

MIL-L-81542A(AS)  
AMENDMENT 3  
15 August 1981  
SUPERSEDING  
AMENDMENT 2  
24 JULY 1978

## MILITARY SPECIFICATION

### LIFE RAFT, INFLATABLE, ONE MAN, TYPE LR-1

This amendment forms a part of Military Specification MIL-L-81542A(AS) dated 29 March 1976 and has been approved by the Naval Air Systems Command, Department of the Navy.

#### PAGE 1

Add to bottom of page:

"Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Commanding Officer, Naval Air Engineering Center, ESSD (Code 93), 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.

#### PAGE 2

#### 2.1 Drawings

Delete: 67A319C17 Patch, Directive Compliance Inflatable Life Rafts

#### PAGE 3

3.4.2 Delete second and fifth sentences in their entirety.

#### PAGE 4

3.4.3 Delete the text in its entirety and substitute: Seam construction and seam tape, patch, and attachment applications shall be in accordance with applicable drawing requirements. The techniques and precautions outlined in 3.4.2 shall be used in order to effect optimum bonding properties, and to ensure compliance with the requirements of this specification. The adhesive shall be applied in a straight line parallel to the edges of the seam, seam tape, patch or attachment and shall extend from just being visible to a maximum of one inch beyond the applicable edge. The adhesive shall not be allowed to remain in clots or permitted to extend in such a manner as to result in localized stiffness. There shall be no spots or stains resulting from the cementing operation. The cemented areas shall not contain any trapped air, channels, edge lifts, or excessive wrinkling.

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PAGE 5

- 3.4.4 Delete last sentence in its entirety.
- 3.4.5 Line 7, Delete "2. inches" and substitute "3 inches".
- 3.7.4 Delete all references to Directive Compliance Patch and 67A319C17.

PAGE 7

- 3.8.4 Delete "5.25 pounds" and substitute "5.50 pounds".

PAGE 9

- 4.3.1 Line 4, Delete "4044" and substitute "6031".
- 4.3.1 Delete second sentence in its entirety.

PAGE 11

- 4.4.3 Delete the first sentence in its entirety and substitute the following:

"Upon completion of the first article inspection program, recommendations and comments pertinent for use in monitoring production, will be forwarded by the Government activity responsible for the inspection program (see 6.2(d)), to the Contracting Officer."

PAGE 13

- 4.5.1.3 Delete in its entirety and substitute the following:

"4.5.1.3 Sampling for Tests and Examinations of the Life Rafts at a Laboratory. Upon completion of the tests and examinations specified in 4.5.1.2, a random sample shall be selected from each lot in accordance with MIL-STD-105, Inspection Level S-3, (see 6.2(j)). The sample size shall be based only on the applicable sample size code letter corresponding to the Inspection Level S-3. Each life raft selected as a sample unit shall be identified by its assigned serial number (see 6.2(e)) and shall be forwarded to the Government Laboratory specified in the Procurement document (see 6.2(f)) for the following tests and examinations (listed sequence mandatory):

TESTS AND EXAMINATIONS

Weight	(3.8.4 and 4.7.5)
Operations	(3.8.1 and 4.7.2)
Leakage	(3.8.3 and 4.7.4)
Visual Examination of Life Rafts	(4.7.1.1)
Dimensional Check of Life Rafts	(4.7.1.1)

The serial number of the units in the lot, represented by the sample units, shall be furnished to the Government laboratory. The initial costs of tests and examinations will be borne by the Government, however, the costs of the tests and examinations of sample units resubmitted from a reworked lot, or from a new lot which may be necessitated by the rejection of a previous lot, shall be borne by the contractor. Sample units from a rejected lot shall not be resubmitted for tests and examinations without the approval of the contracting officer. Upon completion of testing, the sample units will be returned to the contractor, at the contractor's expense. The Government activity responsible for conducting the inspection program (see 6.2F) shall report the results of tests and examinations to the designated inspection and acceptance office specified in the procurement document. Final acceptance of the lot from which the sample units were selected shall be based upon successful completion of the inspection program by the cognizant Government Quality Assurance Representative/Specialist; applying the applicable acceptance criteria specified in Table II."

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Table III: Delete item 10 in its entirety and substitute the following:

"10. Any channels or voids in any cementing operation. 1/

PAGE 16

Table III, Classification of Defects for the Visual Examination of the Life Rafts

Add the following defect under the Minor category:

216. Excessive wrinkling in any cementing operation.

PAGE 20

5.2.1 Line 1, Delete "5.3.2" and substitute "5.2.2".

PAGE 21

6.2d Add after (see 4.4.1) "and the Government Activity responsible for conducting the inspection program (see 4.4.3)."

PAGE 22

6.3 Lines 12 and 14, Delete "4044" and substitute "6031". Add to end of paragraph "(see 4.3.1)."

Preparing Activity  
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