

U.S. DEPARTMENT OF AGRICULTURE
FOREST SERVICE

SPECIFICATION

BAG, FIRE SHELTER, POLYVINYL

1. SCOPE

1.1 Scope. This specification covers the requirements for a quick-opening polyvinyl bag for the fire shelter specified by 5100-320.

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those in effect on the date of the invitation for bids or request for proposals (see 6.2).

SPECIFICATIONS

USDA FOREST SERVICE

5100-320 - Shelter, Fire

STANDARDS

FEDERAL

FED-STD-376 - Preferred Metric Units for Use By the Federal Government

(Unless otherwise indicated, copies of federal and military specifications, and standards are available from the Standardization Documents Order Desk, Building 4D, 700 Robbins Ave., Philadelphia, PA 19111-5094. Copies of Forest Service specification 5100-87 are available from USDA Forest Service, Missoula Technology and Development Center, Building 1, Fort Missoula, Missoula, MT 59804-7294.)

Beneficial comments (recommendations, additions, deletions) and any pertinent data that may be used in improving this document should be addressed to: USDA Forest Service, Missoula Technology and Development Center, Building 1, Fort Missoula, Missoula, MT 59804-7294 by using the Specification Comment Sheet at the end of this document or by letter.

5100-604A

2.1.2 Other Government documents, drawings, and publications. The following other Government documents, drawings, and publications form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents shall be those in effect on the date of the invitation for bids or request for proposals (see 6.2).

DRAWINGS

USDA FOREST SERVICE

MTDC-991 - Polyvinyl Bag with Tear Strip for Fire Shelter

(Copies are available from the USDA Forest Service, Missoula Technology and Development Center, Building 1, Fort Missoula, Missoula, MT 59804-7294.)

2.2 Non-Government publications. The following documents form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of these documents are those in effect on the date of the invitation for bids or request for proposals (see 6.2).

AMERICAN SOCIETY FOR QUALITY CONTROL (ASQC)

Z1.4 - Sampling Procedures and Tables for Inspection by Attributes

(Copies are available from the American Society for Quality Control, 611 East Wisconsin Avenue, Milwaukee, WI 53202.)

(Non-Government standards and other publications normally are available from the organizations that prepare and 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 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 First article. The polyvinyl fire shelter bag will be subjected to first article inspection (see 6.3) in accordance with 4.3.

3.2 Materials and components. Materials and components shall be as specified herein and in the applicable drawing, MTDC-991.

3.3.1 Material.

3.3.1.1 Polyvinyl film. The film used to fabricate the bag shall be Achilles USA stock number KFC040-1.5S or KBC040-1.5S, 10 mil (± 1 mil) thickness. The film shall be clear.

3.3.1.2 Pull tab strip. The pull tab strip shall be fabricated from film meeting the requirements of L-P-375C, Type I, Class II, color Red, 25 mil thick minimum in a single layer.

5100-604A

3.4 Patterns. Standard patterns (MTDC-991 sheet 3) will be furnished by the Government. The standard patterns shall not be altered in any way and shall be used only as a guide for cutting the contractor's working patterns. The contractor's working patterns shall be identical to the standard patterns.

3.5 Construction.

3.5.1 Polyvinyl bag. The polyvinyl bag shall be constructed from a single piece of film with a tear strip embossed into the film. The polyvinyl bag shall be oriented so the film machine direction is parallel to the length of the bag (see MTDC-991 sheet 2). The tear strip shall be centered in both length and width directions, and located as shown on MTDC-991 sheets 2 and 3. The tear strip shall be scored to the depth necessary to assure uniform tearing of the strip when the pull tab strip (sealed to the tear strip) is pulled, but will not allow the tear strip to prematurely self-initiate.

3.5.2 Sealing. The pull tab strip shall be heat sealed to the polyvinyl bag within the score lines of the tear strip as shown on MTDC-991. The film shall be folded in half and both edges sealed together along the entire length (see MTDC-991). The folded over ends shall be within 1/4 inch of each other when sealing is completed. In all heat seals, RF dielectric heat sealing is acceptable. In all heat seals, care shall be taken to ensure sufficient heat is used for a complete seal, and to prevent the use of excessive heat causing the area of the sealing to become brittle. The sealing of the pull tab strip to the polyvinyl bag shall not touch or cross the score lines of the tear strip.

3.5.4 Vent holes. Each polyvinyl bag shall have a vent hole near each pull tab as shown in MTDC-991, each vent hole shall be 1/8 (+1/16 -1/32) inch in diameter. There shall be no evidence of cracks forming around the edges of the holes.

3.6 Opening. When the pull tab strips are pulled to open the polyvinyl bag, each end of the tear strip shall separate its entire length to the bottom of the bag. The bag shall not tear in any other area except along the tear strip score lines and the pull tab strip shall not separate from the tear strip when tested in accordance with 4.4.

3.7 Marking. The words "PULL RING TO OPEN" shall be printed or silk screened or applied by label along the pull tab strip as shown on MTDC-991 sheet 3 and shall be black. As an alternative the wording may be inverted on one end. The words shall be in capital letters 1/4 (+1/4 -1/16) inch in height.

3.8 Deviations and waivers. Deviations and waivers to the materials or construction specified herein shall not be allowed unless authorized in writing by the administrative contracting officer.

3.9 Workmanship. The polyvinyl bag shall conform to the quality of product established by this specification. The occurrence of defects shall not exceed the applicable acceptable quality levels.

3.10 Metric products. Products manufactured to metric dimensions will be considered on an equal basis with those manufactured using inch/pound units, provided they fall within the tolerances specified using conversion tables contained in the latest revision of FED-STD-376, and all other requirements of this specification are met.

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/her 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 of ensuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling inspection, as part of 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.

4.1.2 Responsibility for dimensional requirements. Unless otherwise specified in the contract or purchase order, the contractor is responsible for ensuring that all specified dimensions have been met. When dimensions cannot be examined on the end item, inspection shall be made at any point or at all points in the manufacturing process necessary to ensure compliance with all dimensional requirements.

4.1.3 Certification of compliance. Unless otherwise specified, certificates of compliance supplied by the manufacturer of the components, listing the specified test method and test results obtained, may be furnished in lieu of actual lot by lot testing performed by the contractor (see 4.3.2). When certificates of compliance are submitted, the Government reserves the right to check test such items to determine the validity of the certification. When certificates of conformance are submitted as a part of a first article inspection, copies of the test reports shall be submitted.

4.2 Sampling for inspections and tests. Sampling for inspections and tests shall be made in accordance with ANSI/ASQC Z1.4. The inspection level and acceptable quality level (AQL) shall be as specified. All polyvinyl bags manufactured at one time shall be considered a lot for purposes of acceptance inspection and test. A sample unit shall be one complete polyvinyl bag.

4.3 Quality conformance inspection. Each end item lot shall be sampled and inspected as specified in 4.3.4.1 and 4.3.4.2. First articles submitted in accordance with 3.1 shall be inspected as specified in 4.3.4.1 and 4.3.4.2. The presence of any defect or failure to pass any test shall be cause for rejection of the first article.

4.3.1 Component and material inspection. In accordance with 4.1, components and materials shall be inspected in accordance with all the requirements of referenced documents, drawings, and standards unless otherwise excluded, amended, modified, or qualified in this specification or applicable purchase document.

5100-604A

4.3.2 Certification. As part of first article presentations and lot inspections, it shall be acceptable for the contractor to provide certificates of compliance for all materials and components in lieu of actual lot by lot testing. In addition, when the contractor changes component or material suppliers, a new certification based on actual test results shall be required. All certificates shall include as a minimum:

- Specification, type, class, form, etc. as applicable
- Quantity purchased
- Purchase source, address, and telephone number
- Purchase date
- Lot number traceable to materials used in production
- Contract number

4.3.3 In-process inspection. Inspection shall be made at any point or during any phase of the manufacturing process to determine whether cut lengths, cut parts, markings for location of components, and location of assembled component parts are in accordance with specified requirements. Whenever nonconformance is noted, corrections shall be made to the parts affected and lot in process. Components that cannot be corrected shall be removed from production.

4.3.4 End item examination.

4.3.4.1 End item visual examination. The end items shall be examined for the defects list in table I on a lot by lot basis. The lot size shall be expressed in units of complete polyvinyl bags. The inspection level shall be S-3, and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 4.0 for major defects and 15.0 for combined major and minor defects. Unless otherwise specified, defects shall be scored on an individual basis, i.e., each seam, each stitching end, each dimension, etc.

TABLE I. End item visual defects

| <u>Examine</u> | <u>Defect</u> | <u>Classification</u> | |
|----------------|--|-----------------------|--------------|
| | | <u>Major</u> | <u>Minor</u> |
| Polyvinyl bag | Not material specified | (see 4.3.4.1.1) | |
| | More than one break of 1/8 inch or less in length per bag | | X |
| | Break or tear more than 1/8 inch in length | X | |
| | Evidence of cracking around vent holes | | X |
| | Evidence of brittle plastic around tear strip, vent holes, outer edges, or top closing heat seal | X | |
| | Note: The polyvinyl bags shall be inspected for any signs of tears or cracks. Suspected areas should be flexed back and forth several times. Tears and cracks that increase in length shall be considered evidence of brittle plastic. | | |
| Pull tab strip | Not material specified | (see 4.3.4.1.1) | |
| | Not fully welded entire length of pull strip. | X | |
| | Any evidence of cracking | X | |
| Marking | Omitted, incorrect, illegible, misplaced, or size of characters not as specified | | X |
| Cleanness | Any noticeable grease or oil stains, dirt, or other visible impurities | | X |

5100-604A

4.3.4.1.1 Material not as specified. Any evidence of non-conformance of material discovered before or after acceptance of first article shall fail the subject lot, and shall require re-submission of first article samples.

4.3.4.2 End item dimensional examination. End items shall be examined for the defects listed in table II on a lot by lot basis. Only those dimensions that can be evaluated without damaging or disassembling the end items shall be examined. The inspection level shall be S-3. An AQL, expressed in terms of defects per hundred units, shall be 6.5 major defects and 15.0 for combined major and minor defects.

TABLE II. End item dimensional defects

| Examine | Defect | Classification | |
|---|---|----------------|-------|
| | | Major | Minor |
| Dimensions (overall) | Smaller than nominal dimensions less applicable minus tolerance indicated on drawings, but not smaller than nominal dimensions less twice the applicable minus tolerances | | X |
| | Smaller than nominal dimensions less twice the applicable minus tolerance | X | |
| | Larger than nominal dimensions and applicable plus tolerance | | X |
| Component and location dimensions (not otherwise classified herein) | Not within specified tolerance | | X |
| Stitch margin and gauge | Not within specified tolerance | | X |

4.4 Polyvinyl bag opening test.

4.4.1 First article tests. As a part of first article testing, 1000 bags shall be fabricated and pull tested (2000 pull tests). Failure of any pull test shall fail the first article. The test bags shall be in the form they would be just prior to insertion of the fire shelter, i.e. with the film scored, pull tab strip sealed on and edges sealed together.

4.4.2 Opening test. The opening test shall require pulling down on first one end of the red pull tab strip and then the other to completely release the tear strip from the polyvinyl bag. The test shall be conducted in the following manner:

The selected pull tab strip shall be grasped and with the open end of the polyvinyl bag secured, the pull tab strip pulled towards folded end of the bag, separating the tear strip from the polyvinyl bag along the score line to the folded end of the bag. The other end of the pull tab strip shall then be pulled in a similar manner until the tear strip completely separates from the bag. When a pull tab strip is pulled, if the tear strip does not open along the scored lines, or if the tear strip separates from the pull tab strip, or the bag tears in any place other than the embossed lines, then a failure has occurred. Since there are two ends to the pull tab strip per bag, there can be up to two opening failures per bag.

5100-604A

5. PREPARATION FOR DELIVERY

5.1 Preparation for delivery. As this is a component to the Fire Shelter (5100-320), there are no specific packaging or marking requirements beyond what is specified by paragraph 3.7.

6. NOTES

6.1 Intended use. The polyvinyl bag is intended to be used to encase the fire shelter in a protective quick-opening bag that can be opened wearing heavy-duty gloves.

6.2 Ordering data. Documents utilizing this material should specify the following:

(a) Title, number and date of this specification.

6.3 First article. First articles shall be inspected and approved under the appropriate provisions of Federal Acquisition Regulation 52.209. The first article shall consist of 1000 fabricated polyvinyl fire shelter bags completely assembled without fire shelter or top sealing. In addition to sample inspection for dimensional compliance, all sample bags will be pull tested in accordance with 4.4.2.

6.4 Notice. When Government drawings, specifications or other data are used for any other purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility nor any obligation whatsoever.

6.5 Preparing Activity. USDA Forest Service, Missoula Technology and Development Center (MTDC), Building 1, Fort Missoula, Missoula, Montana 59804-7294.

Standardization Document Improvement Proposal

This form is provided to solicit beneficial comments that may improve this document and enhance its use. Contractors, government activities, manufacturers, vendors, and users are invited to submit comments to:

USDA Forest Service
Missoula Technology and Development Center
Bldg. 1, Fort Missoula
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Attach any additional pertinent information that may be of use in improving this document to this form and mail in an envelope. A response will be provided when the submitter includes their name and address.

NOTE: This form shall not be used to submit requests for 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 document, or to amend contractual requirements.

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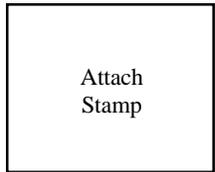
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