

MIL-C-23315A(MC)

1 September 1971

SUPERSEDING

MIL-C-23315(MC)

1 June 1962

CROWNS, SERVICE CAP

1. SCOPE

*1.1 Scope. This specification covers requirements for the removable tropical wool and polyester/wool 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 - Crown, Tropical, Wool, Khaki
 Type II - Crown, Tropical, Polyester/Wool, Green

Schedule of sizes

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

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

MILITARY

MIL-C-326	- Cloth, Silesia, Cotton.
MIL-C-368	- Cloth, Satin, Rayon and Cloth, Twill, Rayon.
MIL-F-20268	- Frame, Service Cap.
MIL-C-21115	- Cloth, Tropical, Wool; Polyester/Wool.

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STANDARDS

FEDERAL

FED-STD-751 - Stitch, Seam, And Stitching

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.)

*2.2 Other publications. The following document forms 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.

UNIFORM CLASSIFICATION COMMITTEE
Uniform Freight Classification Rules

(Application for copies should be addressed to Uniform Classification Committee, Room 202 Union Station, 516 W. Jackson Blvd. Chicago, Illinois 60606.)

3. REQUIREMENTS

3.1 Samples. Samples are 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, the first article consisting of the number of finished crowns of each size specified by the procuring activity (see 6.2) 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 Material.

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

(a) Type I. Cloth, tropical, wool, 10.5-ounce, conforming to type I, class 1 of MIL-C-21115, khaki shade M-1 (see 6.3).

(b) Type II. Cloth, polyester /wool, tropical, 9.0-ounce, conforming to type III of MIL-C-21115, green shade 2235 (see 6.3).

*3.3.2 Lining. The material for lining the crowns shall be cloth, rayon twill, 3.7-ounce, conforming to class 1 of MIL-C-368; khaki shade 2101 for type I crowns and green shade 2208 for type II crowns (see 6.3).

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*3.3.3 Silesia. The material for 1/2-inch-wide bias-cut stay tape for reinforcing the front quarter seam shall be cloth, cotton, silesia, 4.5-ounce, conforming to type I of MIL-C-326. The color of the silesia shall be green shade 2202 or black shade 3212.

*3.3.4 Thread. The thread for the applicable seaming, stitching and buttonhole making operations shall be as follows for each type crown.

*3.3.4.1 Cotton thread. The cotton thread shall conform to type IC2 and IA3 of V-T-276 and to the requirements specified in Table I.

*3.3.4.2 Silk thread. The silk thread shall conform to type I of V-T-301 and to the requirements specified in Table I.

Table I. Thread requirements

Operations	Thread	
	Cotton (inside)	Silk (outside)
Seaming and stitching except overedge stitching	Left twist, ticket No. A, 3-ply (needle and bobbin)	Left twist, size A, 3-ply (needle and bobbin)
Overedge stitching	Left twist, ticket No. 70, 2-ply (needle and bobbin)	
Buttonholes		Left twist, size A, 3-ply (needle and looper)

*3.3.4.3 Color and colorfastness. The color of the thread shall be khaki shade P-1, cable No. 66019, for type I crowns and green shade T-1, cable No. 66023, for type II crowns. The threads, when tested in accordance with the applicable thread specification, shall show good fastness to wet (dry) cleaning and light.

*3.3.5 Eyelets and washers. The eyelets and washers shall be brass (0.008 \pm 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. The washer is required on front eyelet only.

*3.3.6 Label. Each crown shall be provided with a combined identification and size label conforming to type I, class 4 of DDD-L-20, except the content shall include the name of supplier ^{1/} and in addition, the Wool Products Act information shall be included in the label. 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. The crowns are intended to be dry cleaned and labels shall show fastness to dry cleaning.

*3.- Design. The crown shall be the Marine Corps design shown in Figure 2, having a one-piece top fully lined with rayon cloth; 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; and raw edges overedge stitched. The crowns are designed to properly fit the cap frame and crown support with which they are intended to be used (see 6.1).

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

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*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 II. 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 specified material in accordance with the pattern parts indicated below:

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

*3.6 Construction

*3.6.1 Manufacturing requirements. The crowns shall be manufactured in strict accordance with the operations and the stitch, seam, and stitching types specified in Table I.

*3.6.1.1 Operations. 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.

*3.6.1.2 Stitches, seams, and stitchings. The stitching, seam, and stitching types specified in Table II 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 cover. The number of stitches per inch as specified in Table II indicates the minimum and maximum number permitted.

*3.6.1.2.1 Overedge stitching. Overedge or serge stitching shall be done on serging machines with knife attachment properly set to trim the raw edge, when overedged, without cutting the material.

*3.6.1.2.2 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 backstitched not less than 1/2 inch on each side of the skip or break.

*3.6.1.3 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) Sew on shade tickets.
- (c) Adhesive type tickets which show discoloration and the adhesive mass which adheres to the material upon removal of the tickets.
- (d) Any marking medium which would tend to leave a permanent mark.

TABLE II MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
1.	<p><u>Cutting.</u></p> <p>a. Cut the crowns in strict accordance with patterns furnished by the Government.</p> <p>b. Cut the materials in the direction indicated by directional lines on the patterns.</p> <p>c. Cut all component parts of the crowns from one piece of the basic material.</p> <p>d. Cut crown lining from one piece of rayon twill material.</p>					
2.	<p><u>Replacement of damaged parts.</u></p> <p>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.</p> <p>b. Replace any part damaged during the manufacturing process by needle chews which may be expected to develop into a hole, scissors or knife cut, tear, holes, mends or burns.</p>					
3.	<p><u>Shade markings.</u></p> <p>a. Mark or ticket (see 3.6.1.3) the component parts of the crowns to insure proper assembly and a uniform shade and size throughout the crown.</p> <p>b. Adhesive type shade tickets, when used, shall be adhered to the inside of the crowns.</p> <p>c. The use of tickets with metal fastening devices is prohibited on rayon lining.</p>					

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TABLE II MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
4.	<u>Make headband.</u> Finished appearance. The band shall finish smooth and flat 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 the headband in half end to end and join the two ends with a 1/4-inch seam. Press the seam open and flat with a heated pressing iron or pressing machine. c. Fold the headband in half lengthwise and stitch 3/16 to 1/4 inch from the folded lower edge.					
		301 or 401	SSa-1 SSa-1	10-14 10-14	A A	A A
		301 or 401	OSf-1 OSf-1	10-14 10-14	A A (silk) (silk)	A A
5.	<u>Join quarters.</u> Finished appearance. The quarters shall be joined without twists, puckers, pleats or other distortions. All top-stitching shall be uniform. a. The quarters shall consist of one ply of basic material. b. Seam quarters together at the sides and back, 1/4 inch from edges. c. Overedge stitch the sides and back raw edge seams together. or d. Seam and stitching may be performed simultaneously with a machine that will seam and overedge stitch in one operation. e. Turn the seam allowance flat against the side and back quarters and top-stitch the quarters, through the seam allowance, 1/16 to 3/32 from the raised edge. f. On the outside of the finished crown, the raised edge of the side seams shall be towards the back of the crown as worn and the raised edge of the back seam shall be towards the right of the crown as worn.					
		301 or 401	LSq-2 (a) LSq-2 (a)	10-14 10-14	A A	A A
		504 or 505	EFd-1 EFd-1	6-8 6-8	70/2 70/2	70/2 70/2
		301 or 401	LSq-2 (b) LSq-2 (b)	10-14 10-14	A A (silk) (silk)	A A

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TABLE II MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
5.	<u>Join quarters.</u> (cont'd)					
	g. Seam the front edges together 1/4 inch from raw edges.	301	SSz-3 (a)	10-14	A	A
	h. Spread open front seam and position 1/2-inch-wide silesia bias stay tape on the inside of the front quarter seam. Top stitch 1/16 to 3/32 inch on each side of the joining seam.	301	SSz-3 (b)	10-14	A	A
	i. The front seam may be pressed open.					
6.	<u>Join lining to crown.</u>					
	Finished appearance. The lining shall be joined to the 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 uniformly 1/8 to 3/16 inch from edge.	301 or 401	SSa-1	6-8	A	A
7.	<u>Join quarters to crown.</u>					
	Finished appearance. Quarters shall be joined to crown without twists, puckers, pleats or other distortion. The top stitching shall be uniform.					
	a. Position the quarters on the outside of crown with edges and notches matching and join with a 1/4-inch seam.	301 or 401	LSq-3 (a)	10-14	A	A
			LSq-3 (a)	10-14	A	A
	b. Overedge stitch the raw edge of the quarters-crown seam allowance, catching the raw edge of the crown lining in the stitching.	504 or 505	EFd-1	6-8	70/2	70/2
	or					
	c. Seam and stitching may be performed simultaneously with a machine that will seam and overedge stitch in one operation.					
	d. Turn down and topstitch the quarters through the seam allowance with a double row of stitches. The double row of stitches shall be 1/8-inch gage, with the outer row 1/16 inch from the raised edge of quarters.	301 or 401	LSq-3 (b)	10-14	A (silk)	A
			LSq-3 (b)	10-14	A (silk)	A

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TABLE II MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
8.	<u>Join headband to quarters.</u> Finished appearance. Headband shall be joined to quarters without twists, puckers, pleats or other distortions. 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 the joining seam of headband matching back seam of quarters. b. Seam headband to quarters, 1/4 inch from raw edges. c. Overedge stitch raw edge of the headband quarters seam allowance. or d. Seam and stitching may be performed simultaneously with a machine that will seam and overedge stitch in one operation.					
		301 or 401	LSq-2 (a) LSq-2 (a)	10-14 10-14	A A	A A
		504 or 505	EFd-1 EFd-1	6-8 6-8	70/2 70/2	70/2 70/2
9.	<u>Stitch label to cover.</u> a. Position the combination identification and size label 1-1/4 +1/4 inches to the right or left of the center back seam, with the top edge of label lapped approximately 3/16 inch on underside of overedge stitched headband quarters seam allowance. Stitch label to the seam allowance approximately 1/8 inch from top edge of label.	301	LSa-1	8-12	A	A
10.	<u>Topstitch quarters-headband seam.</u> Finished appearance. The raised edge of quarters shall be uniformly topstitched without twists, puckers, pleats or other distortions. a. Turn down the headband and topstitch the quarters through the headband-quarters seam allowance, 1/16 to 3/32 inch from the raised edge.	301 or 401	LSq-2 (b) LSq-2 (b)	10-14 10-14	A A	A (silk) A (silk)

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TABLE II MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
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 1/4 to 3/8 inch from lower edge of headband with the purling on the outside. Center of buttonholes shall be $5\text{-}3/4 \pm 1/16$ inches from center front of crown.</p> <p>a. Mark the right and left side, respectively, of the headband $5\text{-}3/4$ inches from the center front 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>			48 per buttonhole including tack	A (silk)	A
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 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 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 $1 \pm 1/8$ inch from its corresponding side seam. The center of all eyelets shall be midway between the upper and lower raised edges of quarters. Side eyelets shall be in horizontal alignment.</p>					
13.	<p><u>Clean crowns.</u></p> <p>a. Trim all ends of stitchings and remove all loose threads from the crowns.</p> <p>b. Remove all spots, stains, markings and shade tickets from the crown without injury to the material.</p>					

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*3.7 Finished measurements. The finished crown shall conform to the measurements shown in Table III.

Table III. Finished measurements

Component	Dimensions (inches)
Height of headband <u>1/</u>	1-5/8 min., 1-3/4 max.
Height of quarters <u>2/</u>	
- at front	2-1/4 \pm 1/8
- at sides	2-1/2 \pm 1/8
- at back	2 \pm 1/8

1/ Measurement for height of headband shall be taken from the lower finished edge of headband to the lower raised edge of quarters.

2/ Measurement for height of quarters shall be taken at the raised front, side and back seam, respectively, from upper to lower raised edge of quarters.

*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 twists, wrinkles or other distortions. The crown shall lie smooth and flat without twists, wrinkles or other distortions. The headband of the crown shall extend down to the welt on headband of frame without stretching or wrinkling. Button-holes 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 of product established by this specification. The occurrence of defects shall not exceed the levels set by the applicable acceptable quality levels (AQL).

4. QUALITY ASSURANCE PROVISIONS

*4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the supplier 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.

*4.1.1 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 Inspection. Inspections shall be in accordance with the provisions set forth in MIL-STD-105, except where otherwise indicated herein.

*4.2.1 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.

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*4.2.2 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 IV for characteristics noted. All test reports shall contain the individual values utilized in expressing the final results.

*4.2.2.1 Sampling for testing. Unless otherwise specified in subsidiary specifications, sampling shall be in accordance with the following. The lot shall be unacceptable if one or more sample units fail to meet any test requirements specified herein.

<u>Lot size (lot unit)</u>	<u>Sample size (sample unit)</u>
800 or less	2
801 through 22,000	3
22,001 and over	5

The unit for expressing lot size and sample unit for testing each component shall be in accordance with the applicable subsidiary specification and as follows:

<u>Component</u>	<u>Lot size expressed as</u>	<u>Sample unit for testing</u>
Eyelets	1000	15 each
Washers	1000	15 each

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Table IV - Test methods

Components	Characteristics	Rqmt. para.	Test method	No. Determinations per sample unit	Results reported as:
Eyelets	Material identification	3.3.5	Std. Com'l	1	Pass or fail
	Color (flange)	3.3.5	Visual	1	Pass or fail
	Scores	3.3.5	Visual	1	Pass or fail
Washer	Material identification	3.3.5	Std. Com'l	1	Pass or fail

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*4.2.3 Examination of the end item. The end item shall be examined for defects listed in 4.2.3.1 and 4.2.3.2.

*4.2.3.1 General defects. General defects shall be classified as follows:

Examine	Defect	Classification	
		Major	Minor A B
Material defects and damages	a. Any hole or weakening defect that may develop into a hole, such as a smash, multiple float, loose slub, etc.	X	
	b. Shade bar, unsightly slub etc.	X	
	c. Needle chew which may develop into a hole.	X	
	d. Scissors or knife cut, tear, mend or burn.	X	

NOTE: Material defects and workmanship damages are to be classified as indicated above only when the condition is one which definitely weakens the fabric or when it is so conspicuously located as to be clearly noticeable. Weakening or nonweakening defects which are inconspicuous and have negligible effect on serviceability are to be classified as follows:

Material defect - No defect.

Workmanship damages - Minor B defect.

Shaded parts	Any shaded part clearly noticeable.	X	
Cleanness	a. One or more spots or stains on outside, clearly noticeable.	X	
	b. One or more spots or stains on inside, clearly noticeable.		X
	c. Thread ends not trimmed or loose thread not removed on major portion of crown.		X
	d. One or more shade tickets not removed.		X
	e. Any shade marking exposed and visible on outside of crown (score only when clearly noticeable).		X

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Examine	Defect	Classification	
		Major	Minor A B
Components and assembly	a. Any defective component.		X
	b. Any component part omitted.	X	
	c. Any required operation omitted or improperly performed: - seriously affecting appearance or serviceability. - affecting appearance or serviceability, but not seriously.	X	X
Cutting	Any component part not cut in accordance with directional lines on pattern or specified requirements.	X	
Seams and stitching	a. General		
	1. Any part of crown caught in any unrelated operation or stitching.	X	
	2. Seams twisted, puckered or pleated, affecting appearance (unless otherwise classified herein).		X
	3. Thread breaks or ends of all stitching (when not caught in other seams or stitching) not backstitched.		X
	4. Wrong shade or two shades of thread used on outside of crown.		X
	b. Gage of stitching (edge, raised or double stitching)		
	1. Irregular, i. e., unevenly gaged or various stitching not uniform, affecting appearance.		X
	2. Edge or raised stitching sewn too close to edge, resulting in damage of cloth.	X	
	3. Beyond range or width specified or varies more than 1/16 inch when no range is specified.		X
	c. Open seams		
	Any seam open:		
	- more than 1/4 inch.		X
	- more than 1/8 inch but not more than 1/4 inch.		X

NOTE: One or more broken or two or more continuous skipped or run-off stitches constitute an open seam. On double stitched seams, a seam is considered open when one or both sides of seam are open.

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Examine	Defect	Classification	
		Major	Minor A B
	d. Raw edge		
	- more than 1/8 inch but not more than 1/4 inch.		X
	- more than 1/4 inch but not more than 1/2 inch.		X
	- more than 1/2 inch.	X	
	NOTE: Raw edges are classified as such only if occurring at places where the edge is required to be turned under. Raw edges not securely caught in stitching shall be classified as an open seam.		
	e. Run-offs		
	1. Joining seams when resulting in an open seam		
	- use "Open Seam" classification.		
	2. Edge or raised stitching (when not resulting in an open seam:		
	- more than 1/4 inch but not more than 3/4 inch.		X
	- more than 3/4 inch.		X
	f. Seam and stitching types		
	1. Wrong seam or stitch type.		X
	2. Looper thread of 401 stitch type finishing on outside of crown.		X
	g. Stitch tension		
	1. Loose tension resulting in a loose seam.	X	
	2. Tight tension (stitches break when normal strain is applied to seam or stitching).	X	
	3. Loose tension on edge or raised stitching resulting in loosely exposed bobbin thread or top thread.		X
	NOTE: Puckering is evidence of tight tension. When puckering is evident, seam shall be tested by exerting normal pull in lengthwise direction of seam.		
	h. Stitches per inch (to be scored only when the condition exists on the major portion of seam).		
	Less than specified:		
	- one stitch.		X
	- two stitches.		X
	- three or more stitches.	X	

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Examine	Defect	Classification	
		Major	Minor A B
	i. Stitches skipped or broken (on edge, top or raised stitching when seam is seamed, turned and stitched):		
	1. More than 1/2 inch.		X
	2. More than 1/4 inch but not more than 1/2 inch.		X
	3. On overedge stitching, more than 1 inch.		X
Buttonholes (construction)	a. Not securely caught on fabric, causing stitching to pull away from fabric.	X	
	b. One or more broken stitches in one buttonhole.		X
	c. One or more broken stitches in two buttonholes.	X	
	d. More than two skipped stitches in one or both buttonholes.		X
	e. Tack on one or both ends omitted or insecure: - one buttonhole. - both buttonholes.	X	X
	f. Wrong type or uncut buttonhole.		X
	g. Very ragged buttonholes.		X
	h. Less than 3/4 inch or more than 1 inch in length.		X
Eyelets (applying to all eyelets)	a. Eyelet broken, bent or insecurely clinched: - one eyelet. - two or more eyelets.	X	X
	b. Material pleated in clinching, affecting appearance.		X
	c. Raw edge exposed beyond edge of eyelet on outside of crown on one or more eyelets.	X	
	d. Not specified type, size or finish.		X

*4.2.3.2 Detailed defects applicable to specific parts. Detailed defects applicable to specific parts shall be classified as follows:

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Examine	Defect	Classification	
		Major	Minor A B
Band	a. Band less than 1-5/8 inches or more than 1-3/4 inches wide.		X
	b. Irregular in width by more than 1/8 inch, affecting appearance.		X
	c. Back seam not aligned with back quarter seam by 3/16 inch or more.		X
	d. Upperside twisted or too full, affecting smoothness on outside.		X
	e. Band overlapping quarters at joining seam.	X	
	f. Puckered or pleated at joining to quarters.		X
Buttonholes (position)	a. Positioned from bottom edge of band: - less than 3/16 inch but not less than 1/8 inch or more than 5/16 inch but not more than 3/8 inch. - less than 1/8 inch or more than 3/8 inch.		X X
	b. Position of center of buttonhole from center front of crown. - less than 5-5/8 inches but not less than 5-1/2 inches or more than 5-7/8 inches but not more than 6 inches. - less than 5-1/2 inches or more than 6 inches.		X X
Crown piece	a. Poorly shaped.	X	
	b. Crown puckered or pleated at joining to quarters.		X
	c. Crown unevenly joined to quarters, i.e., twisting, puckering, or pleating around the edge.		X
	d. Joining seam not topstitched or not pressed open.		X
	e. Topstitched seam not worked out, distorting contour of edge	X	

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Examine	Defect	Classification	
		Major	Minor A B
Crown lining	Tight, short or twisted, affecting smoothness on outside of crown.	X	
Front eyelet (position)	a. Front eyelet not reinforced on underside with brass washer.	X	
	b. Front eyelet not set on front quarter seam.	X	
	c. Front eyelet not centered with width of front quarter: - by more than 1/8 inch, but not more than 1/4 inch. - by more than 1/4 inch.	X	X
Side eyelets (position)	a. Side eyelets out of horizontal alignment: - by 1/4 inch or more but not more than 3/8 inch. - by more than 3/8 inch.	X	X
	b. Side eyelets misplaced from mid-point between crown and band by more than 1/4 inch.		X
	c. Position of side eyelets from each side of side seams less than 7/8 inch or more than 1-1/8 inches.		X
NOTE: Position of all eyelets measured from center of eyelets.			
Quarters	a. Seam joining quarters twisted or distorted, i.e., 1/4 inch or more from vertical position.		X
	b. Joining seam not topstitched: - on one seam. - on more than one seam.		X X
	c. Quarters puckered or pleated at joining to band or crown.	X	
	d. Any quarter deviating from required measurements: - by more than 1/8 inch but not more than 1/4 inch. - by more than 1/4 inch.	X	X

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Examine	Defect	Classification	
		Major	Minor A B
Underside of band	Edges of bands not overedge stitched.		X
Labels	Identification-size label missing, incorrect or illegible.		X

*4.2.3.3 Fit test. Crowns shall be fit tested against applicable size cap frames in accordance with schedule of sizes of crowns being purchased. The following defects are applicable to covers which improperly fit the corresponding size cap frame.

Head size	Band of crown fitting frame too loose, causing fullness on band or too tight, not permitting band to enter frame.
Crown size	Circumference of crown too small, not permitting crown wire to lie smoothly. Circumference of crown too large, not providing snug fit, affecting appearance.

*4.2.3.4 Inspection levels and AQL's. Inspection levels and AQL's expressed in defects per 100 units (DHU) shall be as follows:

4.2.3.1 and 4.2.3.2

Inspection level III of MIL-STD-105

Major	1.5 DHU
Major and Minor A (combined)	4.0 DHU
Total, Major, Minor A and B (combined)	10.0 DHU

4.2.3.3

Inspection level L-6 of MIL-STD-105

One class	4.0 DHU
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*4.2.4 Examination of preparation for delivery requirements. An examination shall be made to determine compliance with packaging, packing and marking requirements of 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 with the exception that it need not be sealed. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot size shall be the number of shipping containers in the end item inspection lot. The inspection level shall be L-4 and the AQL shall be 4.0 DHU.

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<u>Examine</u>	<u>Defect</u>
Marking (exterior and interior)	Omitted, incorrect, illegible, of improper size, location, sequence, or method of application.
Materials	Any component missing or damaged.
Workmanship	Inadequate application of components, such as incomplete closure of case liners, container flaps, loose strapping, inadequate stapling. Bulging or distortion of containers.
Content	Number of intermediate packages is more or less than required.

5. PREPARATION FOR DELIVERY

*5.1 Packaging. Packaging shall be level A or C, 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) crowns of one class and size only, unit packaged as specified in 5.1.1.1, shall be placed in a set-up paperboard 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 Level C. The crowns shall be packaged in accordance with manufacturer's normal practice.

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

*5.2.1 Level A. Ten (10) intermediate packages of one type and size only (200 crowns), packaged as 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 of one type and size only (200 crowns), packaged as 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.

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*5.2.3 Level C. 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 or regulations of other carriers applicable to the mode of transportation.

*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 _____
 Name of Supplier _____

5.3.1 Labels. 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.

6. NOTES

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

*6.2 Ordering data. Purchasers should exercise any desired options offered herein, and procurement documents should specify the following:

*6.2.1 Procurement requirements.

- (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) Number of crowns in first article (see 3.2).
- (e) Level of packaging and packing required (see 5.1 and 5.2).

*6.2.2 Contract data requirements. Data conforming to Data Item Descriptions DI-R-4803, DI-R-4805, DI-T-4901, DI-T-4902, DI-T-4903 and DI-T-4904 will usually be required for delivery in connection with this specification. When so required, such data will be specified for delivery on a DD Form 1423 included in the contract.

*6.3 Samples and shade samples. For information regarding the availability of samples of the crowns and of the standard shades specified, address inquiry to the procuring activity issuing the Invitation for Bids.

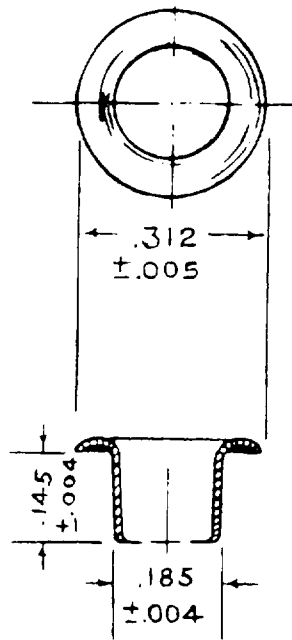
*6.4 First article. Examination, test, and approval shall be as specified by the contracting officer (see 3.2).

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*6.5 Marginal notations. 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 has been done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and suppliers 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.

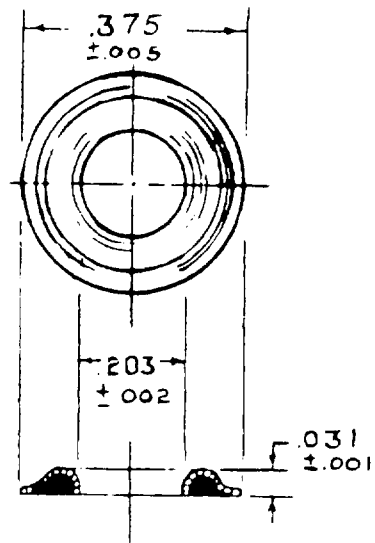
Preparing activity:
Navy - MC
Project No. 8405-N337

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EYELET

SCORED BARREL
6 TO 8 SCORES



WASHER

FIGURE 1. CROWNS, SERVICE CAP:
TROPICAL, WOOL, AND POLYESTER/WOOL

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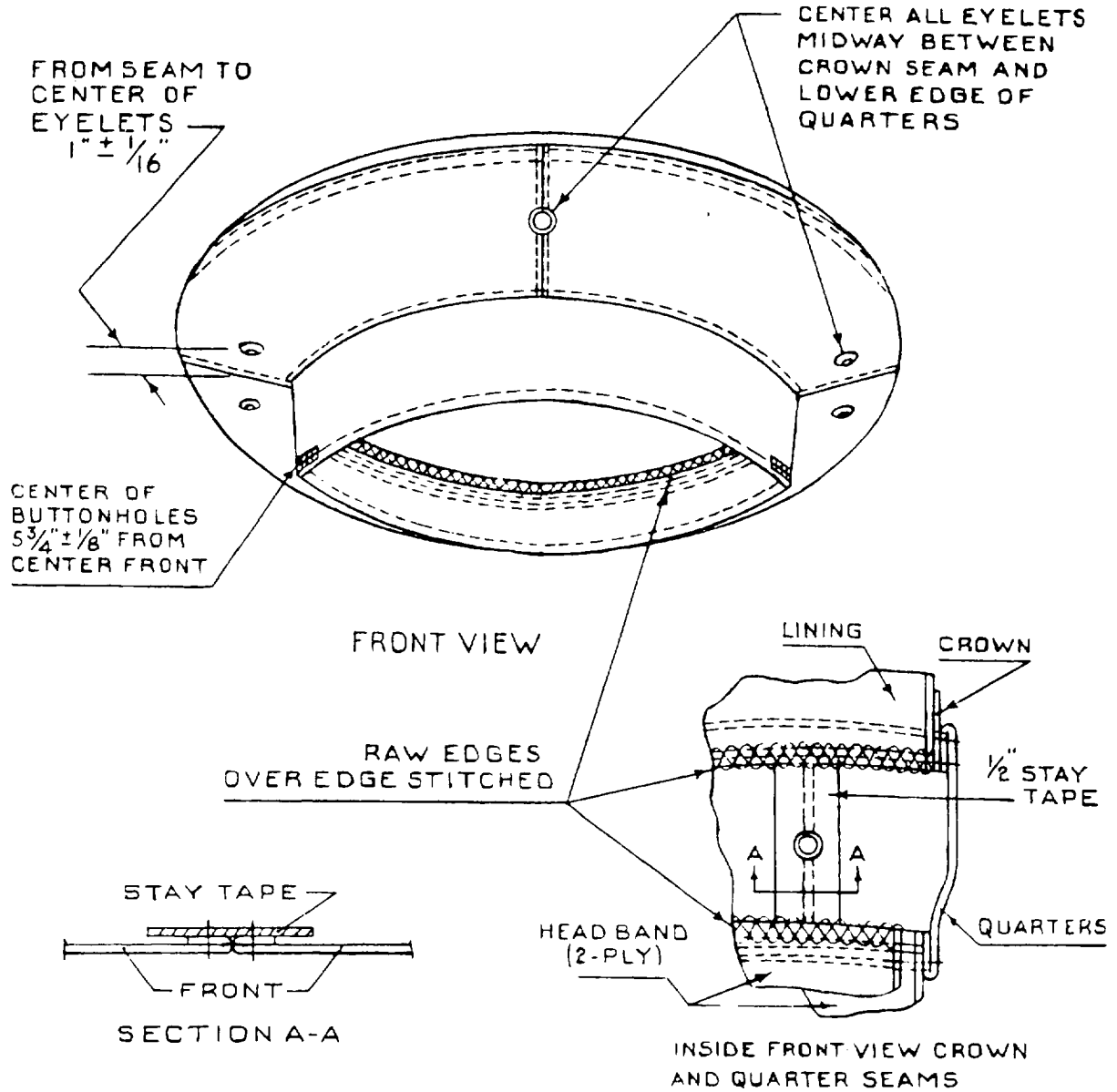


FIGURE 2. CROWNS, SERVICE CAP: TROPICAL, WOOL, AND POLYESTER/WOOL

M.C.S.A.
826: R.G.F.
1 Sep '71

SPECIFICATION ANALYSIS SHEET		Form Approved Budget Bureau No. 119-R004
<u>INSTRUCTIONS</u>		
This sheet is to be filled out by personnel either Government or contractor, involved in the use of the specification in procurement of products for ultimate use by the Department of Defense. This sheet is provided for obtaining information on the use of this specification which will insure that suitable products can be procured with a minimum amount of delay and at the least cost. Comments and the return of this form will be appreciated. Fold on lines on reverse side, staple in corner, and send to preparing activity (as indicated on reverse hereof).		
SPECIFICATION		
ORGANIZATION (of submitter)		CITY AND STATE
CONTRACT NO.	QUANTITY OF ITEMS PROCURED	DOLLAR AMOUNT \$
MATERIAL PROCURED UNDER A		
<input type="checkbox"/> DIRECT GOVERNMENT CONTRACT <input type="checkbox"/> SUBCONTRACT		
1. HAS ANY PART OF THE SPECIFICATION CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE?		
A. GIVE PARAGRAPH NUMBER AND WORDING.		
B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES.		
2. COMMENTS ON ANY SPECIFICATION REQUIREMENT CONSIDERED TOO RIGID		
3. IS THE SPECIFICATION RESTRICTIVE?		
<input type="checkbox"/> YES <input type="checkbox"/> NO IF "YES", IN WHAT WAY?		
4. REMARKS (Attach any pertinent data which may be of use in improving this specification. If there are additional papers, attach to form and place both in an envelope addressed to preparing activity)		
SUBMITTED BY (Printed or typed name and activity)		DATE

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OFFICIAL BUSINESS

Commanding General (826)
Marine Corps Supply Activity
1100 South Broad Street
Philadelphia, Pennsylvania 19146

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