

MIL-B-1462F
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 SUPERSEDING
 MIL-B-1462E(GL)
 15 June 1977

MILITARY SPECIFICATION

BELT, GENERAL OFFICER'S

This specification is approved for use by the U.S. Army Natick Research, Development, and Engineering Center, Department of the Army, and is available for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This document covers a leather belt for general officers.

1.2 Classification. The belts shall be of the following sizes as specified (see 6.2).

Schedule of sizes

28	34	40
29	35	41
30	36	42
31	37	43
32	38	44
33	39	45
		46

2. APPLICABLE DOCUMENTS

2.1 Government documents.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: U.S. Army Natick Research, Development, and Engineering Center, Natick, MA 01760-5014, by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter,

AMSC H/A

FSC 8440

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2.1.1 Documents. The following documents form a part of *this* document to the extent specified herein. Unless otherwise specified, the issues of these documents shall be those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation.

SPECIFICATIONS

FEDERAL

- V-T-285 - Thread, Polyester
- KK-L-271 - Leather, Cattlehide, Strap, Vegetable Tanned
- UU-P-553 - Paper, Wrapping, Tissue
- PPP-B-636 - Boxes, Shipping, Fiberboard
- PPP-B-676 - Boxes, Setup
- PPP-T-45 - Tape, Gummed, Paper, Reinforced and Plain, for Sealing and Securing

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- MIL-F-10884 - Fasteners, Snap
- MIL-L-35078 - Loads, Unit; Preparation of *Semiperishable* Subsistence Items; Clothing, Personal Equipment and Equipage; General Specification For
- MIL-W-43061 - Wax, Machine Stitching

STANDARDS

FEDERAL

- FED-STD-311 - Leather, Methods of Sampling and Testing
- FED-STD-751 - Stitches, Seams, and Stitchings

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- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
- MIL-STD-129 - Marking for Shipment and Storage
- MIL-STD-147 - Palletized Unit Loads
- MIL-STD-731 - Quality of Wood Members for Containers and Pallets

DRAWINGS

U.S. ARMY NATICK RESEARCH, DEVELOPMENT, AND ENGINEERING CENTER

- 2-4-54 - Belt, General Officer's; Assembly, Details and Sections

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(Copies of documents required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting activity.)

2.2 Other publications. The following documents form a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DOD adopted shall be those listed in the issue of the DODISS specified in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS shall be the issues of the nongovernment documents which are current on the date of the solicitation.

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

D 3951 - Standard Practice for Commercial Packaging

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

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

2.3 Order of precedence. In the event of a conflict between the text of this document and the references cited herein, the text of this document shall take precedence. Nothing in this document, however, shall supersede applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 First article. When specified in the contract or purchase order, a sample shall be subjected to first article inspection (see 4.3, 6.2, and 6.4).

3.2 Materials.

3.2.1 Leather, cattlehide. The leather shall be full grain cattlehide side leather and shall be chrome tanned or vegetable tanned or combination tanned with chrome and vegetable tanning agents. The area of a side shall be no greater than 22 square feet. The leather shall be drum dyed and finished shade Black 111 and shall match the standard sample (see 6.3). The leather shall have a two-way boarded appearance. The thickness of the leather components shall be as specified in the drawing. All exposed raw edges of the leather in the belt shall be stained to match the color of the grain surface of the leather. The leather shall be tested in accordance with 4.4.1 for resistance to dry and wet crocking. Staining of the dry crock cloth shall be not lower than Munsell value 9.0 and staining of the wet crock cloth shall be not lower than Munsell value 8.5.

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3.2.2 Leather, cattlehide, vegetable tanned. The filler strip shall be leather conforming to type II or III, class 2 of KK-L-271 except that the leather shall be flesh splits. The thickness of the filler strip shall be as specified in the drawing. The color shall be natural and no finish shall be applied. Requirements applicable to colorfastness, cracking, breaking force and elongation are not applicable.

3.2.3 Thread, polyester. The thread shall be Black AA, C.A. 66043, type I, class 1, subclass C and size 3 conforming to V-T-285.

3.2.4 Tape, pressure-sensitive adhesive, 5/8 inch wide. The tape shall be made from a woven base fabric weighing 3 to 4 ounces per square yard.

3.2.5 Wax, stitching. The wax shall be black conforming to MIL-W-43061.

3.2.6 Fasteners, snap. The snap fasteners shall conform to style 2A, finish 3 of MIL-F-10884. The button and eyelet shall be of sufficient length to insure a secure clinch.

3.2.7 Staples. The staples shall be cadmium plated steel wire or stainless steel wire, 18 gauge. The stapling machine shall be pre-set to form staples approximately 3/8 inch wide and 3/16 inch leg length. The staples shall be securely clinched.

3.3 Construction. The construction shall conform in all respects to Drawing 2-4-54 and as specified herein.

3.3.1 Stitches, seams and stitchings. All stitching shall conform to stitch type 301 of FED-STD-751, with 6 to 8 stitches per inch. Stitching shall be performed on a machine using the hot wax specified in 3.2.5. Thread tension shall be maintained so that there will be no loose stitching resulting in a loose bobbin or top thread or no excessively tight stitching resulting in puckering of the material sewn. The stitch lock will be embedded in the center of the material sewed. All thread ends shall be trimmed to a maximum length of 1/4 inch. Ends of seams and stitching, except on the keeper, when not caught in other seams or stitching shall be overstitched one stitch.

3.3.1.1 Repairs of type 301 stitching. Repairs of stitching shall be as follows:

a. When thread breaks or bobbin run-outs occur during sewing, the stitching shall be repaired by restarting the stitching one stitch back of the end of stitching.

b. Thread breaks or two or more consecutive skipped or run-off stitches noted during inspection of the item (in-process or end item) shall be repaired by overstitching. The stitching shall start one stitch back of the defective area and continue one stitch beyond the defective area onto the existing

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stitching. Loose or tight stitching shall be repaired by removing the defective stitching without damaging the material and restitching in the required manner. 1/

1/ When making the above repairs, the ends of stitching are not required to be backstitched.

3.3.2 Setting of style 2A snap fasteners. The hole punched before inserting the male or female part of the fastener shall be smaller than the outside diameter of the fastener tube so that the tube must be forced through the hole. The fasteners shall be securely clinched.

3.4 Marking.

4 Size marking. The belt size shall be indented in the leather on the inner side of belt upon the facing in the size characters and in the location shown on Drawing 2-4-54. No other brands or marks shall appear upon the belts.

5 Replacement of defective components. During the spreading, cutting, and manufacturing process, components having material defects or damages that are classified as defects in 4.4.3 and 4.4.4 shall be removed from production and replaced with nondefective and properly matched components.

3.6 Workmanship. The belt shall conform to the quality of product established by this document and the occurrence of defects shall not exceed the applicable acceptable quality levels.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or purchase order, the contractor 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 this document where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.1.1 Responsibility for compliance. All items must meet all requirements of sections 3 and 5. The inspection set forth in this document shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirement in the document shall not relieve the contractor of the responsibility of assuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling in quality conformance does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to acceptance of defective material.

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4.1.2 Responsibility for dimensional requirements. Unless otherwise specified in the contract or purchase order, the contractor is responsible for assuring that all specified dimensions have been met. When dimensions cannot be examined on the end item, inspection shall be made at any point, or at all points in the manufacturing process necessary to assure compliance with all dimensional requirements.

4.1.3 Certificates. When certificates of compliance are submitted, the Government reserves the right to inspect such items to determine the validity of the certification.

4.2 Classification of inspection. The inspection requirements specified herein are classified as follows:

- a. First article inspection (see 4.3).
- b. Quality conformance inspection (see 4.4).

4.3 First article inspection. When a first article is required (see 6.2), it shall be examined for the defects specified in 4.4.3 and 4.4.4. The presence of any defect shall be cause for rejection of the first article.

4.4 Quality conformance inspection. Unless otherwise specified, sampling for inspection shall be performed in accordance with MIL-STD-105.

4.4.1 Component and material inspection. In accordance with 4.1, components and materials shall be inspected in accordance with all requirements of referenced documents unless otherwise excluded, amended, modified or qualified in this document or applicable purchase document. In addition, the full grain leather shall be tested for colorfastness (resistance to crocking) in accordance with Method 3031 of FED-STD-371. The lot shall be rejected if any specimen fails to meet requirements for colorfastness. Sampling for testing the leather shall be in accordance with sampling procedures for non-fabricated leather as defined in FED-STD-311.

4.4.1.1 Certification. The contractor shall furnish a certificate of compliance for the requirements specified in 3.2.4 and 3.2.7. The contractor shall also certify that the leather specified in 3.2.1 is full grain cattlehide tanned and drum dyed in accordance with 3.2.1 and does not exceed 22 square feet in total area. Failure to comply with any of the above requirements shall be cause for rejection of the lot.

4 In-process inspection. Inspection of sub-assemblies shall be made to ascertain that construction details which cannot be examined in the finished product are in accordance with specified requirements. The Government reserves the right to exclude from consideration for acceptance, any material or service for which in-process inspection has indicated nonconformance.

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4.4.3 End item visual examination. The end items shall be examined for the defects listed in table I. The lot size shall be expressed in units of belts. The sample unit shall be one belt. The inspection level shall be II and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 2.5 for major defects and 6.5 for total (major and minor combined) defects.

TABLE I. End item visual defects

Examine	Defect	Classification	
		Major	Minor
Color and finish of grain cattlehide leather	Black color does not compare favorably with approved sample or color not uniform seriously affecting appearance.	X	
	Color not uniform affecting appearance but not seriously		X
	Not specified boarded finish		X
Thread	Not specified color	X	
Cleanliness	Any permanent stain or spot clearly noticeable, that cannot be removed	X	
	Any spot or stain removable with cleaning agent		X
Belt size	Not as specified	X	
Material, general	Any component not fabricated of the specified material	X	
Quality of grain cattlehide leather	Not full grain	X	
	Any hole, cut, or rupture:		
	- Seriously affecting serviceability or appearance	X	
	- Affecting serviceability or appearance but not seriously		X
	Damage to grain of leather, boney or brittle leather:		
- Seriously affecting serviceability or appearance	X		
- Affecting serviceability or appearance but not seriously		X	

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TABLE I. End item visual defects (cont'd)

Examine	Defect	Classification		
		Major	Minor	
Quality of grain cattlehide leather (cont'd)	Scar tissue (e.g., badly healed, scratch or brand), abraded grain, flanky leather, heavy fat wrinkle: - Seriously affecting serviceability or appearance	X		
			X	
	Distinct difference in grain structure between leather parts of an assembly: - Seriously affecting appearance	X		
			X	
	Loose or pipey leather: - Seriously affecting serviceability or appearance	X		
			X	
	Construction and workmanship	Any component or assembly omitted or misplaced, operation omitted or not properly performed: (i.e., belt loop positioned at angle that affects proper closure; snap fastener reversed in assembly to belt) - Seriously affecting serviceability or appearance	X	
				X
		Any part fractured, ripped, punctured, torn, defective, malformed, or damaged: - Seriously affecting serviceability	X	
				X
Belt not fabricated with grain side of leather on exterior surfaces		X		
Edges and laps of leather parts not edged and stained as specified or irregularly edged and stained affecting appearance			X	

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TABLE I. End item visual defects (cont'd)

Examine	Defect	Classification	
		Major	Minor
Construction and workmanship (cont'd)	Any part not skived where required		X
	Not constructed with proper number of leather pieces	X	
Metal components	Any snap fastener or staple not securely set or clinched	X	
	Snap fastener too tightly clinched resulting in cutting of leather	X	
	Snap fastener does not function properly, i.e., fails to snap close, provide a secure closure, or open freely	X	
	Incorrect style snap fastener	X	
	NOTE: The fastener shall be snapped and unsnapped twice to determine whether parts of fastener separate freely and also effect a secure closure.		
	Any sharp burr or metal sliver	X	
Seams and stitching	Not specified stitch type	X	
	Spacing of stitching irregular or not as specified:		
	- Seriously affecting serviceability or appearance	X	
	- Affecting serviceability or appearance, but not seriously		X
	Loose stitch tension resulting in a loosely secured seam	X	
	More than three continuous stitch locks exposed on surface of leather but the seam is tight		X
	Tight stitch tension, i.e. stitches rupture leather	X	
	Any row of stitching omitted	X	
	Four or five stitches per inch		X
	Less than four stitches per inch	X	
	More than eight stitches per inch, damaging leather	X	
	More than eight stitches per inch but not damaging leather		X
Thread ends not trimmed as specified		X	
Any open seam	X		
Repair of seam not as specified		X	

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TABLE I. End item visual defects (cont'd)

<u>Examine</u>	<u>Classification</u>
Seams and stitching (cont'd)	NOTE: A seam shall be classified as open when one or more stitches joining a seam are broken or when two or more consecutive skipped or run-off stitches occur
Marking	Missing; incomplete; incorrect; not legible, not specified size, not in proper location, not accomplished as specified X

4.4.4 End item dimensional examination. Examination shall be made of the belt for conformance to the dimensions annotated with an asterisk (*) on Drawing 2-4-54. The lot size shall be expressed in units of belts. The sample unit shall be one belt. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 4.0.

4.4.5 Packaging examination. The fully packaged end items shall be examined for the defects listed below. The lot size shall be expressed in units of shipping containers. The sample unit shall be one shipping container fully packaged. The inspection level shall be S-2 and the AQL, expressed in terms of defects per hundred units, shall be 2.5.

<u>Examine</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 specified
Workmanship	Inadequate application of components, such as: incomplete sealing or closure of flap, improper taping, inadequate stapling, loose strapping Open and non-continuous heat sealed seams (including closure seam) Omission of vent hole in polyethylene bag Incorrectly fabricated bag Bulged or distorted container
Content	Number of belts per shipping container is more or less than specified

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4.4.6 Palletization examination. The fully packaged and palletized end items shall be examined for the defects listed below. The lot size shall be expressed in units of palletized unit loads. The sample unit shall be one palletized unit load, fully packaged. The inspection level shall be S-1 and the AQL, expressed in terms of defects per hundred units, shall be 6.5.

<u>Examine</u>	<u>Defect</u>
Final shed dimensions	Length, width, or height exceeds specified maximum requirement
Palletization	Pallet pattern not as specified Interlocking of loads not as specified Load not bonded with required straps as specified
Weight	Exceeds maximum load limits
Marking	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application

5. PACKAGING

5.1 Preservation. Preservation shall be level A or Commercial as specified (see 6.2).

5.1.1 Level A. Each coiled belt shall be completely wrapped in tissue paper conforming to type I, class 1 or 2 of UU-P-553 or placed in a snug-fitting clear polyethylene film bag of 0.00125 inch thickness (+ 25 percent tolerance). The polyethylene bag shall be formed with heat sealed seams that are straight, continuous, and parallel to each other and the formed edges of the bag. The bag closure shall be effected by heat sealing with the heat seal as close as possible to the open end. The bag may be fabricated from polyethylene film tubing or sheeting. A 1/4 inch diameter hole shall be made at one corner of each bag to allow the excess air to escape. Each wrapped or bagged belt shall be packed in a snug-fitting set-up paperboard box conforming to type 1, variety 1, class A, style 4 of PPP-B-676. Dimensions shall approximate 6 inches in length, 6 inches in width, and 1-3/4 inches in depth. Approximate dimensions are furnished as a guide only. Box closure shall be secured with 2-inch minimum width gummed paper tape conforming to type III, grade B of PPP-T-45, applied at the center of the length opening and extending along the bottom and up each side at least one-half the depth of the box.

5.1.2 Commercial. Belts shall be preserved in accordance with ASTM D 3951.

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

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5.2.1 Level A packing. Forty-eight belts of one size only, preserved as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC, grade V2s of PPP-B-636. Inside dimensions of the shipping container shall approximate 18 inches in length, 12 inches in width, and 10-1/2 inches in depth. Approximate dimensions are furnished as a guide only. Each shipping container shall be closed in accordance with method III, waterproofed in accordance with method V, and reinforced as specified in the appendix of PPP-B-636, except that inspection shall be in accordance with 4.4.5. Toward the end of the contract, or when there is less than the required amount per shipping container of the same size, mixed sizes may be packed within the same shipping container. Shipping containers shall be arranged in unit loads in accordance with MIL-L-35078 for the type and class of load specified (see 6.21). Strapping shall be limited to nonmetallic strapping, except for type II, class F loads.

5.2.2 Level B packing. Forty-eight belts of one size only, preserved as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC, type CF (variety SW) or SF, class domestic, grade 275 of PPP-B-636. Inside dimensions of the shipping container shall approximate 18 inches in length, 12 inches in width, and 10-1/2 inches in depth. Approximate dimensions are furnished as a guide only. Each shipping container shall be closed in accordance with method II as specified in the appendix of PPP-3-636, except that inspection shall be in accordance with 4.4.5. Toward the end of the contract, or when there is less than the required amount per shipping container of the same size, mixed sizes may be packed within the same shipping container.

5.2.2.1 Weather-resistant fiberboard containers. 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 method III as specified in the appendix of PPP-3-636, except that inspection shall be in accordance with 4.4.5.

5.2.3 Commercial. Belts, preserved as specified in 5.1, shall be packed in accordance with ASTM D 3951.

5.3 Palletization. When specified (see 6.2), belts, packed as specified in 5.2.2 and 5.2.3 shall be palletized on a 4-way entry pallet in accordance with load type Ia of MIL-STD-147. Pallet type shall be type I (4-way entry), type IV, or type V in accordance with MIL-STD-147. Pallets shall be fabricated from wood groups I, II, III, or IV of MIL-STD-731. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding means K and L or film bonding means O or P. Pallet pattern shall be number 7 in accordance with the appendix of MIL-STD-147.

5.4 Marking. In addition to any special marking required by the contract, interior packages and shipping containers shall be marked in accordance with MIL-STD-129 or ASTM D 3951, as applicable.

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5.4.1 Polyethylene bagged unit packs. Polyethylene bagged unit packs shall have the required identification information legibly printed or stamped in black directly on the bag across the center face *or* on a white paper label inserted within the bag so as to permit ready identification.

5.4.2 Labels, mixed sizes. Each shipping container packed with mixed sizes shall have securely attached to the end and side, directly under the printing or stercilling, a white paper label 5-by 4-inches with *the* words "MIXED NSN's" plainly stamped or printed thereon and under these words shall be legibly stamped or printed the correct quantity and NSN's contained therein.

6. NOTES

6.1 Intended use. The belt is for use by general officers. The Buckle, General Officers' Belt, Gold-Plated conforming to MIL-B-40006 is used with the belt.

6.2 Ordering data. Acquisition documents should specify the following:

- a. Title, number, and date of this document.
- b. Belt sizes (see 1.2.1).
- c. When a first article sample is required (see 3.1, 4.3, and 6.4).
- d. Selection of applicable levels of preservation-packaging and packing (see 5.1 and 5.2).
- e. Type and class of unit load required (see 5.2.1).
- f. When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).
- g. When palletization is required (see 5.3).

6.3 Sample. For access to a standard shade sample of leather, address the procuring activity issuing the invitation for bids.

6.4 First article. When a first article is required, it shall be inspected and approved under the appropriate provisions of FAR 52.209. The first article should be a preproduction sample. The contracting officer should specify the appropriate type of first article and the number of units to be furnished. The contracting officer should include specific instructions in all acquisition instruments, regarding arrangements for selection, inspection, and approval of the first article.

6.5 Subject term (key word) listing.

Belt
General officers

6.6 Changes from previous issue. Asterisks are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.

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Custodians:

Army - GL
Navy - NU

Review activities:

Army - MD
DLA - CT

Preparing activity:

Army - GL

Project No. 8440-A173