

SPECIFICATION FOR FABRIC, GREEN, COATED,
FOR UNITED STATES PASSPORT

Property No. 291439

General Requirements

The fabric shall be coated with pyroxylin, acrylic, polyurethane, or other non-migratory resin. The surface and finish must be soft and pliable and shall not crack when bent sharply. It shall have no tendency to stick when pressed between newsboard for a period of 24 hours. The surface shall not be oily and must be suitable for heat stamping with imitation gold stamping foil.

The fabric must be properly treated to lay flat and have sufficient stiffness for use on the Uno automatic passport binding line. The back surface, however, must be receptive to a water-based polyvinyl acetate emulsion adhesive used to bond the end sheet.

Specific Requirements

Size of sheet.....16-7/16" x 7-7/16" \pm 1/16" each direction
417.5 mm x 189.0 mm \pm 1.5 mm

Grain.....long direction

Thickness.....0.014" \pm 10% (0.356 mm \pm 10%)

Composition.....100% cotton

Weave.....2/1 drill

Ply.....single

Weight, finished cloth.....10 ounces per square yard (338 g/m²) \pm 10%

Weight, base cloth.....5.0 ounces per square yard (169 g/m²) minimum

Thread count.....100 per square inch (40 per square cm)

Breaking strength (strip method)

warp: 80 pounds per inch min.
(14.0 kN/M)

filling: 50 pounds per inch min.
(8.8 kN/M)

Porosity.....15 sec. min.

Color.....Green, close visual match to PMS 553C.

Embossing.....Skiver

Gloss.....medium

Fade resistance: 72 hours, no fade, Atlas Fadeometer with enclosed carbon arc lamp at 60°C.

Laminator Test

The coating shall be capable of withstanding temperatures of up to 350°F (177°C) for a period of 45 seconds without affecting the surface of the coating when going through a laminating machine as used by the State Department for issuing passports. Scratches or marks on the surface of the cover resulting from the lamination process shall constitute failure of the test.

Adhesion of Coating

The coating of a 6" by 6" (152 mm by 152 mm) sample cut 45 degrees to the warp or filling direction, clamped between 1" by 2" jaws under a load of 30 pounds (13.6 kg) for 30 seconds shall show no cracks, breaks, or pinholes.

Packaging

The sheets are to be packaged on a skid (not a pallet) using the following procedures.

1. The sheets on the bottom of the skid should lay on a type of material that will protect them from being damaged or adversely affected by the boards or nails in the boards.
2. The sheets shall be completely and securely wrapped in heavy weight kraft paper or asphalt laminated paper or heavy corrugated paper in such a manner as to be protected from moisture and damage from other environmental factors.
3. There shall be no overhang of the sheets on the skids. The sheets shall be placed flush to the edge of the skids in such a manner that no handling problems will develop in the productions of passports.
4. The skids shall be banded four ways and when the bands are removed they should leave no crimp marks on the edges or surface of the sheets which would adversely affect the quality of the finished passport.
5. The total weight of the skids shall not exceed 2500 pounds (1200 kg).
6. The runners of the skids shall be made of a solid piece of 2" x 8" wood and shall not be made of pieces of wood nailed together to form a runner.
7. Each skid shall have ten lifts or layers. Each lift is to contain 3000 sheets which shall be wrapped in moisture proof material. The 3000 sheets per lift are to consist of 10 bundles of 300 sheets per bundle.
8. The stacked sheets on the skid should not stick together or become blocked as a result of applied pressure.

SAMPLE:

A sample of at least 100 sheets of the size specified above is required for laboratory tests and production of sample books.

Date of last revision: February 8, 1993.

SPECIFICATION FOR FABRIC, BLUE, COATED,
FOR UNITED STATES PASSPORT

Property No. 294551

General Requirements

The fabric shall be coated with pyroxylin, acrylic, polyurethane, or other non-migratory resin. The surface and finish must be soft and pliable and shall not crack when bent sharply. It shall have no tendency to stick when pressed between newsboard for a period of 24 hours. The surface shall not be oily and must be suitable for heat stamping with imitation gold stamping foil.

The fabric must be properly treated to lay flat and have sufficient stiffness for use on the Uno automatic passport binding line. The back surface, however, must be receptive to a water-based polyvinyl acetate emulsion adhesive used to bond the end sheet.

Specific Requirements

- Size of sheet.....16-7/16" x 7-7/16" ± 1/16" each direction
417.5 mm x 189.0 mm ± 1.5 mm
- Grain.....long direction
- Thickness.....0.014" ± 10% (0.356 mm ± 10%)
- Composition.....100% cotton.
- Weave.....2/1 drill
- Ply.....single
- Weight, finished cloth.....10 ounces per square yard (338 g/m²) ±10%
- Weight, base cloth.....5.0 ounces per square yard (169 g/m²) minimum
- Thread count.....100 per square inch (40 per square cm)

- Breaking strength (strip method),
warp: 80 pounds per inch min.
(14.0 kN/M)
- filling: 50 pounds per inch min.
(8.8 kN/M)

- Porosity.....15 sec. min.

- Color.....Blue, to match GPO standard

- Embossing.....Skiver

- Gloss.....medium

- Fade resistance: 72 hours, no fade, Atlas Fadeometer with enclosed carbon arc lamp at 60°C.

Laminator Test

The coating shall be capable of withstanding temperatures of up to 350°F (177°C) for a period of 45 seconds without affecting the surface of the coating when going through a laminating machine as used by the State Department for issuing passports. Scratches or marks on the surface of the cover resulting from the lamination process shall constitute failure of the test.

Adhesion of Coating

The coating of a 6" by 6" (152 mm by 152 mm) sample cut 45 degrees to the warp or filling direction, clamped between 1" by 2" jaws under a load of 30 pounds (13.6 kg) for 30 seconds shall show no cracks, breaks, or pinholes.

Packaging

The sheets are to be packaged on a skid (not a pallet) using the following procedures.

1. The sheets on the bottom of the skid should lay on a type of material that will protect them from being damaged or adversely affected by the boards or nails in the boards.
2. The sheets shall be completely and securely wrapped in heavy weight kraft paper or asphalt laminated paper or heavy corrugated paper in such a manner as to be protected from moisture and damage from other environmental factors.
3. There shall be no overhang of the sheets on the skids. The sheets shall be placed flush to the edge of the skids in such a manner that no handling problems will develop in the productions of passports.
4. The skids shall be banded four ways and when the bands are removed they should leave no crimp marks on the edges or surface of the sheets which would adversely affect the quality of the finished passport.
5. The total weight of the skids shall not exceed 2500 pounds (1200 kg).
6. The runners of the skids shall be made of a solid piece of 2" x 8" wood and shall not be made of pieces of wood nailed together to form a runner.
7. Each skid shall have ten lifts or layers. Each lift is to contain 3000 sheets which shall be wrapped in moisture proof material. The 3000 sheets per lift are to consist of 10 bundles of 300 sheets per bundle.
8. The stacked sheets on the skid should not stick together or become blocked as a result of applied pressure.

Sample

A sample of at least 100 sheets of the size specified above is required for laboratory tests and production of sample books.

Date of last revision: January 5, 1994.