

INCH-POUND

A-A-55184

10 March 1993

COMMERCIAL ITEM DESCRIPTION

BERET, MAN'S, WOOL

The General Services Administration has authorized the use of this Commercial Item Description in preference to MIL-B-43172.

Abstract. The berets are intended for wear by designated military personnel of the Department of Defense.

Classification. The berets shall be one type in the following classes and sizes:

Class 1 - Rifle Green (Army)
 Class 2 - Blue (Air Force)
 Class 3 - Maroon (Air Force)
 Class 4 - Scarlet (Air Force)
 Class 5 - Medium Blue (Air Force)
 Class 6 - Black (Army and Air Force)
 Class 7 - Maroon (Army)
 Class 8 - Gray (Air Force)
 Class 9 - White (Air Force)

Schedule of sizes

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

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 8405

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distribution is unlimited.

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Salient Characteristics. The beret shall consist of a knitted wool outershell, lined with polyester and bound with leather or nylon tape. A rayon braid, threaded through the binding, is tied in a bow at the back. The braid shall be cut to fit the head size plus 10 inches ($\pm 1/4$ inch) to allow for tying. The braid shall be free to move through the binding to allow for adjustment and the ends of the braid shall extend through the opening at center back. The beret shall have a badge stay sewn on the inside of the left front with one end 1 inch ($\pm 1/4$ inch) to the right of the center front and the bottom edge (at center of stay) $3/4$ to $7/8$ inch from the bottom of the lining. The beret shall have a felt cushion sewn on the inside bottom raw edge of the blocked shell. The binding shall finish smooth and even in width. The ends of the binding shall be abutted at center back, $1/4$ inch off center tolerance, of beret. The binding shall be sewn grain side up. Except for color, all classes of the beret are the same. The color shall be Rifle Green 297 for class 1 berets, Blue 1561 for class 2, Maroon 1560 for class 3, Scarlet 1591 for class 4, Medium Blue 1592 for class 5, Black 1593 for class 6, Maroon 453 for class 7, Gray 1609 for class 8, and White 1610 for class 9. Figure I is furnished solely for guidance and information. The construction shall conform in all respects to the requirements specified in this document.

Material. The shell shall be knit from singles yarn of 64's grade (average fiber diameter, 20.60 to 22.04 microns with a 5.19 maximum standard deviation), or finer, blended wool, on a flat or circular reciprocating beret machine with 9 or 10 needles per inch. The shell shall contain not less than 95 percent wool based on the dry weight of the specimen when tested in accordance with Table I. After fulling and dyeing, the shell shall be blocked to size, shaped, and sheared to a smooth finish. The shell shall be mothproofed. The color 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. The material for the lining and crown interlining shall be polyester and cotton or polyester and rayon. The cushion strip shall be pressed wool felt. The badge stay shall be burlap. As an alternate, the badge stay shall be medium density, water resistant fiberboard produced from a highly purified alpha-cellulose vegetable fiber, impregnated with a minimum 32 percent of compounded neoprene. The thickness of the fiberboard shall be 0.060 ± 0.003 inch. The color of the finished badge stay shall be natural (tan). The badge stay shall not curl, nor show any sign of separation. The badge stay shall not shrink more than 1.0 percent in any direction. The leather for the binding shall be full grain, vegetable tanned sheepskin. The leather shall be drum dyed Black 111 and the thickness shall be 2.0 to 2.5 ounces. (DOD Standardized Shades for Sewing Threads) and shall show "good" colorfastness to light, perspiration, and wet drycleaning.

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As an alternate the banding may be nylon tape dyed black, tape-plain weave, non-critical use (shuttle or shuttleless loom, nylon 6 or nylon 6,6), one inch width (\pm .032 inch) or polymer coated fabric, black in color and one inch in width. The drawcord shall be 5/16 inch wide braid having 64 ends of 300 denier continuous filament rayon yarn, when tested in accordance with the component testing section. The color shall be black and shall show "good" fastness to wet dry-cleaning when tested in accordance with the component testing section. The thread for all seaming and stitching shall be cotton-covered polyester thread, ticket No. 50, 2 ply and 70, 2 ply or as an alternate, cotton thread, ticket Nos. 30 or 36. The thread shall be dyed Black AA, C A. 66043

Component testing. The finished treated shell shall conform to the following requirements:

Weight, minimum - 16.5 ounces per square yard
Bursting strength, minimum - 45 pounds

The lot shall be unacceptable if one or more sample units fail to meet any of the test requirements specified. The lot size expression and the sample size shall be in accordance with the following:

<u>Component</u>	<u>Lot size expressed as</u>	<u>Sample unit for testing</u>
Shell	Shells	12 shells
Badge stay	Pounds	3 square feet
Braid	Yards	1/4 yard

The polymer coated fabric shall have the following requirements when tested as specified in Table I:

Composition - Urethane	39 percent \pm 5 percent
Polyester	23 percent \pm 2 percent
Cotton	38 percent \pm 2 percent

Coating: Flexible polyurethane

Total weight: 11.0 \pm 0.5 oz./sq. yd.

Thickness: 0.30 - .036

Breaking strength: min. 60 lb. in both machine and cross machine directions

The number of sample units to be tested shall be determined as follows:

<u>Lot size</u>	<u>Sample size</u>
800 or less	2
801 up to and including 22,000	3
22,001 and over	5

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Table 1.
Component Tests.

<u>Component</u>	<u>Characteristic</u>	<u>Test method</u>
Shell	Wool grade	ASTM D 3991 <u>1/</u>
	Wool content	2101
	Sheared finish	<u>1/</u>
	Colorfastness:	
	- Light	5660
	- Perspiration	5680
	- Wet drycleaning	5622
	- Crocking	5651
	Weight	5041
Thread	Bursting strength	5120
	Colorfastness:	
	- Light	5660
	- Perspiration	5680
Badge stay: Alphacellulose fiberboard <u>2/</u> (when applicable)	- Wet drycleaning	5622
	Material identification	<u>3/</u>
	Water resistance	<u>4/</u>
	Thickness	5030
	Color	Visual <u>5/</u>
Braid	Shrinkage	5550 <u>6/</u>
	Material identification	<u>1/</u>
	Denier of yarn	<u>1/</u>
	Width	Measurement <u>5/</u>
	Number of ends	Count <u>5/</u>
	Colorfastness to wet dry- cleaning	5622
Polymer coated fabric binding	Material identification	<u>1/</u>
	Weight oz./sq. yd.	5041
	Thickness	5030
	Breaking strength	5100

- 1/ Unless otherwise specified, certificate of compliance shall be submitted and will be acceptable for the stated requirement.
- 2/ Samples of badge stay shall be conditioned for 24 hours at a relative humidity of 50 ± 3 percent and a temperature of $70 \pm 2^{\circ}\text{F}$ prior to testing.
- 3/ A certificate of compliance shall be submitted to the contracting officer or his designated representative that the composition and the amount of impregnation are as specified

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- 4/ Water resistance - A drop of distilled water shall be placed on the surface of the badge stay board and shall not be completely absorbed in 1 hour. Three determinations shall be made per sample unit and the results reported as "pass" or "fail".
- 5/ For this examination, one determination shall be made per sample unit and the results reported as "pass" or "fail".
- 6/ The test procedure shall be modified to be adaptable for the type of material tested. The three test specimens shall be cut 4 inches by 8 inches and the average result reported as "pass" or "fail".

Label. Each beret shall have a combination size, identification, and garment care instruction indicating "DRY CLEAN CLEANING" label, marking, direct printing, stamping, or stenciling, except the size for all characters shall be 1/8 inch. The labels shall show colorfastness to wet dry-cleaning equal to or better than the standard sample. When no standard sample is available, the labels shall be clearly legible and shall show "good" colorfastness to wet dry cleaning (Method 5622 of FED-STD-191).

Patterns. The government shall furnish a single size pattern. The contractor is responsible for grading patterns for additional sizes. The pattern generally provides for a seam allowance of 1/4 inch for joining seams. Commercial patterns may be used in lieu of the government furnished pattern provided they conform to the cited design and finished measurements.

Sizes and Measurements. The finished beret shall conform to the measurements below.

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Table 11.
Finished measurements (in inches).

Beret size	Inside beret circumf. 1/	Crown length 2/	Crown width 3/	Front quarter 4/	Back quarter 5/	Right and left quarter 6/
6-3/8	20-1/8	9-7/8	9-3/8	3	2-1/2	2-3/4
6-1/2	20-1/2	10	9-1/2	3	2-1/2	2-3/4
6-5/8	20-7/8	10-1/8	9-5/8	3	2-1/2	2-3/4
6-3/4	21-1/4	10-1/4	9-3/4	3	2-1/2	2-3/4
6-7/8	21-5/8	10-3/8	9-7/8	3	2-1/2	2-3/4
7	22	10-1/2	10	3	2-1/2	2-3/4
7-1/8	22-3/8	10-5/8	10-1/8	3	2-1/2	2-3/4
7-1/4	22-3/4	10-3/4	10-1/4	3	2-1/2	2-3/4
7-3/8	23-1/8	10-7/8	10-3/8	3	2-1/2	2-3/4
7-1/2	23-1/2	11	10-1/2	3	2-1/2	2-3/4
7-5/8	23-7/8	11-1/8	10-5/8	3	2-1/2	2-3/4
7-3/4	24-1/4	11-1/4	10-3/4	3	2-1/2	2-3/4
7-7/8	24-5/8	11-3/8	10-7/8	3	2-1/2	2-3/4
Tolerance	± 3/16	± 5/16	± 3/16	± 3/16	± 3/16	± 3/16

- 1/ Laying the beret flat on the table, head opening up, measure inside beret circumference around bottom edge of binding on the finished beret.
- 2/ Laying the beret flat on the table, head opening down, measure from front (folded edge) to back (folded edge) as indicated by "A" in figure 1.
- 3/ Laying the beret flat on the table, head opening down, measure from side (folded edge) to side (folded edge) as indicated by "B" in figure 1.
- 4/ Laying the beret flat on the table, head opening up, measure the front quarter from bottom (folded edge) of binding to the outside (folded edge) of crown as indicated by "C" in figure 1.
- 5/ Laying the beret flat on the table, head opening up, measure the back quarter from bottom (folded edge) of binding to the outside (folded edge) of crown as indicated by "D" in figure 1.
- 6/ Laying the beret flat on the table, head opening up, measure the right and left quarters from bottom (folded edge) of binding to the outside (folded edge) of crown as indicated by "E" in figure 1.

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

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.

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

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. Beret 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 beret shall be examined for the defects listed below. The lot size shall be expressed in units of berets. The sample unit is one beret. The inspection level shall be II and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 1.0.

Defects. The beret shall be examined for the following defects: any hole, cut, tear, color not as specified; any spot or stain (outside); thread ends not removed; label missing, incorrect, or illegible; measurement of item not as specified.

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Dimensional Examination. The finished beret 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 beret. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 2.5.

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.

<u>Examination</u>	<u>Defect</u>
Marking (Exterior and interior)	Omitted; incorrect; illegible; of improper size location, sequence, or method of application.
Materials	Any component missing, damaged, or not as required.
Workmanship	Inadequate application of components, such as: Incomplete closure of container flaps, loose strapping, inadequate stapling, or improper taping. Bulged or distorted container. Open and non-continuous heat sealed seams and closure or polyethylene bag.
Content	Number of intermediate packs per shipping container is more or less than required. Number of berets per intermediate pack is more or less than required. <u>1/</u> Size shown on one or more berets not as specified on intermediate or outer container. <u>1/</u>
Palletization	Length, width, or height exceeds specified maximum requirements. Pallet type not as specified. Load not bonded as specified.

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1/ For this defect, two intermediate packs from each container in the sample shall be examined.

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

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:
Army - GL
Air Force - 11

Civil Agency Coordinating
Activity:
GSA - FSS

Review Activity:
Army - GL
Air Force - 45, 82, 99

Preparing Activity:
DLA - CT

User Activity:
Air Force - 45

Project No.
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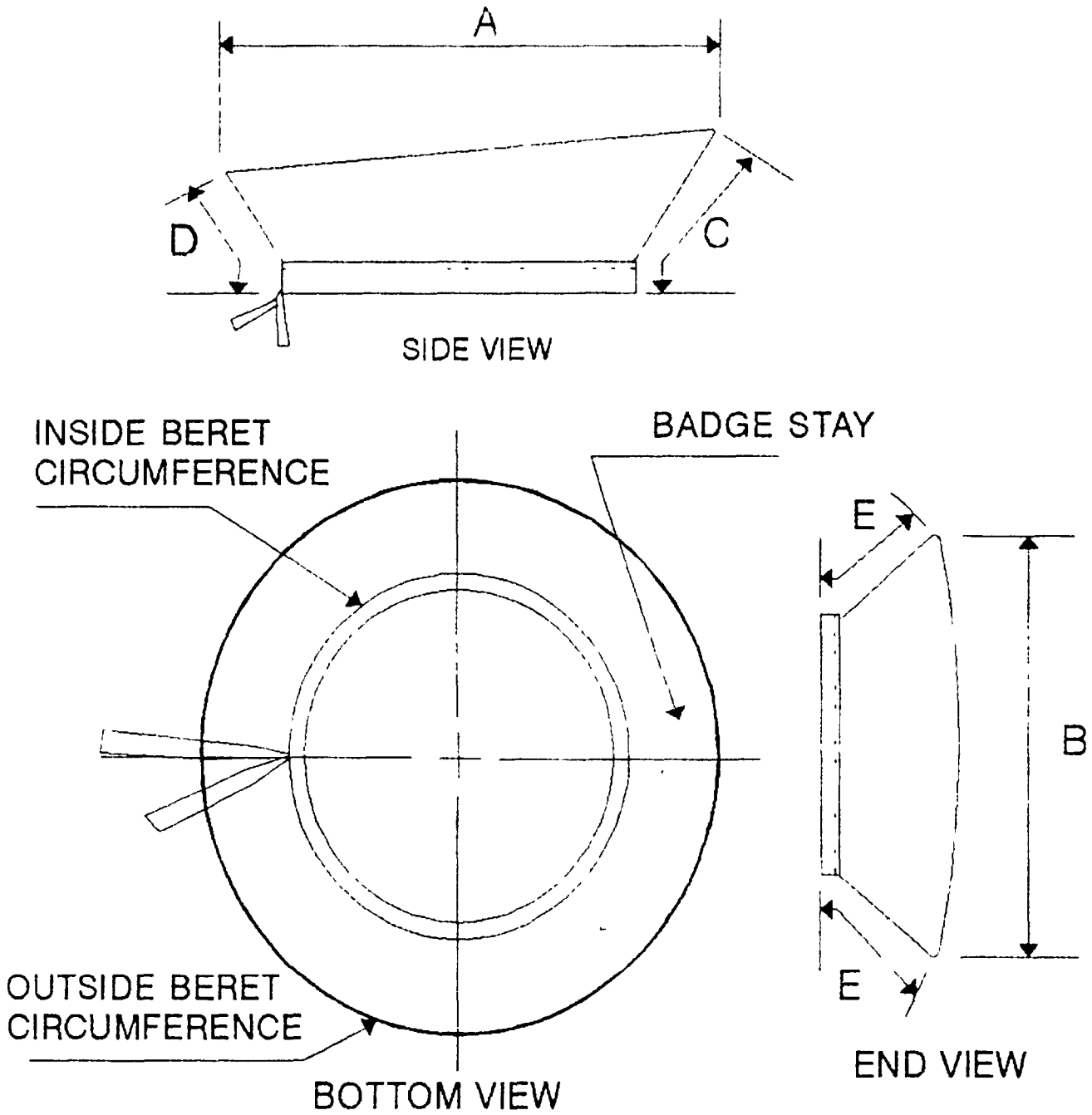


FIGURE 1
BERET, MAN'S, WOOL

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.

1 RECOMMEND A CHANGE:		1 DOCUMENT NUMBER A-A-55184	2 DOCUMENT DATE (YYMMDD) 93-03-12
3 DOCUMENT TITLE BERET, MAN'S, WOOL			
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-FLSD (12-3-D)		b. 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 5419 Philadelphia, Pennsylvania 19101-8419		IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT Defense Quality and Standardization Office 5207 Leesburg Pike, Suite 1403, Falls Church, VA 22041-3466 Telephone (703) 756-2340 AUTOVON 289-2340	