

INCH-POUND

MIL-C-44130C(GL)  
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SUPERSEDING  
MIL-C-44130B(GL)  
21 December 1988

## MILITARY SPECIFICATION

CAP, GARRISON, WOMEN'S, POLYESTER/WOOL, AG-344

This specification is approved for use by the Natick Research, Development, and Engineering Center, Department of the Army, and is available for use by all Departments and Agencies of the Department of Defense.

### 1. SCOPE

1.1 Scope. This specification covers a polyester/wool serge cloth cap for female personnel.

1.2 Classification. The caps shall be of one type in the following classes and sizes (see 6.2).

Class 1 - General Officers  
Class 2 - Officers  
Class 3 - Warrant Officers  
Class 4 - Enlisted Personnel

#### Schedule of sizes

20	23
20-1/2	23-1/2
21	24
21-1/2	24-1/2
22	25
22-1/2	

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be used in improving this document should be addressed to: U.S. Army Natick Research, Development, and Engineering Center, Natick, MA 01760-5019 by using the Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8410

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## 2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 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 listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

## SPECIFICATIONS

## FEDERAL

- A-A-50199 - Thread, Polyester Core: Cotton- or Polyester-Covered
- CCC-C-476 - Cloth, Bunting, Nylon; and Nylon and Wool
- DDD-L-20 - Label: For Clothing, Equipage and Tentage,  
(General Use)
- PPP-B-636 - Boxes, Shipping, Fiberboard

## MILITARY

- MIL-C-823 - Cloth, Serge; Wool, Wool and Nylon, Polyester and Wool
- MIL-B-1667 - Braid, Textile, Cord-Edge
- MIL-L-35078 - Loads, Unit: Preparation of Semiperishable Subsistence Items; Clothing, Personal Equipment and Equipage; General Specification For

## STANDARDS

## FEDERAL

- FED-STD-191 - Textile Test Methods
- FED-STD-751 - Stitches, Seams, and Stitchings

## MILITARY

- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
- MIL-STD-129 - Marking for Shipment and Storage
- MIL-STD-147 - Palletized Unit Loads
- MIL-STD-731 - Quality of Wood Members for Containers and Pallets
- MIL-STD-902 - Provisions for Evaluating Quality of Caps, Garrison, Women's

(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from the Standardization Documents Order Desk, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.)

2.2 Non-Government publications. The following documents form a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DOD adopted are those listed in the issue of the DODISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of the documents cited in the solicitation (see 6.2).

THE COLOR ASSOCIATION OF THE UNITED STATES

Standard Color Card of America

Department of Defense Standard Color Card for Sewing Threads

(Application for color cards should be addressed to the Color Association of the United States, 343 Lexington Avenue, New York, NY 10016-0927. If color cards are not available from the Color Association, individual color samples may be obtained from the contracting activity or as directed by the contracting activity.)

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

D 3951 - Standard Practice for Commercial Packaging

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103-1187.)

(Non-Government standards and other publications are normally available from organizations that prepare or distribute the documents. These documents also may be available in or through libraries or other informational services.)

2.3 Order of precedence. 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), a sample shall be subjected to first article inspection (see 6.3) in accordance with 4.3.

3.2 Samples.

3.2.1 Guide sample. Guide samples, when furnished, are solely for guidance and information to the contractor (see 6.4). Variation from this specification may appear in the sample, in which case this specification shall govern.

3.2.2 Standard sample. The finished cap shall match the standard sample for shade and shall be equal to or better than the standard sample with respect to all characteristics for which the standard sample is referenced (see 6.4).

3.3 Material. It is encouraged that recycled material be used when practical as long as it meets the requirements of this specification.

3.3.1 Basic material. The basic material for the cap shall be polyester and wool, Army Green 489, type III, class 3, conforming to MIL-C-823.

3.3.2 Laminate interlining. The interlining for the cap shall be a polyester foam with nylon tricot laminate having a weight of 0.6 to 1 ounce per square yard, and shall be prebonded to the basic material. Under no circumstance shall the dry heat temperature of the lamination process exceed  $315^{\circ}\text{F} \pm 6^{\circ}\text{F}$  when applying the foam/knit to the basic material. The thickness of the bonded foam/knit/basic material shall not exceed 0.05 when tested as specified in 4.4.1.1. The color of the nylon tricot shall be black and the color of the foam shall be either black or charcoal. The laminate interlining shall meet the initial bonding strength and preproduction dry-clean testing requirements in 3.3.2.1 and 4.4.2.1.

3.3.2.1 Interlining bond strength. The foam/knit laminate, after being bonded to the basic material, shall conform to the following bond strength requirements when tested as specified in 4.4.1.1.

<u>Bond strength (minimum)</u>	<u>Ounces (per inch width)</u>
Initial	12

3.3.3 Nylon bunting. The nylon bunting for the sweatband shall be dyed black and shall conform to type I, class A of CCC-C-476, except that the color-fastness therein shall not apply. The dyed bunting shall show "good" fastness to dry cleaning, perspiration, and crocking when tested in accordance with the methods specified in 4.4.1.1.

3.3.4 Braid. The braid for classes 1, 2, 3, and 4 caps shall conform to the requirements of classes 1, 2, 3, and 4 of MIL-B-1667, respectively.

3.3.5 Thread. The thread for stitching shall be cotton-covered polyester core, ticket number 40-2 or 3 ply, 50-2 ply, and 70-2 ply, conforming to A-A-50199. The thread shall be dyed Green E, C.A. 66034. Stitching which appears on the headband shall be black. The dyed thread shall show fastness to wet-dry cleaning, light, and perspiration.

3.4 Identification and size label. Each cap shall have a combination identification-size label conforming to type VI, class 4 of DDD-L-20. The label shall show "good" fastness to dry cleaning. The label shall contain the instructions "DRY CLEAN ONLY. PRESSING/IRON TEMPERATURE WITH STEAM SHALL BE  $325^{\circ}\text{F} \pm 6^{\circ}\text{F}$  OR USE WOOL SETTING WITH STEAM." in 1/8 inch maximum height lettering.

3.5 Design. The design of the caps shall be as shown on figure 1.

3.6 Patterns. Patterns which provide a 1/4 inch allowance for all seams, unless otherwise specified, will be furnished by the Government to the contractor for cutting working patterns. The Government patterns shall not be altered in any way and are to be used only as a guide for cutting the contractor's working patterns. The contractor may make minor alterations to his working patterns to suit his method of manufacture. However, the finished cap must meet the finished measurements as specified in table III and shall possess the desired finished appearance.

3.6.1 List of pattern parts. The components of the cap shall be cut from the materials specified according to the pattern parts indicated in table I.

TABLE I. Pattern parts

Material	Pattern nomenclature	Cut parts
Basic material with prebonded interlining (foam/knit laminate)	Crown <u>1/</u>	1
	Curtain	1
	Side panel	2

1/ Contractor may trim off front point indicated at cut line.

### 3.7 Construction.

3.7.1 Stitches, seams, and stitching. Stitches, seams, and stitching types specified in table II shall conform to FED-STD-751. Where two or more seam or stitch types are given for the same part of an operation, any one of them may be used. When stitch type 401 is used, the looper (underthread) shall be on the inside of the cap. Seam allowance shall be maintained with seams sewn so that raw edges, run-offs, twists, pleats, or puckers will not result. All seams shall start and finish evenly. Ends of a continuous line of stitching shall be overlapped not less than 1/2 inch. The ends of the label stitching shall be overlapped not less than three stitches.

3.7.1.1 Type 301 stitching. Ends of all seams and stitching produced with 301 stitch type, when not caught in other seams or stitching, shall be backtacked or overstitched not less than 1/2 inch. Thread tension shall be maintained so that there will be no loose stitching resulting in loose bobbin or top thread or excessively tight stitching resulting in puckering of the materials sewn. The lock shall be embedded in the materials sewn.

3.7.1.1.1 Repairs of type 301 stitching. Repairs of type 301 stitching shall be as follows:

a. When thread breaks or bobbin run-outs occur during stitching, the stitching shall be repaired by restarting the stitching a minimum of 1/2 inch back of the end of the stitching. 1/

b. Thread breaks or two or more consecutive skipped or run-off stitches noted during inspection of the item shall be repaired by overstitching. The stitching shall start a minimum of 1/2 inch in back of the defective area and continue a minimum of 1/2 inch beyond the defective area onto the existing stitching. Loose or excessively tight stitching shall be repaired by removing the defective stitching without damaging the materials and restitching in the required manner. 1/

1/ When making the above repairs, the ends of the stitching are not required to be backstitched.

3.7.1.2 Types 101, 301, 401, 406, 503, 504, and 505. Thread tension shall be maintained so that there will be no loose stitching. All repairs shall be in accordance with 3.7.1.1.1a and 3.7.1.1.1b. Repairs to stitch type 401 may be accomplished by use of stitch type 301.

3.8 Use of automated apparel equipment. Automated apparel equipment may be used to perform any of the operations specified in table II, providing that the seam and stitch type are as specified and the finished component conforms to the required configuration. When a Government furnished shaper pattern is forwarded, the component shall conform to that pattern.

3.9 Manufacturing operations requirements. The cap shall be manufactured in accordance with all operations specified in table II. The contractor is not required to follow the exact sequence of operations listed, unless otherwise specified. Any additional basting or holding stitches used to facilitate manufacture are permissible provided the threads are removed or do not show on the finished cap.

3.9.1 Figure 1. Figure 1 is furnished for guidance and information purposes only. If there are any inconsistencies between the written specification and the figure, the written specification shall govern.

NO.	TABLE II. MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
1.	<u>Cut components</u> a. Cut the cap components from the prebonded material in strict accordance with furnished patterns, which show size, shape, directional lines, and notches for proper assembly of all parts. b. Cut the nylon bunting for sweatbands on the bias 1 inch wide.						
2.	<u>Replacement of damaged parts</u> During the spreading, cutting, and manufacturing process, components having material defects or damages that are classified as defects in MIL-STD-902, as specified in 4.4.1, shall be removed from production and replaced with non-defective and properly matched components.						
3.	<u>Marking and bundling.</u> a. Mark, ticket, or bundle all components of the cap to ensure a uniform shade, color pattern, and size throughout the cap. b. Any method of marking may be used except: (1) Corrosive metal fastening devices. (2) Sew-on tickets. (3) Adhesive type tickets which leave traces of adhesive on the material after removal of the tickets.						

NO.	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
4.	<u>Attach label</u>  Position the combination label on the inside left laminate side panel (as worn) 3/4 inch above the bottom raw edge and stitch 1/16 to 1/8 inch from edge on all four sides. Stitching shall not extend above curtain on finished cap.	301	LSbj-1	10-14	50 or 70	50 or 70	
5.	<u>Make crown</u>  Fold crown in half lengthwise, face to face. Stitch fold 1/2 + 1/16 inch deep at center, tapering to nothing 1/2 to 3/4 inch from each end and securely backtack.	301	OSf-1	10-14	50	50	
6.	<u>Make sides</u>  a. Position the outershell side panels face to face with edges even. Stitch each end (front and back) from bottom edge to notch at top.  b. Open front seam and raise stitch 1/16 to 1/8 inch on each side of seam.	301	SSz-3(a)	12-14	50	50	
7.	<u>Join panels to crown</u>  a. Position top of side panels to crown, face to face. Stitch together, matching the notch at front of crown to center front. Join seam of the side panels, and the point at back end of crown to center back.	301 or 401	SSa-1	12-14	50	50	



NO.	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	BOBBIN/ LOOPER	COVER
7.	<p><u>Join panels to crown (cont'd)</u></p> <p>b. Spread back seam open and raise stitch 1/16 to 1/8 inch from joining seam beginning at bottom, and crossing over at notch in crown. With seam allowance at top of crown turned towards inside, continue raise stitching around crown and down opposite side of back seam.</p> <p>c. Turn cap right side out, smoothing out all points and seams. Press cap smooth and flat with a heated pressing machine or a heated steam iron.</p>	301 or 401	SSz-3(b) and LSar-2(b)	12-14	50	50	
8.	<p><u>Join braid to curtain</u></p> <p>a. With tape edge of braid and top edge of curtain even, stitch at base of braid the length of curtain, ensuring that stitching does not go through the cord edge of the braid.</p> <p>NOTE: Operation 8.a may be omitted provided that the top of the curtain is positioned tightly against the cord edge of the braid in the finished cap.</p> <p>b. Turn the braid to the wrong side and stitch to the curtain with a double row of stitching 1/8 to 3/16 inch from the edge.</p> <p>c. Press curtain smooth and flat with a heated pressing machine or a heated steam iron.</p>	301 or 401 or 101	LSq-3(a)	12-14	50	50	
		301 or 401 or 406	LSq-3(b)	12-14	50	50	

NO.	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
9.	<p><u>Join curtain to panel</u></p> <p>a. Overlap the ends of the curtain (left side over right side of cap as worn), and match with the front and back seams of the panels in the position worn. Join together as indicated by pattern notches. Sew the left end of the curtain slightly full from the notch to the end to avoid a tight edge when the cap folds at the front.</p> <p>NOTE: The curtain shall cross itself at the front seam of the caps; a tolerance of 1/4 inch from the exact alignment will be allowed.</p> <p>b. The bottom of side panels and curtains shall be aligned so that the notches and seams coincide. Stitch in place.</p> <p>c. Turn curtain down and side panel seam under side panel and raise stitch 1/8 to 3/16 inch on side panel. Stitching shall not go thru the curtain.</p>	301 or 401 or 101	SSa-1	6-8	50	50	
10.	<p><u>Attach sweatband.</u></p> <p>The sweatband shall be uniformly stitched, and finished smooth and flat, without twists, gathers, puckers, pleats or raw edges.</p> <p>a. Cut sweatband to size. The edges of the sweatband shall be folded under 1/4 inch on each side, producing a finished sweatband width of 1/2 inch. The sweatband may be commercially cut, folded, and put on rolls. The splice shall be sewn with the raw edges turned to the inside.</p>	101 or 301 or	LSq-2(a) 401	6-8	50	50	
		301 or 401	LSq-2(b)	6-8	50	50	

NO.	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
10.	<p><u>Attach sweatband.</u> (cont'd)</p> <p>b. With curtain turned down, position bottom turned edge of sweatband on line of stitching created by joining panel to curtain. Sweatband shall cover raw edges of curtain and side panels. Stitch sweatband on both sides 1/32 to 1/16 inch from edges.</p> <p>c. Overlap ends of sweatband for about 1 inch. Ends shall not overlap at the back seam of the cap. One of the following operations shall be used:</p> <p>(1) Turn top end under 1/4 to 1/2 inch and stitch.</p> <p>(2) Overedge the edge of top end.</p> <p>(3) Stitch ends 1/4 inch beyond edge and back tack.</p>	301	SSat-2	10-14	50	50	
11.	<p><u>Cleaning.</u></p> <p>a. Trim all thread ends</p> <p>b. Remove all loose threads, spots, stains, and shade, color, and size markings.</p>	301 503 or 504 or 505	SSat-2 EFd-1	10-14 8-10	50 70	50 70	
12.	<p><u>Pressing.</u></p> <p>a. On the inside of cap, press smooth and flat with a heated pressing machine or a heated steam iron, forming a crease on the bottom edge.</p>	301	SSat-2	10-14	50	50	

NO.	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
12.	<p><u>Pressing.</u> (cont'd)</p> <p>b. The entire cap may be touched up as necessary, using steam, to remove all wrinkles and unwanted creases.</p> <p>c. Remove all gloss and pressing impressions by using live steam.</p>						

3.10 Finished measurements. The finished caps shall conform to the finished measurements shown in table III.

TABLE III. Finished measurements in inches 1/

	Measurement	Cap size	Tolerance
Center front (A) <u>1/</u>	3-1/2	20 to 25	$\pm 1/8$
Center back (B) <u>1/</u>	2-1/4	20 to 25	$\pm 1/8$
Overall at side center (C) <u>1/</u>	4	20 to 25	$\pm 1/8$
Center front (D) <u>2/</u>	2-7/8	20 to 25	$\pm 1/8$
Side (E) <u>2/</u>	3-1/8	20 to 25	$\pm 1/8$
Center back (F) <u>2/</u>	1-7/8	20 to 25	$\pm 1/8$
Top crown (G) <u>2/</u>	3	20 to 25	$\pm 1/8$
Circumference <u>3/</u>	20	20	$\pm 1/4$
	20-1/2	20-1/2	$\pm 1/4$
	21	21	$\pm 1/4$
	21-1/2	21-1/2	$\pm 1/4$
	22	22	$\pm 1/4$
	22-1/2	22-1/2	$\pm 1/4$
	23	23	$\pm 1/4$
	23-1/2	23-1/2	$\pm 1/4$
	24	24	$\pm 1/4$
	24-1/2	24-1/2	$\pm 1/4$
	25	25	$\pm 1/4$

- 1/ The overall height measurements of the panels shall be taken at the front (A), the back (B), and the side (C) where the front lap-over terminates from the bottom folded edge of the curtain to the crown joining seam (see figure 1).
- 2/ The finished measurements of the height of the curtain shall not include the braid and be taken at the front (D), at side where the front lap-over terminates from the bottom folded edge of the curtain to the top edge of the curtain (E), and the back (F). The top crown (G) shall be measured at the widest part of the cap (see figure 1).
- 3/ The finished measurement for the circumference shall be taken with a gage.

3.11 Workmanship. The finished cap shall conform to the quality of product established by this specification and the occurrence of defects shall not exceed the applicable point values.

#### 4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements (examinations and tests) as specified herein. Except as otherwise specified in the contract or purchase order, the contractor may use his own or any 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 this specification where such inspections are deemed necessary to ensure supplies and services conform to prescribed requirements.

4.1.1 Responsibility for compliance. All items shall meet all requirements of sections 3 and 5. 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 ensuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations, is an acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to accept defective material.

4.1.2 Responsibility for dimensional requirements. Unless otherwise specified in the contract or purchase order, the contractor is responsible for ensuring that all specified dimensions have been met. When dimensions cannot be examined on the end item, inspection shall be made at any point, or at all points in the manufacturing process necessary to ensure compliance with all dimensional requirements.

4.1.3 Certificates of compliance. When certificates of compliance are submitted, the Government reserves the right to inspect such items to determine the validity of the certification.

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

- a. First article inspection (see 4.3).
- b. Quality conformance inspection (see 4.4).

4.3 First article inspection. When a first article is required (see 3.1 and 6.2), it shall be examined for the applicable end item visual and dimensional defects in accordance with the sampling and inspection provisions of MIL-STD-902.

4.4 Quality conformance inspection. Unless otherwise specified, sampling for inspection shall be performed in accordance with MIL-STD-105.

4.4.1 Component and material inspection. In accordance with 4.1, components and materials shall be inspected in accordance with all the requirements of referenced documents unless otherwise excluded, amended, modified, or qualified in this specification or applicable purchase document.

4.4.1.1 Component and material certification. A certificate of compliance may be acceptable as evidence that the characteristics listed in table IV conform to the specified requirements when tested by the specified methods.

TABLE IV. Component and material tests

Material	Characteristic	Requirement paragraph	Test method
Foam/knit laminate	Weight	3.3.2	5041 <u>1/</u>
	Thickness	3.3.2	5030 <u>1/</u>
	Bond strength	3.3.2.1	5951 <u>1/</u>
Sweatband, nylon bunting	Colorfastness to:		
	Dry cleaning	3.3.3.1	5620 <u>1/</u>
	Perspiration	3.3.3.1	5680 <u>1/</u>
	Crocking	3.3.3.1	5651 <u>1/</u>

1/ Refers to test method in FED-STD-191.

4.4.2 In-process inspection. Inspection of subassemblies for the class 1 and 2 caps shall be made to ascertain that the stitching does not go through the cord edge of the braid in accordance with the specified requirements. After the completion of operation 8.a., 15 percent of each hours production of the curtain from each stitching machine shall be randomly selected and inspected. The finding of any stitching in the cord edge shall be cause for rejection of the lot. The Government reserves the right to exclude from consideration for acceptance, any material or service for which in-process inspection has indicated nonconformance.

4.4.2.1 Interlining preproduction dry clean test. Prior to production of any caps, a 12 inch by 12 inch swatch of foam interlining material, as described in 3.3.2, shall be randomly cut from a lot of material representative of 1,000 caps in the end item lot. The swatch shall be commercially dry cleaned three times using perchlorethylene solvent 4 to 6 pound load with ballast at 6 to 9 minutes and bottom steam pressed in the nonlocked position for 20 seconds and vacuum for 10 seconds after each of the three dry cleanings. As an alternate, Method 5580 of FED-STD-191 may be utilized, with bottom steam pressing in a nonlocked position for 20 seconds and vacuum for ten seconds. One specimen shall represent the preproduction lot of 1,000 caps, and the shrinkage need not be

calculated. In addition, perchlorethylene shall be used in lieu of stoddard solvent as a dry cleaning agent. The specimen shall be placed in the tumble jar, and 25 mL of soap solution, and 250 mL of perchlorethylene shall be added. The tumble jar shall be operated on the soap cycle for 5 minutes, on a single 3-minute rinse cycle, and then the specimen shall be air dried.

4.4.3 Point count inspection. Sampling and inspection provisions for end item visual examination, dimensional examination, and packaging examination shall be performed in accordance with MIL-STD-902.

4.4.4 Palletization examination. The fully packaged and palletized end items shall be examined for the defects listed below. The lot size shall be expressed in units of palletized unit loads. The sample unit shall be one palletized unit load, fully packaged. The inspection level shall be S-1 and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 6.5.

<u>Examine</u>	<u>Defect</u>
Finished dimensions	Length, width, or height exceeds specified maximum requirement
Palletization	Pallet pattern not as specified Load not bonded as specified
Weight	Exceeds maximum load limits
Marking	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application

## 5. PACKAGING

5.1 Preservation. Preservation shall be level A or Commercial as specified (see 6.2).

### 5.1.1 Level A preservation.

5.1.1.1 Unit packing. Each cap shall be placed in a flat-style clear polyethylene film bag of 0.00125-inch thickness ( $\pm$  25 percent tolerance). The polyethylene film bag shall be formed with heat-sealed seams that are straight, continuous, and parallel to each other and to the formed edges of the bag. The bag shall be at least 1 inch greater in length than the cap. The unsealed opening shall be at the smallest dimension of the bag.

5.1.2 Commercial preservation. The caps shall be preserved in accordance with ASTM D 3951.

5.2 Packing. Packing shall be level A, B, or Commercial as specified (see 6.2).



5.2.1 Level A packing. One hundred caps, preserved as specified in 5.1, shall be packed in a shipping container conforming to style RSC-L, grade V2s of PPP-B-636. The caps shall be arranged in two rows of fifty. Inside dimensions of the box shall be approximately 21-1/2 inches in length, 19-1/2 inches in width, and 4 inches in depth for sizes 20 through 22-1/2, and 23-1/2 inches in length, 19-1/2 inches in width, and 4 inches in depth for sizes 23 through 25. The two rows of caps shall be separated by a corrugated fiberboard partition having dimensions of 19-1/2 inches by 4 inches. Each box shall be closed, waterproofed, and reinforced in accordance with the appendix of PPP-B-636. Boxes shall be arranged in unit loads in accordance with MIL-L-35078 for the type and class of load specified (see 6.2). Strapping shall be limited to nonmetallic strapping, except for type II, class F loads.

5.2.2 Level B packing. One hundred caps, preserved as specified in 5.1, shall be packed in a shipping container conforming to style RSC-L, type CF (variety SW) or SF, class domestic, grade 275 of PPP-B-636. The caps shall be arranged in two rows of fifty. Inside dimensions of the box shall be approximately 21-1/2 inches in length, 19-1/2 inches in width, and 4 inches in depth for sizes 20 through 22-1/2; and 23-1/2 inches in length, 19-1/2 inches in width, and 4 inches in depth for sizes 23 through 25. The two rows of caps shall be separated by a corrugated fiberboard partition having dimensions of 19-1/2 inches by 4 inches. Each box shall be closed in accordance with method II as specified in the appendix of PPP-B-636.

5.2.2.1 Weather-resistant container. When specified (see 6.2), the container shall be a grade V3c, V3s, and V4s fiberboard box fabricated in accordance with PPP-B-636 and closed in accordance with the appendix of PPP-B-636.

5.2.3 Commercial packing. Caps, preserved as specified in 5.1, shall be packed in accordance with ASTM D 3951.

5.3 Palletization. When specified (see 6.2), caps, packed as specified in 5.2.2 or 5.2.3, shall be palletized on a 4-way entry pallet in accordance with load type Ia of MIL-STD-147. Pallet type shall be type I (4-way entry), type IV or type V in accordance with MIL-STD-147. Pallets shall be fabricated from wood groups I, II, III, or IV of MIL-STD-731. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding means C and D or film bonding means F or G. Pallet pattern shall be number 86 in accordance with the appendix of MIL-STD-147.

5.4 Marking. In addition to any special marking required by the contract or purchase order, unit packs, shipping containers, and palletized unit loads shall be marked in accordance with MIL-STD-129 or ASTM D 3951, as applicable.

## 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 caps are intended for wear by female personnel of the Department of the Army.

6.2 Acquisition requirements. Acquisition documents must specify the following:

- a. Title, number, and date of this specification.
- b. Class and size required (see 1.2).
- c. Issue of DODISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.1.1 and 2.2).
- d. When a first article is required (see 3.1, 4.3, and 6.3).
- e. Levels of preservation and packing (see 5.1 and 5.2).
- f. Type and class of unit load required (see 5.2.1).
- g. When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).
- h. When palletization is required (see 5.3).

6.3 First article. When a first article is required, it shall be inspected and approved under the appropriate provisions of FAR 52.209. 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 also include specific instructions in acquisition documents regarding arrangements for selection, inspection, and approval of the first article.

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

6.5 Subject term (key word) listing.

Clothing  
Hat  
Headgear  
Uniform

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

Custodian:

Army - GL

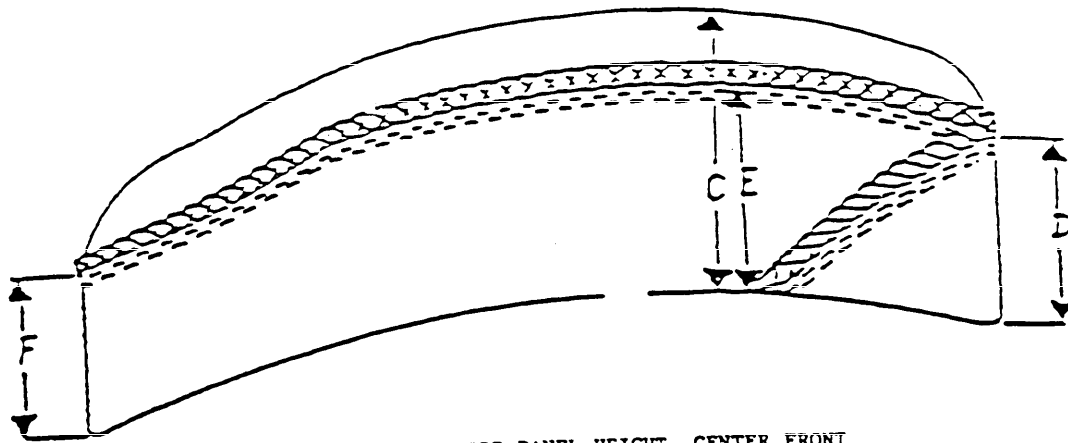
Review activities:

Army - MD  
DLA - CT

Preparing activity:

Army - GL

(Project 8410-A757)



- A SIDE PANEL HEIGHT, CENTER FRONT
- B SIDE PANEL HEIGHT, CENTER BACK
- C PANEL, OVERALL AT SIDE CENTER
- D CURTAIN HEIGHT, CENTER FRONT
- E SIDE OVERALL, CURTAIN
- F CURTAIN HEIGHT, CENTER BACK
- G TOP CROWN

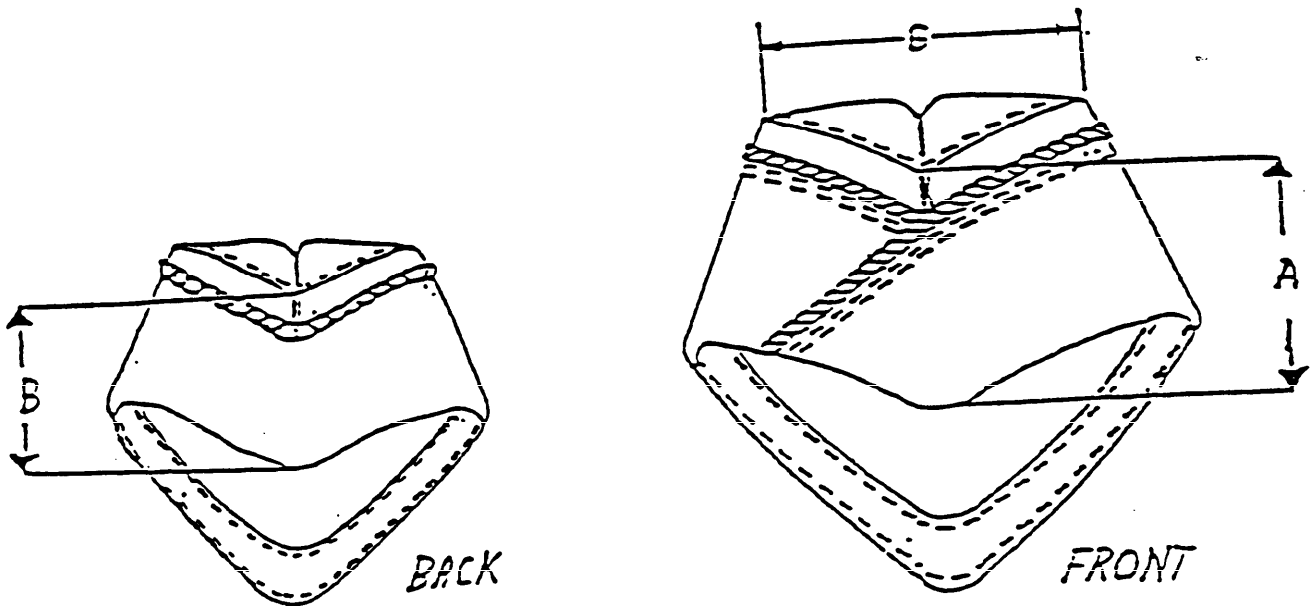


FIGURE 1 - Cap, Garrison, Women's, Polyester/Wool, AG-344

# STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

## INSTRUCTIONS

1. The preparing activity must complete blocks 1, 2, 3, and 8. In block 1, both the document number and revision letter should be given.
2. The submitter of this form must complete blocks 4, 5, 6, and 7.
3. The preparing activity must provide a reply within 30 days from receipt of the form.

NOTE: This form may not be used to request copies of documents, nor to request waivers, or clarification of requirements on current contracts. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements.

<b>I RECOMMEND A CHANGE:</b>	<b>1. DOCUMENT NUMBER</b> MIL-C-44130C (GL)	<b>2. DOCUMENT DATE (YYMMDD)</b> 1991 January 11
<b>3. DOCUMENT TITLE</b> CAP, GARRISON, WOMEN'S, POLYESTER/WOOL, AG-344		
<b>4. NATURE OF CHANGE</b> <i>(Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)</i>		
<b>5. REASON FOR RECOMMENDATION</b>		
<b>6. SUBMITTER</b>		
<b>a. NAME (Last, First, Middle Initial)</b>	<b>b. ORGANIZATION</b>	
<b>c. ADDRESS (Include Zip Code)</b>	<b>d. TELEPHONE (Include Area Code)</b> (1) Commercial (2) AUTOVON (if applicable)	<b>7. DATE SUBMITTED (YYMMDD)</b>
<b>8. PREPARING ACTIVITY</b>		
<b>a. NAME</b> U.S. Army Natick RD&E Center	<b>b. TELEPHONE (Include Area Code)</b> (1) Commercial 508-651-4532 (2) AUTOVON 256-4532	
<b>c. ADDRESS (Include Zip Code)</b> Commander, U.S. Army Natick RD&E Center ATTN: STRNC-IRT Natick, MA 01760-5019	<b>IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT:</b> Defense Quality and Standardization Office 5203 Leesburg Pike, Suite 1403, Falls Church, VA 22041-3466 Telephone (703) 756-2340 AUTOVON 289-2340	