

**INCH-POUND**

MIL-STD-1613B  
1 March 1990

**SUPERSEDING**  
MIL-STD-1613A  
25 June 1980

MILITARY STANDARD  
PROVISIONS FOR EVALUATING QUALITY  
OF  
GLOVES, LEATHER, DRESS



AMSC N/A

FSC 84GP

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MIL-STD-1613B

FORWARD

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 document supplements the military specifications listed below. It provides a standard description for defects and standardizes examination requirements.

Specification

Title

PD-274

Gloves, Leather, Dress, Lined and Unlined  
(U.S.M.A.)

MIL-G-24909

Gloves, Men's and Women's

## MIL-STD-1613B

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## 1. SCOPE

1.1 Scope. The scope of this standard is to provide standardized provisions for evaluating the quality of leather dress gloves.

1.2 Application. This standard will be made applicable to contracts by references in the appropriate glove specifications. If there are any inconsistencies between the requirements of the applicable specification and this standard, the specification will govern.

## 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 document 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

MIL-STD-105	- Sampling Procedures and Tables for Insection by Attributes
MIL-STD-109	- Quality Assurance Terms and Definitions
MIL-STD-1491	- Glossary of Knitting Imperfections

(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 takes 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 MIL-STD-1491.

3.2 Quality assurance terms and procedures. Definitions of quality assurance terms and procedures, when 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 runoff, or when two or more continuous skipped or runoff stitches occur.

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## 4. GENERAL REQUIREMENTS

4.1 This standard contains the provisions for intermediate examination, end item examination, dimensional examination, and packaging inspection for Leather Dress Gloves. If there are any inconsistencies between the requirement 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 Intermediate examination.

5.1.1 Preassembled knit liner. The preassembled knit liner shall be examined and all defects shall be penalized as indicated in Table I. 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 II. The sample unit shall be one completely fabricated liner. The lot shall be unacceptable if:

- a. The point value of 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 - Classification of defects

	<u>Point Value</u>
<b>I. Material Defects and Workmanship Damages</b>	
a. Hole, cut, tear or rip, visible mend, needle chew or open place (longest dimension in any direction):	
1. Up to 1/4 inch, inclusive	2
2. More than 1/4 inch	3
b. Loose yarn, snagged yarn, float, drop stitch, broken yarn, thin place, knitted in waste, shade bar, area of no dye penetration, dye streak, tucking defect; more than 1/2 inch (longest dimension in any direction)	1
c. Knot, slubby yarn more than twice the diameter size of the normal diameter of the yarn	1
<b>II. Color not as specified</b>	2

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Table I - Classification of defects (cont'd)

	<u>Point Value</u>
III. Thread for fingers and thumb closure (when applicable):	
a. Omitted	2
b. Color other than specified, or mismatched for shade with the liner	1
IV. Construction and Assembly	
a. Not as specified	2
b. When applicable, fingers and thumb open or insecurely closed	2
c. Bulky, twisted, or poorly formed	2

5.2 End item examination. The gloves shall be examined and all defects shall be penalized as indicated in Table IV of this standard. The sample size shall be based on lot size and the acceptance value for 3 and 2 point defects and total (3, 2, and 1 point) defects shall be as specified in Table III. The sample unit shall be one glove and the selection shall be by pairs. Defects for pairing shall be classified as a single defect. The lot shall be unacceptable if:

- a. The point value of 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.

5.3 Dimensional examination. The appropriate number of gloves selected in pairs, and as determined from the table below, shall be examined for conformance to the dimensional requirements cited in the table of measurements of the appropriate glove specification. When a measurement deviates from a dimension and tolerance specified, the glove shall be penalized one point. The lot shall be unacceptable if the total point value exceeds the maximum acceptable point value specified below. Each size glove present in the lot shall be represented in the sample selected for this examination.

<u>Lot size</u>	<u>Sample size</u>	<u>Maximum Acceptable Point Values</u>
Up thru 500	8	0
501 thru 3200	13	1
3201 thru 35,000	20	2
35,001 and up	32	3

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5.4 Examination of packaging requirements. An examination shall be made to determine that packaging, packing, and marking comply with Section 5 requirements of the appropriate glove specification. Defects listed below shall be scored one point. The sample unit shall be one shipping container fully prepared for delivery. 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, 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, bulged or distorted container.
Content	Number of items per shipping container is more or less than required. Size shown on one or more items not as specified on shipping container. <u>1/</u>

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

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

5.6 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.

5.7 Continuation of inspection. Normal, tightened, or reduced inspection shall continue unchanged on successive lots except where switching procedures in 5.8 require change.

#### 5.8 Switching procedures.

5.8.1 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).

5.8.2 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.



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5.8.3 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.

5.8.4 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 Tables II and III); or
- c. Production becomes irregular or delayed; or
- d. Other conditions warrant that normal inspection be reinstated.

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Table II - Sampling Provisions for Preassembled Knit Liner

	Lot size	Sample size	Maximum acceptable point values	
			3&2 point defects	3,2,&1 point defects
Normal Inspection	Up thru 50	5	2 points	4 points
	51 thru 150	8	3 points	5 points
	151 thru 280	13	4 points	6 points
	281 thru 500	20	5 points	7 points
	501 thru 1200	32	6 points	9 points
	1201 thru 3200	50	9 points	13 points
	3201 thru 10,000	80	14 points	19 points
	10,001 thru 39,000	125	19 points	26 points
	39,001 and over	200	27 points	38 points
Tightened Inspection	Up thru 50	5	2 points	3 points
	51 thru 150	8	2 points	4 points
	151 thru 280	13	3 points	5 points
	281 thru 500	20	4 points	6 points
	501 thru 1200	32	5 points	7 points
	1201 thru 3200	50	6 points	9 points
	3201 thru 10,000	80	9 points	13 points
	10,001 thru 39,000	125	14 points	21 points
	39,001 and over	200	22 points	32 points
			<u>3&amp;2 point defects</u>	<u>1/</u>
Reduced Inspection	Up thru 280	5	2-3 points	5 points
	281 thru 500	8	2-5 points	7 points
	501 thru 1200	13	3-8 points	10 points
	1201 thru 3200	20	4-11 points	14 points
	3201 thru 10,000	32	6-14 points	18 points
	10,001 thru 39,000	50	9-17 points	22 points
	39,001 and over	80	14-22 points	27 points

1/ If the first value is exceeded but the second value has not been exceeded, accept the lot but reinstate normal inspection (see 5.8.4b). The second value is the maximum acceptable point value.

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Table III - Sampling Provisions for Leather Dress Gloves

	Lot size	Sample size	Maximum acceptable point values	
			3&2 point defects	3,2,&1 point defects
Normal Inspection	Up thru 50	13	3 points	5 points
	51 thru 150	20	5 points	7 points
	151 thru 280	32	7 points	10 points
	281 thru 500	50	9 points	13 points
	501 thru 1200	80	14 points	19 points
	1201 thru 3200	125	19 points	26 points
	3201 thru 10,000	200	27 points	38 points
	10,001 thru 39,000	315	38 points	54 points
	39,001 and over	500	57 points	80 points
Tightened Inspection	up thru 50	13	2 points	4 points
	51 thru 150	20	3 points	6 points
	151 thru 280	32	5 points	8 points
	281 thru 500	50	7 points	10 points
	501 thru 1200	80	9 points	14 points
	1201 thru 3200	125	14 points	21 points
	3201 thru 10,000	200	22 points	32 points
	10,001 thru 39,000	315	33 points	48 points
	39,001 and over	500	49 points	72 points
Reduced Inspection	Up thru 280	13	2-8 points	10 points
	281 thru 500	20	3-11 points	13 points
	501 thru 1200	32	6-14 points	17 points
	1201 thru 3200	50	8-17 points	21 points
	3201 thru 10,000	80	14-22 points	27 points
	10,001 thru 39,000	125	19-27 points	34 points
	39,001 and over	200	27-35 points	46 points

3&2 point  
defects 1/

1/ If the first value is exceeded but the second value has not been exceeded, accept the lot but reinstate normal inspection (see 5.8.4b). The second value is the maximum acceptable point value.

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\*6. NOTES

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

\*6.1 Intended use. This standard contains requirements for evaluating quality of leather dress gloves.

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

\*6.3 Changes from previous issue. The margins of this standard are marked with an asterisk to indicate where 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.

\*6.4 Subject term (key word) listing.

Handwear, Defects of  
Handwear, Inspection of

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Table IV - Classification of Defects

	<u>Point Value</u>
I. <u>Leather Defects and Damages</u>	
a. Any hole (except pinhole or needle hole), tear, thin or weak area (including evidence or slaughter cut)	3
b. Not full grain	3
c. Not soft and pliable	3
d. Grain damage(s) or imperfection(s), e.g., grub or tick marks, cockle, scratch, scar, abrasions and blocking	*
e. Wrinkles	*
f. Brittle or bony area	*
g. Flesh side of leather not smooth or contains loose flesh in excess of one square inch in total area	2
h. Loose, spongy, or flanky	*
i. Excessive stretch in length direction of glove	3
j. Three or more pinholes throughout glove	1
k. Three or more exposed needle holes	1
l. Spot or stain, discoloration, e.g., bloom, blushing, bronzing, spue	2
m. Loose flesh protruding from seam (i.e., not cut clean)	1

\*The defect shall be classified as 3 points when it seriously affects the serviceability or appearance and 1 point when affecting serviceability or appearance, but not seriously.

II. Shaded Parts

- |   |   |
|---|---|
| a. On outside:<br>-Any part shaded or variation in shade within a glove | 2 |
| b. On inside:<br>-Any liner part badly shaded within a glove            | 1 |

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Table IV - Classification of Defects (cont'd)

	<u>Point Value</u>
III. <u>Cleanness</u>	
a. Spot or stain on liner or lining	1
b. Thread ends - on outside:	
1. More than one but not more than three not trimmed to less than 1/2 inch	1
2. More than three not trimmed to less than 1/2 inch	2
c. Two or more shade or size tickets not removed	1
d. Any evidence of the gum paste visible on the surface of the knitted liner	1
e. Any evidence of gum paste or adhesive on leather	1
IV. <u>Cutting</u>	
-Any component part not cut in accordance with specified pattern or not in accordance with specification requirements	3
V. <u>Components and Assembly</u>	
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

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Table IV - Classification of Defects (cont'd)

	<u>Point Value</u>
VI. <u>Seams and Stitching</u>	
a. Accuracy of seaming:	
1. Seam puckered	1
2. Seam irregular, pleated or wavy	2
3. Any part of glove caught in unrelated operation	2
4. Ends of stitching produced with 301 stitch type, when not caught in other seams or stitching, backtacked less than 1/4 inch	1
5. Ends of stitching produced with 401 stitch type, when not caught in other seams or stitching, not having chain extending beyond each end	2
6. Ends of stitching produced with 401 stitch type, when not caught in other seams or stitching, having chain extending less than 1/2 inch or more than 3/4 inch beyond each end	1
7. Thread breaks (all stitch types) stitched less than 1/2 inch beyond each end of break	1
b. Gage of stitching and seam allowance:	
1. Stitching irregular, not within range specified, or varies more than 1/16 inch when no range is specified	1
2. Width of seam allowance varies more than 1/16 inch from allowance specified	2
c. Open seam or stitching (see 3.3):	
-On all seams, except silking or hem stitching	3
d. Runoff, skipped, or broken stitches:	
1. On joining seam - when resulting in an open seam, use "Open seam or stitching" classification	
2. On silking stitching:	
(a) -one skipped or broken stitch	1
(b) -two or three skipped or broken stitches	2
(c) -four or more skipped or broken stitches	3
3. On hem stitching:	
(a) -up to 1/4 inch, inclusive	1
(b) -more than 1/4 inch	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 misplaced or not beginning or ending where specified	1
4. Loooper thread of 401 stitch type on outside	3

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Table IV - Classification of Defects (cont'd)

	<u>Point Value</u>
VI. <u>Seams and Stitching</u> (cont'd)	
f. Stitches per inch (to be scored only when the condition exists on the major portion of seam or stitching):	
1. Less than the minimum	2
2. More than the maximum	1
g. Stitch tension:	
1. Loose tension resulting in a loose seam	3
2. Loose tension or hem or silking resulting in loosely exposed thread	2
3. Tight tension (stitches break or cutting of leather or liner results when normal strain is applied in the direction of the seam or stitching)	3
4. Unbalanced tension where stitch locks, exposed on either surface of leather occurring intermittently (none over 1 inch), with a total of less than three inches randomly distributed throughout the glove	2
5. Unbalanced tension where stitch locks, exposed on either surface of leather occurring continuously over 1 inch	3
VII. <u>Thread</u>	
a. On outside:	
-Color other than specified or mismatched for shade with the leather	1
b. On inside:	
-Color other than specified or mismatched for shade with the liner	1
VIII. <u>Snap Fasteners</u>	
a. Omitted	3
b. Not specified type or size	3
c. Misplaced, loose, not positioned or attached as specified	2
IX. <u>Leather Piping</u>	
a. Omitted	3
b. Misplaced, loose, not positioned or attached as specified	2



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Table IV - Classification of Defects (cont'd)

	<u>Point Value</u>
X. <u>Leather Reinforcement Stay Pieces</u>	
a. Omitted	3
b. Misplaced, loose, not positioned or attached as specified	2
XI. <u>Glove Lining</u>	
a. Omitted	3
b. Loose, not positioned or attached as specified	2
c. Hole, cut, tear or rip, visible mend, or smash:	
1. Up to 1/4 inch, inclusive	2
2. More than 1/4 inch	3
d. Color not as specified	1
XII. <u>Glove Liner</u>	
a. Omitted	3
b. Loose, not positioned or attached as specified	2
c. Hole, cut, tear or rip:	
1. Up to 1/4 inch, inclusive	2
2. More than 1/4 inch	3
d. Poor fit of liner to shell (liner too tight or has too much fullness)	2
XIII. <u>Hem</u>	
a. Twisted	2
b. Puckered	1
c. Finished with not as specified	1
XIV. <u>Thumb, Fingers, and Fourchettes</u>	
a. Thumb type other than specified	3
b. Fingers formed with specified fourchette	3
c. Fingers or thumb twisted or poorly shaped	2

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Table IV - Classification of Defects (cont'd)

	<u>Point Value</u>
XV. <u>Silking</u>	
a. Any row of silking omitted	3
b. Any row of silking not constructed as specified	2
c. Any row of silking out of alignment with crotch of fingers by more than 1/8 inch	1
d. Any row of silking not specified distance from the crotch of fingers	1
e. Any center row of silking not length specified	2
f. Any outer row of silking not converging to specified distance on either side of the center row of silking	1
g. Any pair of silking rows spaced unevenly within each glove or not uniform in both gloves	1
h. The beginning and ending threads on any row of silking not pulled through to the inside of glove and tied	2
i. Two or more thread ends not trimmed to less than 1/2 inch	1
XVI. <u>Identification and Size Label</u>	
a. Omitted, incorrect, or illegible:	
1. On one glove	1
2. On both gloves	2
b. Misplaced	1
c. Cloth label, when applicable, not attached as specified or stitching through the printing	1
d. Color of the marking ink not as specified	1
XVII. <u>Finishing</u>	
-Gloves not layed-off	2

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Table IV - Classification of Defects (cont'd)

	<u>Point Value</u>
<b>XIII. <u>Pairing</u></b>	
a. Mismatched, i.e., two gloves of different sizes or two gloves for the same hand	3
b. Unevenness in length of fingers, thumb, or overall length of the two gloves:	
1. More than 1/4 inch up to 3/8 inch, inclusive	2
2. More than 3/8 inch	3
c. Mislabeled, i.e., two gloves of same size with different sizes on label	1
d. Unevenness in width of finished top opening of the two gloves:	
1. More than 1/8 inch up to 1/4 inch, inclusive	1
2. More than 1/4 inch	2
e. Pair not tacked together or not tacked as specified	1
f. Tacking insecure (less than 2 stitches)	1
g. Tacking too tight, i.e., not permitting the gloves to pull apart without tearing the leather	2
h. Tacking not located as specified	1
i. Mismatched, i.e., variation in color, shade, or grain structure	2

## Custodians:

Navy - NU  
 Army - GL  
 Air Force - 11

## Preparing activity:

Navy - NU

Project 84GP-0021

## Review activities:

Navy - MC  
 Army - MD  
 Air Force - 82, 99  
 DLA - CT

## User activities:

Navy - CG



**STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL***(See Instructions - Reverse Side)*

1. DOCUMENT NUMBER MIL-STD-1613B		2. DOCUMENT TITLE PROVISIONS FOR EVALUATING QUALITY OF GLOVES/LEATHER/DRESS	
3a. NAME OF SUBMITTING ORGANIZATION		4. TYPE OF ORGANIZATION (Mark one)	
b. ADDRESS (Street, City, State, ZIP Code)		<input type="checkbox"/> VENDOR	
		<input type="checkbox"/> USER	
		<input type="checkbox"/> MANUFACTURER	
		<input type="checkbox"/> OTHER (Specify): _____	
5. PROBLEM AREAS			
a. Paragraph Number and Wording:			
b. Recommended Wording:			
c. Reason/Rationale for Recommendation:			
6. REMARKS			
7a. NAME OF SUBMITTER (Last, First, MI) - Optional		b. WORK TELEPHONE NUMBER (Include Area Code) - Optional	
c. MAILING ADDRESS (Street, City, State, ZIP Code) - Optional		8. DATE OF SUBMISSION (YYMMDD)	

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