

**U.S. NAVY CLOTHING & TEXTILE RESEARCH FACILITY (NCTRF)
IMPROVED CHEMICAL, BIOLOGICAL, RADIOLOGICAL DUFFEL BAG (ICB BAG)
DRAFT SPECS**

DESIGN DETAILS. The bag shall have waterproof, thermal bonded seams, a shoulder strap crossing diagonally from the left front of the bag to the right back of the bag with swivel hook at the front connection, and a grab handle on each short side of bag. Transparent vinyl identification (ID) windows will be located on the center front and right side of the bag. Webbing shall be Box-X stitched to basic material patches and bonded to bag per marks on pattern. The bag will have a roll-down style top with double buckle closure. The bag shall be printed with "CBR-D KIT" and placed according to marks on pattern.



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TABLE I – BASIC MATERIALS

LOCATION	① BAG MATERIAL	② ID WINDOWS	③ SHOULDER STRAP & GRAB HANDLES	④ BAG CLOSURES STRAPS	⑤ SHOULDER STRAP TRI-GLIDE ADJUSTER	⑥ SHOULDER STRAP CLASP	⑦ SHOULDER STRAP CONNECTION	⑧ BAG CLOSURE DUAL TAB SIDE RELEASE BUCKLES	⑨ THREAD	⑩ “CBR-D KIT” LETTERING	⑪ BATTEN
MATERIAL	Matte finish Vinyl Reinforced Polyester Laminated Fabric	Double Polish Clear Vinyl	Webbing, Polyester	Webbing, Polyester	Acetal Heavy Duty Sliplok 100 lb break strength	Nylon Plasti-Metallic Hook 160 lb break strength	Acetal Double Bar D-Ring 145 lbs break strength	Acetal Single Bar Stealth Male 150 lbs break strength and Acetal Single Bar Stealth Female 150 lbs break strength Stays 150 when mated together	Thread, Nylon, Twisted, Bonded, Multiple Cord, Non-Wicking	See NU/PD20002 (Encl 1)	Flexible Plastic Stiffener
SPEC or MFG STYLE #	A-A-55308 Type I, Class 1, Form 1	MIL-P-18080	MIL-PRF-17337 Class 2	MIL-PRF-17337 Class 2	National Molding Part #4784 or equal	National Molding Part # 6727 or equal	National Molding Part # 4776 or equal	National Molding Part #6812 and Part #6359 or equal	A-A-59826, Type II, Class B	See NU/PD20002 (Encl 1)	TBD
SHADE	Kelly Green Pantone 341CP (or AMS-STD-595/14193)	Clear	Black	Black	Black	Black	Black	Black	Black	Yellow Pantone 3965C (or AMS-STD-595/13591)	Natural Clear or Black
QTY/BAG	1.25 yds	8.5” x 5.25”	2-1/3 yds	2/3 yd	1	1	1	2 pairs	-	-	43” x 1”
WEIGHT/SIZE	18 oz	10-12 Gauge	2”	1”	2”	2”	2”	1”	Tex 70	-	30 or 50 mil (measures 1 mm)
KNOWN SOURCE	Bruin Plastics www.bruinplastics.com		Texcel Industries www.texcelindustries.com		National Molding Duraflex USA nationalmolding.com				American & Efird www.amefird.com	NAZDAR Ink nazdar.com	Piedmont Plastics and US Plastic TBD
Sources are suggestions only; equal components may be used											

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TABLE II – SEAMS AND STITCH TYPES

SEAMS	SEAM TYPE	STITCH TYPE	STITCH PER INCH
SHOULDER STRAP BOX-X TO PATCH	LSbj-1	301	6-8
SHOULDER STRAP CONNECTION POINT BOX-X TO PATCH	LSbj-1	301	6-8
GRAB HANDLE BOX-X TO PATCH	LSbj-1	301	6-8
GRAB HANDLE BOX STITCHING	LSbj-1	301	6-8
FRONT CLOSURE BOX-X TO PATCH	LSbj-1	301	6-8
TOP EDGE HEM	LSaf-2	301	6-8
SIDE PANEL TO MAIN BODY	Thermal Bonded, 1/2" (-1/8, +0) seam allowance		

Note:

- Manufacturer shall use best commercial practices and notify NCTRF if any deviations are made from this table
- Manufacturer may change seam allowance on patterns to accommodate machinery

TABLE III – CBR-D KIT LETTERING DIMENSIONS AND MARKINGS (INCHES)

	CENTERED C,B,R,D,K,T	CENTERED I	CENTERED -
HEIGHT	2-1/2	2-1/2	3/8
WIDTH	1-5/8	3/8	3/4
TOLERANCE	± 1/8 each letter	± 1/8 Height / ± 1/16 Width	± 1/16

TABLE IV. WEBBING CUT LENGTHS (INCHES)

LOCATION	WIDTH	CUT LENGTH
SHOULDER STRAP (AROUND ENTIRE BODY OF BAG)	2 (± 1/16)	58-1/2 (± 1/2)
SHOULDER STRAP (CONNECTION POINT)	2 (± 1/16)	5-1/2 (± 1/8)
GRAB HANDLE (SHORT SIDES OF BAG)	2 (± 1/16)	9 (± 1/4)
TOP CLOSURE (ROLL DOWN PORTION)	1 (± 1/16)	6 (± 1/8)
BOTTOM CLOSURE (BACK OF BAG)	1 (± 1/16)	4 (± 1/8)

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TABLE V – LIST OF PATTERN PARTS

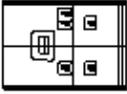
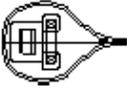
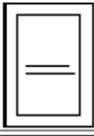
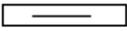
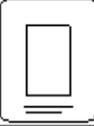
Piece Name	Piece Image	Piece Category	Piece Description	Fabric
ICBBAG-BODY		BODY	CUT 1	A
ICBBAG-SIDE		SIDE	CUT 2	A
ICBBAG-BATTEN		BATTEN	CUT 2	C
ICBBAG-CLEAR_WINDOW		CLEAR WINDOW	CUT 2	B
ICBBAG-HANDLE_PATCH		HANDLE PATCH	CUT 8	A
ICBBAG-HANDLE_TEMPLATE		HANDLE TEMPLATE	CUT 0	X
ICBBAG-STRAP_TEMPLATE		STRAP TEMPLATE	CUT 0	X
ICBBAG-WINDOW_FRAME		WINDOW FRAME	CUT 2	A
ICBBAG-SHOULDER_STRAP_HANDLE_PATCH		STRAP HANDLE PATCH	CUT 1	A

TABLE VI. TABLE OF FINISHED MEASUREMENTS (TOFM) (INCHES)

	BAG HEIGHT (A)	BAG WIDTH (B)	BAG LENGTH (C)	ID HOLDER LENGTH (D)	ID HOLDER HEIGHT (E)
DIMENSION	19	13-1/4	20	5	4
TOLERANCE	± 1/2	± 1/2	± 1/2	± 1/2	± 1/2

FIGURES

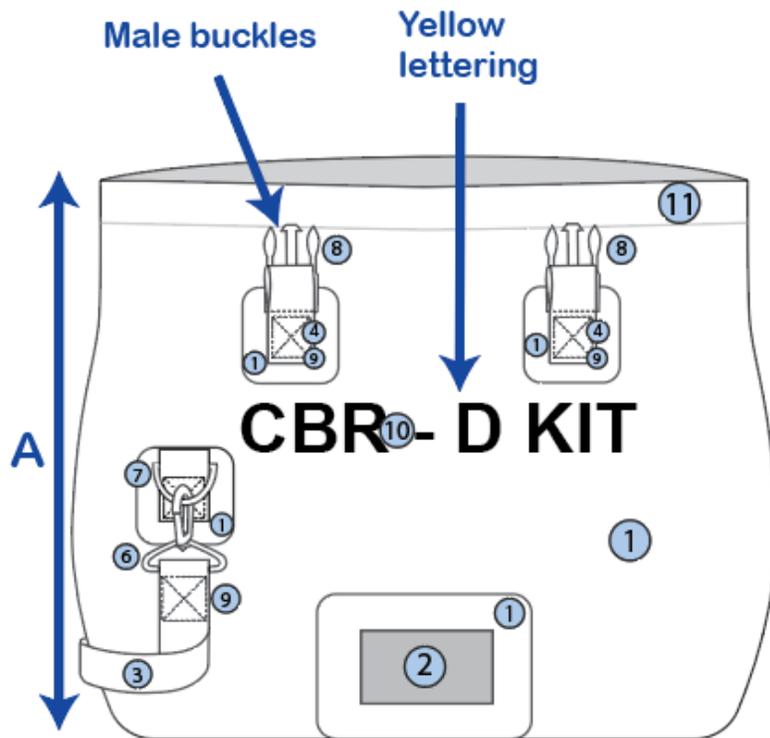
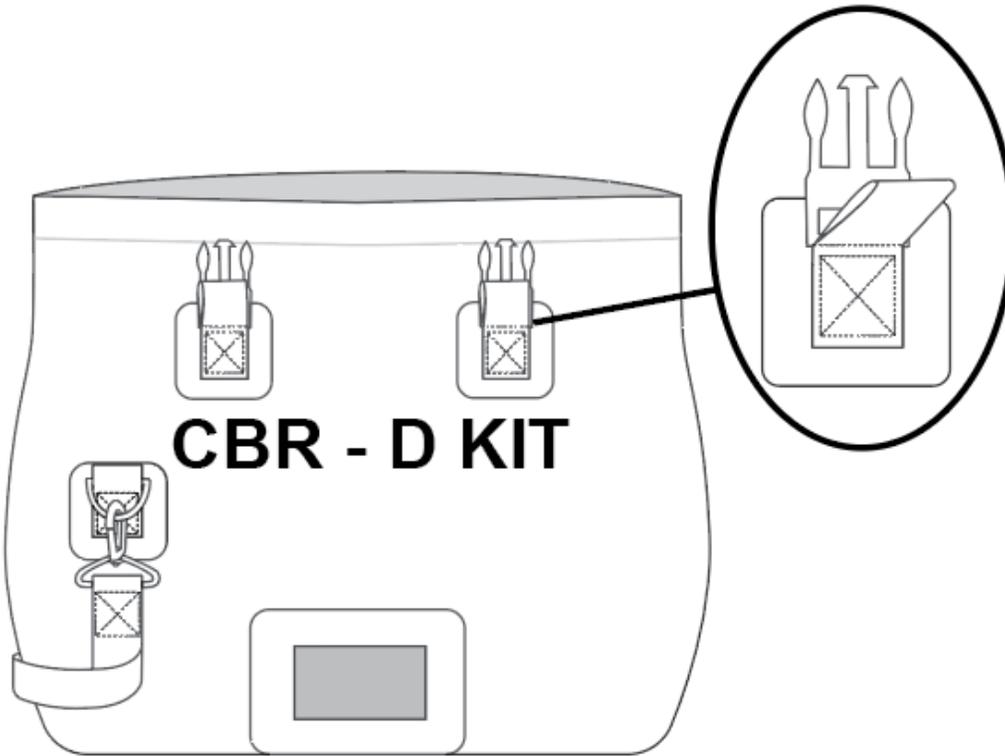


FIGURE 1. FRONT VIEW, UNROLLED

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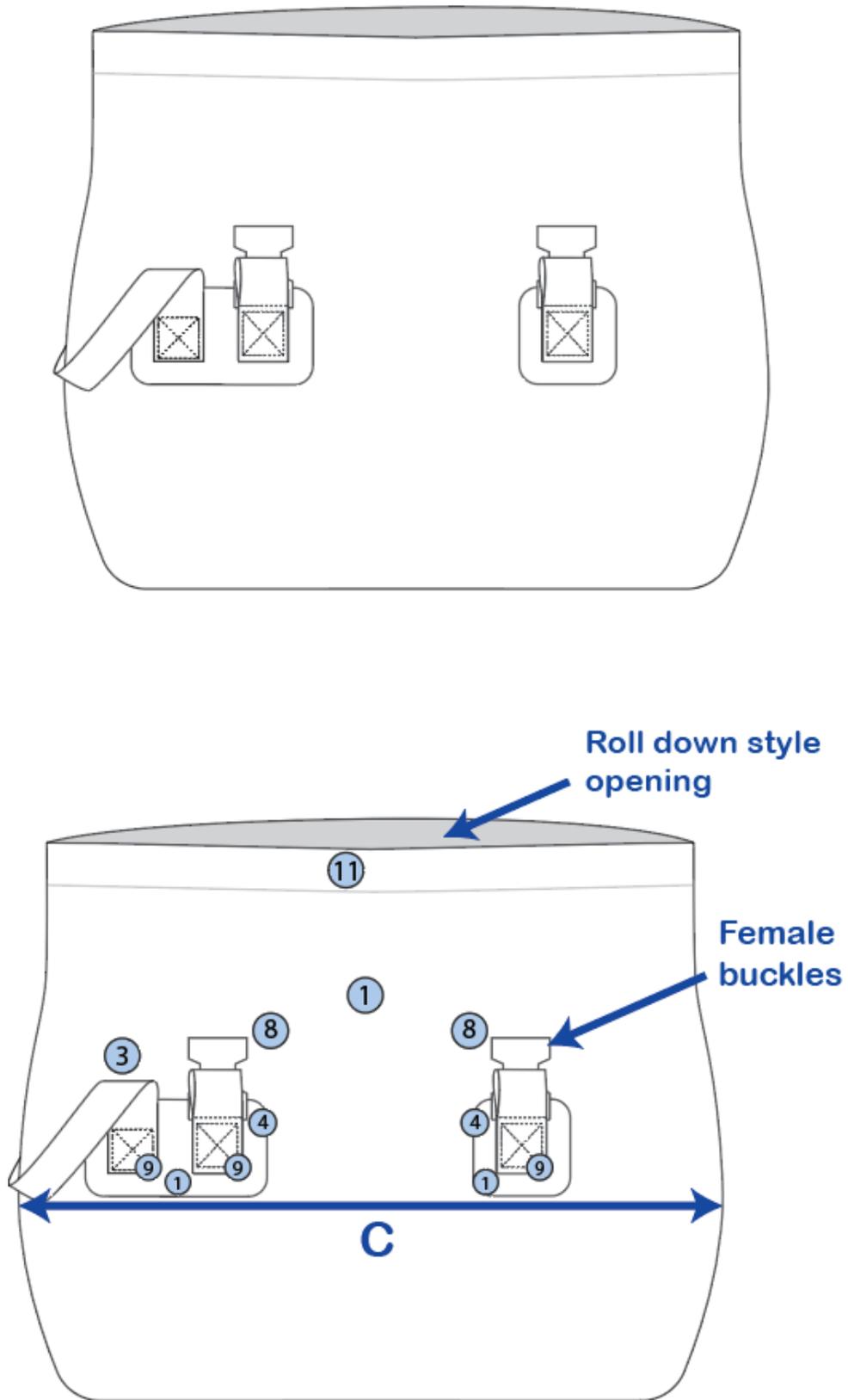


FIGURE 2. BACK VIEW, UNROLLED

NCTRF - iCB BAG

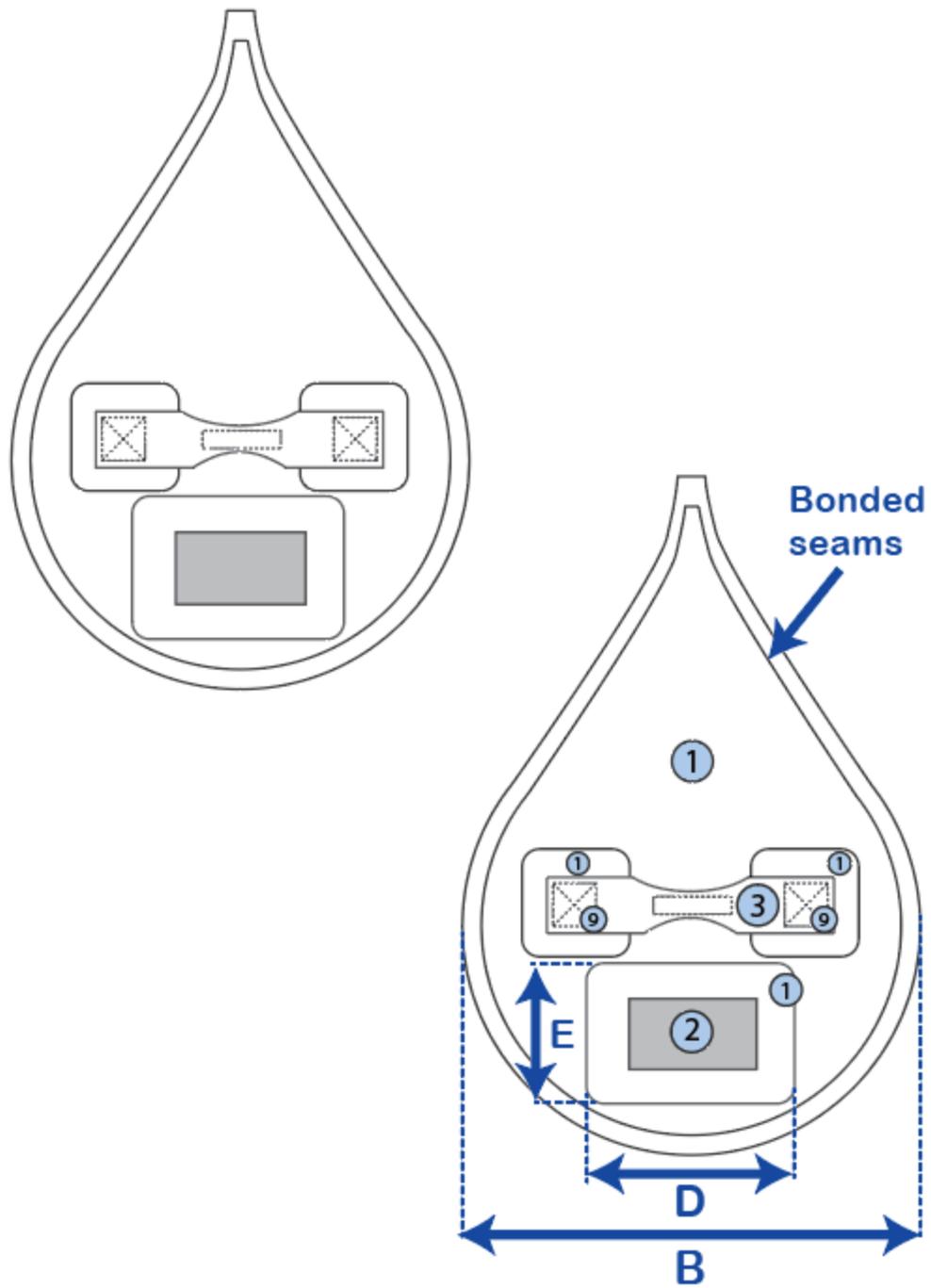


FIGURE 3. RIGHT SIDE VIEW, UNROLLED, GRAB HANDLE AND ID WINDOW

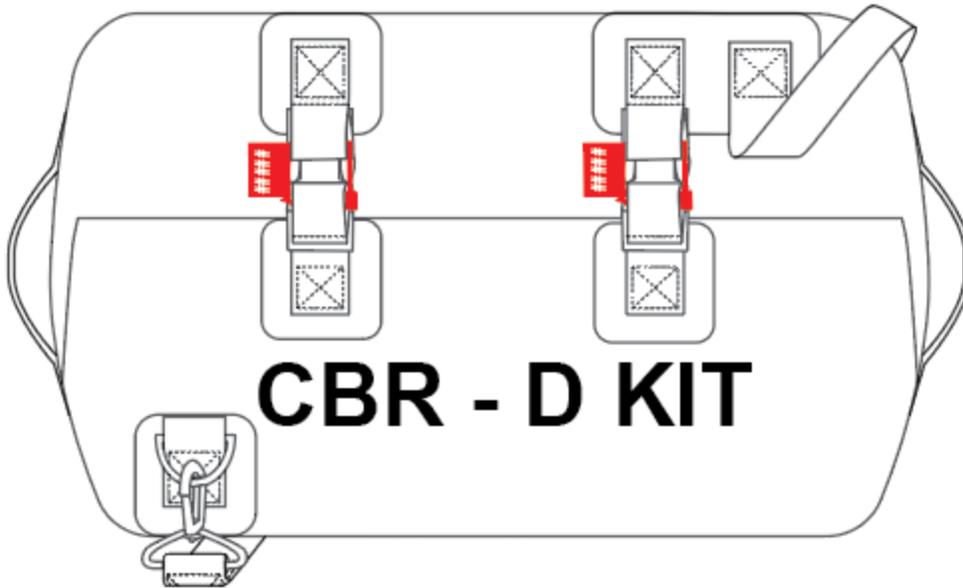
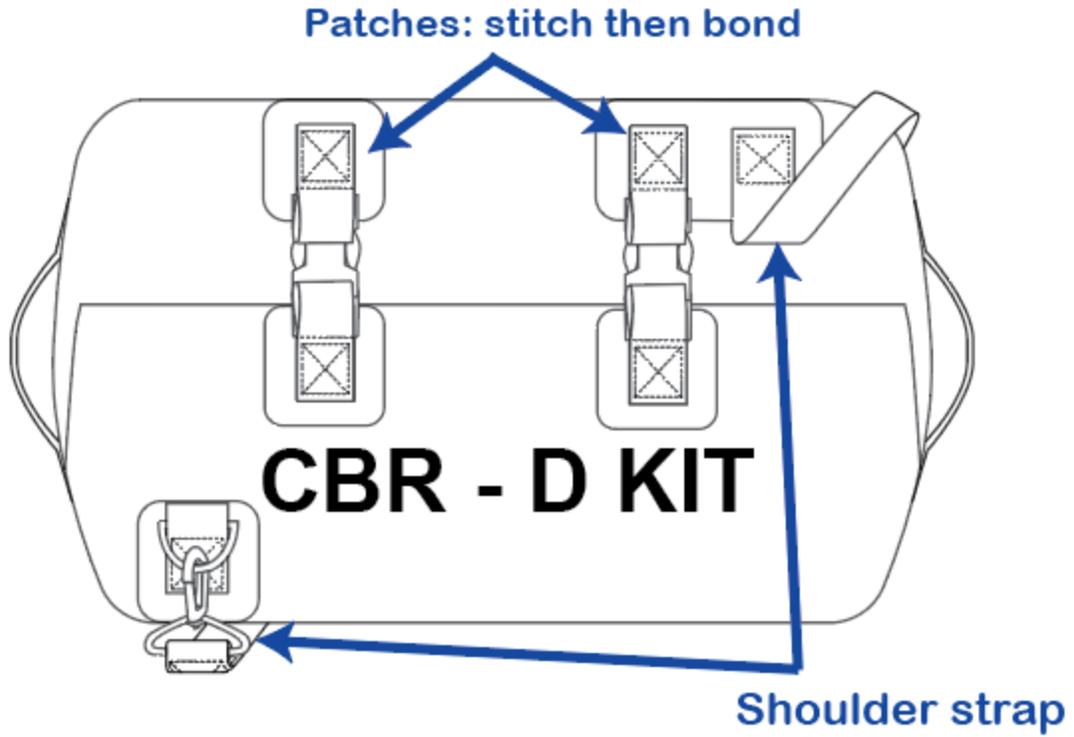


FIGURE 4. TOP VIEW, ROLLED, LETTERING, RED TAB LOOPS AND LOCATIONS

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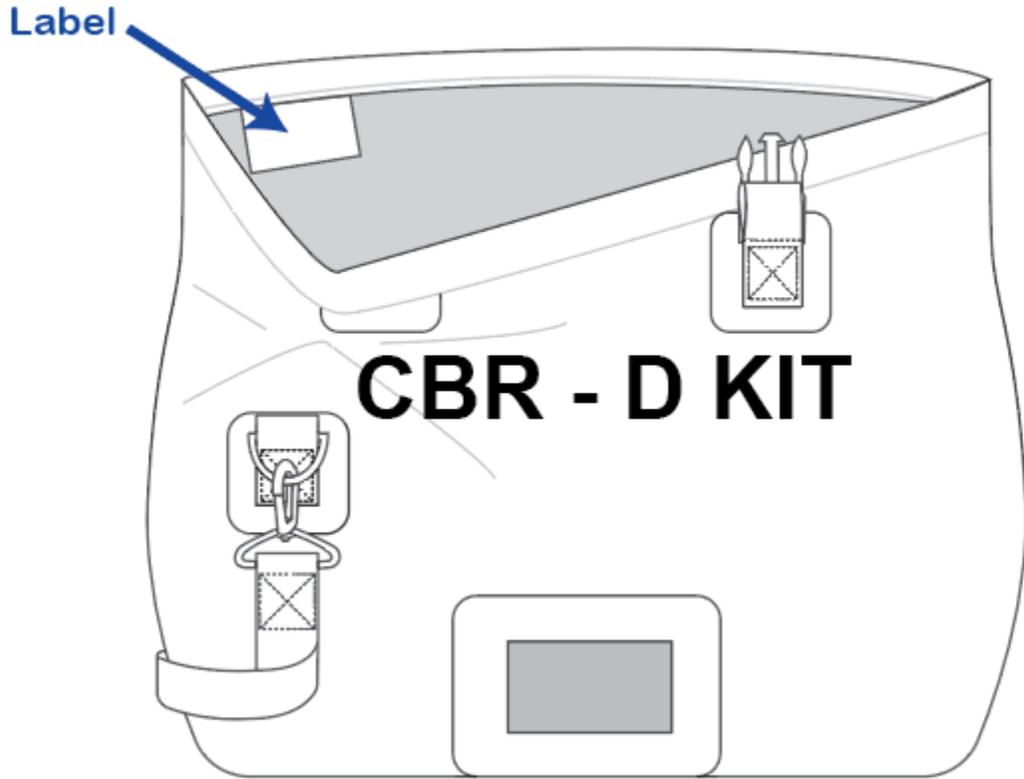


FIGURE 5. FRONT AND INSIDE VIEW, UNROLLED, LABEL CAUGHT IN SEAM

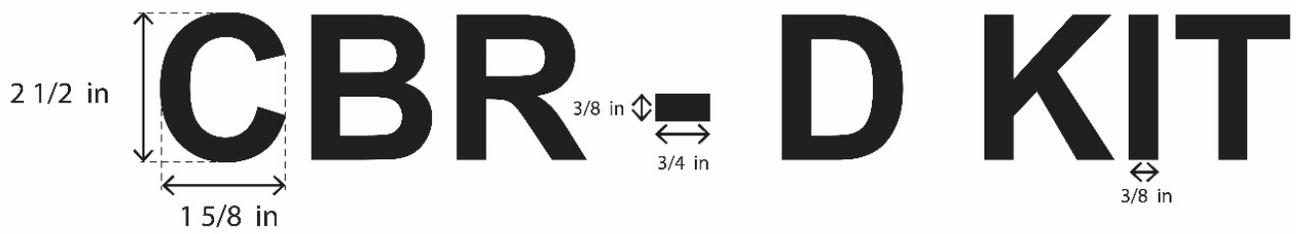


FIGURE 6. LETTERING DIMENSIONS