

MIL-C-18186D(MC)

12 September 1984

SUPERSEDING

MIL-C-18186C(MC)

15 March 1971

MILITARY SPECIFICATION

CROWNS, SERVICE CAP

This specification is approved for use by U. S. Marine Corps, Department of the Navy, and is available for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification covers requirements for removable service cap crowns.

1.2 Classification. The service cap crowns shall be of the following types and sizes as specified (see 6.2):

Type I - Polyester/rayon Gabardine; White

Type II - Wool Serge; Green

Schedule of sizes

6-3/8	6-7/8	7-1/4	7-5/8
6-1/2	7	7-3/8	7-3/4
6-5/8	7-1/8	7-1/2	
6-3/4			

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications, standards, and handbooks. Unless otherwise specified, the following specifications, standards, and handbooks of the issue listed in that issue of the Department of Defense Index of Specifications and Standards (DODISS) specified in the solicitation form a part of this specification to the extent specified herein.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to the Commandant of the Marine Corps, Headquarters, U. S. Marine Corps (LMA-1), Washington, DC 20380, by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

MIL-C-18186D(MC)

SPECIFICATIONS

FEDERAL

- V-T-285 - Thread, Polyester.
- V-T-301 - Thread, Silk.
- DDD-L-20 - Label; For Clothing, Equipage And Tentage (General Use).
- PPP-B-636 - Box, Shipping, Fiberboard.
- PPP-B-676 - Box, Set-up.
- PPP-T-45 - Tape, Gummed Paper, Reinforced And Plain, For Sealing and Securing.

MILITARY

- MIL-C-368 - Cloth, Satin, Rayon And Cloth, Twill, Rayon.
- MIL-C-823 - Cloth, Serge, Wool; Wool And Nylon, Polyester And Wool.
- MIL-C-20268 - Frame, Cap, Man's.
- MIL-C-41820 - Cloth, Gabardine, Polyester And Rayon.

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.
- MIL-STD-147 - Palletized Unit Loads.
- MIL-STD-1394 - Provisions for Evaluating Quality of Cap Crowns.

(Copies of specifications, standards, handbooks, drawings, and publications required by manufacturers in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting officer.)

2.1.2 Other Government documents, drawings, and publications. The following other Government documents, drawings, and publications form a part of this specification to the extent specified herein.

LAWS AND REGULATIONS

U. S. POSTAL SERVICE MANUAL

(Application for copies should be addressed to the Superintendent of Documents, U. S. Government Printing Office, Washington, DC 20402.)

MIL-C-18186D(MC)

2.2 Other publications. The following document(s) form a part of this specification to the extent specified herein. The issues of the documents which are indicated as DoD adopted shall be the issue listed in the current DoDISS and the supplement thereto, if applicable.

UNIFORM CLASSIFICATION COMMITTEE, AGENT

Uniform Freight Classification Rules

(Application for copies should be addressed to the Uniform Classification Committee, Room 1106, 222 South Riverside Plaza; Chicago, Illinois 60606.)

NATIONAL MOTOR FREIGHT TRAFFIC ASSOCIATION, INC., AGENT

National Motor Freight Classification

(Application for copies should be addressed to the American Trucking Association, Inc., Tariff Order Section, 1616 P Street, N. W., Washington, DC 20026.)

2.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein, the text of this specification shall take precedence.

3. REQUIREMENTS

3.1 Standard samples. The standard sample is furnished solely for guidance and information to the supplier (see 6.3). Variation from this specification may appear in the sample, in which case the specification shall govern.

3.2 First article. Unless otherwise specified (see 6.2), before production is commenced, a finished crown shall be submitted, or made ready for the contracting officer or his authorized representative for inspection. The approval of the first article authorizes the commencement of production but does not relieve the supplier of responsibility for compliance with all provisions of this specification. The first article shall be manufactured by the supplier in the same facilities to be used for the manufacture of the production item.

3.3 Materials

3.3.1 Basic material. The basic material for each type crown shall conform to the following:

(a) Type I. Cloth, gabardine, polyester/rayon, 8 ounce, white shade 2400 conforming to type III class 1 of MIL-C-41820.

(b) Type II. Cloth, wool, serge, 15-ounce, green shade 2234 conforming to type I, class 5 of MIL-C-823.

3.3.2 Lining for crown (type II). The material for lining the type II crown shall be cloth, rayon, twill, 3.7-ounce, conforming to class 1 of MIL-C-368. The color of the lining shall be green shade 2208.

MIL-C-18186D(MC)

3.3.3 Thread. Thread for seaming, stitching, overedging and for making buttonholes shall be as follows for each type crown:

Operations	Thread	
	Polyester	Silk
Seaming, stitching	<u>Type I (inside and outside);</u> <u>Type II (inside)</u> left twist, ticket No. A, 3-ply (needle and bobbin)	<u>Type II (outside)</u> left twist, size A, 3-ply (needle and bobbin)
Overedge stitching	<u>Types I and II</u> left twist, soft finish ticket No. 70, 2-ply (needle and bobbin)	
Buttonholes	<u>Type I</u> left twist, ticket No. A, 3-ply (needle and bobbin)	<u>Type II</u> left twist, size A, 3-ply (needle and looper)

3.3.3.1 Polyester thread. The polyester thread shall be size A, 3-ply conforming to type I, class 1 of V-T-285 and to the requirements specified above.

3.3.3.2 Cotton thread. The cotton thread for basting and overedging shall be a good commercial grade.

3.3.3.3 Silk thread. The silk thread shall conform to type I of V-T-301, and to the requirements specified above.

3.3.3.4 Color and colorfastness. The color of the thread for type I crowns shall be white shade (bleached) Cable No. 66050 and for type II crowns, olive drab shade T-1, Cable No. 66023. The colored threads, when tested in accordance with the applicable thread specification, shall show good fastness to wet (dry) cleaning, and in addition, the silk thread shall show good fastness to light.

3.3.4 Eyelets and washers. The eyelets and washers shall be brass (0.008 + 0.001 inch thick), and shall conform to the style and dimensions shown on Figure 1. The entire eyelet or the flange only of the eyelet shall be enameled to closely match the shade of the basic material. The barrel of the eyelets shall be scored with 6 to 8 scores.

3.3.5 Label. Each crown shall be provided with a combined identification and size label conforming to type VI, class 4 of DDD-L-20, except the content shall include the name of supplier ^{1/} and in addition, the Wool Products Act

^{1/} Size of characters for name of supplier shall be minimum 6 point (approximately 1/16 inch).

MIL-C-18186D(MC)

information shall be included in label for type II crown. The label shall measure not less than 1-3/4 inches by 1-1/4 inches with a minimum 1/4-inch margin at the top for sewing. Type I crown is intended to be laundered; type II crown is intended to be dry cleaned. Label shall show fastness to laundering and dry cleaning.

3.4 Design. The crown shall be the Marine Corps design shown on Figure 2 having a one-piece crown, two front and two back quarters, a two-ply one-piece headband, one buttonhole at each side of headband for attaching crown to cap frame, two metal eyelets in each side and one in front, raw edges overedge stitched, and the crown of type II fully lined with rayon cloth. The crowns are designed to properly fit the cap frame and crown support with which they are intended to be used (see 6.1).

3.5 Patterns. Standard patterns shall be furnished to the supplier by the Government. The standard patterns provide a 1/4-inch allowance for all seams except as otherwise specified in Table I. Standard patterns show size, seam allowance, direction lines for cutting, and are marked or notched for proper cutting, placement and assembly of the component parts.

3.5.1 List of pattern parts. The crowns shall be cut from the materials specified herein in accordance with pattern parts indicated below:

<u>Item</u>	<u>Pattern nomenclature</u>	<u>No. of cut parts</u>
	<u>Material: Basic material</u>	
1.	Quarters, front	2
2.	Quarters, back	2
3.	Crown	1
4.	Headband	1
	<u>Material: Cloth, rayon, twill</u>	
5.	Lining, crown (type II)	1

3.6 Construction. The crowns shall be manufactured in strict accordance with the operations and the stitch, seam, and stitching types specified in Table I. The supplier is not required to follow the exact sequence of the operations as listed in Table I, but all operations specified shall be used to manufacture the crowns.

3.6.1 Stitches, seams, and stitching. The stitch, seam, and stitching types specified in Table I shall conform to FED-STD-751. Whenever two or more stitch or seam types are specified for the same operation, any one of them may be used. Where stitch type 401 is used, the looper (underthread) shall be on the inside of the crown. The number of stitches per inch as specified in Table I indicates the minimum and maximum number permitted. Overedge or serge stitching shall be done on serging machines with knife attachment properly set to trim the raveled edge without cutting material.

MIL-C-18186D(MC)

3.6.1.1 Tacking and backstitching. Ends of seams and stitching produced with 301 type stitch when not caught in other seams or stitching shall be backtacked not less than 1/4 inch. Thread breaks (all stitch types) shall be secured by stitching back of break not less than 1/2 inch. When stitch type 401 is used, ends of seams and stitching shall be caught in other seams or stitching, and skipped stitches and thread breaks may be repaired using stitch type 301 back-stitched not less than 1/2 inch on each side of the skip or break.

3.6.2 Shade marking. The component parts of the crown shall be marked to insure a uniform shade and size throughout the crown. Any method of shade marking may be used except:

- (a) Corrosive metal fastening devices.
- (b) Adhesive type tickets which show discoloration and the adhesive mass which adheres to the material upon removal of the tickets.
- (c) Any marking medium which would tend to leave a permanent mark.

TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
1.	<u>Cutting.</u> a. Cut crowns in strict accordance with patterns furnished by the Government. b. Cut materials in the direction indicated by directional lines on the patterns. c. Cut the component parts of each type crown from one piece of the applicable basic material. d. Cut crown lining for type II crowns from one piece of rayon twill material.					
2.	<u>Replacement of damaged parts.</u> a. Replace, at time of cutting, any part containing damages such as holes or seriously weakening defects such as smashes, multiple floats, and slubs likely to develop into holes.					

MIL-C-18186D(MC)
TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
2.	<u>Replacement of damaged parts.</u> (con't)					
	b. Replace any part damaged during the manufacturing process by needle chews which may be expected to develop into a hole, scissor or knife cuts, tears, holes, mends, burns and large exposed drill holes.					
3.	<u>Shade markings.</u>					
	a. Mark or ticket all component parts of crowns to insure proper assembly and a uniform shade and size throughout the crown.					
	b. The use of tickets with metal fastening devices and the sew-on tickets are prohibited on the rayon lining.					
	c. Adhesive type shade tickets, when used, shall be adhered to the inside of the crowns.					
4.	<u>Make headband.</u>					
	Finished appearance. The band shall finish smooth and flat and center back seam shall spread open without twists, pleats, puckers or other distortion. The band shall be uniform in shape. Edgestitching shall be uniform in width.					
	a. The headband shall be made of one ply of basic material.					
	b. Fold headband in half end to end and join the two ends with a 1/4-inch seam. Spread the seam open and press smooth and flat with a heated pressing iron.	301	SSa-1	12-16	A	A
	c. Fold headband in half lengthwise with the seam on the inside and stitch 3/16 to 1/4 inch from folded lower edge.	301	OSf-1	12-16	A (Type I) A (silk) (Type II)	A I) A II)

MIL-C-18186D(MC)
TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
5.	<u>Join quarters.</u> Finished appearance. The quarters shall be joined without twists, puckers, pleats or other distortion. All topstitching shall be uniform. a. Each quarter shall consist of one ply of basic material. b. Serge the raw side and top edges of all quarters. c. Seam quarters together at the sides 1/4 inch from edges. d. Spread open seams and topstitch each quarter 1/16 to 3/32 inch from joining seam for quarters.					
		504 or 505	EFd-1 EFd-1	6-8 6-8	70/2 70/2	70/2 70/2
		301	SSz-3 (a)	12-16	A	A
		301	SSz-3 (b)	12-16	A (Type I) A (silk) (Type II)	A A
6.	<u>Join lining to crown (type II crowns only)</u> Finished appearance. The lining shall be joined to crown without pleats, puckers or other distortions. The stitches shall not be visible on the outside of the finished crown. a. Seam rayon lining to crown 1/8 to 3/16 inch from edge. b. Overedge stitch together the raw edges of crown and lining.					
		301 or 401	SSa-1 SSa-1	6-8 6-8	A A	A A 2
		504 or 505	EFd-1 EFd-1	6-8 6-8	70/2 70/2	70/2 70/
7.	<u>Overedge stitch crown (type I only)</u> a. Overedge stitch the raw edges of the crown.					
		504 or 505	EFd-1 EFd-1	6-8 6-8	70/2 70/2	70/2 70/2

MIL-C-18186D(MC)
TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
8.	<u>Join quarters to crown.</u> Finished appearance. Quarters shall be joined to crown without twists, puckers, pleats or other distortion. The topstitching shall be uniform.					
	a. Position quarters on outside of crown with edges even and notches matching and join with a 1/4-inch seam.	301	SSz-3 (a)	12-16	A	A
	b. Press seam open with heated pressing iron.					
	c. Topstitch crown and quarters 1/16 to 3/32 inch from seam joining quarters to crown.	301	SSz-3 (b)	12-16	A (Type I) A (silk) (Type II)	A A A A
9.	<u>Join headband to quarters.</u> Finished appearance. Headband shall be joined to quarters without twists, puckers, pleats or other distortion. The joining seam of headband shall be in line with back seam of quarters.					
	a. Position headband on outside of quarters with raw edges even, with notches matching and with joining seam of headband matching back seam of quarters. Position combination identification size label 1-1/4 + 1/4 inch to right or left of center backseam with the top edge of label lapped approximately 3/16 inch on underside of headband.					
	b. Join headband to quarters, with label, by seaming and overedging the raw edges in one operation. The bight of the overedge stitching shall be 1/4 inch.	515 or 516 or 519	SSa-2	10-14	A	A

MIL-C-18186D(MC)
TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
10.	<p><u>Topstitch quarters-headband seam.</u></p> <p>Finished appearance. The raised edge of quarters shall be uniformly topstitched without twists, puckers, pleats or other distortions.</p> <p>a. Turn back the quarters at the headband - quarters joining seam and topstitch the quarters 1/16 to 3/32 inch from the raised edge. The stitching shall be through the headband-quarters - label joining seam allowance.</p>	301	LSg-2 (shows finished seam)	12-16	A (Type I) A (silk) (Type II)	A (Type I) A (Type II)
11.	<p><u>Make buttonholes.</u></p> <p>Finished appearance. The buttonholes shall be clean cut, well made and correctly positioned. The stitching shall be securely caught in the fabric. Buttonholes shall finish parallel to and 3/8 + 1/16 inch from lower edge of headband with the purling on the outside. Center of buttonholes shall be 5-3/4 + 1/8 inches from center front of crown.</p> <p>a. Mark the right and left side, respectively, of the headband 5-3/4 inches from center front of crown for the location of one buttonhole.</p> <p>b. Make a horizontal, straight type buttonhole, cut 3/4 to 1 inch long, at each of the marks, securely tacking ends of buttonhole.</p>	But- ton hole		48 per button- hole includ- ing tack	A (Type I) A (silk) (Type II)	A (Type I) A (Type II)
12.	<p><u>Attach eyelets.</u></p> <p>Finished appearance. The eyelets shall be attached from the outside and securely clinched on the inside without distortion of, or damage to, the crown or without splitting the flange of the eyelet. The front eyelet shall be centered on the front seam; the side eyelets shall</p>					

MIL-C-18186D(MC)
TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
12.	<p><u>Attach eyelets.</u> (con't)</p> <p>be properly positioned from side seam and top and bottom edges of quarters.</p> <p>a. Mark the crowns for the location of five metal eyelets.</p> <p>b. Punch a hole at the mark for the front eyelet through the center of front seam.</p> <p>c. Attach front eyelet and securely clinch over a brass washer placed on the inside of the crown.</p> <p>d. Attach two eyelets to each side of crown at the marks.</p> <p>e. In the finished crown, the center of each side eyelet shall be 1 +1/8 inch from its corresponding side seam. The center of all eyelets shall be midway between the upper and lower edges of quarters. Side eyelets shall be in horizontal alignment.</p>					
13.	<p><u>Clean crowns.</u></p> <p>a. Trim all ends of stitching and remove all loose threads from the crown.</p> <p>b. Remove all spots, stains, markings and shade tickets from the crown without injury to the material.</p>					

MIL-C-18186D(MC)

3.7 Finished measurements. The finished crown shall conform to the measurements as follows:

Finished measurements	
<u>Component</u>	<u>Dimensions</u> <u>Inches</u>
Height of headband <u>1/</u>	1-5/8 minimum; 1-3/4 maximum
Height of quarters <u>2/</u>	
- at front	2-1/8 <u>+1/8</u>
- at sides	2 <u>+1/8</u>
- at back	1-7/8 <u>+1/8</u>

3.8 Fit. Each size crown shall properly fit the corresponding size cap frame and crown support for which it is intended (see 6.1). Crowns shall fit snugly without distorting either the headband of the frame or the crown wire of the support. Quarters shall have a smooth, rounded appearance without twisting, wrinkles or other distortions. The crown shall lie smooth and flat without twisting, wrinkles or other distortions. The headband of the crown shall extend down to the welt on headband of frame without stretching or wrinkling. Buttonholes shall properly engage with posts on frame without twists, wrinkles or other distortions. Front eyelet of crown shall center on stay of crown support.

3.9 Workmanship. The finished crown shall conform to the quality and grade of product established by this specification. The occurrence of defects shall not exceed levels set by the applicable quality levels (AQL's).

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. 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 the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

- 1/ Measurement for height of headband shall be taken from lower finished edge of headband to lower raised edge of quarters.
- 2/ Measurement for height of quarters shall be taken at front, side and back seams, respectively, from lower raised edge of quarters to crown seam.

MIL-C-18186D(MC)

4.1.1 Certificate of compliance. Where certificates of compliance are submitted, the Government reserves the right to check such items to determine the validity of the certification.

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

1. First article inspection (see 4.4).
2. Quality conformance inspection (see 4.5)

4.3 Inspection conditions. Inspection shall be in accordance with provisions set forth in MIL-STD-105, except where otherwise indicated in MIL-STD-1394.

4.4 First article inspection. When first article is required, inspection shall be made of a completely fabricated crown for conformance to all provisions of this specification.

4.5 Quality conformance inspection.

4.5.1 Component and material inspection. In accordance with 4.1 above, components and materials shall be tested in accordance with all requirements of referenced specifications, figures and standards unless otherwise excluded, amended, modified or qualified in this specification or applicable purchase document. In addition to testing provisions contained in subsidiary specifications, figures and standards, testing shall be performed on components listed in Table II for characteristics noted. All test reports shall contain the individual values utilized in expressing the final results.

4.5.2 Sampling for testing. Testing shall be in accordance with sampling provisions tables cited in MIL-STD-1394.

4.5.3 Examination of the end item. Examination of the end item shall be performed in accordance with the provisions of MIL-STD-1394.

4.5.4 Dimensional examination. The dimensional examination provisions for the finished crown shall be as listed in 3.7 and as specified in MIL-STD-1394.

4.5.5 Examination of packaging. The examination for compliance with packaging, packing and marking requirements shall be as specified in MIL-STD-1394.

TABLE II - TEST METHODS

Components	Characteristic	Reqt. para.	Test method	No. Determinations per sample unit	Results reported as:
Eyelets	Material identification	3.3.4	Std. Com'l	1	Pass or fail
	Color (Flange)	3.3.4	Visual	1	Pass or fail
	Scores	3.3.4	Visual	1	Pass or fail
Washer	Material identification	3.3.4	Std. Com'l	1	Pass or fail

MIL-C-18186D(MC)

MIL-C-18186D(MC)

5. PACKAGING

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

5.1.1 Level A.

5.1.1.1 Unit packaging. Each crown shall be placed in an individual polyethylene bag measuring 13 by 13 inches with 1-inch lip at the open end. The polyethylene flexible film shall be 0.0015 inch thick. Prior to or during final heat sealing operation, excess air within the bag shall be expelled. Each bag shall contain a label (see 5.3).

5.1.1.2 Intermediate packaging. Twenty (20) type I crowns, or 10 type II crowns, unit packaged as specified in 5.1.1.1, shall be placed in a set-up paper-board box conforming to type II, class A, style 4 of PPP-B-676. The outside dimensions of the set-up boxes (cover included) shall be 11-1/4 inches long 11-3/4 inches wide and 3-1/4 inches deep. The depth of the box cover shall be 1 inch. The cover shall be secured to the box with 2-inch minimum width gummed paper tape conforming to type III of PPP-T-45, applied around the girth of the box, at the center.

5.1.2 Commercial. The crowns shall be packaged in accordance with manufacturer's normal practice.

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

5.2.1 Level A. Ten (10) intermediate packages specified in 5.1.1.2 shall be packed on end, two in length and five in width, within a close-fitting, fiberboard box conforming to style RSC, grade V3c or V3s, class weather resistant of PPP-B-636; closure shall be in accordance with the appendix thereto. 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 container.

5.2.2 Level B. Ten (10) intermediate packages specified in 5.1.1.2 shall be packed on end, two in length and five in width, within a close-fitting, fiberboard box conforming to style RSC, type CF or SF, class domestic, grade 275 of PPP-B-636; closure shall be in accordance with the appendix thereto. 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 container.

5.2.3 Commercial. Crowns, packaged as specified in 5.1, shall be packed in a manner to insure carrier acceptance and safe delivery at destination. Containers shall be in accordance with Uniform Freight Classification Rules, National Motor Freight Classification and U. S. Postal Service Manual, or as applicable.

MIL-C-18186D(MC)

5.3 Marking. In addition to any special marking required by the contract or order, the intermediate packages and shipping container shall be marked in accordance with the requirements of MIL-STD-129. A white paper label with the following information legibly printed or stamped thereon in black shall be inserted within each polyethylene bag in order to permit ready identification:

Nomenclature
 Size _____ Stock number _____
 Contract number _____
 Contractor _____

5.3.1 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 white paper label 5 by 4 inches with the words "MIXED SIZES" plainly stamped or printed thereon and under these words shall be legibly printed the correct quantity and sizes contained therein.

5.4 Palletization. When specified (see 6.2), crowns packed as specified in 5.2 shall be palletized in accordance with load type I of MIL-STD-147. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding means K and L. Pallet patterns shall be in accordance with the appendix of MIL-STD-147. Interlocking of loads shall be effected by reversing the pattern of each course. If the container is of a size which does not conform to any of the pallet patterns specified in MIL-STD-147, the pallet pattern used shall first be approved by the contracting officer.

6. NOTES

6.1 Intended use. This specification covers white polyester/rayon gabardine and green wool serge service cap crowns intended for use with the service cap frame and crown support conforming to MIL-F-20268.

6.2 Ordering data.

6.2.1 Acquisition requirements. Acquisition documents should specify the following:

- (a) Title, number and date of this specification.
- (b) Type and size required (see 1.2).
- (c) Whether first article is required (see 3.2).
- (d) Level of packaging and packing required (see 5.1 and 5.2).
- (e) When palletization is required (see 5.4).

6.2.2 Data requirements. When this specification is used in an acquisition which incorporates a DD Form 1423, Contract Data Requirements List (CDRL), the data requirements identified below shall be developed as specified by an approved Data Item Description (DD Form 1664) and delivered in accordance with the approved CDRL incorporated into the contract. When the provisions of DAR 7-104.9 (n) (2) are invoked and the DD Form 1423 is not used, the data specified below shall be delivered by the contractor in accordance with the contract or purchase order requirements. Deliverable data required by this specification is cited in the following paragraphs.

MIL-C-18186D(MC)

Paragraph no.	Data requirements	Applicable DID no.	Options
(a) 4.	Inspection System Program Plan	DI-R-4803	- -
(b) 4.4	First Article Inspection Procedure	DI-T-4901	- -
(c) 4.4	First Article Inspection Report	DI-T-4902	- -
(d) 4.5	Production/Acceptance Inspection Procedures	DI-T-4903	- -
(e) 4.5	Production Inspection Reports	DI-T-4904	- -

(Data item descriptions related to this specification, and identified in section 6 will be approved and listed as such in DoD 5000.19L., Vol. II, AMSDL. Copies of data item descriptions required by contractors in connection with specific acquisition functions should be obtained from the Naval Publications and Forms Center or as directed by the contracting officer.)

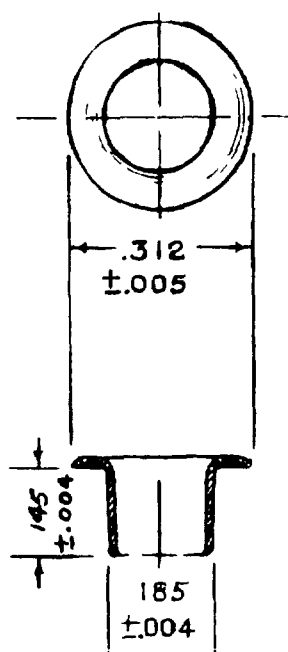
6.3 Standard samples. The standard sample may be obtained from the procuring activity or as directed by the contracting officer.

6.4 First article. Examination, test, and approval shall be as specified by the contracting officer (see 3.2).

6.5 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.

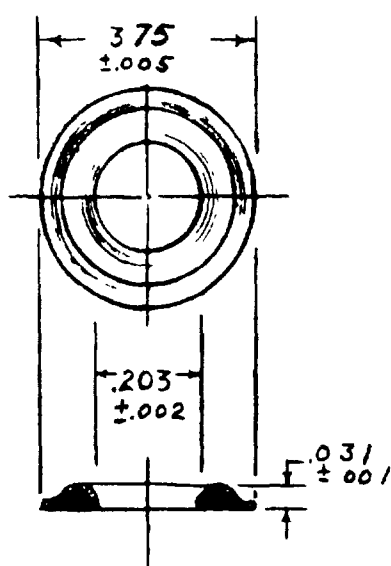
Preparing activity:
Navy - MC
Project Number 8405-N949

ML-C-18186D(MC)



EYELET

SCORED BARREL
6 TO 8 SCORES



WASHER

FIGURE 1. CROWNS, SERVICE CAP

MIL-C-18186D(MC)

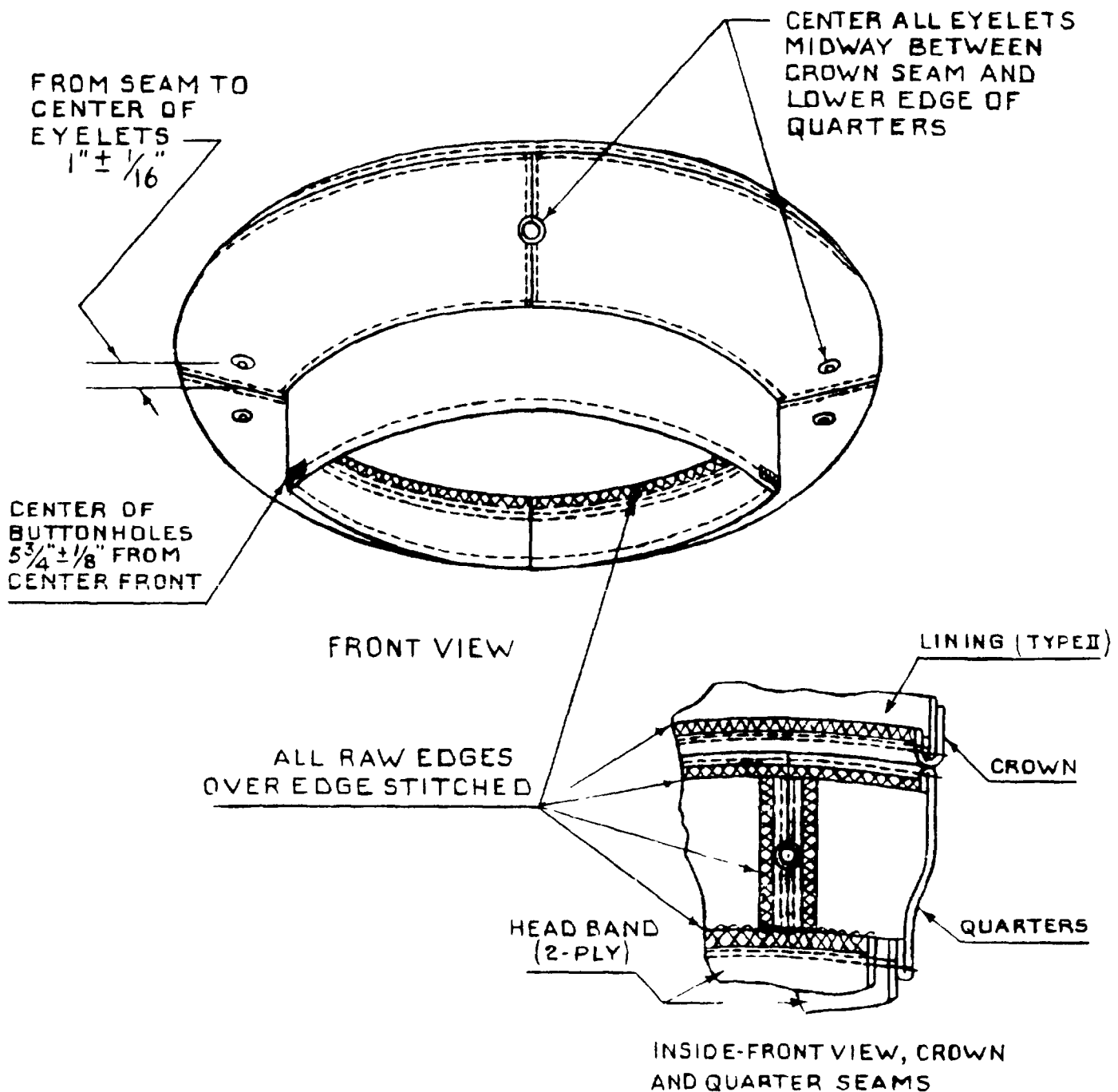


FIGURE 2. CROWNS: SERVICE CAP

INSTRUCTIONS: In a continuing effort to make our standardization documents better, the DoD provides this form for use in submitting comments and suggestions for improvements. All users of military standardization documents are invited to provide suggestions. This form may be detached, folded along the lines indicated, taped along the loose edge (*DO NOT STAPLE*), and mailed. In block 5, be as specific as possible about particular problem areas such as wording which required interpretation, was too rigid, restrictive, loose, ambiguous, or was incompatible, and give proposed wording changes which would alleviate the problems. Enter in block 6 any remarks not related to a specific paragraph of the document. If block 7 is filled out, an acknowledgement will be mailed to you within 30 days to let you know that your comments were received and are being considered.

NOTE This form may not be used to request copies of documents, nor to request waivers, deviations, or clarification of specification requirements on current contracts. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements.

(Fold along this line)

(Fold along this line)

DEPARTMENT OF THE NAVY



NO POSTAGE
NECESSARY
IF MAILED
IN THE
UNITED STATES

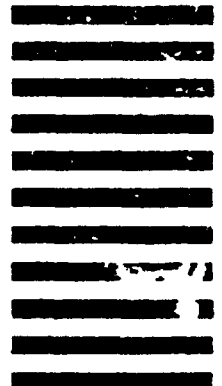
OFFICIAL BUSINESS
PENALTY FOR PRIVATE USE \$300

BUSINESS REPLY MAIL

FIRST CLASS PERMIT NO 12503 WASHINGTON D C

POSTAGE WILL BE PAID BY THE DEPARTMENT OF THE NAVY

Commandant of the Marine Corps
Headquarters, U.S. Marine Corps
(Code LMA-1)
Washington, D.C. 20380



STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

1 DOCUMENT NUMBER MIL-C-18186D(MC)		2 DOCUMENT TITLE CROWNS, SERVICE CAP	
3a NAME OF SUBMITTING ORGANIZATION		4 TYPE OF ORGANIZATION (Mark one) <input type="checkbox"/> VENDOR <input type="checkbox"/> USER <input type="checkbox"/> MANUFACTURER <input type="checkbox"/> OTHER (Specify) _____	
b ADDRESS (Street, City, State, ZIP Code)			
5 PROBLEM AREAS			
a Paragraph Number and Wording			
b Recommended Wording			
c Reason/Rationale for Recommendation			
6 REMARKS			
7a NAME OF SUBMITTER (Last, First, MI) - Optional		b WORK TELEPHONE NUMBER (Include Code) - Optional	
c MAILING ADDRESS (Street, City, State, ZIP Code) - Optional		8 DATE OF SUBMISSION (YYMMDD)	

(TO DETACH THIS FORM, CUT ALONG THIS LINE)