

MIL-S-8784B
13 Apr 1971
SUPERSEDING
MIL-S-8784A
24 May 1958

MILITARY SPECIFICATION

SEALING COMPOUND, LOW ADHESION, FOR REMOVABLE PANELS AND FUEL TANK INSPECTION PLATES

This specification has been approved by the Department of Defense and is mandatory for use by the Departments of the Army, the Navy, and the Air Force.

1. SCOPE

1.1 Scope. This specification covers two classes of accelerated synthetic rubber compounds for sealing access doors and accessories of integral fuel tanks, fuel cell cavities and accessories where gaskets are required.

1.2 Classification. The sealants shall be of the following classes, as specified (see 6.2):

Class A - Sealing material suitable for brush application.

Class B - Sealing material suitable for application by injection or extrusion gun and spatula.

1.2.1 Dash numbers. The following dash numbers shall be used to designate the minimum application time in hours.

Class A dash numbers shall be -1/2, -2.

Class B dash numbers shall be -1/2, -2.

EXAMPLE: Class A-2 shall designate a brushable material having 2 hours application time. Class B-1/2 shall designate an extrusion-gun material having an application time of 1/2 hour.

2. APPLICABLE DOCUMENTS

2.1 The following specifications and standards, of the issue in effect on date of invitation for bids, form a part of this specification to the extent specified herein:

FSC 8030

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SPECIFICATIONS

Federal

QQ-A-250/13	Aluminum Alloy Alclad 7075, Plate and Sheet
TT-E-751	Ethyl Acetate, Technical
TT-M-261	Methyl-Ethyl-Ketone, Technical
TT-N-97	Naptha, Aromatic
TT-I-735	Isopropyl Alcohol
TT-S-735	Standard Test Fluids, Hydrocarbon
CCC-C-432	Cloth, Cotton, Sheetting (Unbleached, Bleached and Dyed)
PPP-B-636	Boxes, Fiber
PPP-C-96	Cans, Metal, 28 Gage and Lighter

Military

MIL-I-631	Insulation, Electrical, Synthetic Resin Composition, Nonrigid
MIL-P-38714	Packaging and Packing of Two Component Materials in Semkits

STANDARDS

Federal

FED TEST METHOD STD NO. 601	Rubber Sampling and Testing
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Military

MIL-STD-105	Sampling Procedures and Tables for Inspection by Attributes
MIL-STD-129	Marking for Shipment and Storage

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

2.2 Other publications. The following documents form a part of this specification. Unless otherwise indicated, the issue in effect on date of invitation for bids, shall apply.

American Society for Testing Materials Standard Designation

ASTM D2240	Indentation Hardness of Rubber and Plastics by Means of a Durometer
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(Application for copies should be addressed to the American Society for Testing Materials, 1916 Race Street, Philadelphia, Pa 19103)

3. REQUIREMENTS

3.1 Materials. The basic ingredient used in the manufacture of these products shall be synthetic rubber of the polysulfide type. The sealants shall cure by the addition of separate curing compound to the base compound, and shall not depend on solvent evaporation for curing.

3.1.1 The sealant furnished shall be a product which has been tested and which has passed the tests specified herein.

3.2 Properties.

3.2.1 Color. The base compound shall be red in color prior to the addition of curing compound, and the red color shall remain evident in the cured condition.

3.2.2 Specific gravity. The specific gravity of the cured sealant materials shall not exceed 1.55 at 68°F/39°F (20°C/4°C).

3.2.3 Nonvolatile content. The nonvolatile content of the base compound shall be not less than the amounts specified below:

Class A - 90 percent by weight

Class B - 97 percent by weight

3.2.4 Viscosity of base compound. Class A sealants shall be suitable for brush application, and the base compound shall be within the range of 100 to 300 poises. Class B sealants shall be suitable for application by extrusion or injection gun, and the base compound shall be within a range of 8,000 to 12,000 poises.

3.2.5 Flow. The freshly mixed sealant shall exhibit a flow within the limits specified in table I, when a cylindrical section formed in a standard device is allowed to flow under its own weight on a vertical surface until cured.

TABLE I
Flow limits

Class	Flow in inches	
	Minimum	Maximum
B-1/2	1/4	1-1/4
B-2	1/4	1-1/4

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3.2.6 Application time. The mixed sealant shall have an application time at $77^{\circ} \pm 2^{\circ}\text{F}$ ($25^{\circ} \pm 1^{\circ}\text{C}$) of not less than the time in hours specified in table II, after addition of the curing compound, and shall remain suitable for application during that period.

TABLE II
Application time

Class A	Hours	Class B	Hours
A-1/2	1/2	B-1/2	1/2
A-2	2	B-2	2

3.2.7 Tack-free time. The mixed sealant shall cure to a tack-free condition in not more than the time in hours specified in table III, after the addition of the curing compound. The mixed sealant shall continue to cure when placed in contact with test fluid at the expiration of the application time as determined in 4.5.5.

TABLE III
Tack-free time

Class A	Hours	Class B	Hours
A-1/2	10	B-1/2	10
A-2	24	B-2	24

3.2.8 Hardness. The sealant after curing 7 days shall have an instantaneous hardness value in the range of 30 to 60 Shore "A" points.

3.2.9 Adhesion. The adhesion of the cured sealant to aluminum-surfaced aluminum-alloy panels shall be as specified below when tested in accordance with 4.5.9:

Class A - Positive adhesion not to exceed 2 pounds per inch.

Class B - Positive adhesion not to exceed 2 pounds per inch.

3.2.10 Resistance to heat. The cured sealant, after immersion in hydrocarbon test fluid, followed by air drying and baking, shall show no visual evidence of softening, sponging, blistering, checking, cracking, shrinkage, or loss of

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adhesion, and shall not harden by more than 10 Shore "A" points, when tested in accordance with 4.5.10.

3.2.11 Resistance to salt water and hydrocarbon. The cured sealant, after immersion in a two-layer liquid consisting of salt water and hydrocarbon test fluid for 20 days in accordance with 4.5.11, shall show no visual evidence of softening, blistering, nor shall there be any evidence of corrosion of the metal under the sealant.

3.2.12 Resistance to hydrocarbons. A section of the cured sealant, after exposure for 14 days to hydrocarbon test fluids and aging in accordance with the procedure outlined in 4.5.12, shall remain intact and retain flexibility. When bent through 180 degrees on a 1/8-inch mandrel, with the fuel-exposed surface on the outside of the bend, the sealant shall show no cracks in the fuel-exposed surface.

3.2.13 Low-temperature flexibility. The cured sealant shall withstand the flexibility test described in 4.5.13 at -65°F (-54°C) without cracking, chipping or loss of adhesion.

3.2.14 Accelerated storage stability. A full, tightly closed 1-quart container of the base compound, after 14 days storage at 120°F (40°C), shall show no skinning, hardening, separation, or settling of the material. The curing compound shall not be adversely affected by aging 14 days at 120°F in a tightly closed full container and shall be capable of being restored to a condition suitable for use by stirring. The aged base compound and the aged curing compound, when mixed, shall meet the requirements of this specification for working life and tack-free time when tested as required 4.5.5. and 4.5.6. The aged base compound shall meet the original viscosity requirements.

3.3 Packaging shall be accomplished in accordance with section 5.

4. QUALITY ASSURANCE PROVISIONS

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

4.2 Classification of tests. The tests under this specification shall be classified as follows:

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First article tests
acceptance tests

First article tests shall consist of all the tests under this specification. Acceptance tests shall consist of the tests described in 4.5.2 through 4.5.8. (See 6.4.)

4.2.1 Test report. The manufacturer shall furnish a test report showing that the material satisfactorily conforms to this specification.

4.3 Acceptance tests. Acceptance of the lot shall be based on compliance with the requirements of this specification as demonstrated by successful completion of the tests described in 4.5.2 through 4.5.8.

4.3.1 Inspection lot. For purposes of sampling, a lot shall consist of all sealing compound of the same class and composition manufactured as one batch and offered for delivery at one time.

4.3.2 Sampling tests.

4.3.2.1 Sampling for inspection of filled containers. A random sample of filled containers shall be selected from each lot by the Government Inspector, in accordance with Standard MIL-STD-105 at Inspection level I and Acceptance Quality Level (AQL) equals 2.5 percent defective to verify compliance with all stipulations of this specification regarding fill, closure, marking, and other requirements not involving tests, and as specified in 4.5.1.

4.3.2.2 Sampling for inspection of sealant. From each inspection lot the Government Inspector shall select enough containers at random to form two separate specimens. These containers shall be sealed, marked, and held for test of the sealant. The sample specimens shall be subjected separately to the following tests as described under "Test methods." If either specimen fails one or more of these tests, the lot shall be rejected. Rejected lots may be resubmitted for Acceptance tests provided the contractor has removed or reworked all nonconforming products.

Nonvolatile content
Viscosity
Flow
Application time
Tack-free time
Hardness
Specific gravity

4.4 Test conditions.

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4.4.1 Preparation of test panels. The metal test panels shall be thoroughly cleaned of all contaminants, using the formulation as specified in table IV below, and wiped dry with clean, non-oily wiping cloths or tissues.

TABLE IV
Formulation of cleaner

Ingredient	Specification	Percent by volume
Aromatic petroleum naphtha	TT-H-97, Type I Grade B	50
Ethyl acetate	TT-B-751	20
Methyl-ethyl-ketone	TT-M-261	20
Isopropyl alcohol	TT-I-265	10

4.4.2 Application of sealant. Unless otherwise specified, the sealant shall be applied to the panels in a manner which will produce a coating having a thickness of $1/8 \pm 1/32$ inch when cured. Multiple applications of Class A sealant may be necessary to build up the required thickness. All test specimens shall be prepared, cured, and tested in a room having a temperature of $77^\circ \pm 2^\circ\text{F}$ ($25^\circ \pm 1^\circ\text{C}$) and a relative humidity of 50 ± 5 percent, except as otherwise specified. All specimens shall be tested 7 days after application of the sealant.

4.5 Test methods.

4.5.1 Inspection of filled containers. Each sample-filled container selected in accordance with 4.3.2.1 shall be examined by the Government Inspector for defects of the container and the closure, for evidence of leakage, and for unsatisfactory markings; each sample filled container shall also be weighed to determine the amount of the contents. Any container in the sample having one or more defects or under required fill shall be rejected, and if the number of defective containers in any sample exceeds the acceptance number for the appropriate sampling plan of Standard MIL-STD-105, the lot represented by the sample shall be rejected. Rejected lots may be resubmitted for Acceptance tests provided the contractor has removed or repaired all nonconforming containers.

4.5.2 Nonvolatile content. From 5 to 10 grams of the mixed sealing compound shall be transferred as rapidly as possible to a cup approximately 3 inches in diameter and $3/4$ inch in depth. A fitted cover shall immediately be placed over the cup and the weight determined accurately by using an enclosed beam balance which will weigh accurately to the nearest milligram. The cover shall then be removed and the sealing compound heated for 24 hours at $158^\circ \pm 2^\circ\text{F}$ ($70^\circ \pm 1^\circ\text{C}$).

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It shall then be cooled, the cover replaced, and the weight determined accurately. The percentage of total solids shall be calculated as follows:

$$\text{Percentage of solids} = \frac{\text{Final weight of sample}}{\text{Initial weight of sample}} \times 100$$

The weight of the cup and cover shall be determined accurately before using and subtracted from the initial and final weights.

4.5.3 Viscosity. The viscosity shall be determined after the sample has been stored at the proper temperature for 24 hours, thoroughly mixing the base compound by stirring, closing the container, and then allowing a 1-hour rest period. A Brookfield Viscosimeter shall be used, and the readings shall be converted to poises. For Class A material, the No. 4 spindle shall be used at 10 rpm, and for Class B, the No. 7 spindle shall be used at 2 rpm. The instrument shall be run for 1 minute before the first reading is made.

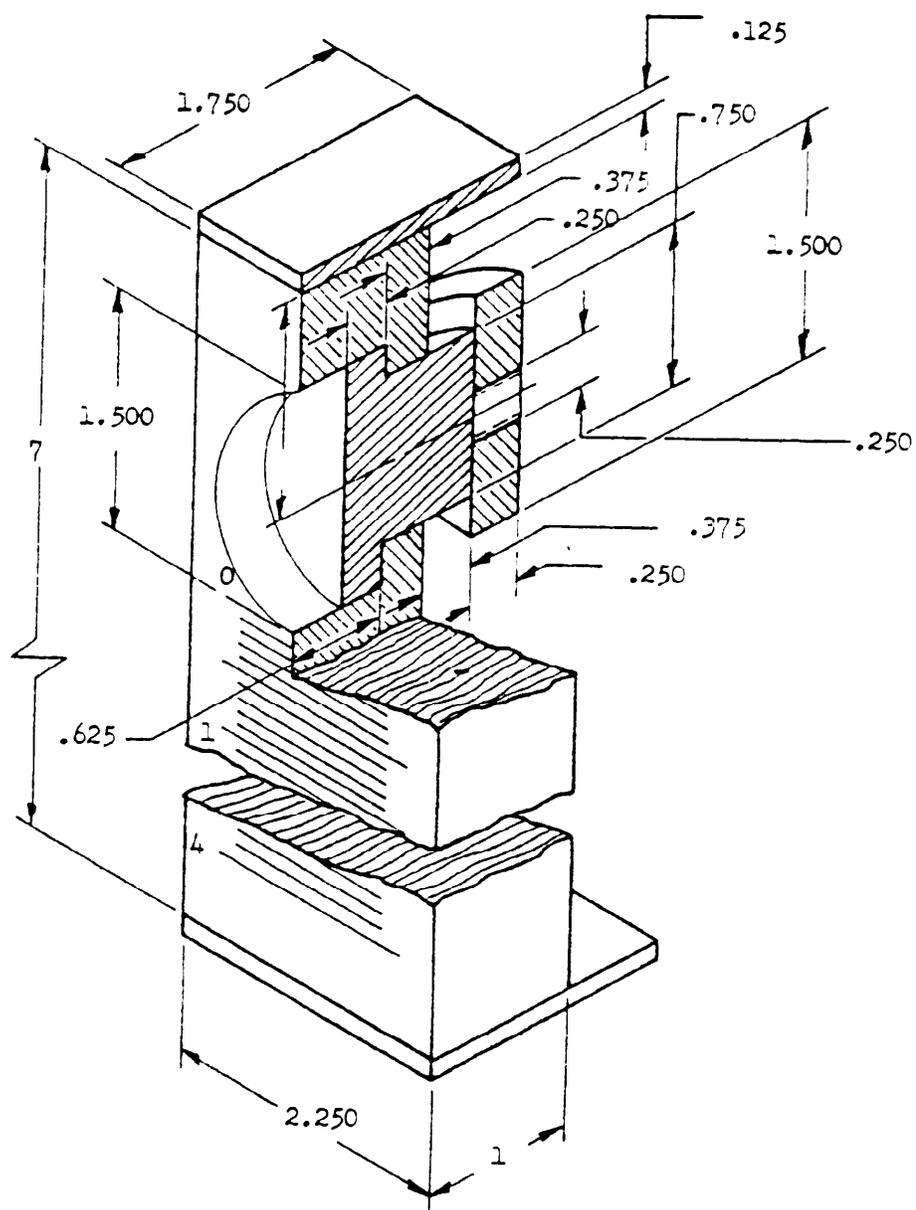
4.5.4 Flow. The flow test jig, as shown in figure 1, shall be placed on a table with the front face upward and with the plunger depressed to the limit of its travel. Fifty grams of the base material and the proper amount of curing compound shall be mixed. The compound shall be mixed on a flat plate using a steel spatula in such manner that a minimum of air is included. Not more than 5 minutes shall be allowed for mixing. Enough of the mixed sealant shall be transferred within 1 minute to fill the recessed cavity of the jig and leveled off even with the block. The jig shall be stood on its end, and the plunger advanced to the limit of its forward travel within 5 seconds. The flow measurement shall be made when the sealant has cured. The flow shall be measured from the tangent to the lower edge of the plunger to the farthest point to which flow has occurred.

4.5.4.1 This test and tests described in 4.5.5, 4.5.6, 4.5.7, and 4.5.8 shall be conducted on sealing compound mixed at the same time.

4.5.5 Application time. A small quantity of the mixed Class B sealant shall be picked up periodically on a spatula or tongue depressor and shall be used to strike a clean aluminum panel a glancing blow with the sealant at about 30 degrees from the panel. Any bouncing of the sealant on the panel before wetting the metal indicates the sealant is beyond its application time. Mixed Class A material shall be tested for application time with the Brookfield Viscosimeter using the No. 7 spindle at 10 rpm. The time at which a reading equivalent to 2,500 poises is reached shall be considered the end of the application time.

4.5.6 Tack-free time. A small sheet of smooth polyethylene film conforming to MIL-I-631, Type A, 0.004 ± 0.002 inch thick shall be pressed with the thumb onto a 1-square-inch area of sealant and withdrawn. The time at which the film

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MATERIAL: ALUMINUM ALLOY
 DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: Decimals \pm .016.

FIGURE 1. Flow-test jig

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no longer adheres tightly to the sealant shall be considered the tack-free time. A panel, 1 by 5 inches, aluminum-surfaced aluminum alloy, shall be coated with sealant. At the expiration of the application time as determined in 4.5.5, the panel shall be immersed to 1/2 its length in test fluid conforming to TT-S-735, Type III, at 77°F (25°C). The test panel shall be removed from the fluid at the end of 72 hours and examined. The sealant shall be cured to a rubber-like condition.

4.5.7 Hardness. Shore "A" hardness shall be conducted on a Shore "A" durometer in accordance with ASTM D2240.

4.5.8 Specific gravity. Specific gravity shall be conducted by any available, suitable means using a sample of the cured sealant, measuring approximately 1 by 2 by 0.25 inches.

4.5.9 Adhesion. A coat of the sealing compound shall be applied as specified in 4.4.2 to an aluminum-surfaced aluminum alloy panel measuring 2-3/4 by 6 by 0.040 inches and conforming to QQ-A-250/13. One end of a 3- by 12-inch strip of cotton sheeting conforming to CCC-C-432 shall then be placed on the panel leaving a loose end 6 inches in length. The 3- by 6-inch area of fabric shall then be worked into the compound by a soft paint brush which has been wet with the sealant or worked in with a knife. Wetting the surface of the fabric with the compound will facilitate application of the fabric. At the end of 7 days, the panels shall be immersed for 48 hours at 77° ± 2°F (25° ± 1°C) in aromatic hydrocarbon test fluid conforming to TT-S-735, Type III. A 1-inch-wide strip shall be cut through the sealant and fabric to the metal and extended the full length of the loose end of the fabric. The loose end of the 1-inch-wide fabric strip shall be clamped in one jaw of a suitable testing machine, and the adjacent end of the panel shall be fastened in the other jaw. The testing machine and its operation shall be as specified in Method No. 8031 of Federal Test Method Standard No. 601 with jaw separation of 2 inches per minute. The adhesion shall be measured as the average pull in pounds per inch required to separate the coating from the metal surface. Positive adhesion is indicated if the strip can be used to lift the panel from a flat surface such as a table top, prior to pulling on the testing machine. The adhesion shall be measured within 10 minutes after removal from the test fluid.

4.5.10 Resistance to heat. A coat of sealant shall be applied to a panel measuring 2-3/4 by 6 by 0.040 inches, and shall be immersed for 48 hours at 120° ± 5°F (49° ± 2°C) in aromatic hydrocarbon test fluid conforming to TT-S-735 Type III, in a closed container with one-half of the sealant above the liquid level. The panel shall then be removed, air dried at 77° ± 2°F (25° ± 1°C) for a period of 24 hours, and baked at 180° ± 5°F (82° ± 2°C) for a period of 72 hours. The panel shall then be examined for changes in film properties.

4.5.11 Resistance to salt water and hydrocarbon. A coated panel, measuring 2-3/4 by 6 inches, of aluminum-surfaced aluminum alloy conforming to QQ-A-250/13

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shall be immersed vertically for 20 days in a covered glass vessel containing a two-layer liquid, consisting of a two-layer liquid, consisting of a 3.0 percent aqueous sodium chloride solution and 30 percent aromatic hydrocarbon test fluid conforming to TT-S-735, Type III, with 2 inches of the panel exposed to the salt mixture, 2 inches of the panel exposed to the aromatic test fluid, and the remainder of the panel exposed to the air-vapor mixture. The temperature during the test shall be maintained at $120^{\circ} \pm 2^{\circ}\text{F}$ ($49^{\circ} \pm 1^{\circ}\text{C}$). Immediately upon removal from the liquid, the panel shall be examined for softening, blistering, leaching, or loss of adhesion of the film, and there shall be no corrosion apparent on the metal.

4.5.12 Resistance to hydrocarbon. Five panels, measuring 2-3/4 by 6 inches, of aluminum-surfaced aluminum alloy conforming to QQ-A-250/13 shall be prepared, having five parallel sealant fillets approximately 1 inch apart. Each fillet shall be applied 3/16 inch thick by 1/2 inch wide by 2 inches long. The panels shall be cured for 7 days. One panel shall be retained as control. Two panels shall be immersed in closed quart containers filled with hydrocarbon test fluids conforming to TT-S-735, Type I and Type III. The full containers shall be maintained in a temperature controlled bath at $120^{\circ} \pm 2^{\circ}\text{F}$ ($49^{\circ} \pm 1^{\circ}\text{C}$). The fluids shall be agitated daily. After exposure of 14 days the panels shall be removed from the test fluids and the fillets cut cleanly away from the metal. The removed sealant sections shall be dried at $120^{\circ} \pm 5^{\circ}\text{C}$ ($49^{\circ} \pm 2^{\circ}\text{C}$) for 16 hours and examined in accordance with 3.2.12.

4.5.13 Low-temperature flexibility. The properly cured coated panels, measuring 1 by 6 by 0.032 inches, of aluminum-surfaced aluminum alloy conforming to QQ-A-250/13, shall be immersed for 48 hours at $120^{\circ} \pm 5^{\circ}\text{F}$ ($49^{\circ} \pm 2^{\circ}\text{C}$) in aromatic hydrocarbon test fluid conforming to TT-S-735, Type III. At the completion of the immersion period, the panels and the flexibility jig shown on figure 2 shall be subjected to a temperature between -62° and -65°F (-52° and -54°C) for 2 hours. While at this temperature, one end of the test panel shall be put in the slotted position and the other end bent rapidly around the curved portion of the flexibility test jig with the sealant on the exterior of the radius. The panels shall then be removed and examined.

4.5.14 Color. The sealant materials shall be examined visually for conformance to 3.2.1

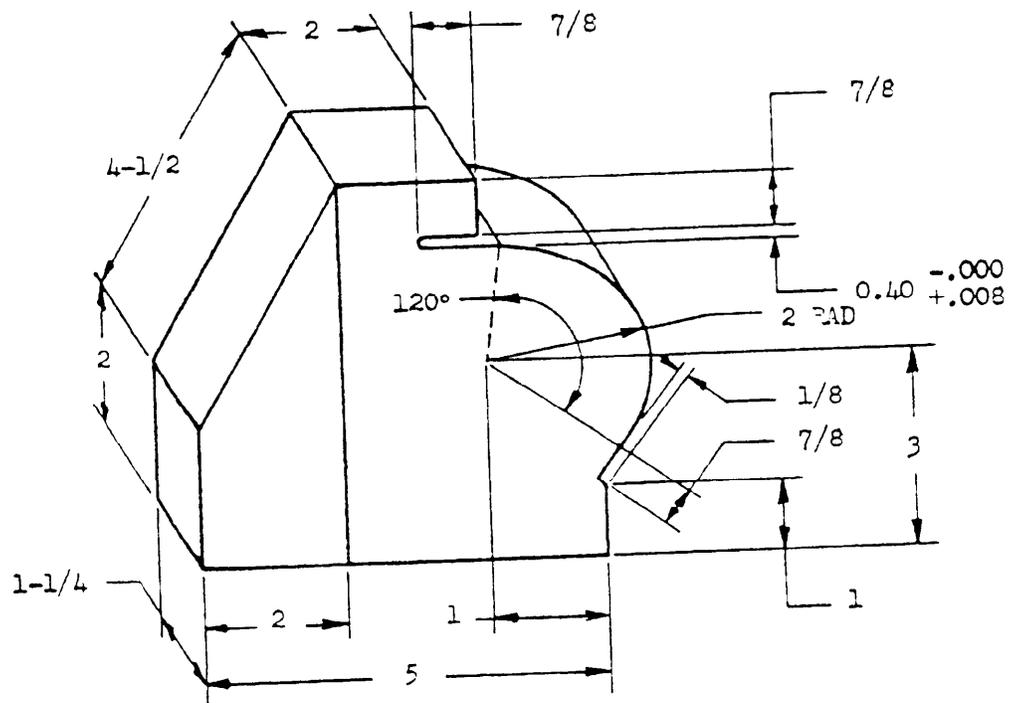
5. PREPARATION FOR DELIVERY

5.1 Packaging. Packaging shall be level A.

5.1.1 Level A.

5.1.1.1 Unit packaging. The base compound and the curing agent shall each be packaged in its own container. Each curing agent container shall be packaged

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MATERIAL: MAPLE WOOD
 DIMENSION IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCE:
 Angles $\pm 1/2^\circ$, Fractions $\pm 1/16$

FIGURE 2. Low temperature flexibility test jig

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with one base compound container in a manner that will prevent accidental separation but will permit easy separation for mixing purposes. The ratio of the quantity contained in base container to the quantity contained in the curing agent container shall be the same as the recommended mixing ratio of the base compound and curing agent.

5.1.1.1.1 Individual containers. The base compound shall be furnished in 1/2-pint, 1-pint, 1-quart, or 1-gallon metal cans, as specified in the contract or order. Metal cans shall conform to type V, class 2 of PPP-C-96, except that tinplate cans with paper labels may be used, unless specifically prohibited. The base compound contained in each size container shall be as follows:

<u>Size of container</u>	<u>Amount of base compound</u>	<u>Volume tolerance</u>
1/2 pint	6 fluid ounces	± 1/8 fluid ounce
1 pint	12 fluid ounces	± 1/4 fluid ounce
1 quart	24 fluid ounces	± 1/2 fluid ounce
1 gallon	96 fluid ounces	± 2 fluid ounces

The air in the top of the base compound containers shall be replaced with nitrogen gas immediately prior to closing the containers. The curing agent shall be furnished in glass jars or in suitable plastic containers approved by the procuring activity. The jars or plastic containers, as applicable, shall have vertical, smooth inside walls, and no internal projections or internal lips exceeding 1/16 inch. The glass jars shall be closed with enameled metal or plastic continuous threaded screw caps having a nonabsorbent lining material. Caps shall be tightened adequately and further sealed with cellulose bands, or equivalent. One container each of the base compounds and curing agent, individually packaged in accordance with the foregoing, shall be enclosed in a Grade W50 container conforming to PPP-B-636 and shall constitute a complete kit.

5.1.1.1.2 Sectional-type containers. The base compound and curing agent shall be furnished in high density polyethylene sectional-type 2-1/2 ounce or 6-ounce cartridges, conforming to MIL-P-38714, as specified in the contract or order. The total content of base compound and curing agent contained in each sectional-type container shall be as follows:

<u>Size of container</u>	<u>Total content (base and curing)</u>	<u>Volume tolerance</u>
2 1/2 ounce	2 fluid ounces	± 1/8 fluid ounce
6 ounces	3 1/2 fluid ounces	± 1/8 fluid ounce

5.2 Packing. Packing shall be level A or B as specified.

5.2.1 Level A. The sealing compound shall be packed in overseas-type shipping containers in accordance with the requirements of the appendix to PPP-C-96 for

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filled can containers, and MIL-P-38714 for the sectional type containers.

5.2.2 Level B. The sealing compound shall be packed in domestic-type shipping containers in accordance with the requirements of the appendix to FPP-C-96 for filled can containers, and MIL-P-38714 for the sectional type containers.

5.3 Marking of shipments. Interior packages and exterior shipping containers shall be marked in accordance with MIL-P-38714 and MIL-STD-129 as applicable. The identification shall also include the stock number or other identification number as specified in the purchase document (see 6.2).

NOTE: The contractor shall enter the Federal Stock Number specified in the purchase document or as furnished by the procuring activity. When the Federal Stock Number is not provided or available from the procuring activity, leave space therefor and enter the stock number or other identification as provided by the procuring activity.

6. NOTES

6.1 Intended use. The sealing compounds covered by this specification are intended for sealing access doors and accessories of integral fuel tanks, cell cavities, and components where a low adhesion sealing compound is required. The sealant materials are not intended for repair or sealing the interior seams or fasteners of integral fuel tanks, bladder or self-sealing fuel cells.

6.2 Ordering data. Procuring documents should specify the following:

- Title, number, and date of this specification
- Class of sealant, with dash number required
- Level of packaging and packing required (see section 5)
- Method of packaging
- Required size of base compound container
- Federal Stock Number, Stock Number, and other identification required by the activity (see 5.3)

6.3 Marginal indicia. Margins of this specification are not marked with a line to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were made, due to the intensiveness of the changes.

6.4 Waiver. The first article inspection tests need not be repeated for new orders or follow on orders provided the materials and processes have not been changed and a certified statement to this effect is furnished to the procuring activity. The waiving of the first article inspection tests will be strictly at the discretion of the procuring activity.

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CUSTODIANS:
Army - 1F
Navy - AS
Air Force - 04

PREPARING ACTIVITY:
Air Force - 04
PROJECT NO. 8030-0367

DEVELOPER ACTIVITIES:
Army - 1F
Navy - AS

USDA ACTIVITIES:
Navy - 10, 00

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