

MIL-T-1111G
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SUPERSEDING
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MILITARY SPECIFICATION

TENT, COMMAND POST, M-1945, FIRE, WATER, WEATHER AND

MILDEW RESISTANT, OLIVE DRAB, COMPLETE

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

1. SCOPE

1.1 Scope. This document covers one type of wall tent, having the following dimensions: width, 10 feet; length, 20 feet, 7 inches; ridge height, 9 feet; and side wall height, 5 feet, 10-1/2 inches. The tent is equipped with a liner, detachable sidewall screens, and a cover.

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this specification to the extent specified herein. Unless otherwise specified, the issues 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.

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

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SPECIFICATIONS

FEDERAL

- L-P-378 - Plastic Sheet and Strip, Thin Gauge Polyolefin
- L-S-125 - Screening, Nonmetallic, Insect
- T-C-571 - Cords, Cotton; General and Special Purpose, Sash and Venetian Blind

- T-T-871 - Twine, Cotton, Wrapping
- T-T-911 - Twine, Fibrous, Jute
- V-F-106 - Fasteners, Slide, Interlocking
- V-T-285 - Thread, Polyester

- TT-P-595 - Preservative Coating, Canvas
- 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
- PPP-B-636 - Box, Shipping, Fiberboard

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- MIL-P-500 - Plates, Tent Peak and Ridge
- MIL-W-530 - Webbing, Textile, Cotton, General Purpose, Natural or in Colors
- MIL-H-1608 - Hooks, Tent
- MIL-R-1670 - Rope, Tent-Lay
- MIL-L-1709 - Lines, Tent
- MIL-S-1734 - Slips, Tent Line
- MIL-C-2399 - Cement, Liquid, Tent Patching
- MIL-R-3390 - Rings, Dee
- MIL-C-10859 - Cloth, Oxford, Cotton (Permeable)
- MIL-G-16491 - Grommet, Metallic
- MIL-L-35078 - Loads, Unit: Preparation of Semiperishable Subsistence Items; Clothing, Personal Equipment and Equipage; General Specification For
- MIL-T-40625 - Tubing, Bias Sewn (Burlap or Osnaburg) Cloth
- MIL-S-43002 - Shield, Stovepipe, Tent, Nonmetallic
- 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-43638 - Webbing, Textile, Woven, for Tent Framing
- MIL-W-44049 - Webbing, Textile and Tape, Textile, Polypropylene, General Purpose, Natural or in Colors

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STANDARDS

FEDERAL

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

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MIL-STD-105 - Sampling Procedures and Tables for Inspection
by Attributes
MIL-STD-129 - Marking for Shipment and Storage
MIL-STD-147 - Palletized Unit Load
MIL-STD-731 - Quality of Wood Members for Containers and Pallets

(Copies of specifications, standards, and handbooks required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting activity.)

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

Department of the Army Field Manual FM 10-16 General Repair of Tents,
Canvas and Webbing

(Copies may be obtained from the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402.)

DRAWINGS

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

5-4-269 - Tent, Command Post, M-1945, FWWMR, OD, Complete;
Assembly
5-4-270 - Views and Sections
5-4-271 - Body and Details
5-4-272 - Rear End and Details
5-4-273 - Vestibule Side and Roof
5-4-274 - Window Details
5-4-275 - Stovepipe Opening and Screen
5-4-276 - Ventilator and Opening
5-4-277 - Blackout Curtain and Lugs
5-4-278 - Liner Assembly
5-4-279 - Liner Body and Details
5-4-280 - Liner Front End and Rear End
5-4-501 - Tent, Command Post, M-1945, FWWMR, OD, Complete;
Erection Instructions
5-4-504 - Liner Erection Instructions
5-4-3359 - Tent Cover

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(Copies of drawings, publications, and other Government 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 specification 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 solicitation.

AMERICAN SOCIETY FOR TESTING AND MATERIALS

D 3951 - Standard Practice for Commercial Packaging

(Copies should be obtained from the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.)

(Nongovernment standards and other publications are normally available from the organizations which prepare or which distribute the documents. These documents also may be available in or through libraries or other informational services.)

2.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein, the text of this specification shall take precedence. Nothing in this specification, 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 be as specified herein (see 6.5).

3.2.1 Cloth, cotton duck. The cloth shall conform to MIL-C-43627, Olive Drab 7.

3.2.2 Cloth, cotton oxford. The cloth shall conform to type I, class 2 of MIL-C-10859.

3.2.3 Tape, textile, cotton. The tape shall be dyed Olive Drab 7 and shall conform to type I, class 4, 3/4-inch, 1-inch, 1-1/2, inch and 2-inch widths of MIL-W-43566. For liners only, alternatively the tape shall be polypropylene, conforming to type I class 4 of MIL-W-44049.

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3.2.4 Webbing, textile, cotton. The webbing shall be dyed Olive Drab shade No. 7 and shall conform to type III, class 4, 5/8-inch width of MIL-W-530.

3.2.5 Webbing, low elongation. The low elongation webbing shall conform to types I and II of MIL-W-43638.

3.2.6 Thread, polyester.

3.2.6.1 Tent, screens and cover. The thread shall conform to type I, class 1, sub-class B, shade S-1 (Cable No. 66022) of V-T-285. The dyed thread shall show fastness to weathering equal to or better than the standard shade sample (see 6.3). When no standard shade sample is available, the dyed thread shall show good fastness to weathering.

3.2.6.2 Liner. The thread shall be natural and shall conform to type I or II, class 1 of V-T-285.

3.2.6.3 Sizes. Thread sizes shall be as follows:

For all stitching on tent, screens and cover, except bartacking and stitching indicated by "Z" on drawings	- Size FF for needle and F bobbin
For bartacking	- Size E for needle and bobbin
For stitching on tent, screens and cover indicated by "Z" on drawings	- Size FF for needle, size F for looper
For all stitching on liner, except stitching indicated by "Z" on drawings	- Size E for needle and bobbin
For stitching on liner indicated by "Z" on drawings	- Size E for needle and for looper

3.2.7 Screening, nonmetallic. The screening shall conform to type III, class 1, size 18 by 18, of L-S-125, and the color shall be olive green.

3.2.8 Shield, pipe, space heater. The stovepipe shield shall conform to MIL-S-43002.

3.2.9 Cord, cotton. The braided cord shall conform to type I, class 3, size 4 of T-C-571. The shade shall be olive drab in color prior to finishing. The color of the cord after treatment will be acceptable.

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3.2.10 Plastic film. The film shall conform to the requirements for 0.0060 inch thick film, type I, class 1, grade A, B or C, finish 1 of L-P-378 except that the film thickness shall be 0.020 ± 0.004 inch. The requirements for slip, ink adhesion, water vapor permeability, impact resistance, and heat-seal strength shall not be applicable.

3.2.11 Lines, tent. The tent lines shall conform to MIL-L-1709. Types and use shall be as follows:

<u>Type</u>	<u>Use</u>
I	Footstop
III	Door tie line
VI	Doorflap line and jumper line
X	Jumper line
XVI	Hoisting line
XIX	Corner line
XXI	Door eave line and cover tie line

3.2.12 Rope, tent-lay. The rope for the stiffener shall conform to type I or II, class 2, 1-1/8 inch circumference of MIL-R-1670.

3.2.13 Fasteners, slide, interlocking. The slide fasteners shall conform to size H, wire stirrup pull of V-F-106. Slide fastener chain shall be fabricated of brass or polyester coil. The slider for the brass chain shall be brass and the slider for the polyester coil shall be die cast zinc alloy. The slide fastener tape shall be dyed to match olive drab shades S (CA 66519) and be water repellent and mildew-resistant. (Tapes made of 100 percent polyester need not be tested for mildew resistance.) The color of the tape after treatment will be considered acceptable. The tape shall show good fastness to weathering. Alternatively, the slide fastener chain shall be polyester continuous monofilament in a ladder or coil type configuration. Color of the chain shall be Olive Drab or natural finish brass and the sliders shall be brass. Types and styles shall be as follows:

- a. For window, sidewall and stovepipe opening - Type I, style 2 slide fastener.
- b. For blackout curtain and liner opening - Type III, style 1 slide fastener.

3.2.14 Grommet, metallic. The grommets shall conform to type III, class 3, sizes 0, 4, and 5 of MIL-G-16491.

3.2.15 Plate, ridge. The ridge plates shall conform to type II and III of MIL-P-500.

3.2.16 Rings, dee. The dee rings shall conform to either class 1 or 2, configuration K, size 1 by 3/4 inch of MIL-R-3390.

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

3.2.18 Hooks, tent. The triangle eye hooks shall conform to type I, size 1-1/2-inch of MIL-H-1608.

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

3.3.1 Stitching, machine.

3.3.1.1 Types of stitching. All stitch types, except bartacking, shall conform to FED-STD-751 as follows:

For tent, screens and cover:

For all stitching except stitching indicated by "Z" on drawings, and alternatively for attachments of slide fasteners

- Type 301, 5 to 7 stitches per inch

For stitching indicated by "Z" on drawings and for attachments of slide fasteners

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

For liner:

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

- Type 301, 6 to 8 stitches per inch

For stitching indicated by "Z" on drawings and alternatively for attachments of slide fasteners

- Type 401, 6 to 8 stitches per inch. Chain portion of stitching shall not appear on outside of liner.

For bartacking:

- Bartack, 1/2 (+1/8, -1/16) inch long with 1/8 inch bight and shall contain 28 stitches

3.3.1.2 Type 301 stitching. Ends of all stitching shall be backstitched or overstitched 1/2 inch minimum except when caught in other stitching or turned under in a hem. Thread tension shall be maintained so that there will be no loose stitching resulting in puckering of material sewn. The lock shall be embedded in the material sewn.

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

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

b. Thread breaks or two or more consecutive skipped or run-off stitches noted during inspection of the item (in-process or end item) shall be repaired by overstitching. The stitching shall start a minimum of 1 inch before the defective area (1/2 inch on box, box and cross, and W-W stitching) and continue a minimum of 1 inch beyond the defective area onto the existing stitching. Loose or excessively tight stitching shall be repaired by removing the defective stitching, without damaging the materials, and restitching in the required manner. 1/

1/ When making the above repairs, the ends of the stitching are not required to be backstitched.

3.3.1.3 Type 401 stitching. Thread tension shall be maintained so that there will be no loose stitching. Both ends of seams or stitching produced with a 401 stitch type, when not turned under a hem or held down by other stitching, shall have a 3/4 to 1 inch chain extending beyond each end. The looper (under thread) shall always be on the inside of the tent or cover. All repairs shall be made in accordance with 3.3.1.2.1a or 3.3.1.2.1b.

3.3.1.4 Automatic stitching. Automatic stitching machines may be used to perform any of the required stitch patterns provided the requirements of the stitch pattern, stitches per inch, size and type of thread are met, and at least three or more tying, overlapping or backstitches are used to secure the ends of the stitching.

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

3.3.1.6 Lubrication of thread. The addition of any lubricant to the polyester sewing thread prior to or during the sewing operation is prohibited.

3.3.1.7 Stitching margins. Unless otherwise specified, all stitch margins shall be 1/8, +1/16, -0 inch.

3.3.1.8 Bartacking. Bartacking shall be free of thread breaks and loose stitching.

3.3.2 Setting of grommets. Holes punched to receive the grommets shall be smaller than the outside diameter of the grommet barrel so that the barrel must be forced through the hole. The grommets shall be securely clinched without cutting the materials or splitting or damaging the grommets.

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3.3.3 Repairs. Any necessary repairs shall be effected in accordance with Department of the Army Field Manual FM 10-16 except that hand-sewn 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 contracting officer authorization. Repairs required as a result of failure to meet the requirements of the cup test and when authorized by the contracting officer shall be performed by treating with a compound conforming to type I, class 1, shade olive drab of TT-P-595 prior to retesting (see 4.5).

3.3.4 Wicking of sewing thread (cup test). There shall be no dripping of water through the tent stitching when the tent is tested as specified in 4.5.1. The cup test is intended to insure that nonwicking thread has been utilized and that no lubrication has been added to the polyester thread during the sewing operation.

3.3.5 Splicing of cloth. There shall be no splicing of roof, wall or tent cover panels. Splicing of reinforcements will be permitted and, if performed, shall conform to the following requirements:

- a. Eight feet or less in length - One splice permitted;
More than 8 feet but not more than 12 feet in length - Two splices permitted;
More than 12 feet in length - Three splices permitted.
- b. The shortest length of any spliced piece shall be not less than 2 feet.
- c. Pieces shall be joined as shown on Drawing 5-4-272, section C-C.

3.3.6 Splicing of webbing. There shall be no splicing of webbing in any portion of the roof section of the tent. Splicing of webbing will be permitted in the liner and other areas of the tent, and if performed, shall conform to Drawing 5-4-270. The minimum distance between splices shall be 6 feet.

3.3.7 Replacement of defective components. During the spreading, cutting, and manufacturing process, components of the tent having material defects or damages that are classified as defects in 4.4.2 or 4.4.3 shall be removed from production and replaced with non-defective and properly matched components.

3.3.8 Fusing of ends of synthetic webbing and tape. All ends of synthetic webbing and tape shall be fused. The apparatus used to fuse the ends shall be capable of providing sufficient heat to provide a smooth edge with the cut ends of the yarns all fused together. Fusing of the ends shall be accomplished prior to being assembled for stitching.

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

3.4.1 Special marking. The letters "U.S." on the tent, liner, and cover, and the nomenclature 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 labels. Identification labels shall conform to type VI, class 6 and shall be 3-1/2 inches by 5-1/2 inches minimum with a blank space of at least 1-1/4 inches provided at the bottom of the label for the Department of Defense inspector's stamp. Identification labels shall be stitched to the tent, cover, liner, and screen wall in the locations shown on the drawings.

3.4.3 Label of erection instructions. Label of erection instructions shall conform to type VI, class 7 and shall be stitched to the tent, liner, and cover in the locations shown on the drawings. The label shall be a proportionate copy of Drawing 5-4-501 for the tent, Drawing 5-4-504 for the liner, and Drawing 5-4-3359 for the cover, as reproduced from a glossy print of each drawing furnished by the contracting officer. The size of the label shall be, borderline to borderline, $15 + 1/4$ inches in the longer dimension, with a minimum 1/2-inch margin outside of the borderline on all sides.

3.5 Workmanship. Cloth components shall be clean and free of holes, cuts, tears, or cloth defects such as multiple floats or broken or missing yarns. Webbing and tape shall not have frayed or scalloped edges and rope components shall be free of cuts or breaks. Thread tension shall be maintained so that there will be no loose stitching and seam allowances shall be maintained with seams properly sewed so that no runoffs, twists, pleats, or open seams shall result. Care shall be taken to insure that no needle chews occur. All thread ends shall be trimmed to 1/4 inch or less in length. Metal components shall be free of burrs, sharp edges and corroded areas and shall not be broken or malformed.

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.

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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.

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

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 defects specified in 4.4.3 and 4.4.4, and tested as specified in 4.4.5. The presence of any defect or failure of 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.

4.4.2 In-process inspection. Inspection shall be made of the following operations and requirements to establish conformance to specified requirements. Whenever nonconformance is noted, correction shall be made to the items affected and to the operation. Items which cannot be corrected shall be removed from production.

- a. Hole punching conformance to requirements in 3.3.2.
- b. Lubrication of thread conformance to requirements in 3.3.1.6.

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4.4.3 End item visual examination.

4.4.3.1 Tent, command post, 1945, complete. The end item shall be in an erected position so that both the inside and outside of the tent can be examined along with its cover, liner and screenwall for defects listed in table I. The lot size shall be expressed in units of tents. The sample unit shall be one tent. The inspection level shall be I and the (AQL), expressed in terms of defects per hundred units, shall be 40 for major defects, 150 for major and minor A combined defects, and 250 for total (major, minor A and minor B combined) defects.

4.4.3.2 Liner, only. The end item shall be in an erected position so that both the inside and outside of the tent liner can be examined for defects listed in table I. The lot size shall be expressed in units of liners. The sample unit shall be one liner. The inspection level shall be I and the AQL, expressed in terms of defects per hundred units, shall be 25 for major defects, 65 for major and minor A combined defects, and 150 for total (major, minor A and minor B combined) defects.

4.4.3.3 Screen wall, only. Both sides of the screen wall shall be examined for defects listed in table I. The lot size shall be expressed in units of screen walls. The sample unit shall be one screen wall. The inspection level shall be I and the AQL, expressed in terms of defects per hundred units, shall be 10 for major defects, 25 for major and minor A combined defects, and 100 for total (major, and minor A and minor B combined) defects.

4.4.3.4 Cover, only. Both sides of the cover shall be examined for defects listed below in table I. The lot size shall be expressed in units of covers. The sample unit shall be one cover. The inspection level shall be I and the AQL, expressed in terms of defects per hundred units, shall be 10 for major defects, 25 for major and minor A combined defects, and 100 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, tear, or hole (including exposed drill hole) greater than 1/8 inch in length or diameter:		
	-on tent	X	
	-on cover or sod cloth		X

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

Examine	Defect	Classification		
		Major	Minor	
			A	B
Fabric (cont'd)	Cut, tear, or hole (including exposed drill hole) 1/8 inch or less in length or diameter:			
	-more than 20 holes:			
	-on tent	X		
	-on cover or sod cloth		X	
	-more than 10 but not more than 20 holes:			
	-on tent		X	
	-on cover or sod cloth			X
	-more than 5 but not more than 10 holes:			
	-on tent			X
	Cut, tear, or hole on liner:			
	-greater than 1/4 inch in length or diameter	X		
	-greater than 1/8 inch but not greater than 1/4 inch in length or diameter		X	
	Cut, tear, or hole 1/8 inch or less in length or diameter			
Screening	-more than 20 holes:	X		
	-more than 10 but not more than 20 holes:		X	
	-more than 5 but not more than 10 holes:			X
	Broken or missing yarns, multiple floats clearly visible at normal inspection distance (approximately 3 feet)		X	
	Hole, cut or tear:			
	-more than 2 inches in length or diameter	X		
	-more than 1/4 inch but not more than 2 inches in length		X	
	-1/4 inch or less in length			X

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

Examine	Defect	Classification		
		Major	Minor	
			A	B
Webbing and tape	Edge frayed or scalloped			X
Film, polyethylene	Any cut, puncture, crack, or deep crease	X		
Rope components	Any cut or break		X	
	Eye splice omitted		X	
Tent lines	Improperly knotted; eye on footstops less than 3-1/2 inches			X
	Not spliced as specified; free ends not finished as specified; length 2 inches less than specified			X
Hardware	Broken or missing	X		
	Malformed:			
	-fails to perform intended function	X		
	-but will perform intended function		X	
	Corroded area			X
	Burr or sharp edge which may cause injury in handling or damage to fabric	X		
Grommets	Improperly set; two or more teeth exposed			X
	Clinched loosely, allowing grommet to rotate in hole			X
	Clinched excessively tight, cutting fabric, damaged or split:			
	-on tent	X		
	-on cover		X	
Tent hook, triangle eye	Misplaced, so that eave triangle fails to correspond with No. 4 grommets on eaves, or obstructs passage of pole spindle	X		
	Hook portion not inserted through ridge plate holes, or not securely closed allowing the connecting hardware to become disengaged; set with hook portion facing roof, causing hook portion to chafe roof			X

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

Examine	Defect	Classification	
		Major	Minor A B
Ridge plates	Misplaced, so that center hole on plate fails to correspond with the No. 5 grommet on ridge resulting in obstruction of passage of pole spindle	X	
Dee rings	Not attached to vestibule as specified		X
Seams and stitching	Open seam on stitch type 301:		
	-for more than 1/4 inch but not more than 1 inch		X
	-for more than 1 inch		X
	Open seam on stitch type 401:		
	-one row of stitching open for 1 inch or less on tent, liner, or cover		X
	-one row of stitching open for more than 1 inch:		
	-on tent roof or liner		X
	-on tent wall or cover		X
	-both rows of stitching open (not necessarily at the same location):		
	-on tent roof or liner	X	
	-on tent wall or cover		X
NOTE: A seam shall be classified as open when one or more stitches joining a seam are broken and are not overstitched, or when two or more 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 sides of a seam are open.			
Raw edges caught in stitching:			
	-more than 1 inch but not more than 3 inches		X
	-more than 3 inches	X	

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

Examine	Defect	Classification	
		Major	Minor A B
Seams and stitching (cont'd)	Pleated or puckered seams		X
	Thread breaks not repaired as specified		X
	Needle chews resulting in cut, tear, or hole (see cut, tear, or hole under fabric examination)		
	One or more required rows of stitching omitted (except on boxstitching)	X	
Boxstitching	Boxstitching incomplete:		
	-one row of stitching omitted		X
	-two or more rows of stitching omitted	X	
	W-W stitching incomplete:		
	-two or more rows of stitching omitted	X	
	-one row of stitching omitted		X
	Any "W" stitching less than specified length by more than 1 inch		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		X
	Tight, as evidenced by puckering of seam for more than 6 inches		X
Stitches per inch	Less than minimum specified:		
	-on panel joining seams		X
	-other than on panel joining seams:		
	-one stitch		X
	-two or more stitches		X
	More than maximum specified:		
	-one stitch		X
	-two or more stitches		X

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

Examine	Defect	Classification	
		Major	Minor A B
Seams and stitching (cont'd)			
Stitches per inch (cont'd)	NOTE: Variation in the number of stitches per inch, caused by the operator speeding up the machine in order to sew over heavy places or heavy seams or 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	Larger than specified: -for less than 4 inches in length -for 4 inches or more in length Less than specified: -for more than 2 inches but not more than 4 inches in length -for more than 4 inches in length		X X X
Stitching ends	Overstitched less than 1/2 inch on stitch type 301 (except where ends are held down by other stitching, turned under in a hem or where stitching is performed automatically) Secured with less than three tying, overlapping, or backstitches when automatic stitching is performed		X X
Stitching indicated by "Z" on drawings	Chain portion of stitching shows on outside of tent, liner, screen walls or cover		X
Mends, darns or patches	Repairs not in accordance with Department of the Army Field Manual FM 10-16; not authorized by the contracting officer (see 3.3.3)	X	

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

Examine	Defect	Classification		
		Major	Minor A	B
Components and assembly	Any component not fabricated of applicable referenced material	X		
	Any component operation omitted	X		
Construction details:				
Hems	Constructed with partial turnunder when doubled turnunder is required		X	
	Twisted or pleated			X
Cloth splicing	Splice in roof, wall or tent cover panels	X		
	Number of splices per reinforcement more than specified			X
	Spliced pieces not joined as shown on Drawing 5-4-272 section C-C		X	
Splicing of webbing	Splicing (when necessary) not made as indicated on drawing		X	
	Distance between splices less than stated		X	
	Splicing of webbing in roof portion	X		
Reinforcements	Improperly applied, causing excessive fullness on reinforcements or reinforced parts		X	
	Not securely stitched to reinforced parts on all sides, or not securely caught in seams of reinforced parts	X		
Binding	Loosely applied; ends not finished as specified		X	
Slide fasteners	Slider jams or fails to interlock chain	X		
	Any tape improperly assembled causing failure of chain to effect a smooth and secure closure	X		
	Wrong length	X		
	Width not as specified	X		
	Puckering of tape	X		

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

Examine	Defect	Classification	
		Major	Minor A B
Construction details: (cont'd)			
Slide fasteners (cont'd)	Broken or missing scoops Thong omitted	X	X
	NOTE: The inspector shall pull slide fasteners three or four times to an open and closed position to determine proper function and effectiveness of each fastener.		
Side walls, outside window panes and screens	Film not securely caught in frame stitching all around panes Edges of screen or rear end window not securely caught in stitching attaching window reinforcement webbing to opening Blackout curtain and window pane not assembled to window opening as indicated on Drawing 5-4-274		X X X
Pole cut-outs on sod cloths	Misplaced. i.e., failing to provide clearance for eave pole		X
Lugs "A" and "B"	Not constructed as indicated on Drawing 5-4-277 or not attached to side walls as indicated on Drawing 5-4-277, Section E-E, F-F and K-K		X
Stovepipe shield	Cut, tear, or hole (except pinhole) Abrasion, blister, or lump Edges of fabric visible through inside edge of molded collar Die cut hole visible through outside edge of molded collar Set to roof with oval opening in a horizontal position instead of vertical	X X X X	X

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

Examine	Defect	Classification	
		Major	Minor A B
Construction details: (cont'd)			
Ventilator	Screening not securely caught in stitching attaching reinforcement webbing to ventilator opening		X
	Ventilator duct or cover not constructed or not assembled to ventilator opening as indicated on Drawing 5-4-276.		X
Blackout curtain	Not assembled to vestibule, body walls and roof as indicated on Drawing 5-4-270, Section A-A		X
	Stitching joining curtain to roof, continuous around peak at ridge, failing to provide for passage of end of front plate		X
Eaves	Excessive fullness along eave overlap		X
Points of stress on ridge and eaves	Webbing loops engaging hardware set loose, failing to relieve stress from canvas	X	
Liner:			
Windows and panes	Plastic pane and frame attached to window opening on outside of liner in lieu of inside	X	
	Window assembly not stitched to walls through window opening reinforcement tape	X	
Eaves	Tie tapes set inside of liner in lieu of outside	X	
Stovepipe opening	Tie tapes set on inside of liner at opening in lieu of outside; tie tapes not securely caught in both rows of stitching attaching reinforcement tape to opening		X

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

Examine	Defect	Classification	
		Major	Minor A B
Construction details: (cont'd)			
Liner: (cont'd)			
Ridge	Stitching attaching hoisting line loops to ridge end extending to end of loops, failing to provide clearance for hoisting lines	X	
General	Any other construction detail not performed as specified		X
Labels	Omitted, incorrect, illegible, or misplaced: -erection instructions -identification	X	X
Markings	Omitted, incorrect, illegible, or misplaced		X
Cleanness	Grease or oil stains		X
	Thread ends not trimmed to 1/4 inch or less (except in slide fastener area)		X
	Thread ends not trimmed to 1/4 inch or less in slide fastener area	X	

4.4.4 End item dimensional examination.

4.4.4.1 Tent, only. 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 tent. 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, 25 for major and minor A combined defects, and 65 for total (major, minor A, and minor B combined) defects.

4.4.4.2 Cover, only. The end item shall be examined for the defects listed in table II. The lot size shall be expressed in units of covers. The sample unit shall be one cover. The inspection level shall be S-3 and the AQL,

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expressed in terms of defects per hundred units, shall be 6.5 for major defects, 15 for major and minor A combined defects, and 65 for total (major, minor A, and minor B combined) defects.

TABLE II. End item dimensional defects (tent and cover)

Examine	Defect	Classification	
		Major	Minor A B
Overall dimensions of tent and cover	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 of screen walls, openings, or cover	Smaller than specified dimensions less applicable minus tolerance indicted 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	X	
	Larger than specified dimensions and applicable plus tolerance indicated on drawings	X	
Grommets	Eave grommets set out of alignment with center line of roof reinforcement webbing by more than 1/2 inch; set with rim even with or extending beyond eave bend line	X	
	Ridge grommets set-off center of ridge: -by more than 1/2 inch, but not more than 1 inch		X
	-by more than 1 inch	X	
	Screen walls grommets do not correspond with grommets on lugs		X
	Lug and screen grommets unequally spaced by more than 1/2 inch		X
	Wall bottom grommets set with rim extending beyond bottom edge of walls; intermediate and corner wall bottom grommets set off center of seams by more than 1/4 inch		X

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

Examine	Defect	Classification	
		Major	Minor A B
Hems	Hems required to finish less than 3/4 inch in width, less than specified; hems required to finish 3/4 inch or more in width, less than specified by more than 1/4 inch		X
Windows	Inner edge of webbing reinforcements uneven with edges of window openings by more than 1/8 inch		X
Reinforcements	Finished dimensions less than specified by more than 1/2 inch		X
Location dimensions (unless otherwise specified)	Not within the specified tolerance but not exceeding twice the applicable tolerance Exceeding twice the applicable tolerance		X
		X	

4.4.4.3 Liner, only. The end item shall be examined for the defects listed in table III. The lot size shall be expressed in units of liners. The sample unit shall be one liner. 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, 15 for major and minor A combined defects, and 40 for total (major, minor A, and minor B combined) defects.

TABLE III. End item dimensional defects (liner)

Examine	Defect	Classification	
		Major	Minor A B
Overall dimensions of liner	Smaller than specified dimensions less applicable minus tolerance indicated on drawings Larger than specified dimensions and applicable plus tolerance indicated on drawings	X	X
Dimensions of openings	Larger or smaller than specified dimensions by more than 1/2 inch (unless otherwise specified)		X

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TABLE III. End item dimensional defects (liner) (cont'd)

Examine	Defect	Classification	
		Major	Minor A B
Tape, tie	Finished length less than specified by more than 1 inch		X
Windows	Inner edges of reinforcement tape uneven with edges of window open- ing by more than 1/8 inch		X
Location dimensions	Not within specified tolerance: -not exceeding twice the applicable tolerance		X
	-exceeding twice the applicable tolerance		X

4.4.5 End item testing. The completely fabricated tents shall be tested as specified in 4.5.1 for conformance to the wicking requirement specified in 3.3.4. The lot size shall be expressed in units of tents. The sample size shall be the number of tents indicated by inspection level 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 AQ', 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.
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.

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4.4.7 Palletization examination. The fully packaged and palletized end items shall be examined for the defects listed below. The lot size shall be expressed in units of palletized unit loads. The sample unit shall be one palletized unit load, fully packaged. The inspection level shall be S-1 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 requirement.
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.

4.5 Method of Inspection.

4.5.1 Wicking of sewing thread (cup 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 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.

5.1.1.1 Complete tent. Each tent shall have the screens laced in place and the slide fasteners closed, except the fastener attached to the backout curtain. The tent shall be folded at the ridge and laid out flat, one side on top of the other, the sod cloth and vestibule door flaps being extended and the blackout curtain arranged neatly, one half on top of the other half. The rear of the tent shall be folded over on top of the tent, the fold line extending from the rear ridge plate down along the rear body slide fasteners. The door flaps shall

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be folded over on top of the vestibule, and the vestibule shall then be folded over on top of the tent, the fold line extending from the front ridge plate down along the front body slide fasteners. The ridge shall be folded over on top of the tent deck down to the eave. The sod cloths shall be folded over on top of the side walls up to the eave. The tent deck shall then be folded over on top of the side walls. The exposed eave lines shall be placed on the folded tent. The tent liners shall be folded in a similar manner as specified for the tent. The folded tent liner shall then be placed on the folded tent. Each end of the folded tent shall be folded over to the center and then one half folded over on top of the other half, the liner being within the folds of the tent. The folded tent shall then be placed within the tent cover and the covers securely closed using the lines and grommets provided.

5.1.1.2 Liner. Each liner when procured separately (see 6.2) shall be folded or rolled into a compact unit.

5.1.2 Commercial. Tents or liners when procured separately shall be preserved in accordance with ASTM D 3951. (see 6.2)

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

5.2.1 Level A packing.

5.2.1.1 Complete tent. One complete tent, preserved as specified in 5.1, shall be packed in a close-fitting plywood box conforming to overseas type, style A of PPP-B-601. Each box shall be provided with skids fabricated as specified in the box specification. Each box shall be closed and reinforced with steel strapping in accordance with the box specification.

5.2.1.2 Liner. Each liner when procured separately (see 6.2), preserved as specified in 5.1, shall be packed in a shipping container. The shipping container shall be a fiberboard box conforming to style RSC-L, grade V2s of PPP-B-636. Inside dimensions of the box for the liner shall be approximately 36 inches in length, 9 inches in width, and 9 inches in depth. Boxes shall be top-loading or end-loading. Each box shall be closed, waterproofed, and reinforced with strapping or tape banding in accordance with the appendix of PPP-B-636. Boxes 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.

5.2.2.1 Complete tent. One complete tent, preserved as specified in 5.1, shall be wrapped 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 hand sewn with type I or II, 16 ply cotton twine conforming to T-T-871 or type I, size No. 2 jute twine conforming to T-T-911, with approximately one stitch to

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the inch and every third stitch knotted. Alternatively, the seams of the wrap may be machine-sewn. In lieu of the sewn wrap, bias sewn tubing conforming to MIL-T-40625 may be used. A minimum of 5 inches of wrapping or tubing shall be gathered together on each of the four corners and sewn into ears for handles. Whenever machine sewing is used, the thread type, stitch type, and number of stitches per inch shall conform to the requirements specified in MIL-T-40625. The polyester thread used to manufacture the tent may be used for effecting the machine sewn closure of the wrapping or tubing.

5.2.2.2 Liner. Each liner when procured separately (see 6.2), preserved as specified in 5.1, shall be packed in a shipping container. The shipping container shall be a fiberboard box conforming to style RSC-L, type CF (variety SW) or SF, class domestic, grade 275 of PPP-B-636. Inside dimensions of the box for the liner shall be approximately 36 inches in length, 9 inches in width, and 9 inches in depth. Boxes shall be top-loading or end-loading. Each box shall be closed in accordance with method II as specified in the appendix of PPP-B-636.

5.2.2.2.1 Weather-resistant shipping container. 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 the appendix of PPP-B-636.

5.2.3 Commercial packing. Tents or liners when procured separately, preserved as specified in 5.1, shall be packed in accordance with ASTM D 3951.

5.3 Palletization. When specified (see 6.2), liners packed as specified in 5.2.2 and 5.2.3, shall be palletized on a 4-way entry pallet in accordance with load type Ia of MIL-STD-147. Pallet type shall be type I (4-way entry), type IV, or type V in accordance with MIL-STD-147. Pallets shall be fabricated from wood groups I, II, III, or IV of MIL-STD-731. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding means K and L or film bonding means O or P. Pallet pattern shall be number 50 for the liners in accordance with the appendix of MIL-STD-147.

5.4 Marking. In addition to any special marking required by the contract or purchase order, shipping containers and cloth covered bundles shall be marked in accordance with MIL-STD-129 or ASTM D 3951, as applicable.

5.4.1 Additional marking. The following shall be stenciled or imprinted on each shipping container and cloth covered bundle in characters not less than 3/4 inch high: "SEE ERECTION INSTRUCTIONS SEWED TO INSIDE OF TENT COVER".

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6. NOTES

6.1 Intended use. The tent is used in theaters of operations to provide office shelter for staff sections of the several command echelons. The tent may be completely blacked out, and thus may be used in combat areas without fear of observation. When necessary, this tent may be used for the quartering of three officers. The tent is also suitable for use as a battalion aid station, the vestibule being long enough to accommodate a stretcher and bearers when both the blackout curtain and the front door are closed.

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).
- d. When a liner is procured separately (see 5.1.1.2, 5.2.1.2 and 5.2.2.2).
- e. Type and class of unit load required (see 5.2.1.2).
- f. When weather resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.2.1).
- g. When palletization is required (see 5.3).

6.3 Standard samples. For access to a standard shade sample of thread, address the contracting activity issuing the invitation for bids.

6.4 First article. When a first article is required, it shall be inspected and approved under the appropriate provisions of FAR 52.209. The first article should be a preproduction sample. The contracting officer should specify the appropriate type of first article and the number of units to be furnished. The contracting officer should include specific instructions in all acquisition instruments 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 Other components. The tent covered by this document consists of the following components:

- a. Tent, Command Post, M-1945, Fire, Water, Weather and Mildew Resistant, Olive Drab.
- b. Liner; Tent, Command Post, M-1945, Fire, Water, Weather and Mildew Resistant, Olive Drab.
- c. Screen Wall; Tent, Command Post, M-1945, Fire, Water, Weather and Mildew Resistant, Olive Drab.
- d. Tent Cover, General Purpose Use.

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6.7 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 seams.
- b. Failure at eave (except "W" stitching):
 - 1. Stitching joining roof and wall - treat all stitching on fabric eave.
 - 2. Webbing stitching - treat all webbing stitching on roof.
- c. Failure at ridge (except "W" stitching):
 - 1. Stitching attaching ridge reinforcement - treat all stitching on roof reinforcements.
 - 2. Webbing stitching - treat all webbing stitching on roof.

6.8 Seam retreatment. A satisfactory method of applying the textile compound for repair of leaking seams is as follows:

- a. A suitable volume of textile compound conforming to type I, class I of TT-P-595 (NSN 8010-00-515-2487) 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 four-inch wide stiff brush is recommended for use. The first coat shall be air dried for a minimum of four 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.

6.9 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.

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6.10 Subject term (key word) listing.

Command Post
Shelter
Tent

6.11 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
Navy - NU
Air Force - 99

Preparing activity:

Army - GL
Project No. 8340-0505

Review activities:

Army - MD
Air Force - 82
DLA - CT

User activities:

Navy - YD, MC
Air Force - 45

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