

MIL-T-43618B
15 September 1983
SUPERSEDING
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MILITARY SPECIFICATION

TAPE, PRESSURE SENSITIVE ADHESIVE, FOR MENDING NYLON PARACHUTE CANOPIES

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 mending tape for repairing small tears in nylon cargo parachute canopies. The tape is rip-stop nylon fabric, coated on one side with pressure sensitive adhesive which is protected with a removable liner.

* 2. APPLICABLE DOCUMENTS

2.1 Government documents. Unless otherwise specified, the following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of this document to the extent specified herein.

SPECIFICATIONS

FEDERAL

PPP-B-601 - Boxes, Wood, Cleated - Plywood
PPP-B-636 - Boxes, Shipping, Fiberboard

MILITARY

MIL-C-7020 - Cloth, Parachute, Nylon

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: US Army Natick Research and Development Laboratories, Natick, MA 01760 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

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STANDARDS

FEDERAL

FED-STD-191 - Textile Test Methods

MILITARY

MIL-STD-105 - Sampling Procedures and Tables for Inspection
by Attributes

MIL-STD-129 - Marking for Shipment and Storage

MIL-STD-147 - Palletized Unit Loads

(Copies of documents required by manufacturers in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting officer.)

2.2 Other publications. Unless otherwise specified, the following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of this document to the extent specified herein.

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

D 3611 - Accelerated Aging of Pressure - Sensitive Tapes

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.

3. REQUIREMENTS

3.1 Materials.

3.1.1 Cloth. The base cloth for the tape backing shall be made of polyamide multi-filament yarns prepared from hexamethylene diamine and adipic acid or its derivatives. The yarns shall have a melting point of not less than 472°F and shall not be bleached in any manner or process. The cloth shall be of a color suitable for assuring conformance to the color requirement for the tape (see 3.2.1). The cloth shall show good colorfastness to cold water and light.

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3.1.1.1 Weave. The rip-stop cloth shall be plain weave, except that it shall have reinforcing ribs in both directions, made by pairing two warp yarns and two filling yarns to weave as one at uniform intervals. There shall be not less than 4.5 repeats of the pattern per inch in both directions.

3.1.2 Adhesive. The adhesive for the tape shall be a water insoluble, pressure sensitive adhesive which requires no heat, solvent, or other preparation, prior to, or after application of the tape to clean, dry nylon cloth.

3.1.3 Liner. The liner for protecting the adhesive shall be of such material as to permit easy removal for fast, distortion free application of the tape. During removal, the liner shall not break and shall not remove the adhesive from the cloth backing when tested as specified in 4.2.3.

3.2 Tape construction. The finished tape shall consist of the nylon rip-stop cloth backing specified in 3.1.1, completely and evenly coated on one side with the adhesive specified in 3.1.2. There shall be no adhesive strike-through to the face of the tape as evidenced by stickiness of the surface, discoloration or boardiness. The adhesive shall be protected with the liner specified in 3.1.3. The tape shall conform to the requirements specified in table I when tested as specified in 4.2.3.

TABLE I. Physical requirements

Characteristic	Requirement	
	Minimum	Maximum
Weight (exclusive of liner), ounces per square yard	2.7	3.5
Yarns per inch		
Warp	100	-
Filling	95	-
Breaking strength, pounds		
Warp	75	-
Filling	60	-
Elongation, percent		
Warp	18	-
Filling	20	-

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TABLE I. Physical requirements (cont'd)

Characteristic	Requirement	
	Minimum	Maximum
Holding power, inches of slippage:		
Initial	-	1/8
After water immersion	-	1/8
After accelerated aging	-	1/8
At 150°F	-	1/8
Impact resistance, inch-pounds:		
At standard conditions	24	-
At minus 40°F	24	-
Blocking, scale rating	-	No. 1

3.2.1 Color. Unless otherwise specified, the color of the tape shall be Olive Green 106 (see 6.2).

3.2.1.1 Color matching. The color shall match the standard shade sample (see 6.3) under artificial daylight having a color temperature of 7000 ± 500 kelvins and shall be a good approximation to the standard sample under incandescent lamplight at 2850 ± 100 kelvins.

3.3 Base cloth age. The date of delivery of the tape shall be not more than 3 years from the date of manufacture of the base cloth (see 4.2.1).

* 3.4 Marking. Each roll shall have a tag attached to the inner end of the cloth, with the date of coating (month and year) clearly marked. Each outer wrapper or tag and shipping container shall also be marked with the date of coating (see 5.4). In addition the date of coating (month and year) shall be legibly printed on the liner throughout its full length, at least once in every 12 inches, using a suitable ink which will not rub off or, degrade, or affect cloth tape in any manner.

3.5 Put-up. The tape shall be furnished in rolls and shall be wound with the liner side in, on a core of sufficient rigidity to prevent distortion of the roll. The inside diameter of the core shall be 3 inches $-0 + 1/16$ inch. The roll of tape shall be restrained from unwinding by a piece of pressure sensitive adhesive tape.

3.6 Width. Unless otherwise specified (see 6.2), the width of the tape shall be 42 inches $\pm 1/2$ inch.

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3.7 Length. Unless otherwise specified (see 6.2), the length of the tape in the roll shall be 60 + 2 yards. The roll may contain not more than three splices. The splices shall be made so that the pieces will not separate when unwinding the tape. No piece in the roll shall be less than 5 yards in length.

3.8 Workmanship. The tape shall conform to the quality of product established by this document.

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 the document where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.1.1 Certificate of compliance. Where certificates of compliance are submitted, the Government reserves the right to check test such items to determine the validity of the certification.

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

4.2.1 Component and material inspection. In accordance with 4.1 components and materials shall be inspected and tested in accordance with all the requirements of referenced documents unless otherwise excluded, amended, modified, or qualified in this document or applicable procurement document.

4.2.1.1 Certification. The contractor shall furnish a certificate of compliance with each shipment or lot, certifying that the materials and components conform to the applicable requirements listed below:

<u>Component</u>	<u>Characteristic</u>	<u>Requirement</u>	<u>Test Method</u>
Cloth backing	Filament	3.1.1	-
	Melting point	3.1.1	-
	Bleaching	3.1.1	-
	Colorfastness to:		
	Cold water	3.1.1	5630 of FED-STD-191
	Light	3.1.1	5660 of FED-STD-191
	Age	3.3	-

The certificate shall be accompanied by actual test, inspection, or other verifiable data.

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* 4.2.2 End item examination.

- * 4.2.2.1 Yard by yard examination. The tape shall be examined for the defects listed below. The sample unit shall be 1 yard. The number of rolls from which the sample is to be selected shall be as specified in table II. An approximately equal number of yards shall be examined in each roll sampled. The inspection level shall be I and the acceptable quality level (AQL), expressed in terms of defects per hundred units shall be 4.0.

<u>Examine</u>	<u>Defect</u>
Cloth backing	Not weave specified (see 3.1.1.1) Any hole, cut, or tear Texture definitely ruptured Open place, crack, or hitch-back Floats or skips-multiple 1/2 inch or more in either warp and filling direction or harness skips Not coated on one side only with adhesive Adhesive side of cloth backing not completely and evenly covered with adhesive Any edge ragged, nicked, crushed, or uneven Sticky edges Any solid lump 1/ Spot, stain, or streak - more than 1 inch in its longest dimension 1/ Any adhesive strike-through as evidenced by stickiness of the surface, discoloration or boardiness
Liner	Missing Not dated as specified Does not completely cover adhesive
Color	Not color specified

1/ Clearly visible at normal inspection distance (approximately 3 feet).

TABLE II. Sample size

<u>Lot size (yards)</u>	<u>Sample size (rolls)</u>	<u>Maximum number of defects acceptable in sample ^{2/}</u>
Up to 1300 1/	3	0
1301 up to and including 3200	5	0
3201 up to and including 8000	7	0
8001 up to and including 22,000	10	0
22,001 and more	15	1

1/ If lot contains fewer than three rolls, each roll in the lot shall be examined.

2/ Applicable to length examination only (see 4.2.2.3.2).

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4.2.2.2 Roll examination. The tape rolls shall be examined for the defects listed below. The lot size shall be expressed in rolls. The sample unit shall be one roll. The inspection level shall be I and the AQL, expressed in terms of defects per hundred units, shall be 4.0.

<u>Examine</u>	<u>Defect</u>
Assembly of roll	End of roll not secured Not wound evenly and tightly Core missing, loose, distorted, or broken Core not within specified tolerances Not wound with liner side in
Marking	Liner marking missing, not legible, incorrectly spaced, incorrectly dated. Transferred to cloth, affects or degrades cloth tape.
Unwinding of roll (examine both sides)	When unwinding, material sticks together, causing tearing or injury to any surface Pieces separate when unwinding

4.2.2.3 Dimensional examination.

4.2.2.3.1 Width. The tape rolls shall be examined for width. Any width not within the tolerance specified in 3.6 shall be classified as a defect. The lot size shall be expressed in rolls. The sample unit shall be one roll. The inspection level shall be S-2 and the AQL, expressed in terms of defects per hundred units, shall be 4.0.

4.2.2.3.2 Length in individual roll. Each individual roll in the sample shall be examined for the defects listed below. The sample unit for this examination shall be one roll. The sample size (number of rolls selected as sample) and the maximum acceptable number of defects shall be as shown in table II.

Any roll containing more than three pieces.
Any piece in roll less than 5 yards.
Any roll with a gross length of less than 58 yards.
Any roll with a gross length of more than 62 yards.

4.2.2.3.3 Total yardage in sample. The rolls examined shall be those selected for examination of individual rolls as specified in 4.2.2.3.2. The lot shall be unacceptable if the average of the actual gross lengths of the rolls in the sample is less than 60 yards.

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4.2.3 End item testing. Each lot of the tape shall be tested for the characteristics shown in table III. For sampling for test purposes, the lot size shall be expressed in units of 1 yard and the sample size (number of sample units) shall be as specified below. The sample unit shall be 1 yard of tape. The lot shall be unacceptable if one or more sample units fail to meet any specified requirement. All test reports shall contain the individual values utilized in expressing the final result.

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

TABLE III. End item tests

<u>Characteristic</u>	<u>Requirement paragraph</u>	<u>Test method</u>
Weight (including liner)	3.2	5041 <u>1/</u>
Yarns per inch	3.2	5050 <u>1/</u>
Breaking strength	3.2	5104 <u>1/</u>
Elongation	3.2	5104 <u>1/</u>
Liner removal		
At standard conditions	3.1.3	4.3.2
After accelerated aging of tape	3.1.3	4.3.3
Holding power		
Initial	3.2	4.3.4
After accelerated aging of tape	3.2	4.3.5
After water immersion	3.2	4.3.6
Impact		
At standard conditions	3.2	4.3.8
At minus 40°F	3.2	4.3.9
Blocking	3.2	4.3.10

1/ Refers to FED-STD-191.

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4.2.4 Packaging inspection. An examination shall be made to determine that the preservation, packing, and marking comply with the section 5 requirements. The sample unit shall be one shipping container, with the exception that it need not be closed. Defects of closure listed below shall be examined on shipping containers fully packaged. The lot size shall be the number of shipping containers in the end item inspection lot.

<u>Examine</u>	<u>Defect</u>
Markings	Omitted; incorrect; illegible; improper size, location, sequence, or method of application.
Materials	Any component missing, damaged or not as specified.
Workmanship	Inadequate application of components such as: incomplete closure of container flaps, improper taping, loose strapping or inadequate stapling. Bulged or distorted container.

4.2.4.1 Palletization examination. An examination shall be made to determine that the palletization complies with the section 5 requirements. Defects shall be scored in accordance with the list below. The sample unit shall be one palletized unit load fully packaged. The lot size shall be the number of palletized unit loads in the end item inspection lot. The inspection level shall be S-1 and the AQL shall be S-1 and the AQL shall be 6.5 defects per hundred units.

<u>Examine</u>	<u>Defect</u>
Finished dimension	Length, width, or height exceeds specified maximum requirement.
Palletization	Pallet not as specified. Interlocking of loads not as specified. Load not bonded with required straps as specified.
Weight	Exceeds maximum load limits.
Marking	Omitted; incorrect; illegible; of improper size, location, sequence or method of application.

4.3 Methods of inspection.

4.3.1 Test conditions. Results of physical tests obtained under testing conditions defined in FED-STD-191 will be accepted.

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4.3.2 Liner removal at standard conditions test. The tape shall be in an amount sufficient to form a seam (see 4.3.2.1) which will provide the specimens required for the tests specified in 4.3.4, 4.3.6, 4.3.7, 4.3.8 and 4.3.9. The adhesive cloth tape and the liner shall be separated and examined. Any break or tear in the liner or any removal of adhesive from the cloth tape shall be considered a test failure.

4.3.2.1 Seam preparation. The tape examined in 4.3.2 shall be used to form a seam by overlapping two layers of the tape on one layer of 1.1 ounce rip-stop parachute cloth conforming to type I of MIL-C-7020. The seam shall be formed such that specimens cut from the seam will conform to the configuration and dimensions shown on figure 1. Prior to applying the tape to form the sample seam, the parachute cloth shall be reinforced with drafting tape in the area which will be adjacent to the lap seam when completed. The tape may also serve as a gage mark for the 1/2 inch laps. The drafting tape shall be removed after the lap seam is pressed together by hand. The seam shall then be given four lengthwise passes (two in each direction) of a steel roller, 1 inch in diameter, 1-3/4 inches in width, equipped with a handle and means for adding weight so that the roller assembly weighs 10 pounds \pm 0.1 pound total, uniformly distributed in the axial direction. The four passes shall be made at approximately 12 inches per minute roller speed. Prior to cutting into test specimens, the sample seam shall be conditioned at standard conditions for 24 \pm 2 hours. Distortion of the weave of the parachute cloth and fraying of critical edges shall be prevented during sample seam and specimen preparation. Cutting shears shall be well sharpened. Areas of parachute cloth immediately adjacent to cuts to be made, and which are to be cut away, shall be reinforced with drafting tape.

4.3.3 Liner removal after aging test. The tape shall be in an amount sufficient to form a seam (see 4.3.3.1) which will provide the specimens required for the test specified in 4.3.8. The tape shall be aged in accordance with ASTM D 3611. The aged adhesive cloth tape and the liner shall be separated and examined. Any break or tear in the liner or any removal of adhesive from the cloth tape shall be considered a test failure.

4.3.3.1 Seam preparation for aged tape. The seam shall be prepared as specified in 4.3.2.1 except that the tape used shall be the aged tape examined in 4.3.3.

4.3.4 Holding power initial, test. Two 1-inch wide specimens, prepared from the seam specified in 4.3.2.1 shall be used. Clamp one end of each specimen to the horizontal support. Attach a 1000 \pm 5-gram weight to the other end in such a manner that the load is distributed uniformly across the full width of the specimen. Make a gage mark at the line of overlap. At the end of 30 minutes, measure the slippage from the gage mark. Slippage of more than 1/8 inch in either specimen shall constitute failure of the sample unit with respect to holding power at standard conditions.

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- * 4.3.5 Holding power test of aged tape. Two 1-inch wide specimens, prepared from the seam specified in 4.3.3.1, shall be tested as specified in 4.3.4. Slippage of more than 1/8 inch in either specimen shall constitute failure of the sample unit with respect to holding power of aged tape.
- 4.3.6 Holding power test after water immersion. Two 1-inch wide specimens, prepared from the seam specified in 4.3.2.1, shall be submerged in water at $75 \pm 5^\circ\text{F}$ for 24 hours. Remove the samples from the water and without drying the specimens, immediately test for holding power as specified in 4.3.4, except that a weight of 500 ± 5 grams shall be used. Slippage of more than 1/8 inch in either specimen shall constitute failure of the sample unit with respect to holding power at standard conditions.
- * 4.3.7 Holding power test at 150°F . The test shall be conducted as specified in 4.3.4 except that the test specimens and apparatus shall be pre-conditioned at $150^\circ\text{F} \pm 2^\circ\text{F}$ for 30 minutes and the holding power test shall be conducted at that temperature. Failure of either specimen constitutes failure of the sample unit with respect to holding power at 150°F .
- 4.3.8 Impact strength test at standard conditions. Two 1/2 inch wide specimens shall be prepared from the seam specified in 4.3.2.1. Clamp or adhere each test specimen across a rigid 4-inch span (e.g., across the open side of a 4 by 1.58-inch structural aluminum or steel channel) with the overlap located at the center of the span. The specimens shall be just sufficiently taut to prevent sagging. Impact the overlap using an impactor consisting of a 1-inch diameter steel rod weighing 2 pounds dropped through a guide tube held in a vertical position directly over the center of the span. The impacting end of the steel rod shall be flat and at right angles to the rod center line. Failure is defined as separation of the specimen at the adhesive bond or as relative slippage of the bonded area. Breaking of the fabric does not constitute failure in this test. Failure of either specimen shall constitute failure of the sample unit with respect to impact strength at standard conditions.
- 4.3.9 Impact strength test at -40°F . The test shall be conducted as specified in 4.3.7 except that test specimens and apparatus shall be conditioned at $-40^\circ \pm 2^\circ\text{F}$ for 1 hour and the impact shall be delivered at the same temperature. Failure of either specimen constitutes failure of the sample unit with respect to impact strength at -40°F .
- 4.3.10 Blocking test. Bond a 2-inch square of the tape to the center of a 3-inch square of the 1.1 ounce rip-stop cloth specified in 4.3.2.1. Place this assembly between two larger squares of the 1.1 ounce rip-stop cloth and in turn center this

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assembly between two 4-inch square, flat glass plates. Place in an oven at $150 \pm 2^\circ\text{F}$ and place a weight of 4 pounds on the assembly. Heat the assembly for 16 hours and remove from the oven and allow to cool at standard conditions for 1 hour. Examine for any evidence of strike-through of the adhesive, i.e., through the rip-stop cloth or through the tape backing. Evaluate the blocking in accordance with Method 5872 of FED-STD-191.

5. PACKAGING

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

5.1.1 Level A. Each roll of tape, put up as specified in 3.5, shall be unit packed in a snug-fitting fiberboard box conforming to style RSC (end-opening), grade W5c or W5s of PPP-B-636. Inside dimensions of each box shall approximate 6-1/4 by 6-1/4 by 44 inches. Approximate dimensions are furnished as a guide only. Each box shall be closed and waterproofed in accordance with method IV as specified in the appendix of PPP-B-636.

5.1.2 Commercial. Rolls of tape 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. Four rolls of tape, preserved as specified in 5.1, shall be packed in a fiberboard or cleated-plywood shipping container conforming to style RSC, grade V2s of PPP-B-636; or overseas type, style A or I, grade A, type 2 load of PPP-B-601, as specified (see 6.2). Each wood container shall be surface treated with a water repellent wood preservative as specified in PPP-B-601. Level A unit packs shall be packed flat one in length, two in width, and two in depth within the shipping container. Inside dimensions of each shipping container shall approximate 44-1/2 inches in length, 13 inches in width, and 13 inches in depth when 42 inch width tape is specified; and 38-1/2 inches in length, 13 inches in width, and 13 inches in depth when 36 inch tape is specified. Approximate dimensions are furnished as a guide only. Each fiberboard shipping container shall be closed in accordance with method III or method V and reinforced as specified in the appendix of PPP-B-636. Each wood container shall be closed and reinforced in accordance with the appendix of PPP-B-601.

5.2.2 Level B packing. Four rolls of tape, preserved as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC, type CF (variety SW) or SF, class domestic, grade 275 of PPP-B-636. Level A unit packs shall be packed flat one in length, two in width, and two in depth within the

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shipping container. Inside dimensions of each shipping container shall approximate 44-1/2 inches in length, 13 inches in width, and 13 inches in depth when 42 inch width tape is specified; and 38-1/2 inches in length, 13 inches width, and 13 inches in depth when 36 inch tape is specified. Approximate dimensions are furnished as a guide only. Each shipping container shall be closed in accordance with method II as specified in the appendix of PPP-B-636.

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

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

5.3 Palletization. When specified (see 6.2), rolls of tape, packed as specified in 5.2, shall be palletized in accordance with load type I of MIL-STD-147. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding means K and L. Pallet patterns shall be in accordance with the appendix of MIL-STD-147. Interlocking of loads shall be effected by reversing the pattern of each course. If the container is of a size which does not conform to any of the pallet patterns specified in MIL-STD-147, the pallet pattern used shall first be approved by the contracting officer.

5.4 Marking. In addition to any special marking required by this document (see 3.4) or by the contract or purchase order, unit packs, shipping containers and palletized unit loads shall be marked in accordance with MIL-STD-129 or ASTM D 3951, as applicable.

6. NOTES

6.1 Intended use. The mending tape is primarily intended to be used in making minor repairs on nylon cargo parachute canopies. The tape is not intended for use on cotton or rayon parachutes. Use on nylon personnel parachutes is intended only on specific authorizations.

6.2 Ordering data. Acquisition documents should specify the following:

- a. Title, number, and date of this document.
- b. Color required (if other than OG-106, see 3.2.1).
- c. Width and length (if other than that specified in 3.6 and 3.7).
- d. Selection of the applicable levels of preservation and packing (see 5.1 and 5.2).
- e. Type of shipping container desired for level A packing (see 5.2.1).
- f. When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).
- g. When palletization is required (see 5.3).

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6.3 Color and samples. Samples of the color shade (see 3.2.1.1) may be obtained from the contracting activity or as directed by the contracting officer.

6.4 Changes from previous issue. The margins of this document are marked with an asterisk to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous issue.

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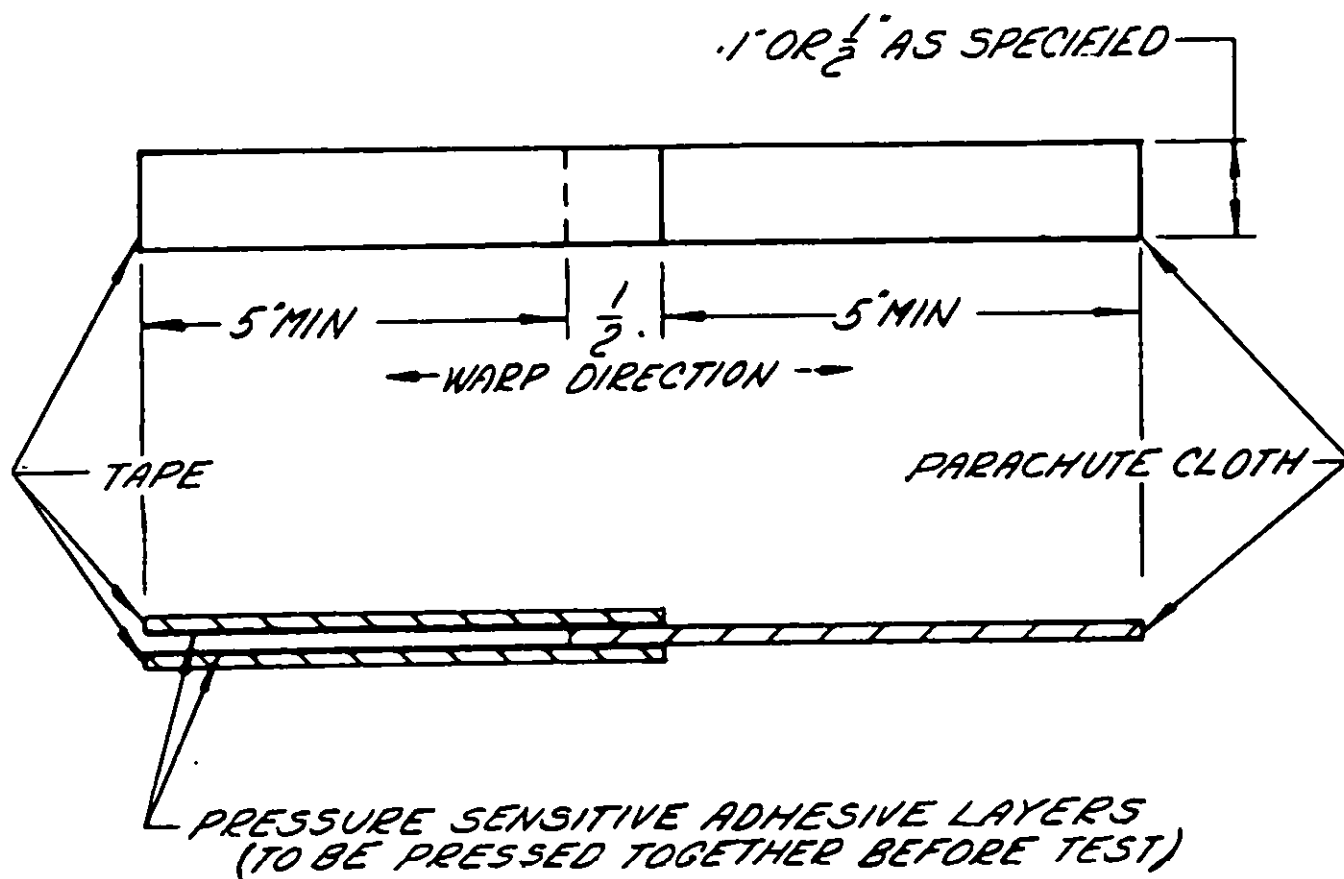


FIGURE 1 SPECIMEN FOR HOLDING POWER
AND IMPACT STRENGTH TESTS

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