

INCH-POUND

MIL-S-21711E
AMENDMENT 2
14 October 1994

MILITARY SPECIFICATION

SHOES, WOMEN'S

This amendment forms a part of military specification MIL-S-21711E, dated 3 December 1982, and is approved for use by all departments and agencies of the Department of Defense.

PAGE 2

Federal Specifications, after line 3 add:

"NN-P-71 Pallet, Material Handling, Wood Stringer
Construction, 2 Way and 4 Way (Partial)"

Military Specifications, before line 1 add:

"MIL-P-15011 Pallet, Material Handling, Wood, Post
Construction, 4 Way Entry"

Military Standards, after line 3 add:

"MIL-STD-147 Palletized Unit Loads"

2.1.2 - Delete and substitute:

"2.1.2 Other Government documents, drawings, and publications.
The following other Government documents, drawings, and
publications form a part of this specification to the extent
specified herein. Unless otherwise specified, the issues are
those cited in the solicitation."

2.1.2, under US Postal Service Manual, line 2, after "20402" add
"-0001"

AMSC N/A

1 of 8

FSC 8435

DISTRIBUTION STATEMENT A.

Approved for public release;
distribution is unlimited.

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PAGE 2

2.1.3 - Delete in its entirety

2.2 - Delete and substitute:

"2.2 Non-Government. The following document(s) form a part of this specification to the extent specified herein. Unless otherwise specified, the issue of documents which are DOD adopted shall be those listed in the issue of the DODISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS shall be the issue of the documents cited in the solicitation."

PAGE 3

2.2, line 7, after "19103" add "-1187"
line 11, after "20036" add "-1404"
line 15, after "60606" add "-5808"

after line 15, add the following:

"2.3 Order of precedence. In the event of a conflict between the text of this document and the references cited herein (except for related associated detail specifications, specification sheets, or MS standards), the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained."

3.2 - Delete and substitute:

"3.2 First article. When specified, the contractor shall furnish sample unit(s) for first article inspection and approval (see 4.2 and 6.2)."

PAGE 4

3.3.2.1 - Delete in its entirety and substitute:

"3.3.2.1 Fungicide. All leather components shall contain not less than 0.18 percent nor more than 0.70 percent paranitrophenol fungicide when tested as specified in 4.3.1."

3.3.4.1, sentence 3 - Delete in its entirety

3.3.4.1 - Add the following statement to the end of the paragraph:

"There is a deviation from component specification KK-I-570C. On page 3, Table I, delete insoluble ash characteristic in its entirety and substitute "insoluble ash percent, footnote 1, type I, 7.0 maximum, type III, 10.0 maximum."

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PAGE 4

3.3.5.2, line 5 - Delete "0.12" and substitute "0.11"

PAGE 5

3.3.6.3, line 1 - Delete " $(\pm 1/32)$ " and substitute " $(+1/16, -1/32)$ "

PAGE 6

3.3.6.6, line 3 - Delete "5/8 inch" and substitute "1/2 inch"

PAGE 7

After paragraph 3.3.8.2, add the following new paragraph:

"3.3.8.3 Laminated Box Toe/Water-Activated. As an alternate, when automated lasting is used, a water-activated, laminated box toe may be used. This box toe shall be a laminate of an alloyed ionomer resin of at least 60 percent virgin ionomer (surlyn) laminated with woven fabric on both sides with partially water-soluble acrylic adhesive coating laminated over the fabrics. The combined thickness of this five-layer laminate shall be .038 inches \pm .0075 inches."

PAGE 15

3.7.14, after sentence 4 - Add the following:

"When automatic backpart lasting equipment is used, the tack at the center of the heel seat may be omitted."

PAGE 16

3.7.18.2, line 6 - Delete "shank" and substitute "shoe"

3.7.21, line 3 - Delete "5-1/2" and substitute "6"

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3.7.29.4, line 1 - Delete "shall" and substitute "may"

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4.1.1 - Delete and substitute:

"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 assuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling in quality conformance does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to acceptance of defective material.

4.1.2 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 and 4.3 - Delete and substitute:

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

1. First article inspection (see 4.2)
2. Quality conformance inspection (see 4.3)

4.2 First article inspection. When required, the first article submitted in accordance with 3.2 shall be inspected as specified in 4.3.4 for compliance with design, construction, workmanship, appearance and dimensional requirements.

4.3 Quality conformance inspection. Sampling for inspection shall be performed in accordance with MIL-STD-105, except where otherwise indicated."

4.3.1 - Add the following sentences to the end of the paragraph:

"A certificate of compliance shall be submitted and will be accepted for the stated testing and inspection requirements contained in the component specification for the following components:

Component	/ Paragraph number
Welting	3.3.5.1
Laces	3.3.17
Upper thread	3.3.15.1.1
Thread, sole stitch	3.3.15.2
Thread, sole stitch	3.3.15.2.1
Thread, inseaming	3.3.15.2.2
Quarter, top binding	3.3.6.2
Twill, toe lining	3.3.6.1

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In addition to the certificate of compliance, a laboratory test report shall be provided with each component lot/shipment from each supplier for prime contractor records and verification by the government when testing/inspection is deemed necessary on all components covered by a certificate of compliance."

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4.3.1.1.3, Footnote 1/, line 2 - After "area" add "providing there is no serious adverse affect on appearance or serviceability"

PAGE 24

After paragraph 4.3.3, add the following:

"Contractors will not be required to perform the intermediate examination specified in paragraph 4.3.3; however, contractors will be required as part of their inspection system to establish stations for examination of intermediate products for the characteristics listed in the aforementioned paragraph, as well as for additional defects which may be detectable. The Government reserves the right to perform the intermediate examinations in accordance with specification requirements and to reject any lots found to be nonconforming. For leather requirements in this specification, the following is applicable: delete AQL requirements for "totals" and all associated verbiage. Contractors shall reattach all heel pads that are removed by the Government in the performance of verification inspection."

PAGE 26

4.3.3.1.3, after "For 4.3.3.1.1 (Upper fittings)" change the AQLs to read "1.0"

4.3.3.1.3, after "For 4.3.3.1.2 (Bottoms)" change the AQLs to read "1.0"

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4.3.4.1, outsole defects a and b - Delete and substitute:

- "a. Less than 6 stitches per inch - major
- b. More than 7-1/2 stitches per inch - minor"

PAGE 31

4.3.5, lines 4 and 5 - Delete "packaged with the exception that it need not be closed" and substitute "prepared for delivery"

PAGE 32

4.3.5, after paragraph add the following:

"4.4.4 Palletization examination. An examination shall be made to determine that the palletization complies with the section 5 requirements. Defects shall be scored in accordance with the list below. The sample unit shall be one palletized unit load fully packaged. The lot size shall be the number of palletized unit loads in the end item inspection lot. The inspection level shall be S-1 and the acceptable quality level, expressed in terms of defects per hundred units, shall be 6.5 as specified in MIL-STD-105.

<u>Examine</u>	<u>Defect</u>
Finished dimension requirements	Length, width, or height exceeds specified maximum
Palletization	Pallet pattern not as specified Interlocking of loads not as specified Load not bonded with required straps as specified
Weight	Exceeds maximum load limits
Marking	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application"

5.1.1, line 2 - Delete the following:

"As an alternate, each shoe shall be inserted into a snug-fitting clear polyethylene film bag of 0.00125 inch thickness (\pm 25 percent tolerance). The open end of the bag shall extend a minimum of 2 inches beyond the length of the shoe."

PAGE 33

5.1.2, line 1 - Delete "(Commercial packaging)"

5.2.1, lines 11-14 - Delete last sentence in its entirety

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5.2.2, lines 11-13 - Delete last sentence in its entirety

5.2.3, line 1 - Delete "(Commercial packing)"

5.3, line 1 - After "the contract" add "or order"

5.3, after paragraph add the following:

"5.4 Palletization. When specified (see 6.2), item, 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. Each prepared load shall be bonded with primary and secondary straps in accordance with the bonding means C, K, and L, or O or P. Pallet patterns shall be in accordance with the appendix of MIL-STD-147. The pallet shall be 4-way, type IV; type V, class 1, size 2; or type VIII, fabricated from wood groups I, II, III, or IV, grade A of NN-P-71, or 4-way, style 1, size A, type I, class 1 fabricated from groups specified in MIL-P-15011. Interlocking of loads shall be effected by reversing the pattern of each course. If the container is of a size which does not conform to any of the patterns specified in MIL-STD-147, the pallet pattern used shall first be approved by the contracting officer."

5.3.1 - Delete in its entirety

PAGE 34

6.2 c. - Delete and substitute:

"c. When a first article inspection is required, (see 3.2), the item will be tested and should be a first article sample. The contracting officer should include specific instructions in acquisition documents regarding arrangements for examinations, quantity, and approval of the first article."

Add the following to the end of the paragraph:

"f. When palletization is required (see 5.4)."

After 6.7 add the following:

"6.8 Subject term (key word) listing

Footwear, woman's
Outsole, rubber
Shoe, dress, black
Shoe, Blucher oxford"

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Custodians:

Navy - NU

Army - GL

Air Force - 99

Preparing activity:

DLA - CT

Review activities:

Army - MD

Air Force - 11, 82

Project Number 8435-0061

User activities:

Navy - CG, MC

Air Force - 45