

MIL-T-5661E
 17 March 1988
 SUPERSEDING
 MIL-T-5661D
 16 September 1970

MILITARY SPECIFICATION

TAPE AND WEBBING, TEXTILE, WOVEN REINFORCING, COTTON

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

1. SCOPE

1.1 Scope. This specification covers five types of woven cotton reinforcing textile tape and webbing intended for use in the manufacture of aeronautical equipment.

1.2 Classification. The tape and webbing shall be of the following types, as specified (see 6.2).

Type I	-	Plain weave
Type II	-	Double herringbone weave
Type III	-	Twill weave
Type V	-	Plain (transverse cord) weave
Type VI	-	Nonelastic weave

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications and standards. The following specifications and standards 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.

SPECIFICATIONS

Military

MIL-D-5549	Dope; Cellulose-Acetate-Butyrate, Clear For Aircraft Use
MIL-W-43334	Webbing and Tape, Textile, Packaging and Packing of

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Systems Engineering and Standardization Department (Code 53), Naval Air Engineering Center, Lakehurst, NJ 08733-5100, by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8315

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STANDARDS

Federal

FED-STD-191 Textile Test Methods

Military

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

2.1.2 Other Government documents. The following other Government document forms 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.

FEDERAL TRADE COMMISSION

Textile Fiber Products Identification Act

(Copies of specifications, standards and publications 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 document forms 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 issue of the nongovernment documents which is current on the date of the solicitation.

COLOR ASSOCIATION OF THE UNITED STATES, INC.

TCA Cable Numbers and Colors

(Applications for copies should be addressed to the Color Association of the United States, Inc., 343 Lexington Avenue, New York, NY 10016.)

(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 (except for associated detail specifications, specification sheets or MS standards), 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.

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3. REQUIREMENTS

3.1 Materials. The tape and webbing shall be made from carded or combed yarns evenly spun from cotton of a grade and staple length that will produce a material meeting the requirements specified herein.

3.2 Weave.

3.2.1 Type I. The weave of Type I shall be plain (1 up and 1 down).

3.2.2 Type II. The weave of Type II shall be that commercially designated as 2-up, 2-down herringbone twill, having 3 reversals of twill, 1 at the center and 1 on each side of the center midway between the center and each edge. The tape or webbing shall be made with 2 ends weaving as one, or all ends weaving singly in the warp.

3.2.3 Type III. The weave of Type III shall be a 2-up and 2-down twill with reversal at 1/4 and 3/4 of the width.

3.2.4 Type V. The weave of Type V shall be plain with 2 warp yarns weaving as 1, except that at the selvage there shall be 3 warp yarns weaving singly.

3.2.5 Type VI. The weave of Type VI shall be what is commercially known as "nonelastic" and shall be in accordance with Figure 1. The ground and binder warp ends shall be 2 ply. The stuffer warp ends shall be 5 ply. The filling yarn shall be evenly distributed between the face and back of the tape and webbing. The 1 inch shall contain 24 ends in each selvage or 12 ends in each selvage.

3.2.6 Filling yarn. The weave for all types shall be with one filling yarn per shed when a shuttle loom is used. The weave for all types shall be with two filling yarns per shed when a shuttleless loom is used (see 6.2).

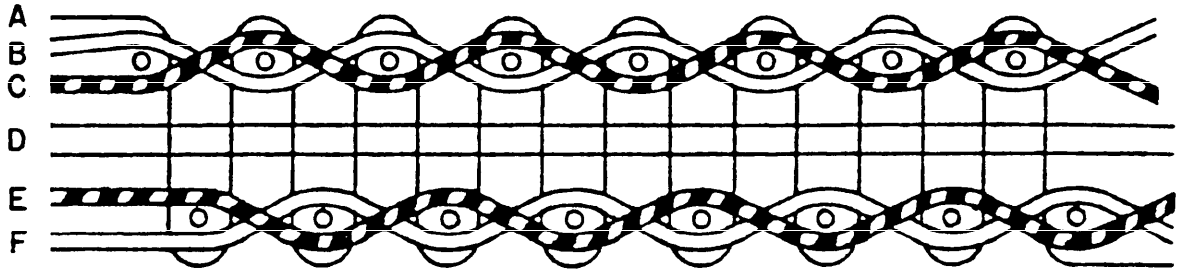
3.3 Construction and physical properties. The construction and physical properties of the tape and webbing shall be as specified in Table I. When latch type shuttleless looms are utilized, the filling yarn shall traverse the full width of the tape and shall be held at the edge by an extra catch-cord end interlacing with the filling yarn, in a method depicted in Figure 2 or 3. When bobbin type shuttleless looms are utilized, interlacing of the catch-cord and filling shall occur within the selvage area before the first binder end (Figure 4).

3.4 Extractable matter. The natural color tape and webbing shall contain no more than 5.0 percent methyl-ethyl ketone extractable matter, and the dyed tape and webbing shall contain no more than 4.0 percent methyl-ethyl ketone extractable matter, when tested as specified in 4.3.

3.5 Acidity (pH). The water extract of the tape and webbing shall have a pH of 6.0 to 8.0, when tested as specified in Table IV.

3.6 Compatibility with dope. The Type I tape and webbing shall be compatible with aircraft dope. The dope shall dry within 45 minutes and show no signs of cracking and peeling when applied to the finished tape and webbing as specified in 4.4.2.

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- A. 2 BINDER WARP ENDS
- B. } 2 FACE WARP ENDS EACH
- C. }
- D. 2 STUFFER WARP ENDS
- E. } 2 BACK WARP ENDS EACH
- F. }

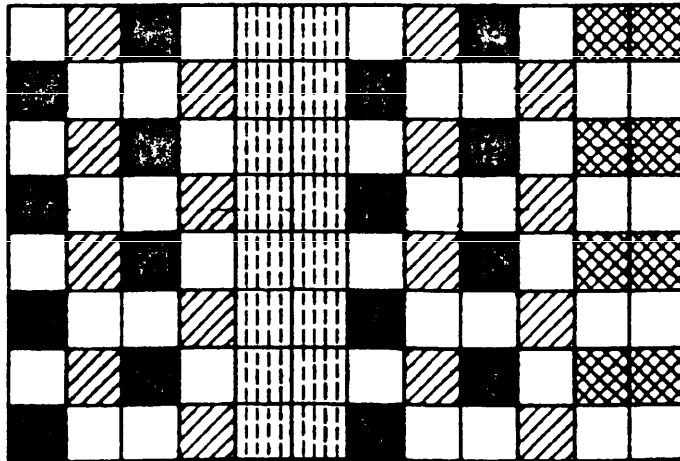


FIGURE 1. Construction, Type VI.

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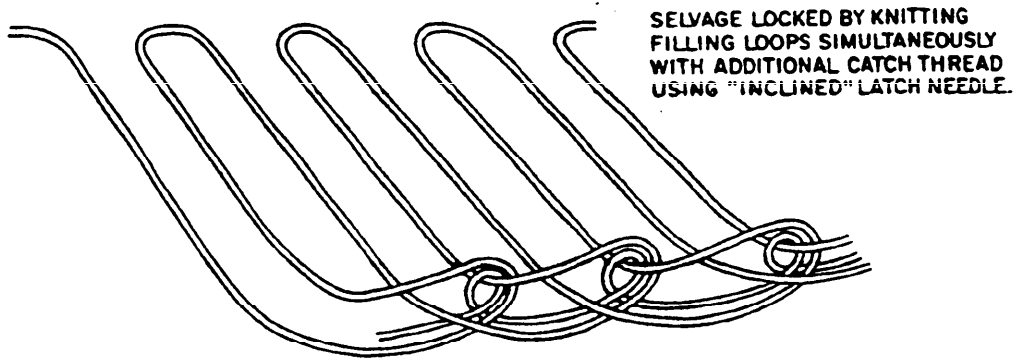


FIGURE 2. Catch-cord diagram, latch type.

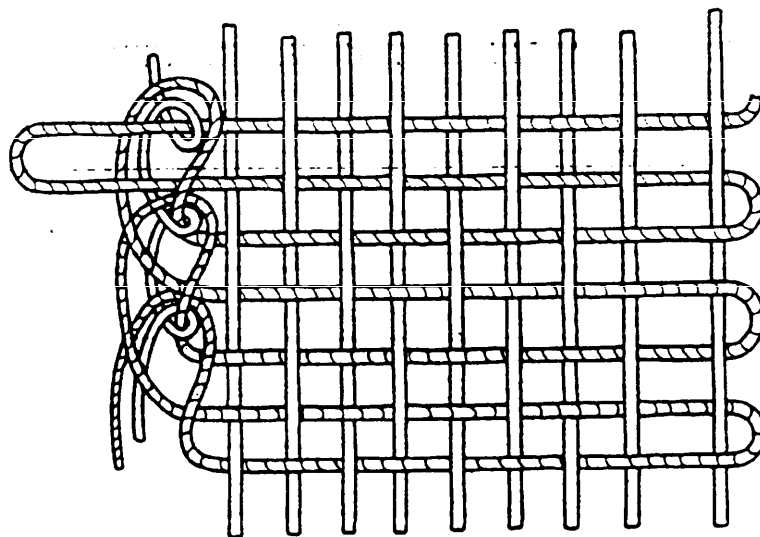


FIGURE 3. Catch-cord diagram, latch type.

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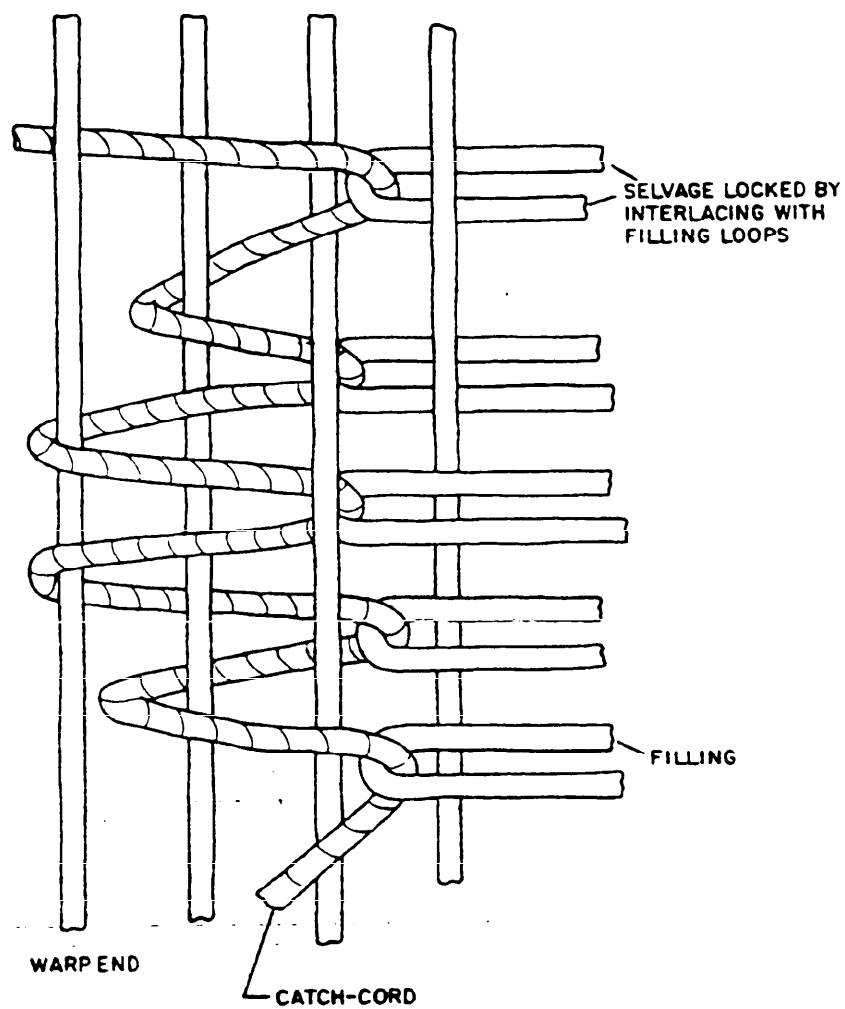


FIGURE 4. Catch-cord diagram, bobbin type.

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TABLE I. Construction and physical properties. 1/

Type	Width inch ±1/32	Weight oz/linear yd., max.	Yarn ply, min.		Total warp ends, min.	Picks/inch min. shuttle loom	Picks/inch min. shuttle- less loom	Breaking strength lbs, min.
			Warp	Filling				
I	1/4	0.11	4	2	7	20	16	80
	3/8	0.15	4	2	10	20	16	120
	1/2	0.22	4	2	14	20	16	150
	5/8	0.28	4	2	18	20	16	170
	3/4	0.33	4	2	22	20	16	200
	1	0.47	4	2	30	20	16	250
II	1/2	0.15	2	2	142	48	32	110
	3/4	0.22	2	2	212	48	32	165
	1	0.29	2	2	284	48	32	220
	1-1/4	0.36	2	2	356	48	32	275
	1-1/2	0.43	2	2	426	48	32	330
	1-3/4	0.50	2	2	496	48	32	375
III	2	0.57	2	2	568	48	32	425
	1/2	0.10	2	1	64	60	45	45
	5/8	0.12	2	1	85	60	45	55
	3/4	0.14	2	1	96	60	45	75
	1	0.65	4	4	48	16	15	350
	2	1.30	4	4	96	16	15	650
VI	5/8	0.23	See 3.2.5	2	95	46	32	80
	1	0.98	See 3.2.5	2	112	52	32	375

Ground Binder Stuffer

1/ For suggested yarn numbers, see 6.3.

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3.7 Color. Unless otherwise specified, the color for all types of tape and webbing shall be natural (unbleached). When an olive drab color is specified, the tape or webbing shall match TCA Cable No. 66022, Shade S-1 (U.S. Army Olive Drab).

3.7.1 Colorfastness. The dyed tape and webbing shall show at least "good" colorfastness to water, salt water (without soap) and light at 20 Standard Fading Hours and good resistance to crocking when tested as specified in Table IV.

3.8 Length and put-up. Unless otherwise specified, tape and webbing shall be furnished on rolls, containing 100 ± 10 yards. Each roll shall contain not more than 3 pieces, and no piece shall be less than 5 yards long. Tape and webbing 1/2 inch or less in width may be furnished on double-headed spools or tubes containing 500 ± 10 yards. Each spool or plastic tube shall have not more than 6 pieces, and no piece shall be less than 5 yards long.

3.9 Identification ticket. Each roll, spool or tube of tape or webbing shall have an identification ticket attached in accordance with MIL-W-43334.

3.10 Fiber identification. Each roll, spool or tube of tape or webbing shall be labeled, ticketed or invoiced for fiber content in accordance with the Textile Fiber Products Identification Act.

3.11 Workmanship. The finished tape or webbing shall conform to the quality and grade of product established by this specification. The occurrence of defects shall not exceed the levels set by the applicable 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 the specification 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 specification shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the specification 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.

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4.2 Classification of inspections. The inspections specified herein are classified as quality conformance inspections.

4.3 Quality conformance inspection. Quality conformance sampling and inspection shall be performed in accordance with the provisions herein and in MIL-STD-105, except where otherwise indicated.

4.3.1 Inspection of the end item. The end item shall be inspected for defects in accordance with 4.3.1.1 through 4.3.1.5.

4.3.1.1 Yard-by-yard examination. The required yardage of each roll, spool or tube shall be inspected on both sides and visual defects classified as listed in Table II. All defects found shall be counted regardless of their proximity one to another except where two or more defects represent a single local condition of the tape or webbing, in which case only the more serious defect shall be counted. A continuous defect shall be counted as one defect for each warpwise yard or fraction thereof, in which it occurs. The sample unit for this examination shall be one linear yard. The sample size shall be in accordance with Inspection Level II of MIL-STD-105. The Acceptable Quality Level shall be 2.5 for major defects and 6.5 for total defects per 100 units. The lot size shall be expressed in units of one linear yard each. An approximately equal number of yards shall be examined from each roll selected. The number of rolls from which the sample is to be selected shall be in accordance with Table III of this specification.

TABLE II. Classification of defects.

Examine	Defects	Major	Minor
Abrasion mark, bruise	Resulting in rupture of individual yarns or plies, distortion in the orientation of threads, dimensional distortion, areas visibly thinner than adjoining unaffected areas	X	
Broken or missing end	Any	X	
Broken or missing pick	2 or more within a linear inch, regardless of the size of missing portion	X	
	Single, missing for more than 1/4 inch width		X
Coarse filling bar	Yarn larger in diameter than in adjoining unaffected area resulting in increased stiffness or thickness		X
Crease	Twisted or distorted, will not lay flat upon application of manual pressure		X
Cut, hole, tear (including edges)	(See "Broken ends" and "Broken picks")	X	

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TABLE II. Classification of defects (continued).

Examine	Defects	Major	Minor
Double end	Resulting from wrong draw (see "Wrong draw")		X
Drop-ply	Clearly visible, on more than 2 ends within same length and extending over 9 linear inches or more	X	
	Clearly visible, on 1 or 2 ends within same length and extending over 9 linear inches or more	X	
Edges cut or frayed	Clearly visible	X	
Edges beaded or corded	Visible increase in thickness or mis-formed selvage		X
Edges folded or rolled	(See "Crease")		X
Edges loopy	Forming clearly visible filling loops or edges tied loosely to body for 2 linear inches or more		X
Edges loose	Resulting in waviness, distortion in orientation of filling, or looseness along edges		X
Edges tight	Resulting in visible tension along edge, or pucker, waviness, bagginess or slackness that cannot be flattened by manual pressure	X	
Edges scalloped	Any visible indentation of edge	X	
Fine or light filling bar	Clearly visible		X
Float	Multiple, 1/2 inch or more in combined warp and filling directions, or single, floating over more than 1 inch		X
	Multiple, less than 1/2 inch in combined warp and filling directions, or single, float over more than 1/2 inch but not more than 1 inch if in warp, over more than 1/4 of the width but not more than 1 inch if in filling		X
Identification label	Missing, incomplete, incorrect, illegible or insecurely attached		X

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TABLE II. Classification of defects (continued).

Examine	Defects	Major	Minor
Heavy filling bar, heavy place	Visibly stiffer or thicker than adjoining unaffected area	X	
Hitch-back, crack, open place	Clearly visible opening between adjoining picks, or warpwise tension area over part of the width, resulting in light or heavy places		X
Jerked-in filling, slough off	Clearly visible		X
Kinks	More than 3 in any 9 linear inches clearly visible on surface		X
Knots	More than 1 knot	X	
	Untrimmed ends extending from surface		X
Mispick, skips	Resulting in widthwise repeated floats more than 1/4 inch long	X	
	Resulting in abrupt break in sequence of weave, or widthwise repeated floats 1/4 inch or less long		X
Mixed filling, shade bar	Clearly visible		X
Slack end	2 or more in same length, jerked-in between picks, or forming clearly visible loops on surface	X	
	Single, jerked-in between picks, or forming clearly visible loops on surface		X
Slub or slug	More than twice the thickness of the yarn (or ply if plied)		X
Spot, stain, streak (rust, dirt, oil, grease, dye)	Any uncleaned spot, stain or streak clearly visible		X
Smash	Any smash	X	
Tight end	Clearly visible		X

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TABLE II. Classification of defects (continued).

Examine	Defects	Major	Minor
Tight pick or filling	Resulting in rolling (see also "Edges scalloped")	X	
Wavy or ridgy	Clearly visible, will not flatten under manual pressure (resulting from uneven tension)	X	
Weak or tender spot	Any	X	
Wrong draw	Extending 9 linear inches or more	X	
Width	Less than minus tolerances, more than plus tolerances	X	

4.3.1.2 Examination for filling yarn per shed.

4.3.1.2.1 Shuttle loom. When a shuttle loom is used the lot shall be unacceptable if any roll, plastic spool, or plastic tube in the sample contains more than one filling yarn per shed.

4.3.1.2.2 Shuttleless loom. When a shuttleless loom is used the lot shall be unacceptable if any roll, plastic spool, or plastic tube in the sample contains more than two filling yarns per shed or only one filling yarn per shed.

4.3.1.3 Flagging of defects. All defects shall be flagged by red and white strings, red denoting major defects (except when no major defects are allowed), and white denoting minor defects, unless otherwise specified by the procuring activity. Continuous defects shall be identified by sewing the string into the selvage and knotting at the start and at the end of the defect in the warpwise direction. Localized and continuous defects shall be flagged, unless stated otherwise.

4.3.1.4 Overall examination. Each defect listed below shall be counted no more than once in each roll examined. The sample unit for this examination shall be one roll. The sample size and acceptance number shall be as shown in Table III.

Defect

Objectionable odor.
 Uncleaness throughout.
 Off shade (not within established tolerance).
 Poor color penetration, cloudy, mottled or streaky throughout.
 Poorly constructed, not firmly and tightly woven.
 Not labeled in accordance with Textile Fiber Products
 Identification Act.

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TABLE III. Sample size.

Lot size in yards	Sample size		Maximum number of defects acceptable in sample
	Rolls	Spools or tubes	
1,200 or less 1/	3	2	0
1,201 up to and including 3,200	5	3	0
3,201 up to and including 10,000	8	5	0
10,001 up to and including 35,000	13	8	0
35,001 up to and including 150,000	20	13	1
150,001 and over	32	20	2

1/ If a lot contains fewer than 3 rolls or 2 spools or tubes, each unit in the lot shall be examined.

4.3.1.5 Length examination.

4.3.1.5.1 Examination for length of individual roll. Each 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 and acceptance number shall be as shown in Table III.

Defect

- Gross length less than specified minimum length or more than specified maximum length.
- Gross length more than 2 yards less than gross length marked on roll ticket.
- Any piece less than 5 yards in length.
- Any roll containing more than 3 pieces.
- Any spool or tube containing more than 6 pieces.

4.3.1.5.2 Examination for total yardage in sample. The lot shall be unacceptable if the total of the actual gross lengths of rolls in the sample is less than the total of the gross lengths marked on roll tickets.

4.3.2 Examination of preparation for delivery requirements. An examination shall be made in accordance with the provisions of MIL-W-43334 to determine that preservation, packing and marking requirements of Section 5 are complied with in this specification.

4.4 Testing of the end item. The methods of testing specified in FED-STD-191, wherever applicable and as listed in Table IV, shall be followed. The physical and chemical values specified in Section 3 apply to the results of the determinations made on a sample unit for test purposes as specified in the applicable test methods. All test reports shall contain the individual values utilized in expressing the final result. The sample size shall be as follows:

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

The lot size shall be expressed in units of 1 linear yard each. The sample unit for testing shall be 15 yards. The lot shall be unacceptable if one or more sample units fail to meet any requirements specified.

TABLE IV. Test methods.

Characteristics	Requirement reference	Test method
Weave	3.2	Visual <u>1/</u>
Width	Table I	5020
Weight	Table I	5040
Yarn ply	Table I	Visual
Warp ends	Table I	5050
Picks per inch	Table I	5050
Breaking strength <u>2/</u>	Table I	5100 <u>2/</u>
Extractable matter	3.4	4.3.1
Acidity (pH)	3.5	2811
Compatibility with dope	3.6	4.3.2
Colorfastness to		
Water	3.7.1	5630
Salt water (without soap)	3.7.1	5632
Light (20 standard fading hours)	3.7.1	5660
Resistance to crocking	3.7.1	5651

- 1/ One determination shall be made from each sample unit and the result reported as pass or fail.
- 2/ The faces of the jaws of the testing machine shall be cushioned by covering with cotton duck or other suitable material to prevent breaks at the jaws, and the width of the jaws shall be 1/2 inch greater than the material being tested.

4.4.1 Extractable matter. A specimen weighing approximately 5 grams shall be tested. The warp yarns shall be separated from the filling and care taken to prevent the loss of any yarns during the course of the test. The specimen shall be placed in a weighing bottle and dried to constant weight at $104^{\circ} \pm 1^{\circ}\text{C}$ ($220^{\circ} \pm 2^{\circ}\text{F}$). The original dry weight shall be recorded. The dry specimen shall be placed in a Soxhlet extractor and the extraction with methyl-ethyl ketone shall be run for 6 hours. The sample shall then be removed, air dried, then dried to constant weight in a weighing bottle at $104^{\circ} \pm 1^{\circ}\text{C}$ ($220^{\circ} \pm 2^{\circ}\text{F}$) and a final dry weight shall be recorded.

$$\text{Percent Extractable Matter} = \frac{\text{Loss in weight on extraction}}{\text{Original dry weight of specimen}} \times 100$$

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4.4.2 Compatibility with dope. The compatibility with dope shall be performed with dope conforming to MIL-D-5549. The dope shall be taken from approved samples. A piece of the tape or webbing sample shall be drawn taut and smooth by hand over the open end of a beaker and fastened in position with drafting tape, or other suitable method of attachment. One brush coat of dope shall be spread uniformly over the surface of the taut tape and webbing in no more than 2 strokes of the brush. The dope shall be at package consistency. The doped sample shall then be allowed to dry for 45 minutes under laboratory conditions $23 \pm 1.1^{\circ}\text{C}$ ($73.5 \pm 2^{\circ}\text{F}$) and 50 ± 2 percent relative humidity and examined for dryness and compatibility with the dope. The doped sample shall be examined for signs of peeling and cracking. If the doped sample has not dried within 45 minutes, the following test shall be used to determine whether the dope is at fault: Using a doctor blade with a clearance of 0.008 inch, spread a coat of the dope (at package consistency) smoothly on a plate glass panel. Dope conforming to applicable specification requirements will dry hard to a transparent film within 10 minutes under laboratory conditions.

5. PREPARATION FOR DELIVERY

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

5.1.1 Levels A and C. Webbing and tape, put up as specified, shall be preserved in accordance with the applicable requirements of MIL-W-43334.

5.2 Packing. Packing shall be Level A, B or C as specified (see 6.2).

5.2.1 Levels A, B and C. Webbing and tape shall be packed in accordance with the applicable requirements of MIL-W-43334.

5.3 Marking. In addition to any special marking required by the contract or order, shipments shall be marked in accordance with MIL-W-43334.

6. NOTES

6.1 Intended use. The Type I tape and webbing are suitable for reinforcing tape on cloth under lacing cords of airfoil sections. Types II, III, V and VI tape and webbing are suitable for building and reinforcing applications in parachute packs.

6.2 Ordering data.

6.2.1 Acquisition requirements. Procurement documents should specify the following:

- a. Title, number and date of this specification.
- b. Type (see 1.2).
- c. Width (see Table I).
- d. Color (see 3.7).
- e. Filling yarn (see 3.2.6).
- f. Catch-cord interlacing (see 3.2.7).

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- g. Quantity required.
- h. Selection of applicable levels of preservation and packing (see 5.1 and 5.2).

6.3 Yarn numbers. Suggested yarn numbers for the tape and webbing are as specified in Table V.

TABLE V. Yarn numbers.

Type	Warp	Yarn number	
		Filling shuttle loom	Filling shuttleless loom
I	20/3/4	24/2	40/2
II	60/2	30/2	40/2
III	40/2	38/1	60/2
V	8/4 or 10/5	8/4 or 10/5	8/2
VI	--	--	--

6.4 Subject term (key word) listing.

Cotton
Parachute packs
Tape
Under lacing cords
Webbing
Woven reinforcing

6.5 Changes from previous issue. Asterisks (or vertical lines) 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 - AS
Air Force - 11

Preparing Activity:
Navy - AS
(Project No. 8315-0167)

Review Activity:
Air Force - 99
DLA - CT

User Activity:
Army - ME
Navy - NU, MC
Air Force - 45

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NOTE: This form may not be used to request copies of documents, nor to request waivers, deviations, or clarification of specification requirements on current contracts. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements.

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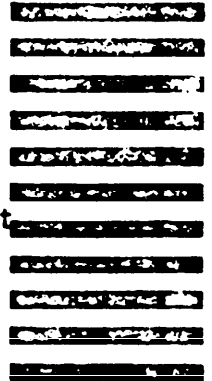
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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

1. DOCUMENT NUMBER

2. DOCUMENT TITLE

3a. NAME OF SUBMITTING ORGANIZATION

4. TYPE OF ORGANIZATION (Mark one)

 VENDOR USER MANUFACTURER OTHER (Specify): _____

b. ADDRESS (Street, City, State, ZIP Code)

5. PROBLEM AREAS

a. Paragraph Number and Wording:

b. Recommended Wording:

c. Reason/Rationale for Recommendation:

6. REMARKS

7a. NAME OF SUBMITTER (Last, First, MI) - Optional

b. WORK TELEPHONE NUMBER (Include Area Code) - Optional

c. MAILING ADDRESS (Street, City, State, ZIP Code) - Optional

8. DATE OF SUBMISSION (YYMMDD)