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MILITARY STANDARD
PROVISIONS FOR EVALUATING QUALITY
OF
CAPS, GARRISON, MEN'S



AMSC N/A

FSC 8405

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FOREWORD

1. This military standard is approved for use by all Departments and Agencies of the Department of Defense.
2. 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.
- * 3. This document supplements the military specifications listed below. It provides a standard description for defects and standardizes examination requirements.

	<u>SPECIFICATION</u>	<u>TITLE</u>
*	MIL-C-3261	- Cap, Garrison, Air Force Blue
	MIL-C-17614	- Cap, Garrison, Man's
*	MIL-C-21181	- Cap, Garrison, Man's: Wool, Green
*	MIL-C-24012	- Caps, Garrison: Men's, Polyester/Wool
	MIL-C-43419	- Cap, Garrison, Polyester/Wool, Tropical, Army Green
		344

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1. SCOPE

- * 1.1 Scope. This document covers standardized provisions for evaluating the quality of garrison caps for men.

* 2. APPLICABLE DOCUMENTS

- * 2.1 Government documents.

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

STANDARDS

FEDERAL

FED-STD-4 - Glossary of Fabric Imperfections

MILITARY

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

MIL-STD-109 - Quality Assurance Terms and Definitions

- * 2.2 Non-Government publications. The following document(s) form a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DoD adopted are those listed in the issue of the DODISS specified in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of the non-Government documents which are current on the date of the solicitation.

AATCC Photographic Comparative Rating of Single and Double Needle Seams
(Method 88E, two photos)

- * 2.3 Order of precedence. In the event of a conflict between the text of this document and the references cited herein, the text of this document shall take precedence. Nothing in this document, however, shall supersede applicable laws and regulations unless a specific exemption has been obtained.

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* 2.4 Source of documents.

* 2.4.1 Government standards. Copies of the referenced federal and military standards are available from the Department of Defense Single Stock Point, Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120-5099. For specific acquisition functions, these documents should be obtained from the contracting activity or as directed by the contracting activity.

* 2.4.2 Non-Government publications. Non-Government documents are generally available for reference from libraries and technical groups. The documents listed may be obtained as follows:

AATCC Photographic Comparative Rating of Single and Double Needle Seams
(Method 88B, two photos):

Copies may be purchased from The American Association of Textile Chemists and Colorists, P.O. Box 12215, Research Triangle Park, NC 27709.

3. DEFINITIONS

3.1 Fabric defects. Definitions of fabric defects, where applicable, shall be in accordance with FED-STD-4.

3.2 Knots and slubs. Only knots and slubs that exceed the limits specified in the basic cloth specification shall be scored as defects in evaluating quality of the finished cap.

3.3 Open seam. A seam shall be classified as open when one or more stitches joining a seam are broken or runoff, or when two or more continuous skipped stitches occur. Double stitched seams are considered open when one or both rows of stitching are open.

3.4 Raw edge. A raw edge is defined as any edge not finished as specified including any protruding edge on the outside of the cap.

3.5 Outside-inside. The terms "outside" and "inside" as used in this standard are defined as follows:

- * Outside - Any part of cap that is visible when the cap is examined from a distance of 3 feet at shoulder level height and positioned as worn. The cap shall be completely rotated.
- * Inside - Any part of cap that is not visible when the cap is examined from a distance of 3 feet at shoulder level height and positioned as worn. The cap shall be completely rotated.

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* 3.6 Puckering. In the course of the sampling examination, seams suspected of being puckered shall be examined with the cap lying flat on the inspection table at a distance of 3 feet and shall be rated in comparison with the AATCC photographic comparative rating for seams. Puckering on a major portion of the suspected seam that is less than rating 4 for single needle seams or double needle seams shall be scored as a puckered seam.

3.7 Quality assurance terms and procedures. Definitions of quality assurance terms and procedures, where applicable, shall be in accordance with MIL-STD-105 and MIL-STD-109.

* 4. GENERAL REQUIREMENTS

This section is not applicable to this document.

* 5. DETAILED REQUIREMENTS

* 5.1 Purpose. This standard contains the provisions for inspection, end item examination, dimensional examination and packaging examination for garrison caps. If there are any inconsistencies between the requirements of the appropriate cap specification and the provisions of the standard, the cap specification shall control. This standard assigns to the listed defects, point values of 1, 2, or 3 depending on degree of severity. The higher point values are assigned to those defects having more detrimental effect on the appearance or serviceability of the item.

5.2 Inspection procedures. Inspection procedures shall be as specified in MIL-STD-105 except where otherwise indicated in this document.

5.3 Initiation of inspection. Normal inspection shall be used at the start of inspection unless otherwise directed by the responsible procurement quality assurance element administering the contract.

5.4 Continuation of inspection. Normal, tightened or reduced inspection shall continue unchanged on successive lots except where switching procedures in 5.5 require a change.

5.5 Switching procedures.

5.5.1 Normal to tightened. When normal inspection is in effect, tightened inspection shall be instituted when two out of five consecutive lots have been rejected on original inspection (i.e., ignoring resubmitted lots for this procedure).

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5.5.2 Tightened to normal. When tightened inspection is in effect, normal inspection shall be instituted when five consecutive lots have been considered acceptable on original inspection.

5.5.3 Normal to reduced. When normal inspection is in effect, reduced inspection shall be instituted providing that all of the following conditions are satisfied:

- a. The preceding 10 lots have been on normal inspection and none have been rejected on original inspection; and
- b. The total number of points for 3 and 2 point defects in the samples from the preceding 10 lots is equal to or less than 60 percent of the total maximum acceptable point values for 3 and 2 point defects from the preceding 10 lots; and
- c. The total number of points for 3, 2 and 1 point defects in the sample from the preceding 10 lots is equal to or less than 75 percent of the total maximum acceptable point values for 3, 2 and 1 point defects from the preceding 10 lots; and
- d. Production is at a steady rate; and
- e. Reduced inspection is considered desirable by the procurement quality assurance element administering the contract.

5.5.4 Reduced to normal. When reduced inspection is in effect, normal inspection shall be instituted if any of the following occur on original inspection:

- a. A lot is rejected; or
- b. A lot is considered acceptable but exceeds the applicable first value (see 1/ to table I); or
- c. Production becomes irregular or delayed; or
- d. Other conditions warrant that normal inspection be instituted.

* 5.6 End item visual examination. The caps shall be examined as indicated in 3.5 for all defects except puckering. The puckering examination shall be as described in 3.6. All defects shall be penalized as indicated in table II. The sample size shall be based on lot size, and the maximum acceptable point values for 3 and 2 point defects and total (3, 2 and 1 point) defects shall be as specified in table I. The sample unit shall be one finished cap. The lot shall be unacceptable if:

- a. The point value for 3 and 2 point defects exceeds the applicable maximum acceptable point value; or

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b. The point value for total (3, 2 and 1 point) defects exceeds the applicable maximum acceptable point value.

TABLE I. Sampling provisions for end item visual examination

Lot size		Sample size	Maximum acceptable point values	
			3 & 2 point defects	3, 2 & 1 point defects
Normal inspection	Up through 90	20	3 points	9 points
	91 - 150	32	5 points	13 points
	151 - 280	50	8 points	19 points
	281 - 500	80	13 points	29 points
	501 - 1200	125	18 points	41 points
	1201 - 3200	200	26 points	60 points
	3201 - 10,000	315	36 points	86 points
	10,001 - 35,000	500	55 points	127 points
35,001 and over	800	78 points	183 points	
Tightened inspection	Up through 150	32	3 points	10 points
	151 - 280	50	5 points	15 points
	281 - 500	80	8 points	23 points
	501 - 1200	125	13 points	35 points
	1201 - 3200	200	21 points	54 points
	3201 - 10,000	315	31 points	81 points
	10,001 - 35,000	500	47 points	122 points
	35,001 and over	800	70 points	183 points
Lot size		Sample size	Maximum acceptable point values	
			3 & 2 point defects <u>1/</u>	3, 2 & 1 point defects
Reduced inspection	Up through 280	20	3-10 points	9 points
	281 - 500	32	5-13 points	13 points
	501 - 1200	50	8-16 points	19 points
	1201 - 3200	80	13-21 points	22 points
	3201 - 10,000	125	18-26 points	41 points
	10,001 - 35,000	200	26-34 points	60 points
	35,001 and over	315	35-44 points	86 points

1/ If the first value is exceeded but the second value has not been exceeded, accept the lot but reinstate normal inspection (see 5.5.4b). The second value is the maximum acceptable point value.

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TABLE II. End item visual defects

Defect	Point Value
I. <u>MATERIAL DEFECTS AND WORKMANSHIP DAMAGE</u>	
a. Any hole, cut, tear, smash, mend, needle chew, drill hole or open place:	
1. On outside (see 3.5) (longest dimension in any direction):	
(a) - up to 1/4 inch, inclusive	2
(b) - more than 1/4 inch	3
2. On inside (see 3.5) (longest dimension in any direction):	
(a) - up to 1/4 inch, inclusive	1
(b) - more than 1/4 inch	2
b. Loose yarn, snagged yarn, misweave, float, coarse yarn, area of no dye penetration, dye streak, missing yarn, broken yarn, thin place, shade bar or woven in waste:	
1. On outside (longest dimension in any direction):	
(a) - up to 1/4 inch, inclusive	1
(b) - more than 1/4 inch	2
c. Permanent fold, pleat or crease in cloth (when caught in seaming or stitching):	
1. On outside	3
d. Leather:	
1. Cracked, cut or thin, weak spot	2
2. Spongy, flanky or stretched (showing a coarse grain and uneven appearance)	2
3. Any scar, wrinkle or scratch visible at a distance of three feet	2
4. Finish on leather peeling off	2
5. Needle chews in leather	2
e. Knot or slub (see 3.2) on outside	2
II. <u>SHADED PART</u>	
a. On outside:	
1. Variation in shade within a part or between two or more parts	2
III. <u>PRESSING</u>	
a. Burned or scorched	3
b. Blocking or pressing omitted	2

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

Defect	Point Value
III. <u>PRESSING</u> (cont'd)	
c. Poorly pressed	1
d. Pressing impression or gloss on outside of cap	1
e. Bottom edge of cap not pressed as specified	1
f. Curtain at front or back edge not pressed as specified	1
IV. <u>CLEANNESS</u>	
a. Any spot or stain on outside visible at 3 feet (largest dimension in any direction):	
1. Up to 1/4 inch, inclusive	2
2. More than 1/4 inch	3
b. Any marking exposed or visible on outside	3
c. Thread ends on inside and outside:	
1. More than one but not more than three not trimmed to less than 3/8 inch	1
2. More than three not trimmed to less than 3/8 inch	2
3. Three or more loose threads not removed	1
d. One or more shade or size tickets not removed	1
e. Thread end caught for a distance of more than 1/4 inch in line of stitching on outside	1
f. Visible basting thread not removed	1
V. <u>COMPONENT AND ASSEMBLY</u>	
a. Any component part or operation omitted (unless otherwise classified herein)	3
b. Any component not as specified	3
c. Any component part tight, twisted, distorted, pleated or full (unless otherwise classified herein)	2
d. Any operation not as specified (unless otherwise classified herein)	2
VI. <u>CUTTING</u>	
a. Any component part not cut in accordance with specified pattern, directional lines on patterns or not in accordance with specification requirements	3
b. Twill line of any outside part not running in specified direction	3

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

Defect	Point Value
VII. SEAMS AND STITCHING	
a Accuracy of seaming:	
1. Seam puckered (score only when on major portion of seam) (see 3.6)	1
2. Seam irregular, pleated or wavy	2
3. Part caught in any unrelated operation or stitching	2
4. End of stitching when not caught in another seam or stitching backtacked less than 1/4 inch; or end of continuous stitching overlapped less than 1/2 inch	1
5. Stitching overlapping end of thread break less than 1/2 inch	1
6. Optional basting or holding stitching not removed or visible on outside of cap	1
7. Not specified color or varying shades of thread used on outside	2
b. Gage of stitching and seam allowance:	
1. Edge, top or raised stitching sewn too close to edge resulting in damage to cloth	2
2. Seam allowance not as specified by 1/16 inch or more. (Score only when condition exists on more than 1/2 the length of the seam)	1
3. Irregular or not within range specified or varies more than 1/16 inch when no range is specified. Score only when condition exists on major portion (i.e. more than 1/2 the length) of the seam	1
c. Open seam.	
1. On outside:	
(a) - up to 1/4 inch	1
(b) - 1/4 inch up to and including 1/2 inch	2
(c) - more than 1/2 inch	3
2. On inside:	
(a) - 1/4 inch up to and including 1/2 inch	1
(b) - more than 1/2 inch	2
d. Raw edge: (see 3.4)	
1. On outside (excluding left end of curtain):	
(a) - up to 1/4 inch inclusive	1
(b) - more than 1/4 inch up to and including 3/4 inch	2
(c) - more than 3/4 inch	3
2. On inside:	
(a) - 1/4 inch up to and including 1/2 inch	1
(b) - more than 1/2 inch up to and including 1 inch	2

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

Defect	Point Value
VII. <u>SEAMS AND STITCHING</u> (cont'd)	
(c) - more than one inch	3
3. Raw edge on inside lining along bottom edge more than one inch	1
e. Seam and stitch type:	
1. Not specified seam or stitch type	2
2. Any line of stitching omitted	3
3. Any line of stitching not beginning or ending where specified (unless otherwise classified herein)	1
4. Looper thread of 401 stitch type on outside	3
f. Stitch tension:	
1. Loose tension resulting in a loose seam	3
2. Loosely exposed loops of lower or top thread on edge, top or raised stitching	2
3. Tight tension (stitches break when normal strain is applied in the direction of the seam or stitching)	3
g. Stitches per inch (score only when condition exists on more than 1/2 the length of seam):	
1. More than the maximum specified	1
2. Less than the minimum specified:	
(a) - by one or two stitches	1
(b) - by three or more stitches	2
h. Runoff, skipped or broken stitch:	
1. Joining seam - use (open seam) classification	-
2. Edge, top or raised stitching:	
* (a) - up to 1/2 inch inclusive	1
* (b) - more than 1/2 inch	2
VIII. <u>EYELET</u>	
a. One or more omitted or added	3
b. Chipped, broken, cracked, split or bent	3
c. Loose or raw edges exposed around edges of eyelet on outside	3
d. Not securely clinched or clinched too tightly, cutting the fabric	3
e. Positioned other than as specified	2
* f. Side or front puckered or pleated in clinching of 1 or more eyelets	2
* g. Raw edge of front stay lining exposed around edge of washer on inside	1

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

Defect	Point Value
IX. <u>SWEATBAND</u>	
a. Omitted	3
b. Short or tight, causing puckering, gathering or pleats on curtain	3
c. End of sweatband not overlapped as specified, or not finished as specified	1
d. Finished width not as specified	1
e. Joining seam of sweatband not positioned as specified from either side of back seam of cap	1
f. Upper edge of cloth sweatband not turned under and stitched to crown side	1
g. Sweatband not of uniform width along major portion of sweatband	1
h. Lower edge of sweatband exposed beyond rolled edge of curtain	2
i. Zig-zag stitching at overlapped end of sweatband catching any other part of the cap (when applicable)	1
j. Lower edge of sweatband not positioned above bottom rolled edge of curtain as specified	1
X. <u>CROWN PIECE (TOP CROWN)</u>	
a. Depth of fold at center not as specified	2
b. Top edge poorly shaped or puckered	2
c. Tapering at each end not as specified	2
d. Width not as specified	1
e. Top crown seam offset from center:	
1. 1/8 inch up to and including 1/4 inch	1
2. More than 1/4 inch	2
XI. <u>COMBINATION IDENTIFICATION AND SIZE LABEL</u>	
a. Missing, incorrect or illegible	2
b. Not securely caught in stitching	1
c. Positioned less than 1/2 inch or more than 1-1/2 inches to the right or left of the center of the back; or size marking not visible beyond edge of sweatband in finished cap	1
XII. <u>SIDE PIECES</u>	
a. Twisted, full, puckered or distorted	2
b. Top edge poorly shaped or puckered	2

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

Defect	Point Value
XII. <u>SIDE PIECES</u> (cont'd)	
c. Raise or top stitching on top seam omitted	2
d. Side piece joining to curtain tight, resulting in fullness on curtain	2
e. Point not fully forced out (unless otherwise classified herein)	1
XIII. <u>CURTAIN</u>	
a. Top edge poorly shaped	2
b. Top edge long or stretched, causing curtain to stand away from side of cap	2
c. Overlap at front of cap out of alignment with front seam by more than 1/4 inch	2
d. Excessive fullness, puckering or distortion on side piece or on bottom edge of curtain	3
e. Overlap on front of cap reversed, (i.e. right side overlapping left side, as worn)	3
f. Finished left end of curtain from center front of cap not as specified	3
g. Underply of curtain exposed on front of curtain	2
h. Top edge of curtain not positioned tightly against the cord edge of braid	3
XIV. <u>BRAID ON CURTAIN</u>	
a. Tight, causing excessive puckering or fullness on curtain	2
b. Corded edge irregular in width, or flat section of braid exposed beyond edge of curtain	2
c. Loose, causing curtain not to lie smoothly	2
d. End of braid on short end of curtain extending into and caught in the seaming of curtain to bottom edge of crown side	2
e. Edge frayed	3
XV. <u>LINING AND INTERLINING</u>	
a. Tight, short, twisted or distorted, causing any distortion on outside of cap	3
b. Overedge stitching along bottom edge of side piece and lining omitted	2
c. Front and back seams of interlining not free from the side crown seams	1

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- * **5.7 End item dimensional examination.** The sample size for end item dimensional examination shall be based on lot size as shown in table III. The caps shall be examined for conformance to the dimensional requirements cited in the table of measurements of the appropriate cap specification. When a measurement deviates from a dimension and tolerance specified, the cap shall be penalized one point. The lot shall be unacceptable if the total point value resulting from this examination exceeds the maximum acceptable point value specified in table III. Each size of cap present in the lot should be represented in the sample selected for this examination.

TABLE III. Sampling provisions for end item dimensional examination

<u>Lot size</u>	<u>Sample size</u>	<u>Maximum acceptable point values</u>
Up through 500	8	0
501 through 3,200	13	1
3,201 through 35,000	20	2
35,001 and up	32	3

- * **5.8 Packaging examination.** The fully packaged caps shall be examined for the defects listed below. The sample size shall be five shipping containers, fully packaged. The lot shall be unacceptable if one or more defects are found.

<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. Open and noncontinuous heat sealed seams in closure of polyethylene bag. <u>1/</u> Alternative closure of polyethylene bag not provided with tuck or reverse flap. <u>1/</u> Omission of vent hole in polyethylene bag. <u>1/</u> Incorrectly fabricated bag. <u>1/</u> Bulged or distorted container.

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<u>Examine</u>	<u>Defect</u> (cont'd)
Content	Number of intermediate containers is more or less than required. Number of caps per intermediate container is more or less than required. Size shown on one or more caps not as specified on shipping container. <u>2/</u>
Preservation (Naphthalene flakes)	Improperly applied or missing. <u>1/</u>

1/ When applicable.

2/ For this defect, one intermediate package from each shipping container in the sample shall be examined.

* 6. INFORMATION FOR GUIDANCE ONLY

* (This section contains information of a general or explanatory nature which is helpful, but is not mandatory.)

* 6.1 Subject term (key word) listing.

Caps, Garrison, Men's
Inspection
Quality
Uniforms

* 6.2 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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