

MIL-S-40046D
30 September 1984
SUPERSEDING
MIL-S-40046C
10 August 1970

MILITARY SPECIFICATION

SLING, FLAGSTAFF

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

1. SCOPE

1.1 Scope. - This specification covers three flagstaff slings, two are in colors and made of 8 webbing, and the other is made of black leather.

1.2 Classification. - The sling shall be of the following classes (see 6.2):

- Class 1 - Olive drab shade No. 7
- Class 2 - White
- Class 3 - Black

2. APPLICABLE DOCUMENTS

2.1 The following documents of the issue in effect on date of invitation for bids or request for proposals, form a part of this specification to the extent specified herein.

SPECIFICATIONS

FEDERAL

- V-T-276 - Thread, Cotton.
- V-T-285 - Thread, Polyester.
- FF-R-556 - Rivet, Solid, Small, Rivets, Split, Small Rivets, Tubular, Small, Flat Washer (Burr) and Caps, Rivets General Purpose.
- KK-L-271 - Leather, Cattlehide, Strap, Vegetable-Tanned.
- QQ-B-626 - Brass, Leaded and Nonleaded: Rod, Shapes, Forgings and Flat Products with Finished Edges (Bar and Strip).
- QQ-C-390 - Copper Alloy Castings (including Cast Bar).
- TT-E-529 - Enamel, Alkyd, Semigloss.
- DDD-L-20 - Labels, for Clothing, Equipage, and Tentage (General Use).
- PPP-B-636 - Boxes, Shipping, Fiberboard.
- PPP-B-676 - Boxes, Setup.

Beneficial comments (recommendations, Additions, deletions) and any pertinent data which may be used in improving this document should be addressed to: Director, The Institute of Heraldry, US Army, Cameron Station, Alexandria, VA 22304-5050, 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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- MIL-F-495 - Finish, Chemical, Black, for Copper Alloys.
- MIL-W-530 - Webbing, Textile, Cotton, General Purpose, Natural or in Colors.
- MIL-L-3851 - Loop, Slide (for Equipage).
- MIL-F-10336 - Fiber, Sheet, Vulcanized.
- MIL-T-43566 - Tape, Textile, Cotton, General Purpose, Natural or in Colors.
- MIL-P-26514 - Polyurethane Foam, Rigid or Flexible, for Packaging.

STANDARDS

FEDERAL

- FED-STD-311 - Leather, Methods of Sampling and Testing.
- 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.

DRAWINGS

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- 5-1-338 - Sling, Flagstaff; Assembly, Details and Sections.
- 5-1-637 - Sling, Flagstaff; Leather, Black, Navy.

(Copies of specifications, standards and drawings required by the contractor in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

(Figures 1 and 2 are miniature copies of the referenced drawings and are attached for information purposes only.)

3. REQUIREMENTS

3.1 Samples. -

3.1.1 Guide samples. - Guide samples of the end item, when furnished, are solely for guidance and information (see 6.3). Variation from this specification may appear in the sample, in which case this specification shall govern.

3.1.2 Standard sample. - At the request of the contractor (see 6.3) the Contracting Officer will furnish standard shade sample of the tape, webbing, and thread which shall be used for matching color and colorfastness only.

3.2 First article. - When specified (see 6.2), before production is commenced, a sample of the finished sling shall be submitted or made available to the Contracting Officer or his authorized representative for inspection as specified in 4.3.1.1 and 4.3.1.2. The approval of the first article authorizes the commencement of production, but does not relieve the contractor of responsibility for compliance with all applicable provisions of this specification. The first article shall be manufactured in the same facilities to be used for the manufacture of the production items.

3.3 Materials. - Materials shall conform to the referenced specifications and to the requirements specified herein.

3.3.1 Webbing, textile, cotton. - The webbing shall be as specified herein and when no shade sample is available the webbing shall show good fastness to weathering.

3.3.1.1 Class 1. - Webbing for the class 1 sling shall conform to type II, class 4, 3-3/4 inches in width and type IV, class 4, 2-1/4 inches in width of MIL-W-530. The webbing shall be dyed olive drab shade No. 7 to match the standard sample furnished (see 6.3).

3.3.1.2 Class 2. - Webbing for class 2 sling shall conform to type II, class 2a, 3-3/4 inches in width and type IV, class 2a, 2-1/4 inches in width of MIL-W-530. The webbing shall be white (3022) and shall match the standard sample furnished (see 6.3).

3.3.2 Tape, textile, cotton. -

3.3.2.1 Class 1. - The tape for the class 1 sling shall conform to type I, class 4 of MIL-T-43566. The tape shall be one inch in width and shall be dyed olive drab No. 7 to match the standard sample (see 3.1.2).

3.3.2.2 Class 2. - The tape for the class 2 sling shall conform to type I, class 2 of MIL-T-43566 except the bleached tape shall be mildew resistant and water repellent treated.

3.3.3 Thread. -

3.3.3.1 Class 1 and 2 Slings. - The thread shall conform to type I or II, class 1, subclass A or B of V-T-285. The size of the thread shall be as follows:

For tufting - Size 3.

For all stitching except tufting - Size FF.

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3.3.3.2 Class 3 Sling. - The thread shall be black cotton glazed cord conforming to type IIIB, ticket number 10/5 or 10/6 of V-T-276.

3.3.3.3 Color. - The thread for sewing all parts, except leather, shall be olive drab S-1 (Cable No. 66022) for class 1 slings and natural for class 2 slings. The thread used for sewing leather components and for tufting shall be dyed black. All thread shall show fastness to weathering equal to, or better than, the shade sample. If no sample is available the thread shall show good fastness to weathering.

3.3.4 Copper Base Alloy. -

3.3.4.1 Bronze. - The bronze for the class 1 and 2 socket shall conform to Alloy B5 (85-5-5-5) of QQ-C-390.

3.3.4.2 Brass. - The brass for the buckles on the black leather sling shall conform to QQ-B-626. Forged buckles shall use Alloy 377. Machine parts shall use Alloy 360.

3.3.5 Malleable iron. - The malleable iron for the sockets shall conform to any malleable iron suitable for casting.

3.3.6 Leather. - Leather shall be black and shall conform to type II, of KK-L-271, except the requirements for chromic oxide and lead shall not apply.

3.3.6.1 Thickness. - Component parts of sling should have specified thickness requirements.

3.3.7 Steel. - Steel for the plate shall conform to any cold rolled commercial quality steel suitable for the purpose.

3.3.8 Fiberboard. - Vulcanized fiberboard for the back shall conform to MIL-F-10336.

3.3.9 Rivet and burrs. - Rivets shall conform to type VI, grade F, black chemical finish of FF-R-556. The plate rivets shall be 1/8 inch in diameter and 5/16 inch in length. The rivets for attaching the socket shall be 3/16 inch in diameter and 5/16 inch in length. Burrs shall be fabricated from brass with a black chemical finish.

3.4.5 Stitching. - All stitching, except tufting stitching, shall conform to stitch type 301 of FED-STD-751, with 6 to 8 stitches to the inch.

3.4.5.1 Type 301 stitching. - Thread breaks in stitching shall be backstitched not less than one inch at each break. Stitching shall be backstitched not less than one inch at the ends, except where the ends are turned under in a hem or caught by other stitching. Thread tension shall be maintained so that there will be no loose stitching and that the lock will be embedded in the materials sewn. All thread ends on the webbing shall be trimmed.

3.4.5.2 Stitching. - Stitches shall pass through the reinforcement tuft, leather pad cover, polyurethane foam padding, 1/8 inch hole of fiberboard and pad A as shown on drawing 5-1-338. The thread shall be drawn sufficiently taut to secure the reinforcement tuft and produce a surface contour for the finished pad generally conforming to that shown in section GG of drawing 5-1-338. The two free ends of each tufting thread shall be securely tied together on the front side of pad A as indicated on the drawing.

3.4.6 Riveting. - The class 1 and 2 slings shall be assembled as shown on drawing 5-1-338. The socket of the sling shall be securely riveted in the center of the plate with four rivets. The rivet heads shall be flush with the surface of the socket. The steel plate shall be centered on and securely riveted to the webbing pad B with not less than 6 rivets. The rivet heads shall be flush with the plate surface. The base of the socket shall be centered on the steel plate when riveting is completed.

3.4.7 Class 3, Assemblies and Details. - The method of attaching straps and holders shall be as follows:

a. Stitch straight edges of front connecting pieces to holder and buckle straps 1/8 inch from edge, positioned as indicated on drawing, i.e., base of holder 1/2 inch from base of connecting pieces, etc.

b. Reverse assembly so that straight edges of connecting piece assembly form a butt seam.

c. Insert shoulder straps between the two front connecting pieces and one back connecting piece and stitch 3/16 inch from edge.

d. Stitch holder to front and back connecting pieces with a double row of stitching across top of holder. Stitching shall be approximately 1-1/2 inches in length. At the option of the manufacturer, the buckle assembly may be cast, forged, or machined, using brass specified in paragraph 3.3.4.2.

3.5 Finishing.

3.5.1 Leather. - The grain surface of the leather shall be finished with a water resistant finish that provides good resistant to crocking when tested in accordance with 4.2.1.

3.5.2 Metal components. -

3.5.2.1 Class 1 and 2 sockets, plates, and buckles. - Iron sockets, steel plates, and steel and iron buckles shall be given a finish consisting of a phosphate treated zinc plate. The zinc plating shall be a minimum of .0005 inch thick and shall be followed by enameling (baked). The enamel shall conform to TT-E-529 and shall be black in color. The coating shall be uniform in thickness, with no objectionable orange peel, wrinkles, drops, streaks, or areas of thin or no film. Bronze sockets and buckles shall be given a black chemical finish conforming to MIL-F-495.

3.5.2.2 Class 3 buckles. - Class 3 buckles shall be made of brass specified in 3.3.4.2 and have a highly polished finish covered with clear lacquer.

3.6 Marking. - The identification marking for the class 1 and 2 slings shall conform to type IV, class 5 of DDD-L-20 and shall be applied to the sling in the location shown on the drawing. The letters U.S. shall be applied in the size characters and in the location shown on the drawing and shall conform to type IV, class 9 of the specification. Fastness shall be as specified for class 5 labels. No markings required for the class 3 sling.

3.7 Workmanship. - The slings shall conform to the quality and grade of product established by this specification, and the occurrence of defects shall not exceed the applicable acceptable quality levels established.

4. QUALITY ASSURANCE PROVISIONS

4.1 Inspection responsibility. - Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the supplier 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.

4.2 Inspection for acceptance. - Inspection shall be in accordance with the provisions of MIL-STD-105, except where otherwise indicated hereinafter.

4.2.1 Testing of components and materials. - In addition to the quality assurance provisions of the subsidiary specifications and drawings, inspection shall be performed on the leather for characteristics indicated in table I. The inspection level shall be S-1 and the acceptable quality level shall be 4.0 defects per hundred units.

TABLE I Leather tests

Characteristic	Rqm't	Test method	Rqm't	#determ	Results
	refer		appl to	per s/u	reported as
			Indiv		
			Unit		
Resistance to					
Crocking:					
Wet	3.5.1	Method 3031.1 of FED-STD-311	X	1	Good, fair, or poor.
Dry	3.5.1	Method 3031.1 of FED-STD-311	X	1	Good, fair, or poor.

4.2.2 In-process inspection. - Inspection shall be made at any point or during any phase of the manufacturing process to determine whether operations or assemblies are accomplished as specified. The Government reserves the right to exclude from consideration for acceptance any material for which in-process inspection has indicated nonconformance. In-process inspection shall be conducted to see that accomplishment of the following is in accordance with specified requirements:

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<u>Requirement operation or assembly</u>	<u>Rqmt' para</u>
Socket (bronze or malleable iron), steel plate, rivets and burrs, and slide buckle conform to specified dimensions, including thickness where applicable, and drawing 5-1-338.	3.3.4,3.3.5, 3.3.7,3.3.9, 3.3.9.1,3.3.9.2, and 3.3.11.
Size of polyurethane foam pad is not as specified	3.4.1
Leather components conform to specified cut dimensions including thickness.	3.4.3 and Dwg. 5-1-338 and 5-1-637
Fiberboard with holes conform to specified dimensions including thickness.	Dwg. 5-1-338

4.3 Inspection of the end item. -

4.3.1 Examination of the end item. - The classification of defects found during examination shall be in accordance with the list shown in 4.3.1.1 and 4.3.1.2. The sample unit for these examinations shall be one finished sling. The inspection levels and the acceptable quality levels shall be a specified in 4.3.1.3.

4.3.1.1 Examination for visual characteristics. -

Examine	Defects	Classification	
		Major	Minor
Webbing or tape (class 1 and 2 only)	Holes, cuts, or tears	x	-
	Webbing defects: seriously affecting serviceability or appearance	x	-
	affecting serviceability or appearance but not seriously . .	-	x
	Not firmly and tightly woven; edges frayed or scalloped	x	-
Leather	Broken grain, badly healed scar, scratch, open grub or tick mark, hole, open vein, flank, or other grain defects seriously affecting serviceability	x	-
	Affecting serviceability but not seriously	-	x
	Not type of leather specified . . .	-	x
	Not color required	x	-

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Examine	Defects	Classification	
		Major	Minor
Hardware	Broken or malformed failing to serve intended purpose, finish omitted or not as specified, corroded area, burr, or sharp edge	x	-
	Finish defects, i.e., objectionable orange peel, wrinkle, drop, streak, thin film or no film	-	x
	Not assembled as specified	x	-
Seams and stitching:			
Open Seams	3/8 inch or less	-	x
	More than 3/8 inch	x	-
	Note: A seam shall be classified as open when one or more continuous skipped stitches or runoffs occur.		
Runoffs (see open seams): Raw edges	Any raw edge, except when required Note: Raw edges not securely caught in stitching shall be classified as open seams.	-	x
Seam and stitch type	Wrong seam or stitch type	x	-
Stitch tension	Loose, resulting in a loosely exposed top or bobbin thread; tight, resulting in excessive tightness or seams	-	x
Stitches per inch	One to two stitches less than minimum specified	-	x
	Three or more stitches less than minimum specified	x	-
	One or more stitches in excess of maximum specified	-	x
Stitching margin	Not as specified affecting serviceability	-	x
Stitching ends	Backstitched less than one inch . .	-	x
Thread breaks	Backstitched less than one inch . . Note: Thread breaks not backstitched shall be classified as open seams.	-	x

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Examine	Defects	Classification	
		Major	Minor
Stitching	One or more required rows of stitching omitted	x	-
Cleanness	Spots or stains not removable: Seriously affecting appearance . . .	x	-
	Affecting appearance but not seriously	-	-
	Thread ends not trimmed throughout .	-	x
Marking (class 1 and 2 only)	Omitted, incorrect, illegible, or misplaced	-	x
	Any required component part or operation omitted (unless otherwise classified herein)	x	-
Components and assembly			
Construction details:			
Socket	Any part of socket welded	x	-
	Not securely riveted through steel plate or riveted with less than four rivets	x	-
	Reverse, i.e., set with bottom section facing shoulder straps . .	x	-
	Set off center of steel plate by 1/8 inch or more	-	x
	Rivet heads not flush with socket surface	-	x
Steel plate	Not securely riveted to webbing pad B or riveted with less than six rivets	x	-
	Corners not uniformly shaped or radius irregular	-	x
	Set with centerline of plate off center of webbing pad B by more than 1/8 inch	-	x
	Rivet heads not flush with plate surface	-	x
Webbing pad B	Constructed with two pieces of webbing instead of one	-	x
	Any part of pad B single ply construction	x	-

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Examine	Defects	Classification	
		Major	Minor
	Edges of webbing pad B uneven with edges of webbing pad A more than 1/8 inch	-	x
	Ends of shoulder strap not inserted between double thickness of pad B. . .	-	x
Webbing pad A	Misplaced, i.e., set between double thickness of webbing pad B instead of back of webbing pad B	-	x
Padding	Not thickness required	x	-
	Not size required	x	-
Pad cover	Not stitched to pad A on four sides . .	x	-
	Set with edges of cover less than 1/8 inch or more than 1/4 inch from edges of pad A	-	x
	Set with grain of leather on inside of pad	x	-
Leather reinforcement tufts	One or more tuft stitching or leather tufts omitted or insecure	x	-
	Loose, i.e., tuft stitching not drawn tightly	-	x
	Set out of horizontal or vertical alignment by 1/4 inch or more	-	x
Shoulder straps	Set with outer edge of straps uneven with corners of webbing pad B by 1/8 inch or more	-	x
	End of webbing inserted in leather tips less than 1/2 inch	-	x
	Either edge of webbing uneven with edges of leather tips by more than 1/16 inch	-	x
Short straps with slide buckles and keepers	Binding at either end of straps loosely improperly applied	-	x
	Misplaced, i.e., set to outside of shoulder straps instead of inside (see Dwg, 5-1-338 assembly, back view)	-	x
	Leather keepers short, failing to accommodate free end of shoulder straps	-	x

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Examine	Defects	Classification	
		Major	Minor
Class 3 slings	Ends of keepers overlapped less than one inch	-	x
	Not assembled as required	x	-
	Component missing	x	-

4.3.1.2 Examination for dimensional characteristics. -

Examine	Defect
Interior angle of shoulder straps (see back view, Drawing 5-1-338 and 5-1-637 (as applicable)	Less than 22 degrees or more than 27 degrees.
Angle of short straps (see back view, Drawing 5-1-338 and 5-1-637 (as applicable)	Less than 45 degrees or more than 50 degrees.
Components and location dimensions.	Not within specified tolerance.

4.3.1.3 Inspection levels and acceptable quality levels. - The inspection levels and acceptable quality levels (express in defects per hundred units) shall be as follows:

Examination	Inspection level	AQL	
		Major	Total
Visual characteristics (4.3.1.1)	II	2.5	10.0
Dimensional Characteristics (4.3.1.2)	S-3	One class	6.5

4.3.2 Examination of preparation for delivery requirements. - An examination shall be made to determine that packaging, packing, and marking requirements of section 5 of this specification are complied with. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully packaged, selected just prior to the closing operation. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot size shall be the number of containers in the inspection lot. The inspection level shall be S-2 and the AQL shall be 2.5 defects per hundred units.

Examine	Defect
Marking (exterior and interior).	Omitted, incorrect, illegible, of improper size, location, sequence, or method of application.
Materials	Any component missing. Any component damaged, affecting serviceability.
Workmanship	Inadequate application of components, such as, incomplete closure of container flaps, loose strapping or taping, inadequate stapling. Bulging or distortion of containers.

5. PREPARATION FOR DELIVERY

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

5.1.1 Level A. -

5.1.1.1 Class 1 and 2. - Disassemble shoulder straps from short straps. Tuck short straps under the shoulder straps and wind shoulder straps around the steel plate, one shoulder strap on each side of the metal socket. Each folded sling shall then be packaged in a snug-fitting, setup paperboard box conforming to type I, variety 2, style 3 or 4 of PPP-B-676. The inside dimension shall be approximately 6-1/4 inches by 5-7/8 inches by 4-1/2 inches. Box closure shall be in accordance with the container specification.

5.1.1.2 Class 3. - Each strap shall be rolled back to the holder area and packaged in a snug-fitting setup paperboard box conforming to type I, variety 1, class A, style 4 of PPP-B-676. Box closure shall be in accordance with the appendix of the container specification. The use of Scotch Brand box closing filament tape No. 898, or equal, 1/2", using a minimum of two 1/2" x 4" ("L" clips) or each edge, may be utilized as an alternate method for effecting closure of set-up boxes.

5.1.2 Level C. - Slings shall be preserved and packaged to afford adequate protection against corrosion, deterioration, and damaged during shipment from supply source to first receiving activity. The supplier may use his standard practice when it meets these requirements.

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

5.2.1 Level A. - Slings of one class only, packaged as specified in 5.1 shall be packed in a snug-fitting fiberboard shipping container conforming to class weather-resistant V3s or V3c grade 275 of PPP-B-636. Closure shall be in accordance with the appendix of the applicable container specification.

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5.2.2 Level B. - Slings of one class only, packaged as specified in 5.1 shall be packed in a snug-fitting fiberboard box conforming to class Domestic, grade 275 of PPP-B-636. Closure shall be in accordance with the appendix of the applicable container specification. The weight of the contents of each shipping container shall not exceed the size and weight limitations of the container specification.

5.2.3 Level C. - Slings of one class only, packaged as specified in 5.1, shall be packed in a manner to assure carrier acceptance and safe delivery at destination at the lowest transportation rate for such supplies. Containers shall be in accordance with the rules and regulations of carriers applicable to the mode of transportation.

5.3 Marking. - Interior packages and shipping containers shall be marked in accordance with MIL-STD-129.

5.2.1 Interior packages. - Interior packages shall be marked as follows:

STOCK NUMBER
NONMENCLATURE
CONTRACT NUMBER
MANUFACTURER'S NAME

6. NOTES

6.1 Intended use. - The flagstaff slings covered by this specification are intended to be used by military flag bearers during parades, reviews, and other ceremonies where flags are desired. The class 1 sling is intended to be used by Army personnel, class 2 is to be used by Air Force personnel and the class 3 sling is to be used by Navy personnel.

6.2 Ordering data. - Procurement documents should specify the following:

- (a) Title, number, and date of this specification.
- (b) Class of sling required (see 1.2).
- (c) When standard samples will not be furnished (see 6.3).
- (d) When a first article is required (see 3.2).
- (e) Selection of applicable levels of packaging and packing (see 5.1 and 5.2).

6.3 Standard and guide samples. - For access to standard or guide samples, address the procurement office issuing the invitation for bids or request for proposals.

INSTRUCTIONS: In a continuing effort to make our standardization documents better, the DoD provides this form for use in submitting comments and suggestions for improvements. All users of military standardization documents are invited to provide suggestions. This form may be detached, folded along the lines indicated, taped along the loose edge (*DO NOT STAPLE*), and mailed. In block 5, be as specific as possible about particular problem areas such as wording which required interpretation, was too rigid, restrictive, loose, ambiguous, or was incompatible, and give proposed wording changes which would alleviate the problems. Enter in block 6 any remarks not related to a specific paragraph of the document. If block 7 is filled out, an acknowledgement will be mailed to you within 30 days to let you know that your comments were received and are being considered.

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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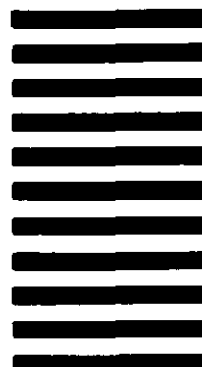


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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

1. DOCUMENT NUMBER

MIL-S-40046D

2. DOCUMENT TITLE

Sling, Flagstaff

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)

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62 MAR

PREVIOUS EDITION IS OBSOLETE.

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