

MIL-P-40061B
31 December 1970
SUPERSEDING
MIL-P-40061A
30 June 1965

MILITARY SPECIFICATION

PANEL MARKER, AERIAL LIAISON, VS-17/GVX

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

1. SCOPE

1.1 This specification covers one type and size of signal panel which is fabricated from laminated fluorescent dyed nylon cloth with an integral pocket for protection of the panel in storage.

2. APPLICABLE DOCUMENTS

2.1 The following documents of the issue in effect on date of invitations for bids or request for proposal, form a part of this specification to the extent specified herein.

SPECIFICATIONS

FEDERAL

V-T-285 - Thread, Polyester
UU-B-36 - Bag, Paper (Grocers)
UU-P-268 - Paper, Kraft, Untreated, Wrapping
DDD-L-20 - Label, for Clothing, Equipage and Tentage (General Use)
PPP-B-601 - Boxes, Wood, Cleated, Plywood
PPP-B-621 - Boxes, Wood, Nailed and Lock-Corner
PPP-B-636 - Box, Fiberboard
PPP-T-45 - Tape, Gummed, Paper, Reinforced and Plain,
for Sealing and Securing

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MIL-T-5038 - Tape, Textile and Webbing, Textile, Reinforcing
Nylon
MIL-C-5040 - Cord, Nylon
MIL-F-10884 - Fasteners, Snap

/FSC 8345/

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STANDARDS

FEDERAL

Fed. Std. 191 - Textile, Test Methods
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-169 - Extreme Temperature Cycle

DRAWINGS

THE INSTITUTE OF HERALDRY

5-1-321 - Panel Marker, Aerial Liaison, VS-17/GVX Assembly,
Sections and Details

(The miniature copy of drawing 5-1-321, identified as figure 1, is for information only.)

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

3. REQUIREMENTS

3.1 Standard sample.- Unless otherwise specified in the contract or purchase order (see 6.2), the contracting officer will furnish a standard sample of each laminated cloth (red-orange and olive drab-orange) which shall be used for matching color, luster, brightness, purity of tone and colorfastness only.

3.2 First article.- When specified (see 6.2), before production is commenced, a sample of the finished panel shall be submitted or made available to the contracting officer or his authorized representative for inspection as specified in 4.2. The approval of the first article authorizes the commencement of production, but does not relieve the contractor of responsibility for compliance with all the applicable provisions of this specification. The first article shall be manufactured in the same facilities to be used for the manufacture of the production items.

3.3 Material.- Materials shall conform to the referenced specifications and the requirements specified herein.

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3.3.1 Cloth, nylon.- The nylon cloth used for the panel marker shall be a five-harness warp sateen, counter 2, which has the following characteristics:

- a. A minimum of 160 ends per inch in the warp and a minimum of 80 picks per inch in the filling.
- b. At least 70 denier yarn shall be used in the warp and at least 100 denier yarn shall be used in the filling.
- c. Maximum weight of 3 ounces per square yard.
- d. The cloth shall be heat treated.
- e. The cloth shall be either pieced dyed or yarn dyed.

3.3.1.1 Color.- The nylon cloth used in fabrication of the panels shall be of the following colors: Fluorescent red, fluorescent orange and olive drab No. 7, as required. The fluorescent red shall match US Army Shade 229 and the fluorescent orange shall match the US Army Shade 230.

3.3.2 Tie tape.- The tape for the tie shall be dyed to approximate olive green Shade No. 106. The tape shall conform to type III of MIL-T-5038, except only the following characteristics shall apply: Material identification, color, width, colorfastness to light, ultimate elongation and breaking strength. Breaking strength shall be not less than 100 pounds.

3.3.3 Thread, polyester.- Thread for stitching shall be natural colored nylon thread, conforming to type I or type II, class 1, size B, 2 or 3 ply of V-T-285, except that only the following characteristics shall apply: Material identification, breaking strength and elongation.

3.3.4 Cord, nylon.- The cord for the tie cords shall be nylon cord dyed to approximate olive green Shade No. 106 and shall conform to type II of MIL-C-5040, except that only the following characteristics shall apply: Material identification, number of carriers and ends, color, colorfastness to light and a minimum breaking strength of 100 pounds.

3.3.5 Snap fasteners.- The snap fasteners shall consist of a socket and stud eyelet combination conforming to style 2, finish 2 of MIL-F-10884.

3.3.6 Adhesive.- Any resin type adhesive may be used in the lamination of the nylon fabric, provided when tested as specified in 4.3.1, the minimum adhesive strength of the lamination shall be 4-1/2 pounds, and that the adhesive does not show signs of cracking, flaking or peeling as a result of the test.

3.4 Construction.- The panel marker shall be constructed in accordance with drawing 5-1-321 and the requirements specified herein.

3.4.1 Stitching.- All stitching shall be machine stitching conforming to Fed. Std. 751. For all stitching, except for tacking, stitch type 301 with 6 to 8

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stitches per inch shall be used. Bar tacks shall be a minimum of 5/8 inch wide with not less than 28 stitches. Thread tension shall be maintained so that no loose stitching shall occur. All thread ends shall be trimmed. When thread breaks occur in the type 301 stitching the break shall be backstitched not less than one inch. Except where ends are turned under in a hem or held down by other stitching the ends of all stitching shall be backstitched not less than 1/2 inch.

3.4.2 Seating of snap fasteners.- Snap fasteners shall be securely clinched to the panel marker. If a hole is punched thru the material to aid in the placement of the fastener, the diameter of the hole shall be sufficiently small to require the stud portion of the stud eyelet combination to be forced thru the hole. Care should be taken when clinching the fastener to the material to insure the fabric is not cut or damaged.

3.4.3 Tape and cord.- The tape and cord shall be attached to the panel marker as shown on drawing 5-1-321. The ends of both the tape and cord shall be heat sealed to prevent raveling.

3.4.4 Laminated cloth.- Two pieces of nylon cloth specified in 3.3.1 shall be laminated back to back using adhesive specified in 3.3.6 so as to form two plies in the following two color combinations:

1. Fluorescent red on one side and fluorescent orange on the other side.
2. Fluorescent orange on one side and olive drab No. 7 on the other side.

3.4.4.1 Characteristic of the laminated cloth.- The laminated cloth shall be as specified herein.

3.4.4.1.1 Weight.- When tested as specified in 4.3.1, the weight of one square yard of laminated cloth shall not exceed 9-1/2 ounces.

3.4.4.1.2 Flexibility.- When tested as specified in 4.4.1, the laminated cloth shall be pliable and shall not crack, flake or peel.

3.4.4.1.3 Breaking strength.- When tested as specified in 4.3.1, the laminated cloth shall have a breaking strength of not less than 195 pounds in both the warp and filling direction.

3.4.4.1.4 Tear resistance.- When tested as specified in 4.3.1, the laminated cloth shall have a tear resistance of not less than 9 pounds in both the warp and filling direction.

3.4.4.1.5 Temperature and humidity.- When tested as specified in 4.4.2, the nylon cloth shall not crack, flake, discolor or delaminate.

3.4.4.1.6 Streaks and spots.- The laminated cloth shall be acceptable when in any one yard length, a total area of not more than 4 square inches is streaked or spotted. There shall be no larger density of spots or streaks in any single yard.

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3.4.4.1.7 Eveness of lamination.- There shall be no lumpy or thick areas in the laminated cloth.

3.4.4.2 Color.- Color of the laminated cloth shall be as specified in 3.3.1.1. and 3.4.4.

3.4.4.2.1 Visual color matching.- The finished laminated nylon cloth shall match the standard sample (see 3.1 and 6.3) and shall be equal or superior to the standard sample with respect to luster, brightness and purity of color tone when viewed under North Sky daylight, or artificial light having a color temperature of 7500 degrees Kelvin. The samples shall be oriented with the warp direction vertical. The observer shall view the samples at a minimum distance of 6 feet. Viewing shall be made perpendicular to the surface of the sample.

3.4.4.2.2 Colorfastness.- When tested as specified in 4.4.3, the laminated nylon cloth shall show color characteristics and fastness to accelerated weathering equal to or better than the standard sample.

3.5 Marking.- Each panel shall be marked as specified on drawing 5-1-321. The markings shall conform to type IV, class 9 of DDD-L-20. The markings shall show fastness to accelerated weathering for 40 standard hours, equal to or better than the standard sample when tested in accordance with DDD-L-20. When no standard sample has been established for fastness to printing, the markings shall show good fastness to accelerated weathering when tested in accordance with DDD-L-20.

3.6 Workmanship.- The finished panel marker shall be clean, well made and shall meet the acceptable quality levels established by this specification.

4. QUALITY ASSURANCE PROVISIONS

4.1 Inspection responsibility.- Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements 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 the prescribed requirements.

4.2 First article inspection.- When a first article is required, the first article shall be inspected and tested for all requirements applicable to the end item testing and examination.

4.3 Sampling for inspection and acceptance.- Sampling for inspection and

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acceptance shall be in accordance with MIL-STD-105, except where otherwise indicated.

4.3.1 Testing of components and materials.- In addition to the quality assurance provisions of the referenced specifications, tests shall be performed on components and materials in table I for the characteristics listed therein. The sample unit for all tests shall be 3 ayds, full width. The requirements are applicable to the individual unit and the lot size can be expressed in yards. For examinations applicable to table I, the acceptance number shall be 0, and the sample size for the designated lot size shall be as follows:

Lot size	Sample size
800 or less	2
801 to 22,000	3
22,001 and over	5

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TABLE I Testing of components and materials.-

Component	Characteristic	Rqm't para	Test method	*determ per s/u	Results reported as	S/U (Inches)
Nylon cloth	Weave	3.3.1	Visual 5050*	1	Pass or fail * yarns in warp and filling	1 pc (10x10)
	Yarn per inch	3.3.1		5		5 pc (3x3)
	Weight	3.3.1	5041*	5	Nearest .1 oz per sq yd	5 pc (2x2)
Laminated nylon cloth	Colorfastness to accelerated weathering	3.4.4.2.2	4.4.3	4	Pass or fail (equal to std sample)	4 pc (2½x10)
	Color	3.4.4.2	3.4.4.2.1 5950*	1	Pass or fail Nearest .1 lb per 2" width	1 pc (12x12)
	Adhesion	3.3.6		5		5 pc (2x6)
	Breaking strength	3.4.4.1.3	5100*	5 ea. direction	Nearest 1.0 lb	10 pc (4x6)
	Tear resistance	3.4.4.1.4	5134*	5 ea. direction	Nearest 1.0 lb	10 pc (3x6)
	Weight	3.4.4.1.1	5041*	5	Nearest .1 oz per sq yd	5 pc (2x2)
	Flexibility	3.4.4.1.2	4.4.1	4	Pass or fail	4 pc (7x7)
	Temperature for humidity:	3.4.4.1.5				
	-Low temperature		5874*	3	Pass or fail	3 pc (8x8)
	-High temperature and high humidity		4.4.2.2	4	Pass or fail	4 pc (4x6)
	-High temperature and low humidity		4.4.2.3	4	Pass or fail	4 pc (4x6)
	-Extreme temperature		4.4.2.4	4	Pass or fail	4 pc (8x8)

* Methods are specified in Fed. Std. 191.

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4.3.1.1 Certification.- The contractor shall certify that the cloth used in lamination has been heat treated in accordance with standard commercial practice and that the denier is a minimum of 70 (warp) and 100 (filling).

4.3.2 Inspection of end item.-

4.3.2.1 Visual examination.- Defects found during the visual examination shall be classified in accordance with 4.3.2.1.1 and 4.3.2.1.2. The unit of product for these examinations shall be one panel marker. The inspection levels and the acceptable quality levels (AQL's) shall be as specified in 4.3.2.1.3. The lot size shall be expressed in units of one panel marker.

Examine	Defects	Classification	
		Major	Minor
Materials Laminated cloths	Spots or streaks exceeding a total of 4 Sq. ins. in total area in any one yard of length.....	x	-
	Lumps or thick areas in laminating cloth.....	-	x
	Any component other than specified.....	x	-
Nylon cords and tape	Hole, cut, tear, mend, patch, needle chew or otherwise impaired affecting serviceability....	x	-
	One or more missing.....	x	-
	Not specified type, size or color.....	-	x
Snap fasteners	Cut, hole or tear affecting serviceability.....	x	-
	Ends not heat-sealed to prevent raveling.....	-	x
	Not securely attached in specified manner.....	x	-
	Not specified type.....	x	-
	More than one missing.....	x	-
Reinforcement patches	One missing.....	-	x
	Any sharp burr, sliver or edge that may damage panel or cause injury in handling.....	x	-
	Improperly assembled; improperly set, not securely clinched, will not engage socket or otherwise defective, affecting serviceability..	x	-
	Grommet clinched excessively tight cutting fabric.....	x	-
	Missing or not securely attached as specified...	x	-
Pocket	Missing.....	x	-
	Not specified color.....	-	x

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Examine	Defects	Classification	
		Major	Minor
Seams and stitchings	Pocket opening corners not reinforced with bar tacking.....	-	x
	Outer edge of pocket stitched to end of panel with a single row of stitching or two rows spaced less than 1-3/16 inch or more than 1-5/16 inch apart.....	-	x
	Outer edges of pocket set uneven with edges of panel by more than 1/16 inch.....	-	x
	Other than specified.....	-	x
	Open more than one inch.....	x	-
	Open more than 1/2 inch, but not more than one inch.....	-	x
	(A seam shall be classified as open when one or more stitches joining a seam are broken or when two or more continuous skipped stitches or run-offs occur. On double stitched seams, a seam is considered open when either one or both sides of the seam are open.)		
	Run-offs (see open seams).....	-	x
	Seams badly twisted, pleated or puckered.....	-	x
	Tension too loose or too tight.....	-	x
	Three or more stitches per inch less than the minimum specified.....	x	-
	Two stitches less than minimum specified.....	-	x
	Two or more stitches in excess of the maximum specified.....	-	x
	(Variation in the number of stitches per inch caused by the operator's speeding up the machine and pulling the fabric in order to sew over heavy seams or 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 in type 301 stitching not back stitched at least 1 inch at each break.....	-	x
	Type 301 stitching not backstitched at the ends, except where ends are turned under in a hem or held down by other stitching.....	-	x
	Stitching margins irregular, i.e., unevenly gauged, clearly noticeable.....	-	x
	Bar tack missing, loose or misplaced.....	-	x
	Ends not trimmed.....	-	x

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Examine	Defects	Classification	
		Major	Minor
Marking (Contractor's identification; instructions for care of panel one of each required on inside of pocket, OD side)	Missing..... Misplaced, misspelled, smeared, type of character not as specified or wrong color.....	x -	- x

4.3.2.1.2 Dimensional examination.- Any dimension that is not within the specified tolerances shall be classified as a defect.

4.3.2.1.3 Inspection levels and acceptable quality levels (AQL's).- The inspection levels and acceptable quality levels expressed in defects per hundred units shall be as follows:

	Inspection Level	AQL Major	AQL Total
For defects applicable to 4.3.2.1.1	II	4.0	10.0
For defects applicable to 4.3.2.1.2	S-2	(one class)	4.0

4.3.2.1.4 Examination of preparation for delivery requirements.- An examination shall be made to determine that packaging, packing and marking comply with the requirements of section 5 of this specification. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully prepared for delivery with the exception that it need not be sealed. Shipping containers fully prepared for delivery shall be examined for the defects of closure listed below. 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 acceptable quality level shall be 2.5.

Examine	Defect
Markings (Exterior and interior)	Omitted, incorrect, illegible, of improper size, location sequence or method of application.
Materials	Any component missing, any component damaged, affecting serviceability.
Workmanship	Inadequate application of components such as incomplete closure of container flaps, inadequate stapling.
Content	Number per container is more or less than required.

4.4 Tests.-

4.4.1 Flexing test.- A specimen of the laminated nylon cloth shall be subject to 1000 flexing cycles at -40 degrees F. and then another 1000 flexing cycles at +150 degrees F. A total of four specimens shall be tested as above, two with the warp placed in the vertical position (opposite faces shall be exposed) and two with the filling direction placed in the vertical position (opposite faces exposed). The specimens shall be 7 inches by 7 inches, capable of being formed into a cylinder 7 inches long and 2 inches in diameter with a 5/8 inch overlap. The apparatus used shall be one which enables the cylinder described to be flexed through a vertical reciprocating motion a distance of 4-1/2 inches. The machine shall be capable of maintaining a speed of 150 to 175 cycles per minute at specified test temperatures. In the unflexed and flexed positions, the mounting cylinders shall be 5 inches and 1/2 inch apart respectively, in order to produce a 4-1/2 inch flexing stroke. The specimen shall be mounted on the specimen holder by means of a ring or hose clamp and the apparatus placed in the test condition specified for one hour. The cloth shall then be examined to determine compliance with 3.4.4.1.2.

4.4.2 Temperature and humidity test.-

4.4.2.1. Low temperature test.- The low temperature test shall be as specified in method 5874 of Fed Std. 191. The cloth shall then be examined to determine compliance with 3.4.4.1.5.

4.4.2.2 High temperature and high humidity.- Four specimens of the laminated nylon cloth, each 4 inches by 6 inches, shall be subject to a temperature of +150 degrees F. The cloth shall then be examined to determine compliance with 3.4.4.1.5.

4.4.2.3 High temperature and low humidity.- Four specimens of the laminated nylon cloth, each 4 inches by 6 inches, shall be subject to a temperature of +150 degrees F. at a relative humidity of 20 ± 5 percent for a period of 14 days. Immediately upon removal from the test chamber, the specimens shall be tested as follows: Two specimens of the laminated cloth shall be bent through 180 degrees, around a 3/16 inch diameter steel rod, in the direction of the warp with the orange side of one and the red or olive drab side of the other exposed. This 180 degrees bend shall be repeated in the direction of the filling with the remaining two specimens. The cloth shall then be examined to determine compliance with 3.4.4.1.5.

4.4.2.4 Extreme temperatures.- Four specimens of the laminated nylon cloth each 4 inches by 6 inches shall be subjected to steps 2A, 6A and 10 of the temperature cycle shown in MIL-STD-169, except step 6A shall be -60 degrees F., +5 degrees, -0 degrees F. The cloth shall then be examined to determine compliance with 3.4.4.1.5.

4.4.3 Accelerated weathering test.- Four specimens of each side of the laminated nylon cloth used in the panels with a piece of the standard sample shall

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be exposed in accordance with method 5671 of Fed. Std. 191 with a 40 hour exposure cycle. The apparatus shall be as specified in method 5804 except that the filters shall be removed when testing. The cloth shall then be examined to determine compliance with 3.4.4.2.2.

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 panel shall be laid out flat, pocket side up. The length of the panel shall be folded toward the pocket in increments of approximately 6 inches, with the tie cords tucked inside the folds, and the folded panel inserted in the pocket. The pocketed panel, with the olive drab side facing out, shall then be folded in the width in thirds with the last fold placed over the first fold and securely tied with the tie tapes attached for that purpose. The folded panel shall form a compact package approximately 8 inches in length, 7-1/2 inches in width and 1-1/2 inches in depth. Each folded panel shall then be completely wrapped in 30-pound kraft paper conforming to grade B of UU-P-268 or packaged in a snug-fitting kraft paper bag conforming to type II of UU-B-36. The kraft paper wrap or bag shall be secured with gummed paper tape conforming to type III, grade B of PPP-T-45. At the option of the manufacturer a folded panel may be placed in a snug-fitting transparent polyethylene film bag and heat sealed. The film for the bag shall be not less than .0015 inch thick. Prior to or during the heat sealing operation, excess air within the bag shall be expelled.

5.1.2 Level C.- Panels shall be packaged to afford adequate protection against deterioration and damage during shipment from supply source to first receiving activity.

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

5.2.1 Level A.- Panels packaged as specified in 5.1, shall be packed in a snug-fitting shipping container conforming to class 2 of PPP-B-621 or overseas type, style A, B, I or J of PPP-B-601. Closure and reinforcement shall be in accordance with the appendix of the applicable specification.

5.2.2 Level B.- Sixty (60) panels packaged as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to W5c, W5s, V3c or V3s of PPP-B-636. Closure shall be in accordance with the appendix of the applicable container specification.

5.2.3 Level C.- Panels packaged as specified in 5.1, shall be packed in such a manner to insure carrier acceptance and safe delivery at destination at the lowest transportation rates available for such supplies. Shipping containers shall be in accordance with the rules and regulations of carriers applicable to the mode of transportation.

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

6. NOTES

6.1 Intended use.- Panel marker covered by this specification is intended to be used by ground forces to affect recognition by air support units.

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

- (a) Title, number and date of this specification.
- (b) When standard samples of laminated cloth will not be furnished (see 3.1).
- (c) When a first article is required (see 3.2).
- (d) Selection of applicable levels of packaging and packing (see 5.1 and 5.2).

6.3 Standard samples.- Standard samples as specified in 3.1 may be obtained from the procurement office issuing the invitation for bid or request for proposal.

Custodians:

Army - IH
Navy - MC
Air Force - 82

Review Activities:

Navy - MC
Air Force - 82
Other - DP

User Activities:

Army - SM, SigC
Navy - MC

Preparing Activity:

The Institute of Heraldry,
United States Army

Project No. 8345-0075

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