

INCH-POUND

MIL-P-2018H
14 August 1989
SUPERSEDING
MIL-P-2018G
26 March 1985

MILITARY SPECIFICATION

PAINT, FACE, CAMOUFLAGE; COMPACT-TYPE CONTAINER

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

1. SCOPE

1.1 Scope. This specification covers a compact-type container with separate compartments containing loam, green, sand, and white colors of camouflage face paint. The paint has infrared properties similar to that of the battle dress uniform (see 6.1).

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 document to the extent specified herein. Unless otherwise specified, the issues of these documents are those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

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 and Development 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 6850

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

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SPECIFICATIONS

FEDERAL

PPP-B-636 - Boxes, Shipping, Fiberboard

MILITARY

MIL-L-35078 - Load Unit Preparation of Semiperishable Subsistence Items Clothing Personal Equipment and Equipage General Specification For

STANDARDS

FEDERAL

FED-STD-313 - Material Safety Data Sheets, Preparation and the Submission of

FED-STD-595 - Colors

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

(Unless otherwise indicated, copies of Federal and Military specifications, standards, and handbooks are available from the Naval Publications and Forms Center, (ATTN: NPODS), 5801 Tabor Ave., Philadelphia, PA 19120-5099).

2.1.2 Other Government documents, drawings, and publications. The following other Government documents, drawings, and publications form a part of this document to the extent specified herein. Unless otherwise specified, the issues are those cited in the solicitation.

U.S. DEPARTMENT OF HEALTH AND HUMAN SERVICES

Federal Food, Drug, and Cosmetic Act and regulations promulgated thereunder

(Copies are available from the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402.)

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DRAWINGS

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

8-2-831 - Paint, Face, Camouflage, Compact-Type Container

(Copies are available from the U.S. Army Natick Research, Development, and Engineering Center, Natick, MA 01760-5014.)

2.2 Non-Government publications. The following documents form a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DOD adopted are those listed in the issue of the DODISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of the documents cited in the solicitation (see 6.2).

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.)

U.S. PHARMACOPEIAL CONVENTION (USP)

Pharmacopeial of the United States

(Application for copies should be addressed to the U.S. Pharmacopeial Convention, 12601 Twinbrook Parkway, Rockville, MD 20852.)

(Non-Government standards and other publications are normally available from the organizations that prepare or 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 document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 First article. When specified (see 6.2), a sample shall be subjected to first article inspection (see 6.3) in accordance with 4.3.

3.2 Material. The ingredients used in the formulation of the face paint shall be as specified herein. Submission of a Material Safety Data Sheet is mandatory for stock classes in FED-STD-313.

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3.2.1 Ceresine wax. Ceresine wax 101 shall have a melting point of 154° to 165°F.

3.2.1.1 Hydrogenated castor oil. Hydrogenated castor oil shall conform to National Formulary of the Pharmacopeial of the United States and have a melting point of 178° to 182°F USP.

3.2.2 Mineral oil. Mineral oil shall conform to Mineral Oil, heavy viscosity, saybolt viscosity 335/365 at 37.8°C (100°F), USP.

3.2.3 Talc. Talc shall conform to Talc USP, except that all shall pass through a U.S. No. 325 mesh sieve.

3.2.4 Color mixture. The required color shall be obtained by use of pigments only. The color mixture shall conform in every respect to the Federal Food, Drug, and Cosmetic Act and regulations promulgated thereunder.

3.3 Composition. The formulation submitted by the contractor shall conform to the material and general composition requirements specified in table I (see 6.4). There shall be no carbon black used in the formulation.

TABLE I. Paint composition

Ingredients	Parts by weight			
	Loam	Green	Sand	White
Ceresine wax	20.0 ± 0.2	20.0 ± 0.2	21.1 ± 0.2	21.0 ± 0.2
Castor wax	4.0 ± 0.2	4.0 ± 0.2	4.0 ± 0.2	4.0 ± 0.2
Mineral oil, heavy visc.	38.0 ± 0.2	37.0 ± 0.2	38.2 ± 0.2	38.2 ± 0.2
Talc	10.0 ± 0.2	10.2 ± 0.2	10.5 ± 0.2	8.4 ± 0.2
Cosmetic yellow <u>1/</u>	4.0 ± 0.2	5.1 ± 0.2	3.0 ± 0.2	---
Cosmetic green (hydrous) <u>1/</u>	10.0 ± 0.21	---	2.1 ± 0.2	---
Cosmetic black <u>1/</u>	4.0 ± 0.2	---	0.3 ± 0.2	---
Cosmetic green (anhydrous) <u>1/</u>	---	15.3 ± 0.2	---	---

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TABLE I. Paint composition (cont'd)

Ingredients	Parts by weight			
	Loam	Green	Sand	White
Titanium dioxide (atlas white) <u>1/</u>	6.0 ± 0.2	6.2 ± 0.2	20.1 ± 0.2	28.4 ± 0.2
Cosmetic burnt sienna <u>1/</u>	4.0 ± 0.2	2.0 ± 0.2	0.7 ± 0.2	---

1/ The pigments shall be refined and of a cosmetic quality to conform to H. Kohnstamm color numbers or equal (see 6.4.1). These commercial numbers contain IR properties commensurate to the Battle Dress Uniforms.

3.4 Softness. The finished face paint shall spread easily with the fingers. However, in its compartment in the container, the face paint shall remain moderately firm at a temperature of 70°F to 90°F and not flow.

3.5 Color and uniformity. When tested as specified in 4.4.4, the color of the face paint shall be uniform and lusterless and shall match the following colors:

<u>Color</u>	<u>Number</u>	<u>Document reference</u>
Green	34151	FED-STD-595
Loam	34086	FED-STD-595
Sand	30277	FED-STD-595
White	37875	FED-STD-595

3.6 Odor. The face paint shall be nearly odorless with no indication of rancidity.

3.7 Form. The face paint shall be furnished in a flat homo-polymer, polypropylene, dull-matte finish (inside and outside), compact-type container having a separate section for each color of paint. Each individual face paint in the container shall have not more than one hole or void greater than 1/8 inch in diameter when tested as specified in 4.4.4.

3.8 Container, compact-type. The dimensions of the container shall be as specified on Drawing 8-2-831. Each color of the face paint shall be located in a separate compartment of the container as shown on the drawing. The container shall be formed of homo-polymer polypropylene material, Olive Drab shade No. 24087 of FED-STD-595, gloss to be not over 45. The inside of the cover shall contain a acrylic mirror, mechanically affixed to the container (snap-on) having 0.060 inch thickness with a tolerance of ± 0.005 inches. The cover of the

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container shall be attached to the base throughout by a "living hinge" of the same composition as the container itself. The cover of the container shall be opened or closed with only a reasonable amount of effort and with a minimum amount of noise. The polypropylene container shall have rounded edges and it shall satisfactorily withstand temperatures of -20°F to 150°F without distortion or deterioration over a maximum shelf life period of 10 years, under these conditions. The cover shall be snug-fitting on all sides.

3.9 Labeling. Each container shall be legibly and neatly labeled on the top side with the legend shown on Drawing 8-2-831. The legend shall be in lithographed neatly and legibly with printed black ink characters, or it shall be molded. The label shall show no softening, smudging, removal, or illegibility when tested as specified in 4.4.4.

National Stock Number
Nomenclature
Specification Number
Name of Manufacturer of Supplier
Date of Manufacture

NOTICE

Apply with finger to dry skin
CAUTION - Avoid contact with eyes

3.10 Performance. The finished face paint shall be easy to apply and spread and shall produce an opaque, uniform-colored coating covering the skin. The face paint covering the skin shall not wash off when tested as specified in 4.4.4.

3.11 Workmanship. The finished face paint shall be clean, smooth, and uniform and shall fill each compartment without overflowing or overlapping into the next one. The paint should not separate from the walls of the container during normal use or storage.

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 (examinations and tests) 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 specification where such inspections are deemed necessary to ensure supplies and services conform to prescribed requirements.

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4.1.1 Responsibility for compliance. All items shall meet all requirements of sections 3 and 5. The inspection set forth in this specification shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the contractor of the responsibility of ensuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations, is an acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to accept defective material.

4.1.2 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 3.1 and 6.2), it shall be examined for the defects specified in 4.4.2 and 4.4.3 and tested as specified in 4.4.4.

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 specification or applicable purchase document.

4.4.1.1 Certification. A certificate of compliance may be acceptable as evidence that the materials and paint compositions conform to the requirements specified in 3.2.1 through 3.3.

4.4.2 End item visual examination. The end items shall be examined for defects listed in table II. The lot size shall be expressed in units of one paint container. The sample unit shall be one paint container. The inspection level shall be I (see 6.5).

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TABLE II. End item visual defects

Examine	Defect	Classification	
		Major	Minor
Compact type container:			
Construction	Not as specified.	101	
	Cover not snug-fitting; not readily opened with fingers.		201
Finish	Not as specified.		202
Label	Omitted, illegible, incorrect or incomplete.	102	
	Not in black ink.		203
Face paint	Each paint color not located in separate compartment.	103	
Workmanship	Not clean, not smooth; not homogeneous.		204
	NOTE: When the shade of the paint is examined and the surface is slightly smeared with the shade of the other paints, this smear shall not be considered a defect.		
	Any portion of a paint falls from the container.		205
	Paint breaks when pressed with fingers.		206
	Paint is loose in container.		207
	Container does not contain the four specified colors of paint.	104	
	Odor stronger than nearly odorless; rancid.	105	

4.4.3 End item dimensional examination. The end items shall be examined for conformance to the dimensions specified on the drawing. Only those dimensions that can be evaluated without damaging or disassembling the end items shall be examined. Any dimension not within the specified tolerance shall be classified as a defect. The lot size shall be expressed in units of paint containers. The sample unit shall be one paint container. The inspection level shall be S-3 (see 6.5).

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4.4.4 End item testing. The end items shall be tested for the characteristics indicated in table III. The sample unit shall be one compact-type container with paints. The sample size shall be five sample units selected at random from the lot. Any test failure shall be cause for rejection of the lot.

TABLE III. End item tests

Characteristic	Requirement paragraph	Test method
Color matching	3.5	4.5.1
Color uniformity	3.5	4.5.2
Presence of holes	3.7	4.5.3
Label fastness	3.9	4.5.4
Paint performance	3.10	4.5.5

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. The inspection level shall be S-2 (see 6.5).

<u>Examine</u>	<u>Defects</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 paint containers per shipping container is more or less than specified

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 packed. The inspection level shall be S-1 (see 6.5).

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<u>Examine</u>	<u>Defect</u>
Finished dimensions	Length, width, or height exceeds specified maximum requirement.
Palletization	Pallet pattern 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.

4.5 Methods of inspection.

4.5.1 Color matching test. Remove each of the face paints from its compartment. Rub each of the face paints on a piece of soft white paper until a solid area of color at least 1 inch square is obtained. Compare each rubout with the applicable standard color chip in FED-STD-595. Any failure to match a color chip shall be a test failure.

4.5.2 Color uniformity test. Cut each of the face paints lengthwise in such a manner as to obtain a clean cut and examine the cut surfaces. Any evidence of color specks, segregation, or streaks shall be a test failure.

4.5.3 Presence of holes test. Examine each of the cut face paints (see 4.5.2) for holes and voids. The presence of two or more holes or voids larger than 1/8 inch in diameter shall be a test failure.

4.5.4 Label fastness test. An area of approximately 1 square inch of the container exterior shall be covered with a full hiding layer of the face paint and allowed to stand thus for 24 hours at room temperature (70°F to 80°F). The test area shall include some of the printed matter. At the end of this time, the face paint shall be wiped off the test area of the container with the aid of facial tissue. The test area of printing shall be examined by comparison with adjacent unexposed areas for evidence of smudging, removal, or other effect. Any evidence of smudging or removal of the printed matter shall be a test failure.

4.5.5 Performance test. Condition each color of face paint at a temperature between 70° to 80°F for at least 1 hour. Under the same conditions, apply the face paint over an area of 1 by 2 inches of previously dried skin on the back of the hand. Ease of application shall be defined by whether or not the paint readily transfers from cake to skin without requiring repeated application to the same area to obtain an opaque coating. Rub the painted area with finger to define whether or not the paint will spread and form a uniform coating covering the skin. Immerse the painted area in water (75° to 80°F) for a period of 1

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minute. With the area immersed in water and using moderate pressure, rub the area with the fingers of the other hand for 1 minute. Observe if face paint is washed off. A transfer of some face paint to the fingers is acceptable. Any failure to conform to the requirements in 3.10 shall be a test failure.

5. PACKAGING

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

5.1.1 Level A packing. Two hundred compact-type containers of face paint (see 3.8) shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC-L, grade V2s of PPP-B-636. The inside of each shipping container shall be fitted with a box liner and top and bottom pads conforming to type CF, class weather-resistant, variety DW, grade V15c of PPP-B-636. Kraft paper shall be placed between each layer of paint containers. Inside dimensions of the shipping container shall be approximately 15-1/4 inches in length, 12-3/4 inches in width, and 5-1/2 inches in depth. Each shipping container shall be closed, waterproofed, and reinforced with strapping or tape banding in accordance with the appendix of PPP-B-636. 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.

5.1.2 Level B packing. Two hundred compact-type containers of face paint (see 3.8) shall be packed in a snug-fitting 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 shipping container shall be fitted with box liner and top and bottom pads conforming to type CF, class domestic, variety DW, grade 275 of PPP-B-636. Kraft paper shall be placed between each layer of paint containers. Inside dimensions of the shipping container shall be approximately 15-1/4 inches in length, 12-3/4 inches in width, and 5-1/2 inches in depth. Each shipping container shall be closed in accordance with method II as specified in the appendix of PPP-B-636.

5.1.2.1 Weather-resistant shipping container. When specified (see 6.2), the shipping container shall be a grade V3c, V3s, or V4s fiberboard box fabricated in accordance with PPP-B-636 and closed in accordance with the appendix of PPP-B-636.

5.1.3 Commercial packing. Compact type containers shall be packed in accordance with ASTM D 3951.

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5.2 Palletization. When specified (see 6.2), end items packed, as specified in 5.1.2 and 5.1.3, shall be palletized on a 4-way entry pallet in accordance with load type Ia of MIL-STD-147. Pallet types 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 C and D or film bonding means F or G. Pallet pattern shall be number 96 in accordance with the appendix of MIL-STD-147.

5.3 Marking. In addition to any special marking requirements specified by the contract or purchase order, shipping containers, and palletized unit loads shall be marked in accordance with MIL-STD-129 or ASTM D 3951, as applicable.

6. NOTES

(This section contains information of a general or explanatory nature that may be helpful but is not mandatory.)

6.1 Intended use. The face paint is intended for use on exposed parts of the skin, i.e., face, back of neck and hands, to color them for camouflage purposes. The following color combinations are recommended for the indicated terrains:

- Green and loam - For grass or foliage covered areas.
- Green and sand - For desert areas.
- White and loam - For snow covered areas.

6.2 Acquisition requirements. Acquisition documents must specify the following:

- a. Title, number, and date of this specification.
- b. Issue of DODISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.1.1 and 2.2).
- c. When a first article is required (see 3.1, 4.3 and 6.3).
- d. Level packing (see 5.1).
- e. Type and class of unit load (see 5.1.1).
- f. When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.1.2.1).
- g. When palletization is required (see 5.2).
- h. Acceptance criteria required (see 6.5).

6.3 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 also include specific instructions in acquisition documents regarding arrangements for selection, inspection, and approval of the first article.

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6.4 Wax-oil composition. In table I composition, the amount of ceresine wax and mineral oil may be varied over a range of 6 parts by weight to obtain the required softness. This is necessary because of the differences in the oil absorption of the various color pigments.

6.4.1 H. Kohnstamm color numbers. H. Kohnstamm color numbers are pigments manufactured by H. Kohnstamm & Company, Inc. that have been approved by FDA and the Office of the Surgeon General to be used for the paint, face formulations.

6.5 Acceptance criteria. The acceptance criteria below are recommended for use. The acceptance criteria as specified in the contract or purchase order shall be binding. Unless otherwise indicated, the following acceptance criteria are in accordance with MIL-STD-105.

6.5.1 For end item visual examination. An acceptable quality level (AQL), expressed in terms of defects per hundred units, of 1.5 for major defects and 6.5 for total (major and minor combined) defects is recommended.

6.5.2 For end item dimensional examination. An AQL, expressed in terms of defects per hundred units, of 2.5 is recommended.

6.5.3 For packaging examination. An AQL, expressed in terms of defects per hundred units, of 2.5 is recommended.

6.5.4 For palletization examination. An AQL, expressed in terms of defects per hundred units, of 6.5 is recommended.

6.6 Subject term (key word) listing.

Battle dress uniform
Infrared

6.7 Changes from previous issue. Due to extensive changes from the previous issue, asterisks were not used to indicate changes made in this document.

Custodians:

Army - GL
Navy - MC
Air Force - 68

Preparing activity:

Army - GL
(Project 6850-1026)

Review activities:

Army - MD
DLA - GS
DPSC - RSTH - 25

User activity:

Navy - MS

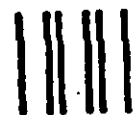
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NOTE: This form may not be used to request copies of documents, nor to request waivers, deviations, or clarification of specification requirements on current contracts. Comments submitted on this form do not constitute or imply authorization to waive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

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and ENGINEERING CENTER
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Natick, MA 01760-5014



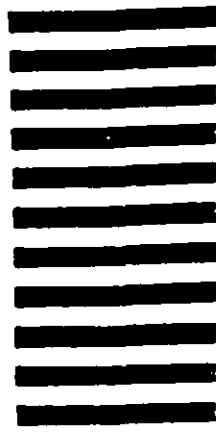
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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

1. DOCUMENT NUMBER
MIL-P-2018H2. DOCUMENT TITLE
Paint, Face, Camouflage; Compact-Type Container

3a. NAME OF SUBMITTING ORGANIZATION

4. TYPE OF ORGANIZATION (Mark one)

 VENDOR USER MANUFACTURER 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)