

MIL-M-18203C(NU)  
23 April 1982  
SUPERSEDING  
MIL-M-18203B(SEA)  
29 November 1961

## MILITARY SPECIFICATION

### MITTEN SHELLS (MEN'S AND WOMEN'S)

This specification is approved for use by the Navy Clothing and Textile Research Facility, Department of the Navy, and is available for use by all Departments and Agencies of the Department of Defense.

#### 1. SCOPE

1.1 Scope. This specification covers the requirements for leather work mitten of one type and size only, used by Naval personnel.

#### 2. APPLICABLE DOCUMENTS

\*2.1 Issue 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-276 - Thread, Cotton

##### MILITARY

MIL-B-543 - Buckle, Tongueless and Web Strap  
MIL-B-17757 - Box, Shipping, Fiberboard (Modular Sizes)  
MIL-L-40051 - Leather, Cattlehide for Glove Leather  
MIL-T-43566 - Tape Textile, Cotton, General Purpose, Natural or in Colors

#### STANDARDS

##### FEDERAL

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

Beneficial comments (recommendations, additions, and deletions) and any pertinent data which may be of use in improving this document should be addressed to: Officer in Charge, Navy Clothing and Textile Research Facility, 21 Strathmore Road, 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.

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## MILITARY

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

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

## \* LAWS AND REGULATIONS

### U. S. POSTAL SERVICE MANUAL

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

2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless otherwise indicated, the issues 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 American Trucking Association, Attn: 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, ILL 60606).

## 3. REQUIREMENTS

\*3.1 Guide sample. Samples when furnished, are solely for guidance to the contractor. Variations from this specification may appear in the sample, in which case this specification shall govern.

\*3.2 First article. When specified, the contractor shall furnish a sample unit(s) for first article approval (see 6.2).

### 3.3 Materials.

\*3.3.1 Leather. The leather used for the mitten shall be full grain chrome tanned cowhide bends conforming to type II, class b of MIL-L-40051 and to the physical and chemical requirements of Table I. The color of the leather shall be cream and there shall be no requirement for colorfastness.

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Table I - Physical and chemical requirements 1/

	Minimum	Maximum
Chromic oxide (percent)	3.0	-
Chloroform extract (percent)	12.0	-
Ash (percent)	-	8.0
pH	3.5	-
Shrinkage (temperature C)	96°	-
Flexibility (percent)	-	150
Stiffness (pounds)	-	.20
Tensile strength (pounds/sq. inch)	-	2000
Elongation at 15 pounds load (percent)	25	-
Stitch tearing strength (pounds)	32	-

1/ Chemical Requirements Dry basis

\*3.3.2 Thread, cotton. The cotton threads shall be unbleached and shall conform to type 1A1, 4 ply of V-T-276. The ticket number for the closing thread shall be 16.

\*3.3.3 Loop and buckle strap. The loop and buckle strap shall be leather as specified in 3.3.1 or 5/8 inch tape conforming to type I, Class 1 or 3 of MIL-T-43566. The tape may be water repellent treated and when Class 3 is used, the color shall be olive drab.

3.3.4 Buckles. The buckles shall be steel, 5/8 inch, double bar, tongueless, lip type II, style 3, class 3 of MIL-B-543.

\*3.3.5 Combination identification and size label. Each shell have an identification label centered on the outside of mitten above the buckle and strap. The label shall conform to Type III or IV, class 4 of DDD-L-20, bearing the following inscription:

MITTEN SHELL (MEN'S AND WOMEN'S)  
 CONTRACT NO: DLA 100-00-0-0000 (Example)  
 STOCK NO: 8415-00-240-4645  
 LEATHER CATTLEHIDE 100%  
 CONTRACTORS NAME

Universal  
size

\*3.4 Description. The leather mittens shall be unlined "Chopper" type with a continuous thumb and shall have a buckle strap wrist closure (see figure 1).

3.4.1 Figure. The figure is furnished for information purposes only. When inconsistencies exist between the written specification and the figure, the written specification shall govern.

3.5 Patterns. Patterns used for cutting shall be consistent with good commercial practice.

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3.6 Stitches, seams, and stitching. The stitch, seam, and stitching types specified herein shall conform to FED-STD-751. Unless otherwise specified, all stitching shall be 1/8 inch gauge.

3.6.1 Stitches per inch. Where a range of stitches is specified in Table II, it shall be interpreted to mean the minimum and maximum number permitted.

3.6.2 Tacking and backstitching. Tread breaks or stitches, when not caught in other seams or stitching, shall be securely tacked or backstitched at the ends for not less than 3/8 inch.

3.7 Construction. The mittens shall be made in accordance with all operations shown in Table II. The contractor is not required to follow the exact sequence of operations as listed, provided the finished mitten is identical with that produced by following the exact sequence as shown.

Table II - Construction of mittens

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
1.	Cutting. The leather pieces for the mittens shall be cut in accordance with standard commercial practice.					
2.	Buckle piece and strap piece. a. The width of the buckle piece and strap piece shall be $5/8$ ( $\pm 1/16$ ) inch wide. b. The cut leather for buckle piece. Fold the strip of leather in half across the length, fleshside to fleshside, inserting the buckle. The folded strap shall finish $1\ 1/2$ ( $\pm 1/8$ ) inch. c. The leather for the strap end shall be cut to finish $6\ 3/4$ ( $\pm 1/4$ ) inches long. Fold back one end $1/2$ ( $\pm 1/8$ ) inch, fleshside to fleshside and stitch on all four sides.	301 or 401	EFa-1 and SSa-1	9-12	16-4	16-4
*	d. As an alternate, cotton tape may be used (see 3.3.3) with one end folded back $1/2$ inch and bartacked. OR Assembly.			28 per bartack		
3.	a. Stitch the palm, back and thumb pieces together around the edges leaving an opening, at the top of the mittens, simultaneously inserting the buckle piece with the inserted buckle at the thumb side and the strap piece with the fleshside of the strap piece against the smooth side of the back piece in the seam opposite the thumb. b. The buckle piece and the strap piece shall be $1\ 3/4$ ( $\pm 1/4$ ) inches from top open end of mitten.	301 or 401	SSa-1	9-12	16/4	16/4

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Table I - Construction of mittens (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
3.	Assembly. (cont'd) c. Place a second row of stitching 1/16 inch gauge over the buckle piece along the closing seam, starting 3/4 (+ 1/8) inch before the piece and finishing 3/4 (+ 1/8) inch, after the buckle piece. The stitching shall be parallel to and not overlapping the first row of stitching.	301 or 401	SSa-1	9-12	16/4	16/4
4.	Blocking. a. Trun mitten to the outside (finished position). b. The mittens shall be properly blocked on commercial electrical or steam heated forms.					
5.	Pairing. The finished mittens shall be paired and tacked or stapled together in accordance with best commercial practice which will permit the mittens to be pulled apart without damaging the leather. When staples are used, the metal shall be non-corrosive.					

NCTR Form 1, 15 Sep 1967

3.8 Measurements. The measurements of the finished mittens shall be as shown in table III. Measurements shall be made as indicated in figure 1. All measurements and tolerances are expressed in inches.

Table III - Measurements

Area	Measurements	Tolerance
A. Overall length	10 1/4	$\pm 1/2$
B. Width (across palm at thumb crotch)	5 1/4	$\pm 1/4$
C. Gauge, thumb crotch straight to top of mitten	5 1/2	$\pm 1/2$
D. Gauge, thumb crotch to tip of thumb	3 1/4	$\pm 1/4$
E. Width of thumb (at crotch outer edge to outer edge)	2 1/2	$\pm 1/8$

A, B, C, D, and E refer to figure 1.

3.9 Workmanship. The finished mittens shall conform to the quality of product established by this specification. The occurrence of defects shall not exceed the acceptable quality levels.

#### 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 this specification where such inspections are deemed necessary to assure supplied and services conform to the 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 Classification of inspection. The inspection requirements specified herein are classified as follows:

1. First article inspection (see 4.3).
2. Quality conformance inspection (see 4.4).

\*4.3 First article inspection. The first article submitted in accordance with 3.2 shall be inspected for compliance with design, construction, workmanship, appearance, and dimensional requirements.

\*4.4 Quality conformance inspection. Inspection shall be performed in accordance with MIL-STD-105, except where otherwise indicated herein.

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\* 4.4.1 Component and material inspection. In accordance with 4.1 above, components and materials shall be inspected and tested in accordance with the requirements of referenced specifications, and standards unless otherwise amended, excluded, modified, or qualified in this specification or applicable purchase document.

4.4.2 Examination of the end item. The defects found during examination of the end item shall be classified in accordance with 4.4.2.1 and 4.4.2.2. The applicable inspection levels and acceptable quality levels (AQL's) shall be as indicated in 4.4.2.3. The sample unit for this examination shall be one mitten and selection of the sample shall be by pairs. The sample unit for pairing defects shall be one pair. Defects for pairing shall be classified as a single defect. The lot size shall be expressed in units of one mitten.

4.4.2.1 Visual examination of mittens. The mittens shall be examined for defects in pairing, color, design, construction, material, workmanship and marking.

<u>Examine</u>	<u>Defect</u>	<u>Major</u>	<u>Minor</u>
PAIRING	Not properly mated, e.g., not right and left.	X	
	Not tacked together.		X
COLOR	Not specified color or badly shaded parts.		X
DESIGN	Any characteristic not in accordance with the specified requirements (unless otherwise indicated herein).	X	
CLEANNESS	Spots or stains clearly noticeable.		X
MATERIAL (Leather)	Any through hole, cut, tear or rip.	X	
	Not cattlehide.	X	
	Not full grain.	X	
	Loose or spongy.	X	
	Flanky leather seriously affecting serviceability.	X	
	Flanky leather affecting serviceability but not seriously.		X
	Not soft and pliable.	X	
	Grain damage penetrating deeply into leather fiber.	X	



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<u>Examine</u>	<u>Defect</u>	<u>Major</u>	<u>Minor</u>
MATERIAL	Grain damage not penetrating deeply into leather fiber (not applicable to minute surface break provided the condition or frequency of same does not have serious affect on appearance).		X
	Deep flesh cut, deep open scratch or deep grub hole.	X	
	Deep fat wrinkles, seriously affecting serviceability.	X	
	Fat wrinkles seriously affecting appearance or affecting serviceability but not seriously.		X
	Any hard scar, brittle or bony area, weak or thin spot, abraded area or otherwise defective seriously affecting serviceability.	X	
	Any scar, bony area, abraded area or otherwise defective affecting serviceability but not seriously.		X
	Salt stains or other form of pronounced discoloration or healed grub marks or other healed damage present to a degree seriously affecting appearance of the item.		X
	Flesh side of leather not smooth or containing loose flesh in excess of one square inch in total area.		X
CONSTRUCTION AND WORKMAN- SHIP General (ap- plicable to all components unless other- wise indicated herein)	Distinct difference in grain structure between parts seriously affecting appearance.		X
	Any component misplaced, operation omitted or not properly performed, seriously affecting serviceability.	X	
	Any component misplaced or operation not properly performed affecting serviceability but not seriously.		X
	Any component missing.	X	
	Any component or assembly damaged or defective seriously affecting serviceability.	X	

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<u>Examine</u>	<u>Defect</u>	<u>Major</u>	<u>Minor</u>
CONSTRUCTION AND WORKMAN- SHIP General (applicable to all com- ponents, unless other- wise indicated herein) (cont'd)	Any component or assembly damaged or defective affecting serviceability but not seriously.		X
	Any workmanship damage, e.g., scissor or knife cut, etc.	X	
	Any mend in leather, i.e., patch, etc. (not applicable to restitched seam repair).	X	
	Needle chews likely to develop into a hole.	X	
	Buckle has sharp burr or metal sliver.		X
SEAMS AND STITCHING	Buckle assembly will not function properly.	X	
	Not specified seam type.	X	
	Not specified stitch type	X	
	Any row of stitching omitted.	X	
	Loose stitch tension resulting in a loosely secured seam.	X	
	Tight stitch tension resulting in cutting of leather or breaking of stitches when normal pull is applied.	X	
	Ends of stitching not backstitched as specified.		X
	Stitching irregular or not as specified seriously affecting serviceability.	X	
	Varies more than 1/16 inch beyond gauge specified.		X
	Unevenly gauged affecting appearance.		X
	Stitching irregular or not as specified affecting serviceability but not seriously.		X
	Any part caught in unrelated row of stitching.	X	

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<u>Examine</u>	<u>Defect</u>	<u>Major</u>	<u>Minor</u>
SEAMS AND STITCHING (Cont.)	One or two stitches per inch less than specified.	X	
	More than the specified maximum number of stitches per inch damaging leather.	X	
	More than the specified maximum number of stitches per inch not damaging leather.		X
ASSEMBLY DETAIL	Mitten not neatly laid off.		X
	Poorly assembled seriously affecting serviceability.	X	
	Poorly assembled affecting serviceability but not seriously, e.g., buckle strap and adjusting strap not sewn in alignment causing malformation when strap is tightened.		X
MARKING	Missing, incomplete, incorrect, not legible, not specified size, not in proper location or not accomplished in the specified manner.		X

4.4.2.2 Dimensional examination. The mittens shall be examined for dimensional defects. Any dimension that is not within the established tolerance shall be classified a defect.

4.4.2.3 Inspection levels and acceptable quality levels (AQL's). The inspection levels and acceptable quality levels, expressed in defects per 100 units, shall be as follows:

<u>Examination</u>	<u>Inspection Level</u>	<u>Major</u>	<u>AQL</u> <u>Total</u>
Applicable to 4.4.2.1	II	2.5 DHU	6.5 DHU
Applicable to 4.4.2.2	S-3	-	4.0 DHU
Applicable to 4.4.3	S-2	-	2.5 DHU

4.4.3 Examination of Packaging requirements. An examination shall be made to determine that packaging, packing and marking requirements of Section 5 of this specification are complied with. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully packed, selected just prior to the closing operation. Defects of closure listed below will be examined on shipping containers fully prepared for delivery. The lot size shall be the number of containers in the inspection lot.

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<u>Attribute</u>	<u>Defect</u>
Markings (exterior and interior)	Omitted, incorrect, illegible, of improper size, location, sequence, or method of application.
Materials	Any component missing. Any component damaged, affecting service-ability.
Workmanship	Inadequate application of components, such as: Incomplete closure of container flaps, loose strapping, etc. Bulged or distorted containers.
Content	Number of intermediate packages is more or less than required.

\* 4.5 Component and material inspection. In accordance with 4.1, components and material shall be inspected in accordance with all requirements of referenced specifications, drawings and standards, unless otherwise excluded, amended, modified or qualified in this specification or applicable purchase document.

Table IV - Instruction for testing

Component	Characteristics	<u>Specification reference</u>	
		<u>Requirement paragraph</u>	<u>Test method FED. STD-311</u>
Leather (1 side)	Thickness	3.3.1.1	1001 <u>1/</u>
	Loose, flaccid or flanky	3.3.1	see 4.5.3 <u>1/</u>
	Tannage	3.3.1	Std Comm'd <u>1/</u>
	Chromic Oxide	T	6516 or 6511 <u>1/</u>
	Chloroform extract	A	6311 <u>1/</u>
	Ash	B	6421 <u>1/</u>
	(pH)	L	6621.1 <u>1/</u>
	Shrinkage temperature	E	7011 <u>1/</u>
	Flexibility after soaking		See 4.5.1 <u>1/</u>
	Stiffness	I	See 4.5.2 <u>1/</u>
	Stitch tearing strength		2151 <u>1/</u>
	Tensile strength		2021 <u>1/</u>
	Elongation		2021 <u>1/</u>

1/ Unless otherwise specified a Certificate of Compliance shall be submitted and shall be acceptable for the stated requirement.

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4.5.1 Flexibility after soaking. Test the dry leather for flex stiffness according to test method 5206 of FED-STD-191 then soak leather in distilled water at 70°F (+ 5°) for one (1) hour, then air dry for twenty-four (24) hours at 70°F (+ 5°). Retest the dried leather for flex stiffness and indicate the percent increase in flex stiffness resulting from the soaking. Specimens for this test shall be cut with the long dimension perpendicular to the backbone.

4.5.2 Stiffness. The specimen shall be 3 by 4 inches, cut with the long dimension parallel to the backbone. The specimen shall be folded in half, grain out in the direction perpendicular to the backbone then carefully folded in half again to form a rectangle 3 inches long and 4 layers thick. The folded specimen shall be fastened with a staple across and 1/4 inch from one end. The other end of the specimen shall be fastened in the vise of the tester, with the cut edges along the side of the upper half of the specimen. The specimen shall extend outward 2 inches from the vise. The procedure shall be continued as specified in method 4211 of FED-STD-311 using a one inch span and a bending moment of 0.5 inch-pound. The results shall be reported in pounds.

4.5.3 Test for loose, flaccid or flanky leather. Degrease a one inch wide sample of suitable length according to method 6321 of Fed. Std. 311. Saturate the surface of the leather with 15 percent Sylmer 32 solution. Allow to dry overnight. Place loose part under hammer, 1/2 pound load and test on Universal Leather Tester or Army tap tester at resistivity of one megohm.

## 5. PACKAGING

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

5.1.1 Level A Packaging. Each pair of mittens shall be secured at the cuffs. Five pairs of mittens, with every other pair reversed shall be bound by any suitable commercial means.

5.1.2 Level C (Commercial packaging). Mittens shall be packaged to afford adequate protection against physical damage during shipment from the contractor to the first receiving activity. The package and the quantity per package shall be the same as that normally used by the contractor for retail distribution.

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

5.2.1 Level A Packing. Ninety (90) pairs of mittens (18 bundles of 5 pairs) packaged as specified in 5.1.1 shall be packaged in a fiberboard shipping container assembled, closed and reinforced conforming to class weather resistant, grade V2s, size 2A of MIL-B-17757. Each container shall have the contents completely covered on top and bottom with a sheet of commercial grade kraft paper.

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5.2.2 Level B Packing. Ninety (90) pairs of mittens (18 bundles of 5 pairs) packaged as specified in 5.1.1 shall be packed in a fiberboard shipping container assembled, closed and reinforced conforming to type CF, class domestic, variety SW, grade 200, size 2A of MIL-B-17757. Each container shall have the contents completely covered on top and bottom with a sheet of commercial grade kraft paper.

5.2.2.1 When specified (see 6.2), the shipping container shall be a grade V3c, V3s, or V4s fiberboard box fabricated in accordance with MIL-B-17757, and closed in accordance with the appendix of the box specification.

5.2.3 Level C (Commercial packing). Mitten 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 deliveries. The quantity per shipping container shall be the same as that normally used by the contractor for retail distribution. Containers shall comply with the U.S. Postal Service Manual, Uniform Freight Classification Rules, or National Motor Freight Classification Rules, as applicable.

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

## 6. NOTES

6.1 Intended use. The leather mitten shells described in this specification are intended for use as work mittens by personnel of the Navy.

\* 6.2 Ordering data. Procurement documents should specify the following:

- a. Title, number, and date of this specification.
- b. Whether first article sample is required (see 3.2).
- c. Selection of applicable levels of packaging and packing (see 5.1 and 5.2).
- d. When weather-resistant grade fiberboard shipping containers are required for level B packaging (see 5.2.2.1).

6.4 Changes from previous issue. 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.

Custodian:  
Navy - NU

Preparing activity:  
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Project No. 8415-N237

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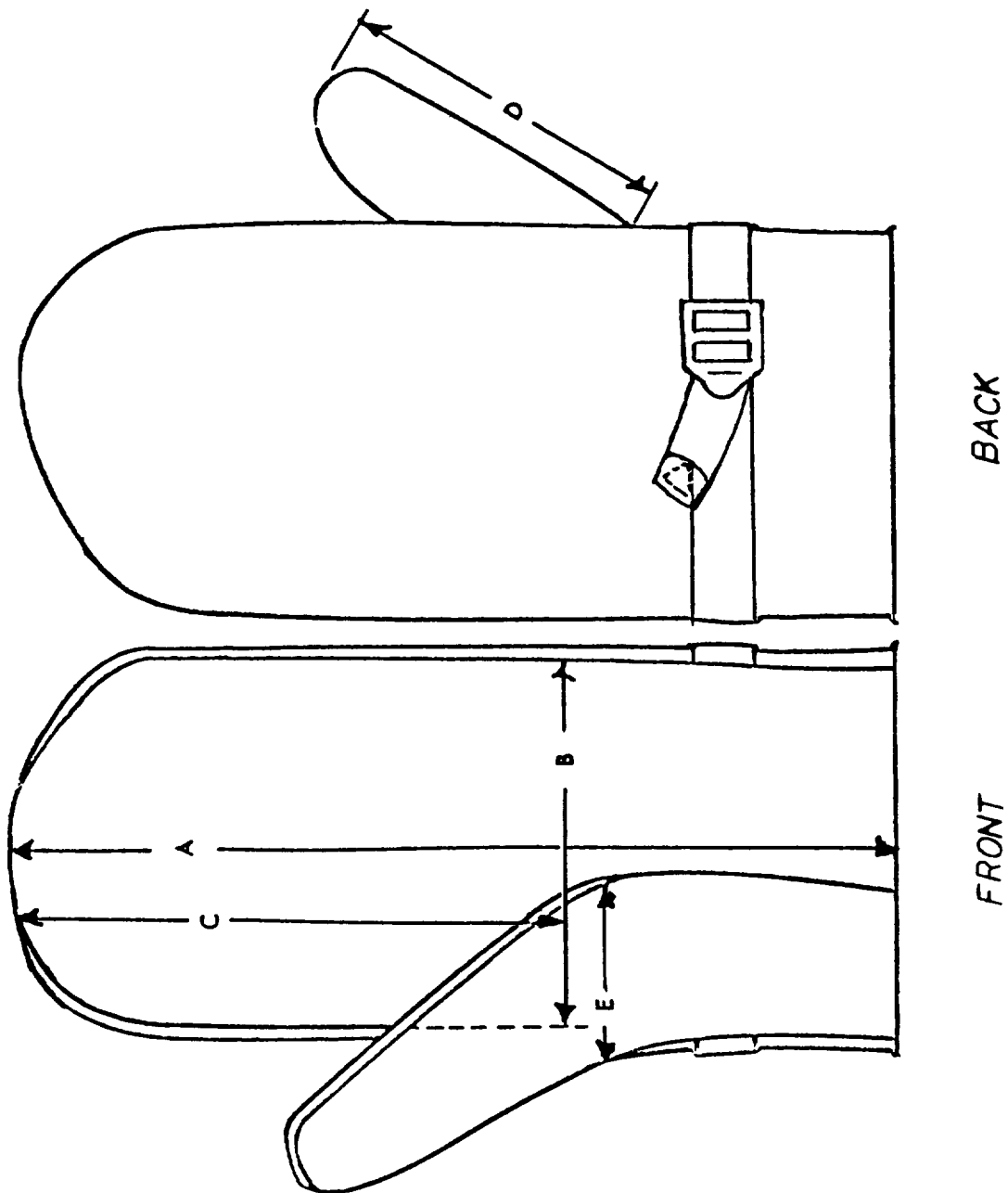


FIG. 1 MITTEN SHELL (MEN'S WOMEN'S )

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**DOCUMENT IDENTIFIER (Number) AND TITLE**

MIL-M-18203C(NU) MITTEN SHELLS (MEN'S AND WOMEN'S)

**NAME OF ORGANIZATION AND ADDRESS OF SUBMITTER**

☐ VENDOR      ☐ USER      ☐ MANUFACTURER

1 ☐ HAS ANY PART OF THE DOCUMENT CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE? ☐ IS ANY PART OF IT TOO RIGID, RESTRICTIVE, LOOSE OR AMBIGUOUS? PLEASE EXPLAIN BELOW

A GIVE PARAGRAPH NUMBER AND WORDING

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C REASON FOR RECOMMENDED CHANGE(S)

**2 REMARKS**

SUBMITTED BY (Printed or typed name and address — Optional)

TELEPHONE NO

DATE

**DD FORM 1426**  
1 OCT 76

Replaces edition of 1 Jan 72 which may be used

S/N 0102-LF-001-4260