

MIL-STD-1611A

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SUPERSEDING

MIL-STD-1611

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MILITARY STANDARD
PROVISIONS FOR EVALUATING QUALITY
OF
HOODS AND HAVELOCKS, WOMAN'S



FSC 8410

MIL-STD-1611A

DEPARTMENT OF DEFENSE

WASHINGTON, D. C. 20301

Provisions for Evaluating Quality of Hoods and Havelocks, Woman's

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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: Officer in Charge, Navy Clothing and Textile Research Facility, 21 Strathmore Road, 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.

FOREWARD

This standard provides a standardized procedure for evaluating quality of hoods and havelocks procured for the Department of Defense. It is intended to list in a single document defects irrespective of fabrics, (i.e., wool, cotton, polyester/cotton) or end use.

The objectives of this standard are to provide:

- a. Standard descriptions for defects.
- b. Standardized examination requirements.

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

<u>Specification</u>	<u>Title</u>
MIL-H-1356	Hood, Winter, Woman's, Field
MIL-H-15121 (SA)	Hood, Rain, Woman's
MIL-H-15502 (SA)	Havelock (Woman's)
MIL-H-43461 (GL)	Havelock, Woman's, Quarpel
MIL-H-82142 (MC)	Hood, Rain, Woman's, Nylon, Rubber Coated, Green
MIL-H-83269 (USAF)	Hood, Rain, Woman's

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1. SCOPE

1.1 Purpose. The purpose of this standard is to provide standardized provisions for evaluating the quality of WOMAN'S HOODS AND HAVELOCKS.

1.2 Application. This standard will be made applicable to contracts by reference in the appropriate Hood or Havelock specifications.

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.

STANDARD

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

MIL-STD-1487 - Glossary of Cloth Coating Imperfections

(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 and MIL-STD-1487. All other defect descriptions in this standard are self-explanatory.

3.2 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.

3.3 Open seam. 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. Double stitched seams are considered open when one or both rows of the stitching are open.

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3.4 Raw edge. Raw edge is defined as any edge not finished as specified including any protruding edge on the outside of the hood or havelock.

3.5 Outside-inside. The terms "Outside" and "Inside" as used in this standard are defined as follows:

Outside - Any part of hood or havelock that is visible when the hoods or havelocks are laid flat on a table.

Inside - Any part of hood or havelock that is not visible when the hoods or havelocks are laid flat on a table.

3.6 Defective button. A button shall be considered defective when it has a sharp, rough, cracked or split edge; scratches, dents, blemishes, imbedded foreign matter, or is badly shaded.

3.7 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 this item.

4. GENERAL

4.1 This standard contains the provisions for end item examination, dimensional examination and the examination of packaging inspection for Woman's hoods and Havelocks. If there are any inconsistencies between the requirement of the appropriate hood or havelock 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 severity. The higher point values are assigned to those defects having the more detrimental effect on the appearance or serviceability of the item.

5. SAMPLE AND INSPECTION PROVISIONS

5.1 End item examination. The hood or havelock shall be examined and all defects shall be penalized as indicated in Table II of this standard. The sample size based on lot size, and the acceptable point values shall be as specified in Table I. The sample unit shall be one hood or havelock. The lot shall be unacceptable if:

(a) The point value for 3 and 2 point defects exceeds the applicable maximum acceptance point value.

OR

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

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

<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 inspection. An examination shall be made to determine that preservation packaging, packing and marking requirements are in compliance with Section 5 of the appropriate hood or havelock 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.
Workmanship	Inadequate application of components, such as: incomplete closure of container flaps, loose strapping, improper taping, inadequate stapling. Bulging or distorted container. Open and non-continuous heat sealed and closure of polyethylene bag <u>1/</u> Omission of vent hole in polyethylene bag <u>1/</u> Incorrectly fabricated bag <u>1/</u>
Content	Number of intermediate packages per container is more or less than required. Number of hoods or havelocks per intermediate package is more or less than required. <u>2/</u> Size shown on one or more hoods or havelocks not as specified on shipping container <u>2/</u> (as applicable). Number of havelocks per shipping container is more or less than required
Preservation (Naphthalene)	Improperly applied or missing, when applicable.
<u>1/</u> When applicable	
<u>2/</u>	For this defect, one intermediate package from each container in the sample shall be examined.

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5.4 Examination for pinholes. Hoods and havelocks, that are fabricated from coated fabric, selected for dimensional examination (see 5.2), shall be given a through-light inspection for pinholes. The through-lighting inspection shall be performed in accordance with MIL-STD-1487. The lot shall be unacceptable if the total point value resulting from this examination exceeds 1 point.

Table I - Sampling provisions for hoods and havelocks

	Lot size	Sample size	Maximum acceptable point values	
			3&2 point defects <u>1/</u>	3,2&1 point defects
Normal Inspection	Up thru 50	13	4 points	9 points
	51 thru 150	20	6 points	12 points
	151 thru 280	32	9 points	18 points
	281 thru 500	50	12 points	25 points
	501 thru 1200	80	15 points	35 points
	1201 thru 3200	125	23 points	46 points
	3201 thru 10,000	200	32 points	67 points
	10,001 thru 39,000	315	45 points	100 points
39,001 and over	500	68 points	150 points	
Tightened Inspection	Up thru 50	13	3 points	7 points
	51 thru 150	20	5 points	10 points
	151 thru 280	32	7 points	14 points
	281 thru 500	50	10 points	20 points
	501 thru 1200	80	13 points	30 points
	1201 thru 3200	125	16 points	40 points
	3201 thru 10,000	200	26 points	58 points
	10,001 thru 39,000	315	39 points	88 points
39,001 and over	500	58 points	130 points	
Reduced Inspection	Up thru 280	13	2-6 points	10 points
	281 thru 500	20	3-9 points	16 points
	501 thru 1200	32	6-14 points	26 points
	1201 thru 3200	50	10-20 points	35 points
	3201 thru 10,000	80	17-26 points	46 points
	10,001 thru 39,000	125	23-32 points	67 points
	39,001 and over	200	32-41 points	100 points

1/ In reduced inspection if the first value is exceeded but the second value has not been exceeded, accept the lot but reinstate normal inspection (see 6.3.4b). The second value is the maximum acceptable point value.

6. INSPECTION. Inspection procedures, except for sampling plans, shall be as specified in MIL-STD-105, except where otherwise indicated in this document.

6.1 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.

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

6.3 Switching procedures.

6.3.1 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).

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

6.3.3 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 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.

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6.3.4 Reduced to normal. When reduced inspection is in effect, normal inspection shall be reinstated 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 reinstated.

Table II - Classification of defects

	Point Value
A. GENERAL DEFECTS	
I. PRESSING (not applicable to MIL-H-82142(MC) and MIL-H-1356)	
Omitted or poorly pressed	2
II. MATERIAL DEFECTS AND WORKMANSHIP DAMAGES	
a. Any hole, cut, tear, smash, scorched area, burn, drill hole or open place:	
1. On outside (longest dimension in any direction):	
(a) - up to 1/4 inch (0.6cm) inclusive	2
(b) - more than 1/4 inch (0.6cm)	3
2. On inside (longest dimension in any direction):	
(a) - up to 1/4 inch (0.6cm), inclusive	1
(b) - more than 1/4 inch (0.6cm)	2
b. Misweave, area of no dye penetration, dye streak, thin place, visible mend, missing yarn, broken yarn or shade bar, more than 1/2 inch (1.3cm) (largest dimension in any direction):	
- on outside	2
c. Knot or slub (see 3.7 on outside)	
	1
d. Permanent fold, pleat or crease in cloth (when caught in seaming or stitching):	
- on outside	3
e. Loose knitting causing sleaziness	
	1

Table II - Classification of defects (cont'd)

	Point Value
A. GENERAL DEFECTS (cont'd)	
II MATERIAL DEFECTS AND WORKMANSHIP DAMAGES (cont'd)	
f. Needle chew on outside:	
1. Up to 1/4 inch (0.6cm), inclusive	2
2. More than 1/4 inch (0.6cm)	3
g. Loose yarn, snagged thread, coarse yarn or woven in waste; more than 1 inch (2.5cm) (largest dimension in any direction):	
- on outside	1
h. Coated fabric:	
1. Any 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
4. Film delaminated from knit	3
III SHADED PARTS	
a. On outside:	
1. Variation in shade between two or more parts (except parts which may be cut from ends)	3
2. Any part cut from ends badly shaded	1
3. Variation in shade within a part (except parts which may be cut from ends)	2
IV CLEANNESNESS	
a. Any spot or stain on outside (largest dimension in any direction):	
1. - up to 3/8 inch (1.0cm), inclusive	1
2. - more than 3/8 inch (1.0cm) up to 3/4 inch (1.9cm), inclusive	2
3. - more than 3/4 inch (1.9cm)	3
b. Thread ends - on outside:	
1. More than four but not more than six not trimmed to less than 1/2 inch (1.3cm)	1
2. More than six not trimmed to less than 1/2 inch (1.3cm)	2

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Table II - Classification of defects (cont'd)

	Point Value
A. GENERAL DEFECTS (cont'd)	
IV CLEANNESS (cont'd)	
c. Thread end caught for a distance of more than 1/4 inch (0.6cm) in line of stitching on outside	1
d. Two or more shade or size tickets not removed	1
e. Any size or shade marking on outside; score as spot or stain (see IV.a.)	
V. COMPONENTS AND ASSEMBLY	
a. Any component part or operation omitted (unless otherwise classified herein)	3
b. Any component not as specified (type, size, color, etc.)	3
c. Any component part tight, twisted, distorted, pleated or puckered (unless otherwise classified herein)	2
d. Any operation not as specified (unless otherwise classified herein)	2
e. Any component part not assembled as specified (unless otherwise classified herein)	2
f. The edge of any component part required to be forced out having folds of more than 1/8 inch (0.3cm) (unless otherwise classified herein)	2
VI CUTTING	
a. Any component part not cut in accordance with specified pattern, directional lines on patterns or not in accordance with specification requirements	3
b. Outside part of item not constructed in the material side as specified.	3

Table II - Classification of defects (cont'd)

		Point Value
VII SEAMS AND STITCHING		
a. Accuracy of seaming:		
1.	Seam puckered (unless otherwise classified)	1
2.	Seam irregular, pleated or wavy (unless otherwise classified)	2
3.	Part of hood or havelock caught in any unrelated operation or stitching	2
4.	End of stitching when not caught in another seam or stitching not backstitched as specified (except attaching labels)	1
5.	Stitching overlapping ends of thread break less than 1/2 inch (1.3cm)	1
6.	Ends of a continuous line of stitching overlapped less than 1/2 inch (1.3cm)	1
7.	Shade of thread used on outside not as specified	2
8.	Needle perforations visible on outside	2
b. Gauge of stitching and seam allowance:		
1.	Gauge irregular or not within range specified or varies more than 1/16 inch (0.2cm) when no range is specified (score only when the condition exists on the length of the seam for a distance of 1 inch (2.5cm) or more)	1
2.	Edge, top or raise stitching sewn too close to edge, resulting in damage to cloth	3
3.	Seam allowance not as specified by 1/16 inch (0.2cm) or more (score only when condition exists on the length of the seam for a distance of 1 inch (2.5cm) or more)	2
c. Open seam (See 3.3):		
1. On outside:		
	(a) - up to 1/2 inch (1.3cm), inclusive	1
	(b) - more than 1/2 inch (1.3cm) up to 3/4 inch (1.9cm), inclusive	2
	(c) - more than 3/4 inch (1.9cm)	3
2. On inside:		
	(a) - more than 3/8 inch (1.0cm) up to 2 inches (5.1cm), inclusive	1
	(b) - more than 2 inches (5.1cm)	2
d. Runoff, skipped or broken stitches:		
1.	On joining seams, score as open seam	-
2.	Edge or raise stitching [more than 1/4 inch (0.6cm)]	1

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Table II - Classification of defects (cont'd)

	Point Value
A. GENERAL DEFECTS (cont'd)	
VII SEAMS AND STITCHING (cont'd)	
e. Raw edges (See 3.4):	
1. On outside:	
(a) -up to 3/4 inch (1.9cm), inclusive	2
(b) -more than 3/4 inch (1.9cm)	3
2. On inside, bottom and side hems (excluding ends of ribbon and front corners of bottom hem) applicable to MIL-H-15502 havelock:	
-more than 1/4 inch (0.6cm)	1
3. On inside more than 1 inch (2.5cm)	1
f. 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. Looper thread of 401 stitch type on outside	3
g. Stitch tension:	
1. Loose tension resulting in a loose seam:	
(a) -up to 1/2 inch (1.3cm), inclusive	1
(b) -more than 1/2 inch (1.3cm) up to 3/4 inch (1.9cm), inclusive	2
(c) -more than 3/4 inch (1.9cm)	3
2. Loosely exposed loops of lower or top thread	1
3. Tight tension (stitches break when normal strain is applied in the direction of the seam or stitching)	3
h. Stitches per inch (cm) (to be scored only when the condition exists on the major portion of seam or stitching):	
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
i. Bartack, backtack, tack or tacking, one or more:	
1. Missing, insecure, misplaced, not serving intended purpose or not specified size or type:	
(a) - for attachment (unless otherwise specified)	2
(b) - for reinforcement	1

Table II - Classification of defects (cont'd)

		Point Value
B. DETAILED DEFECTS		
VIII SEALING OF SEAMS AND STITCHING		
a.	MIL-H-82142(MC)	
1.	Any seam or stitching or needle holes required to be sealed, not properly sealed	3
2.	Sealant not flexible, i.e., cracks or flakes when creased	3
3.	Sealant tacky	2
IX BUTTONHOLES AND EYELETS (not applicable to MIL-H-83269 (USAF) and MIL-H-15502(SA))		
a.	Omitted, added, not specified type or not finished as specified	3
b.	Misplaced or not positioned as specified or placed more than 1/2 inch (1.3cm) from pattern location; out of alignment resulting in bulge or twist when buttoned	3
c.	Gimp omitted, uncut buttonhole, incomplete stitching or stitching not securely caught in fabric	2
d.	Ragged edge, broken stitch or two or more skipped stitches:	
1.	On outside	2
2.	On inside	1
e.	Stitches per buttonhole not as specified	2
f.	Diameter of eyelets not as specified	1
g.	Eyelet not completely reinforced with piece of basic material	1
h.	Finished cut length not as specified	1
i.	Purling not on side specified	1
X. BUTTONS (not applicable to MIL-H-83269 (USAF) and MIL-H-15502(SA))		
	Omitted, misplaced, out of alignment, broken, defective or insecurely sewn	2
XI. HOOD AND PILE TAPE FASTENER (When applicable)		
a.	Not type, class, size or color specified	3
b.	Misplaced or reversed in assembly	3
c.	Not stitched on all sides	1

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Table II - Classification of defects (cont'd)

	Point Value
B. DETAILED DEFECTS (cont'd)	
XII SNAP FASTENER	
a. MIL-H-15502(SA)	
1. Any socket or stud omitted, insecurely attached, not positioned as specified or damaged not serving intended purpose	2
2. Any socket out of alignment with corresponding stud causing noticeable bulge when fastened	1
3. Stud of snap fastener positioned not as specified from bottom of left front hem as worn	1
XIII SHIELD	
a. MIL-H-15502(SA)	
1. Free sides at shield fronts not finishing as specified	1
2. Center back raisestitching appearing on left half as worn	1
3. Shield stitched other than over front crown and over brim components at havelock front	2
4. Shield hems finished less than 5/16 inch (0.8cm) wide, or more than 3/8 inch (1.0cm) wide	1
XIV COLLAR (or Capulette)	
a. MIL-H-15121(SA) and MIL-H-82142(MC)	
1. Badly twisted, excessive fullness or puckering	2
2. Rounded corners poorly shaped or not of uniform shape or size	1
3. Top ply puckered or pleated when joined to underply or lining	1
4. Tight at joining to headpiece or hood causing fullness	2
5. Collar edge not properly forced out	1
XV HEADPIECE	
a. MIL-H-15121(SA) and MIL-H-82142(MC)	
1. Underply tight causing excessive fullness on upper ply affecting appearance (type I only, MIL-H-15121(SA))	3
2. Edge not properly forced out	1
3. Buttonhole flap distorted or misshapen	1
XVI DARTS (not applicable to MIL-H-15502(SA) and MIL-H-83269(USAF))	
a. Ends not properly tapered causing an unsightly bulge	1
b. Not uniform in length by 1/2 inch (1.3cm)	1
c. Length of darts not as specified	1

Table II - Classification of defects (cont'd)

	Point Value
XVII RIBBON (Grosgrain)	
a. MIL-H-15502(SA)	
1. Ribbon width:	
-less than 13/16 inch (2.1cm) wide or more than	
15/16 inch (2.4cm) wide	1
2. Omitted or not as specified	3
XVIII DRAWCORD	
a. MIL-H-1356	
1. Not inserted as specified	1
2. Finished cut length less than 35 inches (88.9cm)	
or more than 37 inches (94.0cm)	1
3. Caught in the stitching of facing	2
4. Extensions of drawcord uneven in length by more than	
1/2 inch (1.3cm), measured from eyelets	2
XIX FACING OR LINING	
a. MIL-H-1356, MIL-H-82142(MC) and MIL-H-43461(GL)	
1. Tight, short or twisted causing fullness or	
twist on outside of hood	2
2. Facing exposed 1/16 inch (0.2cm) or more on outside	
edge of hood	1
3. Excessive fullness on lining	1
XX BRIM	
a. MIL-H-15502(SA) and MIL-H-43461(GL)	
1. Folded edge of pleat(s) faced toward center of	
havelocks	2
2. Free ends of lower brim (including ribbon):	
-less than 2-1/4 inches (5.7cm) or more than	
2-3/4 inches (7.0cm)	1
3. Raised stitching on lower brim	1
XXI FRONT CROWN	
a. MIL-H-15502(SA)	
1. Sides not uniform, i.e., irregular in width by	
1/4 inch (0.6cm) or more	1
2. Raised stitching appearing on brim instead of	
front crown	1

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Table II Classification of defects (cont'd)

	Point Value
B. DETAILED DEFECTS (cont'd)	
XXII TOP PIECE (crown)	
a. MIL-H-15502(SA)	
1. Poorly shaped	2
2. Raised stitching appearing on shield or on front crown instead of top crown	1
XXIII HEM (bottom, facing and tuck-in-flap)	
a. MIL-H-43461(GL) and MIL-H-15502(SA)	
1. Bottom hem or facing hem less than 3/16 inch (0.5cm) or more than 5/16 inch (0.8cm) wide	1
2. Tuck-in-flap hem less than 1/8 inch (0.3cm) or more than 1/4 inch (0.6cm) wide	1
3. Hem(s) twisted	1
XXIV LABELS	
a. Omitted, incorrect or illegible	2
b. Not positioned as specified	1
c. Stitches through the printing	1
XXV PLEATS	
a. MIL-H-83269(USAF)	
1. Pleats not folded towards center back on the outside	2
2. Folds of pleats at center back spread apart more than 1/8 inch (0.3cm) at seam line or other two pleats unequally spaced from center back by 1/4 inch (0.6cm) or more	1
3. Corresponding pleats uneven in depth by more than 1/8 inch (0.3cm)	1
XXVI BINDINGS	
a. MIL-H-83269(USAF)	
1. Binding badly twisted	1
2. Ends of binding at points of hood not trimmed	1
3. Binding not securely caught to edges causing binding to pull away from edge:	
(a) -up to 1/2 inch (1.3cm), inclusive	1
(b) -more than 1/2 inch (1.3cm)	2
4. Binding not securely caught to seam attaching visor to hood:	
(a) -up to 1/2 inch (1.3cm), inclusive	1
(b) -more than 1/2 inch (1.3 cm)	2

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Custodians:

Navy - SA
Army - GL
Air Force - 11

Preparing activity:

Navy - SA

Project No. 8410-0371

Review activities:

Navy - MC
Air Force - 99
Army - MD

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