

INCH - POUND

MIL-R-24677A
AMENDMENT 1
31 March 1993

MILITARY SPECIFICATION
ROPE, FIBROUS, DOUBLE-BRAIDED (POLYESTER)

This amendment forms a part of MIL-R-24677A, dated 01 August 1991, and is approved for use by all Departments and Agencies of the Department of Defense.

PAGE 3

3.3.1: Delete and substitute:

"3.3.1 Fiber finish. Unless otherwise specified (see 6.2), the manufacturer shall use polyester fibers with a marine overlay finish that will ensure in the marine environment that the rope will give improved performance that is better than that of rope made of fibers without an overlay finish. The overlay finish must be highly water insoluble, must resist wash off due to contact with water, and have long term durability with respect to evaporation and reaction with ordinary outdoor marine environments. The finish shall improve the ability to resist internal fiber to fiber abrasion and external abrasion (see 4.4.1). The overlay finish provided shall not violate any other requirements of this specification."

3.4.1, Sentence 1, Line 2: Add the following after "size".

"The fiber producer shall provide type of yarn that has been designed for cordage and tested for its suitability for this application (see 6.3)."

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3.5 Line 2: Delete "4.5 and".

AMSC N/A

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FSC 4020

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distribution is unlimited.

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3.8, Line 2: Delete "kraft paper or".

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TABLE VII. Delete and substitute:

"TABLE VII. Component testing.

Characteristic	Requirement	Test method	Number of determinations per individual sample unit
Fiber:			
Type	3.3	<u>1/</u>	1
Linear density	3.3	4.4.1	1
Tenacity	3.3	4.4.1	1
Outer braid:			
Yarn size	3.4.1	Visual	1
Yarns per strand	Table II	Visual	1
Number of strands	Table II	Visual	1
Braid type	Table II	Visual	1
Multiplier	Table II	4.6.2.2	3
Heat setting	3.4	<u>1/</u>	1
Braider splices	3.10.1	<u>1/</u>	1
Marine finish	3.3.1	<u>1/</u>	1
Inter braid:			
Yarn size	3.4.1	Visual	1
Yarns per strands	Table I	Visual	1
Number of stands	Table I	Visual	1
Braid type	Table I	Visual	1
Multiplier	Table I	4.6.2.2	3
Heat setting	3.4	<u>1/</u>	1
Braider splices	3.10.1	<u>1/</u>	1
Marine finish	3.3.1	<u>1/</u>	1

1/ See 4.4.1"

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Add new paragraph:

"4.6.1.1 Splicing. For each specimen; each end shall have a buried eye splice as recommended by the manufacturer."

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6.2, Add the following:

"(o) When marine finish is not required (see 3.3.1)."

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6.3, Reference paragraph.

Line 1: Add "3.4.1".

Line 4: Add "3.4.1".

PAGE 19

30.1 Add:

"(g) Certification by the fiber contractor, that the yarns have been designed for cordage (see 3.4.1).

(h) Certification that the yarns have been tested for its suitability for this application (see 3.4.1)."

Preparing activity:
NAVY - SH
(Project 4020-0343)

Custodians:

Army - GL

Navy - SH

Air Force - 99

Review activities:

Air Force - 82

DLA - DISC-EHC

User activities:

Navy - CG, MC