

INCH-POUND

MIL-C-19734C(MC)
9 OCTOBER 1990

SUPERSEDING
MIL-C-19734B(MC)
28 July 1978

MILITARY SPECIFICATION

CARRIER: SWORD SCABBARD

This specification is approved for use by the 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 a white leather sword carrier and a black leather sword carrier.

1.2 Classification. The sword carriers shall be of the following classes, as specified (see 6.2):

Class 1 - Carrier, Sword, Dress, white
Class 2 - Carrier, Sword, Service, black

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 Commanding General (PSE-C), Marine Corps Research, Development, and Acquisition Command, 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.
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AMSC N\A

FSC 8465

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

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SPECIFICATIONS

FEDERAL

- A-A-50197 - Thread, Linen
- KK-L-271 - Leather, Cattlehide, Strap, Vegetable Tanned
- UU-P-268 - Paper, Kraft, Wrapping
- UU-P-553 - Paper, Wrapping, Tissue
- DDD-L-20 - Label: For Clothing, Equipage, and Tentage (General Use)

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- MIL-B-17757 - Boxes, Shipping, Fiberboard (Modular Sizes)

STANDARDS

FEDERAL

- FED-STD-191 - Textile Test Methods
- FED-STD-311 - Leather, Methods of Sampling and Testing
- FED-STD-751 - Stitches, Seams and Stitching

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- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
- MIL-STD-129 - Marking for Shipment and Storage

(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from the Standardization Documents order desk, Bldg 4D, 700 Robins Avenue, Philadelphia, PA 19111-5094).

2.1.2 Other Government documents, drawings, and publications. The following other Government publication forms a part of this document to the extent specified herein. Unless otherwise specified, the issue is that cited in the solicitation.

LAWS AND REGULATIONS

U.S. Postal Service Manual

(Copies of the manual may be obtained from the Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402.)

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2.2 Non-Government publications. The following documents form a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DoD adopted are those listed in the issue of the DoDISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DoDISS are the issues of the documents cited in the solicitation (see 6.2).

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, D.C. 20026.)

Department of Defense (DOD) Standard Color Card of Official Standardized Shades for Sewing Threads 1968

(Copies may be obtained from the Color Association of the United States, Inc., 200 Madison Avenue, New York, New York 10016.)

2.3 Order of precedence. In the event of a conflict between the text of this document and the references cited herein (except for related associated detail specifications, specification sheets, or MS standards), the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

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

3.2 First article. When specified (see 6.2), a sample shall be subjected to first article inspection (see 6.4), in accordance with 4.4.

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3.3 Materials.

3.3.1 Basic material. The basic material for each class of carrier shall be as follows:

a. Class 1. The leather shall be 4.5 to 6 ounces in thickness conforming to types I, II, III or IV class 1 of KK-L-271 and shall be free from cuts, damaged grain, open scratches, grub holes, brands, wrinkles, or any other defects which may effect the appearance or serviceability of the finished carrier. The color of the leather shall be white, with a suitable synthetic retannage (melamine, vinyl, or equal), exhibiting properties like or equal to the approved sample. The leather shall be full grain or full grain lightly snuffed, and the flesh side shall be smooth and free from loose flesh. The finish of the leather shall not crack and shall conform to the following when tested as specified in table I.

	<u>Minimum</u>	<u>Maximum</u>
Shrinkage temperature (°C)	85	--

b. Class 2. The leather shall be 4.5 to 6 ounces in thickness conforming to types I, II, III or IV, class 1 of KK-L-271 and shall be free from cuts, damaged grain, open scratches, grub holes, brands, wrinkles, or any other defects which may effect the appearance or serviceability of the finished carrier. The flesh and grain sides of the leather shall match black shade 111. The finish of the grain side of the leather shall closely match the finish of the Marine Corps standard sample (see 6.3). The leather may be slightly skived or shaved to an even thickness but not split. The leather also shall be full grain, lightly snuffed, and the flesh side shall be smooth and free from loose flesh. The finish of leather shall not crack and shall conform to the following when tested as specified in table I.

	<u>Minimum</u>	<u>Maximum</u>
Shrinkage temperature (°C)	85	--

3.3.1.1 Colorfastness. The leather shall show good colorfastness to wet and dry crocking when tested as specified in table I. The white leather shall show no appreciable yellowing when tested as specified in table I.

3.3.2 Thread. Linen thread, constructed of 5 ply with an "S" twist, conforming to type II, class 2 of A-A-50197 shall be used.

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3.3.2.1 Color. The color of the thread shall be natural white shade AG, cable No. 66049, for class 1 carrier and black shade AA, cable No. 66043, for class 2 carrier. (See DOD Standard Color Card of Official Standardized Shades for Sewing Threads 1968).

3.4 Design and construction. The design and construction of the carrier shall conform to figure 1. All stitching shall be done with stitch type 301, seam type SSa-1 conforming to FED-STD-751, 7 stitches per inch, with the ends of the stitching properly and neatly secured. The carrier shall be made from one piece of leather folded in half lengthwise to form two plies of the same design, the front ply to have a slit for insertion of the sword scabbard. The two plies shall be stitched together with a single row of stitches at both sides and with ornamental stitching at the center, leaving an opening at the bottom end of the carrier for the sword scabbard and a loop opening at top for attaching the carrier to a belt as shown in figure 1. The edges of the carrier shall have a well defined crease 1/16 inch wide and neatly placed 1/8 inch from edges. The cut edges of the carriers shall be rounded and finished to closely match the shade for the leather of the applicable carrier. The creasing, edging and finishing of the carrier shall be neatly and accurately done.

3.5 Finished measurements. The finished carrier shall conform to the measurements shown in figure 1.

3.6 Workmanship. The finished carriers shall conform to the quality of product established by this specification.

3.7 Marking. Each carrier shall have an adhesive cloth label attached to the back, above the decorative stitching, containing the nomenclature, contractor name, contract number and NSN. Labels shall conform to type V class 5 of DDD-L-20.

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 the prescribed requirements.

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

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

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

- a. First article inspection (see 4.4)
- b. Quality conformance inspection (see 4.5)

4.3 Inspection conditions. Unless otherwise specified, all inspections shall be performed in accordance with the test conditions specified in MIL-STD-105, except where otherwise indicated herein.

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

4.5 Quality conformance inspection.

4.5.1 Testing of components. Testing of components shall be in accordance with applicable subsidiary specifications and standards to the extent applicable, except that this specification shall govern in the event of conflict. The method of testing specified in MIL-STD-105, FED-STD-191, and FED-STD-311, wherever applicable, and as listed in table I shall be followed. All requirements are applicable to sample units. When the data as to number of determinations per sample unit and the results reported are not as specified in table I, they shall be as required by the reference test method. The lot shall be unacceptable if one or more of the sample units or the lot average fails to meet any of the specified requirements. The unit for expressing lot sizes and sample unit for testing each

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component shall be in accordance with applicable subsidiary specification and as follows:

<u>Lot size</u>	<u>Sample Size (No. of sample units)</u>
800 or less	2
801 to 22,000	3
22,001 and over	5

4.5.2 Examination of the end item. The end item shall be examined for defects listed in 4.5.2.1 and 4.5.2.2. The sample unit for the examination shall be one carrier. The inspection level shall be II (see 6.5).

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TABLE I. Testing of components.

Component & lot size expressed in terms of:	Character- istic	Rqmt. para.	Test method	#Det. Per sample unit	Requirement appl. to sample lot unit avg.	Result reported as:
Leather - for class 1 carrier (1 side)	Material identi- fication 1/	3.3.1	Std. Com'l	1	X	
	Crocking	3.3.1.1	3011 of FED-STD-311	1	X	Good, fair, or poor
	Yellowing 2/	3.3.1.1	5660 of FED-STD-191		X	Good, fair, or poor
	Shrinkage temp.	3.3.1	7011 of FED-STD-311	1	X	To nearest 1°C
Leather - for class 2 carrier (1 side)	Material identi- fication 1/	3.3.1	Std. Com'l	1	X	
	Crocking	3.3.1.1	3011 of FED-STD-311	1	X	Good, fair, or poor
	Shrinkage temp.	3.3.1	7011 of FED-STD-311	1	X	To nearest 1°C

Note: The sample unit for all characteristics is one piece of leather 8 inches by 8 inches and the sample size shall consist of 15 pieces, one piece selected from each of 15 skins. Sampling procedure and location from which sample is to be obtained shall be in accordance with Figure 2, Section 4, FED-STD-311.

1/ Certificate of compliance will be acceptable for this requirement.

2/ Except that the sample shall be exposed for 100 hours.

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4.5.2.1 Visual examination. Defects shall be classified as follows:

Examine	Defect	Classification		
		<u>Major</u>	<u>Minor</u> A B	
Finish	Not specified finish or color, including cut edges of leather.	101		
Cleanliness	Not clean.		201	
Design	Any characteristic not in accordance with the specified requirement (unless otherwise indicated herein).	102		
Material quality of leather	Not full grain or not full grain lightly snuffed.	103		
	Any hole where not required, cut, rupture, or deep scratch.	104		
	Flanky, spongy, or stretchy leather.	105		
	Any brand mark, grub hole, scar tissue, hip mark, wrinkle, brittle or bony area, abraded area, or other defect, seriously affecting serviceability or appearance.	106		
	Any brand mark, grub hole, scar tissue, hip mark, wrinkle, brittle or bony area, abraded area, or otherwise defective, affecting serviceability or appearance, but not seriously.		202	
Construction and workmanship	Any operation omitted or not properly performed, seriously affecting serviceability or appearance.	107		
	Any operation omitted or not properly performed, affecting serviceability or appearance, but not seriously.		203	

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Examine	Defect	Classification		
		Major	Minor	
			A	B
Seams and stitching	Leather not one continuous piece.	108		
	Not fabricated with grain side of leather on exterior surface of carrier.	109		
	Edges not creased or embossed with well-defined line.		204	
	Leather edge not flush and even.		205	
	No slit at bottom end for insertion of sword.	110		
	Not specified stitch type.		206	
	Stitch locks exposed on surface leather.		207	
	Loose stitch tension, resulting in a loosely secured seam.	111		
	Tight stitch tension, resulting in cutting the leather.	112		
	Ends of stitching not properly and neatly secured.		208	
	Gage of stitching not as specified or irregular.		209	
	Any row of stitching omitted.	113		
	Not specified number of stitches per inch.		210	
	Any open seam.	114		
Note: A seam shall be classified as open when one or more stitches joining a seam are broken or when two or more consecutive skipped stitches or run-offs occur.				

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Examine	Defect	Classification		
		Major	Minor	
			A	B
Label	Missing.		211	
	Incorrect information.		212	
	Attached to front.		213	

4.5.2.2 Examination of finished measurements. The end item shall be examined for conformance to the finished measurements shown in figure 1. Any finished measurements deviating from the finished measurement specified herein shall be classified as a defect. In cases where tolerances have not been established, the following shall apply. The inspection level shall be S-3 (see 6.5).

- ± 1/32 inch for measurements less than 1/2 inch.
- ± 1/16 inch for measurements 1/2 inch to less than 3 inches.
- ± 1/8 inch for measurements 3 inches or greater.

4.5.2.3 Inspection of packaging. An inspection shall be made to determine that packaging, packing and marking comply with Section 5 of this specification. Defects shall be scored in accordance with the list below. 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 (see 6.5).

<u>Examination</u>	<u>Defect</u>
Markings (exterior and interior)	Omitted; incorrect; illegible; or of improper size, location, sequence, or method of application.
Materials	Any component missing. Component damaged, or otherwise defective, affecting serviceability.
Workmanship	Inadequate application of components, such as incomplete closure of case liners, container flaps, loose strapping, or inadequate stapling. Bulging or distortion of containers.

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Weight or content (exterior and interior)	Number per container is more or less that required; gross/net weight exceeds requirements.
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5. PACKAGING

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

5.1.1 Level A. Each carrier of one type only shall be completely wrapped with one thickness of tissue paper conforming to type I, class 1 of UU-P-553, then with 50-pound minimum basis weight kraft paper conforming to grade B of UU-P-268 and sealed with paper gummed tape.

5.1.2 Commercial. Carriers shall be packed to afford adequate protection against physical damage during shipment from the supplier to the first receiving activity. The package and the quantity per package shall be the same as that normally used by the contractor for retail distribution.

5.2 Packing. Packing shall be level B or commercial (see 6.2).

5.2.1 Level B. Forty carriers, packaged as specified in 5.1, shall be packed in a fiberboard shipping container with liner conforming to class domestic, variety SW, grade 275 each, size No. 1A of MIL-B-17757 and assembled, closed, and reinforced as specified in the appendix thereto. In addition, each container shall have the contents completely covered on the top and bottom with a sheet of 30 pound minimum basis weight kraft paper conforming to grade B of UU-P-268.

5.2.2 Commercial. Carriers, 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 rates for such supplies. The quantity per shipping container shall be the same as that normally used by the contractor for retail distribution. Containers shall comply with the U.S. Postal Service Manual, Uniform Freight Classification Rule or National Motor Freight Classification Rules, as applicable.

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

6. NOTES

(This section contains information of a general or explanatory nature that may be helpful, but is not mandatory.)

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6.1 Intended use. The carriers are intended for carrying the sword and scabbard by male and female personnel of the Marine Corps.

6.2 Acquisition requirements. Acquisition documents must specify the following:

- a. Title, number, and date of the specification.
- b. Class required (see 1.2).
- c. Whether first article is required (see 3.2).
- d. Number of carriers in first article (see 4.4).
- e. Levels of packaging and packing required (see 5.1 and 5.2).
- f. Acceptance criteria (see 6.5).

6.3 Standard samples and patterns. For information regarding the availability of samples of the carrier and patterns, address inquiry to the procuring activity issuing the invitation for bids (see 3.1).

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

6.5 Acceptance criteria. The acceptance criteria below are recommended for use. The acceptance criteria as specified in the contract or purchase order shall be binding. Unless otherwise specified, the following acceptance criteria are in accordance with MIL-STD-105.

6.5.1 For end item visual examination. An acceptance quality level (AQL), expressed in terms of defects per hundred units, of 2.5 for major defects and 6.5 for major and minor defects combined is recommended.

6.5.2 For end item dimensional examination. An AQL, expressed in terms of defects per hundred units, of 2.5 is recommended.

6.5.3 For packaging examination. An AQL, expressed in terms of defects per hundred units, of 4.0 is recommended.

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6.6 Figure. Figure 1 is furnished for information purposes only. To the extent of any inconsistencies between the written specification and the figure, the written specification shall control.

6.7 Subject (Key word) listing.

Enlisted
Female
Male

6.8 Changes from previous issue. Marginal notations 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 No. 8465-NO52

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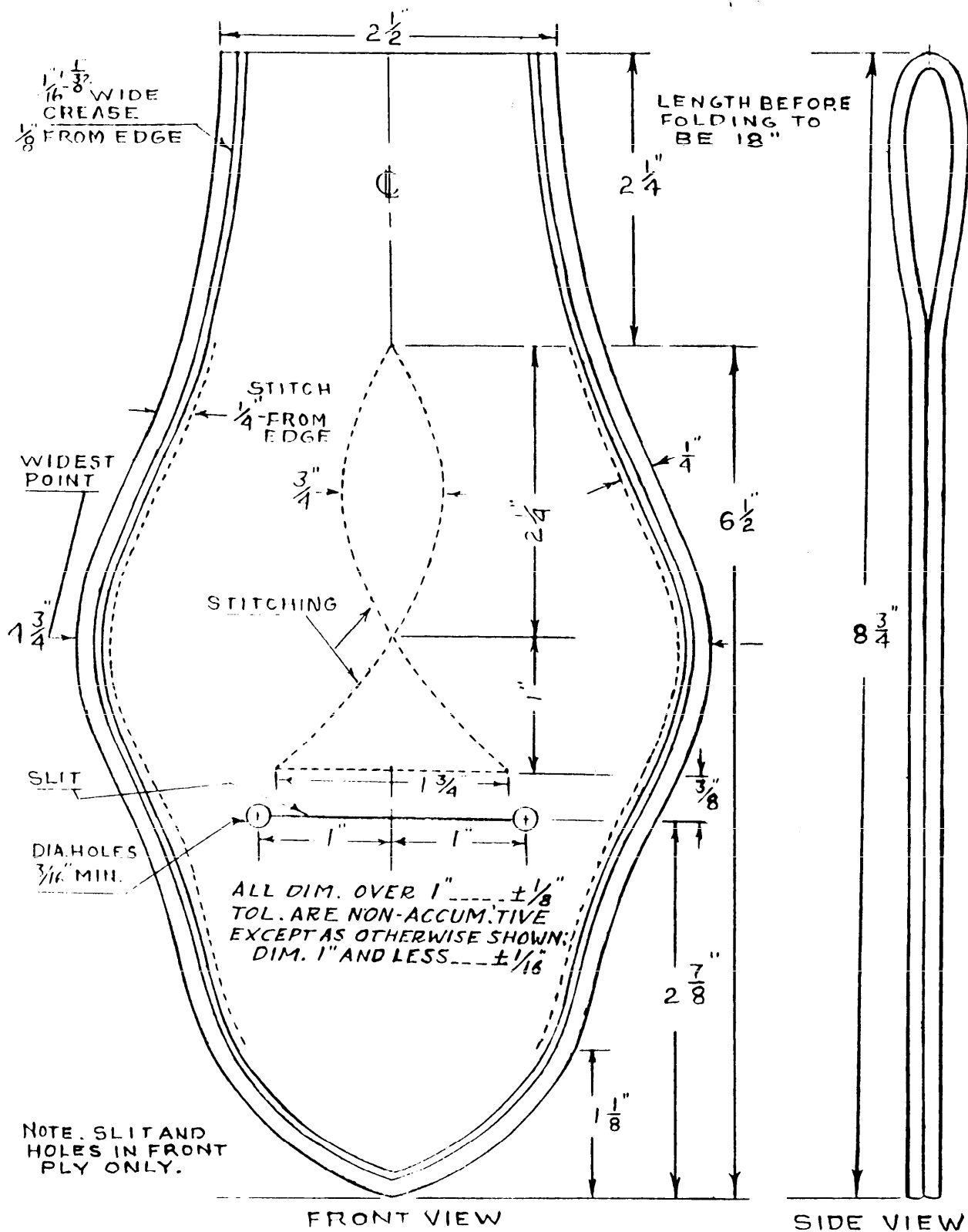


FIGURE 1. CARRIER: SWORD SCABBARD

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

INSTRUCTIONS

1. The preparing activity must complete blocks 1, 2, 3, and 8. In block 1, both the document number and revision letter should be given.
2. The submitter of this form must complete blocks 4, 5, 6, and 7.
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I RECOMMEND A CHANGE:**1. DOCUMENT NUMBER**

MIL-C-19734C(MC)

2. DOCUMENT DATE (YYMMDD)

9 OCTOBER 1990

3. DOCUMENT TITLE

CARRIER: SWORD SCABBARD

4. NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)**5. REASON FOR RECOMMENDATION****6. SUBMITTER****a. NAME** (Last, First, Middle Initial)**b. ORGANIZATION****c. ADDRESS** (Include Zip Code)**d. TELEPHONE** (Include Area Code)

(1) Commercial

(2) AUTOVON
(If applicable)**7. DATE SUBMITTED**
(YYMMDD)**8. PREPARING ACTIVITY****a. NAME**
Commanding General, Marine Corps Research,
Development, and Acquisition Command (PSE-C)**b. TELEPHONE** (Include Area Code)

(1) Commercial

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