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MIL-P-1680D
8 October 1982
SUPERSEDING
MIL-P-1680C
14 July 1967

MILITARY SPECIFICATION

POUCH, KNIFE, MEATCUTTER'S: AND STEEL HOLDER (FOR BELT ATTACHMENT)

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

1. SCOPE

1.1 Scope. This document covers a meatcutter's pouch for holding knives and a meathook and holder for a meatcutter's steel. Both components are for attachment to the user's belt.

2. APPLICABLE DOCUMENTS

2.1 Government documents. Unless otherwise specified, the following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of this document to the extent specified herein.

SPECIFICATIONS

FEDERAL

V-T-285	-	Thread, Polyester.
QQ-A-225/7	-	Aluminum Alloy Bar, Rod, and Wire; Rolled, Drawn, or Cold Finished, 5052.
QQ-A-250/2	-	Aluminum Alloy 3003, Plate and Sheet.
UU-P-268	-	Paper, Kraft, Wrapping.
PPP-B-636	-	Boxes, Shipping, Fiberboard.
PPP-T-45	-	Tape, Gummed, Paper, Reinforced and Plain, For Sealing and Securing.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: US Army Natick Research and Development Laboratories, 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 7340

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MIL-W-530 - Webbing Textile, Cotton, General Purpose, Natural or in Colors.

STANDARDS

FEDERAL

FED-STD-751 - Stitches, Seams, and Stitchings

MILITARY

MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
MIL-STD-129 - Marking for Shipment and Storage
MIL-STD-130 - Identification Marking of U.S. Military Property
MIL-STD-1188 - Commercial Packaging of Supplies and Equipment

DRAWINGS

US ARMY NATICK RESEARCH AND DEVELOPMENT LABORATORIES

5-7-33 - Pouch, Knife, Meatcutter's, and Steel Holder; (for Belt Attachment)

(Copies of documents required by manufacturers in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting officer.)

2.2 Order of precedence. In the event of a conflict between the text of this document and the references cited herein, the text of this document shall take precedence.

3. REQUIREMENTS

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

3.2 First article. When specified, a sample shall be subjected to first article inspection (see 4.3, 6.2 and 6.4).

3.3 Materials. Materials specified shall conform to the applicable documents and requirements specified herein (see 6.6).

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3.3.1 Aluminum.

3.3.1.1 Sheet. Sheet aluminum shall conform to QQ-A-250/2. The temper shall be H12 or H22 except that the temper of the meat hook bracket shall be H16 or H26.

3.3.1.2 Wire. Aluminum wire shall conform to QQ-A-225/7. The temper shall be H38.

3.3.2 Thread, polyester. The thread shall be type I, class 1, sub-class A conforming to V-T-285. The thread size for all stitching, except bartacking, shall be size FF. For bartacking, the thread shall be size E.

3.3.2.1 Color and colorfastness. The thread shall be dyed Olive Drab S-1 (C.A. 66022) and shall show fastness to weathering equal to or better than the standard sample. When no standard sample is available, the thread shall show "good" fastness to weathering.

3.3.3 Webbing, textile, cotton. The webbing shall be dyed to match shade olive drab no. 7 and shall conform to the requirements for type IIb, class 4, 3/4-inch width of MIL-W-530.

3.4 Construction. The construction shall conform in all respects to the drawings listed in section 2 and as specified herein.

3.4.1 Stitches and stitching. All stitching, except bartacking, shall conform to FED-STD-751 as follows:

For all stitching except bartack	Stitch type 301.8 to 10 stitches per inch

3.4.1.1 Bartacks. Bartacks shall be as specified on the applicable drawing and as follows:

Length, ± 1/16	Width, ± 1/32	Stitches per bartack
5/8 inch	1/8 inch	35

Bartacks shall be free from thread breaks and loose stitching.

3.4.2 Automatic stitching. Automatic stitching machines may be used to perform any of the stitch patterns provided the requirements for the stitch pattern, stitches per inch, and size and type of thread are met and at least three tying, overlapping and backstitches are used to secure the ends of stitching.

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3.4.3 Type 301 stitching. Ends of stitching shall be backstitched or overstitched not less than 1 inch except where ends are turned under or caught in other seams and stitching. Thread tension shall be maintained so that there will be no loose stitching resulting in loose bobbin or top thread or excessively tight stitching resulting in puckering of the materials sewn. The lock shall be imbedded in the materials sewed.

3.4.3.1 Repairs of type 301 stitching. Repairs of type 301 stitching shall be as follows:

a. When thread breaks or bobbin run-outs occur during stitching, the stitching shall be repaired by restarting the stitching a minimum of one inch (1/2 inch for box-x) back of the end of the stitching. 1/

b. Thread breaks, or two or more consecutive skipped or run-off stitches noted during inspection of the item (in-process or end item) shall be repaired by overstitching. The stitching shall start a minimum of one inch in back of the defective area (1/2 inch on box-x), continue over the defective area and continue a minimum of one inch (1/2 inch on box-x) beyond the defective area onto the existing stitching. Loose or excessively tight stitching shall be repaired by removing the defective stitching without damaging the materials and restitching in the required manner. 1/

1/ When making the above repairs, the ends of the stitching are not required to be backstitched.

3.4.3.2 Thread ends. All thread ends shall be trimmed to 1/4 inch maximum length.

3.5 Finish. All aluminum shall have a natural finish. The snap for the steel holder shall be nickel plated in accordance with standard commercial practice.

3.6 Metal components. Metal components shall be clean and free of scratches, dents, machine marks, breaks, cracks, punctures, sharp edges, sharp corners, burrs, slivers, and deformities.

3.6.1 Rivets. Rivets shall be tight and completely fill the rivet holes. The rivet heads and peened ends shall be round, concentric, and shall be in full contact with the surface of the joined components.

3.7 Marking. The letters "U.S." and the manufacturer's name or trademark of a character to be easily identifiable with the manufacturer shall be permanently and legibly indented on each knife pouch as indicated on Drawing 5-7-33. Marking shall be in accordance with MIL-STD-130.

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3.8 Replacement of defective components. During the cutting and manufacturing process, components having material defects or damages that are classified as defects in 4.4.3.1, shall be removed from production and replaced with nondefective and properly matched components.

3.9 Workmanship. The finished and assembled pouch shall conform to the quality of product established by this document. The occurance 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 contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or purchase order, 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 document where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

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

a. First article inspection (see 4.3).
b. Quality conformance inspection (see 4.4).

4.3 First article inspection. When a first article is required (see 6.3), it shall be examined for the defects specified in 4.4.3.1, 4.4.3.2. The presence of any defect shall be cause for rejection of the first article.

4.4 Quality conformance inspection. Unless otherwise specified, sampling for inspection shall be performed in accordance with MIL-STD-105.

4.4.1 Component and material inspection. In accordance with 4.1, components and materials shall be inspected in accordance with all requirements of referenced documents unless otherwise excluded, amended, modified, or qualified in this document or applicable purchase document.

4.4.2 In-process inspection. Inspection shall be made at any point or during any phase of the manufacturing process to determine whether cut lengths, cut parts, markings for location of components, and location of assembled component parts are in accordance with specified requirements. Whenever nonconformance is noted, corrections shall be made to the parts affected and lot in process. Parts which cannot be corrected shall be removed from production.

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4.4.3 End item examination. The end item shall be examined in accordance with 4.4.3.1 and 4.4.3.2. The lot size shall be expressed in units of one pouch. The sample unit shall be one pouch.

4.4.3.1 Visual examination. The end item shall be examined for the defects listed below. The inspection level shall be II and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 2.5 for major defects and 6.5 for total (major and minor combined) defects.

Examine	Defect	Classification Major	Minor
Webbing	Not firmly and tightly woven; edges frayed or scalloped.	X	
	Multiple floats		X
	Any cut, hole, tear or smash	X	
	Abrasion mark, slub, broken end or pick		X
	Ends not fused as specified (where required)		X
Metal hardware (general)	Broken or malformed failing to serve intended purpose, corroded area, burr or sharp edge	X	
	Finish omitted, partially omitted or not as specified		X
	Aluminum components not a natural finish		X
	Snap hook not nickel plated	X	
	Not assembled as specified (unless otherwise classified herein)	X	
	Not specified type, size or style	X	
Rivets	Loose, missing	X	
	Not peened, heads or ends not rounded, not in full correct with surfaces		X
Stitching	Missing, not specified pattern	X	
Stitch type	Wrong seam or stitch type	X	
Stitch tension	Loose, resulting in a loose bobbin or top thread		X

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Examine	Defect	Classification Major	Minor
Thread breaks, skipped stitches, or runoffs	Not overstitched as specified		X
NOTE:	Thread breaks or two or more consecutive skipped or runoff stitches not overstitched shall be classified as open seams.		
Ends of stitching	Not secured as specified		X
Rows of stitching	On hanger webbing stitch patterns: (applicable each pattern)		
	-one row of stitching omitted		X
	-two or more rows of stitching omitted	X	
Thread ends	Not trimmed to 1/4 inch maximum length		X
Components and assembly	Any component part omitted or not as specified or any required operation omitted (unless otherwise classified herein)	X	
	Needle chews	X	
	Any mend, darn, patch or splice	X	
Marking	Omitted, illegible, incorrect, or misplaced, not indented		X
Cleanness	Scratches or dents clearly noticeable		X

4.4.3.2 Dimensional examination. Examination shall be made for compliance with all dimensions shown on the drawings which can be examined on the end item, including stitch margins and gauge, excluding reference dimensions. Any dimension exceeding the applicable tolerance shall constitute a defect. The inspection level shall be S-2 and the AQL shall be 6.5 defects per hundred units.

4.4.4 Packaging inspection. An examination shall be made to determine that preservation, packing and marking requirements comply with the section 5 requirements. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully packaged with the exception that it need not be closed. Examination of closure defects listed below shall be made on shipping containers fully packaged. The lot size shall be the number of containers in the inspection lot. The inspection level shall be S-2 and the AQL shall be 4.0 defects per hundred units.

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Examine	Defect
Marking (exterior and interior)	Omitted; incorrect; illegible; of improper size, location sequence or method of application
Materials	Any component missing, damaged or not as specified
Content	Number of bundles per container is more or less than specified

5. PACKAGING

5.1 Preservation. Preservation shall be level A or Commercial as specified (see 6.2).

5.1.1 Level A.

5.1.1.1 Unit pack. Each pouch shall be completely assembled with the belt slide folded down against the front of the pouch. The steel holder shall be fastened to the knife stop by means of its snap and the strap placed in the pouch. The pouch shall then be completely and tightly wrapped in minimum 30-pound kraft paper conforming to type I, grade B of UU-P-268. The kraft paper wrap shall be secured with minimum 2-inch width gummed paper tape conforming to type III, grade B of PPP-T-45.

5.1.1.2 Intermediate pack. Ten pouches, wrapped as specified, shall be alternated end for end and packed on edge in one row in a snug-fitting, intermediate fiberboard box conforming to style RSC, type CF, variety SW, or type SF, class domestic, grade minimum 175 of PPP-B-636. The box shall be closed in accordance with the appendix of PPP-B-636.

5.1.2 Commercial. Pouches shall be preserved in accordance with MIL-STD-1188.

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

5.2.1 Level A packing. Eighty pouches, preserved as specified in 5.1, shall be packed on end in a snug-fitting fiberboard shipping container conforming to style RSC-L, grade V2s of PPP-B-636. Each shipping 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.

5.2.2 Level B packing. Eighty pouches, preserved as specified in 5.1, shall be packed on end in a snug-fitting fiberboard shipping container conforming to RSC-L, type CF (variety SW) or SF, class domestic, grade 275 of PPP-B-636. Each shipping container shall be closed in accordance with method II as specified in the appendix of PPP-B-636.

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5.2.2.1 Weather-resistant fiberboard containers. When specified (see 6.2), the 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 PPP-B-636.

5.2.3 Commercial packing. Pouches, preserved as specified in 5.1, shall be packed in accordance with MIL-STD-1188.

5.4 Marking. In addition to any special marking required by the contract or document, intermediate packs and shipping containers shall be marked in accordance with MIL-STD-129 or MIL-STD-1188, as applicable.

6. NOTES

6.1 Intended use. The knife pouch and steel holder covered by this document are intended for use by meatcutters for carrying knives, a meathook, and a steel.

6.2 Ordering data. Acquisition documents should specify the following:

(a) Title, number, and date of this document.
(b) When a first article is required (see 3.2, 4.3 and 6.3).
(c) Selection of applicable levels of preservation 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 (see 3.1), address the contracting activity issuing the invitation for bids.

6.4 First article. When a first article is required, it shall be inspected and approved under the appropriate provisions of DAR 7-104.55. The first article should be a preproduction sample consisting of one completed pouch. The contracting officer should include specific instructions in all acquisition instruments regarding arrangements for inspection and approval of the first article.

6.5 Asterisks. Asterisks are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.

6.6 Recycled material. It is encouraged that recycled material be used when practical as long as it meets the requirements of the document (see 3.3).

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DOCUMENT IDENTIFIER *(Number)* AND TITLE

MIL-P-1680D Pouch, Knife, Meatcutter's: And Steel Holder (For Belt Attachment)

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