INCH-POUND

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SUPERSEDING
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MILITARY SPECIFICATION

BUCKLES; AND CLIPS, END, STRAP (FOR BELT, TROUSERS)

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

1. SCOPE

1.1 Scope. This document is applicable to buckles and end clips used with belts worn by personnel of the United States military.

1.2 Classification. This specification covers the following types, classes, subclasses and sizes of buckles and clips.

Type I - Buckle, closed front (see Figure 1)
Sizes:
1-1/8 inch
1-5/16 inch
Classes:
Class 1 – Yellow brass
Subclass A – Mirror finish, lacquer coated (see 3.5.2.1)
Subclass B – Mirror finish, chromium plated (see 3.5.2.5.1)
Subclass C – 24K gold plated (see 3.5.2.5.2)
Class 2 – Nickel silver, matte finish (see 3.5.2.4)

Comments, suggestions, or questions on this document should be addressed: Attn: DLA Troop Support, 700 Robbins Avenue, Philadelphia, PA 19111-5096. Since contact information can change, verify the currency of the address information using Acquisition Streamlining and Standardization Information System (ASSIST) online database https://assist.dla.mil.

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Type II - Buckle, open front
Size - 1-1/4 inch (see Figure 2)
Classes:
Class 1 – Yellow brass, black oxidized finish (see 3.5.2.3)
Class 2 – DELETED
Size - 1-5/16 inch (see Figure 3)
Class 3 – Red brass
Subclass A – DELETED
Subclass B - 24K gold plated (see 3.5.2.5.2)
Subclass C – Antique oxidized, lacquer coated (see 3.5.2.2)

Type III - Clip (see Figure 4)
Sizes:
1 inch
1-1/4 inch
Classes:
Class 1 – Yellow brass
Subclass A – Mirror finish, lacquer coated (see 3.5.2.1)
Subclass B – Black oxidized finish (see 3.5.2.3)
Subclass C – Mirror finish, chromium plated (see 3.5.2.5.1)
Subclass D – 24K gold plated (see 3.5.2.5.2)
Class 2 – Nickel silver, matte finish (see 3.5.2.4)
Size - 1-1/4 inch
Classes:
Class 3 – Red brass
Subclass A – Mirror finish, lacquer coated (see 3.5.2.1)
Subclass B – Antique oxidized, lacquer coated (see 3.5.2.2)
Class 4 – DELETED
Subclass A – DELETED
Subclass B – DELETED

2. APPLICABLE DOCUMENTS

2.1 General. The documents listed in this section are specified in sections 3 and 4 of this specification. This section does not include documents cited in other sections of this specification or recommended for additional information or as examples. While every effort has been made to ensure the completeness of this list, document users are cautioned that they must meet all specified requirements of documents cited in sections 3 and 4 of this specification, whether or not they are listed.

2.2 Government documents.

2.2.1 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 cited in the solicitation or contract.

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DEPARTMENT OF DEFENSE SPECIFICATIONS

MIL-F-495 - Finish, Chemical, Black, for Copper Alloys
MIL-DTL-833 - Belt, Trousers, Cotton Webbing, with Clip
MIL-DTL-45204 - Gold Plating, Electrodeposited

(Copies of these documents are available online at https://quicksearch.dla.mil.)

2.2.2 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 are those cited in the solicitation or contract.

DRAWINGS

U.S. ARMY NATICK RESEARCH, DEVELOPMENT AND ENGINEERING CENTER

2-4-57 - Buckles; and Clips, End, Strap (for Belt, Trousers); Type I, (Closed Front) Buckle Sizes 1-1/8" and 1-5/16", Class 1 and 2
2-4-58 - Buckle and Clip, End, Strap (for Belt Trousers); Type III Clip, End, Strap, Sizes 1" and 1-1/4", Class 1, 2, 3 and 4
2-4-63 - Buckle and Clip, End, Strap (for Belt, Trousers); Die Cut Card for Mounting End Clip
2-4-64 - Buckles: and Clips, End, Strap (for Belt, Trousers); Type II, (Open Front) Buckle, 1-5/16" Size, Class 3
4-1-436 - Buckles; and Clips, End, Strap (for Belt, Trousers); Type II, (Open Front) Buckle, 1-1/4 Inch Size, Class 1 and 2

(Copies of drawings are available from the U.S. Army Combat Capabilities Development Command Soldier Center, ATTN: FCDD-SCP-WC, 10 General Greene Avenue, Natick, MA 01760-5019.)

OTHER GOVERNMENT DOCUMENTS AND PUBLICATIONS

DEPARTMENT OF THE ARMY, THE INSTITUTE OF HERALDRY (TIOH)

The Institute of Heraldry, Department of Defense Standard Metal Finish Chip Set

(The standard chip(s) for color or finish may be obtained from the procuring activity for Government procurements.)

2.3 Non-Government publications. The following documents form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those cited in the solicitation or contract.

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AMERICAN SOCIETY FOR QUALITY (ASQ)

ASQ/ANSI Z1.4-2003 - Sampling Procedures and Tables for Inspection by Attributes

(Copies are available online at https://asq.org.)

ASTM INTERNATIONAL

ASTM B36/B36M	-	Standard Specification for Brass Plate, Sheet, Strip, and Rolled Bar
ASTM B122/B122M	-	Standard Specification for Copper-Nickel-Tin Alloy, Copper-Nickel-Zinc Alloy (Nickel Silver), and Copper-Nickel Alloy Plate, Sheet, Strip, and Rolled Bar
ASTM B134/B134M	-	Standard Specification for Brass Wire
ASTM B206/B206M	-	Standard Specification for Copper-Nickel-Zinc (Nickel Silver) Wire and Copper-Nickel Alloy Wire
ASTM E18	-	Standard Test Methods for Rockwell Hardness of Metallic Materials

(Copies of documents are available online at https://www.astm.org.)

SAE INTERNATIONAL

AMS2460 - Plating, Chromium

(Copies of documents are available online at https://www.sae.org.)

2.4 Order of precedence. Unless otherwise noted herein or in the contract, 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. When specified (see 6.2), samples shall be subjected to first article inspection in accordance with 4.3.

3.2 Standard sample. Unless otherwise indicated, the finished buckles and clips shall match the appropriate standard sample (see 6.4) for color, finish and appearance; and shall be equal to or better than the standard sample with respect to all characteristics for which the standard sample is referenced.

3.3 Recycled, recovered, environmentally preferable, or biobased materials. Recycled, recovered, environmentally preferable, or biobased materials should be used to the maximum extent possible, provided that the material meets or exceeds the operational and maintenance requirements, and promotes economically advantageous life cycle costs.

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3.4 Figures. Figures 1 through 4 are furnished for informational purposes only. To the extent of any inconsistencies between the written document and any figure, the written document shall govern.

3.5 Material.

3.5.1 Copper base alloys.

3.5.1.1 Brass. Unless otherwise specified, the material used in the production of yellow brass (Class 1) and red brass (Class 3) buckles and components shall meet the requirements of ASTM B36/ASTM B36M, and shall be of a quality which will be suitable for producing buckles and clips conforming to the requirements specified herein. Unless otherwise specified in the contract or purchase order, copper alloy numbers 26800 (Yellow Brass), Standard H01 shall be used for Class 1 buckle components, except for the roller on Type I, Class 1 buckles (see 3.5.1.1.1); and for Class 1 clips. Copper alloy number 23000 (Red Brass), Standard H01 shall be used for Type II, Class 3 buckles and Type III, Class 3 clips.

3.5.1.1.1 Copper wire. Copper wire used in the production of the Type I, Class 1 buckle rollers shall meet the appropriate requirements of UNS number C26000 or C27000, 1/8 hardness, as specified in ASTM B134/B134M and shall be of a quality which will be suitable for producing buckle components conforming to the requirements specified herein.

3.5.1.2 Nickel silver. The material used in the production of nickel silver buckles (Type I, Class 2) and nickel silver clips (Type III, Class 2) shall meet the requirements of UNS number C75200 specified in ASTM B122/ASTM B122M, and shall be of a quality which will be suitable for producing buckles and clips conforming to the requirements specified herein. Nickel silver shall have a hardness of 75 to 78.5 on a Rockwell 15T scale. Testing for hardness shall be as specified in 4.5.1. Wire used for Type I, Class 2 rollers shall meet the requirements of ASTM B206/ASTM B206M and shall be 1/8 hard tempered.

3.5.2 Finish. Finish requirements for buckles and clips shall be in accordance with the standard samples furnished by the procuring activity. Prior to the contractor going into production, samples shall be provided to the procuring activity for approval. Prior to finishing, all buckles and clips shall be thoroughly cleaned in accordance with commercial best practices and shall be free from corrosion, foreign matter and discoloration. Use of pre-polished brass is prohibited. Use of pre-polished nickel silver is acceptable for clips. Use of pre-polished nickel silver is prohibited for buckles. The finish of all buckles and clips shall be examined in accordance with 4.5.6. Finish shall not be damaged by the clinching of the clips.

3.5.2.1 Mirror finish, lacquer coated. Type I, Class 1, Subclass A buckles shall have the outside face and two edge surfaces of the front piece and the exposed surface of the roller given a mirror-like polished finish. The back plate and clamp shall be bright-dipped or ball-burnished finish. Type III, Class 1, Subclass A; and Type III, Class 3, Subclass A clips shall have the outside surfaces finished with a mirror finish. The completed buckles and clips shall have a coating of lacquer applied in accordance with industry standards after the desired color is

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achieved. Unless otherwise specified, the lacquer shall be clear, synthetic and colorless. Lacquered samples shall be examined (see 4.4.3) and tested (see 4.4.5), and shall meet all requirements prior to acceptance. The dry lacquer film shall be continuous, level, adherent, free from foreign matter, and not blushed, cloudy, hazy or have a rainbow effect. When tested as specified in 4.5.3, there shall be no change in the lacquered surface except for slight overall yellowing and there shall not be more than three dark spots, each not exceeding 1/32 inch in the largest dimension.

3.5.2.2 Antique oxidized finish. Type II, Class 3, Subclass C buckles; and Type III, Class 3, Subclass B clips shall have an antique finish approximating the unbuffed portions of The Institute of Heraldry, Department of Defense Standard Metal Finish Chip Set: Chip #4. Minor striations of darker oxidation are permitted to accentuate the antiqued properties of the buckle and clip. The completed buckles and clips shall have a coating of lacquer applied in accordance with industry standards after the desired color is achieved. Unless otherwise specified, the lacquer shall be clear, synthetic and colorless. Lacquered samples shall be examined (see 4.4.3) and tested (see 4.4.5), and shall meet all requirements prior to acceptance. The dry lacquer film shall be continuous, level, adherent, free from foreign matter, and not blushed, cloudy, hazy or have a rainbow effect. When tested as specified in 4.5.3, there shall be no change in the lacquered surface except for slight overall yellowing and there shall not be more than three dark spots, each not exceeding 1/32 inch in the largest dimension.

3.5.2.3 Black finish. Type II, Class 1 buckles and Type III, Class 1, Subclass B clips shall be given a black chemical finish conforming to MIL-F-495, except that the gloss shall be 40 maximum when evaluated in accordance with 4.5.6. The final rinse stage shall be carefully conducted to remove alkaline residue and drying shall be thorough. The finish shall be smooth, uniform and continuous, without orange peel, wrinkles, drops, streaks, peeling or flaking, specks, scratches or foreign matter. When tested as specified in 4.5.2, the finish shall withstand clinching of the end clip to the belt without flaking, chipping, showing signs of cracks in the finish and without perceptible loss in adhesion to the point where the finish can be removed with a fingernail. Unless otherwise specified, lacquer is not applied to black chemical finished end-items. Samples shall be examined (see 4.4.3) and tested (see 4.4.5) and shall meet all requirements prior to acceptance.

3.5.2.4 Matte finish. The outside face and two edge surfaces of the front and back piece and the exposed surface of the roller of Type I, Class 2 buckles, and all outside surfaces of the Type III, Class 2 clip shall be given a matte finish (sometimes referred to as a satin finish) in accordance with TIOH Metal Finish Chip #17 (see 2.2.2). The scratch pattern shall be parallel to the long dimension.

3.5.2.5 Plating.

3.5.2.5.1 Chromium plating. The plating of Type I, Class 1, Subclass B buckles and Type III, Class 1, Subclass C clips shall be chromium. The outside face and two edge surfaces of the front piece and the exposed surface of the roller of Class 1, sub-class B buckles shall be given a mirror-like polished finish. The back plate and clamp shall be given a bright-dipped or ball-

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burnished finish. Chromium plating shall be in accordance with Class 1, Type I of AMS2460 with a chromium plating thickness of 0.000015 inches.

3.5.2.5.2 Gold plating. The gold for plating of Type I, Class 1, Subclass C buckles; Type II, Class 3, Subclass B; and Type III, Class 1, Subclass D clips shall be 24 karat. The buckle shall be finished in gold flash in accordance with the requirements of MIL-DTL-45204. The outside face and two edge surfaces of the front piece and the exposed surface of the roller of the buckles shall be given a mirror-like polished finish. The back plate and clamp of the buckle shall be bright-dipped or ball-burnished finished. The gold flash shall meet the requirements of being uniform, with no visible breaks, over the entire plated surface. The color shall match TIOH Metal Finish Chip # 6 when tested as specified in 4.5.6.

3.6 Construction and performance. Buckles and clips shall be constructed in accordance with the drawings, designs and details as specified in Table I. The buckles and clips shall be free from all defects specified in Table II. Finished buckles and clips shall meet the dimensional requirements specified in the appropriate drawings. Drawing 2-4-63 may be used to assist in the finishing of clips, if desired.

Table I. Buckle and clip design drawings.

Type	Class	Size	Drawing
I	1	1-1/8 inch, 1-5/16 inch	2-4-57
I	2	1-1/8 inch, 1-5/16 inch	2-4-57
II	1	1-1/4 inch	4-1-436
II	3	1-1/4 inch	4-1-436
II	4	1-5/16 inch	2-4-64
III	1	1 inch, 1-1/4 inch	2-4-58
III	2	1 inch, 1-1/4 inch	2-4-58
III	3	1 inch, 1-1/4 inch	2-4-58
III	4	1 inch, 1-1/4 inch	2-4-58

3.6.1 Buckle function test. Type II buckles shall be tested for proper function in accordance with 4.5.3. At a minimum, buckles shall allow webbing with an appropriately sized end clip to pass through without binding or damaging the buckle, webbing or end clip. The webbing shall lie flat on top of the tongue.

3.6.2 Pull test. The Type I and Type II buckle clamp, and Type II buckle tongue, shall not slip more than 1/4 inch at or below 35 pounds; and the Type I buckle roller shall not slip more than 1/4 inch at or below 20 pounds, when tested in accordance with 4.5.4. The rollers and clamps shall be tested individually for Type I buckles. The buckle shall not incur permanent damage or deformation when tested in accordance with 4.5.4.

3.6.3 Clips. Type III clips shall be produced with the smooth edge of the metal on the outside of the clip. The size 1-1/4 inch clip, when affixed to 1-1/4 inch wide belt webbing and tested as specified in 4.5.3, shall thread through a Type I or Type II buckle, size 1-1/4 inch or 1-

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5/16 inch and of any class specified herein without binding or damaging the buckle, webbing or clip. The size 1 inch clip, when affixed to 1 inch wide belt webbing and tested as specified in 4.5.3, shall thread through a Type I, 1-1/8 inch buckle of any class without binding or damaging the webbing or buckle. Clips shall only be tested and used with the specified webbing and buckle sizes.

3.7 Marking for identification. All buckles shall be marked for identification with the letters "U.S." of the size shown on the applicable drawings (see 2.2) and manufacturer's identification of such known character as to be identifiable. The marking shall be permanently affixed by stamping or etching on the back surface of the buckle's back plate, clamp or ratchet as shown on the applicable drawing. The identification marks shall be incorporated in such a manner that the surface opposite the markings shall show no signs of penetration or unevenness, or that distortion is not caused on any part of the buckle.

3.8 Workmanship. The buckles and clips shall conform to the quality of the product established by this document and the occurrence of defects shall not exceed the applicable acceptance quality limit (AQL) specified in the contract or purchase order.

4. VERIFICATION.

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

a. First article inspection (see 4.3)
b. Conformance inspection (see 4.4)

4.2 Inspection conditions. Unless otherwise specified in this specification or applicable procurement documents, all inspections shall be performed in accordance with all the requirements of the referenced documents.

4.3 First article inspection. When a first article is required (see 6.2), it shall be examined for the defects specified in Table II and tested for the characteristics specified in Table III. The inspection level and Acceptance Quality Limit (AQL) will be as specified in the contract or purchase order. Defects exceeding the AQL or failure of any test will be cause for rejection of the first article.

4.4 Conformance inspection. Conformance inspection shall include the examination of 4.4.3 and 4.4.4 and the tests of 4.4.5, as applicable. Unless otherwise specified, sampling for inspection shall be performed in accordance with ASQ/ANSI Z1.4 and acceptance quality limits shall be as specified in the contract or purchase order.

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

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4.4.2 In-process inspection. Examination shall be made at any point or during any phase of the manufacturing process to determine whether the required operations are accomplished as specified.

4.4.3 End item visual examination. The end items shall be examined for the defects listed in Table II. The lot size shall be expressed in units of buckles or clips (as applicable) of one type, class, subclass and size. The sample unit shall be one buckle or clip, as applicable. The inspection level and AQL shall be as specified in the contract or purchase order. Sampling shall include all types included in the lot, and shall include buckles or clips from the beginning, middle and end of the production run. Unless otherwise noted, scoring shall be performed on defects visible from a normal viewing distance of 3 feet.

TABLE II. End item visual defects.

Examine	Defect	Classification	
		Major	Minor
Color and finish	No finish, or type of finish not as specified 1/	101	
	Discoloration	102	
	Corrosion	103	
	Scratch pattern not in the direction specified 1/	104	
	Finish not adherent (e.g., blistered, peeling, flaking, cracking, etc.) 1/	105	
	Foreign matter, fingerprints or marks embedded in the finish, viewable during use	106	
	Foreign matter, fingerprints or marks embedded in the finish, not viewable during use		201
	Coating is not level, uniform and continuous (e.g., runs, orange peel, wrinkles, drops or streaks)	107	
	Lacquer coating is blushed, cloudy, hazy or has a rainbow effect		202
	Finish is tacky to the touch		203
	Buff, drag or mottled finish exposed to view when in use	108	
	Plating broken, cut through, corroded or erupted 1/	109	
	Back, clamp, roller or inside of buckle or clip is not bright and clean 1/		204
	Penetration of markings to opposite surface	110	
	Surface or structure of buckle or clip wavy, uneven, bent, dented or distorted	111	
Design	Any characteristic not in accordance with the specified design drawing	112	

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TABLE II. End item visual defects. Continued

Examine	Defect	Classification	
		Major	Minor
Construction and workmanship	Component cracked, malformed, fractured, distorted or bent	113	
	Dents, nicks, pits, abrasions or scratches on surfaces exposed to view when in use	114	
	Gouges, burrs, slivers, sharp edges or tool marks	115	
	Component missing	116	
	Component will not operate as intended	117	
	Prongs or teeth not sharply pointed on clip	118	
	Component or part improperly placed	119	
	Markings missing, illegible, or incorrect	120	

1/ As applicable to the type, class, subclass, and size specified.

4.4.4 End item dimensional examination. The end items shall be examined for compliance with dimensions specified with an asterisk on Drawings 2-4-57, 2-4-58, 2-4-63, 2-4-64 and 4-1-436. Measurements shall be taken with a calibrated ruler, tape or micrometer. Any dimension that is not within the specified requirements shall be classified as a defect. The lot size shall be expressed in units of finished buckles or clips, as applicable, of one type, class subclass and size. The sample unit shall be one buckle or clip, as applicable.

4.4.5 End item testing. Testing of the completely finished buckles and clips shall be performed in accordance with Table III for the characteristics specified. The sample unit shall be one buckle or clip, and there shall be one (1) determination per sampled unit.

TABLE III. End item tests.

Characteristic	Types, Classes, subclasses	Requirement reference	Test method reference
Metal hardness	Type I, Class 2; Type III, Class 2	3.5.1.2	4.5.1
Effects of Clinching	Type III, all classes	3.5.2	4.5.2
Lacquer test	Type I, Class 1; Type II, Class 3, Subclass C Type III, Classes 1 and 3, Subclass A	3.5.2.1	4.5.3
Buckle Function	Type II	3.6.1	4.5.4
Pull test	All types and classes of buckles	3.6.2	4.5.5
Clip Function	Type III	3.6.3	4.5.2, 4.5.4

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4.5 Methods of inspection.

4.5.1 Hardness. When required (see 3.5.1.2), testing for hardness shall be conducted in accordance with ASTM E18.

4.5.2 Clinching test, Clips shall be clinched to the webbing with a stamping press with clearance between flat platens at the bottoming point carefully adjusted to the maximum distance that will yield a smooth, closed clip capable of passing through the appropriate buckle without binding or obstruction. The clinched clip shall be inspected for evidence of damage to the clip or the finish. Any clip showing damage, when properly secured as specified, shall be considered a defect.

4.5.3 Lacquer test. Immerse the samples to be tested in a 2 percent by weight of chemically pure potassium sulfide water solution, at a temperature of 100°F for not less than three (3) minutes. Remove and rinse the samples in warm (100°F to 120°F), then cold (32°F to 60°F) then hot (130°F to 150°F) water. Wipe the samples gently with an absorbent cellulose material or whirl to remove residual moisture, and allow to air dry at room temperature for a period of one (1) hour. Any sample failing to meet the drying lacquer film requirements as specified in 3.5.2.1 shall be considered a defect.

4.5.4 Function test. Test Type II buckles and Type III end clips for proper function by threading belt webbing (MIL-DTL-833) (see 2.2) with an end clip attached through the buckle in position of normal use. After the belt has been threaded through, the tongue shall be pressed closed and shall remain closed until manually operated. Any buckle failing to meet the requirements specified in 3.6.1 or 3.6.2 as applicable, shall be considered a defect.

4.5.5 Pull test of buckles. Test all types, classes and subclasses of buckles for holding strength of clamp, rollers and tongue (as applicable) by inserting belt webbing (MIL-DTL-833) (see 2.2) in position of normal use as shown on applicable drawing. Roller and clamp shall be in the locked position. Secure the webbing for the Type I buckle to the 3-inch machine clamps at the roller end and clamp end. Secure the webbing for the Type II buckles to the 3-inch clamps at the tongue end and clamp end. The machine should be tested for correct load setting before testing buckles. If a constant rate of extension (CRE) tensile tester is utilized, set the maximum load crosshead stop setting slightly lower than the requirement specified in 3.6.2 to compensate for the crosshead speed override. A Constant Rate of Traverse (CRT) tensile tester will not require pretesting. The pulling speed shall be set to 12 inches per minute. Any sample failing to meet the pull requirements as specified in 3.6.2 shall be a defect.

4.5.6 Finish examination. The finish shall be compared to the standard sample (see Table IV) for color and gloss. Unless otherwise specified, buckles and clips shall be examined when viewed under filtered tungsten lamps which approximate artificial daylight having a correlated color temperature of 7500K (±200K) with illumination of 100 (±20) foot candles, and shall be a good match to its applicable standard sample under incandescent lamplight at 2856K (±200K)

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TABLE IV. Metal chips for color and gloss evaluation.

Type	Class	Subclass	Color Standard	Color Name
I	1	A	TIOH Metal Chip #1	Brass, Mirror
		B	TIOH Metal Chip #16	Chromium Plated, Mirror
		C	TIOH Metal Chip #6	24K Gold Plated, Mirror
	2		TIOH Metal Chip #17	Matte
II	1		TIOH Metal Chip #21	Dull Flat Black
	2		Deleted	
	3	A	TIOH Metal Chip #1	Red Brass, Mirror
		B	TIOH Metal Chip #6	24K Gold Plated, Mirror
		C	TIOH Metal Chip #4 1/	Brass, Antique Oxidized
III	1	A	TIOH Metal Chip #1	Brass, Mirror
		B	TIOH Metal Chip #21	Dull Flat Black
		C	TIOH Metal Chip #16	Chromium Plated, Mirror
		D	TIOH Metal Chip #6	24K Gold Plated, Mirror
	2		TIOH Metal Chip #17	Matte
	3	A	TIOH Metal Chip #1	Red Brass, Mirror
		B	TIOH Metal Chip #4 1/	Brass, Antique Oxidized
	4	A	Deleted	
		B	Deleted	

1/ Comparison is made to unbuffed portion of chip.

5. PACKAGING

5.1 Packaging. For acquisition purposes, the packaging requirements shall be as specified in the contract or order (see 6.2). When packaging of materiel is to be performed by DoD or in-house contractor personnel, these personnel need to contact the responsible packaging activity to ascertain packaging requirements. Packaging requirements are maintained by the Inventory Control Point's packaging activities within the Military Service or Defense Agency, or within the military service's system commands. Packaging data retrieval is available from the managing Military Department's or Defense Agency's automated packaging files, CD-ROM products, or by contacting the responsible packaging activity.

6. NOTES

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

6.1 Intended use. The buckles and clips are used, with the appropriate webbing, to form belts (see MIL-DTL-833) used by the Services as part of duty, dress and service uniforms.

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6.2 Acquisition requirements. Acquisition documents should specify the following:

a. Title, number, and date of this specification.
b. Type, Class, Size and Sub-class required (see 1.2)
c. The specific issue of individual documents referenced (see 2.2 and 2.3).
d. When first article is required (see 3.1, 4.3, 6.3).
e. Conformance inspection acceptance quality limits (AQL) (see 4.3 and 4.4.2)
f. Inspection conditions (see 4.2)
g. Packaging (see 5.1).

6.3 First article. When a first article inspection is required (see 3.1), it will be inspected and approved under the appropriate provisions of FAR 52.209-4. The first article should be a preproduction sample. The contracting officer should specify the appropriate type of first article and the number of units to be furnished. The contracting officer should include specific instructions in acquisition documents regarding arrangements for selection, inspection, and approval of the first article.

6.4 Standard sample. For access to standard samples and pattern drawings, address the contracting activity issuing the invitation for bids or request for proposal.

6.5 Definitions. Striation – a thin line or band, especially one of several that are parallel and/or close together.

6.6 Steel. Steel is no longer used in the production of items covered by this specification. Type I, Class 2 buckles and Type III, Class 4 clips have therefore been deleted from this specification.

6.7 Subject term (keyword) listing.
Copper alloy
Oxidized
Gold plating
Lacquer

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

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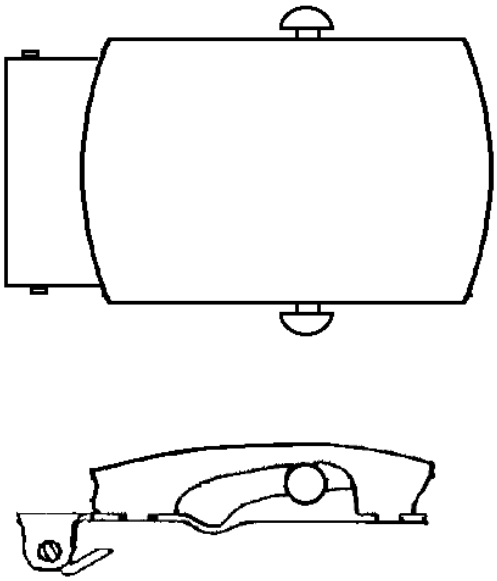

For information only. See Drawing 2-4-57 for design details and detailed dimensions.

FIGURE 1. Type I Buckle.

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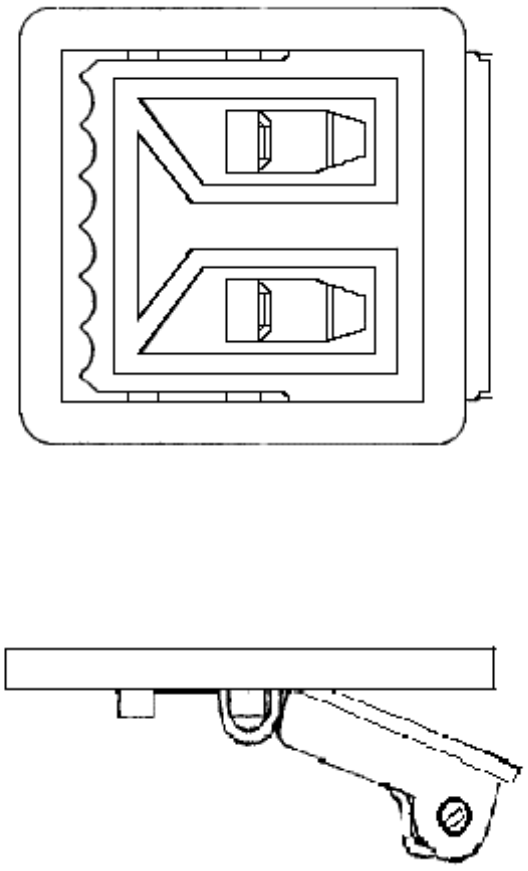

For information only. See Drawing 4-1-436 for design details and detailed dimensions.

FIGURE 2. Type II, Class 1 Buckle.

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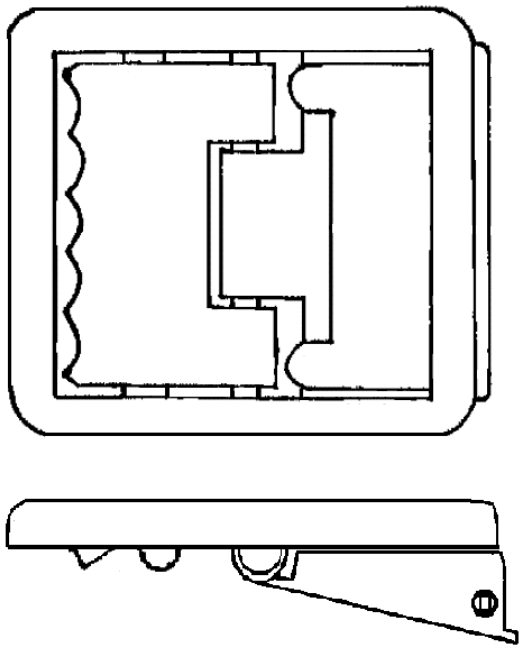

For information only. See Drawing 2-4-64 for design details and detailed dimensions.

FIGURE 3. Type II, Class 3 Buckle.

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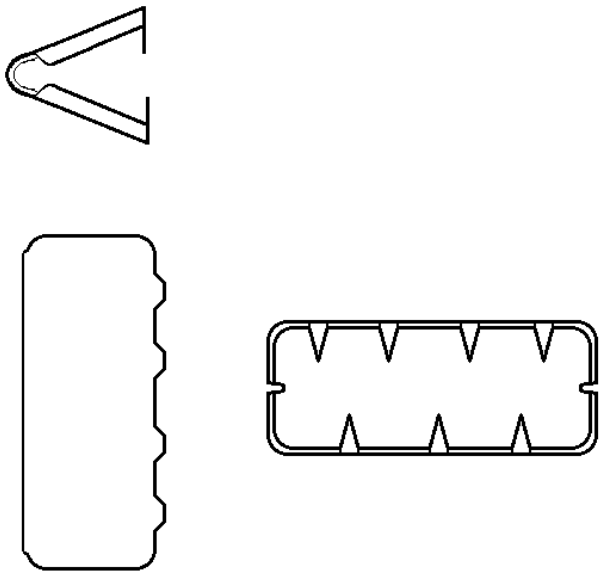

For information only. See Drawing 2-4-58 for design details and detailed dimensions.

FIGURE 4. Type III clip.

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Custodian
Army – GL
Navy – NU
Air Force – 11

Preparing Activity
DLA - CT

Project: 8315-2019-007

Review Activities
Army – IH
Navy – CG, MC

NOTE: The activities listed above were interested in this document as of the date of this document. Since organizations and responsibilities can change, you should verify the currency of the information above using ASSIST Online database at https://assist.dla.mil .

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