

MIL-STD- 1865
30 November 1974

MILITARY STANDARD
PROVISIONS FOR EVALUATING QUALITY
OF
DECORATIONS (UNIT AWARDS), DECORATION SETS, MEDAL
SETS, AND SERVICE RIBBONS WITH RIBBON ATTACHMENTS



FSC 8455

MIL-STD-1865
30 November 1974

DEPARTMENT OF DEFENSE

WASHINGTON, DC 20301

Decorations, Evaluating Quality of MIL-STD-1865

1. This Military Standard is approved for use by all Departments and Agencies of the Department of Defense.
2. Recommended corrections, additions, or deletions should be addressed to The Institute of Heraldry, U.S. Army, Cameron Station, Alexandria, VA 22314

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FOREWORD

This standard provides a standardized procedure for evaluating quality of:

- A. Decorations having a service ribbon (unit awards) or a ribbon attachment (MIL-D-3943 and MIL-S-3951; or MIL-D-3943 and MIL-R-41819).
- B. Decoration Sets (MIL-D-3943, and where applicable, MIL-R-11589, MIL-S-3951, MIL-L-11484, MIL-C-14633, MIL-R-41819).
- C. Medal Sets (MIL-M-3946, MIL-R-11589, MIL-S-3951).
- D. Service Ribbons with Ribbon Attachments (MIL-S-3951 and MIL-R-41819).

It is intended to list in a single document, defects for Heraldic items procured in accordance with two or more of the specifications listed below.

The objectives of this Standard are to:

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

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

| <u>SPECIFICATION</u> | <u>TITLE</u> |
|----------------------|--|
| IP/DES S-153-1 | Rosettes, For Military Decorations |
| MIL-D-3943 | Decorations, General Specification For |
| MIL-M-3946 | Medal, Campaign and Service, General Specification For |
| MIL-S-3951 | Service Ribbons & Bars, Service Ribbon |
| MIL-L-11484 | Lapel Button, General Specification For |
| MIL-R-11589 | Ribbon, Awards, General Specification For |
| MIL-C-14633 | Case, Decoration, Presentation |
| MIL-R-41819 | Ribbon Attachments, Decoration and Medal, General Specification For |

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1. SCOPE

1.1 Purpose. The purpose of this standard is to provide standardized provisions for evaluating the quality of Decoration Sets or Decorations having a service ribbon or ribbon attachment; Medal Sets; or Service Ribbons with Ribbon Attachments.

1.2. Application. This standard will be made applicable to contracts which reference the appropriate combinations of specifications listed in A; B; C or D of the Foreword. It is not applicable to any single specification listed in the Foreword.

2. REFERENCED DOCUMENTS

2.1 The latest issues of the following documents form a part of this standard to the extent specified herein.

SPECIFICATIONS

MILITARY

| | |
|-------------|--|
| MIL-D-3943 | - Decorations, General Specification For |
| MIL-M-3946 | - Medal, Campaign and Service, General Specification For |
| MIL-S-3951 | - Service Ribbons and Bars, Service Ribbon |
| MIL-L-11484 | - Lapel Button, General Specification For |
| MIL-C-14633 | - Case, Decorations, Presentation |
| MIL-R-41819 | - Ribbon Attachments, Decorations and Medal, General Specification For |
| MIL-R-11589 | - Ribbon, Awards, General Specification For |

STANDARDS

FEDERAL

| | |
|-------------|------------------------|
| FED-STD-151 | - Metals; Test Methods |
| FED-STD-191 | - Textile Test Methods |

MILITARY

| | |
|-------------|--|
| MIL-STD-105 | - Sampling Procedure and Tables for Inspection by Attributes |
|-------------|--|

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PURCHASE DESCRIPTION

The Institute of Heraldry, US Army

IP/DES S-153-1 - Rosettes, For Military Decorations

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

3. DEFINITIONS

3.1 Examination Distance. Items shall be examined at a viewing distance of approximately 16 to 22 inches except where the nature of the defect requires closer examination. i.e., stitches per inch, etc.

3.2 Asterisk (*) Defects. Defects designated by an asterisk (*) shall be classified as major when seriously affecting appearance or serviceability or as minor when affecting appearance or serviceability, but not seriously.

3.3 Identification Mark.

3.3.1 Trade Mark. An identification mark such as a letter, word or symbol used in connection with merchandise which points distinctly to a specific supplier.

3.3.2 Hallmark. An identification mark which is issued under a certification program regulated by a specific Government agency or Department other than the procuring agency.

3.3.3 Quality Mark. An identification mark which indicates quality in accordance with Federal Trade Commission trade practice rules for the jewelry industry.

3.4 Samples.

3.4.1 Standard Sample. A sample identified and sealed by an agency or Department other than the procuring agency which is used for matching color and finish only.

3.4.2 Approved Sample. A sample identified and sealed by the procuring agency for the purpose of matching color, finish and other characteristics.

3.5 Face Side. That side of the fabric which by reason of weave, finish or other factor, presents a better appearance than the other side.

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3.6 Shade and Finish Tolerances. Shade or finish range established by the procuring agency based on the standard sample. Contractor may submit samples to the procuring activity for establishment of the range, however, the approved sealed samples remain in effect for acceptance purposes for the duration of the contract.

3.7 Material Engraving Defect. Any material imperfection on the reverse side of a decoration or medal pendant or suspension bar which would interfere with an engraving, shall be classified as a major defect.

4. GENERAL

4.1 This standard contains the provisions for component and end item examination and testing, dimensional examination and the examination and preparation for delivery requirements for decorations and sets, medals and sets, and service ribbons with ribbon attachments. If there are any inconsistencies between the requirement of the appropriate specification and the provisions of this standard, the specification shall take precedence.

5. VISUAL EXAMINATION AND TESTING

5.1 Responsibility for Inspection. Unless otherwise specified in the contract or purchase order the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified, the supplier may utilize his own facilities or any commercial laboratory acceptable to the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

5.2 First Article Sample. When required, inspection and testing of the first article sample shall be made of a completely fabricated decoration or medal set for all provisions of this purchase instrument applicable to the end product examination and tests.

5.3 Quality Conformance Inspection. Unless otherwise specified, inspection shall be in accordance with MIL-STD-105.

5.3.1 Quality Conformance Inspection of Components.

5.3.1.1 Testing of Components*. In addition to the quality assurance provisions of the subsidiary specifications and drawings, testing shall be performed on components and materials listed (as applicable) in Table I for the test characteristics shown.

*NOTE: Not applicable to Government furnished components.

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TABLE I - Component Testing

| Component & Lot Expressed in Terms Of | Characteristic | Rqmt. Para. | Test Method | Rqmt. Appl. To Indiv. Unit | # Deter. Per Sample Unit | Results Reported AS | Sple. Unit | Insp. Lv. | AQL |
|---|----------------------------|--|---|-------------------------------|------------------------------------|--|--|-----------------------------|------|
| Copper Base Alloys, as applicable | Chemical Composition | 3.3.1 (Table 1) MIL-D- D3943 | Method III, Fed Test Method Std. No. 151 | X | 2 for ea element (composite) | To nearest 0.1% for each element | One 4" x 4" piece or equiva- lent for ea alloy and 10 sets of attaching devices | S-1 | N.A. |
| | | 3.4.1 (Table 1) MIL-L- 11484 | " | X | | | | S-1 | N.A. |
| | | 3.3.1 (Table I) MIL-S- 3951 | " | X | | | | S-1 | N.A. |
| | | 3.4.1 (Table I) MIL-R- 41819B | " | X | | | | S-1 | N.A. |
| | | 3.4.1 (Table I) MIL-N- 3946 | " | X | | | | S-1 | N.A. |
| Ribbon, Rayon | Physical Require- ments | 3.3.2 MIL-R- 11589 | Table III MIL-R- 11589 FED-STD- 191 | X | | | 3 Continu- ous Yds. | Para 4.3 MIL-R- 11589 | |

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5.3.1.2 Certification of Compliance. Components and material listed below may be acceptable on the basis of a contractor's certification of compliance for requirements specified in applicable paragraphs of the cited specifications.

| COMPONENT | CHARACTERISTICS | REQUIREMENT PARAGRAPH |
|------------------------|--|--|
| *Gold Alloy | Karat | 3.3.2.1 and 3.3.2.2 MIL-D-3943 and applicable MS Sheet |
| | Karat | 3.4.3.1 MIL-L-11484, 3.4.5 MIL-R-41819 and applicable MS Sheet |
| *Gold Filled Plate | Karat and lamination thickness | 3.4.3.2 MIL-L-11484 and applicable MS Sheet |
| | Karat and lamination thickness | 3.3.2.2 MIL-D-3943, 3.4.6 MIL-R-41819 and applicable MS Sheet |
| Solder (as applicable) | Material identification and melting point | 3.4.4.1 and 3.4.4.2 MIL-L-11484, 3.4.8 MIL-R-41819 |
| Vitreous enamel | Material identification | 3.3.4.1 MIL-D-3943 |
| | Material identification | 3.4.6.1 MIL-L-11484 |
| Organic enamel | Material identification | 3.3.4.2 MIL-D-3943 |
| | Material identification | 3.4.6.2 MIL-L-11484 |
| Attaching Device | Material identification | 3.6.5 MIL-D-3943 |
| | Material identification | 3.7.1 MIL-L-11484 |
| | Material identification and temper | 3.4.2 MIL-S-3951 |
| Rivets | Material identificaiton | 3.4.7 MIL-L-11484 and applicable MS Sheet |
| Gold Plating | Karat and use of white metals as an undercoating | 3.3.2.3 & 3.7.1, MIL-D-3943 3.4.2 & 3.8.1, MIL-M-3946 |

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| COMPONENT | CHARACTERISTICS | REQUIREMENT PARAGRAPH |
|--|--|--|
| Ribbon (Rosettes) | Material identification, Presence of sulfur, crocking, wet-dry cleaning, water, light and adhesive | 3.4.3.3 & 3.9.2.1 MIL-L-11484; 3.4.4 & 3.7.1.1, MIL-R-41819 3.2.1, 3.2.1.1 & 3.3 IP/DES S-153-1 |
| Clips | Material identification | 3.4.1.1 and 3.4.1.1.1 MIL-S-3951 |
| Back Strip | Material identification | 3.4.1.1 and 3.4.1.1.2 MIL-S-3951 |
| Bars | Material identification and temper | 3.4.2 MIL-S-3951 |
| *Sterling Silver | Fineness | 3.3.3.1 MIL-D-3943 and applicable MS Sheet 3.4.2.1 MIL-L-11484 and applicable MS Sheet 3.4.2 MIL-R-41819 |
| Silver Alloy | Fineness | 3.3.3.2 MIL-D-3943 and applicable MS Sheet |
| Silver for Plating | Fineness | 3.4.2.2 MIL-L-11484 and applicable MS Sheet 3.4.3 MIL-R-41819 |
| Lacquer | Material identification | 3.3.9 MIL-D-3943 3.3.8 MIL-C-14633 3.4.5 MIL-L-11484 3.4.7 MIL-R-41819 3.4.4 MIL-M-3946 |
| Fastner, Snap | Type, size, material identification and plating | 3.3.8 MIL-D-3943 |
| Steel for Case Shell and Attachment Tabs | Material identification and thickness | 3.3.1 and 3.4 MIL-C-14633 |

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| COMPONENT | CHARACTERISTIC | REQUIREMENT PARAGRAPH |
|--|--|---|
| Plush and Satin Cloth | Material identification | 3.1.2 MIL-C-14633 |
| Wire for Attachment loops | Material identification and Karat of plating | 3.3.6 MIL-C-14633 |
| Hardware (hinge and striking edge) | Material identification | 3.3.4 and 3.4 MIL-C-14633 |
| Cloth, Pyroxylin Coated or Vinyl (as applicable) | Material identification | 3.3.7, 3.3.7.1 and 3.3.7.2 MIL-C-14633 |
| | Ends and Picks | 3.3.7.1 MIL-C-14633 |
| | Weight per Sq. yard | 3.3.7.1 MIL-C-14633 |
| Lift Tabs | Material identification | 3.4.3.1 MIL-C-14633 |
| Mylar, Leaf | Material identification | 3.3.9 MIL-C-14633 |
| Paper | Material identification and ply | 3.3.3 MIL-C-14633 |
| Polyutherane Pad | Material identification and density | 3.4 MIL-C-14633 |
| Pad | Material identification and plies | 3.4.3.1 and 3.4.3.2 MIL-C-14633 |
| Plastic | Material identification and thickness | 3.3.10 MIL-D-3943 and applicable MS Sheet |
| Cement | Material identification | 3.3.11 MIL-D-3943 |

* The contractor's quality marking may be accepted in lieu of a certification of compliance. The Government reserves the right to select samples of the gold and silver to such extent as it deems advisable (and without additional costs to the Government), for the purpose of verifying the accuracy of contractor's certification.

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5.3.2 Inspection of the End item.

5.3.2.1 Visual Examination. The defects found during examination shall be classified in accordance with 5.3.2.1.1 and 5.3.2.1.2. The lots shall be inspected in accordance with 5.3.2.1.3. The unit of product for these examinations shall be one complete set of decorations or medals with case; one assembled decoration and service ribbon; one assembled decoration and ribbon attachment; or one assembled service ribbon with ribbon attachment.

5.3.2.1.1 Examination of end items for Visual Characteristics.

| EXAMINE | DEFECT | MAJOR | * | MINOR |
|---|--|-------|---|-------|
| Metal Components | | | | |
| Color and finish: unplated, plated and enameled surfaces | Color and finish not as specified or does not compare favorably with the standard or approved sample.... | X | | |
| | Any solder spatter on front or edges..... | | * | |
| | Discoloration, spot or stain..... | | * | |
| | Pitted, Porous or rough surface..... | | * | |
| | Not plated when required or plating is not specified type..... | X | | |
| | Plating is not continuous, or is cut through, is porous, or is not adherent..... | | * | |
| | Foreign matter imbedded..... | | * | |
| | Not enameled when required..... | X | | |
| | Enamel is not type specified or it is cracked, chipped or crazed..... | | * | |
| | Bubble, lump, hole, blister, scratch, foreign inclusion, lap, overrun or skip..... | | * | |
| | Fishscale, copperhead, burn off, scale or specking..... | | * | |
| | Scumming or lack of gloss..... | | * | |
| | Not clean; e.g., blemish such as spot, stain or spatter..... | | * | |
| Lacquering | Not lacquered where required..... | X | | |
| | Lacquer is not set to touch, i.e., is tacky when gentle pressure is applied..... | | | X |

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| EXAMINE | DEFECT | MAJOR | * | MINOR |
|---------------------|---|-------|---|-------|
| Lacquering (cont'd) | Coating is blushed or is clouded... | | | X |
| | Foreign matter imbedded..... | | * | |
| | Coating is not smooth and uniform, or is not adherent, e.g., forms noticeable runs or coarse par- ticles, or is flaking, blistering or peeling..... | | * | |
| Design | Any operation not in accordance with the specified requirements... | | * | |
| | Design altered and does not conform to Government hub..... | X | | |
| | Any warp, twist or distortion pro- ducing irregular surface contour or outline..... | | * | |
| | Any significant detail obliterated. | X | | |
| | Any significant detail reduced..... | | * | |
| | Detail struck over, resulting in a double impression..... | X | | |
| | Edges are not trimmed as specified. | | * | |
| Type and Class | Not as specified..... | X | | |
| Material | Any component not fabricated of the specified material..... | X | | |
| Quality of Metal | Surface pitted, porous, crystalline spotted or open grained..... | | * | |
| | Mutilations such as dig, dent, nick, gouge or scratch affecting appearance..... | | * | |
| | Pinhole, crack or rupture..... | | * | |
| Construction and | Rim, edge or outline is not well defined or not smooth..... | | * | |
| Workmanship | Vitreous enamel is not smooth and level with the dikes, e.g., it is coarse or contains high or low spots..... | | * | |
| | Any enamel not contained within prescribed outline of design..... | | * | |
| | Solder does not completely unite component part to bare metal, i.e., any perceptible opening between component parts..... | | * | |

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| EXAMINE | DEFECT | MAJOR | * | MINOR |
|---------------------------------------|---|-------|---|-------|
| Construction and Workmanship (cont'd) | Joints not clean and smooth, e.g., flux or excess solder not removed. | | | X |
| | Metal burned or reduced in soldering..... | | * | |
| | Any component missing or broken.... | X | | |
| | Any component bent, twisted, deformed or otherwise impaired..... | | * | |
| | Any component not connected or joined as specified, or operation is poorly accomplished..... | | * | |
| | Metal cracked, fractured, malformed, distorted, or otherwise impaired..... | | * | |
| | Dykes or letters are distorted..... | | * | |
| | Not pierced where required..... | X | | |
| | Not trimmed to die struck edges.... | | * | |
| | Design or shape is damaged, distorted or altered by piercing..... | X | | |
| | Piercing is not clean and smooth, e.g., any burrs, drag, cutter or file marks..... | | * | |
| | Wrong type..... | X | | |
| | Color or shade is not a match to the standard or approved sample; or color pattern is not as specified..... | X | | |
| | Finish is not as specified, e.g., is not moire or plain when required..... | | | X |
| | Face side of ribbon not on obverse side of pendant..... | | | X |
| | Soiled or stained..... | | * | |
| | End out, broken or missing yarn, tear, cut, hole, float or defective selvage..... | | * | |
| | Smash..... | X | | |
| Quality of Ribbon Material | Coarse end, knot, slub, uneven texture or other imperfection..... | | * | |
| | More than 2 wrong color threads appearing in selvage or in pattern..... | | | X |

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| EXAMINE | DEFECT | MAJOR | * | MINOR |
|-------------------------------------|--|-------|---|-------|
| Quality of Ribbon Material (Cont'd) | Filling yarn showing between ground and binder (on front surface..... | | * | |
| Sewing (as applicable) | Not sewn or tacked where required.. | X | | |
| | Sewing or tacking is not neatly or securely accomplished, or not as specified..... | | * | |
| | Color of thread does not match the color of ribbon where sewn..... | | * | |
| Attaching Devices | Any component missing | X | | |
| | Component misplaced or is not attached as specified..... | | * | |
| | Fastening device not positioned as specified or components off center by 1/8 inch or more..... | | * | |
| | Any part damaged, distorted, or deformed..... | | * | |
| | Not type, size or material specified..... | X | | |
| | Sharp edge, fin or sliver..... | | * | |
| | Safety catch will not function or is loose (pin may be expected to become disengaged)..... | X | | |
| | Hinged joint does not operate as required, viz., it is too loose or too tight..... | | * | |
| | Pin or prong point is blunted or is hooked, or the pin is bent..... | | * | |
| | Pin point extends less than 1/32 inch beyond the rotor of the safety catch..... | X | | |
| | Pin point extends more than 1/32 inch beyond safety catch..... | | | X |
| | Prong is loose..... | X | | |
| | Prong missing..... | X | | |
| | Clutch fastener will not engage.... | X | | |
| | Toothed ring does not rotate freely or binds..... | X | | |
| | Clutch is loose fit on prong..... | X | | |
| | Threads on post or nut are stripped, crossed, damaged, or not specified size or type..... | X | | |

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| EXAMINE | DEFECTS | MAJOR | * | MINOR |
|--|--|-------|---|-------|
| Attaching Devices (Cont'd) | Staple prongs positioned more than 1/4 inch off center..... | | * | |
| | Post type prong positioned more than 1/16 inch off center from each other..... | X | | |
| | Center of both post type prongs located more than 1/32 inch from applicable centerline..... | X | | |
| | Component parts are not completely joined by solder or not tightly swaged, as required..... | | * | |
| | Area burned or reduced in soldering..... | | | X |
| | Joint not clean and not smooth, e.g., flux or excess solder not removed..... | | | X |
| Lettering and identification and quality marking | Missing, illegible, misspelled, not correct type or size specified, not applied in the specified manner or not in the specified location..... | | | X |
| Assembly of Components: Pendant | Device is not riveted as required. | X | | |
| | Rivets are not correct type or size; or are not properly peened. (May be removed by hand or peening results in rough sharp edges) | X | | |
| | Device is not centered on the pendant (when applicable). | | * | |
| Pendant Ribbon | Ribbon not clinched to bar, i.e., clip slips laterally under slight pressure..... | X | | |
| | Not box pleated at ribbon ring, i.e., both selvages of the front portion of the ribbon are not visible throughout (back portion of the ribbon not completely covered)..... | | * | |
| | Distorted drape, e.g., creased or improperly pleated..... | | * | |

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| EXAMINE | DEFECT | MAJOR | * | MINOR |
|--|--|-------|---|-------|
| Rosettes | Ribbon does not completely cover and line the metal cup..... | | * | |
| | Ribbon does not form a double fan within the cup..... | X | | |
| | Ribbon is not smoothly and securely cemented in place, e.g., any wrinkle, pucker, loose end or area of non-adhesion..... | | * | |
| | Metal form not the correct type or of the same material used in the standard sample..... | X | | |
| | Form's finish not as on standard sample..... | | | X |
| | Form malformed, twisted, cracked, bent out of shape or otherwise impaired affecting use..... | X | | |
| | Sharp edge, burr or sliver..... | X | | |
| Service Ribbon | Clip is loosely or tightly clinched over the back strip.... | X | | |
| | Ribbon is not tautly stretched over the face of the clip..... | | | X |
| | Metal clip is exposed more than 1/32 inch on either side..... | X | | |
| | Device is not centered symmetrically upon the front of the ribbon (where applicable)..... | | * | |
| | Prong of device is missing, is defective, or does not pass through slots in the clip and bar..... | X | | |
| | The prongs of device are not spread apart 180° parallel to the long sides of the bar..... | | | X |
| Lapel Button | Device is not secured by solder (when applicable)..... | X | | |
| Covered Case: (when applicable) Color and Finish | Color and shade of any component is not as specified or is not a close match to the standard or approved sample..... | | * | |

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| EXAMINE | DEFECT | MAJOR | * | MINOR |
|--|---|-------|---|-------|
| Covered Case: (when applicable) Color and Finish (Cont'd) | Ornamentation and lettering is missing, not clear and distinct, not imitation gold mylar leaf, not specified type or size, not applied in the specified manner or location, or spelling is incorrect..... | X | | |
| Design | Not in accordance with the specified requirements..... | X | | |
| Material | Not fabricated of the specified materials..... | X | | |
| Workmanship and Construction | Outer covering is not smoothly and tightly applied, e.g., blisters or wrinkles..... | X | | |
| | Visible imperfection in cover, i.e., cut, torn, abraded or otherwise damaged..... | | * | |
| | Tension of hinge spring is loose, e.g., the lid does not spring close when released from a 30 degree angle..... | X | | |
| | Any fabric not held smoothly or securely in place..... | X | | |
| | Fabric is torn, cut, frayed, split, contains hole, or is otherwise damaged..... | | * | |
| | Case is punctured, broken, indented, malformed, or otherwise damaged..... | | * | |
| | Fabric not clean, e.g., stain, spot, adhesive or foreign matter. | | * | |
| | Attachments, lift tabs, wire loops or cord missing or not securely anchored..... | X | | |
| Plastic Case (when applicable) | Cracked, scratched, fractured, distorted or otherwise impaired.. | | * | |
| Assembly: Of Set in Case | Any component missing..... | X | | |
| | Components do not fit within the case as required..... | | * | |
| | Edges of the top and bottom section of the case are not aligned and in contact when filled case is closed..... | X | | |

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5.3.2.1.2 Examination of end items for Defects in Dimensions. Any dimension that is not within the specified tolerances shall be classified as a defect.

5.3.2.1.3 Inspection levels and AQL's. The inspection levels and acceptable quality levels (AQL's) expressed in defects per hundred units (DHU) shall be as follows:

AQL

| | <u>Inspection Level</u> | <u>Major</u> | <u>Total</u> |
|----------------------------------|-------------------------|--------------|--------------|
| Defects applicable for 5.3.2.1.1 | II | 2.5 | 10.0 |
| Defects applicable for 5.3.2.1.2 | S-3 | (One Class | 4.0 |
| Defects applicable for 5.3.2.1.1 | II | 0.25 | 2.5 |

5.3.2.2 Testing of the End Item. Testing of completely fabricated pendants, lapel buttons and service ribbons with devices shall be performed in accordance with end item testing table II, where applicable, for the characteristics shown therein. The sample unit shall be one each pendant, lapel button and individual unit with one determination per sample unit and the results shall be reported as pass or fail. The inspection level shall be S-1 and the acceptable quality level (AQL) shall be 4.0 d.h.u.

TABLE II - End Item Testing

| CHARACTERISTIC | REQUIREMENT PARAGRAPH | TEST METHOD |
|-----------------------|-----------------------|-------------|
| Test for gold plating | 3.7.1.1 | 4.4.4 |
| | MIL-R-41819 | MIL-R-41819 |
| | 3.7.1 | 4.4.4 |
| | MIL-D-3943 | MIL-D-3943 |
| | 3.8.1 | 4.4.4 |
| | MIL-M-3946 | MIL-M-3946 |
| | 3.9.2.1 | 4.4.6 |
| Test for pins, | MIL-L-11484 | MIL-L-11484 |
| | 3.6.5 | 4.4.3 |
| | MIL-D-3943 | MIL-D-3943 |
| | 3.7.1.2 | 4.4.3 |
| | MIL-L-11484 | MIL-L-11484 |
| | 3.7.5 | 4.4.2 |
| | MIL-M-3946 | MIL-M-3946 |

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TABLE II - End Item Testing (Cont'd)

| CHARACTERISTIC | REQUIREMENT PARAGRAPH | TEST METHOD |
|--|--|--|
| Test for clutch | 3.7.1.1, 3.7.1.4 MIL-L-11484 3.4 MIL-S-3951 | 4.4.4 MIL-L-1148 4.4.2 MIL-S-3951 |
| Test for Screw posts and toothed rings | 3.7.1.3 MIL-L-11484 | 4.4.5 MIL-L-11484 |
| Test for lacquer: liver of sulfur <u>1/</u> | 3.7.2 MIL-R-41819 3.7.3 MIL-D-3943 3.9.4 MIL-L-11484 3.8.3 MIL-M-3946 | 4.4.5.1 <u>1/</u> Lacquered MIL-R-41819 ribbon 4.4.5.1 rings and MIL-D-3943 loops may 4.4.7.1 be tested MIL-L-11484 as an 4.4.5.1 intermediate MIL-M-3946 |
| Tackiness | 3.7.2 MIL-R-41819 3.7.3 MIL-D-3943 3.9.4 MIL-L-11484 3.8.3 MIL-M-3946 | 4.4.5.2 MIL-R-41819 4.4.5.2 MIL-D-3943 4.4.7.2 MIL-L-11484 4.4.5.2 MIL-M-3946 |
| Test for Soldered Joints and Electronic Fused Joints | 3.6.2 MIL-M-3946 3.5.2 MIL-D-3943 3.6.2 MIL-L-11484 3.6.2 MIL-R-41819 3.6.3 MIL-R-41819 | 4.4.3 MIL-M-3946 4.4.2 MIL-D-3943 4.4.2.1 and 4.4.2.2 MIL-L-11484 4.4.3 MIL-R-41819 4.4.2 MIL-R-41819 |
| Test for Organic Enamel | 3.7.2.2 MIL-D-3943 | 4.4.6 MIL-D-3943 |

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5.3.2.3 Examination of Preparation for Delivery Requirements. An examination shall be made to determine that packaging, packing and marking requirements as specified are complied with. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully prepared for delivery with the exception that it need not be sealed. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot size shall be the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 and the AQL shall be 4.0 defects per one-hundred units.

| EXAMINE | DEFECT |
|-------------------------------------|--|
| Markings (exterior and interior) | Omitted, incorrect, illegible, of improper size, location sequence or method of application. |
| Materials | Any component missing. Any component damaged, affecting serviceability. |
| Workmanship | Inadequate application of components such as incomplete closure of case liners, container flaps, loose strapping, inadequate stapling. Bulging or distortion of containers. |
| Weight and Content | Number per container is more or less than required; net weight exceeds requirements. |

Custodians:

Army - IH
Navy - SA
AF - 82

Preparing activity:

The Institute of Heraldry,
United States Army - IH

Project No. 8455-0434

Review Activities:

Navy - SA, MC
AF - 11
Other - DP

User Activities:

Army - SM
Other - CG

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Alexandria, Va. 22314

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PENALTY FOR PRIVATE USE \$300

Commander
The Institute Of Heraldry, U. S. Army
Attn: AGAH-T
Cameron Station
Alexandria, Va 22314

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