

INCH-POUND

MIL-C-3261F(USAF)

22 September 1989

SUPERSEDING

MIL-C-3261E(USAF)

16 January 1980

## MILITARY SPECIFICATION

## CAP, GARRISON, MAN'S, AIR FORCE. BLUE

This specification is approved for use by the Department of the Air Force, and is available for use by all Departments and Agencies of the Department of Defense.

## 1 SCOPE

1.1 Scope This specification covers the requirements for a man's Air Force, garrison, (flight) cap

1.2 Classification The cap shall be of the following types and classes, as specified (see 6 2)

Type I - Texturized polyester serge cloth, 6 5 oz . USAF Blue 1598

Class 1 - General Officers

Class 2 - Officers

Class 3 - Enlisted

Type II - Polyester/wool tropical cloth, 10.00 oz., USAF Blue 1578

Class 1 - General Officers

Class 2 - Officers

Class 3 - Enlisted

Type III - Polyester/wool tropical cloth, 10.25 oz., USAF Blue 1608

Class 1 - General Officers

Class 2 - Officers

Class 3 - Enlisted

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: ASD/ENES, Wright-Patterson AFB OH 45433-6503 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter

AMSC N/A

FSC 8405

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MIL-C-3261F (USAF)

1.2.1 Sizes. The man's cap shall be furnished in the following sizes, as specified (see 6 2).

|       |       |       |       |
|-------|-------|-------|-------|
| 6-3/8 | 6-7/8 | 7-3/8 | 7-7/8 |
| 6-1/2 | 7     | 7-1/2 |       |
| 6-5/8 | 7-1/8 | 7-5/8 |       |
| 6-3/4 | 7-1/4 | 7-3/4 |       |

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-50186 | Cloth, Buckram, Woven and Nonwoven   |
| V-T-276   | Thread, Cotton   |
| NN-P-71   | Pallets, Material Handling, Wood, Stringer Construction, 2-Way and 4-Way (Partial) |
| DDD-L-20  | Label For Clothing, Equipage, and Tentage (General Use)                            |
| PPP-B-601 | Boxes, Wood, Cleated Plywood   |
| PPP-B-636 | Boxes, Shipping, Fiberboard  |
| PPP-T-45  | Tape, Gummed, Paper, Reinforced and Plain, for Sealing and Securing                |

MILITARY

|             |  |
|-------------|--|
| MIL-C-368   | Cloth, Satin, Rayon and Cloth, Twill, Rayon                              |
| MIL-B-1667  | Braid, Textile, Cord-Edge  |
| MIL-S-3577  | Sweatband, Headwear, Leather   |
| MIL-P-15011 | Pallets, Material Handling, Wood Post Construction, 4-Way Entry          |
| MIL-C-21115 | Cloth, Tropical: Wool, Polyester/Wool                                    |
| MIL-C-43482 | Cloth, Poplin, Cotton and Polyester (Water Repellent)                    |
| MIL-T-43548 | Thread, Polyester Core. Cotton-, Rayon-, or Polyester-Covered            |
| MIL-C-43718 | Cloth, Polyester; Polyester and Cotton; Polyester and Rayon, for Pockets |
| MIL-C-83448 | Cloth, Serge, Polyester, Texturized                                      |

STANDARDS

FEDERAL

|             |                                 |
|-------------|---------------------------------|
| 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-901    | Provisions for Evaluating Quality of Caps, Garrison, Men's                           |
| MIL-STD-2073-1 | DoD Materiel Procedures for Development and Application<br>of Packaging Requirements |

(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from the Naval Publications and Forms Center, (ATTN. NPODS), 5801 Tabor Ave., Philadelphia PA 19120-5099.)

LAWS AND REGULATIONS

Rules and Regulations under The Textile Fiber Products Identification Act

(Application for copies should be addressed to the Federal Trade Commission, Washington DC 20580-0001.)

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).

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM D 3951 Standard Practice for Commercial Packaging (DoD adopted)

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

THE COLOR ASSOCIATION OF THE UNITED STATES

Department of Defense (DoD) Standard Color Card of Official Standardized Shades for Sewing Threads

(Application for copies should be addressed to The Color Association of the United States, 343 Lexington Ave., New York NY 10016-0927.)

(Non-Government standards and other publications are normally available from the 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.

MIL-C-3261F(USAF)

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 4.4.

3.2 Guide samples. Guide samples, when furnished (see 6.4), are solely for guidance and information to the contractor. Variations from the document may appear in the samples, in which case the document shall govern.

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

3.3.1 Basic material. The type I cap shall be USAF Color Blue, Shade No. 1598 (see 6.4) conforming to MIL-C-83448; type II cap shall be USAF Color Blue, Shade No. 1578 (see 6.4) conforming to type III, class 3 of MIL-C-21115; and the type III cap shall be USAF Color Blue, Shade No. 1608 (see 6.4) conforming to type III, class 4 of MIL-C-21115.

3.3.2 Braid. The braid used for classes 1, 2, and 3 caps shall conform to classes 5, 6, and 7 of MIL-B-1667, respectively. The polyester yarn described in MIL-B-1667, in lieu of rayon yarn, may be used for the cord cover over the braid.

3.3.3 Sweatband. The sweatband shall be dyed brown conforming to MIL-S-3577 and shall not be less than 7/8 inch wide. The leather sweatband shall be embossed with an imitation turn line 1/8 inch from the top edge. As an alternate, the type I cap may have a sweatband outershell conforming to MIL-C-43718, class 2. The color shall be black. The interlining for the sweatband shall conform to A-A-50186, type III, class 2.

3.3.3.1 Sweatband reinforcement strip. The sweatband reinforcement strip shall be a 5/8 inch wide strip of either print cloth or sheeting that is coated lightly on both sides with pyroxylin or vinyl.

3.3.4 Lining. The lining shall conform to class 1 of MIL-C-368 and shall be gray, approximating USAF Color Gray, Shade No 1154 (see 6.4).

3.3.5 Thread. The thread for all sewing, except the basting thread, shall conform to type IA3, 3 ply, Ticket Nos. 40 and 50 of V-T-276 and to type IA3, 2 ply, Ticket No. 70 of V-T-276 or as an alternate, the thread shall conform to Ticket No. 50, 2 or 3 ply, or Ticket No. 70, 2 or 3 ply of MIL-T-43548. Except for the thread used for stitching that will appear on the sweatband, the thread shall be vat dyed Navy Blue AT, C.A. 66060 (see DoD Standard Color Card). The thread for the stitching that will appear on the sweatband shall be brown, approximately matching the sweatband. The thread for the stitching that will appear on the alternate type I sweatband shall be black or Navy Blue AT, C.A. 66060 (see DoD Standard Color Card), approximately matching the sweatband. The thread shall have good colorfastness to light, perspiration, and wet dry cleaning.

3.3.6 Label. Each cap shall have a combination identification, size, and personal identification label that conforms to type IV or VI, classes 4 and 10 of DDD-L-20. The label shall show colorfastness to dry cleaning. The label shall include the following information:

Name:  
 Service No.:  
 Cap, Garrison, Man's, Air Force, Blue  
 Contract No.: DLA-100-00-0-0000 (Example) 1/  
 Stock No.: 8405-00-000-0000 (Example) 1/  
 Textile Fiber Products information as applicable 1/  
 Contractor: 1/  
 DRY CLEAN ONLY

1/ The contractor shall insert the applicable information.

3.4 Design. The cap shall be envelope style, fully lined, with silver braid for General Officers, silver and blue braid for Officers, and blue braid for Enlisted personnel.

3.5 Patterns. Standard patterns that show size, shape, and notches for proper assembly of all parts will be furnished by the Government (see 6.5). Unless otherwise specified herein, the standard patterns will provide a seam allowance of 1/4 inch. The standard patterns shall be used as a guide in cutting the contractor's working patterns. The contractor's working patterns shall be identical in size and shape to the standard patterns. The standard patterns and the contractor's working patterns shall not be altered in any way.

3.5.1 Pattern parts. The components of the cap shall be cut from the materials specified in accordance with the number of pattern parts indicated in table I.

TABLE I. List of pattern parts.

| Material                      | Pattern nomenclature  | Cut parts |
|-------------------------------|-----------------------|-----------|
| Basic material<br>(see 3.3.1) | Crown 1/              | 1         |
|                               | Panel (side) 1/       | 2         |
|                               | Curtain               | 1         |
| Cloth, lining<br>(see 3.3.3)  | Sweatband outershell  | 1         |
| Buckram<br>(see 3.3.3)        | Sweatband interlining | 1         |
| Lining (see 3.3.4)            | Crown 1/              | 1         |
|                               | Panel (side) 1/       | 2         |

1/ One pattern part for the crown and one pattern part for the panel will be furnished and shall be used to cut both the basic material and the lining

MIL-C-3261F (USAF)

3.6 Construction. The cap shall be constructed in accordance with table II and herein Figure 1 is furnished for guidance and information only. If there are any inconsistencies between the specification and the figure, the specification shall govern.

3.6.1 Stitches, seams, and stitchings. All stitch, seam, and stitching types specified in table II shall conform to FED-STD-751. Whenever two or more methods of seam or stitch types are specified for the same operation, any one may be used. The underside of stitch type 401 shall be on the inside of the cap.

3.6.1.1 Stitches per inch. The number of stitches per inch specified in table II shall be interpreted to be the minimum and the maximum number of stitches per inch permitted.

3.6.1.2 Thread breaks and ends of seams and stitchings. Thread breaks of all stitch types shall be secured by stitching back of the break not less than 1/2 inch. Ends of seams produced with stitch type 301, if not caught in other seams or stitchings or if not the end of a continuous line of stitching, shall be backtacked not less than 1/4 inch. The ends of a continuous line of stitching shall overlap not less than 1/2 inch. Skipped stitches or thread breaks in stitch type 101 may be repaired using stitch type 301.

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

a. When thread breaks, skipped stitches, run-offs, or bobbin runouts occur during sewing, the stitching shall be repaired by superimposing and restarting the stitching a minimum of 1/4 inch back of the end of the stitching. 1/

b. Except for prestitching, thread breaks, two or more consecutive skipped stitches or run-off stitches noted during inspection of the item (in process or end item) shall be repaired by over stitching. The stitching shall start a minimum of 1/4 inch in back of the defective area, continue over the defective area, and continue a minimum of 1/4 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 repairing stitch must be backstitched and thread ends trimmed close to the cap.

3.7 Manufacturing operations requirements. The cap shall be made in accordance with operation requirements 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 stitching to facilitate the manufacture of the cap will be permissible, provided the threads are removed or will not show in the finished cap. Notches to facilitate the assembly or to control the size of the cap (in addition to the notches on the patterns) will be permissible provided the notches will not weaken the cap and will not be visible in the finished cap.

TABLE II. Manufacturing operations.

| No. | Description of Operation   | Stitch Type | Seam and Stitching Type | Stitches Per Inch | Thread |       |
|-----|--|-------------|-------------------------|-------------------|--------|-------|
|     |  |             |                         |                   | Top    | Lower |
| 1.  | <p><u>Cut parts.</u></p> <p>The parts of the cap shall be cut in strict accordance with the patterns (see 3.5) and on the straight in the direction of the warp of the material. All polyester/wool parts of the cap shall be cut out of one piece of material. All texturized polyester parts shall be cut out of one piece of material.</p>  |             |                         |                   |        |       |
| 2.  | <p><u>Replacement of damaged parts</u></p> <p>a. Any part that contains a hole or any weakening defect such as a smash, multiple floats, or a loose slub that might develop into a hole shall be replaced at the time of cutting.</p> <p>b. Any part that contains workmanship damage such as a hole, a scissor or knife cut, a tear, a mend, a burn, or needle chews that might develop into a hole shall be replaced during the manufacturing process.</p> |             |                         |                   |        |       |
| 3.  | <p><u>Marking</u></p> <p>All parts of the cap shall be marked, banded, or ticketed, to insure a uniform shade and size throughout the cap and the proper assembling of all parts (see 3.7.1).</p>  |             |                         |                   |        |       |

## MIL-C-3261F (USAF)

TABLE II. Manufacturing operations. - Contd

| No. | Description of Operation   | Stitch Type   | Seam and Stitching Type | Stitches Per Inch | Thread |       |
|-----|--|---------------|-------------------------|-------------------|--------|-------|
|     |  |               |                         |                   | Top    | Lower |
| 4.  | <u>Attach or apply label.</u>  |               |                         |                   |        |       |
|     | a. The bottom of the label shall be centered, 1 inch above the bottom raw edge, on the left (as worn) panel lining piece and stitched 1/16 inch from the edge on all four sides of the label.  | 301           | LSBj-1                  | 10-14             | 50     | 50    |
|     | OR   |               |                         |                   |        |       |
|     | b. The label shall be applied in the center, 1 inch above the bottom raw edge, on the left (as worn) panel lining piece.   |               |                         |                   |        |       |
|     | NOTE: The label shall be attached or applied before the panel lining pieces are joined to the outershell. The personal identification (name and service no.) at the top of the label shall appear above the sweatband in the finished cap.   |               |                         |                   |        |       |
| 5.  | <u>Make crown.</u>   |               |                         |                   |        |       |
|     | a. The crown pieces (outershell and lining) shall be stitched together with a 1/8 to 3/16-seam.  | 101 or<br>301 | SSa-1                   | 10-14             | 50     | 50    |
|     | b. The crown shall be folded in half lengthwise. The halves of the crown shall be single stitched together at the fold with a 3/8 +1/8-inch seam at the center, tapering to nothing, not more than 1/2 inch from each end of the crown, with the ends of the stitching securely back-stitched. | 301           | OSf-1                   | 10-14             | 50     | 50    |



TABLE II Manufacturing operations. - Contd

| No. | Description of Operation  | Stitch Type | Seam and Stitching Type | Stitches Per Inch | Thread |       |
|-----|---|-------------|-------------------------|-------------------|--------|-------|
|     |   |             |                         |                   | Top    | Lower |
| 6.  | <u>Join panel to crown.</u>   |             |                         |                   |        |       |
|     | a. The panel pieces (outer shell and lining) shall be positioned even with the corresponding edges of the crown and joined to the crown.  | 301 or 401  | LSq-2(a)                | 10-14             | 50     | 50    |
|     | b. The seams joining the panels to the crown shall be turned toward the center of the crown and raised stitched 1/16 inch from the edge of the crown seam, catching all seam allowances in the stitching. The bottom of the stitching shall not show through to the outside of the panels (outer shell or lining).  | 301 or 401  | LSq-2(b)                | 10-14             | 50     | 50    |
| 7.  | <u>Join panels.</u>   |             |                         |                   |        |       |
|     | a. The panel pieces shall be positioned even, face to face. The panel lining pieces shall be positioned even, face to face. The front seam of the panel pieces and the front seam of the panel lining pieces shall be stitched in one continuous stitching. The back seam of the panel pieces and the back seam of the panel lining pieces shall be stitched in one continuous stitching. When stitching the front and the back seams of the panels, the seam allowance of the panels (outershell) and the crown shall be turned toward the top | 301         | LSq-2(a)                | 10-14             | 50     | 50    |

TABLE II. Manufacturing operations. - Contd

| No. | Description of Operation  | Stitch Type             | Seam and Stitching Type | Stitches Per Inch | Thread |       |
|-----|---|-------------------------|-------------------------|-------------------|--------|-------|
|     |   |                         |                         |                   | Top    | Lower |
| 7.  | <p><u>Join panels.</u> - Contd</p> <p>b. The front and the back seams of the panels (outershell) shall be pressed open and flat with a heated pressing iron.</p> <p>c. The cap shall be turned so that the basic fabric will be on the outside. The front and the back seams joining the panels (outershell) adjacent to the crown points shall be smoothed out</p> <p>d. The bottom edges of the panels (outershell and lining) shall be overedge stitched together.</p> <p>e. The panels and the crown shall be pressed smooth and flat with a heated pressing iron or machine, making sure the crown is pressed below the panel edges.</p> |                         |                         |                   |        |       |
| 8.  | <p><u>Join braid to curtain.</u></p> <p>a. The tape of the cord-edge braid shall be joined to the upper edge of the curtain.</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>   | 301 or<br>101 or<br>401 | LSq-3(a)                | 8-12              | 50     | 50    |

TABLE II. Manufacturing operations. - Contd

| No. | Description of Operation   | Stitch Type             | Seam and Stitching Type | Stitches Per Inch | Thread |       |
|-----|--|-------------------------|-------------------------|-------------------|--------|-------|
|     |  |                         |                         |                   | Top    | Lower |
| 8.  | <u>Join braid to curtain.</u> - Contd  |                         |                         |                   |        |       |
|     | b. The raw edges of the seam and the edge of the tape of the cord-edge braid shall be overedge stitched together, or the raw edge of the curtain may be overedge stitched separately. If the raw edge of the curtain is overedge stitched separately, the tape of the cord-edge braid will not need to be overedge stitched. | 503 or<br>504 or<br>505 | EFd-1                   | 8-12              | 70     | 70    |
|     | c. The cord-edge braid shall be turned over, and the curtain edge shall be stitched with a double row of stitching, 1/8- to 3/16-inch gage, with the first row of stitching 1/16 inch from the edge.   | 301 or<br>401           | LSq-3(b)                | 8-12              | 50     | 50    |
|     | NOTE The cord-edge braid shall be sewn onto the curtain evenly so that the cord-edge braid or the curtain will not be wavy or puckered. The cord-edge braid at the underlapping end of the curtain (left side of cap as worn) shall extend to the end of the curtain.  |                         |                         |                   |        |       |
|     | d. The curtain shall be pressed smooth and flat with a heated pressing iron before the curtain is joined to the side panels.   |                         |                         |                   |        |       |
| 9.  | <u>Join curtain to panels.</u>   |                         |                         |                   |        |       |
|     | a. The ends of the curtain shall be overlapped (left side over right side of cap as worn), matched with the front and the back seams of the panels in the position worn and joined together  | 301 or<br>401           | SSa-1                   | 6-8               | 50     | 50    |

TABLE II. Manufacturing operations. - Contd

| No. | Description of Operation   | Stitch Type       | Seam and Stitching Type | Stitches Per Inch | Thread |       |
|-----|--|-------------------|-------------------------|-------------------|--------|-------|
|     |  |                   |                         |                   | Top    | Lower |
| 9.  | <p><u>Join curtain to panels.</u> - Contd</p> <p>as indicated by the pattern notches. The left end of the curtain shall be sewn slightly full from the notch to the end to avoid a tight edge when the cap folds at the front.</p> <p>b A basting stitch that utilizes a good commercial thread shall be sewn across the bottom of the curtain 1/2 inch from the bottom raw edge. As an alternate, a chalk line may be used in lieu of the basting stitch</p> <p>c The bottom serged edge of the panels shall be positioned at the exact line of the basting stitch or chalk line specified in Operation 9 b. The curtain shall be joined to the panels with a single row of stitching.</p> <p>NOTE. The curtain shall cross itself at the front seam of the cap; a tolerance of 1/4 inch from the exact alignment will be allowed.</p> <p>d. The basting stitch or chalk line specified in Operation 9.b shall be removed before the sweatband is joined to the curtain</p> | 101               | OSa-1                   | 6-8               | 50     | 50    |
|     |  | 101 or 301 or 401 | LSa-1                   | 6-8               | 50     | 50    |
| 10. | <p><u>Press cap.</u></p> <p>a. A side shaper shall be inserted between the curtain and the side panels on each side of the cap. The curtain shall be smoothed on the shaper</p>  |                   |                         |                   |        |       |

TABLE II. Manufacturing operations. - Contd

| No. | Description of Operation  | Stitch Type | Seam and Stitching Type | Stitches Per Inch | Thread |       |
|-----|---|-------------|-------------------------|-------------------|--------|-------|
|     |   |             |                         |                   | Top    | Lower |
| 10. | <u>Press cap.</u> - Contd<br><br>b. The cap shall be pressed smooth and flat with a heated pressing machine or a heated steam iron, with the bottom edge folded and creased. The front and the back of the curtain shall not be creased.<br><br>NOTE. The cap shall be completely pressed before the sweatband is attached (see Operation 11).  |             |                         |                   |        |       |
| 11. | <u>Make and attach sweatband.</u><br><br>The sweatband shall be cut to the required length. A two-piece sweatband shall not be used.  |             |                         |                   |        |       |
|     | a. The ends of the sweatband, with the sweatband reinforcement on the underside, shall be abutted and joined with a row of zigzag stitching.  | 304         | FSe-1                   | 8-12              | 40     | 40    |
|     | b. The lower edge of the sweatband shall be zigzag stitched, under even tension, to the bottom of the panels, through the curtain, 1/2 inch outlet only. The zigzag stitching shall be superimposed on and parallel to the serged edge of the panels and shall not show on the outside of the curtain. The sweatband shall not be exposed beyond the bottom pressed edge and shall not be more than 1/4 inch above the bottom pressed edge of the cap. The abutted seam of the ends of the sweatband shall not be less than 1 | 304         | LSa-1                   | 8-12              | 40     | 40    |

TABLE II. Manufacturing operations. - Contd

| No. | Description of Operation  | Stitch Type | Seam and Stitching Type | Stitches Per Inch | Thread |       |
|-----|---|-------------|-------------------------|-------------------|--------|-------|
|     |   |             |                         |                   | Top    | Lower |
| 11. | <p><u>Make and attach sweatband.</u> -<br/>Contd</p> <p>inch or more than 2 inches to the right or the left of the back seam of the cap.</p> <p>OR</p> <p>NOTE: In lieu of Operations 11.a and 11.b, the sweatband may be attached to the curtain as specified in Operations 11 c and 11.d.</p> <p>c The sweatband shall be zigzag stitched through the curtain seam allowance and the panels with the ends of the sweatband overlapping <math>3/4 \pm 1/4</math> inch and the line of stitching overlapped. The zigzag stitching shall be superimposed on and parallel to the serged edge of the panels and shall not show on the outside of the curtain. The sweatband shall not be exposed below nor be more than <math>1/4</math> inch above the bottom pressed edge of the cap. The ends of the sweatband shall not overlap at the back seam of the cap. The double ply of the sweatband shall be not less than 1 inch or more than 2 inches from the seam of the cap.</p> <p>d The overlapped end of the sweatband shall be zigzag stitched to the underlapped portion of the sweatband. The stitching shall be through the sweatband only.</p> |             |                         |                   |        |       |
|     |   | 304         | LSa-1                   | 10-14             | 40     | 40    |
|     |   | 304         | LSa-1                   | 10-14             | 40     | 40    |

TABLE II. Manufacturing operations. - Contd

| No. | Description of Operation  | Stitch Type   | Seam and Stitching Type | Stitches Per Inch | Thread |       |
|-----|---|---------------|-------------------------|-------------------|--------|-------|
|     |   |               |                         |                   | Top    | Lower |
| 11. | <u>Make and attach sweatband.</u> -<br>Contd  |               |                         |                   |        |       |
|     | e. For Type I only. Center the sweatband interlining on the sweatband outershell fabric, leaving 1/4 inch of fabric on each side to be turned over the interlining. Raise stitch 1/8 inch from the folded edge. The finished width of the sweatband shall be 1 +1/8 inch. | 301 or<br>401 | SSbc-1                  | 10-12             | 50     | 50    |
|     | OR  |               |                         |                   |        |       |
|     | f. The sweatband may be made on a roll with a double needle and folder and cut to required length   | 301 or<br>401 | SSbc-2                  | 10-12             | 50     | 50    |
| 12. | <u>Clean cap.</u>   |               |                         |                   |        |       |
|     | a. All ends of the stitching shall be trimmed. Threads shall be removed from the cap.   |               |                         |                   |        |       |
|     | b. All loose threads, spots, and pin tickets shall be removed from the cap.   |               |                         |                   |        |       |
| 13. | <u>Finish pressing.</u>   |               |                         |                   |        |       |
|     | a. The entire cap shall be touched up as necessary, using live steam, to remove all wrinkles and unwanted creases.  |               |                         |                   |        |       |
|     | b. All gloss and pressing impressions shall be removed from the cap.  |               |                         |                   |        |       |

MIL-C-3261F (USAF)

3.7.1 Shade and size marking. The component parts of the cap shall be marked, ticketed, or bundled to insure a uniform shade and size throughout the cap. Any method may be used except.

a. Corrosive metal fastening devices. (Metal devices shall not be used on the lining material.)

b. Sew-on type tickets.

c. Adhesive type tickets whose adhesive causes discoloration or adheres to the material upon removal of the tickets.

3.7.2 Pressing. Unless otherwise specified, all pressing specified in table V shall be performed with a heated pressing iron or steam pressing machine.

3.8 Finished measurements. The finished cap shall conform to the measurements specified in table III.

3.9 Workmanship The finished cap shall conform to the quality of product established by this document. As a final step in the contractor's production control plan, before formation of a lot, each cap shall be examined for selected defects listed in MIL-STD-901. A cap containing a selected defect shall not be included in the end item lot. Selected defects are identified by an asterisk (\*) in the point value column in MIL-STD-901 (see 4.5.3).



MIL-C-3261F (USAF)

TABLE III. Finished measurements (inches).

| Cap Size  | Height of Side Panels 1/ |             |                        | Height of Curtain 2/ |             |        | Circumference 3/ |
|-----------|--------------------------|-------------|------------------------|----------------------|-------------|--------|------------------|
|           | Center Front             | Center Back | Overall at Side Center | Center Front         | Center Back | Side   |                  |
| 6-3/8     | 3-3/8                    | 3-5/8       | 4-5/8                  | 2-3/8                | 2-5/8       | 3-1/4  | 20-1/8           |
| 6-1/2     | 3-3/8                    | 3-5/8       | 4-5/8                  | 2-3/8                | 2-5/8       | 3-1/4  | 20-1/2           |
| 6-5/8     | 3-7/16                   | 3-11/16     | 4-13/16                | 2-7/16               | 2-11/16     | 3-5/16 | 20-7/8           |
| 6-3/4     | 3-7/16                   | 3-11/16     | 4-13/16                | 2-7/16               | 2-11/16     | 3-5/16 | 21-1/4           |
| 6-7/8     | 3-1/2                    | 3-3/4       | 4-7/8                  | 2-1/2                | 2-3/4       | 3-3/8  | 21-5/8           |
| 7         | 3-1/2                    | 3-3/4       | 4-7/8                  | 2-1/2                | 2-3/4       | 3-3/8  | 22               |
| 7-1/8     | 3-9/16                   | 3-13/16     | 4-15/16                | 2-9/16               | 2-13/16     | 3-7/16 | 22-3/8           |
| 7-1/4     | 3-9/16                   | 3-13/16     | 4-15/16                | 2-9/16               | 2-13/16     | 3-7/16 | 22-3/4           |
| 7-3/8     | 3-5/8                    | 3-7/8       | 5                      | 2-5/8                | 2-7/8       | 3-1/2  | 23-1/8           |
| 7-1/2     | 3-5/8                    | 3-7/8       | 5                      | 2-5/8                | 2-7/8       | 3-1/2  | 23-1/2           |
| 7-5/8     | 3-11/16                  | 3-15/16     | 5-1/16                 | 2-11/16              | 2-15/16     | 3-9/16 | 23-7/8           |
| 7-3/4     | 3-11/16                  | 3-15/16     | 5-1/16                 | 2-11/16              | 2-15/16     | 3-9/16 | 24-1/4           |
| 7-7/8     | 3-3/4                    | 4           | 5-1/8                  | 2-3/4                | 3           | 3-5/8  | 24-5/8           |
| Tolerance | ±1/8                     | ±1/8        | ±1/8                   | ±1/8                 | ±1/8        | ±1/8   | +1/4, -1/8       |

1/ The finished measurements shall be taken with a ruler. The overall height measurements of the panels shall be taken at the front, the back, and the center of the cap from the bottom folded edge of the curtain to the top edge of the side panel (see figure 2).

2/ The finished measurements shall be taken with a ruler. The finished measurements of the height of the curtain shall not include the braid and shall be taken at the front, the back and both sides at the point where the front, lap-over terminates from the bottom folded edge of the curtain to the top edge of the curtain (see figure 2)

3/ The finished measurements for the circumference shall be taken with a gage

#### 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.

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

- a First article inspection (see 4.4)
- b Quality conformance inspection (see 4.5)

4.3 Inspection conditions Unless otherwise specified, all inspections shall be performed in accordance with test conditions specified in 4.5.3.

4.4 First article inspection When required (see 3.1 and 6.2), the first article shall be inspected as specified in 4.5.3 for compliance with design, construction, workmanship, and dimensional requirements. The presence of any defect shall be cause for rejection of the first article.

4.5 Quality conformance inspection. Unless otherwise specified, sampling for inspection shall be performed in accordance with MIL-STD-901 or MIL-STD-105, as applicable. The acceptance criteria as specified in the contract or purchase order shall be binding (see 6.6).

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

4.5.2 In-process inspection. Inspection shall be made at any point or during any phase of the manufacturing process to determine whether construction details which cannot be examined in the finished product are in accordance with specified requirements. This inspection shall include verification that the working patterns conform to the Government patterns in all respects. Whenever nonconformance is noted, corrections shall be made to the items affected and lot in process. Items which cannot be corrected shall be removed from production.

4.5.3 Point count inspection. Sampling and inspection provisions for end item examination of the cap, dimensional examination, and packaging inspection shall be performed in accordance with MIL-STD-901. The occurrence of defects shall not exceed the acceptable maximum point value limit specified in MIL-STD-901.

4.5.3.1 Palletization examination. An examination shall be made to determine that the palletization complies with the section 5 requirements. Defects shall be scored in accordance with the list below. The sample unit shall be one palletized unit load fully packaged. The lot size shall be the number of palletized unit loads in the inspection lot. The inspection level shall be S-1 (see 6.6)

| <u>Examine</u>      | <u>Defect</u>   |
|---------------------|---|
| Finished dimensions | Length, width, or height exceeds specified maximum requirements   |
| Palletization       | Pallet pattern not as specified.<br>Interlocking of loads not as specified.<br>Load not bonded with required straps 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. In accordance with the requirements of MIL-STD-2073-1, preservation shall be level A, C, or Commercial, as specified (see 6.2)

### 5.1.1 Level A

5.1.1.1 Unit packing. Each cap shall be inserted in a bag that is made of transparent polyethylene film. The bag shall not be sealed (see 5.4.1) and shall be a minimum of 1 inch longer than the cap.

5.1.1.2 Intermediate packing Sixty caps of one size only, unit packed as specified in 5.1.1.1, shall be packed in an intermediate paperboard box conforming to type CF or SF, class domestic, style RSC of PPP-B-636. The minimum bursting strength of the box shall be 175 pounds per square inch. The inside dimensions of the box shall be approximately 15 inches long, 12-1/2 inches wide and 5-1/2 inches deep. The box shall be closed by applying tape across the lengthwise seams and extending the tape along the bottom and up the side of the box at least 2 inches. The tape shall be a minimum of 2 inches wide and shall conform to type II, class 2 of PPP-T-45

MIL-C-3261F (USAF)

5.1.2 Level C Each cap shall be preserved in accordance with MIL-STD-2073-1 requirements for this level.

5.1.3 Commercial. Each cap shall be preserved in accordance with ASTM D 3951.

5.2 Packing. In accordance with the requirements of MIL-STD-2073-1, packing shall be level A, B, C, or Commercial, as specified (see 6.2).

5.2.1 Level A Three-hundred and sixty caps of one size only, preserved as specified in 5.1, shall be packed in a PPP-B-601, overseas type container. The minimum bursting strength of the shipping container shall be 275 psi. The shipping container shall be securely sealed by applying adhesive (glue) throughout the entire area of contact between the flaps or by a combination of metal stitching the bottom flaps and sealing the top flaps with adhesive. Inspection shall be in accordance with 4.5.3

5.2.2 Level B. Three-hundred and sixty caps of one size only, preserved as specified in 5.1 shall be packed in a PPP-B-636, type CF, class weather resistant container. The minimum bursting strength of the shipping container shall be 275 psi. The shipping container shall be securely sealed by applying adhesive (glue) throughout the entire area of contact between the flaps or by a combination of metal stitching the bottom flaps and sealing the top flaps with adhesive. Inspection shall be in accordance with 4.5.3

5.2.3 Level C Three-hundred and sixty caps of one size only, preserved as specified in 5.1, shall be packed in a PPP-B-636, type CF, class domestic container

5.2.4 Commercial. 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, shall be palletized on a 4-way entry pallet in accordance with load type Ia of MIL-STD-147. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding means K and L or the film bonding means O or P. Pallet patterns shall be in accordance with the appendix of MIL-STD-147. Interlocking of loads shall be effected by reversing the pattern of each course. If the container is of a size which does not conform to any of the patterns specified in MIL-STD-147, the pallet pattern used shall be approved by the contracting officer

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

5.4.1 Polyethylene packages. Polyethylene bagged unit packs shall have the required identification information legibly printed or stamped in black directly on the bag across the center face or on a white paper label inserted within the bag so as to permit ready identification.

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 covered by this specification are intended to be worn as flight and duty headgear by male personnel of the Department of the Air Force.

6.2 Acquisition requirements. Acquisition documents should specify the following:

- a Title, number, and date of this specification
- b. Type, 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 and 2.2).
- d When first article is required (see 3.1).
- e Selection of applicable levels of preservation and packing (see 5.1 and 5.2)
- f When palletization is required (see 5.3).

6.3 First article When first article inspection is required, the item should be a first article sample. The contracting officer should also include specific instructions in acquisition documents regarding arrangements for examinations, approval of first article test results, and disposition of first articles. Invitations for bids should provide that the Government reserves the right to waive the requirement for samples for first article inspection to those bidders offering a product which has been previously acquired or tested by the Government, and that bidders offering such products, who wish to rely on such production or test, must furnish evidence with the bid that prior Government approval is presently appropriate for the pending contract. Bidders should not submit alternate bids unless specifically requested to do so in the solicitation.

6.4 Samples. Guide samples and shade samples can be obtained from the contracting activity or as directed by the contracting officer.

6.5 Government-furnished patterns. The contracting officer should arrange to furnish the patterns listed in 3.5

6.6 Acceptance criteria The acceptance criteria below are recommended for use and unless otherwise specified are in accordance with MIL-STD-105

6.6.1 For palletization examination. An acceptable quality level (AQL), expressed in terms of defects per hundred units (dhu), of 6.5 is recommended (see 4.5.3.1)

MIL-C-3261F (USAF)

6.7 Subject term (key word) listing

Cloth, polyester/wool, tropical  
Cloth, texturized polyester serge  
Crown  
Curtain  
Side panels

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

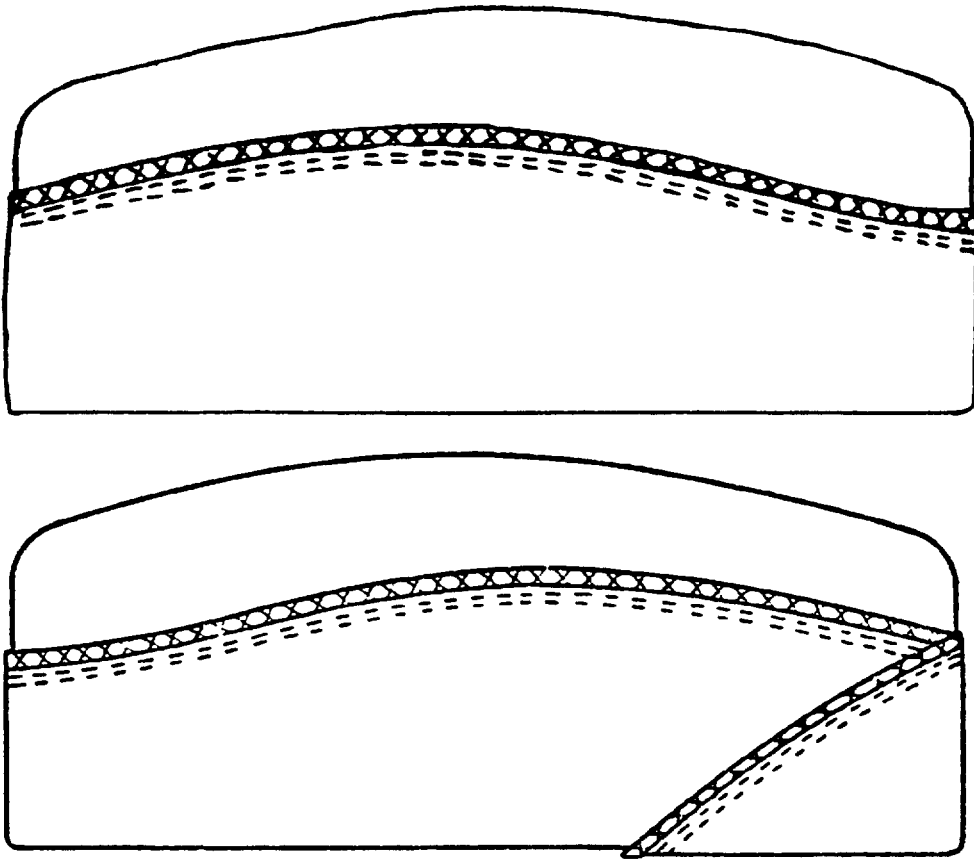
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Air Force - 11  
DLA - DP

Preparing activity  
Air Force - 11

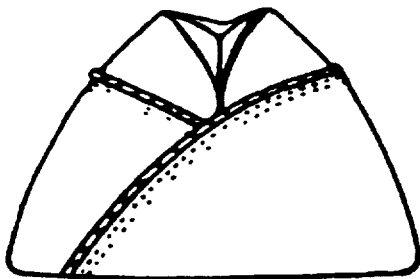
Review activities.  
Air Force - 82, 99  
DLA - CT

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User  
Air Force - 45

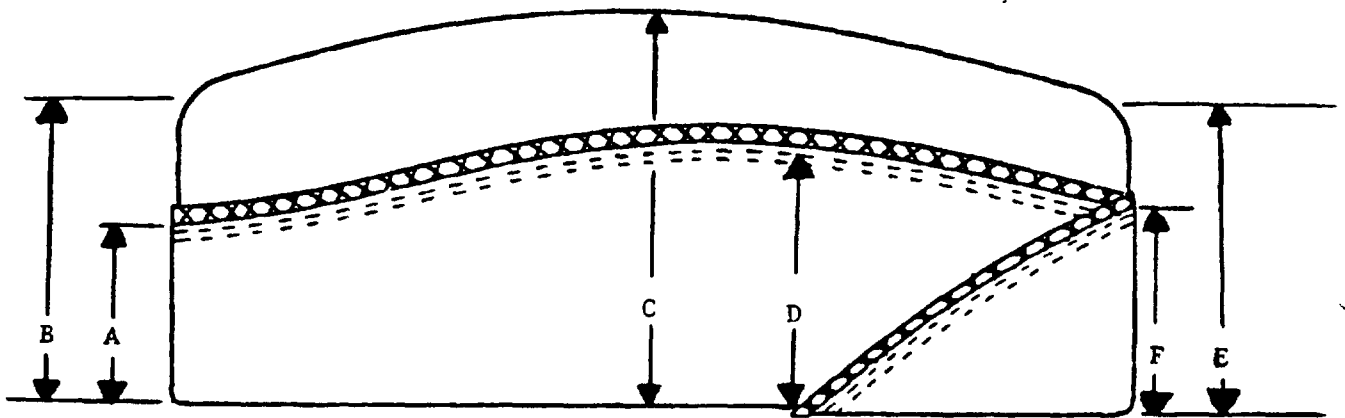


Side views



Front view

FIGURE 1. Man's garrison cap.



- A Curtain height, center back
- B Side panel height, center back
- C Panel, overall at side center
- D Side overall, curtain
- E Side panel height, center front
- F Curtain height, center front

FIGURE 2. Measurement of man's garrison cap.



# STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

1 DOCUMENT NUMBER  
MIL-C-3261F(USAF)

2 DOCUMENT TITLE  
Cap, Garrison, Man's, Air Force, Blue

3a NAME OF SUBMITTING ORGANIZATION

4 TYPE OF ORGANIZATION (Mark one)

- VENDOR  
 USER  
 MANUFACTURER  
 OTHER (Specify) \_\_\_\_\_

b ADDRESS (Street, City, State, ZIP Code)

## 5 PROBLEM AREAS

a Paragraph Number and Wording

b Recommended Wording

c Reason/Rationale for Recommendation

## 6 REMARKS

7a NAME OF SUBMITTER (Last, First, MI) - Optional

b WORK TELEPHONE NUMBER (Include Area Code) - Optional

c MAILING ADDRESS (Street City, State ZIP Code) - Optional

8 DATE OF SUBMISSION (YYMMDD)

CUT ALONG THIS LINE

(TO DETACH THIS FC

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**NOTE:** This form may not be used to request copies of documents, nor to request waivers, deviations, or clarification of specification 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.

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