

MIL-STD-901A  
 NOTICE-1  
7 October 1982

MILITARY SPECIFICATION  
 PROVISIONS FOR EVALUATING QUALITY  
 OF  
 CAPS, GARRISON, MEN'S

TO ALL HOLDERS OF MIL-STD-901A:

1. THE FOLLOWING PAGES OF MIL-STD-901A HAVE BEEN REVISED AND SUPERSEDE THE PAGES LISTED:

NEW PAGE	DATE	SUPERSEDED PAGE	DATE
1	14 June 1977	(Reprinted without change)	
2		2	14 June 1977
3	14 June 1977	(Reprinted without change)	
4		4	14 June 1977
7		7	14 June 1977
8	14 June 1977	(Reprinted without change)	

2. RETAIN THIS NOTICE AND INSERT BEFORE TABLE OF CONTENTS.

3. Holders of MIL-STD-901A will verify that page changes and additions indicated above have been entered. This notice page will be retained as a check sheet. This issuance, together with appended pages, is a separate publication. Each notice is to be retained by stocking points until the Military Standard is completely revised or cancelled.

Custodians:

Army - GL  
 Navy - NU  
 Air Force - 11

Preparing activity:

Army - GL  
 Project No. 8405-0783

Review activities:

Air Force - 99  
 DLA - CT

User activity:

Navy - MC

FSC 8405

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## 1. SCOPE

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

1.2 Application. This standard will be made applicable to contracts by reference in MIL-C-3261, MIL-C-17614, MIL-C-21181, MIL-C-21295, MIL-C-24012 and MIL-C-43419.

## 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. Definitions of fabric defects, where applicable, shall be in accordance with 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 finished 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.

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. Double stitched seams are considered open when one or both rows of stitching are open.

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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 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 examined from a distance of 3 feet (1 m) at shoulder level height and positioned as worn. The cap shall be completely rotated.

Inside - Any part of cap that is not visible when the cap is examined from a distance of 3 feet (1 m) at shoulder level height and positioned as worn. The cap shall be completely rotated.

3.7 Puckering. In the course of the sampling examination, seams suspected of being puckered shall be examined with the cap lying flat on the inspection table at a distance of 3 feet (1 m) and shall be rated in comparison with the AATCC photographic comparative rating (see 7.1) for seams. Puckering on a major portion of the suspected seam that is worse than rating 4 for single needle seams or 4 for double 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 garrison caps. If there are any inconsistencies between the requirements of the appropriate cap specification and the provisions of the standard, the cap specification shall control. This standard assigns to the listed defects, point values of 1, 2, or 3 depending on degree of severity. The higher point values are assigned to those defects having more 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 as indicated in 3.6 for all defects except puckering. The puckering examination shall be as described in 3.7. All defects shall be penalized as indicated in table II of this standard. The sample size shall be based on lot size, and the acceptance values for 3 and 2 point defects and total (3, 2, and 1 point) defects shall be as specified in table I. The sample unit shall be one finished cap. The lot shall be unacceptable if:

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.

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5.2 Dimensional examination. The sample size for dimensional examination shall be based on lot size as shown in the table below. The caps shall be examined for conformance to the dimensional requirements cited in the table of measurements of the appropriate cap specification. When a measurement deviates from a dimension and tolerance specified, the cap shall be penalized 1 point. The lot shall be unacceptable if the total point value resulting from this examination exceeds the maximum acceptable point value for the lot. 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	8	0
501 thru 3,200	13	1
3,201 thru 35,000	20	2
35,001 and up	32	3

5.3 Packaging inspection. An examination shall be made to determine that preservation-packaging, packing, and marking requirements are in compliance with section 5 of the appropriate cap specification. Defects listed below shall be scored 1 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 1 or more points are scored for this examination.

<u>Examine</u>	<u>Defect</u>
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.
Workmanship	Inadequate application of components, such as: incomplete closure of container flaps, loose strapping, improper taping or improper adhesive application, inadequate stapling. Open and noncontinuous heat sealed seams and closure of polyethylene bag. <u>1/</u> Alternative closure of polyethylene bag not provided with tuck or reverse flap. <u>1/</u> Omission of vent hole in polyethylene bag. <u>1/</u> Incorrectly fabricated bag. <u>1/</u> Bulged or distorted container.

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<u>Examine</u>	<u>Defect</u>
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>2/</u> Size shown on one or more caps not as specified on shipping container. <u>2/</u>
Preservation (Naphthalene flakes)	Improperly applied or missing. <u>1/</u>

1/ When applicable.

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

## 6. INSPECTION

6.1 Inspection procedures. Inspection procedures 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 a 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:

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

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TABLE II. Classification of defects

Defect	Point value
<b>I. <u>MATERIAL DEFECTS AND WORKMANSHIP DAMAGE</u></b>	
a. Any hole, cut, tear, smash, mend, needle chew, drill hole, or open place:	
1. On outside (see 3.6) (longest dimension in any direction):	
(a) - up to 1/4 inch (6 mm), inclusive	2
(b) - more than 1/4 inch (6 mm)	3
2. On inside (see 3.6) (longest dimension in any direction):	
(a) - up to 1/4 inch (6 mm), inclusive	1
(b) - more than 1/4 inch (6 mm)	2
b. Loose yarn, snagged yarn, misweave, float, coarse yarn, area of no dye penetration, dye streak, missing yarn, broken yarn, thin place, shade bar, or woven in waste:	
1. On outside (longest dimension in any direction):	
(a) - up to 1/4 inch (6 mm), inclusive	1
(b) - more than 1/4 inch (6 mm)	2
c. Permanent fold, pleat, or crease in cloth (when caught in seaming or stitching):	
1. On outside	3
d. Leather:	
1. Cracked, cut, or thin weak spot	2
2. Spongy, flanky or stretched (showing a coarse grain and uneven appearance)	2
3. Any scar, wrinkle, or scratch visible at a distance of 3 feet (1 m)	2
4. Finish on leather peeling off	2
5. Needle chews in leather	2
e. Knot or slub (see 3.2) on outside	2
<b>II. <u>SHADED PART</u></b>	
a. On outside:	
1. Variation in shade within a part or between two or more parts	2
<b>III. <u>PRESSING</u></b>	
a. Burned or scorched	3
b. Blocking or pressing omitted	2
c. Poorly pressed	1
d. Pressing impression or gloss on outside of cap	1
e. Bottom edge of cap not pressed as specified	1
f. Curtain at front or back edge not pressed as specified	1

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TABLE II. Classification of defects (cont'd)

Defect	Point value
<b>IV. <u>CLEANNESS</u></b>	
a. Any spot or stain on outside visible at 3 feet (1 m) (largest dimension in any direction):	
1. Up to 1/4 inch (6 mm) inclusive	2
2. More than 1/4 inch (6 mm)	3
b. Any marking exposed or visible on outside	3
c. Thread ends on inside and 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
3. Three or more loose threads not removed	1
d. One or more shade or size tickets not removed	1
e. Thread end caught for a distance of more than 1/4 inch (6 mm) in line of stitching on outside	1
f. Visible basting thread not removed	1
<b>V. <u>COMPONENT AND ASSEMBLY</u></b>	
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 as specified (unless otherwise classified herein)	2
<b>VI. <u>CUTTING</u></b>	
a. Any component part not cut in accordance with speci- fied pattern, directional lines on patterns, or not in accordance with specification requirements	3
b. Twill line of any outside part not running in speci- fied direction	3

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