

INCH-POUND

MIL-STD-1394B

6 November 1989

SUPERSEDING

MIL-STD-1394A

22 January 1981

MILITARY STANDARD  
PROVISIONS FOR EVALUATING QUALITY  
OF  
CAP CROWNS



AMSC N/A

FSC 8405

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MIL-STD-1394B

FOREWARD

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: Officer in Charge, Navy Clothing and Textile Research Facility, 21 Strathmore Road, Natick, MA 01760-2490, by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

3. This standard provides a standardized procedure for evaluating quality of cap crowns procured by the Department of Defense.

The objectives of this standard are to:

- (a) Provide standard descriptions for defects.
- (b) Standardize examination requirements.

As of the date of approval of this document, the following specifications will reference this standard:

MIL-C-17620	- Crown, Service Cap (Man's)
MIL-C-18186	- Crowns, Service Cap
MIL-C-23315	- Crowns, Service Cap: Tropical Worsted
MIL-C-26804	- Cover, Service Cap, Air Police, White
MIL-C-38182	- Cover, Service Cap, Man's, Water Repellant

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## 1. SCOPE

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

1.2. Application. This standard will be made applicable to contracts by reference in the appropriate cap crown specifications.

## 2. APPLICABLE DOCUMENTS

\* 2.1 Government documents.

\* 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).

## 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

(Unless otherwise indicated, copies of federal and military specifications, standards and handbooks are available from the Naval Publications and Forms Center, (ATTN: NPODS), 5801 Tabor Avenue, Philadelphia, PA 19120-5099.)

\* 2.2 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. Nothing in this document however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

## 3. DEFINITIONS

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

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3.2 Quality assurance terms. Definitions of quality assurance terms shall be in accordance with MIL-STD-105 and MIL-STD-109.

3.3 Open seam or stitching. The seam shall be classified open when one or more stitches joining a seam are broken or when two or more continuous skipped or runoff stitches occur.

3.4 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 Cap Crowns.

#### 4. GENERAL

4.1 This standard contains the provisions for end item examination, dimensional examination and the examination of packaging inspection for service cap crowns. If there are any inconsistencies between the requirements of the appropriate specification and the provisions of the standard, the 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. DETAILED REQUIREMENTS

5.1 End item examination. The cap crowns shall be examined and all defects shall be penalized as indicated in Table II of this standard. The sample size shall be as specified in Table I. The sample unit shall be one finished cap crown. 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.

Table I - Sampling Provisions

		Maximum Acceptable Point Values	
		3&2 Point Defects	3,2&1 Point Defects
	Lot Size	Sample Size	
Normal Inspection	Up thru 90	1/20	
	91 thru 150	32	3 points 5 points
	151 thru 280	50	5 points 8 points
	281 thru 500	80	8 points 13 points
	501 thru 1200	125	12 points 18 points
	1201 thru 3200	200	16 points 25 points
	3201 thru 10,000	315	24 points 37 points
	10,001 thru 35,000	500	32 points 47 points
	35,001 and over	800	48 points 75 points

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Table I - Sampling Provisions (Cont'd)

		Maximum Acceptable Point Values		
	Lot Size	Sample Size	3&2 Point	3,2,&1 Point
			Defects	Defects
Tightened Inspection	Up thru 90 1/	20		
	91 thru 150 1/	32		
	151 thru 280	50	3 points	5 points
	281 thru 500	80	5 points	8 points
	501 thru 1200	125	8 points	14 points
	1201 thru 3200	200	12 points	20 points
	3201 thru 10,000	315	18 points	30 points
	10,001 thru 35,000	500	28 points	45 points
	35,001 and over	800	42 points	68 points
		Maximum Acceptable Point Values		
	Lot Size	Sample Size	3&2 Point	3,2,&1 Point
			Defects 2/	Defects
Reduced Inspection	Up thru 90 1/	8		
	91 thru 150 1/	13		
	151 thru 280	20	3-5 points	7 points
	281 thru 500	32	4-7 points	9 points
	501 thru 1200	50	5-9 points	13 points
	1201 thru 3200	80	7-11 points	16 points
	3201 thru 10,000	125	12-16 points	22 points
	10,001 thru 35,000	200	16-20 points	29 points
	35,001 and over	315	23-27 points	41 points

1/ For this inspection use first sampling plan below. If sample size equals or exceeds lot or batch size, do 100 percent inspection.

2/ If the first value is exceeded but the second value has not been exceeded, accept the lot but reinstate normal inspection (see 5.7.4b). The second value is the maximum acceptable point value.

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Table II - Classification of DefectsPoint Value

## A. GENERAL DEFECTS

## I. MATERIAL DEFECTS AND DAMAGE

- |   |   |
|---|---|
| a. Hole, cut, tear, smash, mend, needle chew, burn, drill hole, scorched area or open place:  |   |
| 1. On outside (longest dimension in any direction):   |   |
| (a) up to 1/4 inch, inclusive   | 2 |
| (b) more than 1/4 inch  | 3 |
| 2. On inside (longest dimension in any direction):  |   |
| (a) up to 1/4 inch, inclusive   | 1 |
| (b) more than 1/4 inch  | 2 |
| b. Loose yarn, snagged thread, misweave, 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, inclusive   | 1 |
| (b) more than 1/4 inch  | 3 |
| 2. On inside  | 1 |
| c. Permanent fold, pleat or crease in cloth (when caught in seaming or stitching):  |   |
| - on outside  | 3 |
| d. Knot or slub (see 3.2) on outside  | 2 |
| e. Braid:   |   |
| 1. Poorly constructed (i.e., not evenly woven).   | 2 |
| 2. Cut or frayed edges, slack or poorly constructed edge.   | 2 |
| 3. Any broken yarn.   | 2 |

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Table II - Classification of Defects (cont'd)

	<u>Point Value</u>
f. MIL-C-38182	
1. Any pinhole, blister, pick-off in coating or coating flaky.	3
2. Coating uneven, lumpy, abraded or thin.	1
3. Coating tacky or contains imbedded foreign matter.	2
II. SHADED PARTS	
On outside:	
- any part shaded	2
III. CLEANNESS	
a. Any spot or stain:	
1. On outside (largest dimension in any direction):	
(a) up to 3/8 inch, inclusive	1
(b) more than 3/8 inch up to 3/4 inch inclusive	2
(c) more than 3/4 inch	3
2. On inside, but not visible on outside 3/4 inch or more	1
3. On inside and visible on outside (use outside defect classification listed above).	
b. Any marking exposed or visible on outside.	3
c. Three or more thread ends on outside not trimmed to 3/8 inch.	1
d. Two or more shade or size tickets not removed.	1
IV. 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 not assembled as specified.	3
d. Any component part tight, twisted, distorted, pleated or full (unless otherwise classified herein).	2
e. Any operation not as specified (unless otherwise classified herein).	1



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Table II - Classification of Defects (cont'd)

	<u>Point Value</u>
V. CUTTING	
a. Any component part not cut in accordance with specified pattern, directional lines on patterns or not in accordance with specification requirements.	3
VI. SEAM AND STITCHING	
a. Accuracy of seaming:	
1. Seam puckered (unless otherwise classified herein).	1
2. Seam irregular, pleated or wavy.	2
3. Part 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.	1
6. End of a continuous line of stitching overlapped less than 1/2 inch.	1
7. Not specified color thread used on outside.	2
b. Gage of stitching and seam allowance:	
1. Edge, top or raise stitching sewn too close to edge resulting in damage to cloth.	3
2. Seam allowance not as specified by 1/16 inch or more (score only when condition exists on more than 1/2 the length of the seam).	1
3. Irregular or not within range specified or varies more than 1/16 inch when no range is specified (score only when condition exists on more than 1/2 the length of the seam).	1
c. Open seam:	
1. More than 3/4 inch.	3
2. More than 3/8 inch up to 3/4 inch, inclusive.	2
3. Up to 3/8 inch, inclusive.	1
d. Raw edge:	
1. On outside	
(a) up to 3/8 inch, inclusive	1
(b) more than 3/8 inch up to 3/4 inch, inclusive	2
(c) more than 3/4 inch	3

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Table II - Classification of Defects (cont'd)

	<u>Point Value</u>
VI. SEAM AND STITCHING (cont'd)	
2. On inside:	
(a) 1/4 inch up to 1 3/4 inches, inclusive	1
(b) more than 1 3/4 inches	2
e. Seam and stitch type:	
1. Not specified seam or stitch type.	3
2. Any line of stitching omitted or insecure	2
3. Any line of stitching not beginning or ending where specified (unless otherwise classified herein).	1
4. Looper thread of 401 stitch type on outside.	3
f. Stitch tension:	
1. Loose tension resulting in a loose seam.	3
2. Loosely exposed loops of lower or top thread.	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
h. Runoff, skipped or broken stitch:	
1. Joining seam - use "open seam" classification.	-
2. Edge, top or raised stitching (more than 1/4 inch).	1
VII. EYELET	
a. One or more omitted or added.	3
b. Chipped, broken, cracked, split or bent.	3
c. Loose or raw edges exposed around edges of eyelet on outside.	3

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Table 41 - Classification of Defects (cont'd)

	<u>Point value</u>
VII. EYELET (cont'd)	
d. Not securely clinched or clinched too tightly cutting the fabric.	3
e. Washer broken, bent or otherwise defective (where required).	2
f. MIL-C-18186:	
1. Front eyelet:	
(a) front eyelet not reinforced on underside with brass washer	3
(b) front eyelet not set on front quarter seam	3
(c) positioned more than 1/16 inch off center	2
(d) front eyelet not centered with width of front quarter:	
(1) by more than 1/8 inch, but not more than 1/4 inch	2
(2) by more than 1/4 inch	3
2. Side eyelets (position):	
(a) side eyelets out of horizontal alignment:	
(1) by 1/4 inch or more but not more than 3/8 inch	2
(2) by more than 3/8 inch	3
(b) side eyelets misplaced from midpoint between crown and band by more than 1/4 inch	2
(c) position of side eyelets from each side of side seams less than 7/8 inch or more than 1 1/8 inches	2
VIII. BAND	
a. Outside puckered, pleated or twisted.	3
b. Other than one piece of material.	3
c. MIL-C-17620:	
1. The back seam formed when joining the ends of the band not pressed flat, when applicable.	1
2. The finished band less than 1 3/8 inches or more than 1 5/8 inches wide.	2

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Table II - Classification of Defects (cont'd)

## VIII. BAND (cont'd)

Point Value

- |  |   |
|--|---|
| 3. Overedge stitching in the joining of the band to the flare omitted.             | 1 |
| 4. The finished hem of band less than 1/4 inch or more than 3/8 inch wide.         | 1 |
| 5. The back seam not aligned with the back seam of the flare by 3/16 inch or more. | 1 |

## d. MIL-C-18186 and MIL-C-23315:

- |   |   |
|---|---|
| 1. Band less than 1 5/8 inches or more than 1 3/4 inches wide.        | 2 |
| 2. Irregular in width by more than 1/8 inch.                          | 2 |
| 3. Back seam not aligned with back quarter seam by 3/16 inch or more. | 2 |
| 4. Upperside twisted or too full, affecting smoothness on outside.    | 2 |
| 5. Band overlapping quarters at joining seam.                         | 3 |

## IX. BINDING (when applicable)

- |  |   |
|--|---|
| a. Omitted.  | 3 |
| b. Binding strip other than bias-cut.  | 1 |
| c. The binding strip not turned under and positioned evenly over the flare and top piece seam.         | 1 |
| d. The binding tape finished less than 7/16 inch or more than 9/16 inch wide on major portion of seam. | 1 |
| e. The end of binding tape overlapped less than 1 1/2 inches at center of back seam.                   | 1 |

## X. SNAP FASTENERS

- |  |   |
|--|---|
| a. Stud or socket missing, broken, bent, deformed or otherwise defective not permitting proper function. | 3 |
| b. Any socket out of alignment with corresponding stud causing noticeable bulge when fastened.           | 2 |
| c. Stud or socket clinched too tightly cutting the surrounding fabric.                                   | 3 |

## XI. LABEL

- |                                     |   |
|-------------------------------------|---|
| a. Missing, incorrect or illegible: |   |
| 1. Size or combination label.       | 3 |
| 2. Identification label.            | 1 |

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Table II - Classification of Defects (cont'd)

	<u>Point Value</u>
XI. LABEL (cont'd)	
b. Not attached as specified.	1
c. Misplaced or stitching through printing.	1
XII. CROWN PIECE OR TOP PIECE	
a. Other than one piece.	3
b. MIL-C-17620.	
- puckering in the joining of the top piece to the flare	2
c. MIL-C-18186, MIL-C-23315 and MIL-C-26804:	
1. Poorly shaped.	3
2. Crown pleated at joining to quarters.	3
3. Crown puckered at joining to quarters.	2
4. Crown unevenly joined to quarters, i.e., twisting, puckering or pleating around the edge.	2
5. Joining seam not topstitched or not pressed open.	2
6. Topstitched seam not worked out, distorting contour of edge.	3
XIII. CROWN LINING OR TOP PIECE LINING	
a. Omitted, not material specified.	3
b. Tight or twisted appearance on outside of crown.	3
XIV. FLARE	
a. MIL-C-17620:	
1. Other than three pieces of material.	3
2. The seam formed when joining the three pieces of flare not pressed flat, when applicable.	2
3. The finished flare at center of front less than 2 1/8 inches or more than 2 3/8 inches.	2
4. The finished flare at center of back less than 1 7/8 inches or more than 2 1/8.	2
XV. BUTTONHOLE	
a. Any buttonhole omitted.	3
b. Other than type or size required.	3

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Table II - Classification of Defects (cont'd)

	<u>Point Value</u>
c. Stitches not securely caught in fabric, causing stitches to pull away from fabric.	3
d. One or more broken stitches in one buttonhole.	1
e. One or more broken stitches in two buttonholes.	2
f. Any buttonhole uncut.	2
g. Ragged buttonhole.	1
h. MIL-C-17620:	
1. Length of any buttonhole less than 11/16 inch or more than 13/16 inch.	1
2. Any buttonhole positioned less than 1/8 inch or more than 3/16 inch from bottom folded edge of band to center of buttonhole.	1
3. Any buttonhole positioned less than 5 3/8 inches or more than 5 5/8 inches from center front of cap crown to center of buttonhole.	1
i. MIL-C-18186:	
1. Less than 3/4 inch or more than 1 inch in length.	1
2. Positioned from bottom edge of band:	
(a) less than 5/16 inch but not less than 1/4 inch or more than 7/16 inch but not more than 1/2 inch	1
(b) less than 1/4 inch or more than 1/2 inch	2
3. Position of center of buttonhole from center front of crown:	
(a) less than 5 5/8 inches but not less than 5 1/2 inches or more than 5 7/8 inches but not more than 6 inches	1
(b) less than 5 1/2 inches or more than 6 inches	2
j. MIL-C-23315:	
1. Less than 3/4 inch or more than 1 inch in length.	1
2. Positioned from bottom edge of band:	
(a) less than 3/16 inch but not less than 1/8 inch or more than 5/16 inch but not more than 3/8 inch	1
(b) less than 1/8 inch or more than 3/8 inch	2

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Table III - Classification of Defects (cont'd)Point Value

- |  |   |
|--|---|
| 3. Position of center of buttonhole from center front of crown:  |   |
| (a) less than 5 5/8 inches but not less than 5 1/2 inches or more than 5 7/8 inches but not more than 6 inches | 1 |
| (b) less than 5 1/2 inches or more than 6 inches   | 2 |

## XVI. WEBBING

## a. MIL-C-38182:

- |  |   |
|--|---|
| 1. Ends of webbing not joined.         | 3 |
| 2. Length of webbing not as specified. | 2 |

## XVII. HEM

## a. MIL-C-38182:

- |   |   |
|---|---|
| - less than 11/16 inch or more than 13/16 inch wide | 1 |
|---|---|

## XVIII. TUNNEL

## a. MIL-C-38182:

- |  |   |
|--|---|
| - less than 7/16 inch or more than 9/16 inch | 1 |
|--|---|

## XIX. BLOCKING

## a. MIL-C-17620:

- |  |   |
|--|---|
| 1. Blocking omitted.                           | 3 |
| 2. Crown burned or scorched.                   | 3 |
| 3. Poorly blocked, causing a shine or wrinkle. | 2 |

5.2 Dimensional examination. The appropriate number of cap crowns, determined from the table below, shall be examined for conformance to the dimensional requirements cited in the table of measurements of the appropriate crown specification. When a measurement deviates from a dimension and tolerance specified, the cap crown shall be penalized one point. The lot shall be unacceptable if the total point value exceeds the applicable point values specified below. Each size cap crown present in the lot shall be represented in the sample selected for this examination.

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<u>Lot Size</u>	<u>Sample Size</u>	<u>Point Limit Value</u>
Up thru 500	8	0
501 thru 3200	13	1
3201 thru 35,000	20	2
35,001 and up	32	3

\* 5.3 Examination of packaging requirements. An examination shall be made to determine that packaging, packing and marking requirements are in compliance with Section 5 requirements of the appropriate specification. Defects listed below shall be scored one point. The sample size for this examination shall be five shipping containers fully prepared for delivery. Examination for the closure defects listed below shall be made. 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; 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, inadequate stapling. Open and non-continuous heat sealed seams and closure of polyethylene bag. 1/ Omission of vent hole in polyethylene bag. 1/ Incorrectly fabricated bag. 1/ Bulged or distorted container. 1/
Content	Number of intermediate packages per shipping container is more or less than required. Number of cap crowns per intermediate package is more or less than required. Size shown on one or more cap crowns not as specified on shipping container. 2/

1/ When applicable.

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

\* 5.4 Inspection procedures. Inspection shall be as specified in MIL-STD-105, except where otherwise indicated in this document.

\* 5.5 Initiation of inspection. Normal inspection will be used at the start of inspection unless otherwise directed by the procurement quality assurance element administering the contract.



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\* 5.6 Continuation of inspection. Normal, tightened or reduced inspection shall continue unchanged on successive lots except where switching procedures in 5.7 require change.

\* 5.7 Switching procedures.

\* 5.7.1 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).

\* 5.7.2 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.

\* 5.7.3 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

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 sixty 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 seventy-five 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.

\* 5.7.4 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 2/ to Table I); or

c. Production becomes irregular or delayed; or

d. Other conditions warrant that normal inspection be reinstituted.

\* 6. NOTES

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

\* 6.1 Intended use. This standard is intended to provide a standardized procedure for evaluating quality of cap crowns procured by the Department of Defense.

\* 6.2 Issue of DODISS. When this standard is used in acquisition, the applicable issue of the DODISS must be cited in the solicitation (see 2.1.1).

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\* 6.3 Subject term (key word) listing.

Cap crown  
Defects  
Inspection  
Point value  
Quality

\* 6.4 Changes from previous issue. The margins of this standard are marked with an asterisk to indicate where any changes (additions, modifications, corrections, deletions) from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous issue.

Custodian:

Navy - NU  
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Preparing Activity:

Navy - NU

Project No. 8405-0097

Review Activities:

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Air Force - 82, 99  
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**NOTE** This form may not be used to request copies of documents, nor to request waivers, deviations, or clarification of specification 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.

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