

MIL-T-10069G
30 September 1987
SUPERSEDING
MIL-T-10069F
24 May 1971

MILITARY SPECIFICATION

TENT, MAINTENANCE SHELTER, FIRE, WATER, WEATHER AND MILDEW RESISTANT, OLIVE DRAB

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

1. SCOPE

1.1 Scope. This document covers a wall tent having the following dimensions: length 26 feet, 9-1/2 inches; width 18 feet, 2-1/4 inches; sidewall height 8-5/8 inches; ridge height 13 feet, 11-7/16 inches. A metal frame is required to support the tent (see 6.6). A cover is provided to protect the tent during transportation.

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Documents. The following documents form a part of this document to the extent specified herein. Unless otherwise specified, the issue of these documents shall be those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation.

SPECIFICATIONS

FEDERAL

| | |
|----------|---------------------------------|
| T-T-871 | - Twine, Cotton, Wrapping |
| T-T-911 | - Twine, Fibrous Jute |
| V-T-285 | - Thread, Polyester |
| TT-P-595 | - Preservative Coatings, Canvas |

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 8340

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

MIL-T-10069G

- CCC-C-419 - Cloth, Duck, Cotton; Fire, Water, Weather and Mildew and Numbered
- CCC-C-428 - Cloth, Duck, Cotton; Fire, Water, Weather and Mildew Resistant
- CCC-C-429 - Cloth, Osnaburg, Cotton
- CCC-C-467 - Cloth, Burlap, Jute (or Kenaf)
- DDD-L-20 - Label: for Clothing, Equipage and Tentage, (General Use)
- PPP-B-601 - Boxes, Wood, Cleated-Plywood

MILITARY

- MIL-R-1670 - Rope, Tent-Lay
- MIL-L-1709 - Lines, Tent
- MIL-S-1734 - Slips, Tent Line
- MIL-R-2327 - Rings, Connecting, Round
- MIL-P-2383 - Pins, Tent, Wood
- MIL-C-2399 - Cement, Liquid, Tent Patching
- MIL-G-16491 - Grommet, Metallic
- MIL-R-30500 - Rope, Polyester
- MIL-T-43566 - Tape, Textile, Cotton or Polyester, General Purpose, Natural or in Colors
- MIL-C-43627 - Cloth, Duck, Cotton, Plied Yarns, Fire, Water, Weather and Mildew Resistant Treated, Lightdry Finish
- MIL-W-44049 - Webbing, Textile and Tape, Textile, Polypropylene, General Purpose, Natural or in Colors

STANDARDS

FEDERAL

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

MILITARY

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

DRAWINGS

ARMY NATICK RESEARCH, DEVELOPMENT, AND ENGINEERING CENTER

- 5-4-167 - Tent, Maintenance Shelter, FWWMR, OD; Assembly "A"
- 5-4-168 - Tent, Maintenance Shelter, FWWMR, OD; Assembly "B"
- 5-4-169 - Tent, Maintenance Shelter, FWWMR, OD; Details, Sections and Ground Cloth
- 5-4-171 - Tent, Maintenance Shelter, FWWMR, OD; Details "A"
- 5-4-175 - Tent, Maintenance Shelter, FWWMR, OD; Details "D"

MIL-T-10069G

| | | |
|---------|---|--|
| 5-4-176 | - | Tent, Maintenance Shelter, FWWMR, OD; Details "E" |
| 5-4-177 | - | Tent, Maintenance Shelter, FWWMR, OD; Details "F" |
| 5-4-178 | - | Tent, Maintenance Shelter, FWWMR, OD; Details "G" |
| 5-4-179 | - | Tent, Maintenance Shelter, FWWMR, OD; Details "H" |
| 5-4-220 | - | Tent, Maintenance Shelter, FWWMR, OD; Cover |
| 5-4-503 | - | Tent, Maintenance Shelter, FWWMR, OD; Erection Instructions |

2.1.2 Other Government documents. The following other Government documents form a part of this document to the extent specified herein. Unless otherwise specified, the issues shall be those in effect on the date of the solicitation.

FM-10-16 - General Repair of Tents, Canvas and Webbing

(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 activity.)

2.2 Other 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 shall be those listed in the issue of the DODISS specified in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS shall be the issues of the nongovernment documents which are current on the date of the solicitation.

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

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.)

(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. Nothing in this document, however, shall supersede applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 First article. When specified in the contract or purchase order, 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 conform to the requirements on the applicable drawings, to subsidiary specifications and standards applicable thereto and as specified herein (see 6.5).

MIL-T-10069C

3.2.1 Cloth, duck, cotton, 9.85 ounce. Cloth for the tent and cover, except ground cloth, shall conform to MIL-C-43627. The color shall be Olive Drab 7.

3.2.1.1 Duck, cotton, No. 6. Material for the ground cloth shall conform to type I, No. 6, hard texture duck, of CCC-C-419 and shall be dyed and finished to conform to type I, class 1, Olive Drab 7 of CCC-C-428.

3.2.2 Tape, cotton. The cotton tape shall conform to type 1, class 4 of MIL-T-43566, 3/4 inch and 1 inch, Olive Drab 7. For cover only, alternatively, the tape may be polypropylene conforming to type I, class 4, Olive Drab 7 of MIL-W-44049.

3.2.3 Thread, polyester. The thread for all stitching shall conform to type 1, class 1, subclass B, olive drab S-1 (CA. 66022) of V-T-285. The dyed thread shall show fastness to weathering equal to or better than the standard sample. If no standard shade sample is available, the dyed thread shall show good fastness to weathering. Thread sizes shall be as follows:

For all stitching on the tent and cover except stitching indicated by "Z" on drawings

Size F for needle and bobbin

For stitching on the tent and cover indicated by "Z" on drawings

Size F for needle, size E for looper

For all stitching on ground cloth except stitching indicated by "Z" on drawings

Size FF for needle and bobbin

For stitching on ground cloth indicated by "Z" on drawings

Size FF for needle, size F for looper

3.2.4 Twine, cotton, wrapping. The cotton twine shall conform to type II, class 1, 5 ply, of T-T-871.

3.2.5 Rope, tent-lay. The rope shall conform to type I, class 2, 3/4-inch circumference (1/4-inch diameter) of MIL-R-1670. As an alternative, polyester rope conforming to MIL-R-30500, 3/4-inch circumference, may be used.

3.2.6 Lines, tent. Tent lines shall conform to the requirements of MIL-L-1709 in the following types:

| <u>Type</u> | <u>Application</u> | <u>Type</u> | <u>Application</u> |
|-------------|--------------------|-------------|--------------------|
| I | Footstop | XIV | Corner Lacing Line |
| V | Door Fastener | XIX | Eave Line |
| VI | Door Flap Line | XXI | Cover Tie Line |
| VIII | Door Lacing Line | XL | Guy Line |

MIL-T-10069G

3.2.7 Grommets, metallic. Grommets shall conform to type II, class 3, size No. 4 and type III, class 3, size Nos. 4, 5, and 6 of MIL-G-16491.

3.2.8 Slips, tent line. Tent line slips shall conform to type II of MIL-S-1734.

3.2.9 Rings, connecting. Round connecting rings shall conform to class 2 or 5, size 4 of MIL-R-2327.

3.3 Construction. The construction shall conform in all respects to the drawings listed in section 2 and as specified herein.

3.3.1 Stitching, machine.

3.3.1.1 Stitches, seams, and stitches. All stitches, seams, and stitching shall conform to FED-STD-751. The type of seam, stitching, and stitches per inch shall be as specified in table I. Seam allowances shall be maintained with seams sewn so that no raw edges, run-offs, twists, pleats, puckers, or open seams occur.

For all stitching except stitching indicated by "Z" on drawings

Type 301, 5 to 7 stitches per inch

For stitching indicated by "Z" on drawings

Type 401, 5 to 7 stitches per inch. Chain portion of stitching shall not appear on outside of screen or cover.

3.3.1.2 Thread breaks. Thread breaks in stitching shall be overstitched not less than 1 inch at each break on stitch type 301 and not less than 1-1/2 inches at each break on stitch type 401.

3.3.1.3 Stitching ends. Stitching ends shall be overstitched not less than 1 inch on stitch type 301 except where ends are turned under in a hem or held down by other stitching or where stitching is performed automatically. When stitch patterns such as box, box with cross-stitch, "W" stitching, or straight line tacking are performed automatically, at least three or more tying, overlapping, or back stitches shall be used to secure the ends of stitching.

3.3.1.4 Skipped stitches. Skipped stitches on type 401 stitching shall be overstitched not less than 1-1/2 inches and not less than 1 inch on type 301 stitching where two or more consecutive skipped stitches occur. Skipped stitches in type 401 stitching may be overstitched with type 301 stitching.

3.3.1.5 Lubrication of thread. There shall be no lubrication of the thread by any means prior to or during sewing (see 4.4.2).

3.3.1.6 Stitching margin. Unless otherwise specified, all stitching margins shall be $1/8 \pm 1/16$ inch.

MIL-T-10069G

3.3.2 Handstitching. Handstitching shall be made with twine specified in 3.2.4 using four strands twisted together. Each stitch shall be pulled tight and all ends of stitching secured.

3.3.3 Setting of grommets. Hole punched to receive grommets shall be smaller than the outside diameter of the grommet barrel so that the barrel must be forced through the hole. Grommets shall be securely clinched without cutting the materials.

3.3.4 Wicking of tent stitching (cup test). There shall be no wicking of water through the tent stitching when the tent is tested as specified in 4.4.5. The cup test is intended to insure that non-wicking thread has been utilized and that no lubrication has been added to the polyester thread during the sewing operation.

3.3.5 Repairs. Any necessary repairs shall be effected in accordance with Department of the Army Field Manual FM 10-16 except that handsewn patches, or cemented patches other than as specified herein, will not be acceptable. Cemented patches on holes, cuts, or tears not more than 1-inch in diameter or length, using cement specified in MIL-C-2399, shall be permitted. A maximum of three cemented patches per tent will be allowed without prior authorization. All other repairs shall require authorization by the contracting officer. Repairs required as a result of failure of the cup test and when authorized by the contracting office shall be performed by treating with a compound conforming to type I of class 1, shade olive drab of TT-P-595 prior to retesting (see 6.7).

3.4 Marking. All marking and labels shall conform to DDD-L-20.

3.4.1 Special marking. The letters "US" on the tent and cover and the special marking on the cover shall conform to type IV, class 9 in the size characters and in the locations shown on the drawings. Class 9 markings shall be clearly legible after subjection to accelerated weathering.

3.4.2 Identification label. Identification labels shall conform to type VI, class 6, 3-1/2 inches by 5-1/2 inches minimum with a blank space of at least 1-1/4 inches provided on the bottom of the label for the Department of Defense inspector's stamp. Identification labels shall be stitched to the tent and cover in the locations shown on the drawings.

3.4.3 Erection instructions label. The erection instructions labels shall conform to type VI, class 7 and shall be stitched to the tent and cover in the locations shown on the drawings. The size of the label shall be 15 inches \pm 1/4 inch in the longer dimension with a minimum 1/2-inch margin outside of the borderline on all sides. The label shall be a proportionate copy of Drawing 5-4-503 as reproduced from a glossy print of this drawing furnished by the contracting officer.

MIL-T-10069G

3.5 Workmanship. The tent shall conform to the quality of product established by this document and 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 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 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 a 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.

4.2 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 6.2), it shall be examined for the defects specified in 4.4.3 and 4.4.4 and tested for characteristics specified in 4.5.1. The presence of any defect or failure to pass any test 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 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.

MIL-T-10069G

4.4.2 In-process examination. Examination shall be made to determine that the following are specified:

- a. There shall be no lubrication of polyester thread prior to or during the sewing operations for compliance with 3.3.1.5.
- b. Holes punched to receive grommets are in compliance with 3.3.4.
- c. Holes punched to receive snap fasteners are in compliance with 3.3.5.

Whenever nonconformance is noted, correction shall be made to the affected items and to the process.

4.4.3 End item visual examination. The end item shall be examined for the defects listed in table I. The lot size shall be expressed in units of completed fabricated tents with covers. The sample unit shall be one tent with cover. The tent shall be inspected in an erected position so that the interior is easily accessible for examination. The inspection level shall be I and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 4.0 for major defects, 100.0 for combined major and minor A defects, and 250.0 for total (major, minor A, and minor B combined) defects.

TABLE I. End item visual defects

| Examine | Defect | Classification | |
|---------|--|----------------|--------------|
| | | Major | Minor A B |
| Fabric | Cut or tear longer than 1/8 inch; hole (including exposed drill hole) larger than 1/8 inch diameter: | | |
| | - on roof | X | |
| | - on wall | | X |
| | - on cover, sod cloth, or ground cloth | | X |
| | Exposed drill hole (1/8 inch or less) i.e., not covered by attached parts - on roof: | | |
| | - more than four but not more than four | | X |
| | - more than four | | X |
| | Broken or missing yarn; multiple floats | | X |

MIL-T-10069G

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

| Examine | Defect | Classification | |
|---|---|----------------|--------------|
| | | Major | Minor A B |
| Tape | Edges frayed or scalloped | | X |
| Hardware | Broken | X | |
| | Malformed: | | |
| | - fails to perform intended function | X | |
| | - but will perform intended function | | X |
| Grommets | Corroded area | | X |
| | Burr or sharp edge which may cause injury in handling or damage to the fabric | X | |
| | Improperly set, two or more teeth exposed; clinched loosely, allowing grommet to rotate in hole | | X |
| | Clinched excessively tight, cutting fabric | X | |
| | Insecurely clinched; i.e., grommet or washer becomes disengaged: | | |
| | - on ridge or eave | X | |
| | - at any other location | | X |
| Set with rim extending beyond edges of hems, facings, or grommet reinforcements | | X | |
| Rope components | Door flap grommets set off center on seam joining door flaps to end walls, cutting stitching when stitch type 401 is used | X | |
| | Corner grommets misplaced, failing to effect a smooth and secure closure of end walls and side walls | | X |
| | Door opening grommets misplaced, failing to effect a smooth and secure closure of end walls | | X |
| | Any cut or abrasion: | | |
| | - on eave or guy lines | X | |
| - on door flaps, corner on door lacing lines, footstops, or door fasteners | | X | |

MIL-T-10069G

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

| Examine | Defect | Classification | |
|---------------------|--|----------------|--------------|
| | | Major | Minor A B |
| Seams and stitching | Open seam on stitch type 301: | | |
| | - for more than 1/4 inch but not more than one inch | | X |
| | - for more than 1 inch | | X |
| | Open seam on stitch type 401: | | |
| | - one row of stitching open: | | |
| | - for more than 1/4 inch but not more than 1 inch: | | |
| | - on the roof | | X |
| | - on walls or cover | | X |
| | - for more than 1 inch: | | |
| | - on roof | X | |
| | - on walls or cover | | X |
| | - both rows of stitching open (not necessarily at same location): | | |
| | - on roof | X | |
| - on wall or cover | | X | |
| NOTE: | A seam shall be classified as open when one or more stitches joining a seam are broken or when two or more consecutive skipped or run-off stitches occur and are not overstitched. On double stitched seams, a seam shall be classified as open when either one or both of the seams are open. | | |
| | Raw edges caught in stitching: | | |
| | - more than 1 inch but not more than 3 inches | | X |
| | - more than 3 inches | | X |
| | Thread breaks: | | |
| | - overstitched less than 1-1/2 inches on stitch type 401 | | X |
| | - overstitched less than 1 inch on stitch type 301 | | X |
| NOTE: | Thread breaks not overstitched shall be classified as open seams. | | |
| | Skipped stitches: | | |
| | - overstitched less than 1-1/2 inches on stitch type 401 | | X |

MIL-T-10069G

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

| Examine | Defect | Classification | |
|------------------------------|--|----------------|--------------|
| | | Major | Minor A B |
| Seams and stitching (cont'd) | - overstitched less than 1 inch on stitch type 301 (where three or more stitches are skipped consecutively) | | X |
| | NOTE: Skipped stitches not overstitched shall be classified as open seams. | | |
| | Needle chews resulting in cut, tear, or hole larger than 1/8 inch in length or diameter (see cut, tear, or hole) One or more required rows of stitching omitted (except of boxstitching) | X | |
| Boxstitching | Boxstitching incomplete: - one row of stitching omitted - two or more rows of stitching omitted Any boxstitching less than specified length by more than 1/8 inch | | X X X |
| Stitching ends | Overstitched less than 1 inch on stitch type 301 (except where ends are held down by other stitching or turned under in a hem, or where stitching is performed automatically) Secured with less than three tying, overlapping, or back stitches when automatic stitching is performed | | X X |
| Seams | Seams pleated - on roof - on eave or on wall | | X X |
| Seam type | Wrong seam type | X | |
| Stitch type | Wrong stitch type | X | |
| Stitch tension | Loose, resulting in an exposed bobbin or top thread for more than 6 inches Tight, as evidenced by puckering on seams for more than 6 inches | | X X |

MIL-T-10069G

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

| Examine | Defect | Classification | |
|--|--|----------------|--------------|
| | | Major | Minor A B |
| Seams and stitching (cont'd) | | | |
| Stitches per inch | Less than minimum specified (except on panel joining seams): | | |
| | - one stitch | | X |
| | - two or more stitches | | X |
| | Less than minimum specified on panel joining seams | X | |
| | More than maximum specified: | | |
| | - one stitch | | X |
| | - two or more stitches | | X |
| | 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 seams or heavy places in turning corners, shall be classified as follows: | | |
| | a. Within the minor "A" defect classification - minor "B" defect | | |
| | b. Within the minor "B" defect classification - no defect | | |
| Stitching gage | Not as specified | | X |
| Stitching margin | More than specified: | | |
| | - for more than 2 inches but not more than 4 inches in length | | X |
| | - for more than 4 inches in length | X | |
| | Less than specified: | | |
| | - for more than 2 inches but not more than 4 inches in length | | X |
| | - for more than 4 inches in length | X | |
| Stitching indicated by "Z" on drawings | Chain portion of stitching shows on outside of tent, ground cloths, or cover | | X |

MIL-T-10069G

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

| Examine | Defect | Classification | |
|-----------------------------------|--|----------------|--------------|
| | | Major | Minor A B |
| Seams and stitching (cont'd) | | | |
| Mends, darns or patches | Not in accordance with Department of the Army Field Manual FM 10-16 and not authorized by the contracting officer | X | |
| Components and assembly | Any component not fabricated of the applicable referenced material | X | |
| | Any component part or required operation omitted (unless otherwise classified) | X | |
| Hems | Twisted or pleated | | X |
| | Constructed with partial turnunder when double turnunder is required | | X |
| | Less than specified width by more than 1/4 inch | | X |
| Reinforcements and chafing strips | Improperly applied, causing excessive fullness on reinforcement or reinforced parts | | X |
| Binding | Loosely or improperly applied; ends not finished as specified | | X |
| Ring chapes | Any part of chapes single ply construction | | X |
| | Misplaced, failing to effect a smooth and secure closure | | X |
| Construction details: | | | |
| End walls; grommet reinforcements | Misplaced, i.e., grommets on door flaps fail to correspond with grommets on reinforcements and to effect a smooth and secure closure | | X |

MIL-T-10069G

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

| Examine | Defect | Classification | |
|-----------------------------------|--|----------------|--------------|
| | | Major | Minor A B |
| Construction details: (cont'd) | | | |
| Ventilator opening | Cutout on right wall half (facing end wall from inside of tent) | | X |
| | Any part of opening extending beyond edge of chafing string "A" (inside) | | X |
| Ventilator sleeve | Stitched to ventilator opening on inside of tent | | X |
| | Free edge of sleeve not reinforced by rope stiffener | | X |
| Ventilator flap | Misplaced, failing to cover ventilator opening fully | | X |
| | Bottom hem not reinforced by rope | | X |
| Ridge edge reinforcement | Bound edge not stitched through end wall halves and overlapped edges of door flaps | | X |
| Corners | Walls at top end of corners overlapped with end wall on outside, in lieu of inside | X | |
| | Overlapped corners not securely stitched | | X |
| | Top corner grommet not inserted through body end wall | | X |
| Sidewalls: | | | |
| Blackout flaps | Attached to end walls in lieu of side walls | | X |
| Facing "C" | Ends of facing not caught in eave stitching or in bottom hem stitching | | X |
| Heater duct flaps | Misplaced, failing to cover heater duct opening fully | | X |
| | Grommet on bottom edge of flap misplaced, failing to correspond with grommet on bottom hem of sidewall | | X |

MIL-T-10069G

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

| Examine | Defect | Classification | |
|---|--|----------------|--------------|
| | | Major | Minor A B |
| Sidewalls: (cont'd) | | | |
| Heater duct openings | Cut out on lower right of body wall in lieu of lower left corner (facing side wall from inside) | | X |
| Heater duct sleeve | Stitched to duct opening on inside of tent | | X |
| Heater duct sleeve reinforcement | Not reinforcing duct opening fully | | X |
| Eave reinforcement rope | Ends of rope reinforced by not handstitched to eave ends Attached to roof and wall after eave is formed, so that eave extension is not reinforced | X | X |
| Labels | Omitted, incorrect, illegible or misplaced: - erection instructions - identification | | X X |
| Marking: | | | |
| "US" on tent and cover; nomenclature on cover | Omitted, incorrect, illegible or misplaced | | X |
| Cleanness | Grease or oil stains; thread ends not trimmed to 1/2 inch or less | | X |

4.4.4 End item dimensional examination. The end item shall be examined for the defects listed in table II. The lot size shall be expressed in units of tents. The sample unit shall be one completely fabricated tent with cover. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 2.5 for major defects, 40.0 for major and minor A defects combined, and 100.0 for total (major, minor A, and minor B combined) defects.

MIL-T-10069G

TABLE II. End item dimensional defects

| Examine | Defect | Classification | |
|--|--|----------------|--------------|
| | | Major | Minor A B |
| Overall dimensions of tent | Smaller than specified dimensions less applicable minus tolerance indicated on drawings | X | |
| | Larger than specified dimensions and applicable plus tolerance indicated on drawings | | X |
| Dimensions on ground cloth, cover and tent openings (unless otherwise specified) | Smaller than specified dimensions less applicable minus tolerance indicated on drawings, but not smaller than specified dimensions less twice the applicable minus tolerance | | X |
| | Smaller than specified dimensions less twice the applicable minus tolerance indicated on drawings | | X |
| | Larger than specified dimensions and applicable plus tolerance indicated on drawings | | X |
| Location dimensions (unless otherwise specified) | Not within specified tolerances: - not exceeding twice the applicable tolerance | | X |
| | - exceeding twice the applicable tolerance | | X |
| Wall half overlap | Wall halves overlapped less than 1 inch (exclusive of door flaps) | | X |
| Sidewall facing | Outer edge of facing "C" uneven with edge of sidewall by more than 1/8 inch | | X |
| Webbing, tie tapes and wall ties | Finished length less than specified by more than 1/2 inch | | X |
| Grommets | Intermediate bottom grommets set off center of seams joining panel by more than 1/4 inch when 29-1/2 inch duck is used, or set unequally spaced by more than 2 inches when other than 29-1/2 inch duck is used | | X |

MIL-T-10069G

TABLE II. End item dimensional defects (cont'd)

| <u>Examine</u> | <u>Defect</u> | <u>Classification</u> | |
|--|---|-----------------------|--------------|
| | | Major | Minor A B |
| Grommets (cont'd) | Ridge-end grommet set beyond specified location; center ridge grommet set off center of body: | | |
| | - by more than 1/2 inch but not more than 1 inch | | X |
| | - by more than 1 inch | X | |
| | Eave grommets not set as indicated on Drawing 5-4-168 by more than 1 inch | | X |
| Rope components | Corner lacing, eave, cover tie and guy lines less than specified finished length: | | |
| | - by more than 4 inches | | X |
| | - by more than 4 inches but not more than 12 inches | | X |
| | - by more than 12 inches | X | |
| | Any other line less than specified finished length: | | |
| | - by more than 2 inches | | X |
| - by more than 2 inches but not more than 6 inches | | X | |
| - by more than 6 inches | X | | |

4.4.5 End item testing. Tents shall be tested as specified in 4.5.1. The sample unit shall be one completely fabricated tent. The lot size shall be expressed in units of tents. The inspection level shall be S-3. Any test failure shall be cause for rejection of the lot.

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 and the AQL, expressed in terms of defects per hundred units, shall be 2.5.

| <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. |

MIL-T-10069C

| <u>Examine</u> | <u>Defect</u> |
|----------------|---|
| 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 | Number per container is more or less than required. Number of intermediate containers is more or less that specified. Number of containers per intermediate container is more or less than specified. <u>1/</u> |

1/ For this defect one intermediate container shall be examined.

4.5 Methods of inspection.

4.5.1 Wicking test. The tent shall be tested in each of three areas as follows: at the peak, ridge, or joining seam abutting the peaks or ridge; at an intersection of a horizontal and vertical seam such as at an intersection of a side wall and roof; and on a roof panel seam. Suspend the seamed section of the test fabric in the center of a $6 \pm 1/8$ inch diameter hoop and form a depression with the seamed fabric in the hoop to a depth of $1 \pm 1/4$ inch. Slowly pour 500 mL of water at $77^{\circ}\text{F} \pm 4^{\circ}\text{F}$ into the cupped area (depression) and observe the under surface of the fabric for water penetration. Any wicking of water in any test area along the sewing thread, identified by a discoloration or darkening of the thread within 5 minutes after water is poured, shall constitute a test failure. Water leakage through the needle holes or between the plies of the lapped seamed fabric shall not be considered a failure.

5. PACKAGING

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

5.1.1 Level A. The test shall be preserved as follows:

a. Each tent, with corners unlaced, shall be spread out flat, outside up, and folded at the ridge with the roof, side walls, sod cloths, and the two parts of the front and rear walls together.

b. The guy lines shall be coiled and tied and placed on the tent roof. The eave and lacing lines shall be laid toward the center of the tent. The sod cloths shall be folded over on the side walls.

c. The six ground cloths shall be placed on the tent roof just above the eave, staggering them to use the space to the best advantage. The front and rear end walls shall be folded over on the body of the tent.

MIL-T-10069G

d. The ridge shall be brought over and placed on the eave. The roof shall then be folded over and placed on the side walls and the side walls folded in half. The remaining eave and lacing lines shall be laid toward the center of the fold.

e. The ends of the tent shall be folded toward the center, end-over-end, in increments of approximately 2-1/2 feet, making four such folds on each end forming two folded sections adjacent to each other. One of the folded sections shall then be folded on top of the other section.

f. The folded tent shall then be placed within the cover and the cover securely bound and closed with the tie lines provided. All flaps of the cover shall be neatly folded within the package, ends of the tie lines firmly secured to prevent their becoming snagged.

5.1.2 Commercial. The tent shall be preserved in accordance with ASTM D 3951.

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

5.2.1 Level A packing. One tent, preserved as specified in 5.1, shall be packed in a close fitting wood-cleated shipping container conforming to overseas type, style A of PPP-B-601. Each container shall be provided with skids fabricated as specified in the container specification. Each container shall be closed and reinforced with flat steel strapping in accordance with the appendix of the container specification.

5.2.2 Level B packing. One tent, preserved as specified in 5.1, shall be wrapped and sewn in cotton osnaburg cloth conforming to class 2 of CCC-C-429; or burlap cloth conforming to class 3 of CCC-C-467. The wrapping shall be securely handsewn with type I or II, 16-ply twine conforming to T-T-871 or type I, size No. 2 jute twine conforming to T-T-911, with approximately one stitch to the inch and every third stitch knotted, or alternatively, the seam of the wrap may be machine sewn. A minimum of 5 inches of wrapping material or tubing shall be gathered together on each of the four corners and securely sewn into ears for handles. However, the polyester thread used in manufacturing the end item may be used for effecting the machine sewn closure of the wrapping or tubing.

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

5.3 Marking. In addition to any special marking required by the contract or purchase order, shipments shall be marked in accordance with MIL-STD-129 or ASTM D 3951 as applicable.

MIL-T-10069G

5.3.1 Additional marking. Each shipping container and cloth covered bundle shall have stenciled or printed thereon, in characters not less than 3/4 inches high, the following:

SEE ERECTION INSTRUCTIONS

SEWED TO INSIDE OF TENT COVER

6. NOTES

6.1 Intended use. The tent is designed to furnish shelter for tank and truck maintenance crews and their equipment.

6.2 Ordering data. Acquisition documents should specify the following:

- a. Title, number, and date of this document.
- b. When a first article is required (see 3.1, 4.3, and 6.4).
- c. Selection of applicable levels of preservation and packing (see 5.1 and 5.2).

6.3 Sample. For access to samples, address the contracting activity issuing the invitation for bids.

6.4 First article. When a first article sample 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 offer should include specific instructions in all acquisition documents regarding arrangements for selection, inspection, and approval of the first article.

6.5 Recycled material. It is encouraged that recycled material be used when practical as long as it meets the requirements of this document (see 3.2).

6.6 Poles and pins. The following components are required for the erection of Tent, Maintenance Shelter, FWWMR, Olive Drab:

| | <u>Document</u> |
|--|-----------------|
| 1 each, Frame, Tent, Maintenance Shelter Complete: | |
| 3 each, Section number 1, bottom | - MIL-F-1461 |
| 4 each, Section number 2, middle | - MIL-F-1461 |
| 1 each, Section number 3, top | - MIL-F-1461 |
| 38 each, Pin, Tent, Wood, 16-inch | - MIL-P-2383 |
| or Pin, Tent, Aluminum, 9-inch | - MIL-P-501 |
| 18 each, Pin, Tent, Wood, 24-inch | - MIL-P-2383 |
| or Pin, Tent, Steel, 12-inch | - MIL-P-501 |

MIL-T-10069G

6.7 The repair of leaking seams. A satisfactory method of applying the textile compound for the repair of leaking seams is as follows:

a. A suitable volume of compound conforming to type I, class 1 of TT-P-595 shall be thoroughly stirred and diluted with an equal volume of petroleum solvent (Stoddard solvent or equivalent). Thoroughly stir the mixture again before use.

b. Prior to application of the compound, the tents must be dry. Special attention must be taken to insure adequate ventilation and that proper fire preventive measures are taken since the compound is flammable.

c. Two coats of the textile compound shall then be applied to the seams (on the outside of the tent only). A 4-inch wide stiff brush is recommended for use. The first coat shall be air dried for a minimum of 4 hours prior to application of the second coat. Elapsed time between coats may be reduced by providing a supply of hot air to evaporate the solvent more quickly. In this manner, a second coat may be applied as soon as the first coat is dry to the touch. After the application of the second coat, the treated tent shall be allowed to air dry for a period of at least 24 hours.

6.7.1 Seams to be treated. Seams which have failed the test specified in 4.5.1 shall be treated as follows:

- a. Failure at roof panel lap seams - treat all roof panel lap seams.
- b. Failure at peak reinforcement - treat all peak reinforcement stitching.
- c. Failure at eave - treat all stitching at eave and webbing reinforced roof joining seams.

6.8 International standardization agreements. Certain provisions of this specification are the subject of international standardization agreement as cited in NATO, STANAG NO. 2882, relative to camouflage requirements for tents, shelters and subsidiary components. When amendment, revision, or cancellation of this specification is proposed which will affect or violate the international agreement concerned, the preparing activity will take appropriate reconciliation action through international standardization channels including departmental standardization offices, if required.

6.9 Subject term (key word) listing.

Maintenance
Shelter
Tent

MIL-T-10069G

6.10 Changes from previous issue. Asterisks are not used 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

Preparing activity:

Army - GL
Project No. 8340-0497

Review activities:

Army - MD
Air Force - 82
DLA - CT

User activity:

Air Force - 45

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