

MIL-P-41806D
15 March 1983
SUPERSEDING
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MILITARY SPECIFICATION

POLE, SKI, STEEL SHAFT, NONADJUSTABLE

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

1. SCOPE

- * 1.1 Scope. This document covers one type of nonadjustable steel ski pole.

- 1.2 Classification. Ski poles shall be of the following sizes, as specified (see 6.2):

Size 1 - 51 inches overall length
Size 2 - 54 inches overall length
Size 3 - 58 inches overall length

2. APPLICABLE DOCUMENTS

- * 2.1 Government documents. Unless otherwise specified, the following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of this document to the extent specified herein.

SPECIFICATIONS

FEDERAL

QQ-A-225/3 - Aluminum Alloy Bar, Rod, and Wire; Rolled, Drawn,
or Cold Finished, 2011
QQ-S-571 - Solder, Tin Alloy: Tin-Lead Alloy; and Lead Alloy
TT-C-490 - Cleaning Methods and Pretreatment of Ferrous
Surfaces for Organic Coatings
TT-E-529 - Enamel, Alkyd, Semi-Gloss
TT-P-636 - Primer Coating, Alkyd, Wood and Ferrous Metal
WW-T-700/4 - Tube, Aluminum Alloy, Drawn, Seamless, 5052
PPP-B-636 - Boxes, Shipping, Fiberboard

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 Laboratories, Natick, MA 01760 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

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- MIL-B-2505 - Buckles, Center-Bar with Tongue
- MIL-R-3065 - Rubber, Fabricated Products
- MIL-G-16491 - Grommet, Metallic
- MIL-L-40069 - Leather, Cattlehide, Chrome-Tanned, Cold-Climate

STANDARDS

MILITARY

- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
- MIL-STD-129 - Marking for Shipment and Storage
- MIL-STD-1188 - Commercial Packaging of Supplies and Equipment

DRAWINGS

U.S. ARMY NATICK RESEARCH AND DEVELOPMENT LABORATORIES

- 2-10-50 - Pole, Ski, Steel Shaft, Nonadjustable; Assembly and Details
- 2-10-51 - Pole, Ski, Steel Shaft, Nonadjustable; Snow Ring, Billet and Chape Assemblies
- 2-10-66 - Pole, Ski, Steel Shaft, Nonadjustable; Hand Grip

(Copies of documents required by manufacturers in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting officer.)

- * 2.2 Other publications. Unless otherwise specified, the following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of this document to the extent specified herein.

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

- A 53 - Welded and Seamless Steel Pipe
- A 108 - Steel Bars, Carbon, Cold Finished, Standard Quality
- D 412 - Rubber Properties in Tension
- D 1053 - Measuring Rubber Property-Stiffening at Low-Temperature Using a Torsional Wire Apparatus
- D 1149 - Rubber Deterioration-Surface Ozone Cracking in a Chamber (Flat Specimen)
- D 2000 - Elastomeric Materials for Automotive Applications
- D 2240 - Rubber Property - Durometer Hardness
- E 18 - Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.)

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AMERICAN IRON AND STEEL INSTITUTE (AISI)

AISI 4140 - Chemical Requirements of Alloy Steel
 AISI 4150 - Chemical Requirements of Alloy Steel
 AISI 8642 - Alloy Steel Compositions (a)
 AISI 8645 - Alloy Steel Compositions (a)
 AISI 8650 - Alloy Steel Compositions (a)
 AISI 8655 - Alloy Steel Compositions (a)

(Application for copies of Steel Product Manual should be addressed to the American Iron and Steel Institute, 150 East 42nd Street, New York, NY 10017.)

(Technical society and technical association documents are generally available for reference from libraries. They are also distributed among technical groups and using Federal agencies.)

- * 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 shall take precedence.

3. REQUIREMENTS

- * 3.1 Samples.
- * 3.1.1 Guide samples. Guide samples of the end item are solely for guidance and information to the contractor (see 6.3). Variation from this document may appear in the sample, in which case this document shall govern.
- * 3.1.2 First article. When specified a sample shall be subjected to first article inspection (see 4.3, 6.2 and 6.4).

3.2 Materials and components. Materials and components shall be as specified herein and on applicable drawings. Materials not definitely specified shall be of the quality normally used by the manufacturer, provided the completed item complies with all provisions of this document.

3.2.1 Rubber, black synthetic for the webbing. Black synthetic rubber compound for the webbing shall be a commercial blend meeting the requirements specified in 3.2.2.1 through 3.2.2.5.

3.2.1.1 Hardness. The average hardness of the rubber compound for the webbing shall be not less than 65 or more than 75 when tested as specified in 4.4.1.1.

3.2.1.2 Tensile strength. The tensile strength of the rubber compound for the webbing shall be not less than 1500 psi when tested as specified in 4.4.1.1.

3.2.1.3 Elongation. The ultimate elongation of the rubber compound for the webbing shall be not less than 400 or more than 600 percent when tested as specified in 4.4.1.1.

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3.2.1.4 Stiffness. The rubber compound for the webbing shall be capable of being twisted a minimum of 98 angular degrees at a temperature of minus $55^{\circ} \pm 0.5^{\circ}\text{C}$ when the 0.060 inch thick specimen representing the rubber compound is tested as specified in 4.4.1.1.

3.2.1.5 Resistance to cracking. The rubber compound for the webbing shall show no signs of cracking when tested as specified in 4.4.1.1.

- * 3.2.2 Solder. Solder shall conform to composition Sn40 of QQ-S-571 when primer coat and enamel, as specified in 3.2.5 and 3.2.6 are used. When the alternate coating specified in 3.2.6 is used, solder conforming to Braze 053 (TEC), or equal shall be used with the appropriate flux. Prior to use of the "or equal" item, the contractor shall submit the item to the contracting officer with supporting data for approval.

3.2.3 Commercial items. Steel screw, washer, pipe, retaining pin and aluminum wire and rivet shall be commercial quality except as shown on applicable drawing.

3.2.4 Primer. Primer shall conform to composition G or L, as applicable, of TT-P-636.

3.2.5 Enamel. Enamel shall conform to class A or B, composition G or L, as applicable, white color No. 27875 of TT-E-529.

- * 3.2.6 Epoxy coating. As an alternate to the primer and enamel specified above, the ski poles may be coated with standard white Corvett 1555-FC3 epoxy coating, or equal. Prior to use of the "or equal" item, the contractor shall submit the item to the contracting officer with supporting data for approval.

- * 3.3 Construction. The construction shall conform in all respects to the drawings listed in section 2 and as specified herein. The shaft shall be fabricated from steel tubing specified on drawing 2-10-55. The end plug shall be pressed into the shaft and secured by the retaining pin without any looseness. Prior to assembling the point and end plug to the shaft, the inner wall of the shaft shall be thoroughly dried. After the finish on the shaft has been allowed to dry, the snow ring, billet, chape, and hand grip shall be assembled on the shaft as shown on Drawing 2-10-50. The machine screw shall be securely set and tightened in place.

3.3.1 Spot welding. Spot welding shall be smooth and uniform.

3.3.2 Soldering. The collar and point shall be soldered in place with solder specified in 3.2.7. Soldered joints shall be complete, sound, and smooth.

3.3.3 Clinching of rivets and grommets. Rivets and grommets shall be neatly and securely clinched without any crack, split, or burr.

3.3.4 Staking. Prior to the rubber webbing being bonded to the aluminum ring (see 6.5), the tubular wall of the ring shall be staked as shown on Drawing 2-10-51. Staked components shall be securely held together, i.e., free from looseness.

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3.3.5 Strength of rubber bonding to snow ring. The bonding of the rubber to the aluminum snow ring shall be such that the rubber fails with a portion remaining bonded to the ring when tested as specified in 4.4.2.2.

3.4 Finish. After all soldering and welding, and prior to finishing, all burrs, sharp edges, and rough spots shall be removed.

3.4.1 Metal surface preparation. The outer surfaces of the assembled tubular shaft, end plug, collar, point, and ends of retaining pin shall be thoroughly cleaned with pretreatment coatings conforming to type I or II of TT-C-490.

3.4.2 Priming. After metal surface preparation, the outer surfaces of the tubular shaft, end plug, collar, point, and ends of retaining pin shall be coated with primer specified in 3.2.4 if enamel is to be the final coating.

3.4.3 Enameling. After the primer has been allowed to dry, all primed surfaces shall be completely coated with enamel specified in 3.2.5. The coating shall be smooth, uniform, dry film without runs, wrinkles, blisters, area of thin or no film, scratch, foreign matter embedded in finish, and wet or tacky paint.

3.4.4 Epoxy coating. After metal surface preparation, epoxy coating as specified in 3.2.6 shall be applied. The coating shall be smooth, uniform without runs, wrinkles, blisters, areas of thin or no finish, scratches, foreign matter embedded in finish or improperly cured.

3.5 Marking for identification. The letters U.S., the manufacturer's identification mark, and the year of manufacture shall be permanently and distinctly indent stamped or branded on the wrist strap as shown on Drawing 2-10-51.

3.6 Workmanship. Soldered joints and welding shall be free of any crack, burnt or reduced area, pin holes, flux residue, and slag. The finished ski pole shall be clean and free from grease, dirt, malformation, crack, split, burr, sharp edge, rough spot, and being bent out of shape.

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 inspection set forth in the document where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

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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 inspection. When a first article is required (see 6.2), it shall be examined for the defects specified in 4.4.3.1 and 4.4.3.2. 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 Components and materials 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. Material testing. In addition to the quality assurance provisions of the subsidiary specifications and drawings, and as specified herein, testing shall be performed as specified in table I for the characteristics shown therein.

TABLE I. Material testing

Material	Characteristic	Require- ment	Test method	No. deter. per sample	Results reported as
Rubber compound for webbing <u>1/</u>	Hardness	3.2.1.1	4.5.1	5	Average of 5 determ. to nearest scale reading
	Tensile strength <u>2/</u>	3.2.1.2	4.5.2	1	To nearest 100 psi (1 MPa)
	Elongation <u>2/</u>	3.2.1.3	4.5.3	1	To nearest 10 percent
	Stiffness	3.2.1.4	4.5.4	1	To nearest degree
	Resistance to cracking	3.2.1.5	4.5.5	1	Pass or fail

1/ Each separate batch of rubber compounded for fabrication of the webbings shall be tested. A representative composite of the compound shall be fabricated into test specimens sufficient to perform all the specified tests. The test specimens shall be fabricated under the same time, temperature and pressure as the rubber webbings. Any nonconformance with the requirements shall be cause for rejection of the batch represented by the specimen.

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2/ Tensile strength and elongation tests may be performed simultaneously.

4.4.2 In-process inspection.

- * 4.4.2.1 In-process examination. Examinations shall be made during manufacturing processes to determine conformance with the requirements listed in table II. Whenever nonconformance is noted, correction shall be made to the items affected, the lot in progress, and to the operation. Parts which cannot be corrected shall be removed from production.

TABLE II. In-process examination

Requirement	Requirement paragraph
End plug pressed into the shaft and secured by the retaining pin without any looseness.	3.3
Drying of inner wall of tubular shaft prior to assembling the point and end plug.	3.3
Enamel has been applied and allowed to dry prior to assembly of the snow ring and the hand grip with chape and billet assemblies on the shaft.	3.3
Staked components are securely held together, i.e., free from looseness.	3.3.4
Removal of burrs, sharp edges, and rough spots prior to finishing.	3.4
Cleaning of outer surfaces of assembled shaft, end plug, collar, point, and ends of retaining pin prior to priming.	3.4.1
Cleaned outer surfaces of assembled shaft, end plug, collar, point, and ends of retaining pin are primed prior to enameling.	3.4.2

4.4.2.2 In-process inspection of snow rings, shafts and point. The lot shall be all of the snow rings, shafts, or points, as applicable, submitted for inspection at one time. The sample unit shall be one snow ring, shaft, or point, as applicable. The inspection level shall be S-1 with an AQL of 4.0 expressed in terms of defects per hundred units.

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4.4.2.2.1 In-process dimensional examination of shafts and points. A dimensional examination shall be made of the shaft and point prior to assembly and application of finish. Any dimension not within the specified requirements as shown on the drawing shall be classified as a defect.

- * 4.4.2.2.2 In-process testing of snow rings, shafts and points. Testing of snow rings, and testing of shafts and points prior to assembly and application of finish shall be performed as specified in table III.

TABLE III. In-process tests

Item	Characteristic	Require- ment	Test method	Number deter. per sample unit	Results reported as
Snow ring	Strength of rubber bonding	3.3.5	4.5.6	1	Pass or fail
Shaft (item 2-1)	Hardness, Rockwell 30 N 66-30 N 71	Drawing 2-10-50	4.5.7	3	Average of 3 determinations to nearest Rockwell scale reading
Point (item 2-2)	Hardness, Rockwell 30 T 60-30 T 65	Drawing 2-10-50	4.5.7	3	Average of 3 determinations to nearest Rockwell scale reading

4.4.3 End item inspection. The inspection lot shall be all the ski poles of one size offered for inspection at one time. The sample unit shall be one completely assembled ski pole.

4.4.3.1 Visual examination. The ski poles shall be examined for the defects listed in table IV. The inspection level shall be II with an AQL of 4.0 for major defects and 10.0 for total defects, expressed in terms of defects per hundred units.

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TABLE IV. Classification of defects

Examine	Defect	Classification	
		Major	Minor
Finish	Outer surfaces of the tubular shaft, collar, and point not finished	X	
	Color of finish not white		X
	Coating not smooth or uniform		X
	Finish is not dry, i.e., wet or tacky to touch		X
	Run, wrinkle, or blister		X
	Area of no coating exposing bare metal	X	
	Area of no coating or thin film exposing primer coating		X
	Scratch or foreign matter imbedded in finish		X
Construction and workmanship	Any component missing or not as specified	X	
	Machine screw holding the hand grip not securely screwed in place, i.e., is loose.		X
	Component not assembled as shown on applicable drawing, e.g., billet or chape assembly not assembled with grain or flesh side of leather as shown		X
	Not clean, i.e., has dirt or grease		X
	Component is malformed, cracked, split, or bent out of shape	X	
	Burr, sharp edge, or rough spot		X
Leather component	Not one of the specified colors		X
	Not all the same color		X
	Not full grain; cut, tear, or thin area	X	
Welding	Spot weld missing where required	X	
	Not smooth and uniform		X
	Crack, burnt or reduced area, pinhole or slag		X
Molded webbing with aluminum ring	Not black color		X
	Crack, cut, hole or incomplete or thin coverage of aluminum ring		
		X	

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TABLE IV. Classification of defects (cont'd)

Examine	Defect	Classification	
		Major	Minor
Soldering	Collar or point not soldered where required	X	
	Soldered joint is incomplete, not sound, or rough. Contains pinholes or flux not removed.		X
Clinching of rivets and grommets	Not neatly and securely clinched		X
	Crack, split, or burr		X
Identification marking	Missing, wrong location, incomplete, illegible, incorrect, or not accomplished as specified		X

4.4.3.2 Dimensional examination. The ski poles shall be examined for compliance with dimensions specified. Any dimension that is not within the specified tolerance shall be classified as a defect. The inspection level shall be S-2 and the AQL shall be 4.0, expressed in terms of defects per hundred units.

- * 4.4.4 Packaging inspection. An examination shall be made to determine that preservation, packing, and marking are in compliance with section 5. Defects shall be as specified in table V. The sample unit shall be one shipping container fully packaged. The lot shall be the number of shipping containers offered for inspection at one time. The inspection level shall be S-2 and the AQL shall be 2.5, expressed in terms of defects per hundred units.

TABLE V. Examination of packaging

Examine	Defect
Marking	Missing; incorrect; incomplete; illegible; of improper size, location, sequence, or method of application
Materials	Any nonconforming component Any component missing, damaged, or otherwise defective
Workmanship	Bulged or distorted container Inadequate application of components such as; plywood not full sized, incomplete stapling, improper taping, or loose strapping
Contents	Quantity of poles per shipping container, as applicable, is more or less than required

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4.5 Methods of inspection.

4.5.1 Hardness. The hardness of the rubber compound for the webbing shall be determined in accordance with ASTM D 2240. Any specimen, representing the rubber compound, having an average hardness reading of less than 65 or more than 75 shall be classified as a defect.

4.5.2 Tensile strength. The tensile strength of the rubber compound for the webbing shall be determined in accordance with ASTM D 412. Any specimen, representing the rubber compound, having a tensile strength of less than 1500 psi shall be classified as a defect.

4.5.3 Elongation, ultimate. The ultimate elongation of the rubber compound for the webbing shall be determined in accordance with ASTM D 412. Any specimen, representing the rubber compound, having less than 400 or more than 600 percent elongation shall be classified as a defect.

4.5.4 Stiffness. The stiffness of the rubber compound for the webbing shall be determined in accordance with routine inspection procedure of ASTM D 1053 at a test temperature of $\text{minus } 55^{\circ}\text{C} \pm 0.5^{\circ}\text{C}$. The exposure time shall be a minimum of 10 minutes. The type of coolant shall be dry ice cooled methanol. The specimen of the rubber compound shall be 0.060 inch thick. Other specimen thicknesses may be used for the performance of this test provided the thickness of the specimen and relationship between specimen thickness and angular twist is in accordance with ASTM D 1053. Any 0.060 inch thick specimen, representing the rubber compound of the webbing, not capable of being twisted a minimum of 98 angular degrees shall be classified as a defect.

4.5.5 Resistance to cracking. The resistance to cracking of the rubber compound for the webbing shall be determined in accordance with ASTM D 1149 except the test specimen shall be a rubber slab measuring 3 by 3 by 1/2 inch minimum with a 1/8 inch maximum hole molded or punched in its center. The rubber slab shall be mounted on a 7/16 inch minimum diameter steel rod having a pointed end. The pointed end of the steel rod shall be forced through the 1/8 inch hole until the rubber slab has reached the full diameter of the rod and allowed to remain in this position during the seven day ozone-air expose test. After the seven day test period, the rubber slab shall constitute failure of the test and the rubber slab, representing the rubber compound, shall be classified as a defect.

4.5.6 Strength of bonding. The thickened rubber section at the end of juncture of the rubber and aluminum ring shall be slit laterally down to the aluminum ring with a knife or other sharp instrument. The edge of the rubber shall be grasped with a pair of pliers and pulled loose. Any clean separation of the rubber from the aluminum ring shall indicate failure of the strength of bonding test and the sample unit shall be classified as a defect.

* 4.5.7 Rockwell hardness. The Rockwell hardness of the shaft and point shall be tested in accordance with ASTM E 18. Any shaft having an average Rockwell hardness of less than 30 N 66 or more than 30 N 71 shall be classified as a defect. Any point having an average Rockwell hardness of less than 30 T 60 or more than 30 T 65 shall be classified as a defect.

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5. PACKAGING

- * 5.1 Preservation. Preservation shall be level A or Commercial as specified (see 6.2).

5.1.1 Level A. The wrist strap of each ski pole shall be unbuckled, extended out flat against the shaft, and secured in place with cotton tape. Two ski poles of one size only, with snow-rings together, shall be secured at each end with cotton tape. Cotton tape shall not be of the pressure-sensitive or adhesive-backed type.

- * 5.1.2 Commercial. Ski poles shall be preserved in accordance with MIL-STD-1188.

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

- * 5.2.1 Level A packing. Forty-eight ski poles of one size only, preserved as specified in 5.1, shall be packed in the most compact manner in a snug-fitting fiberboard shipping container conforming to style FTC, V3c or V3s of PPP-B-636. The ends of each shipping container shall be reinforced with 1/4 inch thick plywood extending the entire inside width and depth of the shipping container. Each shipping container shall be closed and reinforced with steel strapping or tape banding in accordance with the appendix of the container specification, except that the inspection shall be in accordance with 4.4.4.

- * 5.2.2 Level B packing. Forty-eight ski poles of one size only, preserved as specified in 5.1, shall be packed in the most compact manner in a snug-fitting fiberboard shipping container conforming to style FTC, type CF (variety SW) or SF, class domestic, grade 275 of PPP-B-636. The ends of each shipping container shall be reinforced with 1/4 inch thick plywood extending the entire inside width and depth of the shipping container. Each shipping container shall be reinforced with steel strapping or tape banding in accordance with the appendix of the container specification, except that the inspection shall be in accordance with 4.4.4.

- * 5.2.2.1 Weather-resistant container. When specified (see 6.2), the shipping container shall be V3c, V3s, or V4s fiberboard box fabricated in accordance with PPP-B-636 and closed in accordance with the appendix thereto except that the inspection shall be in accordance with 4.4.4.

- * 5.2.3 Level Commercial. Ski poles, preserved as specified in 5.1, shall be packed in accordance with MIL-STD-1188.

- * 5.3 Marking. In addition to any special marking required by the contract or purchase order, shipping containers shall be marked in accordance with MIL-STD-129 or MIL-STD-1188, as applicable.

6. NOTES

6.1 Intended use. The ski poles are intended for use by military skiers operating over variable snow cover on all types of slope and cross country terrain.

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

- (a) Title, number, and date of this document.
- (b) Size of pole required (see 1.2).
- (c) When a first article is required (see 3.1.2, 4.3, and 6.4).
- (d) Selection of applicable levels of preservation and packing (see 5.1 and 5.2).
- (e) When weather-resistant fiberboard is required for level B pack (see 5.2.2.1).

6.3 Samples. 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 DAR 7-104.55. The first article should be a preproduction sample, consisting of one completely finished ski pole. The contracting officer should include specific instructions in all acquisition documents regarding arrangements for inspection and approval of the first article.

6.5 Bonding material. Bonding materials conforming to Chemlok 205 or Chemlok 220, Hughson Chemical Company, Division of Lord Corporation, Erie, PA 16512 have been found to meet the performance requirement of the rubber webbing bonding to the aluminum ring specified in 3.3.4.

* 6.6 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 irrespective of the marginal notations and relationship to the last previous issue.

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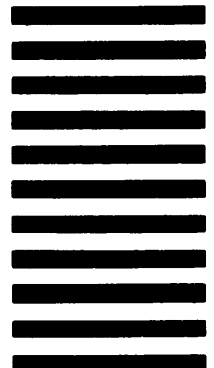
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