 Stitches per inch. All stitching, except bartacking, shall have no less than 9 or more than 12 stitches per inch.

* 3.6 Manufacturing operations requirements. The insect bar shall be made in accordance with operation requirements specified in Table 1. The contractor is not required to follow the exact sequence of operations, provided the finished insect bars are identical to those produced by following the operations listed.

Table I - Construction of Insect Bar

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
1.	a) The insect bar shall consist of: one top panel, two side panels, two end panels and shall have the following features: two extension pieces, twelve reinforcing corners, four tie tape reinforcements, tie tapes and binding as shown in fig 1. b) The top, side and end panels may be fabricated in one or two pieces. c) Cut all component parts of the insect bar in accordance with figure 1, which shows dimentions, shapes, and proper locations of all parts in relationship to each other.					
2.	During the spreading, cutting and manufacturing process, components have material defects or damages that are classified as defects in section 4 of this specification shall be removed and replaced with non-defective components.					
3.	When the top, side, or end panels are fabricated with two pieces joining two edges to form panel, the stitch shall be 1/4 to 5/8 inch gauge with the outer row of stitching to be no less than 1/16 inch from edge.	301 or	LSc-2 or	9-12	B	B

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Table I - Construction of Insect Bar (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
4.	Prepare top panel a) Position two extention of nylon oxford (see 3.3.2) as shown in fig 1. Join each extension piece 1/4 to 5/16 inch gauge the outer row of stitching to be no less than 1/16 inch from edge.	301 or 401	LSc-2 LSa-2	9-12	B B	B A
	b) Position four triangle shape reinforcing corners on the inside of the insect bar, one for each corner with the short leg on the edge of the panel. Stitch all edges of reinforcing corners to nylon netting and extension piece, 1/4 inch from finished edges.	301 or 401	SSa-1	9-12	B B	B A
	c) Position two tie tape reinforcement centered on each end of top panel - fold in half, lapping the outer and inner edges as shown in fig. 1. Stitch 1/4 to 5/16 inch gauge from fused edges.	301 or 401	SSa-1	9-12	B B	B A
5.	Prepare side panel (see operation 3) a) Position two triangle shape reinforcing corners one to each corner on the same edge and side, and with the short leg on edges of panel. Stitch all edges of reinforcing corners to the nylon netting, 1/4 inch from fused edges.	301 or 401	SSa-1	9-12	B B	B B

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Table I - Construction of insect bar (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
5.	(Cont'd)					
	b) Stitch vent opening on each end of side panel for a distance of 10 inches from the bottom edge. The finished hem shall be 1/4 to 3/8 inch wide.	301 or 401	EFa-1	9-12	B B	B A
6.	Prepare end panel (see operation 3)					
	a) Position two triangle shape reinforcing corners one to each top corner on the same edge and side, and with the short leg on edge of panel. Stitch all of reinforcing corners to the nylon netting, 1/4 inch from fused edges.	301 or 401	SSa-1	9-12	B B	B A
	b) Stitch vent opening on each side of the end panel for a distance of 10 inches from the bottom edge. The finished hem shall be 1/4 to 3/8 inch wide.	301 or 401	EFa-1	9-12	B B	B A
	c) Position one tie tape reinforcement, center in between the two reinforcing corners - fold in half, lapping the outer and inner edges as shown in fig. 1. Stitch fused edges 1/4 inch from edge.	301 or 401	SSa-1	9-12	B B	B A
7.	Closing of insect Bar					
	a) Position top panel and side panels so that the reinforcing corners are on the inside of insect bar.					
	b) Stitch both panels and binding together or as an alternate stitch both panels together without binding	301 or 401	BSa-1 LSc-2 LSa-2	9-12	B B B	B B A
	c) Position the combined (top and side) panels of operation 6A and 6B to end panel so that the reinforcing corners finish on the inside of insect bar..					

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Table I - Construction of insect bar (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
7.	(Cont'd) d) Stitch (top, side, and end) panels and binding together in one continuous operation.	301	BSa-1	9-12	B	B
8.	Attach tie tapes a) Position ten tie tapes on the outside of the insect bar as indicated in figure 1. b) Each tie tape shall be positioned on the bound edge seam with the free ends of tie tape finishing 10 1/2 ± 1/4 inch in length Each tape shall be seamed with a 1/2 to 5/8 inch bartack through the bound seam with a bight 1/8 inch.	Bartack		28 Per Bartack	B	B
9.	Attach Label Position and stitch all four sides of label as shown in figure 1	301 or 401			B B	B B
10.	Hem bottom edge of insect bar Turn bottom edge of insect bar to the inside with raw edges turned in and single stitch hem to measure 1/4 to 3/8 inch wide when selvages are not used.	301 or 401	EFa-1	9-12	B B	B A
11.	Clean insect bar Trim, and remove all the thread ends to a length of not more than 1/4 inch. Remove all spots and stains.					
11.	Finish measurement The finish measurements of the insect bar shall conform to the measurements shown on figure 1.					

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3.7 Finished dimension. The finished dimensions of the insect bar shall be as shown on figure 1

3.8 Workmanship. The finished insect bar shall conform to the quality of product established by this specification. The occurrence of defects shall not exceed the applicable acceptable quality levels.

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 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 the prescribed requirements.

4.1.1 Certificate of compliance. Where certificates of compliance are submitted, the Government reserves the right to check test such items to determine the validity of the certification.

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

1. First Article Inspection (See 4.3)
2. Quality conformance (See 4.4)

* 4.3 First article inspection. When required, the first article submitted in accordance with 3.2 shall be inspected for compliance with design, construction, workmanship, appearance and dimensional requirements.

* 4.4 Quality conformance inspection. Inspection shall be performed in accordance with MIL-STD-105, except where otherwise indicated.

4.4.1 Component and material inspection. In accordance with 4.1 above, components and materials shall be inspected and tested in accordance with the requirements of referenced specifications, drawings, and standards unless otherwise excluded, amended, modified or qualified in this specification or applicable purchase document.

4.4.2 Examination of the end item. The defects found during the examination shall be classified in accordance with 4.4.2.1 and 4.4.2.2. The applicable inspection levels and acceptable quality levels (AQL's) shall be as indicated in 4.4.2.3. The sample unit shall be one completely fabricated inspect bar. The lot size shall be expressed in units of insect bars.

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* 4.4.2.1 Visual examination. The insect bar shall be examined for defects classified in accordance with the list below.

Defect	Classification Major	Minor
MATERIAL DEFECTS AND WORKMANSHIP DAMAGES		
a. Any hole, cut, tear, needle chew, or smash	X	
b. Any mend, burn, or patch	X	
c. Any hole noticeably larger than the normal mesh opening in the nylon netting fabric	X	
CLEANNESS		
a. Any spot or stain		X
b. Thread ends not trimmed or loose thread not removed		X
THREAD		
a. Color does not approximate color of base fabric		X
b. Not type or size specified		X
COMPONENT AND ASSEMBLY		
Any component part omitted, not as specified, or required operation omitted, not as specified, (unless otherwise classified herein)	X	
SEAMS AND STITCHING		
a. Accuracy of seaming		
1. Any part of insect bar caught in unrelated operation	X	
2. Seams twisted, puckered, or pleated		X
3. Ends of seams produced with 301 stitch type when not caught in other seams or stitching backtacked less than 1/2 inch		X
4. Ends of seams produced with 401 stitch type when not caught in other seams or stitching having chain extending less than 1/2 inch or more than 3/4 inch beyond each end		X
5. Ends of seams produced with 401 stitch type when not caught in other seams or stitching not having chain extending beyond each end	X	
6. Thread breaks (all stitch types) stitched less than 1/2 inch beyond both ends of break		X

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Defect	Classification Major	Minor
SEAMS AND STITCHING (Cont'd)		
b. Guage of stitching		
1. Irregular, i.e., unevenly guaged, not uniform		X
2. Beyond range of width specified		X
c. Open seams		
1. On one row of 301 stitching, up to and including 1/2 inch		X
2. On one row of 301 stitching more than 1/2 inch	X	
3. On both rows of double needle 301 stitching	X	
4. Any 401 stitching	X	
5. Two or more continuous skipped, broken or runoff stitches		X
d. Any raw edge		X
e. Seam and stitch types		
1. Not specified seam or stitch type		X
2. Looper thread on outside (when 401 stitch is used)		X
f. Stitch tension		
1. Loose tension		X
2. Tight tension	X	
g. Stitches per inch (score only when conditions exists on major portion of a seam) More than specified		X
Less than specified	X	
h. Bartacks		
1. Missing, loose, or misplaced	X	
2. Not size specified		X
3. Extending beyond edges of tie tapes		X
PANELS		
a. Top		
1. Constructed with more than two pieces of netting or the nylon oxford cloth extension piece at one end, instead of at each end	X	
2. Extension pieces cut edges not fused		X
b. Sides		
Constructed with more than two pieces of netting in each panel	X	
c. Ends		
Constructed with more than two pieces of netting in each panel	X	

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Defect	Classification Major	Minor
CORNER REINFORCEMENT		
a. Any omitted or not attached as specified	X	
b. not triangular shaped		X
c. Cut edges of corner reinforcement not fused		X
TIE TAPE REINFORCEMENT		
a. Any omitted or not constructed or attached as specified	X	
b. Cut edges of tie tape reinforcement not fused		X
TIE TAPES		
a. Any omitted or not constructed or attached as specified	X	
b. Cut less than 21 inches in length		X
SEAM BINDING		
a. Omitted or not constructed or attached as specified	X	
b. Finished sides and ends of the insect bar joined and bound for a distance of less than 26 inches from the top forming vents at each bottom corner	X	
LABEL		
a. Missing, incorrect, or illegible	X	
b. Misplaced		X
c. Not stitched around on all four sides		X
HEMS (Vent)		
Not constructed as specified		X
Finished width less than 1/4 inch or more than 3/8 inch.		X

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4.4.2.2 Dimensional examination. The insect bar shall be examined for defects in dimensions in accordance with figure 1. Any measurement deviating from nominal dimensions and tolerances shall be scored as a measurement defect.

4.4.2.3 Inspection levels and acceptable quality levels. The inspection levels and acceptable quality levels (AQL's) expressed in defects per 100 units, for visual and dimensional examinations shall be as follows:

	AQL's	Inspection Level
For examination in 4.4.2.1:		
Major	4.0	II
Total (Major and Minor combined)	15.0	II
For examination in 4.4.2.2:		
One class	4.0	S-3

4.4.3 Examination of packaging requirements. An examination shall be made to determine that packaging, packing and marking complies with the section 5 requirements of this specification. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully prepared for delivery except that it need not be sealed. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot size shall be the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 and the AQL shall be 2.5 defects per 100 units.

Examine	Defect
Marking (exterior and interior)	Omitted, incorrect, illegible, or improper size, location, sequence or method of application
Materials	Any component missing, damaged, or not as specified
Workmanship	Inadequate application of components, such as incomplete closure of container, flaps, improper taping, loose strapping, or inadequate stapling; bulging or distortion of container
Content	Number of insect bars per shipping container is more or less than specified

5. PACKAGING

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5.1 Preservation Packaging. Packaging shall be level A or C as specified (see 6.2).

5.1.1 Level A. Each insect bar shall be neatly folded to measure approximately 23 by 14 inches.

* 5.1.2 Level C. (Commercial Packaging) Insect bars shall be packaged to afford adequate protection against physical damage during shipment from the supply source to the first receiving activity. The package and the quantity per package shall be the same as that normally used by the Contractor for retail distribution.

5.2 Packing. Packing shall be level A, B, or C as specified (see 6.2).

* 5.2.1 Level A. Fifty (50) insect bars, packaged as specified in 5.1 shall be packed in a fiberboard shipping container assembled, closed and reinforced conforming to class weather resistant, size 3A, of MIL-B-17757. The top and bottom of the contents of the container shall be completely covered with a sheet of commercial grade kraft paper.

* 5.2.2 Level B. Fifty (50) insect bars, packaged as specified in 5.1 shall be packed in a fiberboard shipping container assembled and closed conforming to class domestic, size 3A, of MIL-B-17757. The top and bottom of the contents of the container shall be completely covered with a sheet of commercial grade kraft paper.

* 5.2.2.1 When specified (see 6.2) the shipping container shall be grade V3c, V3s or V4s fiberboard box in accordance with MIL-B-17757 and closed in accordance with the appendix of the box specifications.

* 5.2.3 Level C. (Commercial packing) Insect bars, packaged as specified in 5.1, shall be packed in a manner to insure carrier acceptance and safe delivery at destination at the lowest transportation rate for such supplies. Container shall comply with U. S. Postal Service Manual, Uniform Freight Classification Rules or National Motor Freight Classification Rules, as applicable.

5.3 Marking. In addition to any special marking required by the contract or order, the shipping containers shall be marked in accordance with MIL-STD-129.

6. NOTES

* 6.1 Intended Use. The insect bars are intended for use with:

Cot, folding	FSN 7105-00-269-9279
Pole, folding cot insect bar	FSN 7210-00-267-5641

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* 6.2 Ordering data. Procurement documents should specify the following:

(a) Title, number, and date of this specification
(b) When first article sample is required (see 3.2)
(c) Selection of applicable levels of packing and packaging (see 5.1 and 5.2)

6.3 Samples. For access to samples, address the procuring activity issuing the invitation for bids.

* 6.4 Changes from previous issue. The margins of this specification are marked with an asterisk to indicate where changes (additions, modifications, corrections, deletions) 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.

Custodian:
Navy - NU

Review activity:
Navy - MS
DLA - CT

User activities:
Navy - YD, CG, MC

Preparing activity:
Navy - NU

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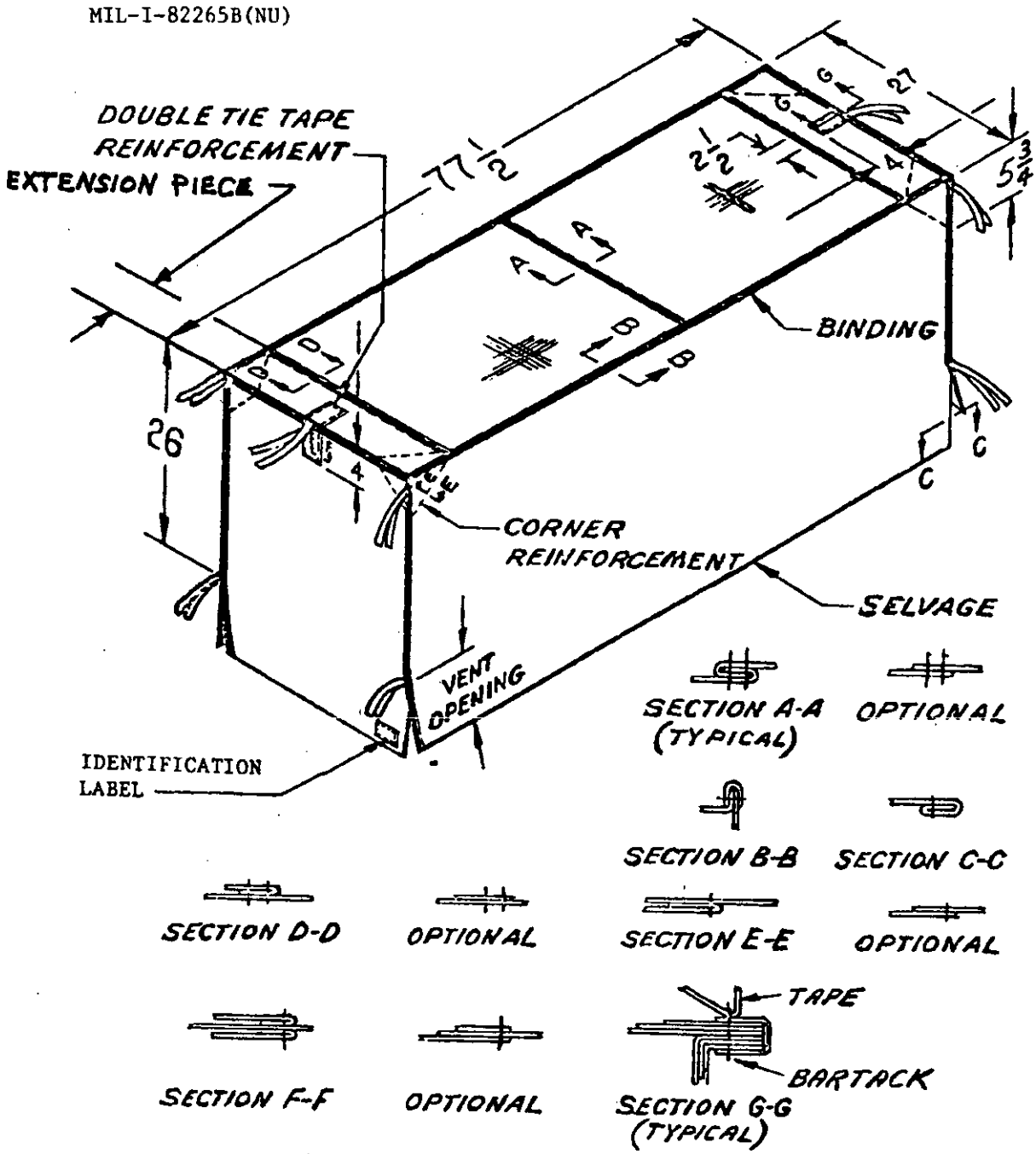

NOTE:

ENDS AND SIDES OF BAR SHALL BE NO LESS THAN 34 INCHES IN HEIGHT. TOLERANCE FOR OVERALL LENGTH, WIDTH AND HEIGHT DIMENSIONS SHALL BE ± 1 INCH AND ALL OTHER DIMENSIONS ± 1/4 INCH.

OPTIONAL STITCHING MAY BE USED WHEN SELVAGE OR FUSED EDGES ARE USED.

FIGURE 1- INSECT BAR, COT TYPE, NYLON NETTING

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DOCUMENT IDENTIFIER *(Number)* AND TITLE

MIL-I-82265B(NU) INSECT BAR, COT TYPE, NYLON NETTING

NAME OF ORGANIZATION AND ADDRESS OF SUBMITTER

☐ VENDOR ☐ USER ☐ MANUFACTURER

1. ☐ HAS ANY PART OF THE DOCUMENT CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE? ☐ IS ANY PART OF IT TOO RIGID, RESTRICTIVE, LOOSE OR AMBIGUOUS? PLEASE EXPLAIN BELOW.

A. GIVE PARAGRAPH NUMBER AND WORDING

B. RECOMMENDED WORDING CHANGE

C. REASON FOR RECOMMENDED CHANGE(S)

2. REMARKS

SUBMITTED BY *(Printed or typed name and address — Optional)*

TELEPHONE NO.

DATE

DD FORM 1426 1 OCT 76 Replaces edition of 1 Jan 72 which may be used. S/N 0102-LF-001-4260