

INCH-POUND

A-A-55190

29 March 1993

COMMERCIAL ITEM DESCRIPTION

SEWING KIT

The General Services Administration has authorized the use of this Commercial Item Description in preference to MIL-S-3276.

Abstract. Sewing kit with contents is intended for use by the military for repairing clothing.

Classification. The sewing kit shall be of one type. The contents of each kit shall be classified as follows:

- Class 1 - Army
 - Style 1 - Male
 - Style 2 - Female
- Class 2 - Air Force

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 8315

DISTRIBUTION STATEMENT A. Approved for public release;
distribution is unlimited.

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Salient Characteristics. The kit shall be a one-piece type made from vinyl chloride film with an upper and lower pocket and an inserted felt pad. It is closed by folding on itself and secured by means of a snap fastener. The vinyl chloride film shall be 12 inches long ($\pm 1/4$ ") and 4-3/4 inches wide with a 2-3/8 inch radius curve on one end. The upper pocket shall be positioned on the curved end of the body piece with the side edges of the pocket even with the side edges of the body piece. The felt pad shall be inserted under the bottom edge of the upper pocket for a distance of 1/4 to 3/8 inches. The bottom edge of the upper pocket and the body piece shall be heat sealed to the felt pad with a 1/8 inch minimum seal in such a manner as to hold the pad securely in place. The bottom end of the body piece shall be turned up 2-1/2 inches from the straight end of the vinyl forming the lower pocket or the lower pocket may be a separate piece 4-3/4 inches by 2-1/2 inches. The side edges of the upper and lower pocket and the bottom edge of the lower pocket, if a separate piece, shall be heat sealed using a 1/8 to 3/16 inch wide heat seal. The strength of the heat seal bond shall not be less than 22 pounds when tested as specified under End Item Performance Testing. The outside edges of the finished kit shall be embossed but not more than 3/16 inches from the edge. The snap fasteners shall be attached with the female 5/8 inches from the center of the curved end and the male 3/4 inch from the folded lower pocket.

Material. The basic materials shall be:

- (a) Colorless, flexible, vinyl chloride film with a minimum 0.020 inches thickness in accordance with ASTM D374 Method C. The film may have a smooth dull matte finish on both sides, or one or both sides may be planished.
- (b) Felt for inside flap of kit shall be at least 45% wool according to AATCC 20A, 0.065 inches thick, according to ASTM D1777, weigh 6.0 ounces per square yard according to ASTM D3776, and with 8.0 pound breaking strength according to ASTM D5034. As an alternate, a 100 percent polyester needle punched nonwoven material weighing from 8.0 to 10.0 ounces per square yard and with a thickness of from 0.070 to 0.95 inches, may be used. 1/
- (c) Snap fasteners shall be pronged ring head type with a black finish conforming to MIL-F-10884.
- (d) Polyethylene bag to hold contents.

1/ Ten 2 by 6 inch specimens shall be cut with a die from each test sample, five taken lengthwise and five crosswise of the piece. The jaws of the clamps shall be not less than 2 inches in width. The thickness of each specimen shall be measured and the cross-sectional area of each specimen shall be calculated before testing. The testing strength shall equal the breaking load divided by the cross-sectional area.

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Construction. The component parts of the kit shall be cut and assembled to conform with measurements shown on Figures 1 and 2.

Contents of Kit. The kits shall contain the following items:

- (a) 14 safety pins, without guards, in commercial sizes 1, 2, and 3 (10 of size 1 mounted on a card)
- (b) 8 steel, nickel plated hand sewing needles in commercial sizes 2 and 4 (4 each size)
- (c) Assorted buttons as shown in the tables below. The metal uniform buttons shall conform to type I, style 2, class A or B of MIL-B-3461. The size 25 line buttons shall have a short shank or hopper back and the 36-line buttons shall have a hopper back. The plastic buttons for all colors shall conform to type II, class D of V-B-871, except the Polyester White BA buttons, listed in table III, which shall be class K.
- (d) The thread in the braids shall be 100% cotton, 3 ply, between 7000 and 10000 yards per pound in accordance with ASTM D1907, in the colors indicated in the tables and with a minimum breaking strength of 2.2 to 3.0 pounds in accordance with ASTM D1578. As an alternate, cotton-covered polyester core, size 50, 2 or 3 ply thread with a minimum of 2.9 pounds breaking strength may be used. Each thread in the braid shall be not less than 24 inches long and the braid itself shall be 21 \pm 1 inches long. The braid shall be of sufficient looseness to permit the withdrawal of a single thread without difficulty. The number of carriers and ends per carrier shall be as indicated in the tables. The thread shall show fastness to light in accordance with AATCC 16 and laundering in accordance with FED -STD 191-5610 equal to or better than the standard samples. When no standard samples are available, the colored thread shall show a minimum "4" (good) level fastness to light and laundering.
- (e) Seam ripper, overall length shall not exceed 4 inches and the blade shall be 1 inch minimum.

TABLE I ARMY-(MALE)

Buttons

<u>Quantity</u>	<u>Style</u>	<u>Size</u>	<u>Color and Cable Number</u>
<u>Plastic</u>			
6	26	30	Olive Green BP 62016 dull
2	20 or 21	24	Black BT 62001
2	20 or 21	30	Black BT 62001
2	20 or 21	40	Black BT 62001
2	15	18	Black BT 62001
2	4	22	Army Green BR 62015
4	25	19	White BA, C.A. 62031
<u>Metal (Uniform)</u>			
2	2, cl A or B	36	Gold plated
2	2, cl A or B	25	Gold plated

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Braided thread

<u>Number of carriers</u>	<u>Ends per carrier</u>	<u>Color and Cable Number</u>
8	6	Olive Drab 66022
8	6	Green E 66034
5	6	Black AA 66043
8	6	Bleached White AH 66050

TABLE II ARMY-(FEMALE)Buttons

<u>Quantity</u>	<u>Style</u>	<u>Size(line)</u>	<u>Color and Cable Number</u>
<u>Plastic</u>			
6	26	30	Olive Green BP 62016-dull
2	20 or 21	24	Army Green BR 62015
2	20 or 21	24	Black BT 62001
2	20 or 21	30	Black BT 62001
2	20 or 21	40	Black BT 62001
2	15	18	Black BT 62001
4	25	17	Poly Army Green BR 62015
4	25	21	Poly Army Green BR 62015

Metal (Uniform)

2	2, class A	30	Gold Plated
2	2, class A	25	Gold Plated

Braided thread

<u>Number of carriers</u>	<u>Ends per carrier</u>	<u>Color and Cable Number</u>
8	6	Olive Drab 66022
8	6	Lt. Green Y 66042
5	6	Black AA 66043
8	6	Green E 66034

TABLE III AIR FORCEButtons

<u>Quantity</u>	<u>Style</u>	<u>Size (line)</u>	<u>Color and Cable Number</u>
<u>Plastic</u>			
2	20 or 21	40	Blue BU 62002
4	20 or 21	24	Blue BU 62002
1	20 or 21	30	Blue BU 62002
2	4	22	Blue BV 62003
2	20 or 21	24	Blue BV 62003
2	24	20	Blue BV 62003
6	26	30	Olive Green BP 62016 dull
10	25	19	Poly White BA 62031

Braided thread

<u>Number of carriers</u>	<u>Size (line)</u>	<u>Color and Cable Number</u>
5	6	Blue M 66027
8	6	Navy Blue AT 66060
8	6	Olive Drab S-1 66022
8	6	White AH 66050

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Buttons. Buttons for each kit shall be packaged in a polyethylene bag and placed in the lower pocket of the kit. The bag shall be closed by folding back the unfilled portion of the bag.

Braided thread. The braided thread shall be folded and inserted into the upper pocket of the kit.

Seam ripper. The seam ripper shall be placed in the upper pocket of the kit below the braided thread.

Safety pins. The card with the safety pins (size 1) shall be placed in the upper pocket of the kit behind the braid with the back of the card next to the kit. The size 2 and size 3 safety pins shall be pinned to the felt strip parallel to the top and bottom of the kit.

Needles. The four needles of each size shall be attached to the felt strip parallel to the top and bottom of the kit.

Workmanship. After completion, the finished sewing kits shall be thoroughly cleaned, 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.

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. The contractor shall furnish a certificate of compliance for corrosion resistance of the safety pins and that the braided thread has the proper twist per inch, ends per carrier, number of carriers, braid looseness, and thread length.

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Examination. Sewing kit 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 sewing kits shall be examined for the defects listed below. The lot size shall be expressed in units of sewing kits. The sample unit is one sewing kit. The inspection level shall be I and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 4.5.

Defects. The sewing kits shall be examined for the following defects:

Material (plastic film) - cut, tear, or hole; scratch, crease or blister more than 1/4 inch in diameter or length; spot, stain, or imbedded foreign matter more than 1/4 inch in diameter; does not have a smooth dull matte finish on both sides.

Construction - Any seam not completely sealed, any component missing, seam construction not as specified, any seam puckered or distorted in heat sealing, kit (complete with contents) cannot be folded on itself and snapped satisfactorily, felt pad not completely caught in seam or not securely held in place, plastic or metal buttons not in conformance with type, class and style specified or nicked, cracked, disfigured, or malformed, entire braid missing, finished length less than 20 inches or more than 22 inches; safety pins malformed or damaged; needles omitted or corroded.

End Item Performance Testing. The end item shall be tested for bonding strength of seal. The bonding strength of seal shall be determined as specified in ASTM D-882 except that no autographic stress-strain curve is required. The test specimens shall be one inch wide with the seam in the center of the specimen. The free ends of the specimen shall be clamped (one in each jaw) in the testing machine. The sample unit shall be one kit without contents. The sampling for testing shall be as below and the lot shall be unacceptable if one or more sample units fail to meet the heat seal requirement of 22 pounds.

Sample size

Lot size (kits)	Sample size (sample units)
800 or less	20
801 to 22,000	27
22,001 and over	45

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Dimensional Examination. The finished sewing kit 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 sewing kit; the inspection level shall be S-2 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 1.5.

Examination	Defect
Material	Missing, damaged, not as specified
Content	Number of sewing kits per shipping container is more or less than required.

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

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

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Sources of Non-Government 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
ASTM-D 882 - Test for Tensile Properties of Thin Plastic Sheeting
Other ASTM Tests

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

American Association of Textile Chemists and Colorists (AATCC) tests

(Applications for copies should be addressed to AATCC, P.O. Box 12215, Triangle Park, NC 27709-2215.

Custodians:
Army - GL
Air Force - 99

Review Activities:
Air Force - 82

User Activity:
Air Force - 11

Civil Agency Coordinating
Activity:
GSA - FSS

Preparing Activity:
DLA - CT

Project No. 8315-0364

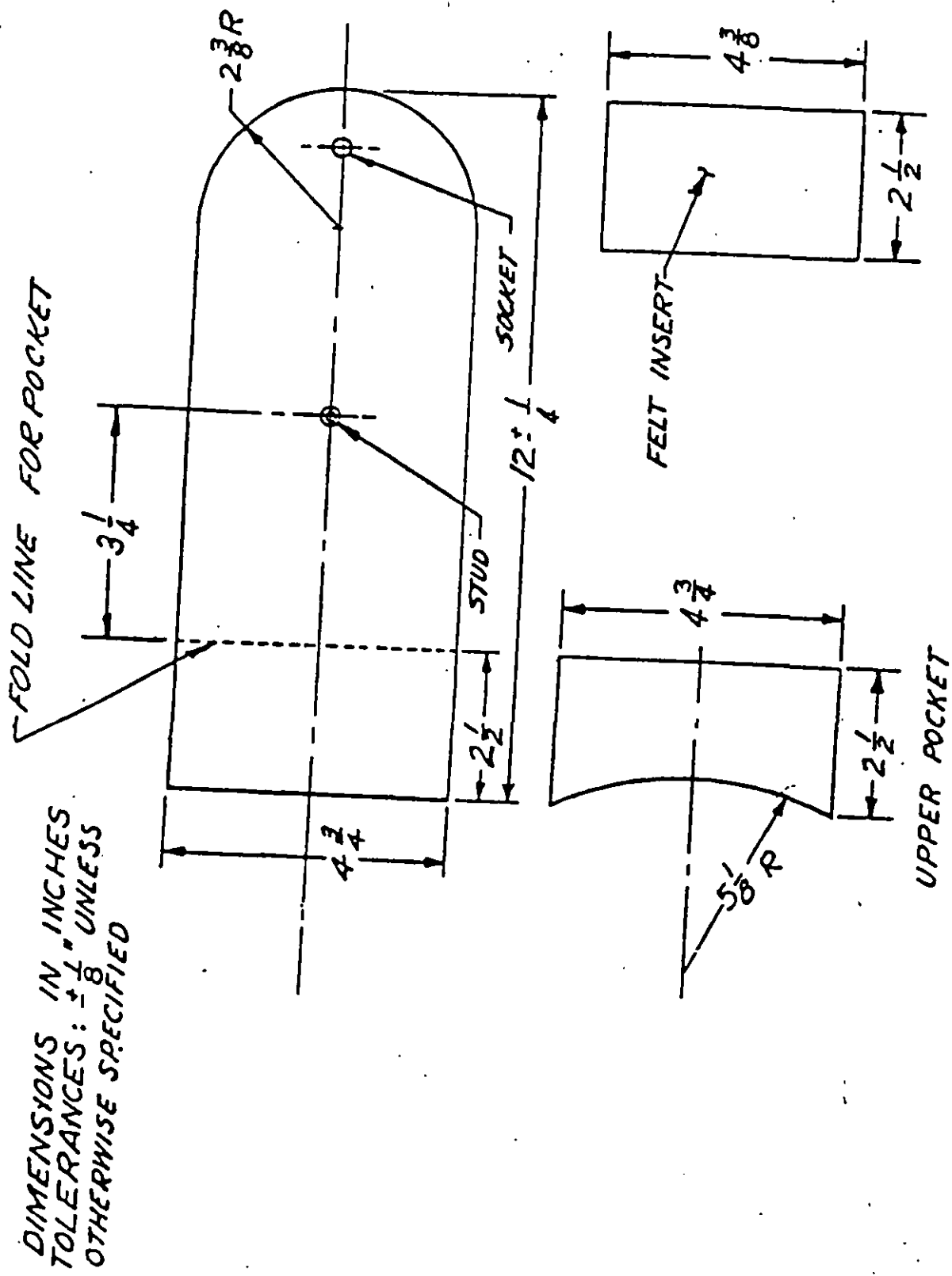


FIGURE 1 - SEWING KIT

DIMENSIONS IN INCHES
TOLERANCES: $\pm 1/8$ " UNLESS
OTHERWISE SPECIFIED

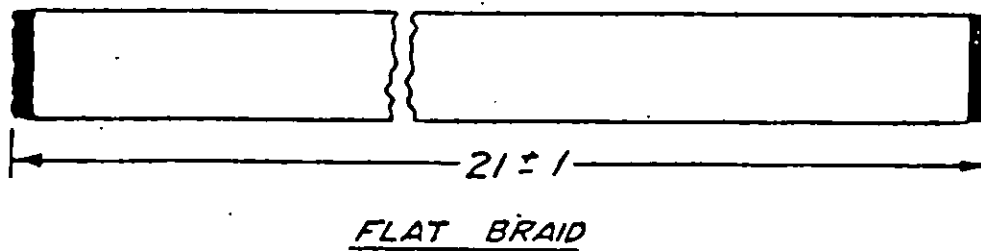
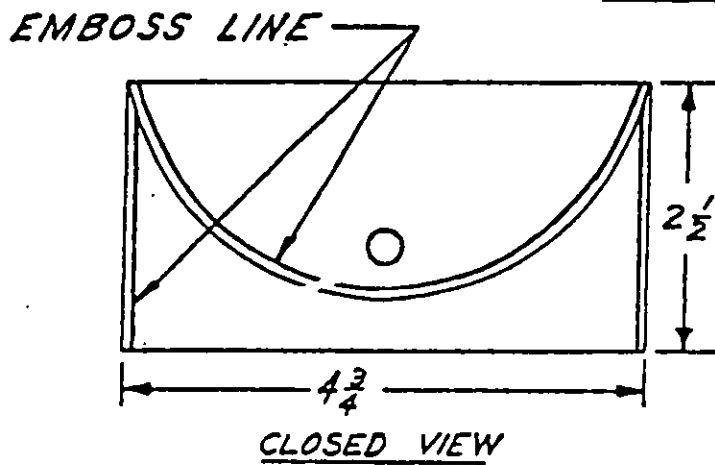
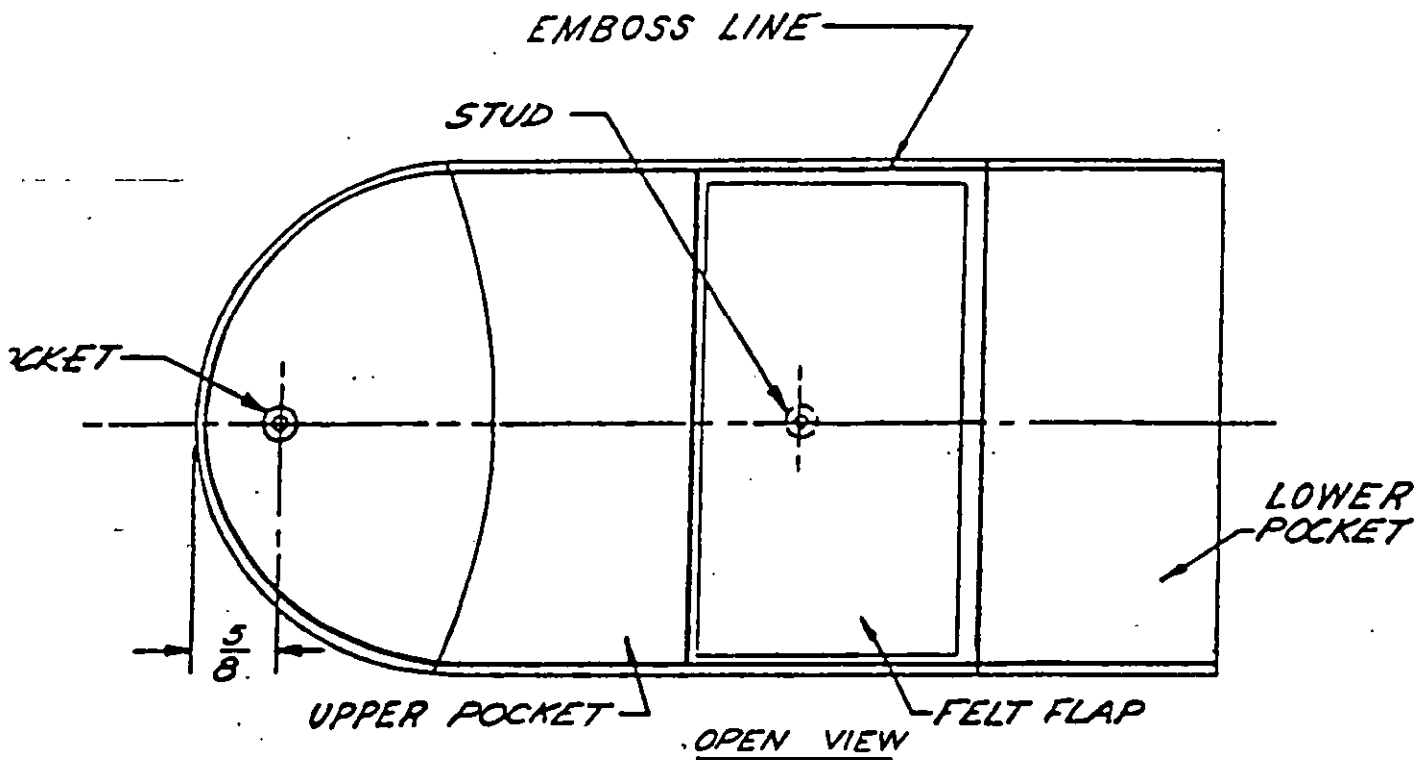


FIGURE 2 - SEWING KIT

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-55190	2. DOCUMENT DATE (YYMMDD) 93/3/29
3. DOCUMENT TITLE SEWING KIT			
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)		b. TELEPHONE (Include Area Code) (1) Commercial 215-737-8105	(2) AUTOVON 444-8105
c. ADDRESS (Include Zip Code) 2800 SOUTH 20th STREET 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 22041-3466 Telephone (703) 756-2340 AUTOVON 289-2340	