



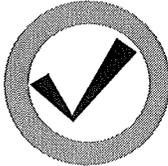
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NOTICE

This documentation has been reviewed by the technical authority and does not contain controlled goods. Disclosure notices and handling instructions originally received with the document shall continue to apply.



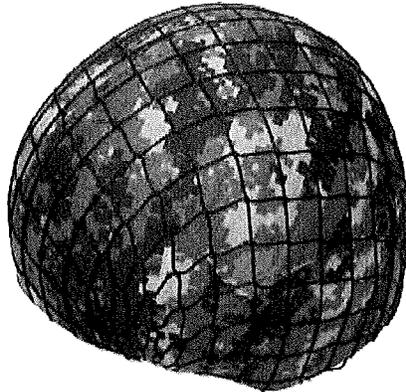
AVIS

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**Manufacturing Data
for
Scrim Net, used on CG 634 Combat Helmet**

1. SCOPE

- 1.1 Scope.** This manufacturing data covers the materials, design, construction and inspection requirements for scrim net, used on the CG634 in-service combat helmet.



- 1.2 Classification.** The scrim net, CG634 combat helmet, covered by this document is identified by the following :

Description: Helmet Cover, Scrim Net, Camouflage NSN 8415 -21-913-9686
Part: DSSPM 123-00, Supplier: 35907



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2. APPLICABLE DOCUMENTS

2.1 Government documents. The following documents form part of this manufacturing data to the extent specified herein. Unless otherwise specified, the issue or amendment of this document effective for a particular contract shall be that in effect on the date of the applicable design data list, the invitation to tender or the contract.

2.2 Sealed patterns.

DSSPM 123-00 Scrim Net, CG634 Combat Helmet

2.3 Technical drawings. Drawings are available from DSCO 4-3.

DND 9675155 - Scrim Net Assembly

DND 9675156 - Net

DND 9675157 - Tab , Front

DND 9675158 - Tab

2.4 Government Supplied. There shall be no Government supplied material for this activity. All construction shall be in accordance with the sealed pattern, DSSPM 123-00 and reference drawings, supplied.

3. ORDER OF PRECEDENCE

3.1 In the event of any inconsistency in the contract documents, the order of precedence shall be contract, manufacturing data, figures and sealed pattern.

3.2 In the event of a conflict between the text of this manufacturing data and the references cited herein, the text of this manufacturing data shall take precedence.



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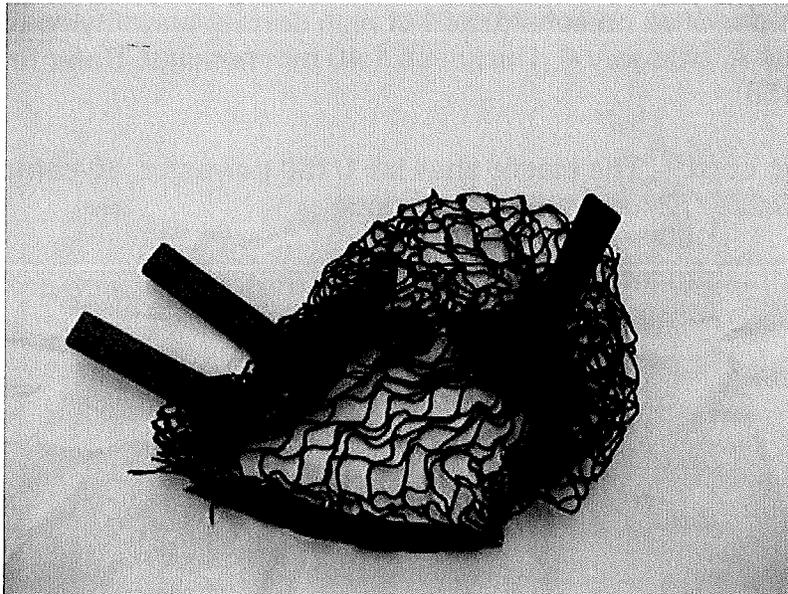
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4. REQUIREMENTS

4.1 Sealed pattern. The sealed pattern, DSSPM 123-00, referred to herein is representative of the required item but is not part of the technical requirement. The sealed pattern may not meet the technical requirements in all respects and shall be used for guidance only during production.

4.2 Design. The design shall be in accordance with this manufacturing data. Sealed pattern DSSPM 123-00, Scrim Net, Combat helmet, should only be used as a guide. The following features shall be incorporated:

- a) One size scrim net shall fit the size small, medium and large CG634 combat helmets
- b) Black polyethylene, front locator tab
- c) Black polyethylene, side locator tabs
- d) Black polyester/rubber elastic cord
- e) Black nylon netting



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4.2.1 Pre-production sample. Pre-production samples shall be a requirement of this manufacturing data. Pre-production samples shall be completely representative of the final product, being made from parts and materials as specified and with equipment and processes which will be used in quantity production.

4.3 Materials

4.3.1 Netting Material. The netting material shall be nylon, dyed black in colour, 6 yarns, 840 denier, standard duty weight, with hole size of 7/8 " x 7/8 ". Refer to Drawing 9675156.

Note: Requirement for "FR as per ASTM D1230- 61" is waived.

4.3.2 Tab, front. Shall be constructed of high density polyethylene sheet, type III, class A, category 4. Thickness 0.70 mm nominal. Refer to Drawing 9675157.

4.3.3 Tab, side. Shall be constructed of high density polyethylene sheet, type III, class A, category 4. Thickness 1.40 mm nominal. Refer to Drawing 9675158.

4.3.4 Elastic cord. The elastic shall be 1/150 polyester, 16 carrier, rubber filler, 0.025 ", 24 ends, black in colour.

Note: Total finished length – revised to 583 mm.



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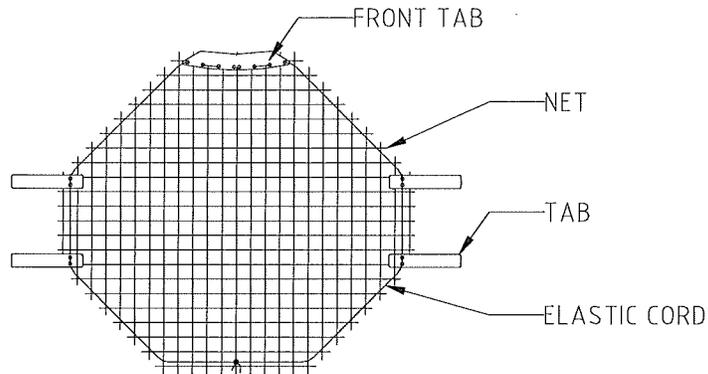


Figure 1. Scrim net assembly

4.4 Cutting

4.4.1 The specified materials and hardware, where not specified herein, shall be cut and used with the best commercial standards and practices. Netting individual ends shall be heat sealed to prevent fraying.

4.5 Labeling The following information shall be printed on each label:

- a) **NATO Stock Number** - 8415-21-913-9686
- b) **Item Name** - Scrim Net, u/o CG 634 Combat Helmet
- b) **Contract Number**W 8486 – 13474-XXXXX.....

The label shall be self adhesive backed and affixed to a suitably sized clear polyethylene bag.



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5. Quality Control/Inspection

5.1 The contractor is responsible for the performance of all inspection requirements as specified herein. Contractors may utilize their own or any other inspection facility acceptable to the Government or its designated representative. The Government reserves the right to perform, any of the inspections which are deemed necessary to ensure that material and services conform to the prescribed requirements. The contractor is responsible for ensuring that all material or services submitted to the Government for acceptance comply with all requirements of the manufacturing data.

5.2 Inspection requirements include:

- a. correct mesh size of nylon netting
- b. correct material for netting
- c. correct dimensions for front and side locator tabs
- d. correct finished size, shall fit all sizes of CG 634 combat helmet
- e. correct colour of components utilized in construction
- f. correct assembly of components used in construction

6. Packaging

6.1 **Packaging and packing.** Packaging, packing and delivery shall be in accordance with the terms of the contract.

6.2 **Preparation for packaging.** Each scrim net shall be packaged into a sufficiently sized, clear, polyethylene bag. Each polyethylene bag shall have a label affixed as per Para 4.5.

7. Notes

7.1 **Ordering data.** Procurement documents should specify the following;

- a) Title, number and date of this document;
- b) NATO stock number and qty's. required;
- c) Pre-production requirements;
- d) Packaging and packing requirements;
- e) The Design Authority.



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7.2 Design Authority. The Design Authority is the Government agency responsible for all technical aspects of design and changes to design. The Design Authority is the Director Soldier Systems Program Management, (DSSPM 3-5).

8. Definition of Terms.

8.1 Master Sealed Pattern. A master sealed pattern is the authorized prototype of the item to be procured, and is held only by the Government.

8.2 Sealed Pattern. A sealed pattern is an exact duplicate of the master sealed pattern and is available to the manufacturer to be used as a guide in production.

8.3 Data List. The data list identifies the drawings and specifications applicable to this document.

