

A-A-50193
June 30, 1989

COMMERCIAL ITEM DESCRIPTION

THREAD, GIMP, COTTON, BUTTONHOLE

The General Services Administration has authorized the use of this commercial item description in preference to Federal Specification V-T-280.

1. CLASSIFICATION

1.1 Classification.

	Ticket number (size)	Ply Minimum	Breaking Strength, lbs. (min) <u>1/</u>
Type I	8	3	6.5
(Soft finish)	10	4	9.0
	12	5	11.3
Type II	8	3	6.8
(Glazed finish)	10	4	9.4
	12	5	11.8

1/ Based on Test Method 4100 of FED-STD-191.

2. SALIENT CHARACTERISTICS

2.1 General description. The thread shall be made from cotton and shall have a soft or a glazed finish as specified in the applicable end item specification or procurement document. The direction of the final twist shall be "S", unless otherwise specified. The thread shall have an average of not more than one thread knot or splice per 500 yards.

Beneficial comments, recommendations, additions, deletions, clarifications, etc., and any other data which may improve this document should be sent to: Commander, U.S. Army Natick Research, Development and Engineering Center, ATTN: STRNC-ES, Natick, MA 01760-5014.

AMSC N/A

FSC 8310

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2.2 Color. The color shall be as specified in the applicable end item specification or in the contract order. The dyed thread shall conform to the applicable approved shade standard. Shade designations by letter (e.g., Olive Drab S-1) and related cable numbers (e.g., C.A. 66022), refer to Standard Shade for Sewing Threads (see 5.3.1).

2.3 Colorfastness. Unless otherwise specified in the end item specification or set forth in the contract or order, the dyed thread shall show "good" fastness to laundering (after 3 cycles) and wet drycleaning (when specified). The applicable test methods are as follows:

<u>Characteristic</u>	<u>FED-STD-191 Test Method</u>
Laundering (after 3 cycles)	5614 <u>1/</u>
Wet drycleaning (when specified)	5622

1/ The test specimens shall be dried after each laundering cycle. The color transfer cloth evaluation shall not apply. No appreciable change in shade or loss of color of the tested specimen shall be visible when compared to the untested thread.

2.4 Finish removal procedure. Before evaluation for shade matching and testing for colorfastness, except for colorfastness to drycleaning, the thread shall be wet drycleaned in accordance with Method 5622 of FED-STD-191 (disregarding reference to the standard sample). Excess solvent shall be removed by centrifuging or wringing. The sample shall then be rinsed in distilled water at 120° to 160°F and dried at a temperature not exceeding 180°F. The dried sample shall then be conditioned for a minimum of 4 hours prior to evaluation for shade matching or colorfastness.

2.5 Shade matching. The color of the finished thread, after removal of finish, shall match the standard sample when viewed under filtered tungsten lamps that approximate artificial daylight and that have a correlated color temperature of 7500 ± 200 K, with illumination of 100 ± 20 foot candles, and shall be a good match to the standard sample under incandescent lamplight at 2300 ± 200 K.

2.6 Finishing materials. No chemical finishes or treatments shall be applied for the purpose of increasing the breaking strength. The finished thread shall have no chemical finishes or treatments other than those commonly used on commercial threads which have been demonstrated to have no deleterious effects on the polyester fiber, including effects in prolonged storage. The type I thread shall have a soft or natural finish having no consistency or luster other than that inherent to the cotton material. The type II thread shall be polished and lustrous with a smooth surface having no protruding fibers.

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2.7 Put-up. Unless otherwise specified, the thread shall be put-up on holders such as commercial spools, cones, or tubes as specified in the contract. The thread shall be wound around the specified holder in one continuous piece, so that each turn and layer is free of entanglement. The outside ending of the thread shall be secured to prevent unwinding, loosening or slippage during handling, shipping or storage.

2.8 Labeling. Each holder shall have a label, adhered securely so as to remain in place and be clearly legible until all thread has been removed. The label shall be printed and include information related to length in yards, direction of twist, color, ply, size, name of thread manufacturer, and nomenclature specifying type.

3. QUALITY ASSURANCE

3.1 Certification. The contractor shall certify, and maintain substantiating evidence, that the product offered meets the salient characteristics and requirements of this Commercial Item Description, and that the product conforms to the producer's own drawings, specifications, standards, and quality assurance practices. The Government reserves the right to require proof of such conformance prior to first delivery and thereafter as may be otherwise provided for under the provisions of the contract.

4. PACKAGING

4.1 Packaging. Tubes, cones, or spools of thread, of like description, weighing less than 8 ounces each, shall be packaged in set-up paperboard or folding paperboard boxes. Those weighing more than 8 ounces each shall be individually packaged in a snug-fitting clear plastic film bag. The bag shall be closed by means of a twist tie, or by tucking the open end into the end of the tube, cone, or spool.

4.2 Packing. Thread of like description, packaged as specified, shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC-L, type CF, class domestic, variety SW, grade 275 of PPP-B-636. The inside of each fiberboard container shall be fitted with a liner conforming to type CF, variety DW, class domestic, grade 275 of PPP-B-636. The fiberboard liner is not required when thread is packaged in a paperboard boxes. The shipping container shall be of a size that can be palletized in accordance with MIL-STD-147. The weight of a packed shipping container shall not exceed 50 pounds. Shipping containers shall be closed in accordance with the appendix of PPP-B-636.

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4.3 Palletization. When specified (see 5.2), thread, packed as specified, shall be palletized on a 4-way entry pallet in accordance with load type Ia of MIL-STD-147. Pallet types shall be type I (4-way entry), type IV, or type V which 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 K and L or film bonding means O or P.

4.4 Marking. In addition to any special markings required by the contract or purchase order, unit packs, shipping containers, and palletized unit loads shall be marked in accordance with MIL-STD-129.

5. NOTES

5.1 Intended use. The thread is intended for use as the reinforcing cord for eyelet-end buttonholes.

5.2 Ordering data.

- a. Title, number, and date of this document.
- b. Type and size of thread required (see 1.1).
- c. Color required (see 2.2).
- d. Colorfastness properties required (see 2.3).
- e. When palletization is required (see 4.3).

5.3 Sources of documents.

5.3.1 Source of nongovernment documents.

THE COLOR ASSOCIATION OF THE UNITED STATES, INC.

Standard Color Card of America

Department of Defense Standard Shades for Sewing Threads

(Color cards may be available from the Color Association of the United States, Inc., 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.)

5.3.2 Source of government documents. Copies of military and Federal documents are available from:

Naval Publications and Forms Center
ATTN: NPODS
5801 Tabor Avenue
Philadelphia, PA 19120-5099

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