

L-C-780a
June 11, 1965
SUPERSEDING
Int. Fed. Spec. L-C-00780 (GSA-FSS)
November 16, 1964

FEDERAL SPECIFICATION

CURTAIN, SHOWER AND WINDOW, PLASTIC

This specification was approved by the Commissioner, Federal Supply Service, General Services Administration, for the use of all Federal agencies.

1. SCOPE AND CLASSIFICATION

1.1 Scope. This specification covers individual and matched sets of vinyl film shower and window curtains.

1.2 Classification.

1.2.1 Type and styles. Curtains shall be of one type and the following styles, as specified (see 6.1).

Style I-Shower curtain (individual)

Style II-Window curtain (individual)

Style III-Shower and window curtain set

2. APPLICABLE SPECIFICATIONS AND STANDARDS

2.1 The following specifications and standards of the issues in effect on date of invitation for bids form a part of this specification to the extent specified herein:

Federal Specifications:

L-P-375-Plastic Film, Flexible, Vinyl Chloride.

V-T-276-Thread, Cotton.

V-T-295-Thread, Nylon.

PPP-B-566-Boxes, Folding, Paperboard.

PPP-B-636-Box, Fiberboard.

PPP-B-665-Boxes; Paperboard, Metal Stayed (Including Stay Material).

PPP-B-676-Boxes, Set-Up, Paperboard.

Federal Standards:

Fed. Std. No. 102-Preservation, Packaging, and Packing Levels.

Fed. Std. No. 123-Marking for Domestic Shipment (Civilian Agencies).

Fed. Test Method Std. 406-Plastics: Methods of Testing.

Fed. Std. No. 751-Stitches, Seams, and Stitchings.

(Activities outside the Federal Government may obtain copies of Federal Specifications, Standards, and Handbooks as outlined under General Information in the Index of Federal Specifications and Standards and at the prices indicated in the Index. The Index, which includes cumulative monthly supplements as issued, is for sale on a subscription basis by the Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402.

(Single copies of this specification and other product specifications required by activities outside

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the Federal Government for bidding purposes are available without charge at the General Services Administration Regional Offices in Boston, New York, Washington, D.C., Atlanta, Chicago, Kansas City, Mo., Dallas, Denver, San Francisco, Los Angeles, and Seattle, Wash.

(Federal Government activities may obtain copies of Federal Specifications, Standards, and Handbooks and the Index of Federal Specifications and Standards from established distribution points in their agencies.)

Military Standards:

MIL-STD-105-Sampling Procedures and Tables for Inspection by Attributes.

MIL-STD-129-Marking for Shipment and Storage.

(Copies of Military Specifications and Standards required by contractors in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

3. REQUIREMENTS

3.1 Material.

3.1.1 Vinyl film. The material for the curtains and the tie backs shall be virgin vinyl film not less than 8 gage (0.008 inch) in thickness conforming to type II, class 1 or 2 of L-P-375.

3.1.2 Grommets. Grommets shall be either anodized aluminum or brass, with a minimum inside diameter of 1/4 inch.

3.1.3 Thread. The thread for hemming shall be mercerized 3-ply cotton, type IC1 or IC2, conforming to V-T-276, or nylon conforming to V-T-295, type III or VII.

3.2 Construction. Shower curtains, window curtains and tie backs shall be fabricated of one piece of vinyl film specified in 3.1.1. The hem at the top of the shower curtain shall be reinforced and shall be a minimum of 1-1/4 inches wide. The hem at the top of the window curtain shall be reinforced and shall be 2 inches wide. The sides and bottom edges of the shower and window curtain shall have a 1/2 inch hem. The sides and ends of the tie backs shall have a 1/4 inch hem. All hems shall be stitched as specified in 3.2.1 and 3.2.2, or shall be electronically heat sealed. Window curtains shall consist of two tailored panels with a reinforced rod pocket at the top and two matching tie backs. Grommets shall be spaced equally along the top hem of the shower curtain, not less than 6 nor more than 8 inches apart, with one in each corner 1/2 inch from top and side edge.

3.2.1 Stitches, seams, and stitching. All stitches, seams, and stitching shall conform to the requirements of Fed. Std. No. 751. All sewing shall be done using thread specified in 3.1.3.

3.2.2 Curtain and tie back hems. The curtain and tie back hems shall be straight and of uniform width. The turn under shall be not less than 1/4 inch. Hems shall be sewn using seam type Efb-1 and stitch type 301 of Fed. Std. No. 751, with not less than 5 stitches per inch.

3.3 Dimensions and tolerances.

3.3.1 Shower and window curtains. The finished hemmed dimensions of the shower curtains shall be 36 by 72 inches or 72 by 72 inches, as specified (see 6.1). Each panel of the window curtain shall be 32 inches wide by 45 inches long or 32 inches wide by 60 inches long, as specified (see 6.1). The following tolerances will be

permitted in the dimensions: Length, = 1/2 inch - width = 1/2 inch.

3.3.2 Tie backs. The width of the hemmed tie back shall not be less than 1-1/2 inches nor more than 2 inches. The length of the hemmed tie back shall be not less than 18 inches nor more than 20 inches.

3.4 Color and finish. The curtains and

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the tie backs shall be colorless frosted vinyl film or matte finish white opaque vinyl film as specified (see 6.1).

3.5 Mildew resistance. The mildew resistance of the curtains when tested in accordance with method 6091 of Fed. Test Method Std. No. 406, shall be such that a rating of zero (0) shall be obtained.

3.6 Workmanship. The curtains and components shall be free from defects or blemishes affecting appearance or serviceability of the item, and shall meet the level of quality established in this specification and subsidiary specifications reference herein.

4. SAMPLING, INSPECTION, AND TEST PROCEDURES

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified, the supplier may utilize his own facilities or any commercial laboratory acceptable to the Government. The Government reserves the right to perform any of the inspections set forth in the specifications where such inspections are deemed necessary to assure that supplies and services conform to prescribed requirements.

4.2 Inspection of components and materials. In accordance with 4.1, the supplier is responsible for insuring that components and materials used were manufactured, examined, and tested in accordance with this specification and referenced subsidiary specifications and standards.

4.3 Inspection for end item lot acceptance. Sampling for inspection and lot acceptance shall be determined in accordance with MIL-STD-105, except where otherwise indicated.

4.3.1 Examination of the end item. The curtains shall be examined for visual and dimensional defects.

4.3.1.1 Visual examination of the end item. Defects found during this examination shall be classified in accordance with the following list. The lot size shall be expressed in terms of one curtain. For all acceptable quality level examinations, the unit of product shall be expressed in the same terms as the lot size. The applicable inspection level for the curtains shall be level I and the acceptable quality level (AQL) shall be 2.5 major defects per hundred units and 10.0 total defects per hundred units.

Table I. Classification of defects

Examine	Defects	Classification	
		Major	Minor
Material	Not as specified	X	
	Color not uniform	X
	Thread not as specified	X	
	Any spot, stain or other discoloration affecting appearance	X

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TABLE I. Classification of defects (Continued)

Examine	Defects	Classification	
		Major	Minor
	Any holes	X	
	Damage such as cut, tear, or needle chew which may develop into a hole.	X	
Hems	Tie backs not fabricated from one piece	X
	Twisted or irregular in appearance	X
	If electronically heat sealed, not completely bonded	X
	Not seam type EFB-1	X
Stitching	Size not as specified	X
	Not stitch type 301	X	
	Thread breaks on end	X
Hardware	Material or coating not as specified	X	
	Omitted grommets or size not as specified	X
	Burr or sharp edge	X

SPECIAL CCB Application Note:

7. This page was missing in the original document and therefore can not be reproduced electronically. Please contact preparing activity for further information.

TABLE II. Classification of preparation for delivery defects

Examine	Defects
Markings (exterior and interior).	Omitted; incorrect; illegible; or improper size, location, sequence, or method of application.

TABLE II. Classification of preparation for delivery defects (Continued)

Examine	Defects
Materials	Any component missing or damaged.
Workmanship	Inadequate application of components such as incomplete closure of container flaps, loose strapping, inadequate stapling. Distortion of container

5. PREPARATION FOR DELIVERY

For civil agency procurement, the definitions and application of levels of packaging and packing shall be in accordance with Fed. Std. No. 102.

5.1 Packaging. Packaging shall be level A, B, or C, as specified (see 6.1).

5.1.1 Level A.

5.1.1.1 Unit packaging.

5.1.1.1.1 Style I or II. Each style I or style II curtain with tie backs shall be compactly folded and packaged in a close-fitting box conforming to PPP-B-566, PPP-B-665 or PPP-B-676.

5.1.1.1.2 Style III. Each style III curtain set with tie backs shall be compactly folded and packaged in a close-fitting box conforming to PPP-B-566, PPP-B-665 or PPP-B-676.

5.1.1.1.3 Intermediate packaging.

5.1.1.1.3.1 Style I. Twelve unit packages of style I curtains of like description shall be packaged in a box conforming to PPP-B-636, class domestic. The box shall be closed with tape in accordance with the appendix to the box specification.

5.1.2 Level B. The curtains shall be packaged as specified in 5.1.1.

5.1.3 Level C. The curtains shall be packaged in accordance with the supplier's commercial practice.

5.2 Packing. Packing shall be level A, B, or C, as specified (see 6.2).

5.2.1 Level A. The curtains in quantities as specified (see 6.2) of like description shall be packed in a close-fitting box conforming to PPP-B-636, class weather-resistant. The box shall be closed, waterproofed sealed and strapped in accordance with the appendix to the box specification.

5.2.2 Level B.

5.2.2.1 Style I. Six intermediate packages of style I curtains of like description in sizes 36 by 72 inches or 3 intermediate packages of curtains of like description in sizes 72 by 72 inches shall be packed in a close-fitting box conforming to PPP-B-636, class domestic. The box shall be closed in accordance with the appendix to the box specification.

5.2.2.2 Style II. Thirty-six unit packages of style II curtains of like description shall be packed in a close-fitting box conforming to PPP-B-636, class domestic. The box shall be closed in accordance with the appendix to the box specification.

5.2.2.3 Style III. Eighteen unit packages of style III curtains of like description shall be packed in a close-fitting box conforming to PPP-B-636, class domestic. The box shall be closed in accordance with the appendix to the box specification.

5.2.3 Level C. The curtains shall be packed to insure carrier acceptance and safe delivery to destination in containers complying with the rules and regulations applicable to the mode of transportation.

5.3 Marking.

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5.3.1 Civil agencies. In addition to markings required by the contract or order, the interior packages and shipping containers shall be marked in accordance with Fed. Std. No. 123.

5.3.2 Military activities. In addition to markings required by the contract or order, the interior packages and shipping containers shall be marked in accordance with MIL-STD-129.

6. NOTES

6.1 Ordering data. Purchasers should exercise any desired options offered herein and procurement documents should specify the following:

- (a) Title, number, and date of this specification.
- (b) Style, color, and size desired (see 1.2.1, 3.3 and 3.4).
- (c) Level of packaging and packing required (see 5.1 and 5.2).

6.2 Transportation description. Transportation descriptions and minimum weights applicable to this commodity are:

Rail:

Curtains, plastic

Carload minimum weight 20,000 pounds, subject to Rule 34, Uniform Freight Classification.

Motor:

Plastic articles

Truckload minimum weights 10,000, 16,000, 21,000, and 30,000 pounds, subject to Rule 115, National Motor Freight Classification.

U.S. Government Printing Office: 1965-753357/490

Copies of this specification may be purchased for 5 cents each.

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INT. AMENDMENT-2 (GSA-FSS)
March 3, 1970
SUPERSEDING
Int. Amendment-1 (GSA-FSS)
June 24, 1966

INTERIM AMENDMENT

TO

FEDERAL SPECIFICATION

CURTAIN, SHOWER AND WINDOW, PLASTIC

This interim amendment was developed by General Services Administration, Federal Supply Service, Washington, D.C., 20406, based upon currently available technical information. It is recommended that Federal agencies use it in procurement and forward recommendations for changes to the preparing activity at the address shown above.

The General Services Administration has authorized the use of this interim amendment as a valid exception to Federal Specification L-C-780A dated June 11, 1965.

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Paragraph 2.1, delete in its entirety and substitute:

"2.1 The following documents of the issue in effect on date of invitation for bids or request for proposal form a part of this specification to the extent specified herein."

Delete in its entirety the paragraph beginning "(Single copies, etc.)" and substitute:

"(Single copies of this specification and other Federal specifications required by activities outside the Federal Government for bidding purposes are available without charge from Business Service Centers at the General Services Administration Regional Offices in Boston, New York, Washington, D.C., Atlanta, Chicago, Kansas City, Mo., Fort Worth, Denver, San Francisco, Los Angeles and Auburn, Washington.

PAGE 2

Paragraph 3.1.2, add the following sentence:

"Unless otherwise specified, embossed grommets 1/4 +/- 1/16 inch in diameter may be used."

Paragraph 3.2, second column, before the last sentence insert the following:

"When grommets are formed by embossing, the top of the shower curtain shall be reinforced with film material to form the heading. The reinforcement material shall be heat sealed to the curtain. Grommets shall be formed in the heading, through the curtain and reinforcement material, by heat sealing and embossing. The minimum breaking strength of the grommets formed by embossing shall be 15 pounds when tested as specified in 4.5.1.

Paragraph 3.2, second column, last sentence, delete the word "her."

Paragraph 3.3.1, delete the first sentence in its entirety and substitute:

"The finished hemmed dimensions of the shower curtains shall be 36 by 72 inches, 36 by 78 inches, 36 by 80 inches or 72 by 72 inches, as specified (see 6.1)."

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INT. AMENDMENT-2 (GSA-FSS)

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Table I, under "Examine", "Defects", and "Minor", add the following:

Embossed grommet	Poor heat seal resulting in inadequate fusion of embossed grommet.	X
	Burned grommet.	X
	Hole diameter of embossed grommet more than 5/16 inch or less than 3/16 inch.	X

First column, after paragraph 4.3.1.2, add the following new paragraph:

4.3.1.3 Testing of the end item. When the finished shower curtain contains embossed grommets (3.1.2 and 3.2), each lot of the finished shower curtains shall be tested for strength of grommets as specified in 4.5.1. The lot size for the purpose of determining the sample size shall be expressed in units of one curtain. The inspection level shall be S-2 of MIL-STD-105 and the sample unit shall be one curtain. The lot shall be unacceptable if any sample unit fails to meet the requirement specified in 3.2. All test reports shall contain the individual values utilized in expressing the final result.

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First column, after Table II, add the following paragraphs:

4.5 Tests.

4.5.1 Strength of embossed grommets. The strength of the embossed grommets shall be determined in accordance with the following method:

"Test specimens.

Test specimens shall be one from the top heading hems as follows:

Each specimen shall contain one grommet.

Length of the specimen shall be 4 inches and the width of the specimen shall be the width of the hem (including seals or seams).

The distance between one short edge of the specimen and the nearest edge of the grommet hole shall be $1/2 \pm 1/16$ inch.

The number of specimens to be tested shall be the number of grommets in the sample unit.

Apparatus.

Pendulum, constant rate of jaw separation (Scott) tensile testing machine equipped for indicating maximum load carried by the specimen. The width of the grips shall be 2 inches minimum and the distance between the grips before testing shall be 3 inches. The upper set of grips (widthwise) shall be 90 deg. from the lower set. Rate of jaw separation shall be 12 inches per minute.

One regular, commercial shower curtain hook or pin having a wire diameter of $.100 \pm .010$ inch.

Procedure.

Insert the curtain hook through the grommet hole and lock the hook.

Clamp the wide part of the hook in the upper grips.

Clamp the lower portion of the specimen in the lower grips so that the assembly is taut and perpendicular to the wide edge of the grips.

Set lower jaw inspection and record maximum load required to rupture the grommet.

Report.

Report the breaking strength of each grommet. The sample unit shall be considered as follows with respect to grommet strength if two or more grommets in the sample unit rupture below the specified 15 pounds."