

INCH-POUND

MIL-R-44375

30 June 1989

MILITARY SPECIFICATION

REPAIR KIT, SKI, SNOW AND ICE TRAVERSING EQUIPMENT (SITE)

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 bag containing materials, tools, and parts for use in the repair of skis and ski poles.

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, Development, and Engineering 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 8465

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

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SPECIFICATIONS

FEDERAL

- A-A-1043 - Steel Wool
- P-C-451 - Coated Abrasive, Cloth, Aluminum Oxide or Silicone Carbide
- QQ-W-461 - Wire, Steel, Carbon (Round, Bare, and Coated)
- DDD-L-20 - Label: For Clothing, Equipage, and Tentage, (General Use)
- GGG-D-671 - Drill; Hand, and Push
- GGG-P-471 - Pliers; Pliers, Slip Joint
- GGG-S-121 - Screwdriver and Screw Starter, Hand
- PPP-B-566 - Boxes, Folding, Paperboard
- PPP-B-636 - Boxes, Shipping, Fiberboard
- PPP-B-676 - Boxes, Set Up

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- MIL-P-116 - Preservation Method Of
- MIL-B-121 - Barrier Material, Greaseproofed Waterproofed, Flexible
- MIL-L-35078 - Loads, Unit: Preparation of Semiperishable Subsistence Items; Clothing, Personal Equipment and Equipage; General Specification For

STANDARDS

FEDERAL

- FED-STD-751 - Stitches, Seams, and Stitchings

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- 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 Avenue, 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.

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DRAWINGS

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

- 2-2-238 - Repair Kit, Ski, Military, All Terrain; File and Scraper
- 2-10-85 - Bag, Repair Kit, Ski, Military, All Terrain; Assembly and Illustration
- 2-10-86 - Bag, Repair Kit, Ski, Military, All Terrain; Details and Sections
- 2-10-108 - Hand Grip Assembly
- 2-10-111 - Basket Assembly
- 2-10-119 - Plug, Expansion

(Copies of drawings 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

E 18 - Rockwell Hardness Test

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103-1187.)

(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.

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3.2 Component parts. The ski repair kit shall consist of the items listed in table I, be in the stated quantities, and conform to the applicable referenced material or source.

TABLE I. Kit components

Item No.	Description	Source	Quantity
1	Bag, repair kit, ski, military, all terrain	Drawing 2-10-85	1
2	Scraper	Drawing 2-2-238	1
3	File	Drawing 2-2-238	1
4	Handgrip assembly	Drawing 2-10-108	2
5	Plug, expansion	Drawing 2-10-119	6
6	Basket assembly	Drawing 2-10-111	2
7	Pliers, slip joint, straight nose combination jaw w/cutter, regular, 6 inches	GGG-P-471, type II, class 2, style A	1
8	Screwdriver, flat tip, close quarter, 1 1/2 inch nominal length	GGG-S-121, type I, class 3	1
9	Wire, seizing, 0.048 inch diameter, 1/4 pound	QQ-W-461, carbon steel No. 1006, finish 1, annealed	1 spool
10	Drill, hand and push	GGG-D-671, type IV, class 1	1
11	Cloth, abrasive, aluminum oxide	P-C-451, type I, class I, 120 grit, 6 by 11 inch sheets	2
12	Tape, filament, reinforced 2 inch by 5 yards long, white translucent color, cold temperature capability	(see 6.4) <u>1</u> /	1 roll

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TABLE I. Kit components - Continued

Item No.	Description	Source	Quantity
13	Polyethylene repair candle, clear color	(see 6.4) <u>1/</u>	2
14	Steel wool	A-A-1043 type III, No. 1 medium	1/8 pound
15	Screwdriver-Pozidriv [®] number 3 point, 8-inch nominal length	(see 6.4)	1
16	Screws flat head with Pozidriv [®] recess, standard number 12 HB type, 16 mm long	(see 6.4)	12
17	Screws flat head with Pozidriv [®] recess, standard number 12AB type, 14 mm long	(see 6.4)	12
18	Structural adhesive kit, 4 ounce	Urethane epoxy, P/N 3535 (see 6.4) <u>1/</u>	1
19	Adhesive, climbing skin 3 1/2 fluid ounces	(see 6.4) <u>1/</u>	1

1/ Prior to inclusion as a component, the contractor shall submit any substituted "or equal" item, together with supporting data to the contracting officer for subsequent approval or disapproval by the responsible military agency.

3.3 Design and construction. The design and construction of the repair kit shall conform to the drawings listed in section 2 and to the requirements specified herein.

3.3.1 Scraper. The scraper shall meet the hardness requirement indicated on Drawing 2-2-238 when tested as specified in 4.4.5.

3.3.2 Stitches, seams, and stitching. All stitching shall conform to type 301 of FED-STD-751.

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3.3.2.1 Automatic stitching. Automatic stitching machines may be used to perform any of the required stitch patterns provided the requirements for 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 stitching.

3.3.2.2 Lubrication of thread. There shall be no lubrication of the thread by any means prior to or during sewing (see 4.4.1.1).

* 3.3.2.3 Type 301 stitching. Ends of all stitching shall be backstitched or overstitched 1/2 inch minimum except when caught in other stitching or turned under in a hem. Thread tension shall be maintained so that there will be no 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.

3.3.2.3.1 Repairs of type 301 stitching. Repairs of type 301 stitching shall be as follows:

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

b. Thread breaks or two or more consecutive skipped or run-off stitches noted during inspection of the item (in-process or end item) shall be repaired by overstitching. The stitching shall start a minimum of 1 inch in back of the defective area (1/2 inch on box, box-x, and W-W stitching) and continue a minimum of 1 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.

(When making the above repairs in a. and b. above, the ends of the stitching are not required to be backstitched.)

3.3.2.4 Thread ends. All thread ends that are visible on the finished item shall be trimmed to a length of not more than 1/4 inch.

3.4 Marking. Marking for the bag shall conform to the requirements of type IV, class 5 of DDD-L-20. The marking shall be placed on the inside of the pocket body (item 4 of Drawing 2-10-86) so as to be readable when the bag is opened.

3.4.1 Location marks. Location marks shall not be drilled. Printed markings for component location shall not be more than 1/32 inch wide.

3.5 Repairs. Repairs such as mends, darns, patches, or splices are not permitted on the bag.

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3.6 Replacement of defective components. During the spreading, cutting, and manufacturing process, components of the bag having material defects or damages that are classified as defects in 4.4.3 shall be removed from production and replaced with nondefective and properly matched components.

3.7 Finish. All components shall be finished in accordance with the applicable requirements of referenced documents. Commercial items shall be finished in accordance with the manufacturer's standard practice.

3.8 Workmanship. The end item shall conform to the quality of product established by this specification.

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.

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 Responsibility for dimensional requirements. Unless otherwise specified in the contract or purchase order, the contractor is responsible for ensuring that all specified dimensions have been met. When dimensions cannot be examined on the end item, inspection shall be made at any point, or at all points in the manufacturing process necessary to ensure compliance with all dimensional requirements.

4.1.3 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.

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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 4.4.3 and 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 Component and material certification. A certificate of compliance may be acceptable as evidence that the thread has not been lubricated during sewing as specified in 3.3.2.2.

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 Drawings 2-10-85 and 2-10-86. The Government reserves the right to exclude from consideration for acceptance, any material or service for which in-process inspection has indicated nonconformance.

4.4.3 End item visual examination. The end items shall be examined for the defects listed in table II. The lot size shall be expressed in units of repair kits. The sample unit shall be one repair kit. The inspection level shall be II (see 6.5).

TABLE II. End item visual defects

Examine	Defect	Classification	
		Major	Minor A B
Fabric	Cut, tear, or hole	101	
	Broken or missing yarns; multiple floats clearly visible at normal inspection distance (approximately 3 feet)		201
	Not color specified		202

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TABLE II. End item visual defects - Continued

Examine	Defect	Classification	
		Major	Minor A B
Webbing	Any cut, hole, tear, or smash	102	
	Edge frayed or scalloped	103	
	Exposed ends not seared		203
	Exposed ends not seared as specified		301
	Improperly assembled	104	
Fastener tape, hook and pile	Any hole, cut, or tear	105	
	Hooks missing or flattened impairing function		204
Buckle	Missing, malformed, or not type specified	106	
	Incorrectly located	107	
Seams and stitching	Open seams: - more than 1 inch	108	
	- more than 1/4 inch but not more than 1 inch		205
	- 1/4 inch or less		302
	NOTE: A seam shall be classified as open when one or more stitches joining a seam are broken or when one or more skipped or run-off stitches occur.		
	Thread breaks overstitched less than 1 inch		303
	NOTE: Thread breaks not overstitched shall be classified as open seams. Needle chews resulting in cut, tear, or hole (see cut, tear, or hole under "Fabric")		
	Mends or darns	109	
Seam type	Wrong seam type	110	
Stitch type	Wrong stitch type	111	

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TABLE II. End item visual defects - Continued

Examine	Defect	Classification	
		Major	Minor A B
Stitch tension	Loose, resulting in an exposed bobbin or top thread for more than 2 inches		304
	Tight, as evidenced by puckering on seams for more than 2 inches		305
Stitches per inch	Less than minimum specified:		
	- one stitch		306
	- two or more stitches	206	
	More than maximum specified:		
- one stitch		307	
- two or more stitches	207		
	NOTE: Variation in the number of stitches per inch caused by the operator speeding up the machine and pulling the fabric in order to sew over heavy places or heavy seams or in turning corners shall be classified as follows:		
	a. Within the minor "B" defect classification - no defect		
	b. Within the minor "A" defect classification - minor B defect		
Stitching margin	Less than specified or larger than specified by more than 3/16 inch:		
	- 4 inches or more in length - less than 4 inches in length		208 308
Stitching ends	Backstitched or overstitched less than 1/2 inch (except where ends are held down by other stitching or turned under in a hem)		309
Components and assembly	Any component missing, damaged, or malformed	112	
	Any component not size, type, or quantity specified	113	
	File modification omitted or not as specified	114	

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TABLE II. End item visual defects - Continued

Examine	Defect	Classification	
		Major	Minor A B
Components and assembly (cont'd)	Any improper assembly or other departure from specified design	115	
	Any dirt, grease, oil, or other foreign substance		310
	Any burrs, sharp edges, or metal slivers		209
Marking	Omitted, incorrect, not type, size, or location specified		210

4.4.4 End item dimensional examination. The end item components listed below shall be examined for conformance to the dimensions specified on the indicated drawings. Only those dimensions that can be evaluated without damaging or disassembling the components 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 repair kits. The sample unit shall be one repair kit. The inspection level shall be S-2 (see 6.5).

<u>Component</u>	<u>Applicable drawing</u>
Scraper	2-2-238
File	2-2-238
Hand grip assembly	2-10-108
Basket assembly	2-10-111
Plug, expansion	2-10-119

4.4.5 Hardness testing. The scraper shall be tested for conformance to the specified hardness requirement in accordance with ASTM E 18. The lot size shall be expressed in units of scrapers. The sample unit shall be one scraper. The inspection level shall be S-2 (see 6.5).

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4.4.6 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>Defect</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 (interior and exterior container)	Number per container is more or less than required

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

<u>Examine</u>	<u>Defect</u>
Finished dimensions	Length, width, or height exceeds specified maximum requirement
Palletization	Pallet pattern not as specified Interlocking of loads 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

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5. PACKAGING

5.1 Preservation. Preservation shall be level A.

5.1.1 Level A.

5.1.1.1 Preservative application. All exposed, uncoated ferrous metal surfaces of the kit components shall be cleaned process C-1, thoroughly dried, and coated with type P-7 preservative of MIL-P-116. The preserved tools shall be individually wrapped or bagged in barrier material conforming to type I or II, grade A, class 1 or 2 of MIL-B-121. Each wrap shall be secured with gummed paper or pressure-sensitive tape, or heat-sealed when heat-sealable material is used. All seams and closures of each bag shall be sealed.

5.1.1.2 Unit packing. The quantities of screws required as specified in 3.2, shall be placed in individual drawstring cloth bags with a label affixed to each bag indicating its contents. All the components of the repair kit shall then be placed in the kit bag and the bag securely closed by the fasteners provided. Each complete kit shall be unit packed in a snug-fitting folding or setup paperboard box or fiberboard box conforming to variety 1, style III, type G, class i or style IV, type J, class i of PPP-B-566; type I, variety 1, class A, style 1 or 2 of PPP-B-676; or style RSC, type CF, variety SW or type SF, class domestic of PPP-B-636, respectively. The inside dimensions of the box shall be approximately 15 3/4 inches in length, 5 3/4 inches in width and 3 1/2 inches in depth. Box closure shall be in accordance with the appendix of the applicable box document.

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

5.2.1 Level A packing. Twelve kits preserved as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC, grade V2s of PPP-B-636. Inside dimensions of the box shall be approximately 24 inches in length, 16 inches in width and 11 inches in depth. 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, except that the inspection shall be in accordance with 4.4.6. 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.

5.2.2 Level B packing. Twelve kits preserved and packaged as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC, type CF (variety SW) or SF, class domestic, grade 275 of PPP-B-636. Inside dimensions of the box shall be approximately 24 inches in length, 16 inches in width and 11 inches in depth. Each shipping container shall be closed in accordance with method II as specified in the appendix of PPP-B-636, except that the inspection shall be in accordance with 4.4.6.

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5.2.2.1 Weather-resistant fiberboard containers. When specified (see 6.2), the shipping container shall be V3c, V3s, or V4s, fabricated in accordance with PPP-B-636, and closed in accordance with method III as specified in the appendix of PPP-B-636, except that the inspection shall be in accordance with 4.4.6.

5.2.3 Commercial packing. Kits preserved as specified in 5.1, shall be packed in accordance with ASTM D-3951.

5.3 Palletization. When specified (see 6.2), kits packed as specified in 5.2.2 or 5.2.3 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 K and L, or film bonding means O or P. Pallet pattern shall be number 3 in accordance with the appendix of MIL-STD-147.

5.4 Marking. In addition to any special marking required by the contract or purchase order unit packs, 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 repair kit is intended for making ski, ski binding, and ski pole repairs in the field.

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. Levels of preservation and packing (see 5.1 and 5.2).
- e. Type and class of unit load (see 5.2.1).
- f. When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).
- g. When palletization is required (see 5.3).
- h. Acceptance criteria required (see 6.5).

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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.

6.4 Sources of supply. The following sources of supply for items may be used:

<u>Item No.</u>	<u>Reference</u>	<u>Item</u>	<u>Source</u>
12	Table I	Tape, filament, reinforced	Minnesota Mining and Mfg. Co. P/N Y-8951, Scotch Brand Filament Tape 935 Bush Avenue St. Paul, MN 55133
13	Table I	Polyethylene repair candle, color clear	F.H. Wiessner Company 159 Lakeside Avenue Burlington, VT 05401 Belconta Corp. 50 Executive Blvd. Elmsford, NY 10523 Ski Care, Inc. P.O. Box 1439 Berthoud, CO 80513
15	Table I	Screwdriver-Pozidriv®	Ski Care, Inc. P.O. Box 1439 Berthoud, CO 80513 The Tool Co. P.O. Box 47 Concord, NH 03301
16 and 17	Table I	Screws flat head with Pozidriv® recess	The Tool Co. P.O. Box 47 Concord, NH 03301 Climb High, Inc. P.O. Box 9210 South Burlington, VT 05401

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<u>Item No.</u>	<u>Reference</u>	<u>Item</u>	<u>Source</u>
18	Table I	Structural adhesive kit	Minnesota Mining and Mfg. Co. P/N 3535 or Equal
19	Table I	Adhesive, climbing skin	Montana Sports, Inc., USA Limited 7770 East Llif Ave. No. D Denver, CO 80231

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 specified, 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 2.5 for major defects, 6.5 for major and minor A combined defects, and 15.0 for total (major, minor A and minor B combined) defects.

6.5.2 For end item dimensional examination. An AQL, expressed in terms of defects per hundred units, of 4.0 is recommended.

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

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

6.5.5 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).

Bindings, ski
Equipment, snow
Poles, ski
Repair, ski equipment

Custodians:

Army - GL
Navy - MC

Review activities:

Army - MD
DLA - CT

Preparing activity:

Army - GL
(Project 8465-0018)

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