

MIL-STD-657A

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SUPERSEDING

MIL-STD-657

27 September 1974

MILITARY STANDARD
PROVISIONS FOR EVALUATING QUALITY
OF
SERVICE CAPS



FSC 8405

MIL-STD-657A

DEPARTMENT OF DEFENSE

WASHINGTON, DC 20301

Provisions for Evaluating Quality of Service Caps.

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1. This Military Standard is approved for use by all Departments and Agencies of the Department of Defense.
2. 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 Command (GL), ATTN: DRDWA-ES, 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.

FOREWORD

This standard provides a standardized procedure for evaluating quality of service caps procured by the Department of Defense.

The objectives of this standard are to.

- a. Provide standard description for defects
- b. Standardize examination requirements

Specifications that will reference this standard are:

<u>SPECIFICATION</u>	<u>TITLE</u>
MIL-C-3095	- Cap, Service, Air Force, Man's
MIL-C-13998	- Cap, Service, Wool, Army Green 64
MIL-C-43415	- Cap, Service, Military Police, White
MIL-C-43563	- Cap, Service, Army Band, Blue

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1. SCOPE

1.1 Purpose. The purpose of this standard is to provide standardized provisions for evaluating the quality of service caps.

1.2 Application. This standard will be made applicable to contracts by reference in MIL-C-3095, MIL-C-13996, MIL-C-43415 and MIL-C-43563. These documents require: (a) as a final step in the contractor's production control plan before formation of a lot, each cap shall be examined for the selected defect stated and (b) a cap containing this selected defect shall not be included in the end item lot. The selected defect is that defect listed in table II which is identified by an asterisk (*) in the Point value column. The selected defect is stated separately in table III.

2. REFERENCED DOCUMENTS

2.1 Issues 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 standard to the extent specified herein.

STANDARDS

FEDERAL

FED-STD-4 - Glossary of fabric imperfections

MILITARY

MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes

MIL-STD-109 - Quality Assurance Terms and Definitions

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

3. DEFINITIONS

3.1 Fabric defects. The fabric defect definitions applicable to the standard are described in FED-STD-4.

3.2 knots and slubs. Only knots and slubs that exceed the limits specified in the basic cloth specification shall be scored as defects in evaluating quality of the service cap.

3.3 quality assurance terms and procedures. Definitions of quality assurance terms and procedures, where applicable, shall be in accordance with MIL-STD-105 and MIL-STD-109.

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3.4 Open seam. A seam shall be classified as open when one or more stitches joining a seam are broken or runoff, or when two or more continuous skipped stitches occur.

3.5 Raw edge. A raw edge is defined as any edge not finished as specified including any protruding edge on the outside of the cap.

3.6 Defective button. A button shall be considered defective when it has sharp rough, cracked, or split edge, has scratch, dent, blemishes, imbedded foreign matter, loose shank, or loose shell; or is badly shaded.

3.7 Outside-inside. The terms outside and inside as used in this standard are defined as follows.

Outside - Any part of cap that is visible when the cap is positioned as worn, at shoulder level height, and examined from a distance of three feet (1 m). The cap shall be completely rotated.

Inside - Any part of cap that is not visible when the cap is positioned as worn, at shoulder level height, and examined from a distance of three feet (1 m). The cap shall be completely rotated.

3.8 Puckering. In the course of the sampling examination, seams suspected of being puckered shall be examined at a distance of 3 feet (1 m) in comparison with the NATCC photographic comparative rating (see 7.1) for seams. Puckering on a major portion of the suspected seam that equals or is worse than rating 3 for single needle seams shall be scored as a puckered seam.

4. GENERAL

4.1 This standard contains the provisions for end item examination, dimensional examination, and packaging inspection for service caps. If there are any inconsistencies between the requirements of the appropriate cap specification and the provisions of this standard, the cap specification shall control. This standard assigns to the listed defects, point values of 1, 2, or 3 depending on severity. The higher point values are assigned to those defects having more detrimental effect on the appearance or serviceability of the item. The defect identified by an asterisk (*) in the Point value column of table II is the defect having the most detrimental effect on the appearance or serviceability of the item.

5. SAMPLE AND INSPECTION PROVISIONS

5.1 End item examination. The caps shall be examined and all defects shall be penalized as indicated in table II of this standard. The sample size based on lot size shall be as specified in table I. The sample unit shall be one finished cap. The lot shall be unacceptable if.

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a. The point value for 3 and 2 point defects exceeds the applicable maximum acceptable point value.

— or —

b. The point value for total (3, 2, and 1 point) defects exceeds the applicable maximum acceptable point value.

— or —

c. The number of selected defects (see 1.2) exceeds the maximum allowed or the sample size (see table I).

5.2 Dimensional examination. The appropriate number of caps, determined from the table below, shall be examined for conformance to the dimensional requirements cited in the table of measurements of the appropriate cap specification. When a head size measurement deviates from a dimension and tolerance specified, the cap shall be penalized three points. When a measurement other than head size deviates from the dimension and tolerance specified, the cap shall be penalized one point. The lot shall be unacceptable if the total point value resulting from this examination exceeds the maximum acceptable point value. Each size of cap present in the lot should be represented in the sample selected for this examination.

Sampling provisions for dimensional examination

<u>Lot size</u>	<u>Sample size</u>	<u>Maximum acceptable point values</u>
Up thru 500	5	2
501 thru 3,200	13	3
3,201 thru 35,000	20	5
35,001 and over	32	7

5.3 Packaging inspection. An examination shall be made to determine that reservation-packaging, packing, and marking requirements are in compliance with section 5 of the appropriate cap specification. Defects listed below shall be scored one point. The sample size for this examination shall be five shipping containers fully prepared for delivery with the exception that they need not be closed. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot shall be unacceptable if one or more points are scored for this examination.

<u>Examine</u>	<u>Defect</u>
Marking (exterior and interior)	Omitted; incorrect, illegible or improper size, location, sequence, or method of application.
Materials	Any component missing, damaged, or not as specified.

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<u>Examine</u>	<u>Defect</u>
Workmanship	Inadequate application of components, such as. incomplete closure of container flaps, loose strapping improper taping, inadequate stapling. Open and non-continuous heat sealed seams and closure of polyethylene bag. Incorrectly fabricated bag. Mechanical tie (used for closure of bag) omitted. Bulged or distorted container.
Content	Number of intermediate packages per shipping container is more or less than required. Number of caps per intermediate package is more or less than required. <u>1/</u> Size shown on one or more caps not as specified on shipping container. <u>1/</u>

1/ For this defect, one intermediate package from each shipping container in the sample shall be examined.

6. INSPECTION

6.1 Inspection procedures. Inspection shall be as specified in MIL-STD-105 except where otherwise indicated in this document.

6.2 Initiation of inspection. Normal inspection shall be used at the start of inspection unless otherwise directed by the responsible procurement quality assurance element administering the contract.

6.3 Continuation of inspection. Normal, tightened, or reduced inspection shall continue unchanged on successive lots except where switching procedures in 6.4 require change.

6.4 Switching procedures.

6.4.1 Normal to tightened. When normal inspection is in effect, tightened inspection shall be instituted when two out of five consecutive lots have been rejected on original inspection (i.e., ignoring resubmitted lots for this procedure).

6.4.2 Tightened to normal. When tightened inspection is in effect, normal inspection shall be instituted when five consecutive lots have been considered acceptable on original inspection.

6.4.3 Normal to reduced. When normal inspection is in effect, reduced inspection shall be instituted providing that all of the following conditions are satisfied:

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a. The preceding 10 lots have been on normal inspection and none have been rejected on original inspection, and

b. The total number of points for 3 and 2 point defects in the samples from the preceding 10 lots is equal to or less than 60 percent of the total maximum acceptable point values for 3 and 2 point defects from the preceding 10 lots, and

c. The total number of points for 3, 2, and 1 point defects in the sample from the preceding 10 lots is equal to or less than 75 percent of the total maximum acceptable point values for 3, 2 and 1 point defects from the preceding 10 lots; and

d. Production is at a steady rate, and

e. Reduced inspection is considered desirable by the procurement quality assurance element administering the contract.

6.4.4 Reduced to normal. When reduced inspection is in effect, normal inspection shall be instituted if any of the following occur on original inspection.

a. A lot is rejected, or

b. A lot is considered acceptable but exceeds the applicable first value (see 1/ to table I) or

c. Production becomes irregular or delayed or

d. Other conditions warrant that normal inspection be instituted.

7. NOTES

7.1 Source for comparative rating of single needle seams. The AATCC Photographic Comparative Rating of Single Needle Seams (Method 88B, 2 photos) is available from:

The American Association of Textile Chemists and Colorists
P.O. Box 12215
Research Triangle Park, NC 27709

7.2 Metric equivalents. Metric equivalents, indicated in parentheses throughout this document, are based on practices, conversion factors, and symbols specified in ASTM E 380 Standard for Metric Practice, and are for information only. In each instance, the value stated in US customary units shall be controlling.

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TABLE I. Sampling provisions for end item examination

	Lot size	Sample size	Maximum acceptance number for selected defects (see 1.2)	Maximum acceptable point values	
				3 and 2 point defects	3, 2, and 1 point defects
Normal inspection	Up thru 50	20	0	3 points	9 points
	51 thru 150	32	0	5 points	13 points
	151 thru 280	50	0	8 points	19 points
	281 thru 500	80	0	14 points	30 points
	501 thru 1200	125	1	19 points	42 points
	1201 thru 3200	200	1	27 points	61 points
	3201 thru 10,000	315	2	38 points	88 points
	10,001 thru 35,000	500	3	57 points	129 points
35,001 and over	800	5	81 points	186 points	
Tightened inspection	Up thru 50	20	0	2 points	7 points
	51 thru 150	32	0	3 points	10 points
	151 thru 280	50	0	5 points	15 points
	281 thru 500	80	0	8 points	23 points
	501 thru 1200	125	1	14 points	36 points
	1201 thru 3200	200	1	22 points	55 points
	3201 thru 10,000	315	2	32 points	82 points
	10,001 thru 35,000	500	3	49 points	124 points
35,001 and over	800	5	73 points	186 points	
Reduced inspection	Up thru 50	8	0	0-5 points	9 points
	51 thru 150	13	0	3-8 points	13 points
	151 thru 280	20	0	3-11 points	17 points
	281 thru 500	32	0	5-14 points	22 points
	501 thru 1200	50	0	8-16 points	27 points
	1201 thru 3200	80	0	14-22 points	38 points
	3201 thru 10,000	125	1	19-27 points	48 points
	10,001 thru 35,000	200	1	27-35 points	67 points
35,001 and over	315	2	35-44 points	94 points	

1/ If the first value is exceeded but the second value has not been exceeded, accept the lot but reinstate normal inspection (see 6.4.4c). The second value is the maximum acceptable point value.

TABLE 11. Classification of Defects

Defect	Point value
I. MATERIAL DEFECTS AND WORKMANSHIP DAMAGE	
a. Basic fabric and lining	
1. Any hole, cut, tear, smush, drill hole, needle chew, or open place.	
(a) On outside (see 3.7) (longest dimension in any direction):	
(1) Up to 1/6 inch (6 mm), inclusive	2
(2) More than 1/4 inch (6 mm)	3
(b) On inside (see 3.7) (longest dimension in any direction):	
(1) Up to 1/4 inch (6 mm), inclusive	1
(2) More than 1/4 inch (6 mm)	2
2. Knot or slub (see 3.2) on outside	2
3. Loose yarn, snagged yarn, misweave, coarse yarn, area of no dye penetration, dye streak, missing yarn, broken yarn, thin place, shade bar, woven in waste, or float.	
(a) On outside (longest dimension in any direction):	
(1) Up to 1/4 inch (6 mm), inclusive	1
(2) More than 1/4 inch (6 mm)	2
4. Permanent fold, pleat, or crease in cloth (when caught in seaming or stitching) on outside	3
b. Braid.	
1. Broken or missing yarn	
(a) One	1
(b) Two	2
(c) Three or more	3
2. Not evenly braided	2
3. Slack, cut, frayed, or uneven edge	3
c. Leather	
1. On outside	
(a) Hole, scar, cut, tear, crack, or peel	3
(b) Soft, spongy, flaky, or stretched (i.e. showing a coarse grain soft spot or uneven appearance)	2
(c) Scratch or wrinkle	2
(d) Vein mark within 1 inch (25 mm) of the center of visor	2
(e) Three or more vein marks more than 1 inch (25 mm) from the center of visor	2

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TABLE II. Classification of defects (cont'd)

Defect	Point value
I. MATERIAL DEFECTS AND WORKMANSHIP DAMAGE (cont'd)	
2. On underside of visor	
(a) hole, crushed, cut, or tear	2
(b) Scratch, crack, peel, scar, wrinkle, or flaky	1
a. Vinyl (visor, chinstrap, or binding) on outside.	
1. Hole, cut, tear, crack, scratch, wrinkle, or peel	2
2. Spot or stain	3
3. Rough or uneven edge	2
II. SHADED PART	
a. On outside.	
1. Variation in shade within a part or between two or more parts.	2
III. LOCKING	
a. Omitted	3
b. Distorted crown or crown gear	2
c. Cap not symmetrical	2
d. Burned or scorched	3
IV. CLEANNESS	
a. Any spot or stain:	
1. On outside (longest dimension in any direction).	
(a) Up to 3/8 inch (10 mm)	2
(b) More than 3/8 inch (10 mm)	3
2. On inside	1
b. Any shade marking exposed or visible on outside	2
c. Thread ends on outside	
1. More than one but not more than three not trimmed to less than 3/8 inch (10 mm)	1
2. More than three not trimmed to less than 3/8 inch (10 mm)	2
d. Visible basting thread not removed	1
e. One or more shade or size tickets not removed	1

TABLE II. Classification of defects (cont'd)

Defect	Point value
V. COMPONENT AND ASSEMBLY	
a. Any component part or operation omitted (unless otherwise classified herein)	3
b. Any component not as specified	3
c. Any component part tight, twisted, distorted, pleated, or full (unless otherwise classified herein)	2
d. Any operation not performed as specified (unless otherwise classified herein)	1
VI. CUTTING	
a. Any component part not cut in accordance with specified pattern, directional lines on patterns, or specification requirements	3
b. Mill line of any outside part not running in specified direction	3
VII. SEAMS AND STITCHING	
a. Accuracy of sewing	
1. Seam puckered (score only when on major portion of seam) (see 3.8)	1
2. Seam irregular, pleated or wavy	2
3. Any part of cap caught in any unrelated operation or stitching	2
4. End of stitching when not caught in another seam or stitching not finished as specified	1
5. Stitching overlapping end of thread break less than 1/2 inch (13 mm)	1
6. End of a continuous line of stitching overlapped less than 1/2 inch (13 mm)	1
7. Not specified color or varying shades of thread used on outside	2
b. Gage of stitching and seam allowance	
1. Edge, top, or raised stitching sewn too close to edge resulting in damage to cloth	3
2. Seam allowance not as specified by 1/16 inch (2 mm) or more (score only when condition exists on more than 1/2 the length of the seam)	2

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TABLE II. Classification of defects (cont'd)

Defect	Point value
VII. SEAMS AND STITCHING (cont'd)	
b. Gage of stitching and seam allowance. (cont'd)	
3. Irregular or not within range specified or varies more than 1/16 inch (2 mm) when no range is specified (score only when condition exists on more than 1/2 the length of the seam)	1
c. Open seam (see 3.4).	
1. On outside:	
(a) More than 1/2 inch (13 mm)	3
(b) More than 1/4 inch (6 mm) up to 1/2 inch (13 mm)	2
(c) Up to 1/4 inch (6 mm) inclusive	1
2. On inside:	
(a) More than 1 inch (25 mm)	3
(b) More than 1/4 inch (6 mm) up to 1 inch (25 mm) inclusive	2
(c) Up to 1/4 inch (6 mm) inclusive	1
d. Raw edge.	
1. On outside:	
(a) Up to 3/16 inch (5 mm) inclusive	2
(b) More than 3/16 inch (5 mm)	3
2. On inside:	
(a) More than 1/4 inch (6 mm) (wherever applicable)	2
e. Seam and stitch type.	
1. Not specified seam or stitch type	2
2. Any line of stitching omitted	3
3. Any line of stitching not beginning or ending where specified (unless otherwise classified herein)	1
4. Loper thread of 401 stitch type on outside	3
f. Stitch tension.	
1. Loose tension resulting in a loose seam	2
2. Loosely exposed loops of lower or top thread on edge, top, or raised stitching	2
3. Tight tension (stitches break when normal strain is applied in the direction of the seam or stitching)	3
g. Stitches per inch (score only when condition exists on more than 1/2 the length of seam).	
1. More than the maximum specified	1
2. Less than the minimum specified	
(a) By one or two stitches	1
(b) By three or more stitches	2

TABLE II. Classification of defects (cont'd)

Defect	Point value
VII. SEAMS AND STITCHING (cont'd)	
a. Runoff, skipped or broken stitch.	
1. Joining seam - use Open seam classification	-
2. Top or raised stitching:	
(a) 1/4 inch (6 mm) up to 1/2 inch (13 mm) inclusive	1
(b) More than 1/2 inch (13 mm)	2
VIII. VISOR	
a. Placed off-center with center of center eyelet by	
1. More than 1/8 inch (3 mm) up to 1/4 inch (6 mm) inclusive	1
2. More than 1/4 inch (6 mm) up to 3/8 inch (10 mm) inclusive	2
3. More than 3/8 inch (10 mm)	3
b. Insecurely stitched to inside of band or stitched on outside of band	3
c. One piece construction, not securely laminated or not molded to proper shape	3
d. Distance from center of center eyelet to point of entry of ends of visor varying more than 1/4 inch (6 mm)	1
e. Skiving on inside edge omitted or folded edge of binding strip finished on underside	2
f. Width of binding not as specified on top or bottom of piece	2
g. Binding strip omitted	3
IX. VISOR WELT	
a. Welt insecurely caught in stitching of visor to inside of inner body band or end of welt not securely stapled	2
b. End of welt not finished as specified	1
c. Pressed fiber strip not inserted into entire width of welt piece, failing to reinforce folded edge of welt	2
X. C.I. STRAP	
a. Loop not securely stitched as specified to strap with double row of stitching, insecurely riveted or stapled	2

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TABLE II. Classification of defects (cont'd)

Defect	Point value
X. CHIN STRAP (cont'd)	
b. Length of each section from end of strap to end of loop not as specified	2
c. Hole misplaced or not specified diameter	1
d. Hole off-center of strap by more than 1/16 inch (2 mm)	1
e. Edge of strap or loop not stained or poorly stained	1
f. End of loop not secured with two staples or embossed line omitted or not clearly visible when examined	1
g. Rivet chipped, broken, or bent	2
h. Chin strap loosens in examination of cap	1
XI. BUTTON OR SOCKET POST	
a. Thread on button post or socket post defective	2
b. Broken, bent, tarnished or loose	2
c. Post insecurely stapled or stitched	1
d. Center of socket post	
1. Less than specified distance from bottom edge of cap	1
2. Less than specified distance from center front of cap	1
XII. BAND	
a. Outside puckered, pleated, twisted, or gathered	2
b. Back seam of band and back quarter seam not aligned by.	
1. More than 1/8 inch (3 mm) up to 1/4 inch (6 mm) inclusive	1
2. More than 1/4 inch (6 mm)	2
c. Back seam not stitched on each side of joining seam or not pressed open as specified	2
d. Stitching along bottom edge of braid less than 1/16 inch (2 mm) or more than 1/8 inch (3 mm) from edge of braid or stitching not through inner body band on air force cap	1
e. Bottom edge of braid less than 1/8 inch (3 mm) or more than 1/4 inch (6 mm) above bottom edge of finished cap	1
f. Top edge of braid not caught in joining seam at top by 1/16 inch (2 mm) or more	2
g. Inner body band crushed, creased, or cut	2
h. Ends of inner body band not finished or secured as specified	1
i. Ends of reinforcement strip not finished as specified	1

TABLE II. Classification of defects (cont'd)

Defect	Point value
III. EYELET	
a. One or more omitted or added	3
b. Cracked, broken, split, or bent	3
c. Fabric cut, puckered, or pleated	2
d. Not securely clinched	2
e. Center eyelet.	
1. Not inserted through front stay	3
2. Eyelet center not positioned as specified	2
f. Side eyelet.	
1. Eyelet center less than 7/8 inch (22 mm) or more than 1-1/8 inches (29 mm) from side quarter seam	2
2. Eyelet center not specified distance above band joining seam	2
3. Center of both eyelets (on same side of cap) unevenly spaced from side quarter seam or band joining seam by more than 1/8 inch (3 mm)	2
4. Distance from center of center eyelet to center of side eyelets varying more than 1/4 inch (6 mm)	2
g. Snapped	1
IV. FRONT PIECE OR SIDE QUARTER	
a. Outside puckered, pleated, or twisted	2
b. Side seam or center back seam	
1. Twisted or distorted, i.e., not fitting in vertical position by	
(a) more than 1/8 inch (3 mm) up to 1/4 inch (6 mm) inclusive	1
(b) more than 1/4 inch (6 mm)	2
2. Not stitched on each side of seam as required	2
c. Interfacing or facing, not positioned as specified from top edge of lining	1
d. Front stiffener not positioned as specified on front quarter	1
V. CROWN	
a. Length dimension not extending from center of front piece to center back joining seam	3
b. Outside puckered, pleated, or twisted	2
c. Poorly shaped or distorted	2

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TABLE II. Classification of defects (cont'd)

Defect	Point value
XV. CROWN (cont'd)	
d. Crown joining not pressed open or not stitched on each side	2
e. Lining, basting stitching, exposed on outside	2
f. Crown protector piece.	
1. Broken, cracked, torn, twisted, puckered, or pleated	2
2. Not centered on crown lining as specified	2
3. Too tight or loose i.e., not flat against crown lining	1
g. Bias tape.	
1. Not caught in both rows of raised stitching of crown seam	2
2. End and side not finished as specified	1
XVI. SWEATBAND	
a. Leather not specified type, finish, or color	2
b. Edge of sweatband or felling stitches exposed and visible on outside	2
c. Puckered, twisted, or pleated	2
d. Cushioning effect not on front	1
e. Stamped size on inside of sweatband missing or incorrect	1
f. Back seam twisted, puckered, bulky, or (abutted edges) out of alignment with bend seam by 1/4 inch (6 mm) or more	2
g. Embossed imitation turn-of-line omitted on top edge of sweatband by more than 1/4 inch (6 mm)	1
h. Strip of cotton fabric extends beyond top edge of sweatband by more than 1/4 inch (6 mm)	1
XVII. FRONT STAY	
a. Not securely caught in stitching of crown and front piece at top or bottom edge	2
b. Elastic or cotton warp/ rayon filling cloth piece not caught in stitching across top of stay	1
c. Placed off center with center of front piece by	
1. More than 1/8 inch (3 mm) to 1/4 inch (6 mm) inclusive	1
2. More than 1/4 inch (6 mm)	2

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TABLE II. Classification of defects (cont'd)

Defect	Point value
.VII. FRONT STRAP (cont'd)	
a. Black material not caught in both vertical rows of stitching, not against brads, or not specified height	1
e. Plastic or cotton warp/rayon filling cloth visible on inside of cap	2
.IV.II. GROUSET	
a. Spring steel wire omitted	2
b. Too large or too small, affecting function	2
c. Ends of grommet not properly joined as specified	1
.III. COORDINATION IDENTIFICATION AND SIZE LABEL	
a. Missing, incorrect, or illegible	3
b. Not securely caught in stitching or not positioned as specified	1
.II. CARDCARD INSTRUCTION LABEL	
a. Omitted, incorrect, or illegible	1

TABLE III. Selected defect

VISOR - Placed off-center with center of center eyelet by more than 3/8 inch.

Custodians.

Preparing activity

Army - GL

Army - GL

Air Force - 11

Project No. 6405-0689

Review activity.

Air Force - 99

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