

MIL-S-29138A  
AMENDMENT-1  
29 January 1986

## MILITARY SPECIFICATION

### SWEATER, WOMAN'S, ACRYLIC

This amendment forms a part of Military Specification MIL-S-29138A, dated 18 August 1981, and is approved for use by all Departments and Agencies of the Department of Defense.

Page 1

2.1 - Delete and add the following:

"2.1 Government documents.

2.1.1 Specifications, standards, and handbooks. Unless otherwise specified, the following specifications, standards, and handbooks of the issue listed in that issue of the Department of Defense Index of Specifications and Standards (DoDISS) specified in the solicitation form a part of this specification to the extent specified."

SPECIFICATIONS, FEDERAL, add "NN-P-71 - Pallet, Material Handling, Wood, Stringer Construction, 2 Way and 4 Way" and "DDD-T-86 - Tape, Textile Cotton, General Purpose (Unbleached, Bleached or Dyed)"

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

STANDARDS, MILITARY, after "MIL-STD-129", add "MIL-STD-147 - Palletized Unit Loads".

Before "LAWS AND REGULATIONS" add new paragraph:

"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."

FSC 8410

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Add new paragraph:

"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 shall take precedence."

3.2, line 4, add new sentence: "The standard sample is identified under Piece No. 86006."

Delete 3.4.1 in its entirety and substitute the following:

"3.4.1 Yarn. The yarn for knitting and for the sewing (lower thread) when applicable, shall consist of 100% virgin acrylic fibers, bean shaped cross section, 30% semi-dull 3 denier fiber, 30% semi-dull 5 denier fiber and 40% bright bi-component 2.5 denier high bulk fibers. The yarn shall be 2/24's (worsted count) (see 4.4.1)."

3.4.2, delete existing Table I and substitute the following:

"Table I - Physical requirements of knitted fabrics

Component	Stitch Type	Wales/inch minimum	Courses/inch minimum
Body	Jersey	8	11
Skirt	2X2 rib	-	18
Sleeves	Jersey	8	11
Cuffs	2X2 rib	-	18
Border/neck front	1X1 flat rib	15	13"

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3.4.2.4.2, line 4, delete "good" and substitute "fair".

line 4, delete "light laundering, and", substitute "light and laundering, and a minimum of good fastness to"

Delete 3.4.2.6 in its entirety and substitute the following:

"3.4.2.6 Dimensional stability. The finished sweater shall not shrink more than 2.0 percent nor elongate more than 2.0 percent in either the length (wale direction) or width (course direction) after being subjected to five (5) launderings. Testing shall be performed as specified in 4.5."

3.4.5, line 2, delete "type I" and substitute "type VI".

line 3, delete "classes 1, 2 and 3" and substitute "class 14".

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Add new paragraph:

"3.4.6 Tape reinforcement. The tape for reinforcing the shoulders shall be cotton, 1/4 inch in width, conforming to Type II, Class 3 of DDD-T-86, except that the minimum filling yarns per inch may be 58. The tape shall be dyed to approximate the shade of the knitted fabric."

3.7.1, line 5, add the following:

"The bight of all overedge stitched seams shall be 1/4 to 5/16 inch gauge."

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3.8.1, line 1, delete "Shape" and substitute "Shade".

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Table II, add the following before operation 1:

"NOTE: Caution should be taken to ensure that the bight of all 504 stitching be maintained at 1/4 to 5/16 inch for the entire length of the seam."

Operation 1b, delete in its entirety and substitute the following:

"b. The continuously knitted body and skirt, sleeves and cuffs shall each be cut from the same respective piece of material. The flat knit border may be cut from a separate piece of material. The length of all cut parts shall run in the wale direction. The color of the flat knit border shall match the color of the body and sleeves."

After "b." add new operation:

"c. All component parts of an individual sweater must be produced from the same yarn merge (dye lot)."

Operation 4, end of sentence - delete "period" "(.)" and add the following:

"simultaneously superimposing a length of shoulder reinforcement tape sufficient to extend the entire length of shoulder seam. The edge of tape shall be aligned evenly with the edges of the seam (see 3.4.6)."

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Table II, operation 5c - Add new sentence: "Or 2 1/2 to 3 inches of stitching chain may be buried in the closing seam by back latch tacking using a chain off thread back-tacking attachment JUKI-Z015 or equivalent."

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Table II, operation 7c - Add new sentence: "Or 2 1/2 to 3 inches of stitching chain may be buried in the closing seam by back latch tacking using a chain off thread back-tacking attachment JUKI-Z015 or equivalent."

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Table II, operation 13, delete in its entirety and substitute the following:

"13. Finishing. The finished sweater shall be washed, softened, tumble dried and steamed to remove wrinkles without allowing steam to be applied to the rib knit cuffs and skirt."

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3.9, delete measurements of Table III and substitute the following:

Table III - Finished Measurements (inches)

Measurement	S(30-32)	M(34-36)	L(38-40)	XL(42-44)	Tolerance
Bust(A)	33	36	39	42	$\pm 1$
Bottom width at skirt(B)	26	28 1/2	31	33 1/2	$\pm 1$
Length(C)	22	22	23	23	$\pm 1, - 1/2$
Sleeve inseam(D)	18	18	18	18	$\pm 1$
Sleeve width(E)	6 1/8	6 1/8	6 1/8	6 1/8	$\pm 1/2$
Width across shoulders(F)	13 1/2	14 1/2	15 1/2	16 1/4	$\pm 1/2$
Cuff width(G)	3 1/8	3 1/8	3 1/4	3 1/4	$\pm 1/4$

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3.10, delete existing Table IV and substitute the following:

Table IV - Weights of finished sweaters

	S(30-32)	M(34-36)	L(38-40)	XL(42-44)
Wgt/dozen	7 lb	8 lb	8 lb	8 lb
(min)	10 oz		10 oz	14 oz
conditioned lbs				

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4.4.2.1, Seams and Stitching, delete "b" in its entirety and substitute:

"b. Gage of stitching:

1. For all stitch types other than 504:  
Irregular, not within range specified, or varies more than 1/16 inch when no range is specified (Score only when the condition exists on more than 1/2 the length of seam) - Minor
2. For all 504 stitch types:  
Irregular, not within range specified (Score even when the condition exists for less than 1/2 the length of the seam) - Major

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4.4.2.1, end of table - add new section:

Defect	Classification	
	Major	Minor
<u>"Shoulder reinforcement tape</u>		
a. Omitted	X	
b. Not attached as specified		X
c. Shade of tape not approximating shade of main assembly		X"

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Add the following new paragraph:

"4.4.4 Palletization examination. An examination shall be made to determine that the palletization complies with the section 5 requirements below. 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 AQL, expressed in terms of defects per hundred units, shall be 6.5.

<u>Examine</u>	<u>Defect</u>
Finished dimensions	Length, width, or height exceeds specified maximum requirements.
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."

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- 5.2.1, line 3, delete "SF" and substitute "CF";  
line 4, delete "grade V2s, size 3" and substitute "variety DW, grade V15c, size 3A"  
line 4, after "MIL-B-17757.", add "The fiberboard for the box liner shall conform to type CF, class domestic of MIL-B-17757."
- 5.2.2, line 4, delete "size 3" and substitute "variety DW, size 3A";  
line 4, after "MIL-B-17757.", add "The fiberboard for the box liner shall conform to type CF, class domestic of MIL-B-17757."

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Delete 5.2.2.1 in its entirety.

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Add the following new paragraph:

"5.4 Palletization. When specified (see 6.2), sweaters, 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, V, or VIII, Class 1, Style A, Size 2, wood group I, II, III or IV, Grade A of NN-P-71, or 4-way, Style 1, Size A, Type I, Class 1 of wood group I, II, III, or IV, grade A of 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.

Delete 6.2c in its entirety and substitute the following:

"c. When first article inspection is required, the item will be tested and should be a first article sample. The Contracting Officer should include specific instructions in acquisition documents regarding arrangement for examinations, quantity, and testing and approval."

Delete 6.2e in its entirety and substitute "e. When palletization is required (see 5.4)."

Delete 6.4 in its entirety.

Delete footnote 1/ in its entirety.

Custodian:  
Navy - NU

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