MIL-B-6362F(USAF)
8 September 1976
SUPERSEDING
MIL-B-6362E
29 April 1966

MILITARY SPECIFICATION

BOOTS, EXTREME COLD WEATHER, N-1B

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

1. SCOPE

* 1.1 Scope. This specification covers one type of man's heavy rubber-soled boot which is designated N-1B.

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

S - for foot sizes 6-1/2 to 7-1/2
M - for foot sizes 8 to 9
L - for foot sizes 9-1/2 to 10-1/2
XL - for foot sizes 11 to 12

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 the specification to the extent specified herein.

SPECIFICATIONS

Federal

C-F-206	Felt Sheet: Cloth, Felt, Wool, Pressed
V-F-106	Fasteners, Slide, Interlocking
V-L-61	Laces, Nylon
V-T-295	Thread, Nylon
UU-P-268	Paper, Kraft, Untreated, Wrapping
CCC-C-419	Cloth, Duck, Cotton, Unbleached, Plied-Yarns, Army And Numbered
CCC-C-428	Cloth, Duck, Cotton; Fire, Water, Weather, And Mildew Resistant
CCC-C-429	Cloth, Osnaburg Cotton
CCC-D-950	Dyeing And Aftertreating Processes For Cotton Cloths
DDD-B-1199	Binding Textile, Cotton, Bias-Cut
PPP-B-636	Box, Fiberboard

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: San Antonio Air Logistics Center, Engineering Division, ATTN: MMEDO, Kelly AFB TX 78241 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

Military

MIL-W-530	Webbing And Tape, Textile, Cotton, General Purpose, Natural Or In Colors
MIL-I-1986	Insole, Footwear, Felt, Insulating
MIL-O-6082	Lubricating Oil; Aircraft Reciprocating Engine (Piston)
MIL-T-43566	Tape, Textile, Cotton, General Purpose, Natural Or In Colors

STANDARDS

Federal

FED-STD-191	Textile Test Methods
FED-STD-601	Rubber: Sampling and Testing
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
MIL-STD-130	Identification Marking Of US Military Property
MIL-STD-143	Specifications and Standards, Order Of Precedence For The Selection Of

DRAWING

Air Force

51F24415	Patterns - Boots, Mukluk, Man's Heavy, Medium Size

(Copies of specifications, standards, drawings, and publications 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.

American Society for Testing Materials

ASTM D-1630	Method of Test for Abrasion Resistance of Rubber Soles and Heels
ASTM D-2176-69	Method of Test for Folding Endurance (MIT Tester)

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

3. REQUIREMENTS

3.1 Preproduction sample. When specified (see 6.2), before production is commenced, one finished pair of boots shall be submitted or made ready for the contracting officer or his authorized representative for inspection as specified in 4.2. The approval of the preproduction sample authorizes the commencement of production but does not relieve the supplier of responsibility for compliance with all applicable provisions of this specification. The preproduction sample shall be manufactured by the supplier in the same facilities to be used for the manufacture of the preproduction items.

3.2 Selection of specifications and standards. Specifications and standards for necessary commodities and services not specified herein shall be selected in accordance with MIL-STD-143.

3.3 Materials.

3.3.1 Rubber.

3.3.1.1 Flexibility. The rubber compounds and the sole area of the boot shall not crack or break when tested as specified in 4.3.4.1.

3.3.1.2 Tackiness. The rubber compounds shall show no evidence of tackiness when tested as specified in 4.3.2.2.1.

3.3.1.3 Swelling. The swelling of the rubber compound shall not exceed 27 percent when tested as specified in 4.3.2.2.2.

3.3.1.4 Abrasive index. The abrasive index of the sole and heel shall be not less than 45. The abrasive index, after aging, shall be not less than 75 percent of the original when tested as specified in 4.3.2.2.3.

3.3.1.5 Vulcanization. Vulcanization shall be accomplished at temperatures to properly cure the rubber portions of the boot without damage to the boot as a whole.

3.3.2 Rubber unit.

3.3.2.1 Insole. The insole shall be made from a good grade of stiffening compound facing with cotton duck on the foot side. The duck shall be of insole grade weighing not less than 7 ounces per square yard. The finished insole shall gage not less than 0.090 and not more than 0.100 inch.

3.3.2.2 Outer filler. The bottom shall be reinforced with an outer filler made from a good grade of stiffening material backed with cotton fabric weighing not less than 3 ounces per square yard. The fabric side of the outer filler shall be toward the outsole.

3.3.2.3 Counter. The counter shall be fabricated from standard cotton sheeting which weighs not less than 2.5 ounces per square yard and which has been frictioned and backed with stiffening compound.

3.3.2.4 Friction heel piece. The friction heel piece shall be made from standard cotton sheeting weighing not less than 2.5 ounces per square yard and shall be frictioned on both sides and coated on one side with gum compound

not less than 0.005 inch thick. The friction heel piece shall cover the counter and shall extend beyond the upper margins of the counter for not less than 1/4 inch.

3.3.2.5 Foxing. The foxing shall be cut from gum stock 0.025 inch thick and shall be 1-1/4 inches (plus or minus 1/16 inch) wide. The foxing shall extend forward around the lower part of the foot section from the shank.

3.3.2.6 Gum heel piece. The gum heel piece shall be 0.025 inch thick, shall cover the exposed area of the friction heel piece, and shall extend beyond the upper edges of the heel piece not less than 1/4 inch.

3.3.2.7 Outsole. The outsole shall be cleated and shall be cut from calendared outsole compound. The outsole shall be not less than 0.275 inch thick at the ball and not less than 0.100 inch thick at the heel.

3.3.2.8 Heel. The heel shall be cleated and shall be cut from calendared outsole stock. The heel shall be not less than 0.500 inch thick, exclusive of the outsole thickness.

* 3.3.3 Upper unit. The upper unit shall be fabricated from Army duck conforming to CCC-C-419, type III, 12.29 ounce weight per square yard, minimum. The duck shall be treated for water and weather resistance in accordance with Type I, Class A of CCC-D-950 except for flexibility.

* 3.3.3.1 Flexibility. The finished cloth shall show maximum bending movement as follows, when tested for this characteristic in accordance with FED-STD-191, method 5202.

Initial (Inch-Pounds under STD Conditions)
0.012

At 0° ±5°F (inch pounds)
0.030

In addition, the treated duck shall withstand a minimum of 12000 MIT endurance flex folds (in each direction) when tested in accordance with Method ASTM D2176-69 at 0° ±5°F with a load tension of 1.5 kilograms (kg).

* 3.3.4 Stays. The front and back stays shall be fabricated from 1-inch-wide tape conforming to MIL-T-43566, type 1, class 8, except that the requirements for fastness to chlorine bleaching and laundering shall not apply. The tape shall be water resistant. The dyeing and water resistance treatment shall conform to CCC-D-950, type 1, class A. The tape shall be dyed sage green and shall approximate USAF Color, shade No. 1531. The eyelet stays shall be fabricated from cotton osnaburg cloth conforming to CCC-C-429, class 3, and shall be frictioned or cemented on both sides and faced both front and back with duck as specified in 3.3.3. A certificate of compliance shall be acceptable for these characteristics

3.3.5 Eyelets. The eyelets shall be fabricated from steel (suitably treated to prevent corrosion), brass, or aluminum. The eyelets shall be of the telescopic type, black finished, and shall have an inside diameter, after insertion, of not less than 1/4 inch.

3.3.6 Thread. The nylon thread shall conform to V-T-295, type I or II, class 1, and as specified in Table I.

TABLE I. THREAD

Operation	Size
Closing	E
Staying	E
Binding	B
Eyestay Stitching	E
Barring	E
Raceway	E
Hemming	E

* 3.3.7 Slide fastener. The slide fastener shall conform to type I, style 3, size MH, brass chain in accordance with V-F-106. Zinc alloy chain may be used as an alternate. The remaining metal components shall be compatible with the chain as directed in V-F-106. The slide fastener chair shall extend from the end of the turned webbing on the front closure at the instep to the top tunnel stitching (plus or minus 1/8 inch). The slide of the fastener shall have a short tab pull with an opening to accommodate a 3/8 inch webbing thong. The finish of metallic parts shall be in accordance with 3.16 of V-F-106; brass shall have a black chemical finish and zinc alloy shall have the manufacturers standard greenish gray chromate finish. The salt spray requirements of V-F-106 shall not apply.

3.3.8 Slide fastener thong. The pull tab for the slide fastener shall be equipped with a 3/8-inch-wide cotton webbing thong conforming to MIL-W-530, type IIa, class 3. The thong shall be threaded through the slot of the pull tab and secured by an overhand knot. The ends of the webbing shall extend approximately 3 inches beyond the pull tab.

* 3.3.9 Felt insole. The removable felt insoles shall conform to type I, class 12R3, 1/4 inch ±1/32 inch thick of C-F-206.

3.3.10 Laces. The laces shall conform to V-L-61, type II, class 2, color sage green USAF shade No. 1509. Each boot shall have two laces; one shall be 36 inches long, inserted in the tunnel, and the other shall be 54 inches long, inserted in the eyelets.

* 3.3.11 Binding. The bias binding shall conform to DDD-B-1199, type II or IV. The width of the binding shall be 1/2 inch (plus or minus 1/16 inch) after folding.

3.4 Design. The boot shall consist of a fabric upper unit, a rubber sole unit, and two removable felt insoles. The tread shall be a nonslip, cleated, or heavily knurled design, and the finished boot shall conform to the general design shown on Figure 1.

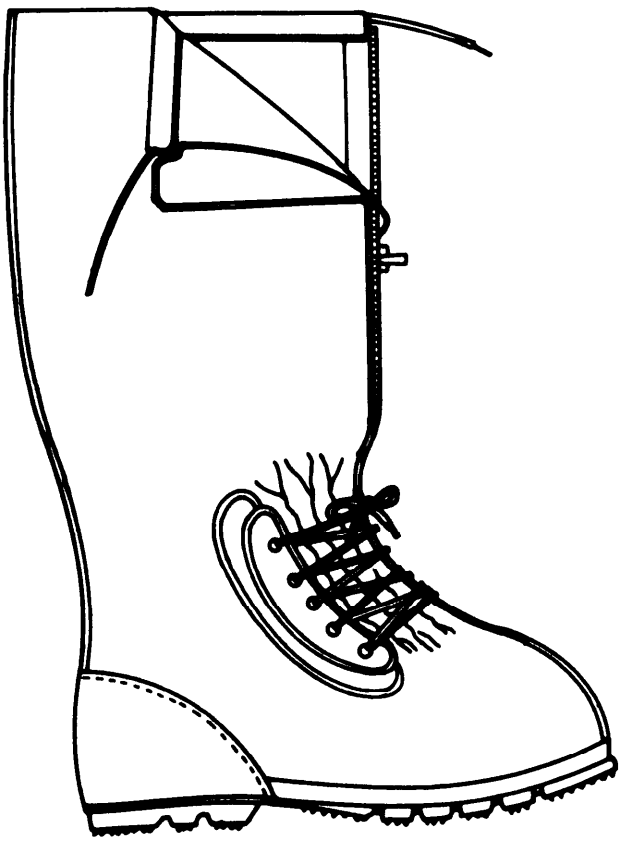


FIGURE 1. FINISHED BOOT

3.5 Construction. The boot shall be constructed over lasts conforming to Table II and Figure 2. The use of extension arm lasts will be permitted.

TABLE II. LASTS

(All Dimensions in Inches)

Description	Sizes				Tolerances All Sizes
	S	M	L	XL	
Length of Bottom	11	11-1/2	12	12-1/2	±1/16
Ball	13-7/8	14-1/4	14-5/8	15	±1/32
Waist	13-3/4	14-1/8	14-1/2	14-7/8	±1/8
Instep	14	14-3/8	14-3/4	15-1/8	±1/16
Heel	19-3/4	20-1/2	21-1/4	22	±1/16
Ankle	16-1/8	16-1/2	16-7/8	17-1/4	±1/16
Leg 10 Inches	17-3/8	17-3/4	18-1/8	18-1/2	±1/16
Leg 14 Inches	17-5/8	18	18-3/8	18-3/4	±1/16
Leg 20 Inches	18-5/8	19	19-3/8	19-3/4	±1/16
Ball Tread	4-3/8	4-1/2	4-5/8	4-3/4	±1/32

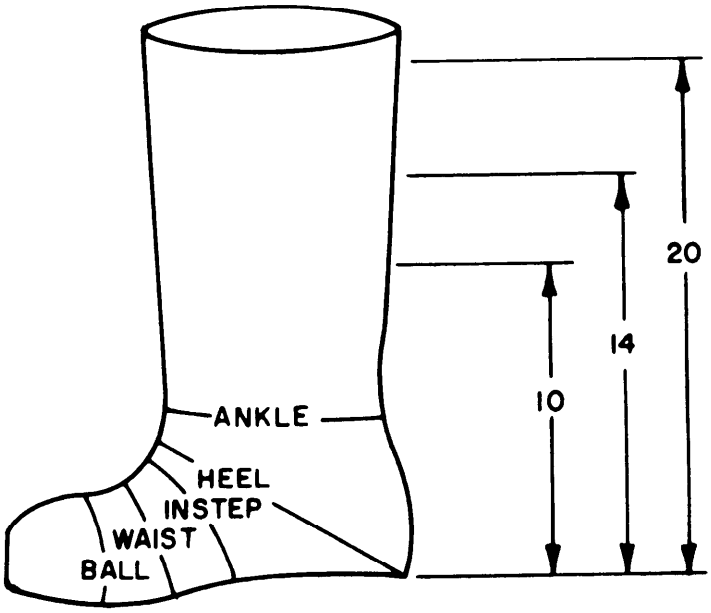
3.5.1 Cutting. The quarters, eyelet stay facings, eyelet stay reinforcements, and tongues shall be cut from cotton duck. The front and back stays shall be cut to length from cotton webbing. The eyelet stays shall be cut from standard osnaburg cloth.

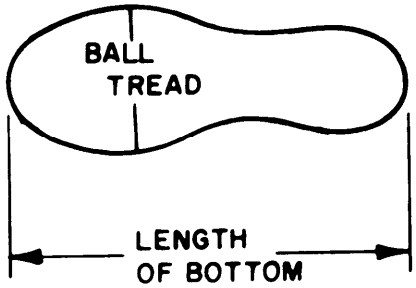
3.5.2 Back seam closure. The quarters shall be closed at the back with seam margins reversed and stayed with stay tape. Seam type SSf-3 shall be used with eight stitches (plus or minus one stitch) per inch.

3.5.3 Tunnel. The top of the quarters shall be turned under 1 inch and stitched down to form a tunnel for the top lace. The tunnel shall be sewn with two rows of stitching, spaced not less than 1/8 nor more than 3/32 inch apart, with 10 stitches (plus or minus 1 stitch) per inch.

* 3.5.4 Front seam closure. The front seam closure from the end of the slid fastener to the foxing shall be accomplished in the same manner as the back seam closure. The end of the webbing which contacts the slide fastener stop shall be turned and stitched. A slide fastener opening downward from the top of the boot shall be stitched to the quarters with four rows of stitching spaced 1/8 inch (plus or minus 1/16 inch) apart. Two rows of the stitching shall be applied to the folded edge of the quarters and two rows shall be applied to the edge of the fastener tape. The four rows of slide fastener stitching shall be continuous from the tunnel down one quarter across the folded front webbing stay and up the other quarter to the tunnel or as an alternate, the four rows of slide fastener stitching may be accomplished prior to turning down the tunnel provided the slide fastener stitching is caught in the tunnel stitching. The ends of the stitching shall be backstitched 1/2 inch (Plus or minus 1/16 inch).

3.5.5 Tongue. The tongue shall be stitched to the inside quarter behind the slide fastener and caught with the two rows of slide fastener stitching placed at the edge of the slide fastener tape.





DIMENSIONS IN INCHES

FIGURE 2. LAST

3.5.6 Eyelet stay reinforcements. The eyelet stay reinforcements shall be located in accordance with the patterns and stitched to the quarters with two rows of stitching located on the binding, 1/16 inch apart, with nine stitches (plus or minus one stitch) per inch.

3.5.7 Eyelet stays. The eyelet stays shall be centered on the eyelet stay reinforcements in accordance with the patterns and stitched to the quarters through the eyelet stay reinforcements on the convex curve of the stays. The stitching, located on the binding of the eyelet stays, shall consist of two rows, 1/16 inch apart, with nine stitches (plus or minus one stitch) per inch. The stitching shall stop just behind the top and bottom eyelets and shall be securely bartacked.

3.5.8 Eyeletting. Five eyelets, as described in 3.3.5, shall be smoothly and firmly clinched on each eyelet stay. One eyelet shall be centrally located on the stay, and the other four eyelets shall be placed 1 inch (plus or minus 1/8 inch) on centers, on each side of the centrally located eyelet. The centers of the eyelets shall be 5/8 inch (plus or minus 1/8 inch) from the free edge of the stay.

3.5.9 Binding. The exposed edges of the quarters, tongue, eyelet stay reinforcements, and eyelet stays shall be bound with bias binding. The binding shall be sewn with 10 stitches (plus or minus 1 stitch) per inch.

3.5.10 Stitches, seams, and stitching. The stitches, seams, and stitching shall conform to FED-STD-751. Unless otherwise specified, stitch type 301 shall be used.

3.6 Patterns. Manufacturer's working patterns for the size medium shall be identical in size and shape to the patterns referenced on Drawing 51F24415. Patterns for sizes small, large, and extra large shall be supplied by the contractor. Commercial grading practices shall be used to determine the size of the patterns. The height for all sizes shall be 20 inches (±1/4 inch).

* 3.7 Color. The color of the cotton duck upper unit shall be sage green, USAF color shade No. 1531 (see 6.3). The color of the rubber compounds shall be black.

3.7.1 The color of the thread, slide fastener tape and thong, laces, front and back stays, and binding shall match the color of the cotton duck upper unit.

3.8 Identification of product.

* 3.8.1 Identification label. The identification label shall be stamped on the inside quarter of each boot, within the boot, using a contrasting colored indelible ink. Use of a heat transfer label will be permitted. The letters shall be block type; the first line shall be not less than 3/8 inch high, the second line not less than 7/32 inch high, and the remaining lines not less than 3/16 inch high. The letters shall be centered approximately 1-1/2 inches from the top of the boot. The information on the label shall be in accordance with the applicable markings specified in MIL-STD-130 with the following specific information included:

Boot, Extreme Cold Weather, N-1B
Specification MIL-B-6362F
Size 1/

1/ Applicable information shall be included by the manufacturer.

3.9 Workmanship. The boot shall be constructed in a thoroughly workmanlike manner. The finished boot shall be clean and free from any defects that might affect appearance or functionability.

4. QUALITY ASSURANCE PROVISIONS

* 4.1 Responsibility for inspection. Unless otherwise specificed 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.

4.2 Preproduction sample inspection. When required, the preproduction sample submitted in accordance with 3.1 shall be inspected as specified in 4.3.3.1.1 and 4.3.3.1.2 and tested as specified in 4.3.4.1 to determine compliance with design, construction, workmanship, dimensional, and flexibility requirements.

4.3 Acceptance tests.

4.3.1 Inspection for acceptance. Unless otherwise specified herein, inspection shall be in accordance with the provisions of MIL-STD-105. In addition to sampling inspection as set forth in MIL-STD-105, process inspection shall be performed during manufacture of the boots to verify that the proper materials are being used, to determine compliance with all required operations and processes which cannot be determined in the completed end product, and to assure that good workmanship has been employed. Any deviation from requirements or poor workmanship found during process inspection may be cause for rejection of the end item or items. For all acceptable quality level (AQL) examinations, the lot size shall be expressed in the same terms as the sample unit.

4.3.2 Inspection and testing of components and materials. In addition to the quality assurance provisions of the subsidiary specifications and drawings, inspection and testing shall be performed on components and materials as specified in Table III, 4.3.2.2.1, 4.3.2.2.2, and 4.3.2.2.3. In Table III all requirements shall be applicable to the individual unit. In 4.3.2.2.1, 4.3.2.2.2, and 4.3.2.2.3, all requirements shall be applicable to the lot (batch) average.

4.3.2.1 Procedure for sampling and preparation of rubber compound test sample. A batch of rubber compound shall consist of the amount of rubber compound that is produced or compounded in 1 day. The composite test piece shall be a 6-inch square of compound 0.25 inch thick. The sample unit shall be two pieces of the compound vulcanized in the same manner as the end item.

TABLE III

INSTRUCTIONS FOR TESTING OF FABRICS, EYELETS, AND INK

Component And Lot Size Expressed In Terms Of	Characteristic	Requirement Paragraph	FED-STD-191 Test Method	No. of Determinations Per Sample Unit	Results reported As		Sample Unit	Insp. Level	AQL
					Numerically To Nearest	Pass Or Fail			
Cotton Fabrics (1 yd full width each type and weight)	Material Identification	3.3.2.1 thru 3.3.2.4	1200 1/	1	-	X	1/4 Yard	S-1	6.5
	Wt Oz/Sq Yd	3.3.2.1 thru 3.3.2.4	5041	5	0.1 oz	-	Full Width	S-1	6.5
Eyelets (100)	Finish	3.3.5	Standard Commercial 1/	1	-	X		S-1	6.5
	Material Identification	3.3.5	Standard Commercial 1/	1	-	X	1 Dozen	S-1	6.5
	Corrosion Preventive Treatment (Steel Eyelets Only)	3.3.5	Standard Commercial 1/	1	-	X		S-1	6.5
Ink (1 Gallon)	Indelibility	3.8.1	Standard Commercial 1/	1	-	X	1 Ounce	S-1	6.5
Cotton Duck	Flexibility - warp filling	3.3.3.1	5202	4	-	X	1 yard	S-1	6.5
Rubber Sole	Flexibility	3.3.1.1	Visual	1	-	X	1 sole	S-1	6.5

1/ A certificate of compliance is acceptable in lieu of testing.

4.3.2.2 Rubber compound tests. The rubber compound shall be tested as follows to determine compliance with the applicable requirements of Section 3.

4.3.2.2.1 Tackiness. The rubber compound shall be exposed to a temperature of 160° ±2°F for a minimum period of 4 hours in a forced air oven adjusted for complete circulation of the air. One determination shall be made on each sample unit.

4.3.2.2.2 Swelling. The rubber compound shall be tested in accordance with method 6211 of FED-STD-601 except that the specimen shall be immersed for a minimum period of 5 hours at 165° ±2°F in oil conforming to MIL-O-6082, grade 1100. Three determinations shall be made on each sample unit.

4.3.2.2.3 Abrasive index. The initial abrasive index of the sole and heel shall be tested in accordance with ASTM D-1630. The sole and heel shall be aged 16 hours in an air oven at 212° ±2°F and the abrasive index then determined in accordance with ASTM D-1630. Three determinations shall be made on each sample unit.

4.3.3 Inspection of end item.

4.3.3.1 Examination of end item. The defects found during examination shall be classified in accordance with 4.3.3.1.1 and 4.3.3.1.2. The AQL and inspection levels shall be as specified in 4.3.3.1.3.

4.3.3.1.1 Visual examination. The boot shall be examined for defects in pairing, design, size, color, finish, workmanship, construction, and marking (see Table IV). The sample unit shall be one completed fabricated boot, and the selection shall be by pairs. For pairing examination, the pair shall be examined together. Each defect found during the examination for pairing shall be scored as a single defect.

4.3.3.1.2 Dimensional examination. The boots shall be examined for defects in dimensions. Any dimension that is not within the established tolerance shall be classified as a defect. The sample unit shall be one boot.

4.3.3.1.3 AQL and inspection levels. The AQL, expressed in defects per one hundred units, and the inspection levels shall be as follows:

Examination	Inspection Level	AQL Major	AQL Total
4.3.3.1.1	II	2.5	6.5
4.3.3.1.2	S-3	---	6.5

4.3.4 Testing of end item. The finished boot shall be tested as specified in 4.3.4.1 to determine compliance with 3.3.1.1. The sample unit shall be one boot, drawn in pairs (except for an odd number). The inspection level shall be S-1 and the AQL shall be 6.5 defects per one hundred units. The requirements are applicable to the individual unit. The lot size shall be expressed in terms of one boot.

* 4.3.4.1 Flexibility. The rubber (sole area) of the finished boot shall be exposed to a temperature of -65° ±2°F for 1 hour and then flexed once by bending back and forth through an angle of 45°.

4.3.5 Examination of preparation for delivery requirements. An examination shall be made to determine that packaging, packing and marking comply with the requirements of Section 5. Defects shall be scored in accordance with Table V. The sample unit shall be one shipping container fully prepared for delivery. The lot size shall be the number of containers in the inspection lot. The inspection level shall be S-2 of MIL-STD-105, and the AQL shall be 2.5 defects per one hundred units.

4.4 Test methods.

4.4.1 Textiles. Unless otherwise sepcified herein, textiles shall be tested in accordance with the applicable test method specified in FED-STD-191.

TABLE IV

CLASSIFICATION OF DEFECTS

EXAMINE	DEFECT	MAJOR	MINOR
Pairing	Not properly mated, i.e., not right and left of same size	X	
	Height variation between boots more than 1/4 inch	X	
Cleanliness	Any spot or stain clearly noticeable		X
Color	Not specified color	X	
	Color not uniform		X
Material	Any component not fabricated of the specified material	X	
Design	Design not as specified	X	
Construction and Workmanship - General (applciable to all components and assemblies unless otherwise indicated herein)	Any component missing	X	
	Any cut, tear, hole, rip, mend, weak place, or other deficiencies seriously affecting serviceability	X	
	Defective or damaged component affecting serviceability but not seriously, e.g., malformed lace eyelet		X
	Any removable felt insole missing or wrong size		X
	Any component misplaced seriously affecting serviceability, e.g., tongue misplaced or creased to an extent where it will cause discomfort to user	X	

TABLE IV (Cont'd)

CLASSIFICATION OF DEFECTS

EXAMINE	DEFECT	MAJOR	MINOR
	Any component misplaced affecting serviceability but not seriously		X
	Any operation omitted	X	
	Any operation not properly performed seriously affecting serviceability	X	
	Any operation not properly performed affecting serviceability but not seriously, e.g., eyelet reversed on assembly		X
	Any part malformed seriously affecting serviceability, e.g., vamp malformed which may result in discomfort to user	X	
	Any part malformed affecting serviceability but not seriously, e.g., malformation in sole to a degree where it may result in only slight loss of traction		X
	Any mend in fabric, i.e., patch, etc, (not applicable to restitched seam repair)	X	
	Needle chews likely to develop into a hole	X	
	Poor or uneven lasting affecting serviceability	X	
	Poor or uneven lasting affecting appearance only		X
	Noticeable separation of insole parts	X	
	Top tunnel missing	X	
	Top tunnel less than 3/4 inch wide		X
	Tunnel lace missing		X
	Quarter, tongue, eyelet stay, or eyelet stay reinforcement binding missing	X	
	Backseam reinforcing tape missing	X	

TABLE IV (Cont'd)

CLASSIFICATION OF DEFECTS

EXAMINE	DEFECT	MAJOR	MINOR
Seams and Stitching	Any open seam NOTE: When one or more stitches are broken or when two or more continuous skipped stitches or runoffs occur in a single-stitched seam or on both rows of stitching in a double-stitched seam, it shall be classified as a major defect. When one or more stitches are broken or when two or more continuous skipped stitches or runoffs occur in only one row of stitching in a double-stitched seam, it shall be classified as a minor defect.		
	Not specified seam or stitch type	X	
	Any row of stitching missing	X	
	Raw edge showing which should be concealed		X
	One or two stitches per inch less than specified		X
	Three or more stitches per inch less than specified	X	
	Loose stitch tension resulting in a loosely secured seam	X	
	Tight stitch tension resulting in puckering of fabric or assembly	X	
	Thread ends not trimmed throughout upper		X
	Any part caught in an unrelated row of stitching	X	
	More than the specified number of stitches per inch damaging assembly	X	
	More than the specified number of stitches per inch but not damaging assembly		X

TABLE IV (Cont'd)

CLASSIFICATION OF DEFECTS

EXAMINE	DEFECT	MAJOR	MINOR
	Ends of stitching not backstitched or bartacked as specified		X
	Gage of stitching irregular or not as specified seriously affecting serviceability	X	
	Gage of stitching irregular affecting serviceability but not seriously		X
Rubber Components	Not securely bonded or vulcanized where required	X	
	Not a natural heat cured finish		X
	Burned gum	X	
	Porous or imbedded foreign matter	X	
	Poor or incomplete vulcanization	X	
Eyelets	Any eyelet not securely clinched to a degree that it can be turned by hand on assembly but is not expected to become detached in use		X
	Any eyelet not securely clinched to a degree that it may become detached in use	X	
	Eyelets not in proper alignment interfering with proper lacing	X	
Slide Fastener	Damaged, broken, or malformed	X	
	Not specified type		X
	Does not function as intended	X	
	Thong missing		X
Marking	Missing, incomplete, incorrect, not applied in the specified manner, misplaced, illegible, or size or color not as specified		X

TABLE V

EXAMINATION OF PREPARATION FOR DELIVERY

EXAMINE	DEFECT
Markings (exterior and interior)	Incorrect, illegible, omitted; of improper size, location, sequence or method of application
Materials	Any nonconforming component; component missing, damaged, or otherwise defective affecting serviceability
Workmanship	Inadequate application of component such as incomplete closure of case liners, container flaps, loose strapping, etc, or bulging or distortion of containers
Content	Number per container is more or less than required

5. PACKAGING

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

5.1.1 Level A. The top of each boot shall be rolled or folded down and nested snugly against the bottom. Each pair of properly mated boots shall then be securely tied together by the laces, with the bottom facing out and the toe of one boot against the heel of the other boot.

5.1.2 Level C. The boots shall be packaged in accordance with the industry's practice.

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

5.2.1 Level A. Twelve pairs of boots, of one size only, packaged as specified in 5.1, shall be laid on their sides and arranged two in length, three in width, and two in depth and packed within a fiberboard shipping container. A sheet of kraft paper having a minimum basis weight of 30 pounds and conforming to UU-P-268 shall be placed between the bottom and top layer. The shipping container shall conform to type CF or SF, weather-resistant, grade V3, style FOL-L of PPP-B-636. The inside of each fiberboard shipping container shall be fitted with a one-piece, double-faced corrugated liner having a minimum bursting strength of 275 pounds per square inch (psi) and conforming to domestic class of PPP-B-636. The ends of the liner shall abut at an opposite corner from the manufacturer's joint. The approximate inside dimensions of the shipping container (inside the double-faced corrugated liner) shall be 28 inches long by 21 inches wide by 10-1/2 inches deep. Any voids occurring within the shipping container shall be filled with fiberboard pads or other suitable dry cushioning material to prevent shifting of the contents. Each shipping container shall be closed, waterproofed by means of tape, and reinforced with flat steel strapping or tape bonding in accordance with the appendix of the container specification. Towards the end of the contract, or when there are less than the required amount per container of the same size, mixed sizes may be packed within the same shipping container.

5.2.2 Level B. Twelve pairs of boots of one size only, packaged as specified in 5.1, shall be laid on their sides and arranged two in length, three in width, and two in depth within a fiberboard shipping container conforming to type CF or SF, class domestic, variety SW, style FOL-L of PPP-B-636 with metal-stitched manufacturer's joint. The minimum bursting strength of the fiberboard shall be 275 psi. The inside of each fiberboard shipping container shall be fitted with a one-piece, double-faced corrugated liner having a minimum bursting strength of 275 psi and conforming to class domestic of PPP-B-636. The ends of the liner shall abut at the opposite corner from the manufacturer's joint. The approximate inside dimensions of the shipping container (inside the double-faced corrugated liner) shall be 28 inches long by 21 inches wide by 10-1/2 inches deep. A sheet of kraft paper having a minimum basis weight of 30 pounds and conforming to UU-P-268 shall be placed between the bottom and top layer of boots. Any voids occurring within the shipping container shall be filled with fiberboard pads or other suitable dry cushioning material to prevent shifting of the contents. Each shipping container shall be closed in accordance with the appendix of the container specification. Towards the end of the contract, or when there are less than the required amount per container of the same size, mixed sizes may be packed within the same shipping container.

5.2.3 Level C. Boots of one size, packaged as specified in 5.1, shall be packed in a manner to insure carrier acceptance and safe delivery at destination at the lowest transportation rate for such supplies. Containers shall be in accordance with rules or regulations of carriers applicable to the mode of transportation.

5.3 Marking. In addition to any special marking required by the contract or order, shipping containers shall be marked in accordance with MIL-STD-129.

5.3.1 Labels, mixed sizes. Each shipping container packed with mixed sizes shall have securely attached to the end and side, directly under the printing or stenciling, a 5- by 4-inch white paper label with the words MIXED SIZES plainly printed or stamped thereon; under these words shall be legibly printed or stamped the correct quantity of pairs and sizes contained therein.

6. NOTES

6.1 Intended use. The Type N-1B boots covered by this specification are intended for use by flying and ground personnel operating under dry cold conditions in temperatures below 15°F. The boots are sized for wear over the following combination of socks:

Ski socks - 2 pairs
Felt socks - 1 pair

6.2 Ordering data. Procurement documents should specify the following:

a. Title number, and date of this specification.

b. Size required (see 1.2).

c. When preproduction testing is required (see 4.2).

d. Selection of applicable levels of packaging and packing (see 5.1 and 5.2).

6.3 USAF color shades. A sample of USAF color shades may be obtained from the procuring activity or as directed by the contracting officer.

6.4 Identification of changes. 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 contractors 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.

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Air Force - 99

Review Activity:
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Preparing Activity:
Air Force - 99

Project No. 8430-F171

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

OMB Approval
No. 22-R255

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CONTRACT NUMBER

MATERIAL PROCURED UNDER A

[ ] DIRECT GOVERNMENT CONTRACT [ ] SUBCONTRACT

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A. GIVE PARAGRAPH NUMBER AND WORDING.

B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES

2. COMMENTS ON ANY DOCUMENT REQUIREMENT CONSIDERED TOO RIGID

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[ ] YES [ ] NO *(If "Yes", in what way?)*

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