

MIL-P-1691G
30 June 1988
SUPERSEDING
MIL-P-1691F
30 June 1982

MILITARY SPECIFICATION

POCKET, AMMUNITION MAGAZINE, 2 CLIPS, .45 CAL.
AUTOMATIC PISTOL, LEATHER

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

1. SCOPE

1.1 Scope. This document covers a leather pocket for ammunition magazines.

1.2 Classification. The pocket shall be one type in the following classes as specified (see 6.2):

Class 1 - With bright brass finished hardware.
Class 2 - With bright chrome finished hardware.

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-1249 - Paper, Wrapping, Tissue
V-T-285 - Thread, Polyester

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 8465

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

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- FF-R-556 - Rivet, Solid, Small; Rivet, Split, Small; Rivet, Tubular, Small; Flat Washer (Burr); and Cap, Rivet; General Purpose
- KK-L-271 - Leather, Cattlehide, Strap, Vegetable Tanned
- QQ-C-320 - Chromium Plating (Electrodeposited)
- QQ-N-290 - Nickel Plating (Electrodeposited)
- PPP-B-566 - Boxes, Folding, Paperboard
- PPP-B-636 - Boxes, Shipping, Fiberboard
- PPP-B-676 - Boxes, Setup
- PPP-T-45 - Tape, Gummed, Paper, Reinforced and Plain, for Sealing and Securing

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- MIL-S-1733 - Support, Snap Fastener
- MIL-F-10884 - Fasteners, Snap
- MIL-L-35078 - Loads, Unit: Preparation of Semiperishable Subsistence Items; Clothing, Personal Equipment and Equipage: General Specification For

STANDARDS

FEDERAL

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

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-51936 - Washer, Flat (Burr)

(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.

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DRAWING

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

2-4-5 - Pocket, Ammunition Magazine, 2 Clips, .45 Cal.,
Automatic Pistol, Leather; Assembly, 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.

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

D 3951 - Standard Practice for Commercial Packaging

(Copies should be obtained from the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103-1187.)

(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 (see 6.5).

- * 3.2.1 Leather. The strap leather shall be 6/64 inch thick conforming to type I, II, III, or IV, class 1 of KK-L-271, except that the thickness tolerances shall be plus 1/64, minus 1/128 inch and the requirement for elongation shall be 30 percent maximum. The grain side of the leather shall

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be dyed and smooth finished. Embossing or printing shall not be permitted. The color of the grain surface shall be Black 111 matching the standard sample (see 6.3). The color of the flesh side shall be natural.

- * 3.2.2 Thread, polyester. The polyester thread for all stitching shall conform to type I, class 1, subclass A, size 3 of V-T-285. The thread shall be black and shall show fastness to perspiration equal to or better than the standard sample. When no standard sample is available, the thread shall show good fastness to perspiration.

3.2.3 Sealer. For finishing the edges of the leather, a colorless aqueous solution of a sealer shall be used. Gum tragacanth has been found suitable for this purpose.

3.2.4 Support, snap fastener. The snap fastener support shall be fabricated from half hard brass and shall conform to class 1 of MIL-S-1733. The snap fastener support for the class 1 pocket shall be given a bright brass finish followed by a coating of lacquer. The snap fastener support for the class 2 pocket shall be given a bright chrome plating conforming to class 1, grade G of QQ-C-320 with a nickel undercoating conforming to class 1, grade G of QQ-N-290.

3.2.5 Fastener, snap. The snap fastener shall conform to style 1 of MIL-F-10884. The female components shall consist of a long prong socket and a clinch plate. The male components shall be an (option c) eyelet base and a size 1 stud, without washer. The snap fastener finish for the class 1 pocket shall conform to finish 1 of MIL-F-10884 followed by a coating of lacquer. The snap fastener finish for the class 2 pocket shall conform to finish 4 of MIL-F-10884. Clinch plates for class 1 and 2 pockets may be furnished conforming to finish 2 of MIL-F-10884.

3.2.6 Rivets, belt and burrs. The rivets shall be sizes No. 10 and 12 conforming to type 1, class 2, grade A or F of FF-R-556. The burrs shall be size 10 conforming to MS-51936. Burrs shall be the same metal as rivets. The rivets and burrs shall be given a black chemical finish. The length of the rivet shall be determined by the contractor and shall effect a secure clinch of the assembled components.

3.3 Construction. The construction shall conform in all respects to Drawing 2-4-5 and as specified herein.

- * 3.3.1 Stitches, seams and stitchings. All stitching shall conform to stitch type 301 of FED-STD-751, with 5 to 7 stitches per inch and a 1/8 inch stitching margin. Stitching shall be in regular lines. Thread tension shall be maintained so that there will be no loose or tight stitching and that the lock will be embedded in the materials sewed. All thread ends shall be securely tied and fused.

3.3.1.1 Repairs of type 301 stitching. Repairs of 301 stitching shall be as follows:

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a. When thread breaks or bobbin run-outs occur during sewing, the stitching shall be repaired by restarting the stitching one stitch in back of the end of stitching.

b. Thread breaks or two or more consecutive skipped or run-off stitches noted during inspection of the item (in-process or end item) shall be repaired by overstitching. The stitching shall start one stitch in back of the defective area, continue over the defective area and continue one stitch beyond the defective area onto the existing stitching. (When making the above repairs in a. and b. above, the ends of the stitching are not required to be backstitched.)

3.3.2 Setting of snap fastener and rivet. A hole shall be prepunched through the leather before inserting snap fastener parts. The hole shall be smaller than the outside diameter of the fastener tube so that the tube must be forced through the hole. The fastener shall be securely clinched. The rivet shall be securely clinched. The roll of the clinched eyelet of the assembled fastener component shall not possess more than two scores (splits).

3.3.3 Replacement of defective components. During the cutting and manufacturing process, components of the pocket having material defects or damages that are classified as defects in 4.4.3 shall be removed from production and replaced with nondefective and properly matched components.

* 3.4 Marking. The contract number and the "US" marking shall be indented in the leather. The markings shall be in the size characters and in the locations shown on the drawing.

3.5 Workmanship. The finished pockets shall conform to the quality of product established by this document and 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 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

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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.

- * 4.1.2 Responsibility for dimensional requirements. Unless otherwise specified in the contract or purchase order, the contractor is responsible for assuring that all specified dimensions have been met. When dimensions cannot be examined on the end item, inspection shall be made at any point or at all points in the manufacturing process necessary to assure compliance with all dimensional requirements.

4.1.3 Certificates of compliance. When certificates of compliance are submitted, the Government reserves the right to inspect such items to determine the validity of the certification.

- * 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 and 4.4.4. 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.

4.4.1.1 Certification. The contractor shall furnish a certificate of compliance certifying that the sealer used conforms to the requirements specified in 3.2.3.

4.4.2 In-process inspection. Inspection shall be conducted to determine whether prepunching of holes for snap fastener parts is being performed in accordance with 3.3.2. The Government reserves the right to exclude from consideration for acceptance any material or service for which in-process inspection has indicated nonconformance.

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 one pocket. The sample unit shall be one pocket. The inspection level shall be II and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 2.5 for major defects and 6.5 for total (major and minor combined) defects.

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NOTE: Appearance defects shall be scored only when the condition is plainly visible at a distance of 3 feet or more.

Defects designated by an asterisk shall be scored as major when seriously affecting serviceability or appearance and minor when affecting serviceability or appearance but not seriously.

TABLE I. End item visual defects

Examine	Defect	Classification	
		Major	Minor
Leather	Not specified color	X	
	Color not uniform		*
	Leather embossed or printed	X	
	Any leather part refinished after assembly		*
	Grain side not smooth finished	X	
	Any operation omitted or not properly performed		*
	Any component misplaced		*
	Needle holes or needle chews		*
	Any hole (except needle hole), cut, or rupture	X	
	Brand mark, healed grub damage, scar tissue, hip mark, or brittle or bony area		*
	Abraded, scratched, or other grain damage		*
	Flanky, spongy, pipey, or stretchy leather		*
	Fat wrinkles		*
	Slaughter cut		*
	Flesh side not smooth or contains loose flesh		X
Hardware, general	Finish omitted (all or in part), not specified color	X	
	Coating flaked or blistered		X
Component and assembly	Any component or assembly omitted or misplaced, operation omitted or not properly performed (i.e., adjustment hole or holes omitted; fastener misplaced so that male portion of fastener is not in alignment with female portion to effect closure)		*

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TABLE I. End item visual defects (cont'd)

Examine	Defect	Classification	
		Major	Minor
Component and assembly (cont'd)	Burr, sharp edge, or metal sliver	X	
	Machine or die mark affecting appearance		X
	Any part defective, damaged, fractured, ripped, punctured, torn, or malformed	*	
	Pocket not fabricated with grain side of leather on exterior side of pocket	X	
Snap fastener	Fastener not functioning properly, i.e., fails to snap closed to provide a secure closure or fails to open freely	X	
NOTE: a. Incomplete roll of the end of the socket eyelet tube and or of stud eyelet tube is evidence of improper and insecure clinching. Fasteners evidencing incomplete roll will separate in use.			
b. The fastener shall be snapped and unsnapped twice to determine whether parts of fastener separate freely and also effect a secure closure.			
	Clinched excessively tight, cutting surrounding material		*
	Clinched loosely, permitting components to rotate freely in the hole in the material		*
	Roll of clinched eyelet fastener assembly contains more than two scores (splits)		X
Rivet	Not properly peened	X	
Thread	Not the specified color	X	

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TABLE I. End item visual defects (cont'd)

Examine	Defect	Classification	
		Major	Minor
Stitching:			
Open seam	Any open seam not repaired	X	
	Repair of open seam not as specified		X
	NOTE: A seam shall be classified as open when one or more stitches joining a seam are broken or when two or more consecutive skipped or run-off stitches occur.		
Run-off (see open seam)			
Seam and stitch type	Wrong seam or stitch type	X	
Stitch tension	Loose, resulting in a loosely secured seam; tight, resulting in tightness of seam	X	
Stitches per inch	One stitch less than minimum specified		X
	Two or more stitches less than minimum specified	X	
	One or more stitches in excess of maximum specified		*
Margin or gage	Stitching margin or gage not as specified or irregular		*
Thread ends	Not tied, not fused		X
Marking	Omitted, illegible, incorrect, misplaced or not as specified		X
Cleanness	Any nonremovable stain or spot	X	
	Any spot or stain removable with cleaning agent		X

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- * 4.4.4 End item dimensional examination. The end item shall be examined for the dimensions annotated with an asterisk on Drawing 2-4-5. Any measurement deviating from the specified dimension shall be classified as a defect. The lot size shall be expressed in units of one pocket. The sample unit shall be one pocket. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 4.0.

4.4.5 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 with the exception that it need not be closed. 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 intermediate containers is more or less than specified Number of pockets per intermediate container is more or less than specified <u>1/</u>

1/ For this defect, two intermediate containers shall be examined.

- * 4.4.6 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

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<u>Examine</u>	<u>Defect</u>
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 pocket, with the flap snap fastened in place, shall be completely wrapped with not less than two thicknesses of tissue paper conforming to type I of A-A-1249. Ten wrapped pockets of one class only shall be packed on edge ten in length, alternately reversed in twos with the fronts of each pair facing each other, within an intermediate folding or setup paperboard box. The folding paperboard box shall conform to variety 1, style III, type G, class i, group I of PPP-B-566. The setup paperboard box shall conform to type I, variety 1, class A, style 3 or 4 of PPP-B-676. Thumb notch requirements are optional. Inside dimensions of each paperboard box shall be 10-1/2 inches in length, 5-1/2 inches in width, and 4-1/2 inches in depth. Box closure shall be secured with 2 inch minimum width gummed paper tape conforming to type III, grade A of PPP-T-45, applied at the center of the length opening and extending along the bottom and up the sides a minimum of 2 inches.
- * 5.1.2 Commercial. Pockets 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. One hundred and eighty pockets of one class only, preserved as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC, grade V2s of PPP-B-636. Level A intermediate packs shall be packed flat two in length, three in width, and three in depth within a shipping container. Inside dimensions of each shipping container shall be approximately 21-3/4 inches in length, 17-1/4 inches in width, and 13-3/4 inches in depth. Approximate dimensions are furnished as a guide only. Each container shall be closed in accordance with method III, waterproofed in accordance with method V, and reinforced as specified in the appendix of PPP-B-636, except that the inspection shall be in accordance with 4.4.5. 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). When unit loads are strapped, strapping shall be limited to nonmetallic strapping, except for type II, class F loads.

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5.2.2 Level B packing. One hundred and eighty pockets of one class only, preserved as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC, type CF (variety SW) or SF, class domestic, grade 275 of PPP-B-636. Level A intermediate packs shall be packed flat two in length, three in width, and three in depth within a shipping container. Inside dimensions of each shipping container shall be approximately 21-3/4 inches in length, 17-1/4 inches in width, and 13-3/4 inches in depth. Approximate dimensions are furnished as a guide only. Each 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 4.4.5.

5.2.2.1 Weather-resistant fiberboard containers. When specified (see 6.2), shipping containers shall be 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 4.4.5.

- * 5.2.3 Commercial packing. Pockets, preserved as specified in 5.1, shall be packed in accordance with ASTM D 3951.
- * 5.3 Palletization. When specified (see 6.2), pockets, 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 means O or P. Pallet pattern shall be number 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, intermediate packs, shipping containers, and palletized unit loads shall be marked in accordance with MIL-STD-129 or ASTM D 3951, as applicable.

6. NOTES

6.1 Intended use. The ammunition magazine pockets, worn with a leather belt, are intended for use by members of the Military Police of the U.S. Army (class 1) and the Air Force (class 2). The pockets are designed to hold two magazines used with the .45 caliber automatic pistol.

6.2 Ordering data. Acquisition documents should specify the following:

- a. Title, number, and date of this document.
- b. Class required (see 1.2).
- c. When a first article sample is required (see 3.1, 4.3, and 6.4).
- d. Selection of applicable levels of preservation and packing (see 5.1 and 5.2).
- e. Type and class of unit load required (see 5.2.1).

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- 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, 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.

Belt, leather
 Pocket ammunition magazine
 Pocket, leather
 Uniform, military police

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.

Custodians:

Army - GL
 Air Force - 99

Preparing activity:

Army - GL

Project No. 8465-0986

Review activities:

Army - MD
 Air Force - 82
 DLA - CT

User activity:

Air Force - 45

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.

NOTE: This form may not be used to request copies of documents, nor to request waivers, deviations, or clarification of specification requirements on current contracts. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements.

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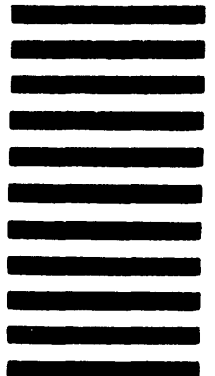


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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

1. DOCUMENT NUMBER MIL-P-1691G		2. DOCUMENT TITLE Pocket Ammunition Magazine, 2 Clips, .45 Cal. Automatic Pistol, Leather	
3a. NAME OF SUBMITTING ORGANIZATION		4. TYPE OF ORGANIZATION (Mark one)	
		<input type="checkbox"/> VENDOR <input type="checkbox"/> USER <input type="checkbox"/> MANUFACTURER <input type="checkbox"/> OTHER (Specify): _____	
b. 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		b. WORK TELEPHONE NUMBER (Include Area Code) - Optional	
c. MAILING ADDRESS (Street, City, State, ZIP Code) - Optional		8. DATE OF SUBMISSION (YYMMDD)	