

INCH-POUND

MIL-S-19206E(MC)

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SUPERSEDING

MIL-S-19206D(MC)

4 May 1990

## MILITARY SPECIFICATION

## SWORD AND SCABBARD (NONCOMMISSIONED OFFICERS)

This specification is approved for use by the U.S. Marine Corps, 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 requirements for the sword and scabbard worn by noncommissioned officers.

1.2 Classification. The sword and scabbard shall be of one type with the sword furnished in the following classes and lengths as specified (see 6.2):

Class 1 - High carbon tool steel  
Class 2 - Stainless steel

Lengths      26-28-30-32

## 2. APPLICABLE DOCUMENTS

2.1 Government documents.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to the Commander (PSE-C), Marine Corps Systems Command, Quantico, VA 22134-5010 by using the self addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8465

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distribution is unlimited.

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2.1.1 Specifications, standards, and handbooks. The following specifications, standards and handbooks form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of these documents shall be 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).

## SPECIFICATIONS

## Federal

- A-A-52094 - Thread, Cotton
- QQ-W-321 - Wire, Copper Alloy
- DDD-L-20 - Label; for Clothing, Equipage, and Tentage (General Use)
- DDD-T-86 - Tape, Textile, Cotton, General Purpose, (Unbleached, Bleached or Dyed).

## Military

- MIL-F-10336 - Fiber Sheet, Vulcanized

## STANDARDS

## Federal

- FED-STD-191 - Textile Test Methods
- FED-STD-311 - Leather, Methods of Sampling and Testing

## Military

- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
- MIL-STD-129 - Marking for Shipment and Storage
- MIL-STD-147 - Palletized Unit Loads
- MIL-STD-731 - Quality of Wood Members for Containers and Pallets

(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from the Standardization Documents Order Desk, Building 4D, 700 Robins Avenue, Philadelphia, PA 19111-5094)

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2.1.2 Other Government documents, drawings, and publications. The following other Government drawing forms a part of this document to the extent specified herein. Unless otherwise specified, the issue is that cited in the solicitation.

DRAWING

MARINE CORPS

P-230-Sword and Scabbard, Noncommissioned Officers,  
U.S.M.C.

(Copies should be obtained from the contracting officer or his authorized representative.)

2.2 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).

Department of Defense (DOD) Standard Color Card of  
Official Standardized Shades for Sewing Threads, 1968

(Application for copies should be addressed to the Color Association of the United States, Inc., 200 Madison Avenue, New York, NY 10016).

2.3 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 takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 Guide Sample. Guide samples are furnished solely for guidance and information to the contractor (see 6.4). Variation from the specification may appear in the sample, in which case the specification shall govern.

3.2 First article. When specified (see 6.2), a sample shall be subject to first article inspection (see 6.3) in accordance with 4.4.

3.3 Materials. The materials for the sword, scabbard and case shall conform in all respects to the requirements specified herein.

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3.3.1 Fiber. The scabbard lining shall be  $0.032 \pm 0.003$  inch thick fiber sheet conforming to MIL-F-10336, except the fiber sheet shall be undyed and free of all sulphur compounds or compounds capable of oxidation to sulfuric acid (see Section 4 table I, for required test).

3.3.2 Sword case. Each sword and scabbard shall be provided with a cotton flannelette case to fit the assembled sword and scabbard.

3.3.2.1 Cloth, cotton, flannelette. The basic material for the sword case shall be cloth, cotton, flannelette. The cloth shall be constructed with a plain weave, and shall have a thread count of  $44 \pm 2$  warp and  $36 \pm 2$  filling threads per inch.

The fabric shall weigh  $4.0 \pm 0.5$  ounces per square yard and shall be evenly napped on one side. The cloth shall be free from any imperfections that would affect the appearance or durability of the case (see Section 4, table I, for required test).

3.3.2.1.1 Color and colorfastness. The color shall be vat-dyed gray. The cloth shall show good fastness to wet (dry) cleaning, laundry, crocking, perspiration, and light (see Section 4 table I, for required test).

3.3.2.2 Drawcord. The tape for the drawcord shall be bleached cotton, 1/2 inch wide, conforming to type II, class 2 of DDD-T-86. The ends of the drawcord shall be hemmed or resin dipped to prevent raveling.

3.3.2.3 Cotton thread. The cotton thread for the sword case shall be cotton, soft finish, ticket number 50, 3-ply, conforming to type I of A-A-52094. The cotton thread shall be dyed gray, shade TS, cable No. 66082. The dyed thread shall show good fastness to laundering, wet (dry) cleaning, and light when tested as specified in the thread specification. (See DOD Standard Color Card of Official Standardized Shades for Sewing Threads, 1968).

3.3.3 Hilt. The hilt shall be made of solid brass, straight cross and ends with an acorn design as shown in Drawing No. P-230. The copper base alloy for the solid brass shall have a chemical composition of 85 percent minimum copper and 15 percent maximum zinc (see Section 4 table I, for required test). The color shall be the basis of acceptability of the metal for composition, except in case of dispute, when an analysis shall be made. The alloy shall be uniform in color and quality, and free from pits, scale (including red oxide), dents, nicks, cracks, deep scratches, segregation, and foreign inclusions that cannot be removed in later processing.

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The finished hilt shall be clean, smooth, free from pits and tool marks, and shall be highly polished to a mirror-like finish.

3.3.3.1 Hilt guard. A piece of white felt or white leather  $1/8 \pm 1/32$  inch thick shall be slotted to fit on the hilt (see Section 4, table I, for required test).

3.3.3.2 Wire. Wire for the grip shall be annealed, 0.02 inch diameter wire conforming to alloy No. 270 of QQ-W-321.

3.3.3.3 Screws. Screws for the scabbard shall have a chemical composition of 63.0 to 68.5 percent copper, 0.10 percent maximum lead, 0.05 percent maximum iron, and 0.15 percent all other elements, except the remainder which shall be zinc. The screw shall be a brass, slotted, headless setscrew with class 2, size 4, fine thread.

3.3.4 Scabbard. Steel for the scabbard shall be minimum 0.020-inch thick cold-rolled one-half hard strip steel when tested as specified Section 4, in table I.

3.3.5 Leather. The grip and scabbard shall be covered with leather, black shade III, having a lustrous finish. The scabbard covering shall be  $2/64$  inch thick case leather when tested as specified Section 4, in table I.

3.3.6 Lacquer. Lacquer shall be a clear, nonpigmented, synthetic lacquer.

3.3.7 Blade. The blade shall be drop forged, machine ground or milled, and finished without blow holes, pocket marks, or other irregularities in the metal.

3.3.7.1 Class 1 - High carbon tool/steel. The blade shall be high carbon tool steel with a minimum carbon content of 0.70 percent when tested as specified in 4.5. The blade shall be hardened full hard and then tempered to show a Rockwell "C" scale hardness test of 48 to 53. A chromium plating shall be applied over an intermediate coating of nickel, or nickel on copper plate. The intermediate plating shall be 0.002 inch thick and may be either on nickel or nickel on copper plate. If the latter is used, the minimum final thickness of nickel shall be 0.001 inch. The chromium plating shall be polished to a bright, smooth finish free from frosty or milky areas, indications of burning, pits, and nodules. The chromium deposit must be adherent, homogeneous, of uniform appearance, and free from laminations, blisters, pinholes, and other defects (see Section 4, table I).

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3.3.7.2 Class 2 - Stainless steel. The stainless steel blade shall be made with a minimum of 12 percent chromium and shall be polished to a bright finish. No additional coatings are required.

3.3.8 Adhesive. The adhesive shall provide a secure and permanent bond between the leather covering and the metal of the scabbard without undesirable effects upon either.

3.4 Design. The sword, scabbard and case shall be the U.S. Marine Corps design shown on figures 1 and 2 and drawing No. P-230.

3.5 Patterns. Patterns for the sword case, cut to finish in accordance with figure 2, shall be furnished by the contractor.

3.6 Construction.

3.6.1 Sword.

3.6.1.1 Blade. The blade shall be the cut and thrust type with a single blood gore and a rounded back edge, shall measure 7/8 inch wide by 1/4 inch thick at the hilt end, and shall have a tapered and curved shape conforming to the sample. All exposed surfaces of the blade shall be polished and free from blemishes.

3.6.1.1.1 Etching. Etching design on each side of and on the back edge of the blade shall be in accordance with Drawing No. P-230. All etching shall be accurately executed in fine contrast and shall be well defined.

3.6.1.2 Grip. The grip shall be grooved and covered with leather, black shade III, firmly secured and fitted flush with the metal and wrapped with yellow brass twisted wire as specified in 3.3.3.2. The twisted wire shall be two ply with 5 to 7 twists per inch, as shown in the sample. The leather shall have a lustrous finish as shown in the sample.

3.6.1.3 Hilt. The hilt, made from material specified in 3.3.3, shall be of the half-basket type with the design conforming to Drawing No. P-230. The finished hilt shall be clean, smooth, free from pits and tool marks, and shall be highly polished to a mirror-like finish.

3.6.1.3.1 Hilt guard. A piece of white felt or leather shall be slotted to fit snugly on the hilt end of the blade. The dimensions of the hilt guard shall conform to the dimensions of the open end of the scabbard indicated on figure 1.

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3.6.2 Scabbard.

3.6.2.1 Scabbard body. The scabbard body shall be made with welded seam, shall be free from burrs, and shall be covered with 2/64 inch thick case leather, black shade III, having a lustrous finish as shown in the sample. The leather shall be evenly and securely cemented to the metal and shall be neatly and evenly stitched.

3.6.2.2 Scabbard components. The top band and shoe shall be made of 20 B.S. gage sheet brass and shall be ornamented as shown in Drawing No. P-230. The brass hook for attaching scabbard to frog shall be fitted to the band as shown in Drawing No. P-230. The band and shoe shall be secured to the scabbard with brass machine screws specified in 3.3.3.3. The finished shoe and band with hook shall be clean, smooth, free from pits and dents, and shall be highly polished to a mirror-like finish.

3.6.3 Lacquering. The sword hilt and the band and shoe on the scabbard shall be thoroughly lacquered. The dry lacquer film shall be continuous, level and adherent. It shall be free from lint, dust, or other foreign inclusions that may affect appearance or serviceability, and withstand the test for tackiness specified in 4.5.1.1.

3.6.4 Sword case. The Sword case shall be made according to figure 2, with the center of the drawcord securely caught in the side seam of the case at the hem for closure. The identification label shall be caught in the stitches of the hem.

3.7 Marking.

3.7.1 Identification marking. Identification marking shall be etched into the blade 1/4 inch (minimum) below the hilt. The letters shall be not less than 1/32 inch in height and each line shall be separated by a minimum of 1/32 inch. The content shall be as follows:

Name of contractor

3.7.2 Size markings.

3.7.2.1 Scabbard. The length of the blade that the scabbard will take shall be stamped into the metal about 1/4 inch from the top, on the side opposite the hook, in 1/8 inch high numerals.

3.7.2.2 Sword. The length of the blade shall be stamped on the underside of the hilt in 1/8 inch high numerals.

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3.7.3 Label. Each sword case shall be provided with an identification-size label conforming to type VI, class 4 of DDD-L-20. The label shall measure not less than 1-3/4 by 1-1/4 inches with a minimum 1/4 inch margin at the top edge for sewing. The sword case is intended to be either laundered or dry cleaned.

3.7.4 Label/tag. Each item shall be individually bar-coded with the type VIII, class 17 label/tag of DDD-L-20. This label/tag shall be located so that it is completely visible on the item when it is folded and/or packaged as specified and so that it causes no damage to the item.

3.8 Finished measurements. The finished sword shall conform to the measurements specified in figure 1 and Drawing No. P-230.

3.9 Fit. Swords and scabbards shall be examined to determine whether they properly fit each other, and that the sword enters the scabbard freely, but not loosely.

3.10 Workmanship. The sword and scabbard, with case, 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 or purchase order, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract, this 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 supplies and services conform to prescribed requirements.

4.1.1 Responsibility for compliance. All items must meet all requirements of sections 3 and 5. The inspection set forth in this specification shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the contractor of the responsibility of ensuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations, is an acceptable practice to ascertain conformance to requirements; however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to accept defective material.

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4.1.2 Certification of compliance. Components and materials listed below may be accepted on the basis of a supplier's certification of compliance with the requirements specified in applicable paragraphs of this specification.

<u>Component</u>	<u>Characteristics</u>	<u>Requirements Paragraph</u>
White felt or leather for hilt guard	Material identification	3.3.3.1
Brass screws	Material identification	3.3.3.3
Leather	Material identification	3.3.5
Lacquer (nonpigmented synthetic)	Material identification	3.3.6
Adhesive	Material identification and bonding properties	3.3.8

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

- a. First article inspection (see 4.4).
- b. Quality conformance inspection (see 4.5).

4.3 Inspection conditions. All inspections shall be in accordance with the provisions specified in MIL-STD-105, except where otherwise indicated herein.

4.4 First article inspection. When first article is required, inspection shall be made of a completely fabricated sword and scabbard, with case, for all provisions of this specifications.

4.5 Quality conformance inspection.

4.5.1 Testing of components. Testing of components shall be in accordance with the applicable subsidiary specifications and standards to the extent applicable, except that this specification shall govern in the event of conflict. The method of testing shall be as specified in FED-STD-191, wherever applicable. Testing shall be performed on components listed in table I for characteristics noted.

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4.5.1.1 Sampling for testing. Unless otherwise specified in subsidiary specifications, sampling shall be in accordance with the following. The lot shall be unacceptable if one or more sample units fail to meet any test requirement specified herein. Items shall be tested for the characteristic listed below.

<u>Lot size (lot unit)</u>	<u>Sample size (sample unit)</u>
800 or less	2
801 through 22,000	3
22,001 and over	5

<u>Characteristic</u>	<u>Rqmt. para.</u>	<u>Test method</u>	<u>Rqmt. appl. to</u>		<u>Det/ spl. unit</u>	<u>Results reported as:</u>
			<u>Spl. unit</u>	<u>Lot avg.</u>		
Tackiness test for lacquer	3.6.3	4.6.1	X	-	1	pass/fail

4.5.2 In-process inspection. Inspections shall be made at any point or during any phase of the manufacturing process to determine whether operations or assemblies are accomplished as specified herein. The Government reserves the right to exclude from consideration for acceptance any material or service for which in-process inspection has indicated non-conformance. In-process inspection shall be conducted to see that accomplishment of the following is in accordance with the specification requirements:

<u>Requirement, operation or assembly</u>	<u>Requirement paragraph</u>
Welded seam on scabbard body	3.6.2.1

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TABLE I. Testing of Components.

Component & lot size expressed in term of:	Characteristic	Rqmt. para.	Test Method	Rqmt appl.		Det. S/U	Pass/ fail	Results reported as:	
				S/U	Lot avg.			Numeri- cally	Sample nearest unit
Copper base alloy (1 lb)	Material indent. copper, % zinc, % (remainder)	3.3.3	-	-	-	-	-	-	2" x2"
			Std coml	-	X	2	-	0.1%	piece
			Std coml	-	X	2	-	0.1%	
Steel; blade 1/ (1 sheet)	Material indent. carbon, % chromium, % Hardness Temper	3.3.7.1	-	-	-	-	-	-	4 oz.
			Std coml	-	X	2	-	0.01%	
			Std coml	-	X	2	-	0.1%	
			Std coml	-	X	1	-	"C" value	
Steel; scabbard (1lb)	Thickness	3.3.7.1	Std coml	X	-	1	X	-	-
			Std coml	X	-	10	-	0.001"	12" length
Material; Hilt guard (1 sheet)	Thickness	3.3.3.1	1011 of FED-STD-311	X	-	10	-	1/64"	8" x8" piece
			1011 of FED-STD-311	X	-	10	-	1/64"	8" x8" piece
Leather	Thickness	3.3.5	1011 of FED-STD-311	X	-	10	-	1/64"	8" x8" piece
Fiber sheet	Sulfur	3.3.1	4.6.2	X	-	1	X	-	6" x6"
Flannelette	Weave Weight	3.3.2.1	Visual	X	-	5	X	-	
		3.3.2.1	FED-STD-191 5041	X	X	5	-	0.1 oz.	

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TABLE I. Testing of Components. - Continued

Component & lot size expressed in term of:	Characteristic	Rqmt. para.	Test Method	Rqmt appl. to:		Det. S/U	Pass/ fail	Results reported as:	
				S/U	Lot avg.			Numeri- cally	Sample nearest unit
Flannelette (Cont'd.)	Texture wrap filling	3.3.2.1	- 5050 5050	- X X	- - -	- 5 5	- - -	- - -	- - -
	Colorfastness wet (dry) cleaning	3.3.2.1.1 5622	- 5622	- X	- -	- -	- X	- -	1 yd.
	laundry crocking	5610 5650	5610 5650	X X	- -	- -	X X	- -	- -
	perspiration	5680 or 5682	5680 or 5682	X X	- -	- -	X X	- -	- -
light dye ident.		5660	5660	X	-	-	X	-	-
		Std compl	Std compl	X	-	-	X	-	-

1/ Shall meet either the carbon requirement of carbon steel or the chromium requirement of stainless steel.

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4.5.3 Examination of the end item. The end item shall be examined for defects listed in 4.5.3.1 through 4.5.3.3. The sample unit shall be one sword and scabbard with case. All defects shall be classified as indicated below, except those numbered 1 through 15 in classification column, which shall be classified as follows listed below.

Major defect - When seriously affecting appearance or serviceability.

Minor A defect - When not seriously affecting appearance or serviceability.

4.5.3.1 General defects. General defects shall be classified as follows:

Examine	Defect	Classification		
		Major	Minor A	B
Color and Finish	Color does not compare favorably with standard sample.	101		
	Polished surfaces of the blade do not compare favorably with the standard sample.		201	
	Stain, discoloration or blemish on the exposed surface of the blade.		202	
	Hilt, shoe, band, or hook not highly polished to a mirror-like finish.	102		
	Hilt, shoe, or band not lacquered.		203	
	Lacquer is pigmented.		204	
	Foreign matter embedded in the finish (i.e., lint, dust, or foreign inclusion) affecting appearance.		205	
	Lacquer coating hazy, cloudy, or powdering.			301

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Examine	Defect	Classification		
		<u>Major</u>	<u>Minor</u>	
			A	B
Color and Finish (cont'd)	Lacquer not smooth, not continuous or not adherent, i.e., flaking, blistering, peeling or has run or sag.			302
	Lacquer not set to touch, i.e., tacky when gentle finger pressure is applied to coating.			303
Quality of leather	Color not as specified.	103		
	Color does not compare favorably with standard sample.	104		
	Color not uniform.		206	
	Finish flaky or not lustrous.			304
	Any <u>permanent</u> type spot or stain that is clearly noticeable.	105		
	Any spot or stain that is clearly noticeable but can be readily removed with cleaning agent.			305
Quality of metal	Hole, cut, grub or tick mark; open or badly healed scratch; boney, loose, pipey, flaky, spongy, or stretchy leather; fat wrinkle.		207	
	Pit, scale, dent, nick, chip-out, crack, scratch or foreign inclusion.		208	
	Metal marks on exposed surfaces, such as nick, dent, crack, dig, gouge or scratch.		209	
Design and construction	Does not compare favorably with either the standard sample or drawing.	106		

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Examine	Defect	Classification		
		Major	Minor A B	
Design and construction (cont'd)	Etching not well defined or not accurately executed in fine contrast.		210	
	Hilt not half-basket.	107		
	Component missing.	108		
	Detail missing, e.g., etching missing from back edge or side of blade or top band or shoe not ornamented.	109		
	Detail obscured, marred, reduced, altered or obliterated.		211	
	Blade not cut and thrust type.	110		
	Blade has more than one blood gore.	111		
	Back edge of blade not rounded as required.	112		
	Curve or taper at blade not as shown on drawing.	113		
	Grip not grooved.	114		
	Leather not firmly secured to grip.		212	
	Leather not flush with metal on grip.			306
	Leather on scabbard loose to metal (Not firmly cemented).		213	
	Band and shoe not secured with headless set screws.		214	
	Flannelette case does not fit assembled sword and scabbard as intended.			307

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Examine	Defect	Classification		
		Major	Minor A B	
Workmanship of sword and scabbard	Any warp, twist or distortion producing irregular surface or outline.	115		
	Piercings not free from superfluous metal.			308
	Hilt not pierced where specified or not as shown on the standard sample.	116		
	Edge not clean or smooth, i.e., burr, drag, step, or roughness.	117		
Seams and stitching of flannelette	Open seam or runoffs more than 1 inch.	118		
NOTE: Raw edges not securely caught in stitching shall be classified as open seams.				
Markings	Wrong seam or stitch type.		215	
	Loose or tight stitch tension.			309
	Identification label not caught in stitches of the hem.			310
	Center of drawcord not securely caught in side seam of case at the hem.			311
	Scabbard not neatly and evenly stitched.			312
	Length of blade not stamped on top band.			313
Label	Numerals are illegible, incorrect, wrong size, or not permanently marked.			314
	Bar code label omitted or misplaced, not readable.		216	

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4.5.3.2 Examination of dimensions. Any dimension that is not within the specified tolerances shall be classified as a defect.

4.5.3.3 Performance examination. Each sword will be tested for the performance requirements listed below:

<u>Examine</u>	<u>Defect</u>
Sword and scabbard	Blade cannot be easily inserted into scabbard.
	Blade cannot be freely withdrawn from scabbard.
	Blade does not fully enter scabbard.
	Swords and scabbard of the same size are not interchangeable.

4.5.4 Examination of packaging. An examination shall be made to determine compliance with packaging, packing and marking requirements of section 5 of this specification. 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 sealed. 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.

<u>Examine</u>	<u>Defect</u>
Markings (exterior and interior)	Omitted; incorrect; illegible; or of improper size, location, sequence or method of application.
Materials	Any component missing; any component damaged, affecting serviceability.
Workmanship	Inadequate application of components, such as incomplete closure of case liners, container flaps, loose strapping, or inadequate stapling. Bulging or distortion of container.
Weight or container	Number per container is more or less than required; gross/net weight exceeds requirement.

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4.5.5 Palletization examination. The fully packaged and palletized end items shall be examined for the defects listed below. The lot size shall be expressed in units of palletized unit loads. The sample unit shall be one palletized unit load, fully packaged.

<u>Examine</u>	<u>Defect</u>
Finished dimensions	Length, width, or height exceeds specified maximum requirement
Palletization	Pallet pattern not as specified Load not bonded as specified
Weight	Exceeds maximum load limits
Marking	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application

4.6 Tests.

4.6.1 Tackiness test. At room temperature (60° to 80°F), press a piece of tissue paper against the lacquered parts for 30 seconds, using any pressure capable of being exerted by the thumb and two fingers. The tissue paper shall not adhere to the lacquered parts, but shall fall free when pressure is released.

4.6.2 Test for sulphur.4.6.2.1 Solutions.

4.6.2.1.1 Acid stannous chloride. Dissolve 100 grams of stannous chloride crystals in 100 ml. of hydrochloric acid (35 percent concentration). Add 50 ml. of distilled water.

4.6.2.1.2 Lead acetate solution. Dissolve five grams of reagent grade lead acetate in 100 ml. of distilled water. Add one drop of glacial acetate acid to clear up the solution if it appears cloudy.

4.6.2.2 Procedure. One to 1.5 grams of material, cut into small pieces shall be used for the test. Place the sample in a test tube of suitable size, and cover with the stannous chloride solution. Place a filter paper, which has been moistened with one drop of lead acetate solution, over the mouth of the tube (punch needle hole in paper). Heat the tube slowly over a low flame until the solution is boiling.

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The solution shall not be boiled more than 10 to 15 seconds as prolonged boiling will reduce the sensitivity of the test. A brown stain appearing on the paper indicates the presence of sulphur.

## 5. PACKAGING

5.1 Packaging. Packaging shall be level A or commercial, as specified (see 6.2).

5.1.1 Level A. Each assembled sword and scabbard shall be enclosed in a cotton flannelette case and packaged in individual corrugated fiberboard boxes of a size to accommodate the sword and protective packaging to afford maximum protection to the contents in transit and storage.

5.1.2 Commercial. Packaging shall be in accordance with the contractor's commercial practice or as indicated by the procuring activity.

5.2 Packing. Packing shall be commercial. The swords and scabbards, packaged as specified in 5.1, shall be packed in a manner to insure carrier acceptance and safe delivery at destination.

5.3 Palletization. When specified (see 6.2), swords and scabbards, packed as specified in 5.2, shall be palletized on a 4-way entry pallet in accordance with load type Ia of MIL-STD-147. Pallet types shall be type I (4-way entry), type IV or type V in accordance with MIL-STD-147. Pallets shall be fabricated from wood groups I, II, III, or IV of MIL-STD-731. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding means K and L or film bonding means O or P. Pallet patterns shall be in accordance with the appendix of MIL-STD-147.

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

## 6. NOTES:

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

6.1 Intended use. The sword and scabbard covered by this specification are intended for wear by specified noncommissioned officers of the U. S. Marine Corps.

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6.2 Acquisition requirements. Acquisition documents should specify the following:

- a. Title, number, and date of this specification.
- b. Issue of DODISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.1).
- c. Class and length required (1.2)
- d. When first article is required (see 3.2)
- e. Level of packaging required (5.1)
- f. When palletization is required (see 5.3)
- g. Acceptance criteria required (see 6.5)

6.3 First article. When a first article is required, it shall be inspected and approved under the appropriate provisions of FAR 52.209. The first article should be a pre-production sample. The contracting officer should specify the appropriate type of first article and the number of units to be furnished. The contracting officer should also include specific instructions in acquisition documents regarding arrangements of selection, inspection, and approval of the first article.

6.4 Standard sample. For access to samples, address the contracting activity issuing the invitation for bids or request for proposal.

6.5 Acceptance criteria. The acceptance criteria shall be as specified in the contract or purchase order.

6.6 Figures. Figures 1 and 2 are furnished for information purposes to the extent of any inconsistencies between the written specification and the figures, the written specification shall govern.

6.7 Subject term (key word) listing.

Blade  
Hilt  
Steel

6.8 Changes for 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.

Preparing Activity:  
Navy - MC  
Project No. 8465-N179

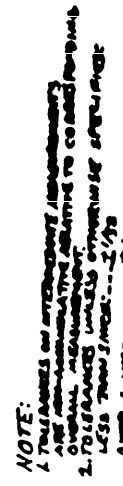
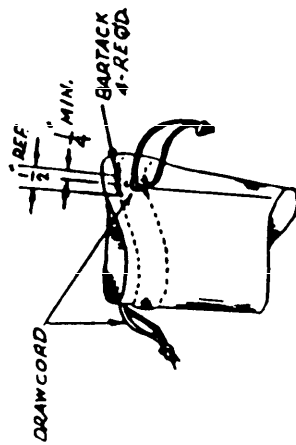
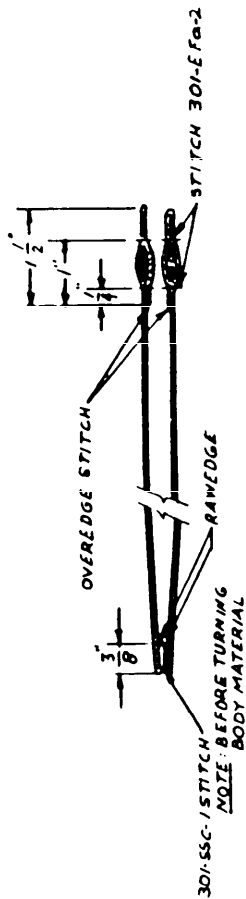


FIGURE 1. SWORD AND SCABARD:N.C.Q.  
0 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100

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EXTERIOR VIEW OF CLOSURE  
SHOWING TWO DRAWCORDS  
ONE ON EACH SIDE OF THE  
BODY SEAM AND HEM.



# 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-S-19206E(MC)

2. DOCUMENT DATE (YYMMDD)  
20 September 1994

### 3. DOCUMENT TITLE

SWORD AND SCABBARD (NONCOMMISSIONED OFFICER'S)

### 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)

7. DATE SUBMITTED  
(YYMMDD)

(1) Commercial  
(2) AUTOVON  
(If applicable)

### 8. PREPARING ACTIVITY

a. NAME

b. TELEPHONE (Include Area Code)

(1) Commercial

(2) AUTOVON

COMMANDER

703-640-4584

278-4584

c. ADDRESS (Include Zip Code)

PROGRAM SUPPORT DIRECTORATE (PSE-C/S)  
MARCORSSCOM, 2033 BARNETT AVE SUITE 315  
QUANTICO VA 22134-5010

IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT:

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5203 Leesburg Pike, Suite 1403, Falls Church, VA 22041-3466  
Telephone (703) 756-2340 AUTOVON 289-2340