MIL-P-2343F

3 November 1973

SUPERSEDING
MIL-P-2343E
29 July 1969

# MILITARY SPECIFICATION

## POCKET, AMMUNITION MAGAZINE, ENLISTED MEN'S, M-1923

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

## 1. SCOPE

1.1 This specification covers a two-compartment pocket, in one type and size, made of olive drab cotton webbing and designed to accomodate one 7-roun magazine for the .45 caliber automatic pistol in each of the two compartments

## 2. APPLICABLE DOCUMENTS

* 2.1 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. |
| FF-R-556 | - | Rivet, Solid, Small; Rivet, Split, Small; Rivet, Tubular, Small; Burr; and Cap, Rivet; General Purp |
| UU-P-268 | - | Paper, Kraft, Untreated, Wrapping. |
| DDD-L-20 | - | Label; For Clothing, Equipage, and Tentage, (Genera Use). |
| PPP-B-636 | - | Boxes, Shipping, Fiberboard. |

MILITARY

| | | |
|---|---|---|
| MIL-W-530 | - | Webbing, Textile, Cotton, General Purpose, Natural or in Colors. |
| MIL-S-1733 | - | Support, Snap Fastener. |
| MIL-H-9890 | - | Hardware, Individual Load Carrying Equipment: And Hardware, Miscellaneous. |
| MIL-F-10884 | - | Fasteners, Snap. |

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 For 40" x 48" Pallets.

DRAWING

ARMY NATICK LABORATORIES

2-4-42 - Pocket, Ammunition Magazine, Enlisted Men's, M-1923

(Figure 1 is a miniature reproduction of referenced drawing and is attached for information only).

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

2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless a specific issue is identified, the issue 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., Tariff Order Section, 1616 P Street, N.W., Washington, DC 20036.)

Uniform Classification Committee, Agent

Uniform Freight Classification

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

3. REQUIREMENTS

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

* 3.2 First article. When specified (see 6.2), the supplier shall furnish a sample for first article inspection and approval (see 4.3, and 6.4).

3.3 Materials.

3.3.1 Webbing, cotton. The cotton webbing shall be Olive Drab 7 conforming to type II, class 4, 3-3/4 inch width and type IIb, class 4, 2-1/4 inch width of MIL-W-530.

3.3.2 Thread, polyester. The polyester thread shall conform to type I, class 1, sub-class b, size FF of V-T-285.

* 3.3.2.1 Color. The thread shall be dyed Olive Drab S-1, C.A. 66022 and shall show fastness to weathering equal to or better than the standard sample.

* 3.3.3 Fastener, snap. The snap fastener shall conform to style I, finish 2 of MIL-F-10884. The female component shall be regular pronged with clinch plate and the male component shall be stud eyelet base, size 1, excep the washer is not required.

3.3.4 Rivet, tubular. The tubular rivets shall be .123 inch nominal size, conforming to type XII, class 3, grade F of FF-R-556, except that the head diameter shall be nominal .313 inch. The rivets shall be given a black chemical finish. The length shall be such as to provide a secure clin of the assembled components.

3.3.5 Keeper, with slide. The keeper with slide shall conform to type X of MIL-H-9890.

* 3.3.6 Support, fastener. The fastener support shall conform to class 1, finish B of MIL-S-1733.

3.4 Construction. The construction shall conform in all respects to Drawing 2-4-42 and as specified herein.

* 3.4.1 Stitching, machine. All stitching shall conform to FED-STD-751, type 301, with 8 to 10 stitches per inch. Ends of all stitching shall be backstitched or overstitched 1/2 inch minimum except where ends are held down by other stitching. Thread tension shall be maintained so that there will be no loose stitching resulting in loose bobbin or top thread, or excessively tight stitching resulting in puckering of the materials sewn. The lock shall be embedded in the materials sewn.

* 3.4.1.1 Repairs of type 301 stitching. Repairs of type 301 stitching shall be as follows:

a. When thread breaks or bobbin run-outs occur during sewing, the stitching shall be repaired by restarting the stitching a minimum of 1/2 inch back of the end of the stitching. 1/

b. Thread breaks, or two or more consecutive skipped stitches or run-offs noted during inspection of the item (in-process or end item) shall be repaired by overstitching. The stitching shall start a minimum of 1/2 inch in back of the defective area, continue over the defective area and continue a minimum of 1/2 inch beyond the defective area onto the existing stitching. Loose or excessively tight stitching shall be repaired by removing the defective stitching, without damaging the materials, and restitching in the required manner. 1/

1/ When making the above repairs, the ends of the stitching are not required to be backstitched.

3.4.1.2 Automatic stitching. Automatic machines may be used to perform any of the required stitch patterns provided the requirements for the stitch pattern, stitches per inch, and size and type of thread are met; and at least three tying, overlapping or backstitches are used to secure the ends of the stitching.

* 3.4.1.3 Thread ends. All thread ends shall be trimmed to a length of 1/4 inch minimum.

3.4.2 Setting of snap fasteners. The hole punched before attaching the female part of fastener shall be no larger than that made by a standard No. 10 round drive punch (5/16 inch diameter hole). The fastener shall be securely clinched without cutting the surrounding material. The male fastener shall be securely clinched to the fastener support.

3.4.3 Setting of tubular rivets. Holes in the material for the rivets may be formed by the rivets when driven into the material or may be prepunched. Prepunched holes shall be smaller than the diameter of the rivet so that the rivets must be forced through the holes. The rivets shall be securely clinched without cutting the webbing under the head end.

* 3.4.4 Repairs. Except as otherwise specified herein, repairs are not allowed to be made to the pocket.

* 3.4.5 Replacement of defective components. During the spreading, cutting and manufacturing process, components having material defects or damages that are classified as defects in 4.4.3.1, shall be removed from production and replaced with non-defective and properly matched components.

3.5 Marking. The identification marking shall be applied in the location shown on the drawing and shall conform to type IV, class 5 of DDD-L-20, except that the nomenclature shall be "Pocket, Ammo, Magazine". In addition, the letters "US" shall be applied in the size characters and in the location indicated on the drawing and shall conform to type IV, class 9 of DDD-L-20. Fastness of the class 9 marking shall be as specified for class 5 marking.

3.6 Workmanship. The finished pocket shall conform to the quality and grade of product established by this specification. 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 supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the supplier 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 prescribed requirements.

* 4.2 Classification of inspection. 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. When required (see 6.2), the first article submitted in accordance with 3.2, shall be inspected as specified in 4.4.3 for compliance with design, construction, workmanship, dimensional, and fit requirements.

4.4 Quality conformance inspection. Sampling for inspection shall be in accordance with MIL-STD-105, except where otherwise indicated hereinafter.

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

4.4.2 In-process inspection. Inspection of subassemblies shall be made to ascertain that construction details which cannot be examined in the finished product are in accordance with requirements indicated on the drawing. Construction methods of subassemblies not in accordance with specified requirements shall be considered not acceptable.

* 4.4.3 Examination of the end item. The classification of defects found during the examination shall be in accordance with 4.4.3.1, 4.4.3.2 and 4.4.3.3. The sample unit for these examinations shall be one completely fabricated pocket. The inspection level and acceptable quality level for these examinations shall be in accordance with 4.4.3.4.

* 4.4.3.1 Visual examination.

| Examine | Defect | Classification Major | Minor |
|---|---|---|---|
| Webbing | Any hole, cut or tear. | X | |
| | Not firmly and tightly woven, edges frayed or scalloped. | X | |
| | Abrasion mark, slub, smash, broken end or pick. | X | |
| | Body or pocket splices, i.e., not one continuous piece. | X | |
| Hardware (general) | Broken or malformed, failing to serve intended purpose, finish omitted, corroded areas, burrs or sharp edges. | X | |
| Snap fastener | Clinched excessively tight, cutting surrounding material. | X | |
| | Clinched loosely, permitting male components to rotate freely in the hole in the fastener support or on female components, socket legs not tightly clinched leaving clinch plate loose. | X | |
| | Incorrect style. | X | |
| | Fastener not functioning properly, i.e. fails to snap closed, provide a secure closure, or open freely. | X | |
| | NOTE: The fastener shall be snapped and unsnapped twice to determine whether parts of fastener separate freely and also effect a secure closure. | | |

| Examine | Defect | Classificati Major | Min |
|---|---|---|---|
| Rivets | Clinched excessively tight, cutting webbing. | X | |
| | Not securely clinched causing looseness of fastener support. | X | |
| | Rivet head placed on fastener support side of pocket. | X | |
| Keeper | Not assembled to pocket properly. | | X |
| | Slide component of keeper jams in open, partly closed, or closed position. | X | |
| | NOTE: The slide component of the keeper shall be fully closed and opened twice to determine whether slide operates freely. | | |
| Open seam | Less than 1/2 inch. | | X |
| | 1/2 inch or more. | 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 stitches or runoffs occur. | | |
| Raw edges (on edges required to be finished) | More than 1/2 inch when securely caught in stitching. | | X |
| | NOTE: Raw edges not securely caught in stitching shall be classified as open seams. | | |
| Seam and stitch type | Wrong seam or stitch type. | X | |
| Stitch tension | Loose, resulting in a loose bobbin or top thread. | | X |
| | Tight, resulting in puckering of webbing. | | X |

| Examine | Defect | Classification Major | Classification Minor |
|---|---|---|---|
| Stitches per inch | One to two stitches less than minimum specified. | | X |
| | Three or more stitches 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 webbing in order to sew over heavy places or in turning corners shall be classified as follows: (a) Within the Minor defect classification - no defect. (b) Within the Major defect classification - Minor defect. | | |
| Thread breaks, skipped stitches or runoffs | Overstitched less than 1/2 inch in each direction beyond the defective stitching area. | | X |
| | NOTE: Thread breaks, skipped stitches or runoffs not overstitched shall be classified as open seams. | | |
| Stitching ends | Ends of stitching not secured as specified (except where ends are held down by other stitching or when ends are turned under in a hem). | | X |
| Components and assembly | Any component part omitted or not as specified, or required operation omitted (unless otherwise classified herein). | X | |
| | One or more rows of stitching omitted. | X | |
| | Needle chews. | X | |
| | Mends or darns. | X | |

| Examine | Defect | Classification Major | Minor |
|---|---|---|---|
| Body | Flap improperly stitched causing distortion or excessive fullness at folded portion. | | X |
| Body, pocket and piece "A" | Raw edges not turned under. | X | |
| Marking: "US" and identification | Omitted, illegible, misplaced, incorrect, or size of characters not as specified. | | X |
| Cleanness | Grease or oil stain clearly noticeable, thread ends not trimmed throughout as specified. | | X |

* 4.4.3.2 Examination for dimensions. Examination shall be made for compliance with all dimensions shown on Drawing 2-4-42 which can be examined on the end item, including stitch margins and gage, excluding reference dimensions. Any dimension exceeding the applicable tolerance shall constitute a defect.

4.4.3.3 Examination of pocket for fit.

| Examine | Defect |
|---|---|
| Fit of ammunition magazines into pocket | Any pocket too small, i.e., magazines fail to fit properly into either one of the individual pockets.<br>Pocket body or flap too short, causing inability to securely close the snap fastener. |

NOTE: Fit examination shall be performed with two standard 7 round ammunition magazines for the .45 caliber automatic pistol (see 6.3). The magazines shall be inserted into the individual pockets without effort other than that necessary to overcome friction between the magazines and the pockets. The flap snap fastener shall be securely closed.

* 4.4.3.4 Inspection level and acceptable quality level (AQL). The inspection levels and AQLs, expressed in defects per hundred units, shall be as follows:

| Examination | Inspection level | AQL |
|---|---|---|
| For defects applicable to 4.4.3.1 | II | 2.5 Major<br>10.0 Total (major and minor defects combined) |
| For defects applicable to 4.4.3.2 | S-3 | 10.0 One class |
| For defects applicable to 4.4.3.3 | S-3 | 0.65 One class |

4.4.4 Examination of preparation for delivery requirements.

4.4.4.1 Examination for packaging, packing and marking. An examination shall be made to determine that packaging, packing and marking comply with the section 5 requirements. 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 closed. 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) | Omitted; incorrect; illegible; of improper size, location, sequence, or method of application. |
| Materials | Any component missing.<br>Any component damaged.<br>Any component not as specified. |
| Workmanship | Inadequate application of components, such as incomplete closure of container flaps, improper taping, loose strapping or inadequate stapling.<br>Bulged or distorted container. |
| Content | Number of bundles per shipping container is more or less than required.<br>Number of pockets per bundle is more or less than required. 1/ |

1/ For this defect, four bundles from each shipping container in the sample shall be examined.

* 4.4.4.2 Examination for palletization. An examination shall be made to determine that the palletization complies with the section 5 requirements. Defects shall be scored in accordance with the list below. The sample unit shall be one palletized unit load fully prepared for delivery. The lot size shall be the number of palletized unit loads in the end item inspection lot. The inspection level shall be S-1 and the AQL shall be 6.5 defects per hundred units.

| Examine | Defect |
|---|---|
| Finished dimensions | Length, width or height exceeds specified maximum requirement. |
| Palletization | Not as specified.<br>Pallet pattern not as specified.<br>Interlocking of loads not as specified.<br>Load not bonded with required straps as specified. |
| Weight | Exceeds maximum load limits. |
| Marking | Omitted; incorrect: illegible; of improper size, location, sequence or method of application. |

## 5. PREPARATION FOR DELIVERY

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

5.1.1 Level A. Each pocket shall have the keepers and flap snap fastener closed. Five pockets, alternately reversed end for end, shall be neatly stacked to form a bundle. The bundle shall be securely tied in the center with cotton tape or twine.

5.1.2 Level C. Pockets shall be packaged to afford adequate protection against physical damage during shipment from the supply source to the first receiving activity. The supplier may use his standard practice when it meets this requirement.

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

* 5.2.1 Level A. Three hundred pockets, packaged as specified in 5.1, shall be packed in a snug-fitting shipping container conforming to style RSC-L, grade V2s of PPP-B-636. The inside of each container shall be fitted with a taped box liner conforming to type CF, class weather-resistant, variety

grade V15c of PPP-B-636. 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 grade B of UU-P-268. Each shipping 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.

* 5.2.2 Level B. Three hundred pockets, packaged as specified in 5.1, shall be packed in a snug-fitting 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 container shall be fitted with a taped box liner conforming to type CF, class domestic, variety DW, grade 275 of PPP-B-636. 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 grade B of UU-P-268. Each shipping container shall be closed in accordance with method I, as specified in the appendix of PPP-B-636.

* 5.2.2.1 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 method III as specified in the appendix of the container specification.

5.2.3 Level C. Pockets, packaged as specified in 5.1, shall be packed in a manner to insure carrier acceptance and safe delivery to destination at the lowest transportation rate for such supplies. Containers shall be in accordance with Uniform Freight Classification Rules or National Motor Freight Classification Rules, as applicable.

5.3 Palletization. When specified (see 6.2), pockets, packed as specified in 5.2, shall be palletized in accordance with load type I of MIL-STD-147. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding means K and L. Pallet patterns shall be in accordance with the appendix of MIL-STD-147. Interlocking of loads shall be effected by reversing the pattern of each course. If the container is of a size which does not conform to any of the pallet patterns specified in MIL-STD-147, the pallet pattern used shall first be approved by the contracting officer.

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

6. NOTES

6.1 Intended use. The pocket is intended for carrying two 7-round magazines for the .45 caliber automatic pistol. The pocket is attached to a pistol belt or individual equipment belt by two keepers.

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

(a) Title, number and date of this specification.
(b) When a first article sample is required (see 3.2, 4.2 and 6.4).
(c) Selection of applicable levels of packaging and packing (see 5.1 and 5.2).
(d) When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).
(e) When palletization is required (see 5.3).

6.3 For access to samples and the standard magazines required for performing the fit examination in 4.4.3.3, address the procuring office issuing the invitation for bids.

* 6.4 First article. When a first article sample is required, it shall be inspected and approved under the appropriate provisions of ASPR 7-104.55. The first article should be a preproduction sample consisting of one completed pocket. The contracting officer should include specific instructions in all procurement instruments, regarding arrangements for inspection and approval of the first article.

6.5 Marginal identification. The margins of this specification are marked with an asterisk to indicate where changes (additions, modifications, correctior deletions) from the previous issue were made. This was done as a convenience or and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and suppliers 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.

Custodians:

Army - GL
Navy - SA
Air Force - 82

Review activities:

Army - MD
Navy - MC

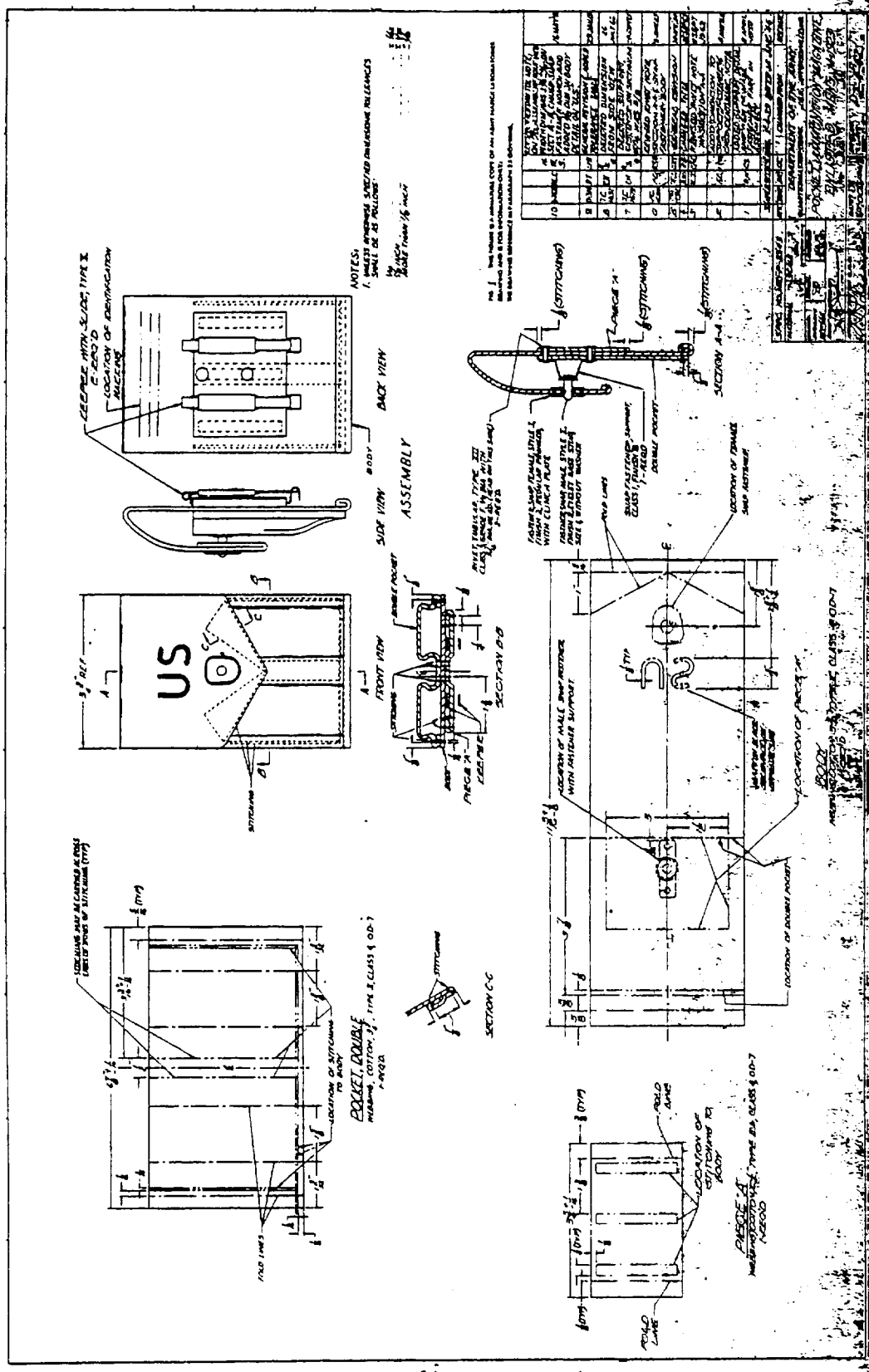
User activity:

Navy - YD

Preparing activity:

Army - GL

Project No. 8465-0434



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U.S. ARMY NATICK LABORATORIES
Natick, Mass. 01760

OFFICIAL BUSINESS
PENALTY FOR PRIVATE USE $300

STSNLT-EQS

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# STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

OMB Approval No. 22-R355

INSTRUCTIONS: The purpose of this form is to solicit beneficial comments which will help achieve procurement of suitable products at reasonable cost and minimum delay, or will otherwise enhance use of the document. DoD contractors, government activities, or manufacturers/ vendors who are prospective suppliers of the product are invited to submit comments to the government. Fold on lines on reverse side, staple in corner, and send to preparing activity. 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. Attach any pertinent data which may be of use in improving this document. If there are additional papers, attach to form and place both in an envelope addressed to preparing activity.

DOCUMENT IDENTIFIER AND TITLE

MIL-P-2343F POCKET, AMMUNITION MAGAZINE, ENLISTED MEN'S, M-1923

NAME OF ORGANIZATION AND ADDRESS

CONTRACT NUMBER

MATERIAL PROCURED UNDER A

☐ DIRECT GOVERNMENT CONTRACT ☐ SUBCONTRACT

1. HAS ANY PART OF THE DOCUMENT CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE?

A. GIVE PARAGRAPH NUMBER AND WORDING.

B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES

2. COMMENTS ON ANY DOCUMENT REQUIREMENT CONSIDERED TOO RIGID

3. IS THE DOCUMENT RESTRICTIVE?

☐ YES ☐ NO *(If "Yes", in what way?)*

4. REMARKS

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

TELEPHONE NO.

DATE

DD FORM 1 JAN 72 1426

REPLACES EDITION OF 1 JAN 66 WHICH MAY BE USED