

MIL-G-43755B

17 September 1976

SUPERSEDING

MIL-G-43755A

1 November 1973

MILITARY SPECIFICATION

GLOVES, LEATHER, LINED, BLACK, WOMAN'S

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 requirements for a slip-on, gauntlet style, woman's lined, leather dress glove.

1.2 Classification. The glove shall be one type in the following sizes, as specified (see 6.2):

Schedule of sizes

6 - 6-1/2 - 7 - 7-1/2 - 8 - 8-1/2 - 9 - 9-1/2

2. APPLICABLE DOCUMENTS

2.1 Issues of documents. 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-295	- Thread, Nylon.
KK-L-254	- Leather, Sheepskin, Chrome Tanned.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be used in improving this document should be addressed to: US Army Natick Research and Development Command, Natick, MA 01760, by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

FSC 8445

MIL-G-43755B

- DDD-L-20 - Label; For Clothing, Equipage, and Tentage, (General Use).
- PPP-B-566 - Boxes, Folding, Paperboard.
- PPP-B-636 - Boxes, Shipping, Fiberboard.
- PPP-B-665 - Boxes: Paperboard, Metal Edged and Components.
- PPP-B-676 - Boxes, Setup.
- PPP-T-45 - Tape, Gummed, Paper, Reinforced and Plain, for Sealing and Securing.

STANDARDS

FEDERAL

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

MILITARY

- MIL-STD-129 - Marking for Shipment and Storage.
- * MIL-STD-1613 - Provisions for Evaluating Quality of Gloves, Leather, Dress

(Copies of specifications and standards required by contractor in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless otherwise indicated, the issue in effect on date of invitation for bids or request for proposal shall apply:

NATIONAL MOTOR FREIGHT TRAFFIC ASSOCIATION, INC., AGENT

National Motor Freight Classification

(Application for copies should be addressed to the American Trucking Associations, Inc., Traffic Department, 1616 P Street, N.W., Washington, DC 20036.)

UNIFORM CLASSIFICATION COMMITTEE, AGENT

Uniform Freight Classification

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

MIL-G-43755B

3. REQUIREMENTS

3.1 Samples.

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

3.1.2 Standard sample. The finished dyed glove shall match the standard sample for shade of leather only (see 6.3).

3.2 Materials.

* 3.2.1 Leather. The leather shall be hair sheep conforming to KK-L-254, type A, class 2, subclass 6, except that:

a. The stitch tearing strength shall have a minimum value of 10 pounds.

b. The colorfastness (resistance to rubbing) for the wet and dry crock cloth shall be not lower numerically than Munsell value 7.0.

c. Staining on the test pads shall have an expanded AATCC value of not less than 3; and 2 specimens from each sample unit shall be tested. One sample shall be tested on the grain side and the other specimen shall be tested on the flesh side. A finish shall not be applied to the grain surface.

3.2.1.1 Color. The color of the leather shall be black shade 511 and shall match the standard sample for shade (see 6.3). The color shall be imparted with a developed dye and the dye shall completely penetrate throughout the thickness of the leather. Testing shall be as specified in 4.2.1.

3.2.1.2 Thickness. The thickness of the leather in all parts of the gloves shall be not less than 1-1/4 ounces nor more than 1-3/4 ounces, when measured as specified in 4.2.2. The skins shall be split, buffed, shaved, or skived to produce the required thickness and a smooth clean surface on the flesh side.

* 3.2.2 Cloth, tricot knit (lining). The lining shall be a 2-bar jersey knit tricot fabric (see 6.5) made with a nominal 20 denier multifilament silk yarn. As an alternate to the tricot silk cloth, the lining may be a 2-bar jersey knit tricot (see 6.5) fabric using a nominal 50 denier multifilament rayon yarn for the front bar and a nominal 40 denier multifilament, semi-dull nylon yarn for the back bar. The finished fabric shall conform to the physical requirements specified in table I when tested as specified in 4.2.1.

MIL-G-43755B

* TABLE I. Physical requirements of fabric

Characteristic	Cloth, Silk, Tricot Knit	Cloth, Nylon/Rayon, Tricot Knit
Weight per sq. yd., oz.	1.0 \pm 0.2	2.75 (min)
Wales per inch (min)	50	40
Courses per inch (min)	52	45
Bursting strength, lbs. (min)	20	65

3.2.2.1 Color. The color of the tricot knit fabric shall be Gray 615 and shall match the standard sample.

3.2.2.1.1 Matching. The color shall match the standard sample under artificial daylight having a color temperature of 7500° Kelvin and shall be a good approximation to the standard sample under incandescent lamplight at 2800° Kelvin.

3.2.2.1.2 Colorfastness. The dyed finished fabric shall show fastness to perspiration and crocking equal to or better than the standard sample. When no standard sample is available, the dyed finished fabric shall show "good" fastness to perspiration and shall show a Munsell value for crocking not lower than 8.5 when tested as specified in 4.2.1.

3.2.3 Thread. The thread used for seaming shall be nylon thread conforming to type I, class 1 of V-T-295. Thread sizes A and B, 3 ply shall be used as indicated in table II. The thread shall be dyed to match Black AA, C.A. 66043 and shall show colorfastness to light equal to or better than the standard sample (see 6.3). When no standard sample is available, the dyed thread shall show "good" fastness to light.

3.3 Identification and size marking. Each glove shall have a combination identification and size label conforming to type III or IV, class 4 of DDD-L-20, except that the marking medium shall be a contrasting color to that of the lining and the label shall show "good" fastness of marking to transference when tested as specified in DDD-L-20. The line, "Certified Table Cut" shall be added at end of label. The label shall be applied to the lining on the inside of the back of the glove at center, $3/4 \pm 1/8$ inch down from the top edge. The item description for use on the label shall be as follows:

"GLOVES, LEATHER, LINED, BLACK, WOMAN'S"

* 3.4 Design. The gloves shall be a lined, leather slip-on type with double stitched pique sewn-in Bolton thumb, shoulder fourchettes, pique sewn back of fingers, inseam sewn front of fingers and side seam, with a machine sewn hem.

MIL-G-43755B

3.5 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 govern.

3.6 Patterns. Standard patterns for the leather components of the glove only, will be furnished by the Government. The standard patterns shall not be altered in any way and are to be used as a guide for making the contractor's working patterns or dies. The working patterns or dies shall be identical to the standard patterns.

3.7 Stitches, seams and stitching. Stitch, seam and stitching types specified in table II shall conform to FED-STD-751. Whenever two or more methods, seams, or stitches are given for the same part of the operation, any one of them may be used. The minimum and maximum number of stitches per inch shall be as specified in table II. Seam allowances for all operations shall be 1/16 to 3/32 inch. The use of sewing machines with trimmer attachments is prohibited. Where required, thread ends shall be trimmed to not less than 1/4 inch nor more than 5/8 inch.

3.8 Cutting. The gloves shall be table-cut by a qualified table cutter and shall show the stamp of the qualified table cutter. There shall be a full leather allowance of 1-1/2 inches (American) for each trunk. Flares shall contain 1-5/16-inch allowance on each side of the trunk and shall begin on a line 3/4 inch below the top of the thumb gouge. The finished top shall be as specified in table III. Thumbs and fourchettes shall have full leather allowance well pulled in. Before the integral portions of the glove are cut, the skins shall be examined on both sides and all weak places eliminated, sorted for shade and weight and properly dampened.

3.8.1 Hand and thumb. The hand and thumb shall be cut in trunk form. The trunk shall be made by pulling the skin evenly and to its limit either in length or width. When its full capacity has been determined by careful measurement, the skin is cut. Each section, either when cut lengthwise or crosswise, is widened out in correct proportion, and each trunk, after being carefully measured, is cut individually and exactly to measurement. Each trunk is paired and matched, then folded in the center and pulled down to the pattern to insure that it will lie straight and fit the hand properly when finished. Each trunk is spudded, trimmed and paired. Each thumb is cut separately, first being cut in length or width, then widened out. The required amount of leather is measured in and matched to the thumb pattern precisely the same as the glove trunk, spudded, trimmed and paired. Prior to cutting out the parts, the lining shall be pasted to individual parts. After this operation, the parts shall be cut out as required.

MIL-G-43755B

3.8.2 Fourchette. Fourchettes for each pair, containing approximately the same amount of leather and matched in color, are punched on the block in the lengthwise direction of the pulled leather.

3.8.3 Match marking. Thumbs and fourchettes from each pair of trunks shall be bundled, and matchmarked with the trunks to insure that the proper size and shade fittings shall correspond to the trunks.

3.9 Construction. The gloves shall be made by and with the use of all operations listed in table II. The contractor is not required to follow the exact sequence of operations listed.

MTL-G-43755B

NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN or LOOPER	COVER
1.	<u>Pasting of lining.</u> The lining shall be pasted to the back of the hand (front and back) back of fingers and thumb prior to slitting. The fourchettes are not lined. The adhesive is not to show through the lining (see 6.4).						
2.	<u>Slitting.</u> A pile of six trunks or less (with lining attached) of one size shall be placed upon the corresponding size steel pattern and pressed against a block and through the trunks.						
3.	<u>Attach thumb.</u> The pipe shall be stitched and the thumb inserted into the gouge of the hand and pique sewn with double stitching, 1/16 + 1/32 inch gauge, outer stitching 1/16 to 3/32 inch from the raw edge. The starting and ending stitches shall be tied and trimmed on the inside of the glove or backstitched.	401	LSa-2	9-11	B	A	
4.	<u>Join fourchette sections.</u> Join fourchette sections for each glove with pique sewing at base of fingers, 1/16 to 3/32 inch from raw edge.	401	LSa-1	9-11	B	A	
5.	<u>Join fourchette sections to fingers and close side seam.</u> a. Pique sew the back of the fingers to the fourchette sections with the longest side starting at the back of the finger crotch. The stitching shall be 1/16 to 3/32 inch from the raw edge.	401	LSa-1	9-11	B	A	

MIL-G-43755B

NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II (cont'd)	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	BOBBIN or LOOPER	COVER
5.	<p><u>Join fourchette sections to fingers and close side seam.</u> (cont'd)</p> <p>b. Inseam the front of the fingers to the fourchette sections, simultaneously closing the side seam of the glove. Check while stitching to insure that the curved tops of each finger are even and that the base of each finger meets at the gore. The starting or ending stitches of the index finger shall be either tied and trimmed on inside of glove or backstitched.</p>	301	SSa-1	9-11	B	B	
6.	<p><u>Hemming (top of glove).</u></p> <p>The top of the glove is to be folded in $1/2 + 1/16$ inch and stitched $1/16$ to $3/32$ inch from raw edge.</p>	301	SSbc-1	9-11	B	B	
7.	<p><u>Trimming.</u></p> <p>Fourchettes shall be trimmed at the top to provide for neat fit and shall conform with the shape of the fingers. All seams and excess fourchette leather shall be uniformly hand trimmed.</p>						
8.	<p><u>Forming.</u></p> <p>The gloves shall be dampened, layed-off on steam or electrically heated boards to proper shape and appearance. Fourchettes shall be folded to give a flat effect to the glove.</p>						

MIL-G-43755B

NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II (cont'd)	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN or LOOPER	COVER
9.	<p><u>Brushing.</u></p> <p>Each glove, after forming, shall be thoroughly plushed, or polished on a rag wheel to bring out the full luster of the leather.</p>						
10.	<p><u>Pairing.</u></p> <p>The gloves shall be matched, paired and tacked together with thread at the closing seam 1/2 inch to 1 inch from the finished top. Tacking shall be done with not less than two stitches, using a ply thread which will permit the gloves to be pulled apart without tearing the leather.</p>						

MIL-G-43755B

3.10 Measurement. The finished glove shall conform to measurements shown in table III.

TABLE III. Finished measurements

Size	Length from tip of middle finger to top of cuff	Width: measur- ing 1/4 inch below where third and little fingers join	Stretch across glove where third and little fingers join (minimum)	Stretch across pipe of thumb (mini- mum)	Finished top meas- ured from thumb gouge to finished top of glove	Width of finished hemmed top of glove
	<u>Inches</u>	<u>Inches</u>	<u>Inch</u>	<u>Inch</u>	<u>Inches</u>	<u>Inches</u>
6	10-1/4	3	5/8	1/4	3	4
6-1/2	10-1/2	3-1/8	5/8	1/4	3	4-1/8
7	10-5/8	3-1/4	3/4	1/4	3	4-1/4
7-1/2	10-3/4	3-3/8	3/4	5/16	3	4-3/8
8	10-7/8	3-1/2	3/4	5/16	3	4-1/2
8-1/2	11	3-5/8	3/4	5/16	3	4-5/8
9	11-1/8	3-3/4	3/4	5/16	3	4-3/4
9-1/2	11-1/4	3-7/8	3/4	5/16	3	4-7/8
Tol- erance	+1/4 -1/8	± 1/8	-	-	+1/4 -1/8	± 1/8

3.11 Workmanship. The finished gloves shall conform to the quality and grade of product established by this specification.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

MIL-B-12570D

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

4.2 Quality conformance inspection.

4.2.1 Component and material inspection. In accordance with 4.1 above, components and materials shall be inspected in accordance with all the requirements of referenced specifications, drawings, and standards unless otherwise excluded, amended, modified or qualified in this specification. In addition to testing provisions combined in subsidiary specifications, drawings or standards, testing shall be performed on components listed in table IV for characteristics noted. Unless otherwise indicated, testing shall be conducted in accordance with FED-STD-191. All test reports shall contain the individual values used in expressing the final result. The sample unit of the cloth shall be one continuous yard, full width. The lot shall be unacceptable if one or more sample units fail to meet any of the test requirements specified. The lot size and sample size shall be in accordance with the following:

<u>Lot size</u>	<u>Sample size</u>
800 or less	2
801 to 22,000 inclusive	3
22,001 and over	5

TABLE IV. Component testing

<u>Component</u>	<u>Characteristic</u>	<u>Require- ment paragraph</u>	<u>Test method</u>
Leather	Developed dye	3.2.1.1	<u>1/</u>
Cloth, tricot knit (lining)	Material identification	3.2.2	<u>1/</u>
	Type of knit	3.2.2	Visual <u>1/</u>
	Denier (size of yarn)	3.2.2	<u>1/</u>
	Weight	3.2.2	5041
	Wales per inch	3.2.2	5070
	Courses per inch	3.2.2	5070
	Bursting strength	3.2.2	5120
	Colorfastness to:		
	Perspiration	3.2.2.1.2	5680
	Crocking	3.2.2.1.2	5651

1/ Unless otherwise specified, a certificate of compliance is required and will be acceptable for the stated requirement.

MIL-G-43755B

4.2.2 In-process inspection. In-process inspection will be performed during manufacturing of the gloves to determine compliance with all required operations and processes which cannot be determined in the completely fabricated gloves. The cut leather parts (before pasting of lining to leather), i.e., thumb, front, back and fourchettes before fabrication shall be tested for thickness. Any part that is not within the required thickness range specified in 3.2.1.2 shall constitute a defect. Thickness shall be determined in accordance with Method 1011 of FED-STD-311. The sample unit for this testing shall be one cut part. The lot for in-process inspection shall be expressed in terms of one cut part. The inspection level shall be S-3 and the acceptable quality level (AQL) shall be 4.0 test failures per hundred units. Any deviation found in the in-process inspection may be cause for rejection of the item or items.

4.2.3 End item examination. Sampling and examination of the end item shall be performed in accordance with the provisions of MIL-STD-1613.

5. PACKAGING

5.1 Preservation-packaging. Preservation-packaging shall be level A or C as specified (see 6.2).

5.1.1 Level A.

5.1.1.1 Unit packaging. Each pair of gloves shall be inserted in an end opening flat style clear polyethylene bag of 0.00125 inch thickness (± 25 percent tolerance). The polyethylene bag shall be formed with heat sealed seams that are straight, continuous, and parallel to each other and the formed edges of the bag. The bag may be fabricated from polyethylene film tubing or sheeting. The bag shall be not less than one inch greater in length than the gloves. The unsealed opening shall be at the smaller dimension of the bag.

5.1.1.2 Intermediate packaging. Ten pairs of gloves of one size only, unit packaged as specified in 5.1.1.1, shall be packaged flat within a folding paperboard box made of 0.045-inch thick kraft-lined (inside and outside) chipboard conforming to variety 1, style III, type G, class I, group I of PPP-B-566; set-up paperboard box made of 0.048-inch thick non-bending paperboard conforming to type I, variety 1, class A, style 4 of PPP-B-676; or metal-edged paperboard box conforming to class 1, style A of PPP-B-665. Inside dimensions of each paperboard box shall be 12-inches in length, 5-1/2 inches in width and 2-1/2 inches in depth. Closure of boxes shall be effected with 2-inch minimum width gummed paper tape conforming to type III, grade A of PPP-T-45, applied across lengthwise seams extending along the bottom and up the sides at least 2 inches.

MIL-G-43755B

5.1.2 Level C. Gloves shall be packaged to afford adequate protection against physical damage during shipment from the supply source to the first receiving activity. The contractor may use his standard practice when it meets this requirement.

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

5.2.1 Level A packing. One hundred and fifty pairs of gloves of one size only, preserved-packaged as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC, grade V2s of PPP-B-636. Level A boxed gloves shall be packed flat three in length, one in width and five in depth within the shipping container. Inside dimensions of each shipping container shall approximate 17-1/2 inches in length, 13 inches in width, and 13 inches in depth. Approximate dimensions are furnished as a guide only. Each fiberboard container shall be closed in accordance with method III, waterproofed in accordance with method V and reinforced as specified in the appendix of PPP-B-636. Toward the end of the contract or when there are less than the required amount per container of the same size, mixed sizes may be packed within the same shipping container.

5.2.2 Level B packing. One hundred and fifty pairs of gloves of one size only, preserved-packaged as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC, type CF (variety SW) or SF, class domestic grade 200 of PPP-B-636. Level A boxed gloves shall be packed flat, three in length, one in width, and five in depth within the shipping container. Inside dimensions of the fiberboard shipping container shall approximate 17-1/2 inches in length, 13 inches in width, and 13 inches in depth. Approximate dimensions are furnished as a guide only. Each shipping container shall be closed in accordance with method II as specified in the appendix of PPP-B-636. Toward the end of the contract or when there are less than the required amount per container of the same size, mixed sizes may be packed within the same shipping container. When specified (see 6.2), the fiberboard shipping container shall be a grade V3c, V3s or V4s fiberboard box fabricated in accordance with PPP-B-636 and closed in accordance with method III as specified in the appendix of the container specification.

5.2.3 Level C packing. Gloves, packaged as specified in 5.1, shall be packed in a manner to insure carrier acceptance and safe delivery at destination at the lowest transportation rate for such supplies. Containers shall be in accordance with Uniform Freight Classification or National Motor Freight Classification, as applicable.

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

MIL-G-43755B

5.3.1 Polyethylene bagged packages. Polyethylene bagged packages shall have the required identification information legibly printed or stamped in yellow directly on the bag across the center face or on a white paper label inserted within the bag so as to permit ready identification.

5.3.2 Labels, mixed sizes. Each shipping container, packed with mixed sizes only 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 stamped or printed the correct quantity of pairs and sizes contained therein.

6. NOTES

6.1 Intended use. The gloves are intended for use by female personnel of the Department of Defense.

6.2 Ordering data. Procurement documents should specify the following:

- (a) Title, number and date of this specification.
- (b) Size required (see 1.2).
- (c) Selection of applicable levels of preservation-packaging and packing (see 5.1 and 5.2).
- (d) When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).

6.3 Samples. For access to samples, address the procuring office issuing the invitation for bids.

6.4 A Karaya gum paste was used for holding the lining to the leather while the glove was being fabricated.

6.5 Knitting machine. The fabric (see 3.2.2) was knitted on a 28 gauge, 2 guide bar tricot machine.

6.6 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 was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous issue.

MIL-G-43755B

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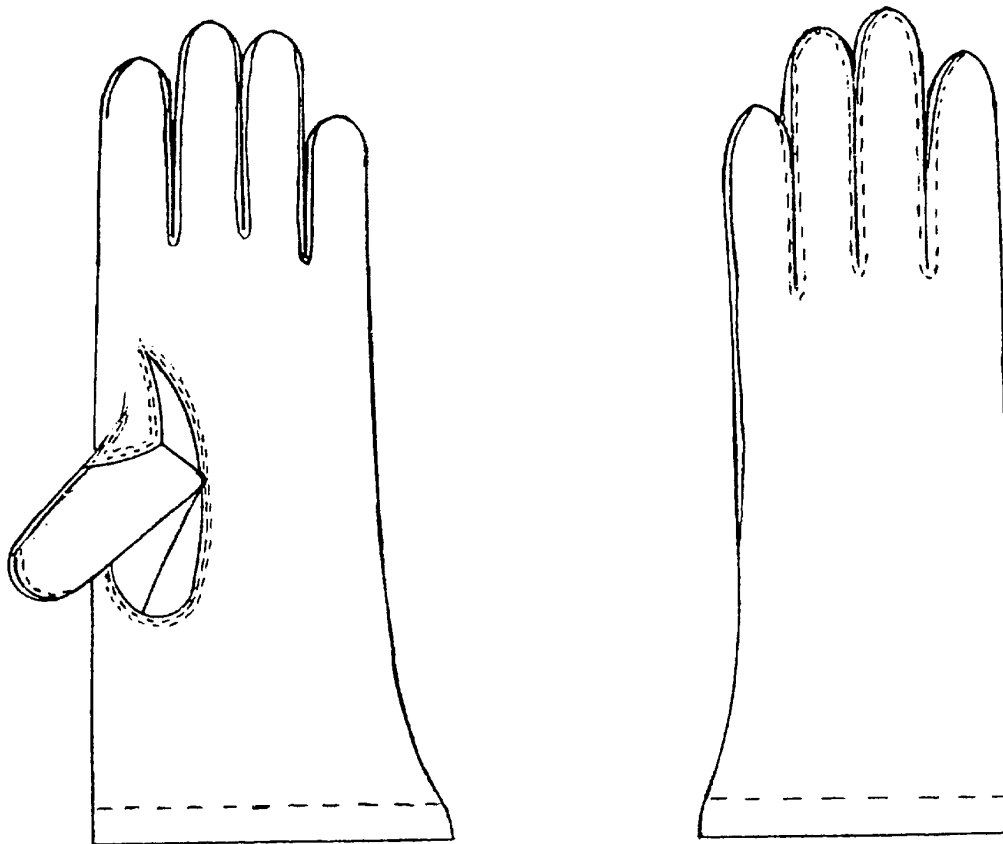
Army - GL
Navy - SA
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Preparing activity:

Army - GL
Project No. 8445-0059

Review activities:

Army - MD
Air Force - 99
DSA - CT



FACE

BACK

*FIGURE 1 GLOVES, LEATHER, LINED,
BLACK, WOMAN'S*

2-1-1075B

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