

MIL-B-1291D

27 July 1970

SUPERSEDING

MIL-B-1291C

21 August 1967

MILITARY SPECIFICATION

BAG, COTTON DUCK, TOOLS AND MAINTENANCE PARTS, STOVE, COOKING, OUTFIT

This specification is mandatory for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 This specification covers a flat-type cotton duck bag, 8 inches by 10-1/2 inches, with a drawstring closure at its top.

2. APPLICABLE DOCUMENTS

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:

SPECIFICATIONS

FEDERAL

T-T-881	- Twine; Cotton, Seine
V-T-285	- Thread, Polyester
UU-P-268	- Paper, Kraft, Untreated, Wrapping
CCC-C-419	- Cloth, Duck, Cotton, Unbleached, Plied-Yarns, Army and Numbered
CCC-D-950	- Dyeing and Aftertreating Processes for Cotton Cloths
DDD-L-20	- Label; For Clothing, Equipage and Tentage, (General Use)
PPP-B-636	- Box, Fiberboard

MILITARY

MIL-G-16491 - Grommet, Metallic

FSC 5140

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STANDARDS

FEDERAL

FED-STD-751 - Stitches, Seams and Stitchings

MILITARY

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

MIL-STD-129 - Marking for Shipment and Storage

DRAWING

ARMY NATICK LABORATORIES

2-3-52 - Bag, Cotton Duck, Tools and Maintenance Parts,
Stove, Cooking, Outfit

(NOTE: Figure 1 is a miniature reproduction of referenced drawing and is attached for information only.)

(Copies of specifications, standards, and drawing required by suppliers in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

- * 2.2 Other publications.- The following documents form a part of this specification to the extent specified herein. Unless otherwise indicated, the issue in effect on date of invitation for bids or request for proposal shall apply.

UNIFORM CLASSIFICATION COMMITTEE

Uniform Freight Classification

(Application for copies should be addressed to the Uniform Classification Committee, Room 202 Union Station, 516 W. Jackson Blvd., Chicago, Illinois 60606.)

NATIONAL MOTOR FREIGHT TRAFFIC ASSOCIATION, INC.,

National Motor Freight Classification

(Application for copies should be addressed to American Trucking Associations, ATTN: Tariff Order Section, 1616 P Street, N.W., Washington, D.C. 20036.)

(Technical society and technical association specifications and standards are generally available for reference from libraries. They are also distributed among technical groups and using Federal Agencies.)

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3. REQUIREMENTS

3.1 First article.- This specification contains provisions for first article examination and approval (see 4.2, 6.2 and 6.4).

3.2 Materials and components.-

* 3.2.1 Cloth, duck, cotton.- The cloth, before finishing, shall be No. 10, hard texture conforming to type I of CCC-C-419. Finished cloth shall conform to type I, class B, shade olive drab No. 7 of CCC-D-950.

* 3.2.2 Thread, polyester.- The thread shall conform to type I, class 1, subclass B, size F of V-T-285. The thread shall be dyed to match shade S-1 (Cable No. 66022) and shall show fastness to chlorine bleaching equal to or better than the standard shade sample (see 6.3). If no standard sample is available, the dyed sample shall show good fastness to chlorine bleaching.

3.2.3 Twine, seine, cotton.- The cotton seine twine used for drawstrings shall conform to type II No. 120 of T-T-881.

3.2.4 Grommet, metallic.- The grommets shall conform to type II, class 3, size No. 2 of MIL-G-16491.

3.3 Construction.- The construction shall conform to Drawing 2-3-52 and as specified herein.

3.3.1 Stitching, machine.- All machine stitching shall conform to type 301, 6 to 8 stitches per inch of FED-STD-751.

3.3.1.1 Thread breaks.- Thread breaks in stitching shall be overstitched not less than 1 inch at each break.

3.3.1.2 Stitching ends.- Ends of stitching shall be overstitched not less than 1 inch, except where such ends are turned under in a hem, are held down by other stitching, or where stitching is performed automatically.

* 3.3.1.3 Skipped stitches.- Two or more skipped stitches occurring consecutively shall be overstitched not less than 1-inch.

3.3.1.4 The addition of any lubricant to the polyester sewing thread, prior to, or during the sewing operation, is prohibited.

3.3.2 Setting of grommets.- Holes punched to receive grommets shall be smaller than the grommet barrel so that the barrel must be forced through the hole. The grommet shall be clinched without cutting the materials.

3.4 Identification marking.- Identification marking shall be applied in the location shown on Drawing 2-3-52 and shall conform to type IV, class 5 of DDD-L-20.

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- * 3.5 Workmanship.- Cloth components shall be free of holes, cuts, tears or cloth defects such as multiple floats or broken or missing yarns. Twine drawstring components shall be free of cuts or breaks. Thread tension shall be maintained so that there shall be no loose stitching and seam allowances shall be maintained with seams properly sewed so that no runoffs, twists, pleats, or open seams shall result. Care shall be taken to insure that no needle chews occur. All thread ends shall be trimmed to 1/2 inch or less. Metal components shall be free of burrs, sharp edges or corroded areas and shall not be broken or malformed.

4. QUALITY ASSURANCE PROVISIONS

- * 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 in the contract or order, the supplier may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.
- * 4.2 First article inspection.- When a preproduction sample is required, it shall be examined for the defects listed in table I and dimensions specified. Any visual defect or any dimension not within the specified requirements shall be cause for rejection of the preproduction sample.
- * 4.3 Inspection.- Sampling for inspection shall be performed in accordance with MIL-STD-105, except where otherwise indicated hereinafter.

4.3.1 Component and material inspection.- In accordance with 4.1 above, components and materials shall be inspected and tested in accordance with all the requirements of referenced specifications, drawings and standards unless otherwise excluded, amended, modified or qualified in this specification or applicable purchase document.

4.3.2 Process examination.- Examination shall be made to determine the following:

- a. That there is no lubrication of polyester thread, either prior to, or during the sewing operation in compliance with 3.3.1.4.
- b. That holes punched to receive grommets are in compliance with 3.3.2.

Whenever nonconformance is noted, correction shall be made to the items affected and to the process.

4.3.3 End product inspection.- A lot shall consist of all completely fabricated tool bags offered for inspection at one time. The sample unit shall be one completely fabricated tool bag. The inspection levels and acceptable quality levels (AQL's) shall be as specified in 4.3.3.3.

4.3.3.1 Visual examination.- The completely fabricated tool bag shall be examined for defects in table I.

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TABLE I.- Classification of defects for visual characteristics

Examine	Defect	Classification	
		Major	Minor A B
Fabric	Cut, tear, or hole:		
	- greater than 1/8 inch but not greater than 1/4 in length or diameter		X
	- greater than 1/4 inch in length or diameter		X
	Broken or missing yarn, multiple floats visible at normal inspection distance (approx. 3 ft)		X
Twine drawstrings	Any cut; any break		X
	Not threaded through hem as specified	X	
	Ends not overhand knotted		X
Grommets	Broken	X	
	Malformed:		
	- fails to perform intended function	X	
	- but will perform intended function		X
	Corroded area		X
	Burr or sharp edge which may cause injury in handling or damage to fabric	X	
	Improperly set; two or more teeth exposed		X
	Clinched loosely, allowing grommet to rotate in hole or to become disengaged		X
Seams and stitching	Clinched tight, cutting fabric	X	
	Open seam:		
	- for more than 1/4 inch but not more than 1 inch		X
	- for more than 1-inch		X

NOTE: A seam shall be classified as open when one or more stitches joining a seam are broken, or when one or more consecutive skipped or run-off stitches occur. On double stitched seams, a seam shall be classified as open when either one or both sides of a seam are open.

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TABLE I.- Classification of defects for visual characteristics (cont'd)

Examine	Defects	Classification	
		Major	Minor A B
Seams and stitching (cont'd)	Raw edge:		
	- more than 1/2 inch but not more than 1-1/2 inches		X
	- more than 1-1/2 inches	X	
	Thread breaks overstitched less than 1 inch		X
	NOTE: Thread breaks not overstitched shall be classified as open seams.		
	Skipped stitches:		
	- overstitched less than 1-inch (when two or more skipped stitches occur consecutively)	X	
	NOTE: Skipped stitches not overstitched shall be classified as open seams.		
	Needle chew resulting in cut tear or hole (see cut, tear or hole)		
	One or more required rows of stitching omitted	X	
Stitching ends	Overstitched less than 1 inch (except where ends are held down by other stitching or turned under in a hem)		X
Seams	Seam pleated		X
Seam type	Wrong seam type	X	
Stitch type	Wrong stitch type	X	
Stitch tension	Loose, resulting in an exposed bobbin or top thread, for more than 2 inches		X

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TABLE I.- Classification of defects for visual characteristics (cont'd)

Examine	Defect	Classification	
		Major	Minor A B
Seams and stitching (cont'd)			
Stitch tension (cont'd)	Tight, as evidenced by puckering of fabric on seams, for more than 2 inches		X
Stitches per inch	Less than minimum specified:		
	- one stitch		X
	- two or more stitches	X	
	More than maximum specified:		
	- one stitch		X
	- two or more stitches	X	
NOTE: Variation in the number of stitches per inch caused by the operator speeding up the machine and pulling the fabric in order to sew over heavy places or in turning corners shall be classified as follows:			
a. Within the minor "B" defect classification - no defect			
b. Within the minor "A" defect classification - minor "B" defect			
Stitching gage	Not as specified		X
Stitching margin	Larger than specified by more than 3/16 inch:		
	- for less than 4 inches in length		X
	- for 4 inches or more in length	X	
Components and assembly	Any operation omitted or incorrectly performed	X	
Hem	Formed on wrong side of bag		X
	Twisted or pleated		X
	Width of hem less than specified by more than 1/4 inch		X

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TABLE I.- Classification of defects for visual characteristics (cont'd)

Examine	Defect	Classification	
		Major	Minor A B
Identification marking	Omitted, incorrect, illegible or misplaced		X
	Size of characters not as specified		X
Cleanness	Grease or oil stains, thread ends not trimmed to 1/2 inch or less		X

4.3.3.2 Dimensional examination.— An examination of the bag shall be made to determine compliance with dimensional requirements. Any dimension not within specified requirements will be classified as a defect.

4.3.3.3 Inspection levels and AQL's.— The inspection levels and AQL's, expressed in terms of defects per hundred units, shall be as follows:

<u>Examination</u>	<u>Inspection level</u>	<u>AQL's</u>
For defects applicable to table I	II	2.5 Major
		6.5 Major and minor A defects combined
		15.0 Total (major, minor A and B defects combined)
For defects applicable to 4.3.3.2	S-3	10.0 One class

- * 4.3.4 Examination of preparation for delivery requirements.— An examination shall be made to determine that packaging, packing and marking are in compliance with the requirements of section 5. Defects shall be scored in accordance with table II. The sample unit shall be one shipping container fully prepared for delivery. The lot shall be the number of shipping containers offered for inspection at one time. The inspection level shall be S-2 and the AQL, expressed in terms of defects per hundred units, shall be 2.5.

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TABLE II.- Examination of preparation for delivery

<u>Examine</u>	<u>Defect</u>
Marking	Omitted, incorrect, illegible, or improper size, location, sequence, or method of application.
Materials	Any component missing or damaged.
Workmanship	Bulging or distortion of container.
Contents	Number of bundles per container is more or less than required. Number of bags per bundle is more or less than required.

- * 4.3.5 Examination of shipping containers.-- When shipping containers are required to be in accordance with PPP-B-636, examination for defects in closure, waterproofing and reinforcing shall be in accordance with the appendix of that specification.

5. PREPARATION FOR DELIVERY

5.1 Packaging.-- Packaging shall be level A or C, as specified (see 6.2).

5.1.1 Level A.-- Each bag, with drawstrings tucked inside the bag, shall be smoothed out flat. Ten bags, alternated top to bottom, shall be neatly stacked to form a bundle measuring approximately 10-1/2 inches in length, 8-inches in width, and 6-1/4 inches in depth. The bundle shall be securely crosstied with cotton tape or twine.

- * 5.1.2 Level C.-- Bags shall be packaged to afford adequate protection against physical damage during shipment from the supply source to the first receiving activity. The supplier may use his standard practice when it meets this requirement.

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

- * 5.2.1 Level A.-- One hundred and twenty bags, packaged as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC-L, grade V2s of PPP-B-636. The inside of each shipping container shall be fitted with a taped liner conforming to grade V3c of PPP-B-636. Level A packages shall be packed flat three in length, two in width, and two in depth within a shipping container. Inside dimensions of each shipping container shall approximate 24-1/2 inches in length, 21-1/2 inches in width, and 12-1/2 inches in depth. Approximate dimensions are furnished as a guide only. Each container shall have the contents completely covered on the top and bottom with a sheet of 30-pound minimum basis weight kraft paper

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conforming to grade B of UU-P-268. Each shipping container shall be closed, waterproofed, and reinforced in accordance with the appendix of the container specification.

- * 5.2.2 Level B.- One hundred and twenty bags, packaged as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC-L, type CF (variety SW) or SF, class domestic, grade 275 of PPP-B-636. The inside of each shipping container shall be fitted with a taped liner conforming to class domestic, variety SW, grade 275 of PPP-B-636. Level A packages shall be packed flat three in length, two in width, and two in depth within a shipping container. Inside dimensions of each shipping container shall approximate 24-1/2 inches in length, 21-1/2 inches in width, and 12-1/2 inches in depth. Approximate dimensions are furnished as a guide only. Each container shall have the contents completely covered on the top and bottom with a sheet of 30-pound minimum basis weight kraft paper conforming to grade B of UU-P-268. Each shipping container shall be closed in accordance with method II as specified in the appendix of the container specification.

- * 5.2.2.1 When specified (see 6.2), the shipping container shall be a grade V3c, V3s or V4s fiberboard box fabricated in accordance with PPP-B-636 and closed in accordance with the appendix thereto.

- * 5.2.3 Level C.- Bags, packaged as specified in 5.1, shall be packed in a manner to insure carrier acceptance and safe delivery to destination at the lowest transportation rate for such supplies. Containers shall be in accordance with Uniform Freight Classification Rules or National Motor Freight Classification Rules, as applicable.

5.3 Marking.- In addition to any special marking required by the contract or order, interior packages and shipping containers shall be marked in accordance with MIL-STD-129. Each interior package shall have attached a manila colored paper shipping tag for the identification information.

6. NOTES

6.1 Intended use.- The cotton duck bag covered by this specification is designed to contain, and to protect from dust and dirt, various items such as wrenches and maintenance parts of a cooking stove in Cooking Outfit, Field, Small Detachment.

6.2 Ordering data.- Procurement documents should specify the following:

- (a) Title, number and date of this specification.
- (b) First article (see 3.1, 4.2 and 6.4).
- (c) Selection of applicable levels of packaging and packing (see 5.1 and 5.2).

- (d) When V-board shipping containers are required for level B shipments (see 5.2.2.1).

6.3 Standard sample.- For access to a standard shade sample of thread, address the procuring office issuing the invitation for bids.

- * 6.4 First article.- The item covered by this specification requires first article examination and approval under appropriate provisions of paragraph 7-104.55 of the Armed Services Procurement Regulations. The first article should be a preproduction sample consisting of one complete unit. The contracting officer should include specific instructions in all procurement instruments regarding arrangements for examination and approval of the first article.

6.5 The margins of this specification are marked with an asterisk (*) to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and suppliers are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous issue.

Custodians:

Army - GL
Navy - SA
Air Force - 69

Preparing activity:

Army - GL
Project No. 8105-0166

Review activities:

Army - CE
Air Force - 84

User activities:

Army - ME, AV
Navy - MC

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SPECIFICATION ANALYSIS SHEET		Form Approved Budget Bureau No. 22-R255
<p>INSTRUCTIONS: This sheet is to be filled out by personnel, either Government or contractor, involved in the use of the specification in procurement of products for ultimate use by the Department of Defense. This sheet is provided for obtaining information on the use of this specification which will insure that suitable products can be procured with a minimum amount of delay and at the least cost. Comments and the return of this form will be appreciated. Fold on lines on reverse side, staple in corner, and send to preparing activity. Comments and suggestions submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or serve to amend contractual requirements.</p>		
SPECIFICATION		MTL-B-1291D
Bag, Cotton Duck, Tools and Maintenance Parts, Stove, Cooking, Outfit		
ORGANIZATION		
CITY AND STATE		CONTRACT NUMBER
MATERIAL PROCURED UNDER A <input type="checkbox"/> DIRECT GOVERNMENT CONTRACT <input type="checkbox"/> SUBCONTRACT		
1. HAS ANY PART OF THE SPECIFICATION CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE? A. GIVE PARAGRAPH NUMBER AND WORDING.		
B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES		
2. COMMENTS ON ANY SPECIFICATION REQUIREMENT CONSIDERED TOO RIGID		
3. IS THE SPECIFICATION RESTRICTIVE? <input type="checkbox"/> YES <input type="checkbox"/> NO (If "yes", in what way?)		
4. REMARKS (Attach any pertinent data which may be of use in improving this specification. If there are additional papers, attach to form and place both in an envelope addressed to preparing activity)		
SUBMITTED BY (Printed or typed name and activity - Optional)		DATE

DD FORM 1426
1 JAN 66

REPLACES EDITION OF 1 OCT 64 WHICH MAY BE USED.