

MIL-S-3276H
17 June 1986
SUPERSEDING
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MILITARY SPECIFICATION

SEWING KITS

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

1. SCOPE

1.1 Scope. This document covers sewing kits with contents for repairing clothing.

1.2 Classification. The kits shall be of the following classes and styles, as specified (see 6.2).

Class 1	-	Army
Style 1	-	Male
Style 2	-	Female
Class 2	-	Air Force

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.

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 8315

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

MIL-S-3276H

SPECIFICATIONS

FEDERAL

C-F-206	- Felt Sheet: Cloth, Felt, Wool, Pressed
L-P-375	- Plastic Film, Flexible, Vinyl Chloride
L-P-378	- Plastic Sheet and Strip, Thin Gauge, Polyolefin
V-B-871	- Button, Sewing Hole, and Button, Staple, (Plastic)
V-T-276	- Thread, Cotton
FF-P-416	- Pins, Safety
PPP-B-566	- Boxes, Folding, Paperboard
PPP-B-636	- Boxes, Shipping, Fiberboard
PPP-B-676	- Boxes, Setup
PPP-T-45	- Tape, Gummed, Paper, Reinforced and Plain, For Sealing and Securing

MILITARY

MIL-B-3461	- Buttons, Insignia, Metal, Uniform and Cap
MIL-F-10884	- Fasteners, Snap
MIL-L-35078	- Loads, Unit: Preparation of Semiperishable Subsistence Items; Clothing, Personal Equipment and Equipage: General Specification For

STANDARDS

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
MIL-STD-731	- Quality of Wood Members for Containers and Pallets

(Copies of documents required by contractors 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)

D 882	- Tensile Properties of Thin Plastic Sheeting
D 3951	- Standard Practice for Commercial Packaging

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

MIL-S-3276H

(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 (except for associated detail specifications, specification sheets or MS standards), the text of this document shall take precedence. Nothing in this document, however, shall supersede applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

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

3.2 Materials.

3.2.1 Basic material. The basic material shall be 0.020 inch thick colorless flexible, vinyl chloride film conforming to type I, class 1 of L-P-375, except that the film may have a smooth dull matte finish on both sides, or one or both sides may be planished.

3.2.2 Felt. The felt for the inside flap shall conform to type III, classification 10A2 of C-F-206.

3.2.3 Fasteners, snap. The fastener shall be style 3, male and female, finish 2, conforming to MIL-F-10884.

3.2.4 Polyethylene bag. The buttons, composition and metal, shall be packaged in a bag of polyethylene film, 0.0020 inch thick, conforming to type I, grades A, B or C, finish 1, of L-P-378. The bag shall measure $2\frac{1}{4} \pm \frac{1}{16}$ inches wide with an inside minimum length of 6 inches.

3.2.5 Contents of kit.

3.2.5.1 Safety pins. The safety pins shall be furnished without a guard in size 1 (ten each), size 2 (two each) and size 3 (two each) and shall conform to FF-P-416. The size 1 safety pins shall be mounted on a plain card, $1\frac{1}{2}$ to 2 inches by $3\frac{1}{2}$ to 4 inches in size. When magnetic safety pins (those attracted to a magnet) are used, the pins shall show no indication of corrosion, when tested as specified in 4.3.1.

3.2.5.2 Needles. The needles shall be steel, Sharps hand sewing needles, with a nickel plated finish, in size numbers 2 and 4 (four each size) (see 6.4).

3.2.5.3 Buttons, plastic. The buttons shall conform to type II, class D for all colors, except the Polyester White BA buttons listed in table III which shall be class K of V-B-871. The quantities, styles, sizes and colors shall be

MIL-S-3276H

as indicated in tables I, II and III. Unless otherwise indicated in the tables the finish shall be glossy.

3.2.5.4 Buttons, metal. The metal uniform buttons shall conform to type I, style 2, class A or B of MIL-B-3461. The size 25-line buttons shall have a short shank or hopper back and the 36-line buttons shall have a regular shank. The quantities and sizes shall be as indicated in tables I and II.

3.2.5.5 Seam ripper. A seam ripper shall be furnished with each kit. The overall length shall not exceed 4 inches and the blade shall be 1 inch minimum (see 6.5).

3.2.5.6 Braided thread. The thread in the braids shall conform to type IA2 and IA3, ticket No. 30, 3 ply, or ticket No. 40, 3 ply, of V-T-276, in colors indicated in tables I, II and III. Each thread in the braid shall be not less than 24 inches long and the braid itself shall be 21 ± 1 inches long. The braid shall be of sufficient looseness to permit the withdrawal of a single thread without difficulty and shall have not less than 7 picks per inch. The number of carriers and ends per carrier shall be as indicated in tables I, II and III. Testing shall be as specified in 4.2.1.1.

3.2.5.6.1 Colorfastness. The thread shall show fastness to light and laundering equal to or better than the standard samples. When no standard samples are available, the colored thread shall show "good" fastness to light and laundering.

TABLE I. Buttons and braided thread, class 1, style 1 kit (Army-Male)

Buttons	Quantity	Style	Size(line)	Color and Cable No.
Plastic	6	26	30	Olive Green BP 62016-dull
	2	20 or 21	24	Black BT 62001
	2	20 or 21	30	Black BT 62001
	2	20 or 21	40	Black BT 62001
	2	15	18	Black BT 62001
	2	4	22	Army Green BR 62015
	4	25	19	White BA, C.A. 62031
Metal (Uniform)	2	2, class A or B	36	Gold Plated
	2	2, class A or B	25	Gold Plated
Braid	Number of carriers	Ends per carrier		Color and Cable No.
Thread	8	6		Olive Drab 66022
	8	6		Green E 66034
	5	6		Black AA 66043
	8	6		Bleached White AH 66050

MIL-S-3276H

TABLE II. Buttons and braided thread, class 1, style 2 kit (Army-Female)

Buttons	Quantity	Style	Size(line)	Color and Cable No.
Plastic	6	26	30	Olive Green BP 62016-dull
	2	20 or 21	24	Army Green BR 62015
	2	20 or 21	24	Black BT 62001
	2	20 or 21	30	Black BT 62001
	2	20 or 21	40	Black BT 62001
	2	15	18	Black BT 62001
	4	25	17	Poly Army Green BR 62015
	4	25	21	Poly Army Green BR 62015
Metal (Uniform)	2	2, class A	30	Gold Plated
	2	2, class A	25	Gold Plated

Braid	Number of carriers	Ends per carrier	Color and Cable No.
Thread	8	6	Olive Drab 66022
	8	6	Lt. Green Y 66042
	5	6	Black AA 66043
	8	6	Green E 66034

TABLE III. Buttons and braided thread, class 2 kit (Air Force)

Buttons	Quantity	Style	Size(line)	Color and Cable No.
Plastic	2	20 or 21	40	Blue BU 62002
	4	20 or 21	24	Blue BU 62002
	1	20 or 21	30	Blue BU 62002
	2	4	22	Blue BV 62003
	2	20 or 21	24	Blue BV 62003
	2	24	20	Blue BV 62003
	6	26	30	Olive Green BP 62016-dull
	10	25	19	Polyester
				White BA 62031

MIL-S-3276H

TABLE III. Buttons and braided thread, class 2 kit (Air Force (cont'd)

Braid	Number of carriers	Size(line)	Color and Cable No.	
Thread	5	6	Blue M	66027
	8	6	Navy	66060
			Blue AT	
	8	6	Olive	66022
	8	6	Drab S-1	
			White AH	66050

3.3 Design. The kit is a one piece type with an upper and lower pocket and an inserted felt pad. It is closed by folding on itself and secured by means of a snap fastener (see figures 1 and 2).

3.4 Construction.

3.4.1 Cutting. The component parts of the kit shall be cut to conform with measurements shown on figures 1 and 2.

3.4.2 Attach felt pad and upper pocket. The upper pocket shall be positioned on the curved end of body piece with the side edges of the pocket even with the side edges of the body piece. The felt pad shall be inserted under the bottom edge of the upper pocket for a distance of 1/4 to 3/8 inch. The bottom edge of the upper pocket and the body piece shall be heat sealed to the felt pad with a 1/8 inch wide (minimum) seal in such a manner as to hold the pad securely in place.

3.4.3 Form bottom pocket and seal side seams. The bottom end of body piece shall be turned up at the fold-line as indicated on figure 1, forming the lower pocket, or the lower pocket may be a separate piece (4-3/4 by 2-1/2 inches, see figure 1). Heat seal the side edges of the upper and lower pocket and the bottom edge of the lower pocket if a separate piece (flat seam), using a 1/8 to 3/16 inch wide heat seal. The strength of the heat seal bond shall be not less than 22 pounds when tested as specified in 4.2.4. The outside edges of the finished kit shall be embossed, but not more than 3/16 inch from the edge.

3.4.4 Attach snap fasteners. The snap fasteners shall be attached as indicated on figures 1 and 2. The stud portion shall not pass through the felt.

3.5 Placement of contents in kits.

3.5.1 Buttons. Buttons for each kit shall be packaged in a polyethylene bag (see 3.2.4), in the quantities indicated in tables I, II, and III and placed in the lower pocket of kit. The bag shall be closed by folding back the unfilled portion of the bag.

MIL-S-3276H

3.5.2 Braided thread. The braided thread shall be folded and inserted into the upper pocket of kit.

3.5.3 Seam ripper. The seam ripper shall be placed in the upper pocket of the kit below the braided thread.

3.5.4 Safety pins. The card with the ten safety pins (size 1) shall be placed in the upper pocket of the kit behind the braid with the back of the card next to the kit. The two size No.2 and the two size No.3 safety pins (see 3.2.5.1) shall be pinned to the felt strip parallel to the top and bottom of kit.

3.5.5 Needles. The four needles of each size (see 3.2.5.2) shall be attached to the felt strip parallel to the top and bottom of kit.

3.6 Workmanship. The finished kits shall conform to the quality of product established by this document. The 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 contractor is responsible for the performance of all inspection requirements 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 the document where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.1.1 Responsibility for compliance. All items must meet all requirements of sections 3 and 5. The inspection set forth in this document shall become part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the document shall not relieve the contractor of the responsibility of assuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling in quality conformance does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to acceptance of defective material.

4.1.2 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.

4.2 Quality conformance inspection. Unless otherwise specified, sampling for inspection shall be performed in accordance with MIL-STD-105.

MIL-S-3276H

4.2.1 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 document or applicable purchase document.

4.2.1.1 Certification. The contractor shall furnish a certificate of compliance for the requirements specified below.

<u>Component</u>	<u>Requirement</u>	<u>Requirement paragraph</u>
Magnetic safety pins (when used)	Resistance to corrosion	3.2.5.1
Braided thread	Picks per inch	3.2.5.6
	Ends per carrier	3.2.5.6
	Number of carriers	3.2.5.6
	Braid looseness	3.2.5.6
	Thread length	3.2.5.6

4.2.2 End item visual examination. The end item shall be examined for the defects listed in table IV. The lot size shall be expressed in units of kits. The sample unit shall be one kit. The inspection level shall be I and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 6.5.

TABLE IV. End item visual defects

<u>Examine</u>	<u>Defect</u>
Material (plastic film)	Cut, tear, or hole. Scratch, crease or blister more than 1/4 inch in diameter or length. Spot, stain, or imbedded foreign matter more than 1/4 inch in diameter. Does not have a smooth dull matte finish on both sides, or one or both sides may be planished.
Felt pad	Cut, tear, or hole (a single nick in the edge of the felt which does not extend beyond 1/8 inch shall not be considered a defect).
Snap fastener	Either part missing, split, or broken. Not securely attached. Material damaged by attachment of fastener. Damaged or otherwise impaired, affecting function.

MIL-S-3276H

TABLE IV. End item visual defects (cont'd)

Examine	Defect
Construction	<p>Seam construction not as specified.</p> <p>Any seam not completely sealed.</p> <p>Felt pad not completely caught in seam or not securely held in place.</p> <p>Felt pad inserted less than 1/4 or more than 3/8 inch under bottom edge of upper pocket.</p> <p>Snap fastener through the felt pad.</p> <p>Any component omitted.</p> <p>Any seam puckered or distorted in heat sealing.</p> <p>Width of heat seal less than 1/8 inch.</p> <p>Embossing omitted, incomplete, or more than 3/16 inch from edge.</p> <p>Kit (complete with contents) cannot be folded on itself and snapped satisfactorily.</p>
Plastic buttons	<p>Not in conformance with type, class and style specified.</p> <p>Color or finish not as specified.</p> <p>Nicked, cracked, scratched, disfigured, or malformed.</p> <p>Sharp edges around periphery or in sewing holes.</p> <p>Stains or foreign matter imbedded.</p> <p>Quantities and sizes not as specified.</p> <p>Flash not removed from holes.</p>
Metal buttons	<p>Not in conformance with type, class, style, and kind of back or shank, specified.</p> <p>Color and finish not as specified.</p> <p>Discoloration, stain, or foreign matter imbedded.</p> <p>Disfigured, or malformed.</p> <p>Sharp edges.</p> <p>Quantities and sizes not as specified.</p>
Braided threads	<p>Entire braid missing.</p> <p>Finished length less than 20 inches or more than 22 inches.</p> <p>Wrong color of one or more ends.</p>
Safety pins	<p>Any omitted (ten size 1 and two each of size 2 and 3 required).</p> <p>Malformed, or damaged, affecting function.</p> <p>Point blunted.</p> <p>Size 1 safety pins not mounted on card as specified.</p> <p>Area with no finish.</p>

MIL-S-3276H

TABLE IV. End item visual defects (cont'd)

<u>Examine</u>	<u>Defect</u>
Needles	Any omitted. Any visible evidence of corrosion. Defective, affecting function.
Seam ripper	Not within specified length. Malformed, or damaged, affecting function.
Polyethylene bags	Cut, tear, or hole. Less than 2-3/16 or more than 2-5/16 inch wide. Inside length less than 6 inches.
Placement of contents	Any of the contents not placed in kit as specified.

4.2.3 End item dimensional examination. The end item shall be examined for conformance to all dimensions shown on figures 1 and 2. Any dimension not within the specified tolerance shall be classified as a defect. The lot size shall be expressed in units of kits. The sample unit shall be one complete kit. The inspection level shall be S-2 and the AQL, expressed in terms of defects per hundred units, shall be 4.0.

4.2.4 End item testing. The end item shall be tested for bonding strength of seal. The bonding strength of seal shall be determined as specified in ASTM D 882, except that no autographic stress-strain curve is required. The test specimens shall be 1 inch wide with the seam in the center of the specimen perpendicular to the long dimension of the specimen. The free ends of the specimen shall be clamped (one in each jaw) in the testing machine. The sample unit shall be one kit without contents. The sampling for testing shall be in accordance with table V and the lot shall be unacceptable if one or more sample units fail to meet the heat seal requirement specified in 3.4.3.

TABLE V. Sample size

<u>Lot size (kits)</u>	<u>Sample size (sample units)</u>
800 or less	2
801 up to and including 22,000	3
22,001 and over	5

4.2.5 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

MIL-S-3276H

packaged. The inspection level shall be S-2 and the AQL, expressed in terms of defects per hundred units, shall be 2.5.

<u>Examine</u>	<u>Defect</u>
Marking (exterior and unit packs)	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 closure of container flaps, improper taping, loose strapping, or inadequate stapling. Bulged or distorted container.
Content	Number of kits per shipping container is more or less than required. Number of kits per unit pack is more or less than required. <u>1/</u>

1/ For this defect, one unit pack from each container in the sample shall be examined.

4.2.6 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, and the AQL, expressed in terms of defects per hundred units, shall be 6.5.

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

4.3 Method of inspection.

4.3.1 Resistance to corrosion test. Score the safety pins on body and head with a file to expose material below the surface. Place the safety pins in a boiling solution of 10 percent sodium chloride contained in a glass beaker for a period of not more than 30 minutes and then allow to remain submerged for a

MIL-S-3276H

period of 24 hours. After expiration of 24 hours immersion, the pins shall be examined to determine compliance with the requirements of 3.2.5.1.

5. PACKAGING

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

5.1.1 Level A. Twelve kits of one class and style only, shall be preserved in a folding paperboard box conforming to variety 1, style III, type G, class i, group I of PPP-B-566 or set-up paperboard box conforming to type I, variety 1, class A, style 4 of PPP-B-676. Inside dimensions of each paperboard box shall be 13-1/2 inches in length, 4-3/4 inches in width and 2-1/2 inches in depth. Box closure shall be secured with 2-inch minimum paper gummed tape conforming to type III, grade A of PPP-T-45.

5.1.2 Commercial. Sewing kits shall be preserved in accordance with ASTM D 3591.

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

5.2.1 Level A packing. Three hundred kits of one class and style only, preserved as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC, grade V2s of PPP-B-636. Level A unit packs shall be packed flat, five in length, one in width, and five in depth within a shipping container. Inside dimensions of each shipping container shall approximate 25-1/2 inches in length, 14-1/4 inches in width, and 13-1/4 inches in depth. Approximate dimensions are furnished as a guide only. 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 4.2.5. 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. Three hundred kits of one class and style, preserved as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC, type CF (variety SW) or SF, class domestic, grade 275 of PPP-B-636. Level A unit packs shall be packed flat, five in length, one in width, and five in depth within a shipping container. Inside dimensions of each shipping container shall approximate 25-1/2 inches in length, 14-1/4 inches in width, and 13-1/4 inches in depth. Approximate dimensions are furnished as a guide only. Each shipping container shall be closed in accordance with method II as specified in the appendix of PPP-B-636, except that inspection shall be in accordance with 4.2.5.

MIL-S-3276H

5.2.2.1 Weather-resistant containers. 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 PPP-B-636, except that the inspection shall be in accordance with 4.2.5.

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

5.3 Palletization. When specified (see 6.2), sewing kits packed as specified in 5.2, 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 number 91 shall be used in accordance with Appendix D 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

6.1 Intended use. The sewing kits are for use by military personnel in repairing clothing.

6.2 Ordering data. Acquisition documents should specify the following:

- a. Title, number, and date of this document.
- b. Class and style required (see 1.2).
- c. Selection of applicable levels of preservation 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).
- f. Type and class of unit load required (see 5.2.1).

6.3 Samples. For access to end item and shade samples, address the contracting activity issuing the invitation for bids or request for proposal.

6.4 Needle descriptions. Sharps are round-eyed needles used for general hand sewing. The length of size 2 needles is 1-3/4 inches and the diameter is 0.034 inch. The length of size 4 needles is 1-11/16 inches and the diameter is 0.030 inch.

MIL-S-3276H

6.5 Seam ripper. Seam rippers conforming to Scovill Model 608 and Sunbrand Stock No. T8296 have been found to meet the requirements of 3.2.5.5. Source of supply are as follows:

Scovill Manufacturing Company, Sewing Notions Division,
P.O. Box 5028, Spartanburg, SC 29301

Sunbrand Division of Wilcox Gibbs, 3900 Green Industrial Way
Atlanta, GA 30341

6.6 Changes from previous issue. Asterisks are not use in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.

Custodians:

Army - GL
Air Force - 99

Review activities:

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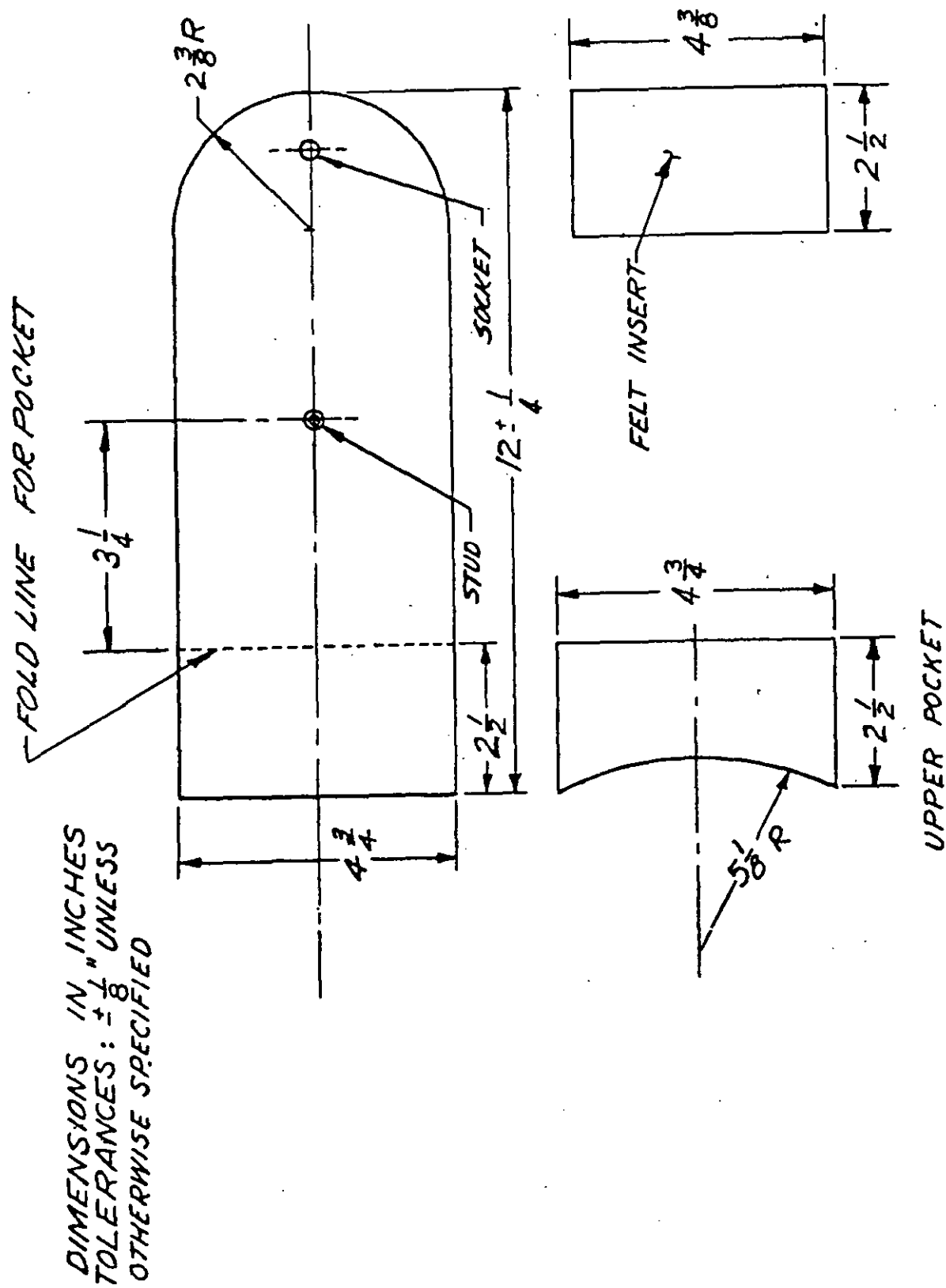


FIGURE 1 - SEWING KIT
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MIL-S-3276H

DIMENSIONS IN INCHES
TOLERANCES: $\pm 1/8$ " UNLESS
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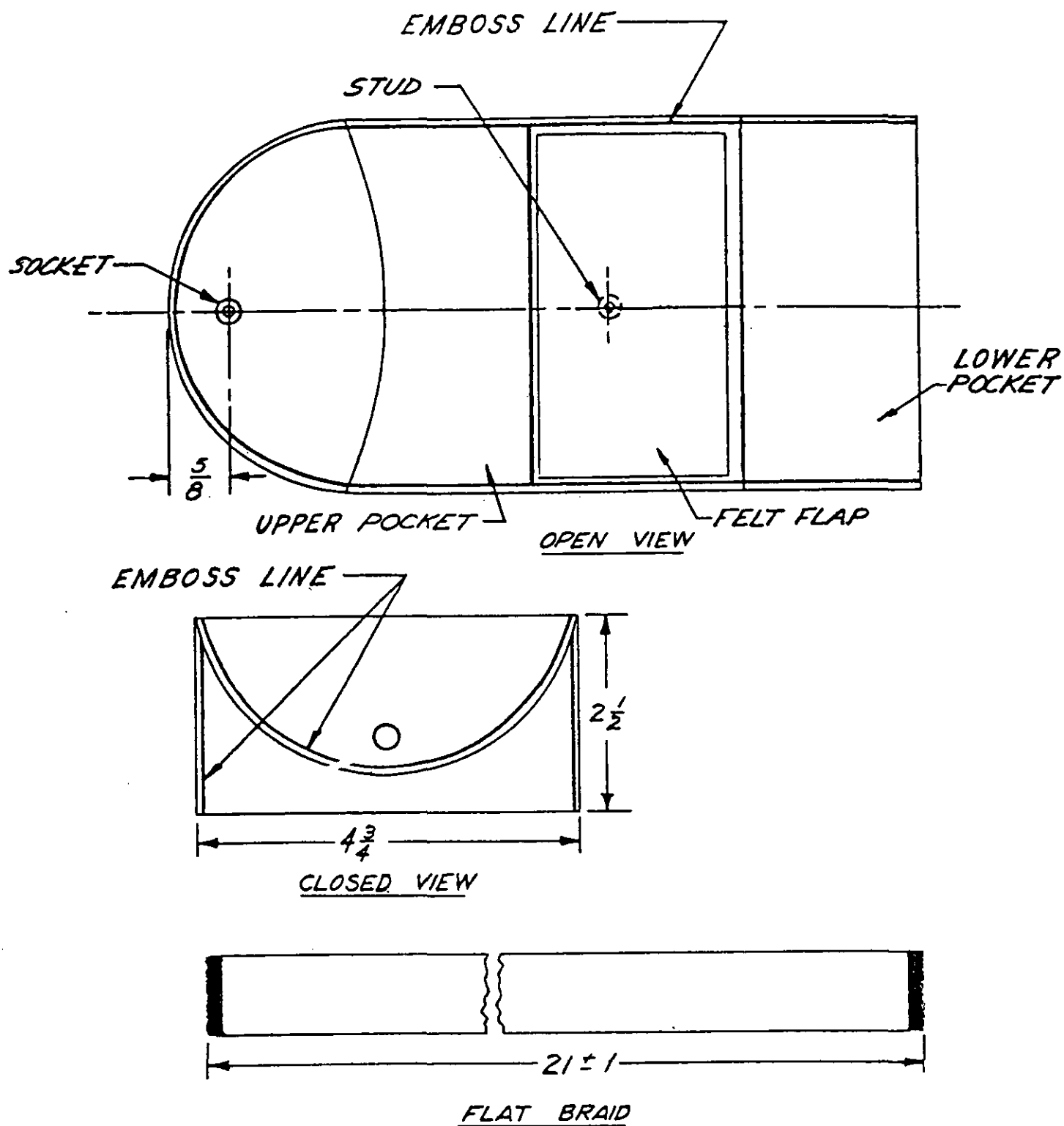


FIGURE 2 - SEWING KIT

2-1-422E

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