

MIL-B-37038A
24 February 1976
SUPERSEDING
MIL-B-37038
15 March 1975

MILITARY SPECIFICATION

BLANKETS, BED, COTTON, THERMAL WEAVE, WHITE

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

1. SCOPE

1.1 Scope. This specification covers the requirements for one type and two sizes of a white (bleached), thermal weave, cotton, bed blankets.

1.2 Classification. The blankets shall be furnished in the following sizes, as specified (see 6.2):

Size 1 - 30 by 40 inches

Size 2 - 66 by 90 inches

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

V-T-276
DDD-L-20

PPP-B-636

Thread, Cotton
Label; for Clothing, Equipage and
Tentage (General Use),
Boxes, Shipping, Fiberboard.

FSC 7210

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STANDARDS

FEDERAL

FED-TEST METHOD STD No. 191 - Textile Test Methods
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

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

3. REQUIREMENTS

3.1 Materials and components. The materials and components shall conform to the applicable specifications and standards listed or required herein.

3.1.1 Blanket cloth. The blanket cloth shall be fabricated from a grade and staple length of cotton, carded, drawn and spun into yarn that when inspected as specified in 4.3.1 and 4.3.1.1 shall conform to the requirements of Table I. The finished cloth shall not be flame retardant treated.

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Table I. Blanket Cloth Properties

Characteristics	Requirements
Weave:	
Body	Cellular leno
Border (each side)	Cellular leno or plain
Color	White (Bleached)
Yarn number and ply:	
Warp	3/2 to 5/2
Filling	3/2 to 5/2
Yarns per inch, body, minimum:	
Warp	7
Filling	11
Yarns per inch, border, minimum:	
Warp	8
Filling	11
Breaking strength, body, pounds, minimum:	
Warp	70
Filling	70
Thickness, body, inch, minimum	0.109
Width of border, inches:	
Size 1 (30 inch width)	1-1/2 to 5-1/2
Size 2 (66 inch width)	4 to 6
Nonfibrous materials, percent maximum 1/	5.0
Flammability, seconds minimum	10.0

1/ Includes the starch and protein content and the chloroform and water soluble materials.

3.1.2 Thread. All the sewing operations shall be performed with the cotton thread conforming to V-T-276, Type 1A1 or 1A2, Ticket Number 30, 3 ply.

3.2 Design. The blanket shall be fabricated from one piece of the cloth without any joining seams, rectangular in shape with hemmed ends (see 3.3.1).

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3.3 Construction. The stitch and stitching types used in the construction of the blanket shall conform to FED-STD-751. Each row of stitching shall be straight and parallel to the seam edge. The straightness of the stitching, in any row, shall be maintained within a tolerance of plus or minus 1/32 inch. The ends of Stitch Type 301 stitching shall be backstitched, by overlapping on themselves, a minimum of 1/2 inch. Each thread break, skip, and run-off shall be overstitched not less than 1/2 inch. The thread tension shall be maintained so that there shall not be any loose or tight stitching and the lock shall be embedded in the materials sewn together. The seam allowances shall be maintained so that no run-off or open seam shall occur. All seams shall start and finish uniformly. No seam shall be twisted, puckered, or pleated and no part of the blanket shall be caught in an unrelated operation or seam. All the sewing thread ends shall be trimmed to a maximum length of 1/4 inch. No cut or raw edge shall be visible.

3.3.1 Construction details. Each blanket shall be fabricated from one piece of the blanket cloth with selvaged sides. Each end shall be turned down with each raw edge turned under, for $1/2 + 1/8$ inch, to form a hem $1 + 1/8$ inch wide, Stitching Type Efb-2 using Stitch Type 301 with a minimum of 6 stitches per inch. Each hem shall be sewn with two rows of stitching, 3/16 to 5/16 inch apart, in a manner that shall catch the turn under. As an alternate, one or two sides of the Size 1, 30 by 40 inches, blanket may be hemmed. The width of the turn under and hem shall be the same as that specified for the ends. No side of the Size 2, 66 by 90 inches, blanket shall be hemmed. The Size 2 blanket may contain a centered plain weave stripe, approximately 2 inches wide, in the entire length of the blanket. The leno weave shall be in the length direction.

3.4 Performance inspection.

3.4.1 Weight. When inspected as specified in 4.3.4.1, the minimum weight of each blanket shall be as follows:

<u>Size</u>	<u>Dimension</u>	<u>Pounds, Minimum</u>
1	30 by 40 inches	0.5
2	66 by 90 inches	2.5

3.4.2 Dimensions. When inspected as specified in 4.3.4.2, the minimum dimensions of each blanket shall be as follows:

<u>Size</u>	<u>Minimum Dimensions</u>
1	30 by 40 inches
2	66 by 90 inches

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3.5 Identification label. The identification label shall conform to DDD-L-20, Type I, Class 1, Launderable Label. The size of the label shall be adequate to contain the following information:

BLANKET, BED, COTTON, THERMAL WEAVE, WHITE
SIZE 30 by 40 or 66 by 90, as applicable
CONTRACT OR ORDER NUMBER
NAME OF MANUFACTURER
NSN

The label shall be a sew-on or heat attachable type. The label shall be attached on all four sides to the underside of the blanket at the lower right hand corner using Stitch Type 301 with 8 stitches per inch minimum. As an alternate, the top or bottom edge of the label may be caught in the hem stitching and the remaining three sides may be sewn to the blanket. No portion of the printing on the label shall be obscured when the label is caught in the hem stitching. When heat attachable labels are used, the back of the label shall contain a thermoplastic compound suitable for being attached to the blanket by heat. When adhered to the blanket, the label shall remain completely adhered without any evidence of separation when inspected as specified in 4.3.2.1.

3.6 Workmanship. The blankets shall not contain any stain, hole, abraded area, tear, cut, mend, patch, scorch, needle chew and any other defect which detracts from its appearance or may impair its serviceability. The blankets shall conform to the quality of grade established by this specification. The occurrence of defects shall not exceed the acceptance criteria established herein.

4. QUALITY ASSURANCE PROVISIONS

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

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4.1.1 Material and component inspection. In accordance with 4.1, the materials and components shall be inspected and tested in accordance with all the requirements of the referenced specifications and standards, unless otherwise excluded, amended, modified, or qualified in this specification or purchase document.

4.1.2 Certificate of quality. When certificates of quality are submitted in accordance with Table II, they shall contain verifiable actual test and inspection data. The Government reserves the right to inspect and test the components to verify the validity of the certification.

4.1.3 Inspection. Inspection, as used in this specification, is defined as both examination (an investigation without the use of special laboratory apparatus or procedures such as visual) and testing (a determination by technical means of the physical and chemical properties) of the item.

4.2 Quality conformance inspection. The sampling and inspection shall conform to MIL-STD-105, except where otherwise indicated herein-after. The quality conformance inspection shall consist of the tests and examinations specified in Table II.

4.2.1 Sampling.

4.2.1.1 Inspection lot.

4.2.1.1.1 Blanket cloth. An inspection lot size shall be expressed in units of one linear yard of the blanket cloth and shall consist of all the blanket cloth received by the blanket manufacturer at one time. The sample unit for inspection shall be one linear yard of the blanket cloth.

4.2.1.1.2 Labels. An inspection lot size shall be expressed in units of one label and shall consist of all the labels received by the blanket manufacturer at one time. The sample unit for inspection shall be one label.

4.2.1.1.3 Blankets. An inspection lot size shall be expressed in units of one blanket made essentially under the same conditions and from the same materials and components. The sample unit for inspection shall be one blanket.

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4.2.1.1.4 Preparation of delivery. An inspection lot size shall be expressed in units of one fully prepared shipping container, containing blankets of one size, fully prepared for delivery from essentially the same materials and components. The sample unit for inspection shall be one shipping container, containing blankets of one size, fully prepared for delivery with the exception that it need not be sealed.

4.2.1.2 Sampling for tests and examinations of the blanket cloth, labels, blankets and preparation for delivery. The sample size, acceptance criteria, tests and examinations required for the blanket cloth, labels, blankets or the preparation for delivery, as applicable, shall be as specified in Table II.

TABLE II. SAMPLE SIZE, ACCEPTANCE CRITERIA, TESTS AND EXAMINATIONS OF THE BLANKET CLOTH, LABELS, BLANKETS AND PREPARATION FOR DELIVERY

ITEM	INSPECTION	PARAGRAPH		SAMPLE SIZE	ACCEPTANCE CRITERIA	
		REQUIREMENT	METHOD			
Blanket Cloth <u>1/</u>	Material	3.1.1	4.3.1	<u>2/</u>	<u>2/</u>	<u>3/</u>
	Weave	3.1.1	4.3.1.1	<u>2/</u>	<u>2/</u>	<u>3/</u>
	Color	3.1.1	4.3.1.1	<u>2/</u>	<u>2/</u>	
	Yarn number	3.1.1	4.3.1.1	<u>2/</u>	<u>2/</u>	<u>3/</u>
	Ply of yarn	3.1.1	4.3.1.1	<u>2/</u>	<u>2/</u>	<u>3/</u>
	Yarns per inch	3.1.1	4.3.1	<u>2/</u>	<u>2/</u>	<u>3/</u>
	Breaking strength	3.1.1	4.3.1	<u>2/</u>	<u>2/</u>	
	Thickness	3.1.1	4.3.1	<u>2/</u>	<u>2/</u>	
	Width of border	3.1.1	4.3.1.1	<u>2/</u>	<u>2/</u>	
	Nonfibrous material	3.1.1	4.3.1	<u>2/</u>	<u>2/</u>	
	Flammability	3.1.1	4.3.1	<u>2/</u>	<u>2/</u>	
Labels <u>1/</u>	Adherence <u>5/</u>	3.5	4.3.2.1	<u>4/</u>	<u>3/</u>	<u>4/</u>

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TABLE II. SAMPLE SIZE, ACCEPTANCE CRITERIA, TESTS AND EXAMINATIONS OF THE BLANKET CLOTH, LABELS, BLANKETS AND PREPARATION FOR DELIVERY (Cont'd)

ITEM	INSPECTION	PARAGRAPH		SAMPLE SIZE	ACCEPTANCE CRITERIA
		REQUIREMENT	METHOD		
Blankets	Visual Examination	3.2 through 3.3.1 3.5 and 3.6	4.3.3.1	Inspection Level II	An acceptable quality level of 2.5 defects per 100 units for Major defects and 6.5 defects per 100 units for total (major plus minor) defects
	Weight	3.4.1	4.3.4.1	Inspection Level S-2	An acceptable quality level of 2.5 defects per 100 units
	Dimensions	3.4.2	4.3.4.2	Inspection Level S-2	An acceptable quality level of 2.5 defects per 100 units
	Preparation for Delivery	Section 5	4.3.3.2	Inspection Level S-2	An acceptable quality level of 2.5 defects per 100 units

1/ The inspection of the blanket cloth and labels shall be conducted either at the contractor's or subcontractor's plant.

2/ The sampling for the testing of the blanket cloth shall be in accordance with 4.2.1.1.1 and as follows:

<u>Lot Size (yards)</u>	<u>Sample Size</u>
800 or less	2
801 up to and including 22,000	3
22,001 and over	5

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The samples shall be taken from the beginning of each roll. The lot shall be unacceptable if one or more sample units fail to meet any of the requirements specified in Table II. Each sample unit taken for inspection shall be used to determine all the characteristics of the blanket cloth specified in Table II.

3/ A certificate of quality may be submitted (see 4.1.2).

4/ The sampling for the testing of the labels shall be in accordance with 4.2.1.1.2 and as follows:

<u>Lot Size (number of labels)</u>	<u>Sample Size</u>
800 or less	2
801 up to and including 22,000	3
22,001 and over	5

The lot shall be unacceptable if one or more of the sample units fail to meet the adherence requirement.

5/ This inspection is only applicable to the labels with thermoplastic backing (heat attachable).

4.3 Inspection methods.

4.3.1 Blanket cloth. The blanket cloth characteristics shall be determined in accordance with the inspection methods of FED-TEST METHOD STD NO. 191 specified in Table III and 4.3.1.1.

<u>TABLE III. Blanket Cloth Properties</u>	
<u>Characteristics</u>	<u>FED-STD-191 Method</u>
Cotton Identification	1200
Yarns per Inch	5050
Breaking Strength	5100 <u>1/</u>
Thickness	5030
Nonfibrous Materials	2611
Flammability	5908

1/ The size of the front jaw for each clamp shall be one by 3 inches.

4.3.1.1 Weave, yarn number, ply of yarn, color and width of border. The weave, yarn number and ply of yarn shall be determined by any standard commercial method. The color shall be determined visually. The width of the border shall be determined with the use of any suitable measuring device.

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4.3.2 Labels. The adherence characteristic of the labels with thermoplastic backing shall be determined in accordance with 4.3.2.1.

4.3.2.1 Adherence. The label with thermoplastic backing shall be attached to the blanket cloth with heat in accordance with the instructions of the manufacturer of the label with thermoplastic backing. The attached labels shall then be laundered for eight consecutive times in accordance with FED-TEST METHOD STD NO. 191, Method 5605. Upon completion of the eighth laundering, the label shall be examined for any evidence of separation from the fabric (see 3.5).

4.3.3 Visual examination.

4.3.3.1 Blankets. Each blanket selected in accordance with Table II as a sample unit from the lot shall be examined visually to determine conformance to this specification. The classification of defects, Table IV, shall be used to classify and enumerate the defects found.

TABLE IV. CLASSIFICATION OF DEFECTS FOR THE VISUAL
EXAMINATION OF THE ASSEMBLED BLANKETS

Defect	Major	Minor
<u>GENERAL</u>		
a. Any hole, scissors or knife cut, tear, mend, burn, or weakening defect such as smash, multiple float, loose slub, needle chew, or abraded area	X	
b. Any portion of the blanket stiffened or scorched by any process of manufacturing	X	
c. Any missing or broken yarn, thin or thick place, misweave, woven in waste, loose yarn, or snagged thread	<u>1</u> /	
d. Color of any component not as specified		X

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TABLE IV. CLASSIFICATION OF DEFECTS FOR THE VISUAL
EXAMINATION OF THE ASSEMBLED BLANKETS (Continued)

Defect	Major	Minor
<u>CLEANNESS</u>		
a. Three or more thread ends not trimmed to a maximum length of 1/4 inch or three or more thread scraps not removed		X
b. Any unsightly slub or stain		X
<u>COMPONENTS AND ASSEMBLY</u>		
a. Any component not as specified or any defect of component or defect of assembly, not herein classified	<u>1/</u>	
b. Any component, component part, or required operation omitted, or any operation improperly performed, not herein classified	<u>1/</u>	
<u>SEAMS AND STITCHING</u>		
a. <u>Accuracy of seaming:</u>		
1. Any hem twisted, puckered, or pleated; any part of the blanket caught in an unrelated operation or stitching		X
2. <u>Ends of stitching:</u>		
(a) Any not securely backstitched	X	
(b) Any secure but backstitched for a distance less than 1/2 inch or the backstitching is not overlapped on itself		X
3. <u>Thread breaks:</u>		
(a) Any not securely overstitched	X	
(b) Any secure but overstitched for a distance less than 1/2 inch		X

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TABL 1. CLASSIFICATION OF DEFECTS FOR THE VISUAL EXAMINATION OF THE ASSEMBLED BLANKETS (Continued)		
Defect	Major	Minor
<u>SEAMS AND STITCHING</u>		
b. <u>Gage of stitching</u> 2/:		
1. Any stitching irregular, uneven or not gaged as specified, or not uniform		X
c. <u>Open seams</u> 3/:		
1. Any more than 1/8 inch but not more than 1/4 inch		X
2. Any more than 1/4 inch	X	
d. <u>Raw edges</u> 4/:		
1. Any more than 1/4 inch but not more than 1/2 inch		X
2. Any more than 1/2 inch	X	
e. <u>Stitching and stitch type:</u>		
1. Not specified stitching type or stitch	1/	
f. <u>Stitch tension:</u>		
1. Any loose stitching 5/	1/	
2. Any tight stitching, resulting in breakage of the stitches, when normal pull is applied 6/	X	
g. <u>Stitches per inch</u> 7/:		
1. <u>Stitches less than specified:</u>		
(a) <u>Blanket (excluding label):</u>		
(1) One		X
(2) More than one	X	

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TABLE IV. CLASSIFICATION OF DEFECTS FOR THE VISUAL
EXAMINATION OF THE ASSEMBLED BLANKETS (Continued)

Defect	Major	Minor
g. <u>Stitches per inch</u> <u>7/</u> (continued):		
(b) <u>Label</u> :		
(1) One or 2		X
(2) More than 2	X	
<u>BLANKETS</u>		
a. Any not fabricated from one piece of cloth (contains a joining seam)	X	
b. Any hem more than 1-1/8 inches or less than 7/8 inch		X
c. Any hem on any side of the Size 2 blankets		X
d. Leno weave on any blanket not in the length direction		X
<u>LABEL</u>		
a. Incomplete, incorrect, or illegible		X
b. Not located as specified		X
c. Stitching omitted on one or more edges, as applicable		X
d. When applicable, any evidence of separation of any heat attached label		X

1/ The defect shall be classified and scored as a major defect, when it seriously affects the serviceability or appearance, otherwise it shall be classified and scored as a minor defect.

2/ The gage of stitching defect shall be scored only when the condition exists for more than 2 inches on any row of stitching.

3/ A seam shall be classified and scored as open when one or more stitches joining a seam are broken or when two or more continuous skipped stitches or run-offs occur. On double stitched seams, a seam shall be classified and scored as open when either one or both sides of the seam contain any of the aforementioned for a single stitched seam.

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- 4/ Any edge that should be turned under and is not, but is securely caught in the stitching, shall be classified and scored, as a raw edge. Any raw edge, that is not securely caught in the stitching shall be classified and scored as an open seam.
- 5/ A seam shall be classified and scored as loose when the top and bobbin threads are on the same surface.
- 6/ Puckering is evidence of tight tension or gathering of the material. When puckering is evident and is not caused by the gathering of the material, the stitching shall be inspected for tight tension and breaking of stitches by exerting normal pull in the lengthwise direction of the stitching, by pulling the material taut to straighten out the seam. Puckering due to the gathering of the material shall be classified and scored as an accuracy of seaming defect.
- 7/ The stitches per inch defect shall be scored only when the condition exists for more than 3 inches on any row of stitching.

4.3.3.2 Preparation for delivery. Each of the fully prepared shipping containers, containing blankets of one size, selected in accordance with Table II as a sample unit from the lot, shall be visually examined to determine that the packaging, packing, and marking conform to this specification. The list of defects, Table V, shall be used to enumerate the defects.

TABLE V. LIST OF DEFECTS FOR PREPARATION FOR DELIVERY

Item	Defect
Exterior and interior markings	Missing, incorrect, incomplete, or illegible; improper location, sequence, or method of application not as specified; size shown on any exterior container or on the label of the blanket not the same.
Packaging and packing material	Any non-conforming component; any component or component part missing, damage, or otherwise defective.
Workmanship	Inadequate application of the components such as incomplete closure of any exterior container, container flap, or loose strapping; bulging or distortion of any container; any polyethylene bag damaged, any vent hole missing, or any open or non-continuous heat sealed seam.

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TABLE V. LIST OF DEFECTS FOR PREPARATION FOR DELIVERY (Cont'd)

Item	Defect
Exterior and interior weight or content	Gross or net weight exceeds the requirement; number per container more or less than specified; more than one size blanket in the same container; any portion of the blanket caught in any heat sealed seam; any blanket distorted or damaged; any not individually packaged within the polyethylene bag.

4.3.4 Performance inspection.

4.3.4.1 Weight. The weight of the blankets shall be determined on any scale or balance capable of weighing to the nearest 0.1 of a pound.

4.3.4.2 Dimensions. The width and length of the blankets shall be determined after the blankets have been laundered in accordance with FED-TEST METHOD STD NO. 191, Method 5550. The size of the blanket shall be determined with the use of any suitable measuring device.

5. PREPARATION FOR DELIVERY

5.1 Packaging. Packaging shall be Level A or C as specified (see 6.2).

5.1.1 Unit of issue. Each blanket of the size, as specified, constitutes one unit of issue.

5.1.2 Level A.

5.1.2.1 Unit package. Each blanket shall be thoroughly clean and neatly folded to an appropriate size and inserted in a snug fitting flat or square style clear polyethylene bag of 0.003 inch thickness (+ 20 percent tolerance). The bag shall be formed with heat sealed seams that are straight, continuous, and parallel to each other and the formed edges of the bag. A 1/4 inch diameter hole shall be made at one corner of the bag to allow excess air to escape and the closure shall be effected by heat sealing or by means of a tuck or reverse flap.

5.1.3 Level C. Blankets shall be packaged in standard commercial containers of the size and kind commonly used, which will afford the degree of protection required for shipment and use of the product for its intended purpose.

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

5.2.1 Level A. Thirty-six (36) size 1 blankets or ten (10) size 2 blankets packaged as specified in 5.1.2.1, shall be packed flat in a snug fitting box constructed in accordance with PPP-B-636, grade V3c or V3s, style RSC-L. Each box shall have the contents covered on the top and bottom with a sheet of 30 pound minimum basis weight kraft paper. Closure, strapping and waterproofing shall be as specified in the appendix of PPP-B-636.

NOTE: Strapping shall not be required for shipments forwarded to a receiving activity within the continental limits of the United States for storage and redistribution.

5.2.2 Level B. Thirty-six (36) size 1 blankets or ten (10) size 2 blankets packaged as specified in 5.1.2.1, shall be packed flat in a snug fitting box constructed in accordance with PPP-B-636, class domestic, grade 275, style RSC-L. Each box shall have the contents covered on the top and bottom with a sheet of 30 pound minimum basis kraft paper. Closure of the box shall conform to method II as specified in the appendix of PPP-B-636.

5.2.3 Level C. Blankets shall be packed in substantial commercial containers, of the type, size, and kind commonly used for the purpose, so constructed as to insure acceptance and safe delivery by common or other carriers, at the lowest rate, to point of delivery called for in the contract or purchase order.

5.3 Marking.

5.3.1 Unit packages. Each polyethylene bag shall have the required information legibly printed in black directly on the bag across the center face or on a white label inserted within the bag so as to permit ready identification. The bag or label shall indicate the following information.

STOCK NUMBER
 SIZE
 QUANTITY (I EA)
 LEVEL OF PACKAGING & DATE PACKED
 CONTRACT OR PURCHASE ORDER NO.
 NAME OF CONTRACTOR

5.3.2 Exterior container. Exterior container shall be marked in accordance with MIL-STD-129.

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6. NOTES

6.1 Intended use. The blankets covered by this specification are intended for use as bed coverings in hospitals, nurseries, and in oxygen enriched environments. The Size 1 blanket is intended for infants. The Size 2 blanket is intended for general hospital use.

6.2 Ordering data. Procurement documents shall specify the following:

- (a) Title, number and date of this specification.
- (b) Quantity and size required (see 1.2).
- (c) Selection of applicable levels of packaging and packing (see 5.1 and 5.2).

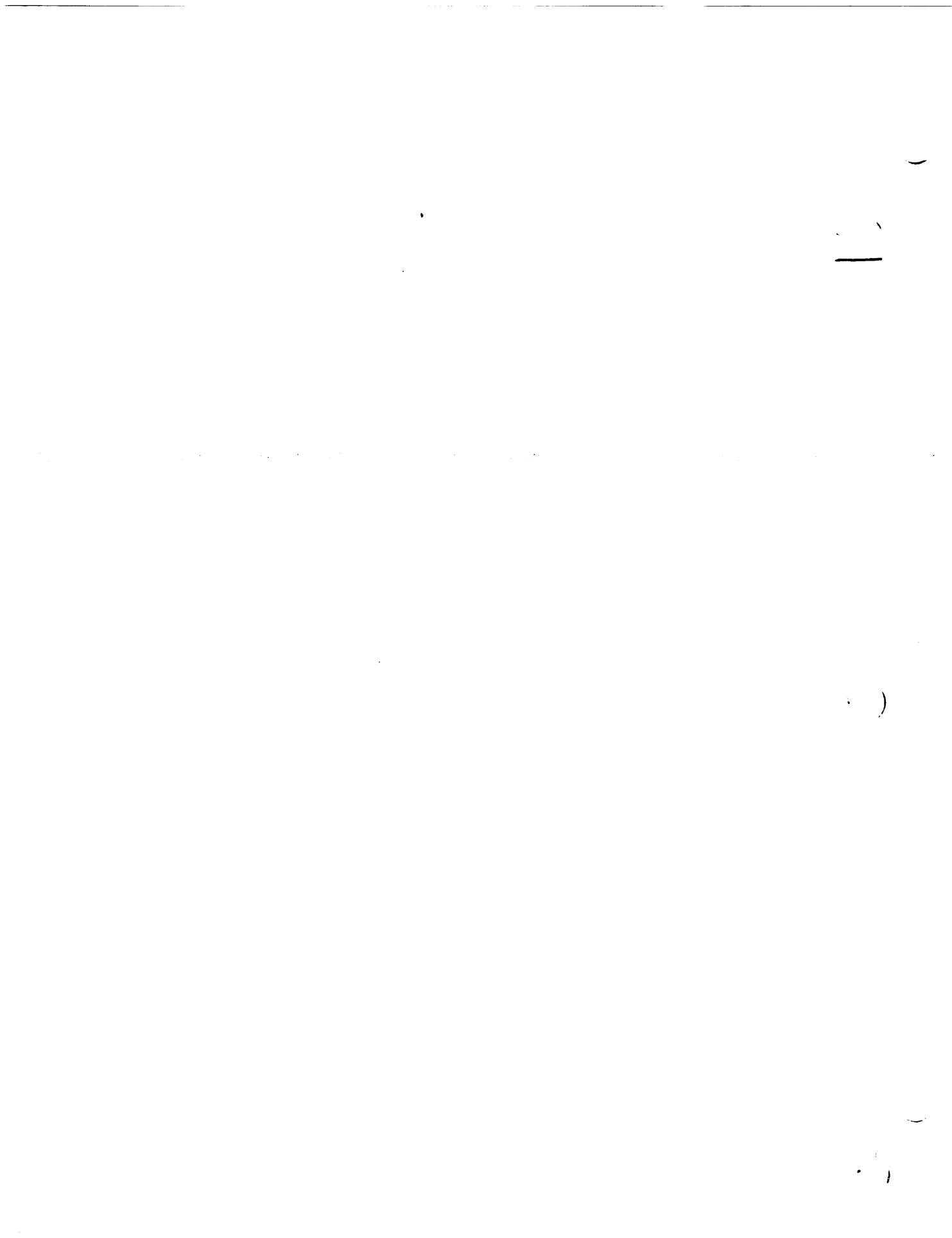
6.3 Catalog Information. This specification is intended to cover the following items appearing in the Federal Supply Catalog:

<u>NATIONAL STOCK NO.</u>	<u>ITEM IDENTIFICATION</u>	<u>SIZE</u>
7210-00-139-5778	BLANKET, BED, Cotton, Thermal Weave, Infant, White, 40 in. long, 30 in. wide.	1
7210-00-139-5779	BLANKET, BED, Cotton, Thermal Weave, White, 90 in. long, 66 in. wide.	2

Custodians:
Army - MD
Navy - MS
Air Force - 03

Preparing activity:
Defense Supply Agency - DM

Project No. 7210-0205



4 GPO: 1974-603-080/6126 2-1

FOLD

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