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INCH-POUND
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SUPERSEDING
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(See 6.5)

PERFORMANCE SPECIFICATION

GASKET MATERIAL, RUBBER, 50 DUROMETER HARDNESS (MAXIMUM)

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

1. SCOPE

1.1 Scope. This specification establishes the requirements for synthetic rubber materials for gaskets 50 durometer hardness maximum.

1.2 Classification. The synthetic rubber shall be of the following classes, as specified (see 3.1 and 6.2):

Class I - Oil resistant, (chloroprene rubber).

Class II - Non-oil resistant, (butadiene-styrene rubber).

Class III - Fuel resistant, (butadiene-acrylonitrile rubber).

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications and standards. The following specifications and 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 (see 6.2).

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Commander, Naval Sea Systems Command, SEA 03R42, 2531 Jefferson Davis Hwy., Arlington, VA 22242-5160 by using the Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 5130

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SPECIFICATIONS

FEDERAL

PPP-F-320 - Fiberboard, Corrugated and Solid, Sheet Stock (Container Grade) and Cut Shapes.

MILITARY

MIL-P-116 - Preservation, Methods of.
MIL-L-19140 - Lumber and Plywood Fire-Retardant Treated.

STANDARDS

FEDERAL

FED-STD-601 - Rubber: Sampling and Testing.

MILITARY

MIL-STD-190 - Identification Marking of Rubber Products.
MIL-STD-289 - Visual Inspection Guide for Rubber Sheet Material.
MIL-STD-298 - Visual Inspection Guide for Rubber Extruded Goods.
MIL-STD-407 - Visual Inspection Guide for Rubber Molded Items.
MIL-STD-2073-1 - DOD Material Procedures for Development and Application of Packaging Requirements.

(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from the Standardization Documents Order Desk, Bldg. 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.)

2.2 NonGovernment publications. The following documents 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 cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of the documents cited in the solicitation (see 6.2).

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

D412 - Rubber Properties in Tension.
D3951 - 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.)

(NonGovernment standards and other publications are normally available from the organizations that prepare or distribute the documents. These documents also may be available in or through libraries or other informational services.)

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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 takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 Material. The material shall be vulcanized synthetic rubber as specified in 1.2, which meet the applicable requirements specified herein.

3.2 Form. The synthetic rubber gasket material shall be furnished in the form specified (see 6.2). This form may be sheets, strips of rectangular cross section, shapes cut from sheets, molded shapes or extruded shapes.

3.2.1 Sheet. Sheet rubber shall have smooth surfaces and shall have the thickness specified (see 6.2). Unless otherwise specified (see 6.2), the tolerances in thickness specified in table I shall apply. Unless otherwise specified (see 6.2), sheet rubber shall be furnished in rolls 36 inches plus or minus 1 inch wide and the length shall be 60 inches plus or minus 1 inch. Rolls shall consist of not more than four lengths of sheet. In no case shall the length of a sheet be less than the width.

TABLE I. Tolerances in width and thickness.

Width, inches	Tolerance (plus or minus)	Thickness, inch	Tolerance (plus or minus) inch
Less than 1/16	0.010 inch	1/32 to 1/16	1/128
1/16 to 1/8, inclusive	1/64 inch	1/16 to 1/8, inclusive	1/64
1/8 to 1/2, inclusive	1/32 inch	1/8 to 1/2, inclusive	1/32
1/2 to 1, inclusive	3/64 inch	1/2 to 1, inclusive	3/64
1 to 2, inclusive	1/16 inch	Over 1	1/16
Over 2	3 percent		

3.2.2 Strip. Strip rubber of rectangular cross section shall have smooth surface and shall have the cross sectional dimensions specified (see 6.2). Unless otherwise specified (see 6.2), the tolerances in thickness and width specified in table I shall apply. Unless otherwise specified (see 6.2), strip rubber shall be furnished in length of 11 feet.

3.2.3 Cut, molded and extruded shapes. Cut, molded and extruded shapes shall have the form, dimensions and tolerances specified (see 6.2).

3.3 Physical requirements. The rubber gasket materials shall conform to the requirements specified in table II. The test methods are detailed in 4.8.

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TABLE II. Physical requirements of rubber.

Initial properties:	Class I	Class II	Class III 1500	Test Method
Tensile strength, psi, minimum	1500	1000	400	4.8.1
Ultimate elongation, per- cent, minimum	400	300	50	4.8.1
Hardness, durometer points, maximum	50	50	1.40	4.8.2
Specific gravity, maximum	1.60	1.40	95	4.8.3
Sealing pressure, psi, minimum	95	95		4.8.4
Properties after oven aging	All classes			4.8.5
Tensile strength, percent of initial, minimum	75			4.8.5.1
Ultimate elongation, per- cent of initial, minimum	70			4.8.5.1
Hardness, durometer points maximum	65			4.8.5.2
Compression set, percent, maximum	30			4.8.5.3
Sealing pressure, psi, minimum	70			4.8.5.4
Properties after light aging:	All classes			4.8.6
Tensile strength, percent of initial, minimum	75			4.8.6
Ultimate elongation, per- cent of initial, minimum	70			4.8.6
Properties after low temperature aging:		All Classes		4.8.7
Flexibility at minus 20°F, load in grams, maximum required to deflect	1 inch 2 inch	25 35		

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Properties after liquid immersions:				
Volume change after water immersion, percent	0 to 5			4.8.8
Water extraction, percent, maximum	0.5			4.8.9
Delamination test	no delamination			4.8.10
Volume change, after immersion in medium No. 1 oil, percent	Class I only			4.8.11
Volume change, after immersion in medium No. 6 fluid, percent	Class III only 0 to 30			4.8.12

3.4 Identification. Material supplied under this specification shall be identified in accordance with MIL-STD-190. Class I material shall be marked with a yellow color and class III material with a red color. No environmental color identification is necessary for class II material. Marking shall be done with a permanent marking material.

3.5 Workmanship. The workmanship shall meet all requirements of this specification.

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 (examinations and tests) 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 this specification where such inspections are deemed necessary to ensure supplies and services conform to prescribed requirements.

4.1.1 Responsibility for compliance. All items shall 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 or ensuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling inspection, as part of the manufacturing operations, is an acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to accept defective material.

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4.2 Classification of inspection. The inspection requirements specified herein are classified as follows:

- (a) First article inspection (not applicable).
- (b) Quality conformance inspection (see 4.6).

4.3 Sampling.

4.3.1 Lot. For the purposes of sampling, examinations and tests, a lot shall consist of not more than one class of material of the same form and dimensions, produced in one plant under essentially the same conditions, not exceeding 2500 pounds, and offered for delivery at one time.

4.2.2 Sampling for examination. Random samples shall be taken from each lot in accordance with the sampling plan given in table III for the examination specified in 4.4. A unit area of material is defined as one square foot, regardless of thickness.

TABLE III. Sampling for examination.

Lot size	Sample size		Accept	Reject 1 2 3
	Major defects	Total defects (major plus minor)		
1 to 15	all	5	0	1
16 to 25	15	10	0	1
26 to 90	25	15	0	1
91 to 150	35	25	0	1
151 to 280	40	30	0	1
281 to 500	50	40	0	1
501 to 1200	65	55	0	1
1201 and over	80	70	0	1

- 1 All defective items shall be replaced with acceptable items prior to lot acceptance.
- 2 Inspect sample size until reject criteria is reached. If reject criteria is reached, the entire lot shall be rejected.
- 3 Reject lots may be screened and resubmitted for inspection and test.

4.3.2.1 Defects defined. Major defect and Minor defect as used in table III are defined as follows: A major defect is a defect that is likely to result in failure, or to reduce materially the usability of the unit of product for its intended purpose. A minor defect is a defect that is not likely to reduce materially the usability of the unit of product for its intended purpose, or is a departure from established standards having little bearing on the effective use or operation of the unit.

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4.3.3 Sampling for tests. Representative samples shall be taken at random from each lot that passes the requirements of 4.4 in sufficient quantity to conduct the production check tests or the quality conformance tests specified in 4.5 and 4.6, as applicable. If the items are of such size or shape that test specimens cannot be prepared from them a substitute sample shall be provided in the form of a piece or pieces of rubber having dimensions appropriate to the tests required. The substitute sample shall be certified to be of the same material and equivalent cure as that used in the lot of finished material offered for delivery.

4.4 Examination. Each of the samples taken in accordance with 4.3.2 shall be subjected to surface examination for workmanship, dimensions and tolerances. MIL-STD-289, MIL-STD-298, and MIL-STD-407 shall be used to determine and evaluate visual defects.

4.4.1 Rejection. If the number of defects exceeds the applicable acceptance number of table III, this shall be cause for rejection of the entire lot represented by the sample.

4.5 Production check tests. Production check tests shall be conducted on samples from (or representing) the first lot of material and from every tenth lot thereafter. All the tests specified in 4.8 shall be conducted.

4.6 Quality conformance tests. Quality conformance tests shall be conducted on samples from (or representing) all lots on which production check tests are not performed. The tests specified in 4.8.1, 4.8.2, 4.8.3 and 4.8.5.3 shall be conducted.

4.7 Action in case of nonconformance. If any of the samples in the production check tests or lot acceptance tests is found not to be in conformance with the requirements of this specification, this shall be cause for rejection of the lot. Furthermore, production check tests shall be performed on each succeeding lot of the contract or purchase order. This additional testing shall be discontinued, except as specified in 4.5, after four successive lots have passed the production check tests.

4.8 Methods of tests. Unless otherwise indicated in the test method, tests shall not be conducted on the test specimens prior to a conditioning period of 4 hours at room temperature 27 ± 5 C (80 ± 9 F). Sample preparation may be undertaken without regard to this time interval.

4.8.1 Tensile properties. Tensile properties shall be determined by ASTM D412 and method 4111 of FED-STD-601. Die III specimens, 0.0800 plus or minus 0.010 inch thick, shall be used for all determinations of tensile properties.

4.8.2 Hardness. The hardness shall be determined in accordance with method 3021 of FED-STD-601. The instantaneous reading shall be taken using a Shore A durometer.

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4.8.3 Specific gravity. The specific gravity shall be determined by the hydrostatic method 14011 of FED-STD-601.

4.8.4 Sealing pressure. The sealing pressure shall be determined in accordance with method 3211 of FED-STD-601. The aging conditions shall be as specified in 4.8.5.

4.8.5 Oven aging. Method 7221 of FED-STD-601 shall be used for oven aging. The aging conditions shall be 46 plus or minus 1/4 hours at 90° plus or minus 1°C. (194° ± 1.8°F.).

4.8.5.1 Tensile properties after oven aging. The tensile properties after oven aging shall be determined by the procedure in 4.8.1.

4.8.5.2 Hardness after oven aging. The hardness after oven aging shall be determined by the procedure in 4.8.2.

4.8.5.3 Compression set after oven aging. Hot compression set after oven aging shall be determined in accordance with method 3311 of FED-STD-601 except that specimens shall be clamped to 40 percent deflection during the oven aging and the time and temperature of aging shall be as specified in 4.8.5.

4.8.5.4 Sealing pressure after oven aging. Sealing pressure shall be determined as specified in 4.8.4 after oven aging the specimens.

4.8.6 Tensile properties after light aging. Specimens shall be light-aged in accordance with method 7311 of FED-STD-601, except the specimens shall be 0.080 plus or minus 0.010 inch thick and the exposure time shall be 100 plus or minus 1/2 hours. After light aging, the tensile properties shall be determined as specified in 4.8.1.

4.8.7 Flexibility. The flexibility test shall be in accordance with method 5211 of FED-STD-601, except that the specimens shall be 1/4 inch thick by 1 inch wide and the temperature shall be minus 29 plus or minus 2°C (-20 ± 3.6°F).

4.8.8 Volume change in distilled water. The volume change after immersion in distilled water shall be determined by method 6211 of FED-STD-601, except that the immersion time shall be 24 plus or minus 1/4 hours.

4.8.9 Extraction in distilled water. The percent extraction shall be determined by method 6621 of FED-STD-601.

4.8.10 Delamination test. The delamination test shall be conducted in accordance with method 6311 of FED-STD-601.

4.8.11 Volume change after immersion in oil. The volume change of class I material shall be determined by method 6211 of FED-STD-601 after immersion in medium No. 1 oil of method 6001 of FED-STD-601 for 70 plus or minus 1/2 hours at 100 plus or minus 1°C (212 ± 2°F).

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4.8.12 Volume change after immersion in medium No. 6 fluid. The volume change of Class III material shall be determined by method 6211 of FED-STD-601 after immersion in medium No. 6 fluid of method 6001 of FED-STD-601 for 168 plus or minus 2 hours at 24 plus or minus 5°C (75 ± 9°F).

4.9 Inspection of packaging. Inspection of preservation, packing and marking for shipment, stowage, and storage shall be in accordance with the requirements of section 5 and the documents specified therein.

5. PACKAGING

(The packaging requirements specified herein apply only for direct Government acquisition.)

5.1 General.5.1.1 Navy fire-retardant requirements.

- (a) Treated lumber and plywood. When specified (see 6.2), all lumber and plywood including laminated veneer material used in shipping container and pallet construction, members, blocking, bracing, and reinforcing shall be fire-retardant treated material conforming to MIL-L-19140 as follows:

Levels A and B - Type II - Weather resistant.
Category 1 - General use.

Level C - Type I - Non-weather resistant
Category 1 - General use.

- (b) Fiberboard. Unless otherwise specified (see 6.2), fiberboard used in the construction of class-domestic, nonweather resistant fiberboard and cleated fiberboard boxes including interior packing forms shall meet the flamespread index and the specific optic density requirements of PPP-F-320 and amendment thereto.
- (c) Cushioning and wrapping materials. The use of excelsior, newspaper, shredded paper (all types), and similar hygroscopic or nonneutral materials and all types of loose fill materials for packaging applications such as cushioning, fill, stuffing, and dunnage is prohibited. Materials selected for cushioning and wrapping shall have properties (characteristics) for resistance to fire (see 6.3). Cushioning or wrapping materials, as applicable, shall be provided to prevent item and package damage and to prevent free movement of the container contents.

5.1.2 Asbestos.

5.1.2.1 Dusting material. Dusting material such as talc, talcum and powdered soapstone shall be asbestos free.

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

5.2.1 Level A. The rubber gasket material in the form specified (see 3.2.1) and of one class, shall be dusted (see 5.1.2) and unit protected in accordance with MIL-P-116, method III and as follows:

- (a) Sheets. Sheets shall be interleaved with either a kraft paper or plastic film, rolled and securely tied, taped or nonmetallic banded to prevent unrolling. Rolls shall be individually wrapped with not less than two thicknesses of 60-pound minimum basis weight kraft paper and secured with minimum 2-inch wide pressure sensitive or gummed tape.
- (b) Strips. Strips, in lengths specified (see 3.2.2), shall be interleaved with either a kraft paper or plastic film, coiled and securely tied or taped to prevent uncoiling. Coils shall be wrapped in kraft paper or plastic film and individually unit packed in a water resistant folding, set-up, or metal edged paperboard or fiberboard box in accordance with the unit container requirements in table I of MIL-STD-2073-1, Appendix F, at the contractor's option. Box closure shall be in accordance with the applicable box specification.
- (c) Cut, molded and extruded shapes. Shapes shall be unit packed in containers as specified for "strips" above.

5.2.2 Level C. Gasket material in the form specified shall be preserved as specified under level A except that the unit containers specified in 5.2.1 (b) shall be as follows:

- (a) The paperboard containers shall be of the domestic or nonweather resistant type, class or variety as applicable, and,
- (b) The fiberboard box shall be of the class-domestic/fire-retardant (see 5.1.1 (b)) with the box closure in accordance with method I using pressure sensitive adhesive tape.

5.2.3 Commercial. Commercial packaging (cleaning, preservation (see 5.1.2), cushioning, and unit pack) requirements shall be in accordance with ASTM D 3951.

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

5.3.1 General requirements for levels A, B and C. Containers selected (see 5.3.2), shall be of minimum weight and cube consistent with the protection required, of uniform size, and contain identical quantities of identical gasket material.

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5.3.2 Levels A, B and C containers. Gasket material preserved as specified (see 5.2), shall be packed in exterior shipping containers for the level of packing specified (see 5.3), in accordance with table VII of MIL-STD-2073-1, Appendix C, and herein. Unless otherwise specified (see 6.2), container selection shall be at the contractor's option.

5.3.2.1 Caseliners, closure and gross weight.

5.3.2.1.1 Caseliners. Unless otherwise specified (see 6.2), level A shipping containers containing gasket material preserved level C or commercial shall be provided with waterproof caseliners in accordance with MIL-STD-2073-1.

5.3.2.1.2 Closure. Container closure, reinforcing, or banding shall be in accordance with the applicable container specification or appendix thereto except that weather-resistant fiberboard boxes shall be closed in accordance with method V and reinforced with non-metallic or tape banding and domestic or fire retardant fiberboard boxes shall be closed in accordance with method I using pressure sensitive tape.

5.3.2.1.3 Weight. Wood, plywood, and cleated type containers exceeding 200 pounds gross weight shall be modified by the addition of skids in accordance with MIL-STD-2073-1 and the applicable container specification or appendix thereto.

5.3.3 Commercial. Gasket material preserved as specified (see 5.2) shall be packed for shipment in accordance with ASTM D 3951 and herein.

5.3.3.1 Container modification. Shipping containers exceeding 200 pounds gross weight shall have a minimum of two, 3-inch by 4-inch nominal wood skids laid flat, or a skid or sill type base which will support the material and facilitate handling by mechanical handling equipment during shipment, stowage and storage.

5.4 Marking.

5.4.1 Levels A, B, C and commercial. In addition to any special marking required (see 6.2), interior (unit) packs and shipping containers shall be marked including bar coding and material cure date (quarter and year) for shipment, stowage, and storage in accordance with MIL-STD-2073-1, Appendix F.

6. NOTES

(This section contains information of a general or explanatory nature that may be helpful, but is not mandatory.)

6.1 Intended use.

6.2 Acquisition requirements. Acquisition documents must specify the following:

- (a) Title, number and date of this specification.
- (b) Class required (see 1.2).

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- (c) Issue of DODISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.1.1 and 2.2).
- (d) Form of material required (see 3.2).
- (e) Dimensions and tolerances required (see 3.2).
- (f) Shape of gaskets required (see 3.2.3).
- (g) When fire-retardant packaging materials are not required (see 5.1.1 (a) and (b)) as applicable.
- (h) Level of packaging and level of packing required (see 5.2 and 5.3).
- (i) Caseliners, if not required (see 5.3.2.1.1).
- (j) Special marking required (see 5.4).

6.3 Cushioning and wrapping materials (see 5.1.1 (c)). Materials having properties for resistance to fire and acceptable for use within unit packs and shipping containers for Navy acquisitions are:

<u>Material</u>	<u>Specification</u>
Paper, Kraft, Treated (Fire Resistant)	A-A-1894
Paper, Kraft, Wrapping	UU-P-268, Type II, Grade C or D
Fiberboard	PPP-F-320, Class- Domestic/Fire Retardant
Plastic Film, Flexible, Cellular	PPP-C-795, Class 3 - Fire Retardant
Polystyrene Expanded, Resilient	PPP-C-850, Grade SE
Plastic, Open Cell, Cushioning	PPP-C-1842, Type I, Style B
Bound Fiber	PPP-C-1120, Type III or IV, Class C
Rubber, Latex Foam	MIL-R-5001, Grade A
Rubber, Cellular	MIL-R-6130, Grade A
Fibrous Glass	MIL-C-17435
Polystyrene Foam	MIL-P-19644, Type II
Rubber, Cellular, Synthetic	MIL-R-20092, Class 5
Polyurethane Foam	MIL-P-26514
Polyurethane Foam, Flexible, Open Cell	MIL-F-81334
Foam-In-Place Packaging Materials:	MIL-F-83671
General Specification For	
Foam, Combustion, Retardant, for Cushioning	MIL-F-87090(SA)
Supply Items Aboard Navy Ships	

6.4 Subject term (key word) listing.

- Molded shapes
- Sheets
- Strips
- Vulcanized synthetic

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6.5 Changes from previous issue. Marginal notations are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.

Custodians:

Army - MR
Navy - SH

Preparing activity:

Navy - SH
(Project 5330-0828)

Review activities:

Navy - MC
DLA - IS

User activities:

Army - GL
Navy - AS, OS
Air Force - 69

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

INSTRUCTIONS

1. The preparing activity must complete blocks 1, 2, 3, and 8. In block 1, both the document number and revision letter should be given.
2. The submitter of this form must complete blocks 4, 5, 6, and 7.
3. The preparing activity must provide a reply within 30 days from receipt of the form.

NOTE: This form may not be used to request copies of documents, nor to request waivers, or clarification of 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.

I RECOMMEND A CHANGE:	1. DOCUMENT NUMBER MIL-G-15624F	2. DOCUMENT DATE (YYMMDD) 94/05-25
3. DOCUMENT TITLE GASKET MATERIAL, RUBBER, 50 DUROMETER HARDNESS (MAXIMUM)		
4. NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)		
5. REASON FOR RECOMMENDATION		
6. SUBMITTER		
a. NAME (Last, First, Middle Initial)	b. ORGANIZATION	
c. ADDRESS (include Zip Code)	d. TELEPHONE (include Area Code) (1) Commercial (2) AUTOVON (if applicable)	7. DATE SUBMITTED (YYMMDD)
8. PREPARING ACTIVITY TECHNICAL POINT OF CONTACT (TOPC):		
NAME Mr. Richard Dempsey SEA 03M3 PLEASE SEND ALL CORRESPONDENCE TO:	b. TELEPHONE (include Area Code) (1) Commercial 703 602-0147	(2) AUTOVON 8-332-0147
c. ADDRESS (include Zip Code) Commander, Naval Sea Systems Command SEA 03R42, 2531 Jefferson Davis Hwy., Arlington, VA 22242-5160	IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT: Defense Quality and Standardization Office 5203 Leesburg Pike, Suite 1403, Falls Church, VA 22041-3466 Telephone (703) 756-2340 AUTOVON 289-2340	