

MIL-L-15040F

26 May 1972

SUPERSEDING

MIL-L-15040E

1 November 1965

## MILITARY SPECIFICATION

### LABELS, GARMENT (WOVEN, RAYON)

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 of woven rayon garment labels for clothing items (see 6.1 and 6.4).

1.2 Classification.- The rayon woven labels shall be of one type in the sizes specified below (see 6.2).

Size A - 1-5/16 inches wide by 3 inches long.

Size B - 3/4 inch wide by 2 inches long.

Size C - 2-1/4 inches wide by 4 inches long.

Size D - 2-1/4 inches wide by 5 inches long.

#### 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

PPP-B-566	-	Boxes, Folding, Paperboard.
PPP-B-636	-	Boxes, Shipping, Fiberboard
PPP-B-676	-	Boxes, Setup.
PPP-T-45	-	Tape, Gummed, Paper, Reinforced and Plain, for Sealing and Securing.

FSC 8315

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STANDARDS

MILITARY

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

FEDERAL

- FED-STD-191 - Textile Test Method.

2.2 Other publications.- The following documents form a part of this specification to the extent specified herein. Unless a specific issue is identified, 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., Tariff Order Section, 1616 P Street, N. W., Washington, D.C. 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, Illinois 60606.)

3. REQUIREMENTS

3.1 Standard sample.- The labels shall match the standard sample for shade, and shall be equal to or better than the standard sample with respect to all characteristics for which the standard sample is referenced (see 6.3).

3.2 Material.-

3.2.1 The labels shall be woven of filament rayon of the regenerated cellulose type (viscose or cuprammonium) in the denier specified.

3.3 Construction.-

3.3.1 The labels shall be woven with the following construction in a taffeta and figured weave when tested as specified in 4.2.5.

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<u>Characteristic</u>	<u>Approximate yarn size</u>	<u>Texture</u>
Ground warp	100 denier singles or 50 denier, 2 ply	144 ends per inch (minimum)
Ground filling	75 denier singles or 100 denier singles	92 picks per inch (min) 84 picks per inch (min)
Figure filling	150 denier singles	84 picks per inch (minimum)
Selvages (sizes A and B)	100 denier singles or 50 denier, 2 ply or 150 denier singles	8 double ends each selvage  8 single ends each selvage
Selvages (sizes C and D)	100 denier singles or 50 denier, 2 ply	12 double ends each selvage

- \* 3.4 Color.- The background and selvages shall be Shade Black 211 and the design and legends shall be white to match the standard shade sample. The use of dyes and compounds containing elementary or labile sulfur capable of oxidation to sulfuric acid is prohibited. The dyestuffs shall be chosen and applied so that the dyed and finished label shall show no more labile sulfur than shown by the standard sample when tested as specified in 4.2.5.

3.4.1 Matching.- The color of the labels shall match the standard sample under natural (north sky) daylight or 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.

3.4.2 Colorfastness.- The labels shall show color fastness to wet drycleaning and perspiration equal to or better than the standard sample when tested as specified in 4.2.5. When no standard sample is available or when the standard sample is not referenced for colorfastness, the labels shall show "good" color fastness to wet drycleaning and perspiration when tested as specified in 4.2.5.

- \* 3.5 Size.- The size shall be as specified (see 1.2 and 6.2). A tolerance of minus 1/16 inch and plus 3/16 inch in length and width shall be permitted on the size specified.

3.6 Design and legend.- The design and the legend of the labels including the size characters shall be specified in the end item specification or procurement document (see 6.2).

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3.7 Workmanship.- The finished label shall conform to the quality and grade of product established by this specification, and the occurrence of defects shall not exceed the applicable acceptable quality levels.

#### 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.- Sampling for inspection shall be performed in accordance with MIL-STD-105, except where otherwise indicated hereinafter.

- \* 4.2.1 Component and material inspection.- In accordance with 4.1 above, components and materials shall be tested in accordance with all the requirements of referenced specifications, drawings and standards unless otherwise excluded, amended, modified or qualified in this specification or applicable purchase documents.

4.2.2 Examination of the end item for visual defects.- Defects found during this examination shall be scored in accordance with the defects listed in table I regardless of their proximity to each other, except where two or more defects represent a single local condition, in which case only one defect shall be counted. The sample unit for this examination shall be one label. The lot size shall be expressed in units of one label each. The AQL for this examination shall be 2.5 defects per 100 units (labels). The sample size shall be in accordance with inspection level I. A maximum of twenty-five (25) labels shall be examined from each package in the sample.

TABLE I.- Visual defects


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Cut, hole or tear.  
 Broken end.  
 Design or legend incomplete, illegible, incorrect or distorted.  
 Label misshapened or distorted.  
 Selvage cut, torn, broken, loopy, stringy or tight to an extent causing puckering.  
 Hard crease.  
 Spot, stain or discoloration. 1/  
 Background and selvage black not matching approved shade standard.  
 Fold mark, where required, omitted or misplaced.  
 Objectionable odor.  
 Hook, needle or card mark - affecting legibility.  
 Slack end forming loops on surface. 1/  
 Tight end. 1/

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1/ Clearly visible at normal inspection distance (approximately 3 feet).

4.2.3 Examination for measurement. - The labels shall be examined for the defects listed in table II. The sample unit for this examination shall be one label. The sample size shall be in accordance with inspection level S-2. The acceptable quality level (AQL) for this examination shall be 4.0 defects per 100 units (labels).

TABLE II.- Defects of measurement


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Size of label	Any dimension not within specified tolerances.
Characters	Size not as specified in end item specification or procurement document.

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4.2.4 Examination of preparation for delivery requirements. - An examination shall be made to determine that the packaging, packing and marking complies with the section 5 requirements. 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 closed. 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 S-2 and the AQL shall be 2.5 defects per 100 units.

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ExamineDefectMarking (exterior  
and interior)Omitted, incorrect, illegible, of improper  
size, location, sequence, or method of  
application.

Materials

Any component missing or damaged, or not as  
specified.

Workmanship

Inadequate application of components, such as:  
incomplete closure of container flaps, loose  
strapping, improper taping, or inadequate stapling.  
Bulging or distorted container.

Content

Number of labels per package is more or less than  
specified. 1/

Weight

Weight of contents of shipping container exceeds  
maximum specified.1/ One package from each shipping container in the sample shall  
be examined for this defect.

- ★ 4.2.5 Testing of the end item.— The methods of testing specified in  
FED-STD-191 wherever applicable, and as listed in table III, shall be followed.  
The physical and chemical values specified in Section 3 apply to the average  
of the determinations made on a sample unit for test purposes as specified  
in the applicable test methods. All test reports shall contain the individual  
values utilized in expressing the final results. The sample size shall be in  
accordance with inspection level S-1. The acceptable quality level (AQL) for  
each characteristic shall be 6.5 test failures per 100 units. The sample unit  
for test purposes shall be eight finished labels. The lot size shall be  
expressed in units of one label each.

★ TABLE III.— Test methods

Characteristic	Requirement paragraph	Test method
Identification of Rayon	3.2.1	1500 or 1520 <u>1/</u>
Weave	3.3.1	Visual <u>2/</u>
Texture:		
Warp	3.3.1	5050
Filling	3.3.1	5050
Selvage	3.3.1	5050
Colorfastness to:		
Wet drycleaning	3.4.2	5622
Perspiration	3.4.2	5680
Presence of labile sulfur	3.4	2020

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

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2/ One determination shall be made per sample unit and results reported as "pass" or "fail".

5. PREPARATION FOR DELIVERY (Applicable to direct Government Procurement only).

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

- \* 5.1.1 Level A.- Five hundred (+ 10) identical labels shall be packaged in a snug-fitting paperboard box conforming to variety 1, style III, type G, class 1 of PPP-B-566; or type I, variety 1, class A, style 3 or 4 of PPP-B-676. Thumb notch requirements shall be optional. The box closure shall be secured with gummed paper tape conforming to type III, grade A of PPP-T-45.
- \* 5.1.2 Level C.- Labels shall be packaged to afford adequate protection against deterioration and physical damage during shipment from the supply source to the first receiving activity. The supplier may use his standard practice when it meets these requirements.

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

5.2.1 Level A.- Identical labels of one size only, packaged as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC, grade V3c or V3s of PPP-B-636. Each container shall be closed, waterproofed and reinforced in accordance with the appendix of the container specification. The weight of the contents of each shipping container shall not exceed 65 pounds.

5.2.2 Level B.- Identical labels of one size only, packaged as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC, type CP (variety SW or SF), class domestic, grade 275 of PPP-B-636. Each container shall be closed in accordance with method II as specified in the appendix of the container specification. The weight of the contents of each shipping container shall not exceed 65 pounds.

5.2.2.1 When specified (see 6.2) the shipping container shall be a grade V3c or V3s fiberboard box fabricated in accordance with PPP-B-636 and closed in accordance with the appendix of the container specification.

5.2.3 Containers shall be in accordance with Uniform Freight Classification Rules, or National Motor Freight Classification Rules, as applicable.

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

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## 6. NOTES

6.1 Intended use.- The labels covered by this specification are intended for use in dress clothing items where they will be permanently visible and the use of another type label would adversely affect the appearance of the item.

6.2 Ordering data.- Procurement documents should specify the following:

- (a) Title, number and date of this specification.
- (b) Size required (see 1.2 and 3.5).
- (c) Design and legend to be printed on labels (see 3.6).
- (d) Selection of applicable levels of packaging and packing (see 5.1 and 5.2).
- (e) When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).

6.3 Standard sample.- For access to the standard sample, address the procuring office issuing the invitation to bid.

6.4 Types of labels and use.- In order to keep the number of sizes of labels to a minimum and in the interest of standardization, it is Department of Defense policy to adhere as closely as possible to the following when procuring labels for a specific use and when specifying the type of labels to be utilized in an end item specification:

(a) All combat and utility clothing shall utilize type I, class 1, 2 or 3 labels of DDD-L-20 with the exception of cotton shirts as noted in "d".

(b) Dress clothing will utilize type I, class 1, 2 or 3 labels of DDD-L-20 with the exception of cotton shirts as shown in "d" below. Woven labels as specified herein may be utilized for size and instruction labels on dress items, but only where they are permanently visible and the use of another type of label would adversely affect the appearance of the item.

(c) All trousers will utilize the type I, class 1, 2 or 3 labels of DDD-L-20.

(d) Cotton shirts, gloves, and miscellaneous items will utilize the type III and IV labels of DDD-L-20 (on shirts the size and stock number will be printed on the collar and the identification label shall be printed on the left side of the tail). For Army purchase only, type I or IV will be utilized on these items.

(e) All woolen items, synthetic, or blends of synthetics and knitted items shall utilize type I labels of DDD-L-20 or woven labels as noted in "b" above for dress items.

(f) Hats and neckwear will utilize type I, class 4 labels of DDD-L-20, when possible.



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(g) Type IV labels of DDD-L-20 shall be utilized for identification labels for equipage.

(h) Type II labels of DDD-L-20 shall be utilized for identification labels for tentage.

(i) Special markings such as the "US" on tentage and equipage will normally utilize the type IV label of DDD-L-20.

6.5 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 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.

Custodians:

Army - GL  
Navy - SA  
Air Force - 11

Preparing activity:

Army - GL  
Project No. 8315-0156

Review activities:

Navy - MC  
Air Force - 82

User activity:

Army - MR

SPECIFICATION ANALYSIS SHEET		Form Approved Budget Bureau No. 22-R255
<b>INSTRUCTIONS:</b> 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. Comments and suggestions submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or serve to amend contractual requirements.		
<b>SPECIFICATION</b> Labels, Garment (Woven, Rayon) MIL-L-1504OF		
<b>ORGANIZATION</b>		
<b>CITY AND STATE</b>		<b>CONTRACT NUMBER</b>
<b>MATERIAL PROCURED UNDER A</b> <input type="checkbox"/> DIRECT GOVERNMENT CONTRACT <input type="checkbox"/> SUBCONTRACT		
<b>1. HAS ANY PART OF THE SPECIFICATION CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE?</b> <b>A. GIVE PARAGRAPH NUMBER AND WORDING.</b>		
<b>B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES</b>		
<b>2. COMMENTS ON ANY SPECIFICATION REQUIREMENT CONSIDERED TOO RIGID</b>		
<b>3. IS THE SPECIFICATION RESTRICTIVE?</b> <input type="checkbox"/> YES <input type="checkbox"/> NO (If "yes", in what way?)		
<b>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)</b>		
<b>SUBMITTED BY (Printed or typed name and activity - Optional)</b>		<b>DATE</b>

DD FORM 1426

REPLACES EDITION OF 1 OCT 64 WHICH MAY BE USED.

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