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 25 March 1988
 SUPERSEDING
 MIL-K-41835C
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MILITARY SPECIFICATION

KIT BAG, FLYER'S

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

1. SCOPE

1.1 Scope. This document covers one type and size flyer's kit bag made of cotton duck with slide fastener closure.

2. APPLICABLE DOCUMENTS

2.1 Government documents.

- * 2.1.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of these documents shall be those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation.

SPECIFICATIONS

FEDERAL

A-A-203	- Paper, Kraft, Untreated
T-T-871	- Twine, Cotton, Wrapping
V-F-106	- Fasteners, Slide, Interlocking
V-T-285	- Thread, Polyester
PPP-B-636	- Boxes, Shipping, Fiberboard

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: U.S. Army Natick Research, Development, and Engineering Center, Natick, MA 01760-5014 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8460

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MILITARY

- MIL-F-10884 - Fasteners, Snap
- MIL-L-35078 - Loads, Unit Preparation of Semiperishable Subsistence Items; Clothing, Personal Equipment and Equipage; General Specification For

STANDARDS

MILITARY

- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
- MIL-STD-129 - Marking for Shipment and Storage
- MIL-STD-147 - Palletized Unit Loads
- MIL-STD-731 - Quality of Wood Members for Containers and Pallets
- MS 27980 - Fasteners, Snap, Style 2 (Regular Wire Spring Clamp Type)

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

- * 2.1.2 Other Government documents, drawings, and publications. The following other Government documents, drawings, and publications form a part of this specification to the extent specified herein. Unless otherwise specified, the issues shall be those in effect on the date of the solicitation.

DRAWINGS

U.S. ARMY NATICK RESEARCH, DEVELOPMENT, AND ENGINEERING CENTER

- 11-1-302 - Kit Bag, Flyer's (Assembly, Details and Sections)
- 11-1-303 - Kit Bag, Flyer's (Details and Sections)

(Copies of drawings, publications, and other Government documents required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting activity.)

- * 2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of the documents which are DOD adopted shall be those listed in the issue of the DODISS specified in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS shall be the issues of the nongovernment documents which are current on the date of the solicitation.

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AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

D 3951 - Standard Practice for Commercial Packaging

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

(Nongovernment standards and other publications are normally available from the organizations which prepare or which distribute the documents. These documents also may be available in or through libraries or other informational services.)

- * 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. Nothing in this specification, however, shall supersede applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 First article. When specified in the contract or purchase order, a sample shall be subjected to first article inspection (see 4.3, 6.2, and 6.4).

3.2 Materials. Unless otherwise specified herein, all materials shall be as specified on Drawings 11-1-302 and 11-1-303 (see 6.5).

- * 3.2.1 Thread. The thread shall be nylon as specified on the drawings, or shall be polyester conforming to type I, class 1, sub-class B, size F of V-T-285. The color for the polyester thread shall be Sage Green, AD, C.A. 66046.
- * 3.2.2 Fastener, slide, interlocking. The slide fastener shall conform to type I, style 18, size MHS nylon or polyester continuous monofilament element fastener (spiral or serpentine) in accordance with V-F-106 and the requirements in 3.2.2.1, 3.2.2.2, 3.2.2.3, and 3.2.2.4. As an alternate to pre-assembled slide fastener, the use of continuous chain method in accordance with 3.4.11.1.1.1 of V-F-106 is allowed.
 - * 3.2.2.1 Color. The color of the element, element sewing thread, slider, stops, stirrup pulls, and thongs shall match the sage green fastener tape. As an alternate, the stops may be black.
 - * 3.2.2.2 Fastener length. The fastener length shall be such as to provide a smooth and secure closure and shall meet the requirements specified in Drawing 11-1-303.
 - * 3.2.2.3 Fastener slider and stirrup pulls. The fastener shall have multiple (throat to throat) sliders with wire stirrup pulls and thongs attached. The slider shall properly fit the fastener chain. The stirrup pulls shall be fabricated from brass or corrosion resistant steel wire, 0.058 inch maximum diameter.

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- * 3.2.2.3.1 Slider identification. For purpose of aiding in end item repair situations, the slider shall be identified with a symbol or marking as to identify the fastener manufacturer.
- * 3.2.2.4 Slide fastener tape. The slide fastener tape shall be 3/4 inch wide, dyed Sage Green No. 1509 to match the standard sample and shall be water repellent treated. The shade imparted by the treatment will be considered acceptable. The dyed tape shall show fastness to weathering equal to or better than the standard sample (see 6.3). When no standard sample is available, the dyed tape shall show good fastness to weathering.

3.2.3 Fasteners, snap. The snap fasteners shall conform to style 2, MS 27980, Part No. MS 27980-1B button, MS 27980-6B socket, MS 27980-7B stud, and MS 27980-8B eyelet, and shall have finish 2 in accordance with MIL-F-10884.

3.3 Construction. The construction shall conform to the documents and drawings listed in section 2 and as specified herein.

NOTE: Dimensions shown on the drawings for body pieces A and B, carrying strap, and the flap, represent dimensions after sub-assembly, and are not to be construed as dimensions of cut parts.

3.3.1 Type 301 stitching. Thread breaks and skips in stitching shall be overstitched not less than 1 inch. Run-offs shall be restitched to conform to the stitch pattern specified on the drawings. Exclusive of automatic machinery, ends of stitching shall be backstitched a minimum of 1/2 inch, except where turned under in a hem or held down by other stitching. Thread tension shall be maintained so that there will be no loose stitching and the lock will be embedded in the materials sewed. All thread ends shall be trimmed.

3.3.1.1 Stitching, automatic machinery. Stitching patterns produced by automatic machines may be utilized in lieu of those specified, providing seam strength efficiency and function are equal to, or better than, the specified pattern, and upon approval by the contracting activity. Certification of equivalency, supported by engineering data, may be required.

- * 3.3.1.2 Thread ends. All thread ends shall be trimmed even with the material to a maximum length of 1/4 inch.

3.3.2 Setting of snap fasteners. Holes shall be prepunched to receive the snap fasteners. The hole shall be smaller than the outside diameter of the fastener tube so that the tube must be forced through the hole. Prepunched holes shall not be accomplished by using the stud or eyelet tubes. Fastener components shall be securely clinched without cutting the material. The roll of the clinched eyelet of the assembled fastener components shall not possess more than two scores (splits).

3.4 Marking. Identification marking shall be as specified on drawing 11-1-302.

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3.5 Workmanship. The kit bag shall conform to the quality of product established by this document and the occurrence of defects shall not exceed the specified 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 purchase 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 this document where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

* 4.1.1 Responsibility for compliance. All items must meet all requirements of sections 3 and 5. The inspection set forth in this document shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirement in the document shall not relieve the contractor of the responsibility of assuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling in quality conformance does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to acceptance of defective material.

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

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

4.3 First article inspection. When a first article is required (see 6.2), it shall be examined for the defects specified in 4.4.3. The presence of any defect shall be cause for rejection of the first article.

4.4 Quality conformance inspection. Unless otherwise specified, sampling for inspection shall be performed in accordance with MIL-STD-105.

4.4.1 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 document or applicable purchase document.

4.4.2 In-process inspection. Inspection shall be made at any point or during any phase of the manufacturing process to determine whether cut lengths, cut parts, marking for location of components, and location of assembled component parts are in accordance with specified requirements. In

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addition, inspection shall be made to determine that prepunched or predrilled holes for receiving snap fasteners are smaller than the outside diameter of the hardware tube or barrel. When nonconformance is noted, correction shall be made to the items affected and to the operation.

- * 4.4.3 End item visual examination. The end item shall be examined for the defects listed in table I. The lot size shall be expressed in units of kit bags. The sample unit shall be one kit bag. The inspection level shall be I and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 2.5 for major defects and 15.0 total (major and minor combined) defects.

TABLE I. End item visual examination

Examine	Defect	Classification	
		<u>Major</u>	<u>Minor</u>
Fabric:			
Duck	Any hole (except exposed drill-holes), cut, tear, smash, open place, or broken or missing yarn	X	
	Two or more exposed drillholes		X
	Shade bar, or fine or coarse filling bar		X
Webbing and tape	Not firmly and tightly woven; edge frayed or scalloped	X	
	Exposed end of lug tape not dipped in wax as required		X
Hardware	Broken or malformed; protective finish omitted; corroded area; burr or sharp edge which may cause injury in handling	X	
Seams and stitchings:			
Open seam	More than 1/2 inch (except box stitching)	X	
	1/2 inch or less (except box stitching)		X
	Any open seam on box stitching		X

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TABLE I. End item visual examination - Continued

Examine	Defect	Classification	
		<u>Major</u>	<u>Minor</u>
Seams and stitching - continued	NOTE: A seam shall be classified as open when one or more stitches joining a seam are broken or when two or more continuous skipped or run-off stitches occur. On double stitched seams, a seam shall be classified as open when either one or both sides of the seam are open.		
Raw edge	More than 1/2 inch when securely caught in stitching		X
	NOTE: A raw edge not securely caught in stitching shall be classified as an open seam.		
Seam and stitch types	Wrong seam or stitch type	X	
Stitch tension	Loose, resulting in a loosely exposed top or bobbin thread; tight resulting in excessive tightness of fabric on seam		X
Stitches per inch	Two or more stitches less than minimum specified	X	
	One stitch less than minimum specified		X
	One or more stitches in excess of maximum specified		X
	NOTE: Variation in the number of stitches per inch caused by the operator speeding up the machine and pulling the fabric in order to sew over heavy places or heavy seams, or in turning corners shall be classified as follows:		

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TABLE I. End item visual examination - Continued

Examine	Defect	Classification	
		Major	Minor
Seams and stitching - continued	(a) Within the major defect classification - Minor defect (b) Within the minor defect classification - No defect		
Stitching margin; gage on double needle stitching	Not as specified, affecting service-ability or appearance		X
Stitching end	Backstitched less than 1/2 inch (except where end is turned under in a hem or held down by other stitching)		X
Thread break, skip, or run-off	Overstitched less than 1 inch		X
	NOTE: A thread break, skip, or run-off not overstitched shall be classified as an open seam.		
Box stitching	Two or more rows of stitching omitted One row of stitching omitted	X	X
Components and assembly	Any required component or operation omitted or not as specified Needle chew Mend, darn, or patch One or more rows of stitching omitted (except box stitching)	X X X X	
Binding	Improperly or loosely applied showing raw edge of fabric End of binding not finished as specified or overlapped less than 3/8 inch	X	X

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TABLE I. End item visual examination - Continued

Examine	Defect	Classification	
		Major	Minor
Handles	Edges of grip section overlapped; edges not folded or not stitched as indicated on drawing		X
Carrying strap	End of carrying strap not finished as specified		X
Reinforcement "A"	Misplaced or not properly attached, failing to serve intended purpose	X	
Marking identifi- cation	Omitted, illegible, incorrect, misplaced, or size characters not as specified		X
	Marking not specified color		X
Snap fasteners	Any fastener not functioning properly (i.e., fails to snap closed, provide a secure closure, or open freely)	X	
	Improper or insecure clinching	X	
	Clinched excessively tight, cutting adjacent material	X	
	Clinched loosely, permitting com- ponents to rotate freely in the hole of the material	X	
	Incorrect style	X	
	Roll of clinched eyelet fastener assembly contains more than two scores (splits)		X
Slide fastener	Not specified type or size	X	
	Does not provide a smooth and secure closure full length of bag opening	X	
	Slider jams or fails to interlock chain scoops	X	
	Any portion of fastener broken, bent, missing, or not aligned making fastener unusable	X	
	Fastener tape not 3/4 inch wide	X	

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TABLE I. End item visual examination - Continued

Examine	Defect	Classification	
		Major	Minor
Slide fastener - continued	Sliders not assembled throat to throat	X	
	Single slider provided instead of two; not furnished with two stirrup pulls, or stirrup pulls not made out of wire	X	
	Thong omitted	X	
	Thong not secured to stirrup pulls as specified		X
	Chain not plastic or not of the configuration specified	X	
Cleanness	Grease, oil, or ink stains clearly noticeable; thread ends not trimmed as specified		X

- * 4.4.4 Packaging examination. The fully packaged end items shall be examined for the defects listed below. The lot size shall be expressed in units of shipping containers. The sample unit shall be one shipping container fully packaged. The inspection level shall be S-2 and the AQL, expressed in terms of defects per hundred units, shall be 2.5.

<u>Examine</u>	<u>Defect</u>
Marking (exterior and interior)	Omitted; incorrect; illegible; of 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 sealing or closure of flap, improper taping, loose strapping, or inadequate stapling Bulged or distorted container
Content	Number of kit bags per container is more or less than required

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- * 4.4.5 Palletization examination. The fully packaged and palletized end items shall be examined for the defects listed below. The lot size shall be expressed in units of palletized unit loads. The sample unit shall be one palletized unit load, fully packaged. The inspection level shall be S-1 and the AQL, expressed in terms of defects per hundred units, shall be 6.5.

<u>Examine</u>	<u>Defect</u>
Finished dimensions	Length, width, or height exceeds specified maximum requirement
Palletization	Pallet pattern not as specified Interlocking of loads not as specified Load not bonded as specified
Weight	Exceeds maximum load limits
Marking	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application

5. PACKAGING

5.1 Preservation. Preservation shall be level A or Commercial, as specified (see 6.2).

5.1.1 Level A. Each kit bag shall be neatly folded to approximately 23 by 13 inches. Five folded kit bags shall then be evenly stacked in a bundle and securely tied at each end with cotton twine conforming to type I or II, 8-ply of T-T-871.

- * 5.1.2 Commercial. Kit bag shall be preserved in accordance with ASTM D 3951.

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

- * 5.2.1 Level A packing. Twenty kit bags, preserved as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC-L, grade V2s of PPP-B-636. The inside of each fiberboard container shall be fitted with a box liner conforming to type CF, class weather-resistant, variety DW, grade V15c of PPP-B-636. Level A bundles shall be packed on their sides, one in length, four in width, and one in depth within a shipping container. Inside dimensions of each shipping container shall be approximately 23-1/2 inches in length, 20-1/2 inches in width, and 13 inches in depth. Approximate dimensions are furnished as a guide only. Each container shall have the contents completely covered on the top and bottom with a sheet of 30-pound minimum basis weight kraft paper conforming to A-A-203. Each shipping container shall be closed in accordance with method III, waterproofed in accordance with method V, and reinforced as specified in

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the appendix of PPP-B-636, except that the inspection shall be in accordance with 4.4.4. Shipping containers shall be arranged in unit loads in accordance with MIL-L-35078 for the type and class of load specified (see 6.2). Strapping shall be limited to nonmetallic strapping, except for type II, class F loads.

- * 5.2.2 Level B packing. Twenty kit bags, preserved as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC-L, type CF (variety SW) or SF, class domestic, grade 275 of PPP-B-636. The inside of each fiberboard container shall be fitted with a box liner conforming to type CF, class domestic, variety DW, grade 275 of PPP-B-636. Level A bundles shall be packed on their sides, one in length, four in width, and one in depth within a shipping container. Inside dimensions of each shipping container shall be approximately 23-1/2 inches in length, 20-1/2 inches in width, and 13 inches in depth. Approximate dimensions are furnished as a guide only. Each container shall have the contents completely covered on the top and bottom with a sheet of 30-pound minimum basis weight kraft paper conforming to A-A-203. Each shipping container shall be closed in accordance with method II as specified in the appendix of PPP-B-636, except that the inspection shall be in accordance with 4.4.4.

5.2.2.1 Weather-resistant fiberboard container. When specified (see 6.2), the fiberboard shipping container shall be a grade V3c, V3s, or V4s fiberboard box, fabricated in accordance with PPP-B-636 and closed in accordance with method III as specified in the appendix of PPP-B-636, except that the inspection shall be in accordance with 4.4.4.

- * 5.2.3 Commercial packing. Kit bags, preserved as specified in 5.1, shall be packed in accordance with ASTM D 3951.
- * 5.3 Palletization. When specified (see 6.2), kit bags, packed as specified in 5.2.2 and 5.2.3, shall be palletized on a 4-way entry pallet in accordance with load type IA of MIL-STD-147. Pallet type shall be type I (4-way entry), type IV or type V in accordance with MIL-STD-147. Pallets shall be fabricated from wood groups I, II, III, or IV of MIL-STD-731. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding means K and L or film bonding O or P. Pallet pattern shall be No. 90 in accordance with the appendix of MIL-STD-147. Interlocking of loads shall be effected by reversing the pattern of each course.
- * 5.4 Marking. In addition to any special marking required by the contract or purchase order, bundles, shipping containers, and palletized unit loads shall be marked in accordance with MIL-STD-129 or ASTM D 3951, as applicable. Each bundle shall have attached a manila colored paper shipping tag for the identification information.

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6. NOTES

6.1 Intended use. The flyer's kit bag is designed primarily to be used for airdropping, recovering, carrying and storing personnel type parachutes and miscellaneous equipment.

6.2 Ordering data. Acquisition documents should specify the following:

- a. Title, number, and date of this document.
- b. When a first article is required (see 3.1, 4.3, and 6.4).
- c. Stock number.
- d. Selection of the applicable levels of preservation and packing (see 5.1 and 5.2).
- e. Type and class of unit load required (see 5.2.1)
- f. When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).
- g. When palletization is required (see 5.3).

6.3 Standard sample. For access to samples of the cotton duck, webbing, tape, and nylon thread, address the contracting activity issuing the invitation for bids.

- * 6.4 First article. When a first article is required, it shall be inspected and approved under the appropriate provisions of FAR 52.209. The first article should be a preproduction sample. The contracting officer should specify the appropriate type of first article and the number of units to be furnished. The contracting officer should include specific instructions in all acquisition instruments regarding arrangements for selection, inspection, and approval of the first article.

6.5 Recycled material. It is encouraged that recycled material be used when practical as long as it meets the requirements of this document (see 3.2).

- * 6.6 Subject term (key word) listing.

Airdrop equipment
Kit bag, flyer's

6.7 Changes from previous issue. The margins of this document 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, as written, irrespective of the marginal notations and relationship to the last previous issue.

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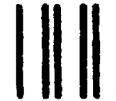
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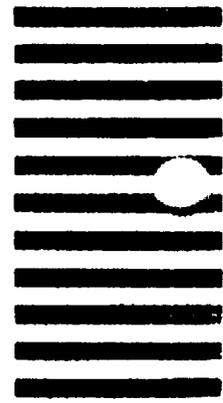
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