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INCH-POUND

A-A-55264
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COMMERCIAL ITEM DESCRIPTION

BRAID, TEXTILE, CORD-EDGE

The General Services Administration has authorized the use of this commercial item description as a replacement for MIL-B-1667 for all Federal agencies.

1. SCOPE. The cord-edge braids are for use on garrison caps worn by military personnel of the Departments of the Army and the Air Force.

2. CLASSIFICATION. The cord-edge braid shall be of the following classes:

Class 1 - General Officers, Army
Class 2 - Officers, Army
Class 3 - Warrant Officers, Army
Class 4 - Enlisted Men, Army
Class 5 - General Officers, Air Force
Class 6 - Officers, Air Force
Class 7 - Airmen, Air Force

3. SALIENT CHARACTERISTICS

3.1 The cord-edge braid shall consist of a flat braid section and a cord section braided together.

3.2 Material

3.2.1 Cotton yarn. The yarns used for the core and flat braid sections for all classes shall be carded cotton yarns.

Beneficial comments, recommendations, additions, deletions clarification, etc. and any data which may improve this document should be sent to: Defense Personnel Support Center, Clothing and Textiles Directorate, Attn: DPSC-FQSC, 2800 South 20th Street, Philadelphia, PA 19145-5099.

AMSC N/A FSC 8315

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3.2.2 Polyester yarn. The polyester yarn used in braiding the cord covers for classes 2, 3, 4, 6 and 7, and for the flat braid sections of all classes shall be nominal 150 denier (17 tex) heat set, texturized, semi-dull multifilament.

3.3 Color. The color of the braid shall be as specified in Table I. The use of dyes and compounds containing elementary sulfur capable of oxidation to sulfuric acid is prohibited. The dyestuff shall be chosen and applied so that the dyed and finished braid shall show no more than a slight trace of labile sulfur as defined when tested as specified in accordance with Method 2020 of FED-STD-191 - Textile Test Methods.

TABLE I. COLORS FOR BRAID

CLASS	CORD COVER	CORE	FLAT BRAID SECTION
1	Gold foil polyester laminate thread or equal	Unbleached or white	Army Green 489
2	Gold foil polyester laminate thread or equal, and Black Cable No. 65018	Unbleached or white	Army Green 489
3	Silver Gray, Cable No. 65008 and Black Cable No. 65018	Unbleached or white	Army Green 489
4	Army Green 489	Unbleached or white	Army Green 489
5	Silver foil polyester laminate thread or equal	Unbleached or white	Air Force Blue 1611
6	Silver foil polyester laminate thread or equal	Unbleached or white	Air Force Blue 1611
7	Air Force Blue 1611	Unbleached or white	Air Force Blue 1611

3.3.1 Colorfastness. The dyed braid shall show a minimum rating of "4" (good) fastness to perspiration, wet drycleaning, light and crocking when tested as specified in accordance with the following test methods:

AATCC 15 for Colorfastness to Perspiration with the following exception: The test for colorfastness for acid and alkaline solution shall apply.

Test Method 5622 of FED-STD-191 - Textile Test Methods for Colorfastness to Wet drycleaning.

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AATCC 16, Option A for Colorfastness to Light with the following exception: When a color change equal to Step 4 on the Gray Scale is evident in either sample being evaluated or the standard sample, exposure shall be continued for an additional number of hours equal to the number of hours at which the color change was apparent. Specimens which do not show a color change until 80 AFU's shall be returned to the machine for a total exposure period not to exceed 140 hours.

AATCC 8 for Colorfastness to Crocking (Dry and Wet) with the following exception: AATCC Test Method 8 shall be followed except that the lengths of cord-edge braid shall be laid so that the cord portions are side by side, presenting the same continuous height.

3.4 Construction

3.4.1 Cord section. The cord section shall consist of a cord cover braided around a cotton core. The width of the finished cord section shall be not less than 3/32 inch and not greater than 1/8 inch. The cover shall conform to the requirements of Table II. Visual confirmation is acceptable.

3.4.2 Core. The core for all classes of braid shall be 4 cotton stuffer yarns. One determination per sample unit shall be made and the result reported as "actual count." Each stuffer yarn shall be a 20/3/4 or 6/4 ply cord with 4 to 6 turns per inch (1-1/2 to 2-1/2 turns/cm) in the final ply. Plus or minus one count on the singles yarn is permissible.

3.4.3 Cord cover. The cord cover shall be braided to conform to the requirements contained in the following paragraphs and Table II.

TABLE II. CORD COVER REQUIREMENTS

Class	1	2	3	4&7	5	6
Number of carriers (minimum): 1/	19	19	19	19	19	19
Ends per carrier (minimum): 1/ Polyester yarn 150 denier (17 tex)		14-2 ends up	14-4 ends up Black, 5-4 ends up Grey	19-4 ends up		14-2 ends up
Silver foil polyester laminate thread or equal:					19-1 ends up	5-1 ends up
Gold foil polyester laminate thread or equal:	19-1 ends up	5-1 ends up				

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TABLE II. CORD COVER REQUIREMENTS (Contd.)

Class	1	2	3	4&7	5	6
Picks per inch (cm) (minimum): 2/ Polyester yarn 150 denier (17 tex)	26 (10)	26 (10)	26 (10)	26 (10)	26 (10)	26 (10)
Braiding type: 3/	Over 2, Under 2	Over 2, Under 2	Over 2, Under 2	Over 2, Under 2	Over 2, Under 2	Over 2, Under 2

1/ One determination per sample unit and the results shall be reported as "actual count."
2/ Three determinations per sample unit and the results shall be reported as "pass" or "fail."
3/ One determination per sample unit and the results shall be reported as "pass" or "fail."

3.4.4 Flat braid section. The flat braid section for all classes shall be braided over 2, under 2 with polyester yarn conforming to the requirements of Table III. Visual confirmation is acceptable.

Table III. Flat Braid Section Requirements

Flat braid section	Classes 1, 3, 4, 5 and 7	Classes 2 and 6
Width:	1/4 - 5/16 (inches) 6 - 7 (mm)	1/4 - 5/16 6 - 7
Number of carriers (minimum): 1/	25	25
Ends per carrier (minimum): 1/	3	2
Picks per inch, (cm) (minimum): 2/	26 (10)	26 (10)
Warp ends for 25 braider: 1/	11-2 ends up	11-2 carrier ends up
Lines for 25 carrier braider (minimum): 1/	6	6

1/ One determination per sample unit and the results shall be reported as "actual count".
2/ Three determinations per sample unit and the results shall be reported as "pass" or "fail".

3.5 Weight. The finished cord-edge braid shall weigh not less than 22.0 ounces per (gross) yard for classes 1, 3, 4, 5 and 7 and not less than 20.0 ounces per 144 (gross) yards for classes 2 and 6, when tested as specified: Two specimens in excess of 1 yard each shall be selected from each sample unit. The specimens of braid in the relaxed state shall then be measured and cut to exactly 1 yard each. While in a standard condition as defined in Section 4 of FED-STD-191 - Textile

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Test Methods, each specimen shall be weighed on a balance or scale accurate to 0.01 ounce. The weight of all one yard specimens shall be averaged and this average value multiplied by 144 to determine ounces per 144 yards to the nearest 0.1 ounce.

3.6 Put-up and length. The braid shall be put up on commercial size double headed spools containing 144 ± 10 yards each. There shall not be more than three lengths per spool and no one length shall be less than 5 yards.

3.7 Label/marking. Each spool shall be labeled, or ticketed for fiber content in accordance with the Rules and Regulations under the Textile Fiber Products Identification Act. This label/tag shall be located so that it is completely visible on the spool when it is packaged as specified and so that it remains on the spool when distributed.

4. REGULATORY REQUIREMENTS

4.1 Regulatory requirements. The offeror/contractor is encouraged to use recovered materials in accordance with paragraph 23.403 of the Federal Acquisition Regulation (FAR), to the maximum extent practicable.

5. QUALITY ASSURANCE PROVISIONS

5.1 Certification. The contractor shall certify and maintain substantiating evidence 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, and is the same product offered for sale in the commercial marketplace. 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 or purchase order.

5.2 Market Acceptability. The following market acceptability criteria are necessary to document the quality of the product to be provided under this commercial item description.

5.2.1 The company offering the item must have been producing the double headed spools of braid being tendered under the contract or purchase order or generically similar models for at least 3 years.

5.2.2 The company must have produced at least 1000 generically similar or identical double headed spools of braid to that being tendered.

5.2.3 Company offering the item must have been producing and selling double headed spools of braid, generically the same as described herein, for a period of 2 years.

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5.3 Warranty. The item offered shall include the standard warranty given to the commercial market beginning with the date of delivery of the individual item.

5.4 Visual examination. The braid shall be examined as indicated in 5.4.1 and 5.4.2.

5.4.1 Yard-by-yard examination. The required yardage of each spool shall be inspected for visual defects. All defects listed shall be counted regardless of their proximity to each other, except where two or more defects represent a single local condition of the braid, in which case only the more serious defect shall be counted. A continuous defect shall be counted as one defect for each warpwise yard or fraction thereof in which it occurs. The sample unit for this examination shall be 1 linear yard. The lot size shall be expressed in units of 1 yard. The number of spools from which the sample shall be selected shall be in accordance with Table IV.

TABLE IV. Sample size

Lot size (yards)	Sample size (spools)
1,300 and less 1/	3
1,301 up to and including 3,200	5
3,201 up to and including 8,000	7
8,001 up to and including 22,000	10
22,001 up to and including 110,000	15
110,001 and over	25

1/ If a lot contains fewer than three spools, each spool in the lot shall be examined.

5.4.2 Defects. Cord section unevenly braided clearly visible at normal inspection distance (approximately 3 feet); core not completely covered; any hole, cut or tear; any abrasion mark, spot or stain; missing or broken yarn; coarse or fine yarn; braiding loose or tight clearly visible at normal inspection distance); width of flat braid section or cord cover section exceeding limits; Not clean throughout; objectionable odor; shaded end to end; does not match referenced color; mottled or uneven color; identification marking missing, illegible or incorrect; not ticketed or labeled in accordance with Textile Fiber Products Identification Act; improperly or insecurely wound on spools, tangled and does not unwind properly; any total length found to be less than the specified minimum length or more than the specified maximum length; any individual length less than 5 yards, any total length found to be more than 2 yards (1.8 m) less than the total length marked on the spool ticket, or any spool containing more than three individual pieces; label missing, incorrect, or illegible; any braid not packaged in accordance with the contract or purchase order.

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6. PACKAGING

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

7. NOTES

7.1 Acceptance criteria. Acceptance criteria shall be as specified in the contract or purchase order.

7.2 Source for Government documents. Copies of military and Federal documents are available from:

Department of the Navy
Defense Printing Service
Detachment Office
700 Robbins Avenue, BLDG 4D
Philadelphia, PA 19111-5093

Rules and Regulations Under the Textile Fiber Products Identification Act - Application for copies should be addressed to:

Federal Trade Commission
Washington, DC 20580

7.2.1 Source for non-Government documents

AATCC Test Methods - Application for copies should be addressed to:

American Association of Textile Chemists and Colorists (AATCC)
P.O. Box 12215
Triangle Park, NC 22709-2215

MILITARY INTERESTS:

Custodians
Army - GL
Air Force - 45

Review Activities

Army - MD
Air Force - SO, 01, 32

CIVIL AGENCY COORDINATING ACTIVITY:
GSA - FSS

PREPARING ACTIVITY:
DLA - CT

Project
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