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

TEST PARAMETERS

ARMY COMBAT BOOTS, SUEDE, FIELD USE

TEST PARAMETERS	QM SPEC NR IC-21ACBSFU dtd 05 July 2019	Classification of Defects	
		Major	Minor
Leather	Shall be flesh-out/Suede, full grain, upper cowhide leather	X	
Thickness.mm			
Vamp	2.0 (minimum)		X
Outer Counter Pocket	1.8 (minimum)		X
Inside Counter Lining	1.0 (minimum)		X
Outer Eyelets Stay	1.6 (minimum)		X
Inner Eyelets Stay Lining	1.4 (minimum)		X
Color	Olive Drab	X	
Color Quality (Spectrophotometric Method) A & B	2 (maximum)	X	
Water absorption, % (30 minutes)	20 (maximum)	X	
Counter Material	Shall be cut from impregnated material	X	
Thickness, mm	1.8 (minimum)		X
Weight, g/m ²	2,200 (maximum)		X
Tensile Strength, kg/2.54 cm (Strip Method)	95 (minimum)	X	
Breaking Strength, Kg (Grab Method)			
Direction A	260 (minimum)	X	
Direction B	200 (minimum)	X	
Box Toes	Shall be cut from impregnated material	X	
Thickness, mm	1.8 (minimum)		X
Weight, g/m ²	1,800 (maximum)		X
Tensile Strength, kg/2.54 cm (Strip Method)	70 (minimum)	X	
Breaking Strength, Kg (Grab Method)			
Direction A	180 (minimum)	X	
Direction B	165 (minimum)	X	
Quarter & Gusset Material	Nylon	X	
Color	Olive Drab	X	
Thickness, mm	0.40 - 0.80		X
Weight, g/m ²	400 (maximum)		X
Breaking Strength, Kg (Grab Method)			
Warp	250 (minimum)	X	
Filling	210 (minimum)	X	

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TEST PARAMETERS	QM SPEC NR IC-21ACBSFU dtd 05 July 2019	Classification of Defects	
		Major	Minor
Thread Count/ 2.54 cm			
Warp	30 (minimum)		X
Filling	24 (minimum)		X
Yarn Size, Denier			
Warp	1,000 (minimum)		X
Filling	1,000 (minimum)		X
Type of Weave	Plain		X
Color Quality (Spectrophotometer Method)	2.0 (maximum)	X	
Vamp Lining	Cut from cotton canvass or polyester canvas	X	
Thickness, mm	0.40 - 1.10		X
Weight, g/m ²	600 (maximum)		X
Breaking Strength, Kg (Grab Method)			
Warp	115 (minimum)	X	
Filling	105 (minimum)	X	
Thread Count/ 2.54 cm			
Warp	35 (minimum)		X
Filling	30 (minimum)		X
Yarn Size, Denier			
Warp	600 (minimum)		X
Filling	600 (minimum)		X
Type of Weave	Twill		X
Color	Black		X
Eyelet Stay Reinforcement	cut from non-woven polyester/nylon fiber material	X	
Thickness, mm	0.40 - 0.8		X
Weight, g/m ²	420 (maximum)		X
Breaking Strength, Kg (Grab Method)			
Direction A	140 (minimum)	X	
Direction B	130 (minimum)	X	
Binding Tape	Nylon	X	
Color	Dark Green	X	
Thickness, mm	0.30 - 0.80		X
Type of Weave	Plain Double		X
Weight, g/linear meter	8.0 (maximum)		X
Breaking Strength, Kg (Grab Method)	90 (minimum)	X	
Width, cm	1.60 – 2.00		X
Color Quality (Spectrophotometer Method)	2.0 (maximum)	X	
Quarter Top Facing and Backstay Tapes	Nylon	X	
Width, cm	2.30 - 2.80		X
Thickness,mm	1.10 – 1.60		X
Breaking Strength, kg	325 (minimum)	X	

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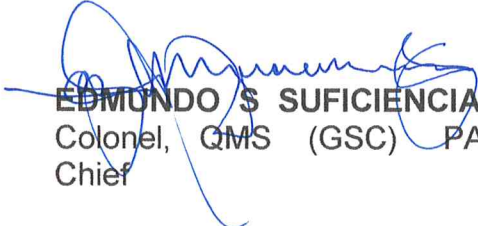


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		Major	Minor
Thread Count/2.54 cm			
Warp	115 (minimum)		X
Filling	40 (minimum)		X
Yarn Size, Denier			
Warp	800 (minimum)		X
Filling	490 (minimum)		X
Type of Weave	Plain Double		X
Color	Dark Green	X	
Color Quality (Spectrophotometric Method)	2.0 (maximum)	X	
Ankle Reinforcement Tape	Nylon	X	
Width, cm	4.80 – 5.20		X
Thickness, mm	1.10 – 1.60		X
Breaking Strength, kg	650 (minimum)	X	
Thread Count/2.54 cm			
Warp	115 (minimum)		X
Filling	40 (minimum)		X
Yarn Size, Denier			
Warp	800 (minimum)		X
Filling	490 (minimum)		X
Type of Weave	Plain Double		X
Color	Dark Green	X	
Color Quality (Spectrophotometric Method)	2.0 (maximum)	X	
Footbed Cushion System/Sock Lining	Shall be pre-molded high-grade cushion material with Olive Drab knitted fabric	X	
Thickness (mm)	3.0 - 8.0		X
Color	Black	X	
	The cushion material should have an open-cell structure as illustrated in Figure 3A and 3B.	X	
	Should have the manufacturer's name or logo imprinted on the center heel portion		X
	Shall be properly fit to the applicable size of the boot.	X	
Insole Construction Assembly	shall be of 2-piece construction	X	
Top Layer	Multiple Layered non-woven polyester/nylon fabric	X	
Thickness, mm	3.0 - 5.0		X
Weight, g/m ²	4,000 (maximum)		X
Puncture Resistance	Shall withstand a resistive force of 122.5 kgf minimum without penetration	X	
Color	Natural or White		X
Bottom Layer	Shall be made from Split leather insole	X	
Thickness, mm	1.30 - 2.00		X
Metals			
Eyelet	Brass or Aluminum	X	
Color	Olive Drab	X	
Outside diameter	1.19 cm – 1.25 cm		X
Inside diameter	0.50 cm – 0.65 cm		X

TEST PARAMETERS	QM SPEC NR IC-21ACBSFU dtd 05 July 2019	Classification of Defects	
		Major	Minor
Speed Lace Loop	Shall be made of brass and coated enamel	X	
Color	Olive Drab	X	
Drainage eyelet with washers	Brass, mesh		X
Color	Olive Drab	X	
Diameter of Head, mm	11 mm ± 1.10 mm		X
Outsole & Heel Rubber			
Color	Olive Drab	X	
Abrasion Resistance (Loss in weight), mg	90 (maximum)	X	
Flex Resistance	Shall not show sign of cracks or splits and shall have no separation between the upper after a minimum of 150 hours continuous flexing	X	
Bond Strength, kgs	70 (minimum)	X	
Hardness, (Shore A)	Shall be 65 ± 10	X	
Bottom Design	Shall be of the Panama style with honeycomb traction.	X	
Markings	Marked by size and contractor's identifications	X	
Thread, Upper Fitting			
No. of Ply	Nylon or Polyester	X	
Color	3 (minimum)		X
Breaking Strength, kg	Olive Drab	X	
Thread, Insole Stitching			
Color	5.0 (minimum)	X	
No. of Ply	Nylon or Polyester	X	
Breaking Strength, kg	Natural/White	X	
Lace Material			
	be round type braided nylon/polyester	X	
	Shall be reinforced with plastic tips 1.8 ± 0.3 cm		X
Color	Olive Drab	X	
Length, cm	160 (minimum)	X	
Breaking Strength, kg	75.0 (minimum)	X	
Fiber Shank			
Thickness, mm	High grade compressed hard fiber	X	
Width, cm	1.90 – 2.50		X
Length, cm	1.40 – 2.00		X
	Boot Size _____ (See para 2.2.9.1)		X
Heel Fillers			
	Shall be made of wood or other suitable material that does not affect vulcanization or proper molding of the heel		X
	Shall be heel-shaped with straight edges		X
Instruction Tag			
	To be tied to the finished boots		X
	Shall be printed using the data supplied in Illustration 1		
	tag shall be printed on tag stock that is 12 cm by 16 cm and folded in the middle to form four printed pages in book form that are 12 cm by 8 cm		
	A punch hole shall be made in the top near the folded edge for insertion of the lace.		
	To be tied to the finished boots		
Construction			
Insole Length, mm	Boot Size: ____ (See Table I)	X	

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TEST PARAMETERS	QM SPEC NR IC-21ACBSFU dtd 05 July 2019	Classification of Defects	
		Major	Minor
Contractor's Label	With contractor's label	X	
Dimensions, cm	3 ± 0.5 x 6 ± 0.5		X
Contents of Label	ARMY COMBAT BOOTS, SUEDE, FIELD USE		X
	Manufacturer: _____		
	Date of Manufacture: _____		
	Lot No: _____		
Upper Stitching No. of Stitches/2.54 cm	8 – 10 stitches		X
Eyeletstay	Shall have a V-Cut	X	
	Shall have a depth of 1.5 ± 0.3 cm located at the center of the eyelet and the speed lace loop as shown in the Figure 3D		X
Speed Lacing and Eyeleting	On each quarter, there shall be five (5) speed lace loops on the upper portion and three (3) eyelets at the bottom spaced evenly from blucher nose to top of quarter	X	
Instruction Tag	Shall have One (1) Instruction Tag	X	
	Shall have two (2) drainage eyelet located just above the insole on the finished boot as illustrated in FIGURE 1	X	
Height, cm	Boot Size: ____ (See Table I) (see FIGURE 5)	X	
Vamp Width, mm	Boot Size: ____ (See Table I) (see FIGURE 4)	X	
Workmanship			
Design	Shall be for a full lace closure boot with puncture resistant insole with a removable cushioned sock lining	X	
Total Test Points		75	67


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