

NOT MEASUREMENT SENSITIVE

MIL-DTL-3476J
21 October 1998
SUPERSEDING
MIL-B-3476H
10 May 1991

DETAIL SPECIFICATION

BRASSARDS, GENERAL SPECIFICATION FOR

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

1. SCOPE

1.1 Scope. This specification covers the general requirements for brassards used by the Department of Defense (see 6.1).

1.2 Classification. Brassards covered by this specification shall be as specified on the applicable military specification sheet and Supplement 1 (see 2.1 and 6.2).

2. APPLICABLE DOCUMENTS

2.1 General. The documents listed in this section are specified in sections 3 and 4 of this specification. This section does not include documents cited in other sections of this specification or recommended for additional information or as examples. While every effort has been made to ensure the completeness of this list, document users are cautioned that they must meet all specified requirements documents cited in sections 3 and 4 of this specification, whether or not they are listed.

2.2 Government documents.

2.2.1 Specifications, standards, and handbooks. The following specifications, standards and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those listed in the issue of the Department of Defense Index of Specifications and Standards (DoDISS) and supplement thereto, cited in the solicitation (see 6.2).

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in preparing this document should be addressed to: Director, The Institute of Heraldry, US Army, 9325 Gunston Road, Room S112, Fort Belvoir, VA 22060-5579, by using the Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document.

AMSC N/A

FSC 8455

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

MIL-DTL-3476J

SPECIFICATIONS

FEDERAL

A-A-52094 - Thread, Cotton

DEPARTMENT OF DEFENSE

MIL-DTL-14652 - Insignia, Embroidered, Organizational, Insignia and Badges, General Specification For

STANDARDS

FEDERAL

FED-STD-191 – Textile, Test Methods

FED-STD-751 – Stitches, Seams and Stitching

SPECIFICATION SHEETS

(See Supplement 1 for list of specification sheets.)

(Unless otherwise indicated, copies of the above specifications, standards and handbooks are available from the Standardization Document Order Desk, 700 Robbins Avenue, Building 4D, Philadelphia, PA 19111-5094.)

2.2.2 Other Government documents, drawings and publications. The following other Government documents, drawings, and publications form a part of this document to the extent specified herein. Unless otherwise specified, the issues are those cited in the solicitation.

DRAWINGS

THE INSTITUTE OF HERALDRY

B-8-42 - Brassard, Location of Dot Fasteners

B-8-42A - Brassard, Location of Dot Fasteners

B-8-61 - Brassard, Location of Hook and Loop Fasteners

(Figures 1, 2, and 3 are miniature reproductions of the referenced drawings and are for information only. Copies of specifications, standards, drawings and specification sheets required by the contractors in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

2.3 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)

MIL-DTL-3476J

(Non-government standards and other publications are normally available from the organizations that prepare or distribute the documents. These documents also may be available in or through libraries or other information services.)

AMERICAN SOCIETY FOR QUALITY CONTROL

ANSI/ASQC Z1.4, 1993 - Sampling Procedures and Tables for Inspection by Attributes

(Application for copies of ANSI/ASQC Z1.4 should be addressed to the American Society for Quality Control, 611 East Wisconsin Avenue, Milwaukee, Wisconsin 53202.)

MERIT RIBBON COMPANY

DoD Standard Shades for Heraldic Yarns for Embroidery and Ribbon, 1993 Edition

(Application for copies of the DoD Standard Shades for Heraldic Yarns for Embroidery and Ribbon should be addressed to Merit Ribbon Co., Inc., 30 David's Drive, Hauppauge, NY 11788.)

THE COLOR ASSOCIATION OF THE UNITED STATES

The Standard Color Reference of America, Tenth Edition
United States Army Color Card, The Official Colors for Branches, Agencies, etc.

(Application for copies of the color card and the U.S. Army Color Card should be addressed to the Color Association of the United States, 343 Lexington Avenue, New York, NY 10016-1187.)

2.4 Order of precedence. In the event of a conflict between the text of this document and the references cited herein (except for related associated specifications or specification sheets), 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 Specification sheets. The individual item requirements shall be as specified herein and in accordance with the applicable specification sheet. In the event of any conflict between the requirements of this specification and the specification sheet, the latter shall govern.

3.2 First article. When specified (see 6.2), a sample shall be subjected to first article inspection in accordance with 4.3.

3.3 Recycled, recovered, or environmentally preferable materials. Recycled, recovered, or environmentally preferable materials should be used to the maximum extent possible provided that the material meets or exceeds the operational and maintenance requirements and promotes economical advantageous life cycle costs.

3.4 Material. The material shall be as specified herein.

MIL-DTL-3476J

3.4.1 Percalé. The percale shall be a preshrunk 100% cotton plain weave fabric conforming to the physical requirements listed below. The color shall conform to the cable number specified on the applicable specification sheet. Colorfastness shall conform to the requirements of 3.7.2.

Weight per square yard (ounces):	3 minimum
Yarns per inch (minimum):	Warp 85, Filling 72
Breaking strength, minimum (pounds):	Warp 45, Filling 30
Weave:	Plain

3.4.2 Wool broadcloth or facing cloth. The wool broadcloth or facing cloth shall be a mothproofed 100% wool or 80% wool, 20% polyester blend fabric conforming to the physical requirements listed below. The color shall conform to the cable number specified on the applicable specification sheet. Colorfastness shall conform to the requirements of 3.7.2.

a. 100% Wool

Weight per square yard (ounces):	16 minimum
Yarns per inch (minimum):	Warp 60, Filling 58
Breaking strength, minimum (pounds):	Warp 40, Filling 35
Weave:	2 up, 1 down right hand twill

b. 80/20% Wool/Polyester

Weight per square yard (ounces):	16 minimum
Yarns per inch (minimum):	Warp 51, Filling 51
Breaking strength, minimum (pounds):	Warp 55, Filling 45
Weave:	2 up, 1 down right hand twill

3.4.3 Wool felt. The wool felt shall be a mothproofed 100% pressed wool fabric conforming to the physical requirements listed below. The color shall conform to the cable number specified on the applicable specification sheet. Colorfastness shall conform to the requirements of 3.7.2.

Thickness (inches):	Nominal 0.063, min. - 0.053, max. - 0.073
Weight per square yard (ounces):	Nominal 12, minimum 11, maximum 13
Breaking strength (pounds):	30 minimum

3.4.4 Cloth, cotton, uniform twill. The cotton uniform twill cloth shall be a preshrunk 100% white cotton twill conforming to the physical requirements of any of the following type materials:

a. Type I

Yarn:	Combed
Ply:	Warp 2, Filling 2
Weight per square yard (ounces):	7.9 minimum, 8.6 maximum
Yarns per inch (minimum):	Warp 116, Filling 56

MIL-DTL-3476J

Breaking strength (pounds):	Warp 180, Filling 120
Weave:	3/1 right hand twill

b. Type II

Yarn:	Combed
Ply:	Warp 2, Filling 1
Weight per square yard (ounces):	7.9 minimum, 8.6 maximum
Yarns per inch (minimum):	Warp 116, Filling 56
Breaking strength (pounds):	Warp 180, Filling 110
Weave:	3/1 right hand twill

c. Type III

Yarn:	Combed
Ply:	Warp 1, Filling 1
Weight per square yard (ounces):	7.7 minimum, 8.4 maximum
Yarns per inch (minimum):	Warp 112, Filling 54
Breaking strength (pounds):	Warp 160, Filling 110
Weave:	3/1 left hand twill

d. Type IV

Yarn:	Combed
Ply:	Warp 1, Filling 1
Weight per square yard (ounces):	7.2 minimum, 7.9 maximum
Yarns per inch (minimum):	Warp 100, Filling 54
Breaking strength (pounds):	Warp 160, Filling 110
Weave:	3/1 left hand twill

e. Type V

Yarn:	Carded
Ply:	Warp 1, Filling 1
Weight per square yard (ounces):	7.2 minimum, 7.9 maximum
Yarns per inch (minimum):	Warp 100, Filling 54
Breaking strength (pounds):	Warp 150, Filling 100
Weave:	3/1 left hand twill

f. Type VI

Yarn:	Carded
Ply:	Warp 1, Filling 1
Weight per square yard (ounces):	8.2 minimum, 8.6 maximum
Yarns per inch (minimum):	Warp 112, Filling 56
Breaking strength (pounds):	Warp 170, Filling 80
Weave:	3/1 left hand twill

3.4.5 Cloth, wool serge. The wool shall be a mothproofed 100% wool serge conforming to the physical requirements listed below. The color shall conform to the shade or cable

MIL-DTL-3476J

number specified on the applicable specification sheet. Colorfastness shall conform to the requirements of 3.7.2.

Weight per square yard (ounces):	18 minimum
Ply:	Warp 2, Filling 2
Yarns per inch (minimum):	Warp 68, Filling 54
Breaking strength (pounds, minimum):	Warp 110, Filling 100
Shrinkage (maximum):	Warp 4.0%, Filling 2.5%
Weave:	2 up, 2 down, 4 harness right twill

3.4.6 Cloth, wool melton. The wool shall be a mothproofed melton conforming to the physical requirements of any of the following type materials listed below. The color shall conform to the shade or cable number specified on the applicable specification sheet. Colorfastness shall conform to the requirements of 3.7.2.

a. Type I

Weight per square yard (ounces):	16 minimum, 17 maximum
Yarns per inch (minimum):	Warp 60, Filling 55
Breaking strength (pounds, minimum):	Warp 58, Filling 46
Weave:	2 up, 1 down right hand twill

b. Type II

Weight per square yard (ounces):	22 minimum, 24 maximum
Yarns per inch (minimum):	Warp 55, Filling 45
Breaking strength (pounds, minimum):	Warp 80, Filling 60
Weave:	3 up, 1 down crowfoot

3.4.7 Cloth, duck, nylon. The nylon duck shall be a bright high tenacity nylon filament of both warp and filling conforming to the physical requirements listed below. The color shall conform to the shade or cable number specified on the applicable specification sheet. Colorfastness shall conform to the requirements of 3.7.2.

Weight per square yard (ounces):	7.25 minimum
Yarns per inch (minimum):	Warp 60, Filling 45
Ply	Warp 2, Filling 2
Breaking strength (pounds, minimum):	Warp 325, Filling 275
Weave:	Plain, 1 up and 1 down

3.4.8 Buckram. The buckram shall be a light, open-weave, single ply fabric conforming to the following physical requirements:

Weight per square yard (ounces):	2.5 minimum
Yarns per inch (minimum):	Warp 40, Filling 20
Breaking strength (pounds, minimum):	Warp 30, Filling 20

3.4.9 Tape. The tape shall be 100% cotton, 3/8 inch (0.95 cm) in width and conform to the physical requirements listed below. The tape shall be black in color. Colorfastness shall conform to the requirements of 3.7.2.

MIL-DTL-3476J

Weight per square yard (ounces):	0.013 minimum
Yarns (minimum):	Face and Back Warp – 37 Binder Warp – 7
Yarns per inch (minimum):	42 yarns per inch (1 yarn per shed) of 20/2 ply, or 84 yarns per inch (2 yarns per shed) of 40/2 ply
Breaking strength (pounds, minimum):	50 warp (full width)

3.4.10 Elastic webbing. Yarn for the elastic webbing shall be 100% cotton. The elastic strands shall be made of compounded natural rubber, synthetic rubber, or a mixture thereof. The color shall conform to the shade or cable number specified on the applicable specification sheet. Colorfastness shall conform to the requirements of 3.7.2. The webbing shall be composed of one ground warp and one elastic warp (with strands wrapped) and one filling. The ground warp shall weave in a two up and two down order and the elastic warp shall weave in such a manner as to be over all the back picks and under all the face picks. The elastic webbing shall meet the following physical requirements:

Width:	1-1/4 inches (3.175 cm) \pm 1/16 inch (0.159 cm)
Thickness:	0.050 inch - 0.65 inch (0.127 cm - 0.165 cm)
Weight per square yard (ounces):	0.54 minimum
Yarns (full width)(minimum):	Ground Warp – 26 Elastic Strands – 14
Yarns per inch (minimum):	52 filling
Elastic strands gage (per inch, maximum fineness):	50

3.4.11 Ink. The ink for marking and stenciling shall be an indelible marking ink. Colorfastness shall conform to the requirements of 3.7.2.

3.4.12 Snap fasteners. Snap fasteners shall be any type brass or steel, pronged ring head type, size 17 ligne with a black or nickel plate finish. Black fasteners shall be used on dark background brassards. Nickel plate fasteners shall be used on white brassards only.

3.4.13 Safety pins. Safety pins shall be 1-1/16 inches (2.699 cm) \pm 1/16 inch (0.159 cm) pin without guard manufactured from brass or stainless steel.

3.4.14 Thread. The cotton thread shall conform to A-A-52094. The size and color shall be as specified on the applicable specification sheet.

3.4.15 Embroidery yarn. The embroidery yarn shall be a semi-dull continuous filament, regenerated cellulose type rayon, two-ply Schiffli type yarn. The yarn shall be 150, 100 or 75 denier as specified on the applicable cartoon or drawing. Unless otherwise specified, the use of two-ply polyester is authorized in lieu of rayon. When polyester yarn is used, 135 denier will be substituted for 150 denier, 90 denier will be substituted for 100 denier, and 70 denier will be substituted for 75 denier rayon.

3.4.15.1 Color. The color of the embroidery yarn shall be as specified on the applicable drawing or cartoon. When overedge stitching is required, the color shall be the same as the embroidered border. The use of sulfur dyes is prohibited (see 3.4.17.1).

MIL-DTL-3476J

3.4.15.2 Matching. The color shall be a good match to the DoD Standard Color Card of Official Standardized Shades for Heraldic Yarns for Embroidery and Ribbons, 1993 Edition, when viewed under filtered tungsten lamps which approximate artificial daylight having a correlated color temperature of 7000 plus or minus 500 K, with illumination of 100 plus or minus 20 foot candles, and under incandescent lamplight at 2300 plus or minus 100 K.

3.4.16 Bobbin yarn. Unless otherwise specified on the applicable specification sheet, the bobbin yarn used in the Schiffli embroidery shall be a continuous multi-filament nylon or two-ply cotton yarn.

3.4.17 Overedge stitching yarn and thread. The yarn and thread used for overedge stitching shall be 600 or 1200 denier multi-filament bright rayon for cover thread (see 3.6.1) and type I, ticket No. 00, 3 ply of A-A-52094 for needle and looper threads.

3.4.17.1 Color. The color of the yarn and thread used for overedge stitching shall be as specified for the embroidered edge on the applicable drawing or cartoon. The use of sulfur dyes is prohibited (see 3.4.15.1).

3.4.18 Fastener tape. The fastener tape shall be commercial type hook and pile tape. The tape shall be the color specified in the applicable specification sheet and shall be stitched to the base in the location shown on drawing B-8-61 (Figure 3) using the thread specified on the specification sheet for appliquéing and stitch type 302 with 10 to 12 stitches per inch.

3.5 Design. Design details shall be as specified in the applicable specification sheet. Unless an exception is specified on the applicable specification sheet, the attaching devices shall be as shown on figure 1 or 2, as applicable. Except where elastic webbing is specified, all Navy, Marine Corps and Coast Guard brassards shall be supplied with two safety pins specified in 3.4.13. The safety pins shall be provided at the top and bottom of each brassard. When embroidery is required on the brassard, the embroidery shall be in accordance with an enlargement or cartoon which, unless otherwise specified (see 6.2), will be furnished by the Government. The finished embroidery shall contain not less than the minimum number of stitches specified on the cartoon.

3.6 Construction. Brassards shall be constructed in accordance with the applicable specification sheets and the requirements specified herein.

3.6.1 Embroidery. Unless otherwise specified on the applicable specification sheet, embroidery shall conform to the requirements for embroidery of shoulder sleeve insignia in MIL-DTL-14652.

3.6.2 Stitches, seams and stitching. Stitches, seams, and stitching shall be in accordance with FED-STD-751. All ends of stitching not caught in seams or other stitching shall be backstitched not less than 1 inch (2.54 cm). Thread breaks shall be backstitched not less than ½ inch (1.27 cm) at each break. Thread tension shall be maintained so there will be no loose stitching and so there shall be equal tension on the top and bottom thread. All thread ends shall be trimmed. The number of stitches per inch, the stitch type and when applicable, the stitching type shall be as specified on the applicable specification sheet. When letters are appliquéed, the stitching shall be located 1/8 inch plus or minus 1/16 inch (0.318 cm plus or minus 0.159 cm) from the edge of the letters. The hems shall have a 1/8 inch (0.318 cm) stitching margin.

MIL-DTL-3476J

3.6.3 Tolerances. Except when otherwise specified on the applicable specification sheet, the following tolerances shall apply for all brassards:

Length	$\pm 1/2$ inch (1.27 cm)
Width	$+ 1/4$ inch (0.635 cm) - 0
Hem	$\pm 1/16$ inch (0.159 cm)
Positioning of snap fasteners <u>1/</u>	$\pm 1/16$ inch (0.159 cm)
insignia centered:	$\pm 1/4$ inch (0.635cm)
Between top and bottom up to	$1/8$ inch (0.318 cm)
Between ends up to	$1/2$ inch (1.27 cm)
Letters centered:	$1/8$ inch (0.318 cm)
Between top and bottom to <u>2/</u>	$1/2$ inch (1.27 cm)
Between ends up to	$\pm 1/8$ inch (0.318 cm)
Appliquéd overall size	$\pm 1/16$ inch (0.159 cm)
Appliquéd width	$\pm 1/2$ inch (1.27 cm)
Stitches per inch	± 2 stitches

1/ Providing there is no excessive bulging when snap fasteners are engaged.

2/ Providing all letters in horizontal rows are visually even.

3.7 Color. The colors of the brassard and threads shall be specified on the applicable specification sheets and shall match the shade indicated by the reference specification as shown in the 10th edition, Standard Color Card of America, the U.S. Army Standard Color Card, the Official colors for Branches, Agencies, etc., or the Department of Defense Standard Shades for Heraldic Yarns for Embroidery and Ribbons, 1993 Edition (see 2.2). When shade standards are specified, the shade samples shall be available from the contracting officer.

3.7.1 Matching. The color shall match the approved standard shade under natural (north sky) daylight or artificial daylight having a color temperature of 7500 degrees Kelvin and shall be a good approximation to the standard shade under incandescent lamplight at 2800 degrees Kelvin.

3.7.2 Colorfastness. The dyed fabric and embroidery yarn shall show good fastness to wet-dry cleaning, crocking, and light for 40 hours, except the black dyed percale shall show fair fastness to crocking.

3.8 Workmanship. The finished brassards shall conform to the quality and grade of product established by this specification. Occurrence of defects shall not exceed the acceptable quality levels.

4. VERIFICATION

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

- a. First article inspection (see 4.3).
- b. Conformance inspection (see 4.4).

MIL-DTL-3476J

4.2 Inspection conditions. Unless otherwise specified, all inspections shall be performed in accordance with the test conditions specified in 4.4.

4.3 First article inspection. Inspection and testing of the first article (see 3.2 and 6.3) shall be made of a completely finished item for all provisions of this specification applicable to the end product examination and tests.

4.4 Conformance inspection. Inspection shall be in accordance with the provisions set forth herein, except where otherwise indicated (see 6.3). Sampling for inspection shall be performed in accordance with ANSI/ASQC Z1.4.

4.4.1 Inspection of components.

4.4.1.1 Testing of components. In addition to the provisions of the subsidiary specifications and drawings, inspection shall be performed on components and materials listed in Table I for the test characteristics shown therein. The testing shall be in accordance with FED-STD-191.

MIL-DTL-3476J

TABLE I. Testing of Components

COMPONENTS	CHARACTERISTICS	REQUIREMENT PARAGRAPH	TEST METHOD	LOT SIZE EXPRESSED	SAMPLE UNIT FOR TESTING
Rayon yarn	Material Identification	3.4.15 or applicable spec sheet	1500, 1510 or 1520	1 cone, spool or tube	1 cone, spool or tube
	Denier	"	4021	"	"
	Twist per inch:	"		"	"
	Single yarn	"	4052	"	"
	Ply yarn	"	4054	"	"
	Colorfastness to:	3.7.2			"
	Wet-dry cleaning	"	5622	"	"
	Crocking	"	5651	"	"
Fabric (Other than buckram)	Light 1/	"	5660	"	"
	Colorfastness to:	3.7.2		1 yard	3 yards
	Wet-dry cleaning	"	5622	"	full width
	Crocking	"	5651	"	"
Buckram	Light 1/	"	5660	"	"
	Laundering for percale only	"	5610	"	"
Buckram	Breaking strength	3.4.8	5100	"	1 yard
	Yard per inch		5050	"	full
	Weave		Visual	"	width

1/ In the event of a dispute resulting from the test with Method 5660, or as a result of suspected anomalous behavior of certain dye types or formulations, the contracting officer may authorize the exposure to natural light in accordance with Method 5662.

4.4.1.1.1 Certification of compliance. Materials listed below may be accepted on the basis of the contractor's certificate of compliance for requirements specified in applicable paragraphs of this specification.

COMPONENTSCHARACTERISTICSREQUIREMENT
PARAGRAPH

Bobbin yarn for
embroidering

Two ply undyed cotton yarn or
continuous filament nylon

3.4.16

4.4.2 Inspection of the end item. Defects found during the inspection shall be classified in accordance with the list shown in 4.4.2.1 and 4.4.2.1.1.

4.4.2.1 Visual inspection of brassards. Examination shall be made at a distance of approximately 16 to 22 inches (40.64 cm to 55.88 cm). The defects found during the examination shall be classified in accordance with 4.4.2.1.1 and 4.4.2.1.2. The sample unit for these examinations shall be one completely fabricated brassard.

MIL-DTL-3476J

4.4.2.1.1 Examination of brassards for visual characteristics. Defects designated by an asterisk (*) shall be classified as major when seriously affecting serviceability or appearance and minor when affecting serviceability or appearance but not seriously.

TABLE II. DEFECTS

EXAMINE	DEFECT	CLASSIFICATION		
		MAJOR	(*)	MINOR
Quality of cloth (tape, background, and letters)	Any component not fabricated of specified material	X		
Color	Color other than specified Off shade	X	*	
Material	Hole, cut, tear, smash or weak place Spots, stains, streaks or shade bars Two or more continuous broken or missing ends or picks Double pick, coarse pick or mispick clearly noticeable Slub, slough-off, float or skip Incorrect number of plies Objectionable odor Not clean	X X X	 * * * *	 X
Stenciling, printing or inking (when applicable)	Marking material used in stenciling or printing adversely affects hand of fabric Design or any part of design omitted Accomplished with incorrect material Poor registration, over printed or feathering Incorrect color Shade variation or uneven penetration of marking material affecting appearance Marking material mottled affecting appearance at 6 feet (1.82 m)	X X X X	 * *	 X
Embroidery (when applicable)	Broken stitches Not applied as specified Design reversed or inverted Design misplaced or in incorrect location Any detail not conforming to applicable cartoon or specification sheet Stitching missing Incorrect color or color arrangement Incorrect shade Stitches out of alignment or not in accord with applicable cartoon or enlargement	 X X X X X X	 * *	

MIL-DTL-3476J

TABLE II. **DEFECTS** (Continued)

EXAMINE	DEFECT	CLASSIFICATION		
		MAJOR	(*)	MINOR
	Closeness and density of stitches not equal to first article sample Float, bunched or tangled yarn Loose tension, resulting in slack, open or loopy appearance Tension too tight affecting appearance		*	
			*	
			*	
			*	
Appliqué (bars, letters, chevrons, cross)	Not applied as specified	X		
	Design reversed or inverted	X		
	Design misplaced or in incorrect direction		*	
	Letter or insignia not neatly trimmed		*	
	Misshapen, distorted, crooked or puckered		*	
	Any letter or brassard part missing	X		
CONSTRUCTION & WORKMANSHIP				
General	Operation omitted	X		
	Operation not accomplished as specified	X		
	Component is not fabricated as specified	X		
	or is not of material specified			
Hem	Not hemmed all around	X		
	Incorrect type of hem	X		
	Hem uneven	X		
Seams, stitches and stitching	Incorrect type of seam, stitches or stitching		*	
	Incorrect color thread		*	
	Row of stitches partially or completely missing	X		
	Incorrect stitching gage or margin			X
	Backstitching omitted	X		
	Ends of stitching not backstitched one inch (2.54 cm) (when not caught in other seams or stitching)		*	
	Thread ends not trimmed on face or back of brassard			X
	Needle chews		*	
	Loose stitch tension resulting in a loosely secured hem or insignia	X		
	More than one skipped stitch		*	
	Stitches per inch exceed tolerance specified			X
	One stitch less than minimum specified			X

MIL-DTL-3476J

TABLE II. **DEFECTS** (Continued)

EXAMINE	DEFECT	CLASSIFICATION		
		MAJOR	(*)	MINOR
	Two or more stitches less than minimum specified	X		
	Overedge stitching not as specified	X		
Open seams	More than 1/4 inch (0.635 cm) but not more than 1/2 inch (1.27 cm) More than 1/2 inch (1.27 cm) NOTE: A seam shall be classified as open when one or more stitches joining a seam are broken or when two or more continuous skipped stitches or run-offs occur. On double stitched seams, a seam shall be considered open when either one or both sides of the seam are open.	X		X
Run-off	See classification of open seam.			
Application of buckram (when applicable)	Missing Edge of buckram not even with edge of insignia Does not reinforce entire design	X X		X
Application of tape loop (when applicable)	Missing Attachment of loop is not accomplished with box stitching or bar tacking Misplaced Loop twisted	X	* *	X
Safety pins (when applicable)	Any missing Not specified size Malformed, misshapen, damaged or otherwise impaired Not constructed as specified Finish shows evidence of corrosion	X X	* *	 X
Snap fastener (when applicable)	Male or female portion missing or broken Male or female portion split Malformed, misshapen, damaged or otherwise impaired Out of alignment or not in location specified Finish does not completely cover fastener Not type finish specified Burr or sharp edge which may cause injury	X X X	* * *	

MIL-DTL-3476J

TABLE II. **DEFECTS** (Continued)

EXAMINE	DEFECT	CLASSIFICATION		
		MAJOR	(*)	MINOR
	Not securely attached	X		
	Will not function as intended	X		
Fastener tape (when applicable)	Missing one or more strips	X		
	Not securely stitched to the base	X		
	Incorrect color	X		
	Incorrect location		*	
	Malformed, damaged or otherwise impaired		*	

4.4.2.1.2 Examination of brassards for dimensions. Any dimension which is not within the specified tolerances shall be classified as a defect.

5. PACKAGING

5.1 Packaging. For acquisition purposes, the packaging requirements shall be as specified in the contract or order (see 6.2). when actual packaging of materiel is to be performed by DoD personnel, these personnel need to contact the responsible packaging activity to ascertain requisite packaging requirements. Packaging requirements are maintained by the Inventory Control Point's packaging activity within the Military Department or Defense Agency, or within the Military Department's System Command. Packaging data retrieval is available from the managing Military Department's or Defense Agency's automated packaging files, CD-ROM products, or by contacting the responsible packaging.

6. NOTES

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

6.1 Intended use. Brassards covered by this specification are intended to be worn on the arm of certain DoD personnel to readily identify that the wearer has a particular job or a temporary duty assignment.

6.2 Acquisition requirements. Acquisition documents must specify the following:

a. Title, number, and date of this specification and the applicable specification sheet (see 1.2).

b. Issue of DoDISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.2).

c. When a first article is required (see 3.2, 4.3, and 6.3).

MIL-DTL-3476J

- d. When a cartoon is required (see 3.5).
- e. Packaging requirements (see 5.1).

6.3 First article. When first article inspection is required, the contracting officer should provide specific guidance to offerors whether the item should be a preproduction sample, a first production sample or a standard production item from the contractor's current inventory as specified in 4.3. The first article should consist of one completed item. The contracting officer should include specific instructions in acquisition documents regarding arrangements for examination, approval of first article test results and disposition of first articles. Invitations for bids should provide that the Government reserves the right to waive the requirement for samples for first article inspection to those bidders offering a product which has been previously acquired or tested by the Government, and that bidders offering such products, who wish to rely on such production or tests, must furnish evidence with the bid that prior Government approval is presently appropriate for the pending contract.

6.4 Armed services medical stock list. This specification includes the requirements for the following items appearing in the Armed Services Medical Stock List:

8455-00-265-4799 - Brassard, Green Cross
8455-00-772-5845 - Brassard, Red Cross

6.5 Subject term (key word) listing.

Arm band

6.6 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.

Custodians:
Army - IH
Air Force - 45
Navy - NU

Preparing activity:
Army - IH

Review activities:
Air Force - 32, 82, 99
Navy - MC
Coast Guard - CG
DLA - CT

(Project No. 8455-0841)

MIL-DTL-3476J

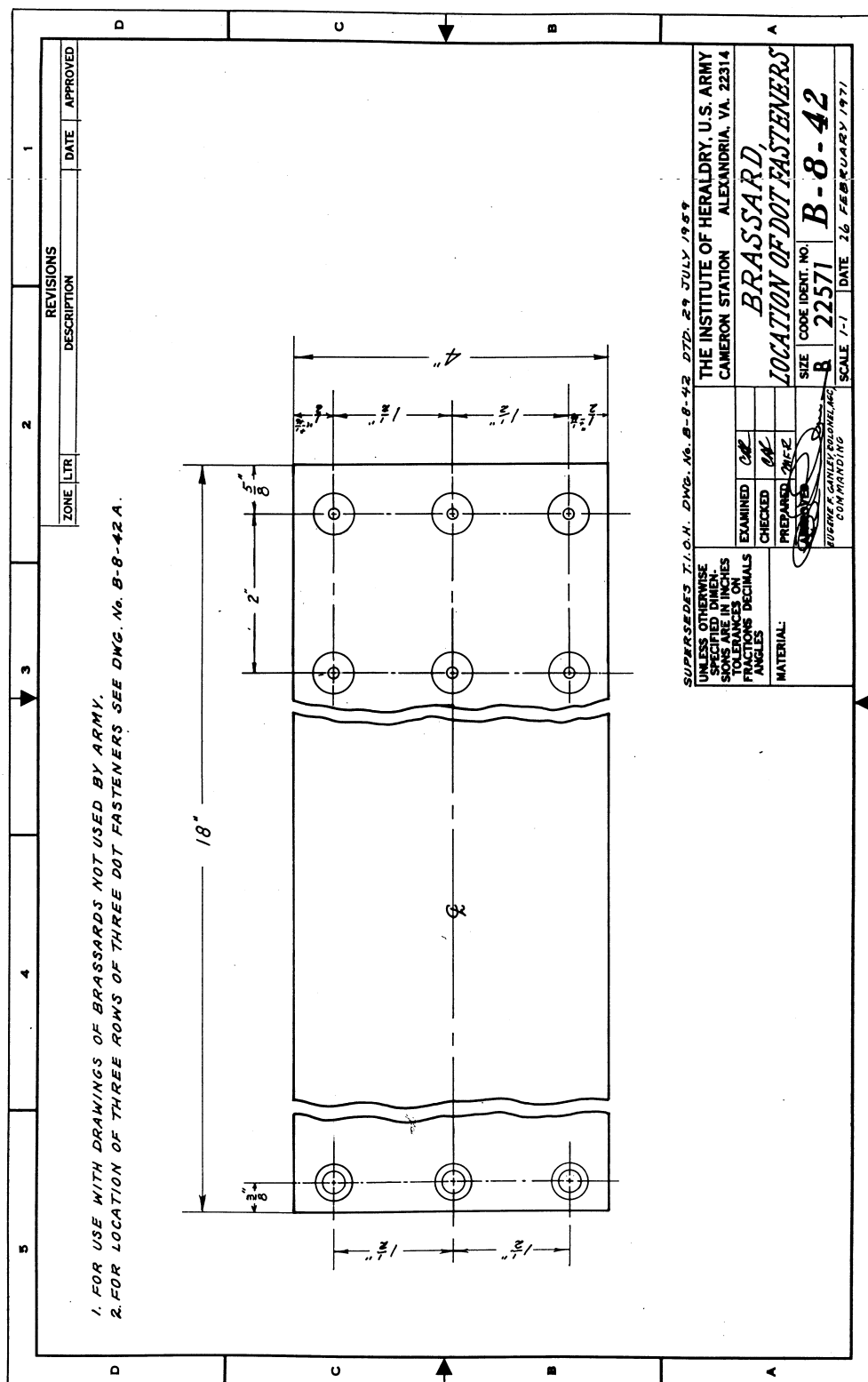


FIGURE 1 - Brassard, location of dot fasteners (2 rows of 3 fasteners)

MIL-DTL-3476J

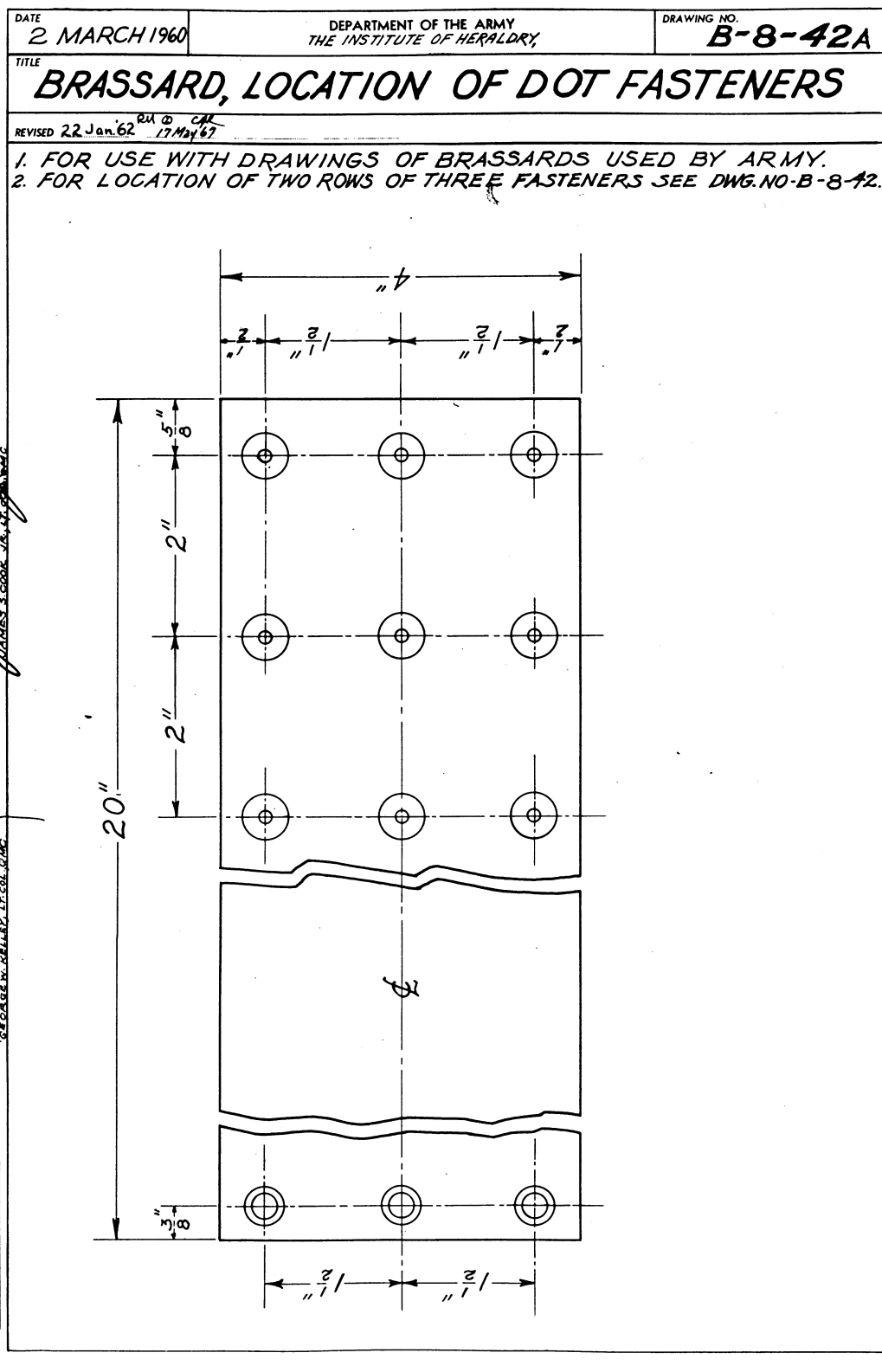


FIGURE 2 - Brassard, location of dot fasteners (3 rows of 3 fasteners)

MIL-DTL-3476J

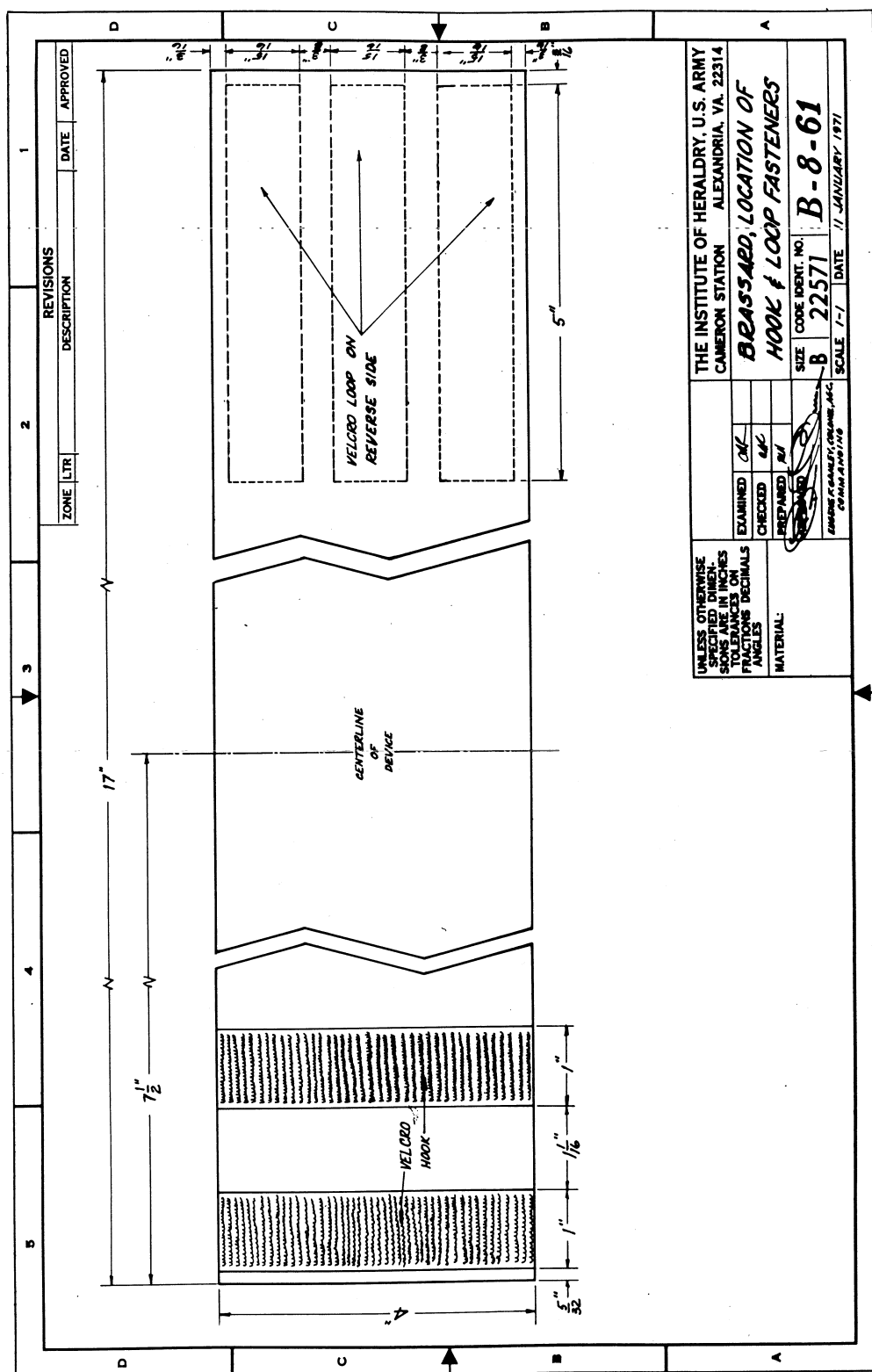


FIGURE 3 - Brassard, location of hook & loop fasteners

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.
3. The preparing activity must provide a reply within 30 days from receipt of the form.

NOTE: This form may not be used to request copies of documents, nor to request waivers, or clarification of 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.

I RECOMMEND A CHANGE:

1. DOCUMENT NUMBER
MIL-DTL-3476J

2. DOCUMENT DATE (YYMMDD)
981021

BRASSARDS, GENERAL SPECIFICATION FOR

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

The Institute of Heraldry, U. S. Army

b. TELEPHONE Include Area Code)

(1) Commercial (2) AUTOVON
(703) 806-4982 656-4982

Technical and Production Division
9325 Gunston Rd., Bldg 1466, Rm S112
Fort Belvoir, VA 22060-5579

Defense Quality and Standardization Office
5203 Leesburg Pike, Suite 1403
Falls Church, VA 22041-3466
(703) 756-2340 DSN: 289-2340