

INCH-POUND

A-A-55087

29 October 1992

COMMERCIAL ITEM DESCRIPTION

SHOES, SWIMMERS

The General Services Administration has authorized the use of this Commercial Item Description in preference to MIL-S-19672.

Abstract. This document covers lightweight coral swim shoes. The shoes are intended for providing protection to the swimmer's feet.

Salient Characteristics. The shoe shall have a plain toe with a nylon duck upper and full length rubber outsole. The shoe shall be a sewed-vulcanized fabrication and include full cotton fabric insole. It may be constructed with a half bellows tongue and lace eyelets with nylon laces, or a zipper, or in a pull on style. The shoe shall have an area of mesh or drain eyelets to allow water to drain out. The color of the outsole compound shall be gray to conform to #36118 of FED-STD-595. Nylon or polyester duck shall be dyed colorfast to match the color specified for the outsole above. Height of shoes shall be standard commercial grade between sizes. Inside back height for size 8 shoe shall be 5-1/4 inches.

Material.

Rubber. Rubber shall be natural rubber, synthetic rubber, or a mixture of natural and synthetic rubber. When tested in accordance with this document, rubber compounds shall be of the composition and physical requirements specified herein.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Defense Personnel Support Center, Clothing and Textiles Directorate, Attn: DPSC-FSSD, 2800 South 20th Street, Philadelphia, PA 19101-8419, by using the Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8430

DISTRIBUTION STATEMENT A.

Approved for public release;
distribution is unlimited.

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Nylon or Polyester Duck. Nylon or polyester duck for the upper shall be woven from not less than three ply twisted thread in both warp and filling and shall conform to the requirements specified herein.

Cotton Fabrics. The fabrics shall be preshrunk, unbleached, and treated to resist fungi. The mildew inhibitor used shall be 2, 2' methylene-bis (4 chloro-phenol).

Thread. The thread shall be nylon. The color shall be as specified for the outsole above. The thread shall be colorfast to light, salt water, and soap.

Ink, Marking, Indelible. The ink shall be black and shall produce marks which are clear and legible. There shall be no offsetting or transfer and no discoloration beyond the limits of the marks.

Quarter. The quarter shall be cut from an integral piece of nylon duck.

Vamp. The vamp shall be cut from an integral piece of nylon or polyester duck.

Inside Toe Cap. The inside toe cap shall be knitted cotton fabric, nominal weight 5.5 ounces per square yard. The cap shall be coated on one side with the lining compound; shall cover the entire inside toe area and extend approximately 1-1/4 inches back from the point of the toe.

Sole. The sole shall be constructed as described below.

Outsole. The outsole shall be fine crepe curl of outsole compound, 0.150 inch thick at the ball, and 0.200 inch thick at the heel. The outsole shall be plain edge.

Foxing. Foxing shall be of the upper compound, under the outsole type. The foxing shall be 1/2 inch wide and 0.025 to 0.040 inch in thickness.

Binder Sole. The binder sole shall be cotton fabric, 5.4 ± 0.5 ounces per square yard. The sole shall be frictioned on both sides and coated on one side with the lining compound to a total thickness of 0.025 inch.

Filler Sole. The filler sole shall be a good grade of stiffening compound 0.050 to 0.060 inch thick.

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Insole. The insole shall be cotton fabric, 7.2 ± 0.5 ounces per square yard. The insole shall be coated on one side with a good grade of stiffening compound and laminated to the stiffening compound coated side of a cotton fabric 5.4 ± 0.5 ounces per square yard; coated on one side with a good grade of stiffening compound, total thickness of insole 0.100 inch.

Sizes and Width. The shoes shall be provided in the following sizes and width:

Sizes - 6; 6-1/2; 7; 7-1/2; 8; 8-1/2; 9; 9-1/2; 10; 10-1/2;
11; 11-1/2; 12; 12-1/2
Width - Medium (M)

Marking. Each shoe shall be stamped inside the quarter with the letters "US", shoe size, width, contract or order number and the contractor's name as follows:

US
8-1/2 (M)
Contract or order No.
Contractor's name

Stamping shall be block letters in black ink as described above; 3/8 inch high in first line, 7/32 inch second line; and 3/16 inch third and fourth line.

Sizes and Measurements. Lasts shall conform to Table I.

Table I. Lasts (size 8 shoe)

	Medium (M) Width	Grade between each full size
Length of bottom	10-13/16	1/3
Width of ball	3-8/12	1/12
Width of heel	2-15/32	Blend
Heel to crown	13-3/8	3/8
Waist	9-1/2	1/4
Ball girth	9-5/8	1/4
Toe spring	3/4	Blend

Dimensional tolerance for the finished shoes shall be within the limit of plus or minus 3-1/2 percent of the dimensions specified.

Workmanship. After completion, the finished shoes shall be thoroughly cleaned, and all loose thread, lint, and foreign matter removed.

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Product Demonstration Model. When required, offerers shall submit samples of their intended production. The Product Demonstration Model will consist of units independently developed. Product Demonstration Models will be analyzed and evaluated by the government. Evaluation criteria and basis for award are contained in the solicitation. Product Demonstration Models will be retained by the government. One (1) Product Demonstration Model approved by DPSC under the resultant contract will serve as a manufacturing standard for the corresponding production items delivered under this contract. Offerers are advised that the Product Demonstration Model does not relieve the successful offerer of his responsibility to perform in accordance with the Commercial Item Description specified above.

Quality Assurance

Certification. The contractor shall certify that the product offered meets the salient characteristics of this 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 the first delivery and thereafter as may be otherwise provided for, under the provisions of the contract. Reliance on contractor QA systems 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.

Examination. Shoe lots shall be inspected in accordance with "Sampling Procedures and Tables for Inspection by Attributes", ANSI/ASQC Z1.4, published by the American Society for Quality Control.

Visual Examination. The shoes shall be examined for the defects listed below. The lot size shall be expressed in units of shoes. The sample unit is one shoe. The inspection level shall be II and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 6.5.

Defects. The shoe shall be examined for the following defects: any hole, cut, tear, rip, mend, weak place or other deficiencies seriously affecting serviceability; exterior color not as specified; exterior color not uniform; any spot or stain (outside); shoes not properly mated (i.e., not right and left of same size); height variation between pair; any component not fabricated of the specified material; design not as specified; any component missing; defective or damaged component affecting serviceability; any component misplaced, seriously affecting serviceability; raw edge showing; irregular or uneven stitching affecting appearance; loose stitch tension resulting in a loosely secured seam; tight stitch tension resulting in puckering of fabric or assembly; any open seam; rubber components not securely bonded or vulcanized; burned gum; porous or imbedded foreign

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matter; poor or incomplete vulcanization; eyelets not securely clinched (if used); eyelets not in proper alignment interfering with proper lacing (if used); thread ends not removed; marking missing, incorrect, or illegible, not applied in the specified manner, misplaced, or size or color not as specified; measurement of item not as specified.

Dimensional Examination. The finished shoes shall conform to the dimensions specified. Any dimension that is not within the established tolerance shall be classified as a defect. The sample unit shall be one shoe; the inspection level shall be II and the AQL, expressed in terms of defects per hundred units, shall be 6.5.

Packaging Examination. The fully packaged shipping containers shall be examined in accordance with defects listed below. The lot size shall be the number of shipping containers in the inspection lot. The inspection level shall be S-2 and AQL, expressed in terms of defects per hundred units, shall be 2.5.

EXAMINE	DEFECT
Marking (exterior and interior)	Omitted; incorrect; illegible; of improper size, location, or method of application
Materials	Any component missing, damaged, or not as specified
Workmanship	Inadequate application of components, such as: incomplete closure of container flaps, loose strapping, improper taping, or inadequate stapling
Content	Number of items in container is more or less than required NSN shown on one or more items not as specified on shipping container
Palletization	Length, width, or height exceeds specified maximum requirements Pallet type not as specified Load not bonded as specified

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Regulatory Requirements. The offeror/contractor is encouraged to use recovered materials in accordance with Public Law 94-580 to the maximum extent practicable.

End Item Performance Testing.

Upper Compound. The upper compound shall conform to the composition, tensile strength (before aging), tensile strength (after aging), and ultimate elongation requirements in Table II below.

Table II. Upper Compound End Item Performance Requirements

Characteristic	Requirement	Test Method FED-STD-601	Deter. Per Sample Unit	Results Reported to:
Minimum percent rubber	66 (by weight)	16101	2	nearest percent
Minimum percent new rubber	66 (by weight)	16101	2	nearest percent
Tensile strength, minimum	1,400 pounds/ square in.-psi	4111	3	nearest 10 psi
Tensile strength after accelerated aging, min.	1,050 psi	4111 and 7001	3	nearest 10 psi
Ultimate elongation, percent minimum	400	4121	3	nearest 5 percent

Lining Compound. The lining compound shall conform to the composition requirements in Table III below.

Table III. Lining Compound End Item Performance Requirements

Characteristic	Requirement	Test Method FED-STD-601	Deter. Per Sample Unit	Results Reported to:
Minimum percent rubber	63 (by weight)	16101	2	nearest percent
Minimum percent new rubber	42 (by weight)	16101	2	nearest percent

Outsole Compound. The outsole compound shall conform to the composition and resistance to abrasion requirements in Table IV below.

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Table IV. Outsole Compound End Item Performance Requirements

Characteristic	Requirement	Test Method FED-STD-601	Deter. Per Sample Unit	Results Reported to:
Minimum percent rubber	45 (by weight)	16101	2	nearest percent
Minimum percent new rubber	45 (by weight)	16101	2	nearest percent
Resistance to abrasion, minimum	35	14111	3	nearest index unit

Nylon or Polyester Duck. The nylon or polyester duck shall be woven from not less than three ply twisted thread in both warp and filling and shall conform to the weight, thread count, tensile strength, and colorfastness requirements in Table V below.

Table V. Nylon or Polyester Duck End Item Performance Requirements

Characteristic	Requirement	Test Method FED-STD-191	Deter. Per Sample Unit	Results Reported to:
Nominal weight per square yard, min.	14 ounces	5041	5	0.1 oz
Thread count				
Warp, minimum	38 per inch	5050	5	number
Filling, minimum	23 per inch	5050	5	number
Tensile strength				
Warp, minimum	600 pounds	5100	5	one pound
Filling, minimum	350 pounds	5100	5	one pound
Colorfastness				
Salt water and soap	"good"	5632	1	good, fair, or poor
Light	"good"	5660	1	good, fair, or poor

Cotton Fabrics. Material identification for cotton fabrics for the lace eyelet stay, drain eyelet stay, counter and counter bind shall be in accordance with Test Method 1200 of FED-STD-191. All weight requirements stated in this document for cotton fabrics shall be in accordance with Test Method 5041 of FED-STD-191.

Preservation, Packing, and Marking. The preservation, packing, and marking shall be as specified in the contract or order.

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Source of Government Documents. Copies of Military and Federal documents are available from:

Standardization Documents Order Desk
Bldg. 4D
700 Robbins Avenue
Philadelphia, PA 19111-5094

Sources of Nongovernment Documents.

ANSI/ASQC Z1.4 - Sampling Procedures and Tables For Inspection
By Attributes

(Applications for copies should be addressed to American
National Standards Institute, 1430 Broadway, New York, NY 10018-
3308.)

ASTM-D 3951 - Standard Practice for Commercial Packaging

(Applications for copies should be addressed to American
Society For Testing and Materials, 1916 Race Street,
Philadelphia, PA 19103.)

Custodian:
DLA - CT

Civil Agency Coordinating
Activity:
GSA - FSS

Preparing Activity:
DLA - CT

Project No. 8430-0409

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.

I RECOMMEND A CHANGE:		1. DOCUMENT NUMBER A-A-55087	2. DOCUMENT DATE (YYMMDD) 29 October 1992
3. DOCUMENT TITLE Shoes, Swimmers			
4. NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)			
5. REASON FOR RECOMMENDATION			
6. SUBMITTER			
a. NAME (Last, First, Middle Initial)		b. ORGANIZATION	
c. ADDRESS (include Zip Code)		d. TELEPHONE (include Area Code) (1) Commercial (2) AUTOVON (if applicable)	7. DATE SUBMITTED (YYMMDD)
8. PREPARING ACTIVITY			
a. NAME Defense Personnel Support Center ATTN: DPSC-FSSD (12-3-D)		d. TELEPHONE (include Area Code) (1) Commercial 215-737-8105	(2) AUTOVON 444-8105
c. ADDRESS (include Zip Code) 2800 South 20th Street P. O. Box 8419 Philadelphia, PA 19101-8419		IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT: Defense Quality and Standardization Office 5203 Leesburg Pike, Suite 1403, Falls Church, VA 22041-3666 Telephone (703) 756-2340 AUTOVON 289-2340	