

GENERAL HEADQUARTERS
ARMED FORCES OF THE PHILIPPINES
OFFICE OF THE QUARTERMASTER GENERAL
Camp General Emilio Aguinaldo
Quezon City

AFP SPECIFICATION

QM SPEC NR E-24MC
14 October 2007
Supersedes
QM SPEC NR E-24MC-1 dtd
16 February 1994

MAT, CANVAS, POLYESTER, WHITE/OD

1. GENERAL

1.1 Scope – This specification covers one (1) type of Mat, Canvas, Polyester, White/OD for use of military personnel of the Armed Forces of the Philippines.

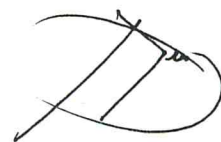
1.2 Grade – The finished mat, canvas shall be of the quality and grade of product prescribed by this specification.

1.3 Size – The mat, canvas shall be of one (1) size only, the dimensions of which are shown in the attached illustration.

2. MATERIALS

2.1 Basic Material – The basic material shall be 100% polyester canvas, white/olive drab (OD) in color and shall conform to the following requirements:

Yarn Count	
Warp -----	500 (min)
Filling -----	500 (min)
Thread Count/2.54cm	
Warp -----	34 doubles (min)
Filling -----	26 doubles (min)
Weight, gm/m ² -----	360 (max)
Thickness, mm -----	0.57 (min)
Breaking Strength (kg) (Grab Method)	
Warp -----	165 (min)
Filling -----	130 (min)
Type of Weave -----	Plain



2.2 Tape Cord – The tape cord for tying the mat to the bed shall be made of the same material specified in para 2.1. It shall have a finished length of 50.8 cm and a finished width of 1.2 (+/- 0.2) cm.

2.3 Thread – The thread to be used for sewing and all stitchings shall be nylon or polyester, 2 ply (min), white/OD with a minimum breaking strength of 2 kgs.

2.4 Tape Cord Support – The tape cord support shall be of two types; namely, Type I which is a quarter of a 12.70 cm diameter circle, and Type II which is half of a 10.16 cm diameter circle. Type I cord support is to be attached to the corners of the mat while Type II tape cord support shall be attached along the longer sides of the mat at points indicated in the attached illustration. The tape cord support shall be of the same material and color shade as the basic material. The design shall be substantially the same as shown in the attached illustration.

2.5 First Article – The contractor shall submit two (2) samples of Mat, Canvas, Polyester, White/OD to the Office of The Quartermaster General, AFP or equivalent office in the Major Services for first article inspection and approval as against the bid sample prior to mass production.

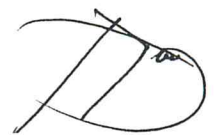
3. CONSTRUCTION

3.1 Cutting – The mat canvas shall be cut to conform with the design shown in the attached illustration. It shall be cut from one piece of material, providing allowances for hemming and stitchings, as specified.

3.2 Stitches – All sewing and stitching shall be running stitches ranging from 3 to 4 stitches to a centimeter.

3.3 Make Mat – The mat shall be hemmed 2.54 cm along its length and 3.81 cm along its width with double rows of stitches of not more than 1.90 cm apart along its length nor more than 3.22 cm apart along its width. The stitchings shall not be less than 0.16 cm nor more than 0.32 cm from the inner and outer edges of the hems with its raw edges turned in. Hemming shall be done by folding first the longer side and then folding the shorter side over the longer side folding. Stitches shall be in accordance with para 3.2 above and the attached illustration.

3.4 Make and Sew Tape Cord – The tape cord shall be made of one (1) piece material and shall be cut to conform with the finished dimensions in para 2.2 allowing 0.68 cm for turning in raw edges. The cord shall be cut along the warp. With the raw edges turned in facing each other, run stitch 0.16 cm from the edge. The end of the cord shall be closed by extending the running stitches around the ends. All tape cords shall be one piece and attached to the mat by double row of stitching of the hems at points indicated in the illustration. The corner tape cords shall be attached at right angle with the edges of the mat 3.81 cm from the mat corners. The six (6) cords along the long sides of the mat shall be attached to the mat, as illustrated.



Attachment shall be made first by stitching the cord with the two (2) rows of stitches on the hems of the mat; second, by running stitches along the edges of the tape cord support upon attachment to the body of the mat.

3.5 Make and Sew Tape Cord Support – The tape cord support shall be cut to conform with the finished dimensions in para 2.4 and then run over-edging stitches along its edges to avoid raveling, or provide an allowance of 0.32 cm to 0.68 cm from turning in raw edges and hem-stitch or run-stitch along its edges. The support shall be attached to the body of the mat at the points specified in the attached illustration so that the tape cord shall be symmetrically set with respect to the support for the sake of good appearance. Attachment to the mat shall be by running stitch, 0.16 cm from the edges of the support. Stitches shall be run on all edges or sides of the tape cord support.

4. WORKMANSHIP

4.1 Finish – The mat shall be clean, well pressed, well finished and free from any defect or blemish which may affect its appearance or serviceability. Overall workmanship shall be the best known to the trade. Poor quality of sewing or workmanship shall be sufficient ground for rejection of the finished article.

4.2 Design – The mat shall be of the design essentially the same as shown in the attached illustration.

4.3 Contractor's Label – Each mat, canvas shall have a contractor's label imprinted to the material located at 2.54 cm below the AFP markings on the opposite side (wrong side) of the mat by the use of silk screen method of printing using black indelible ink or waterproof black paint or by dry heat transfer process of equal fastness. The imprint of the marking shall be in boldface block type of lettering and shall withstand ten (10) laundry tests without appreciable loss of color.

4.3.1 Size of Label – The contractor's label shall be imprinted using Arial font, Size 20.

4.3.2 Contents of Label – The contractor's label shall consist of the following:

MAT, CANVAS, POLYESTER
QM SPEC NR E-24MC
(Name of Contractor)
Lot Nr

4.3.3 "AFP" Marking – The "AFP" marking shall be printed on the center of the mat with the use of black indelible ink or black waterproof vinyl paint using Stencil font, Size 400.



5. INSPECTION

5.1 Inspection may be conducted anytime throughout the entire process of manufacture to determine compliance with the requirements of this specification.

5.2 The passing as satisfactory of any detail of construction or quality of materials used shall not relieve the contractor/manufacturer of the responsibility for faulty workmanship or defective material which may be discovered anytime prior to final acceptance.

5.3 Final inspection of the finished brief shall be conducted either at point of production or at point of delivery.

6. QUALITY ASSURANCE PROVISION

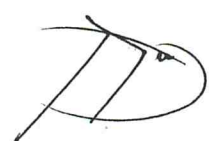
6.1 Bid Samples – Two (2) bid samples of finished mat canvas shall be submitted to the Research and Development Center, AFP to determine extent of compliance with this specification insofar as quality of materials used is concerned. The Office of The Quartermaster General, AFP or equivalent office in the Major Services shall determine the extent of compliance with this specification insofar as workmanship, style and finish are concerned.

6.2 Component and Material Inspection – The first article submitted in accordance with para 2.5 above, components and materials shall be tested in accordance with all the requirements of this specification.

6.3 First Article Inspection – The first article submitted in accordance with para 2.5 above shall be inspected if it is in accordance with the requirements of this specification.

6.4 Responsibility for Inspection – Unless otherwise specified in the contract, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the contractor may use his own or 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 specifications which are deemed necessary to assure that supplies and services conform to prescribed requirements.

6.5 Responsibility for Compliance – All items must meet all the requirements of Sections 2 & 3. 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 assuring that all products or supplies submitted to the government for acceptance comply with all the requirements of the contract.



7. PACKAGING AND PACKING

7.1 Packaging – Each mat shall be properly folded and placed in a transparent (cellophane) bag. The open end of the bag shall be folded and closed with a transparent tape.

7.2 Packing – Two hundred (200) pieces of mats shall be packed in a corrugated carton. The top cover, when closed, shall be sealed with a binding tape and finally secured with nylon straps. The box shall be labeled as follows:

MAT, CANVAS, POLYESTER
Name of Contractor
QTY: 200 pieces

7. MISCELLANEOUS

7.1 The contractor/mannufacturer shall notify the Office of The Quartermaster General, AFP or equivalent office in the Major Services at least seven (7) days before actual production starts so that AFP inspectors can be assigned to oversee the process of manufacture to be followed and to inspect the quality of materials to be used.

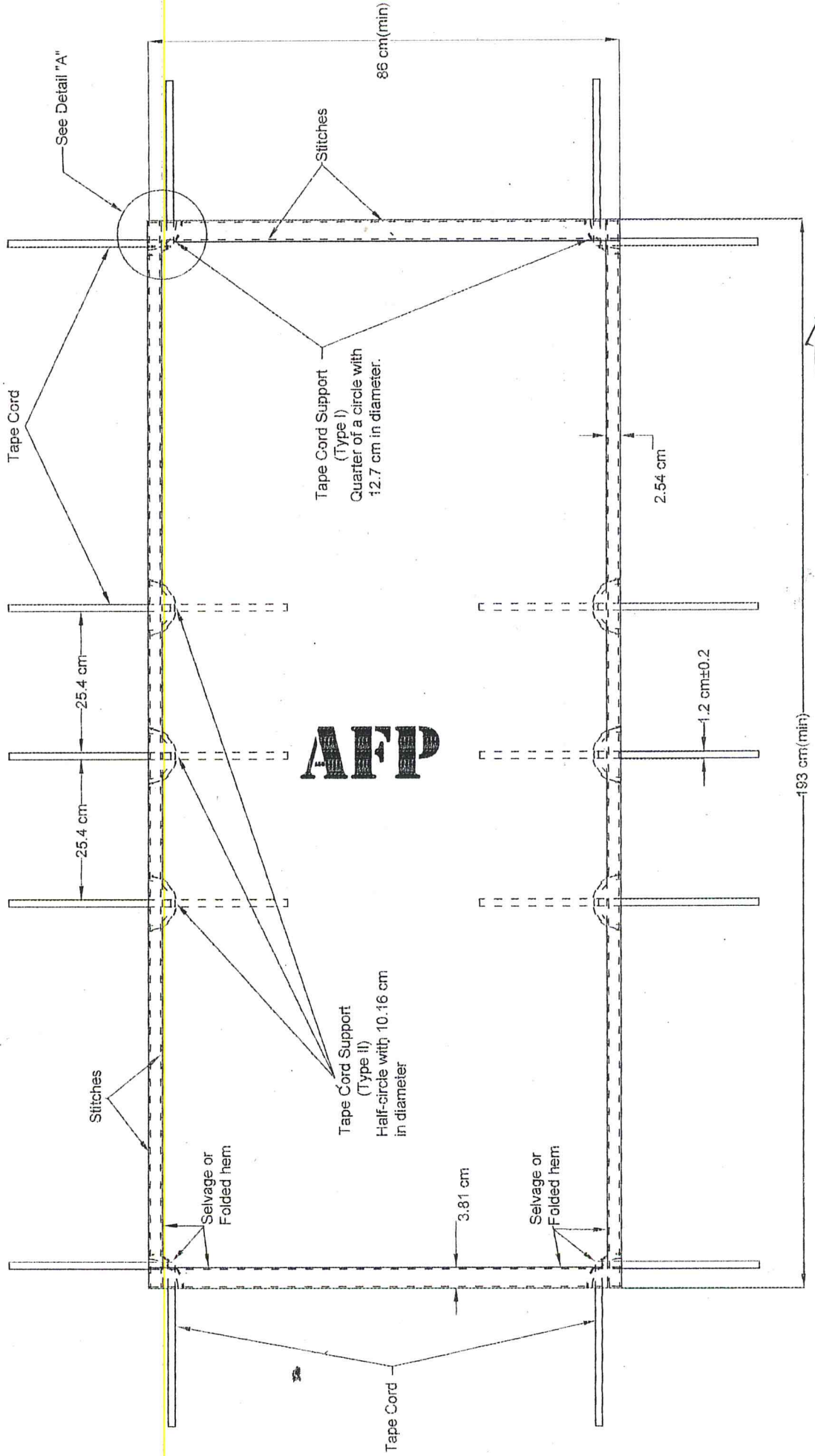
7.2 Any point not covered by this text shall be governed by the attached illustrations which shall be followed in every detail.

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Colonel (PA) GSC
The Quartermaster General, AFP

MAT, CANVAS, POLYESTER, WHITE/OD

QM SPEC NR E-24MC

REF 14 2007



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Colonel PA (GSC)
The Quartermaster General, AFP
NTS

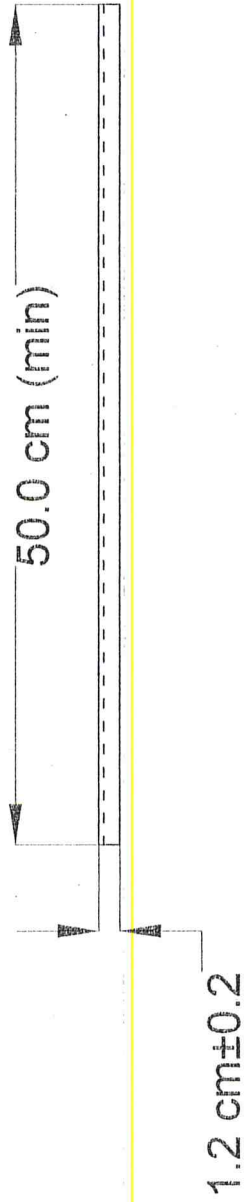
MAT, CANVAS, POLYESTER, WHITE/OD

QM SPEC NR E-24MC

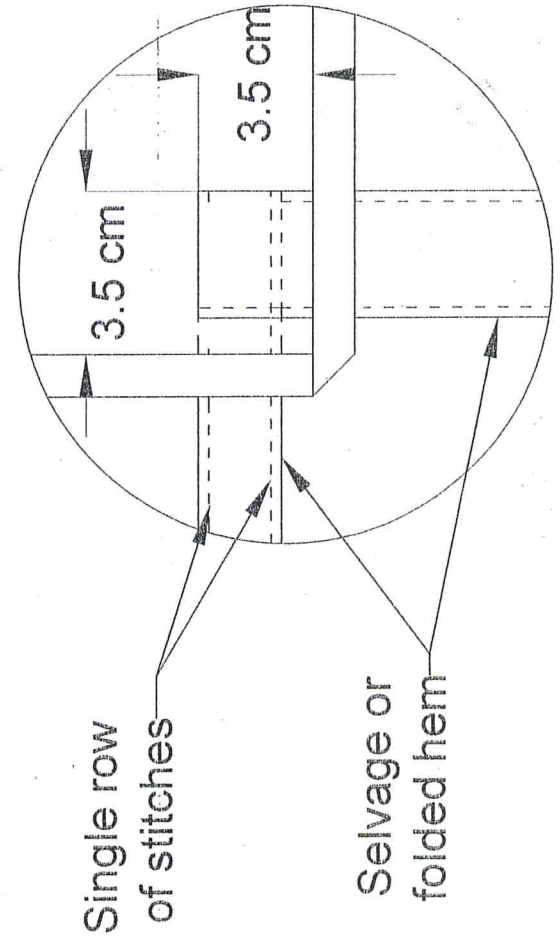
OCT 14 2007

Tape Cord

(Two (2) ply sewed at one side only)



Detail "A"



DETAIL showing
how tape cord is
sewed to mat with
backstitches along
hem-stitches.

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GENERAL HEADQUARTERS
ARMED FORCES OF THE PHILIPPINES
OFFICE OF THE QUARTERMASTER GENERAL
Camp General Emilio Aguinaldo, Quezon City

TEST PARAMETERS
MAT, CANVAS, POLYESTER, WHITE/OD
QM SPEC NR E-24MC

~~APR 22 2008~~

TEST PARAMETERS	QM SPEC NR E-24MC dtd 14 October 2007 Supersedes QM SPEC NR E-24MC-1 dtd 16 Feb 1994	Classification	
		Major	Minor
Dimensions, cm			
Length	193 (minimum)	X	
Width	86 (minimum)	X	
Basic Material	100% Polyester canvas	X	
Color	White/ Olive Drab (OD)	X	
Yarn Size, Denier			
Warp	500 (minimum)		X
Filling	500 (minimum)		X
Thread Count/2.54cm			
Warp	34 doubles (minimum)		X
Filling	26 doubles (minimum)		X
Weight, g/m ²	360 (maximum)		X
Thickness, mm	0.57 (minimum)		X
Breaking Strength, kg			
Warp	165 (minimum)	X	
Filling	130 (minimum)	X	
Type of Weave	Plain		X
Tape Cord	Same as the basic material	X	
Finished Length, cm	50.0 (minimum)		X
Finished Width, cm	1.2 ± 0.2		X
Thread	Nylon or Polyester		X
Color	White/Olive Drab (OD)	X	
No. of ply	2 (minimum)		X
Breaking Strength, kg	2 (minimum)	X	
Tape Cord Support	Same material and color shade as the basic material	X	
Type I	Shall be a quarter of a 12.70 cm diameter circle attached to the corners of the mat	X	
Type II	Shall be half of a 10.16 cm diameter circle attached along the longer sides of the mat	X	
CONSTRUCTION			
Cutting	Cut from one piece of material, providing allowances for hemmings and stitchings	X	
No. of Stitches/cm	3 - 4 stitches		X
Make Mat	Shall be hemmed 2.54cm along its length and 3.81cm along its width with double rows of stitches of not more than 1.90cm apart along its length nor more than 3.22cm apart along its width		X

TEST PARAMETERS	QM SPEC NR E-24MC dtd 14 October 2007 Supersedes QM SPEC NR E-24MC-1 dtd 16 Feb 1994	Classification	
		Major	Minor
	Stitchings shall not be less than 0.16cm nor more than 0.32cm from the inner and outer edges of the hems with its raw edges turned in		X
	Hemmings shall be done by folding first the longer side and then folding the shorter side over the longer side	X	
Make and Sew Tape Cord	Shall be attached to the mat by double row of stitching of the hems	X	
	The corner tape cords shall be attached at right angle with the edges of the mat 3.81cm from the mat corners		X
	The six (6) cords along the long sides of the mat shall be attached as illustrated	X	
Make and Sew Tape Cord Support	The tape cord support shall be sewed with run over-edging stitches along its edges or provided with allowance of 0.32 - 0.68cm from turning in raw edges and hem-stitch or run-stitch along its edges		X
	The support shall be attached to the body of the mat with running stitches, 0.16cm from the edges of the support. Stitches shall be run on all edges or sides of the tape cord support		X
Contractor's Label Location	With contractor's label	X	
	Imprinted to the material located at 2.54cm below the AFP markings on the opposite side (wrong side) of the mat by the use of silk screen method of printing using black indelible ink or waterproof black paint or by dry heat transfer process of equal fastness	X	
Lettering	Shall be boldface block type		X
Contents of Label	MAT, CANVAS, POLYESTER QM SPEC NR E-24MC (Name of Contractor) Lot Nr		X
Type & Size of Label	Arial font, size 20		X
"AFP" Marking	With "AFP" marking	X	
Location	Printed on the center of the mat with the use of black indelible ink or waterproof vinyl paint	X	
Type & Size of Letterings	Stencil font, Size 400		X

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NOTED
DATE APR 22 2008

**HEADQUARTERS
PHILIPPINE ARMY
OFFICE OF THE ARMY QUARTERMASTER
Fort Andres Bonifacio, Metro Manila**

**MAT, CANVAS, POLESTER, WHITE/OD
QM SPEC NR E-24MC dated 14 October 2007**

LIST OF REQUIRED PROTOTYPE SAMPLES FOR TESTING

1. FOR POST QUALIFICATION TEST

PROTOTYPE SAMPLES

RDC -Two (2) pcs

SWATCH MATERIALS

Thread Sewing - 10 m (minimum)

2. FOR ACCEPTANCE TEST

Two (2) pcs of Mat, Canvas, Polyester, OD – Picked at random from delivery

Requirements for this project:

Color - Olive Drab (OD)
Markings - ARMY



**AURELIO T. BADAJOS
Colonel, QMS (GSC) PA
Chief**

HEADQUARTERS
PHILIPPINE ARMY
OFFICE OF THE ARMY QUARTERMASTER
Fort Andres Bonifacio, Metro Manila

MAT, CANVAS, POLESTER, WHITE/OD
QM SPEC NR E-24MC dated 14 October 2007


VISUAL INSPECTION CHECKLIST

PO Nr _____
Supplier _____
Lot Size _____
* Sample Size _____

Date _____

DESCRIPTION OF DEFECTS	CLASIFICATION OF DEFECTS
1. Packing and Packaging	
a. Contents of carton label not as specified	Minor
b. Each Mat, Canvas shall be placed in a transparent cellophane bag.	Minor
c. Two hundred (200) pieces shall be packed in a corrugated carton.	Major
d. The top cover, when closed shall be sealed with a binding tape and secured with nylon straps.	Minor
2. Not olive drab in color	Major
3. The Tape cord and tape cord support shall be of the same basic material.	Major
6. Loose sewing/Untrimmed thread ends	Minor
7. ARMY marking:	
a. Provided with ARMY marking	Major
b. Placed at the center part of the Mat, Canvas	Minor
c. Using waterproof black paint or black indelible ink	Major
7. Contractor's label	
a. Printed below the ARMY markings on the opposite side	Major
b. Using black indelible ink or black waterproof paint	Minor
c. Contents of the label not as specified	Minor
8. Presence of dirt, stains and other defects:	
a. Affecting appearance	Major
b. Does not affect appearance	Minor

*Note: Sample Sizes - is based on Military Standard 105E, Table III-A of General Inspection Level I Code F double sampling plan.


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