

CAP DRESS WHITE, CLASS 2  
CAP, UNIFORM GRAY, CLASS 1  
For  
U.S. Military Academy

1. Specification consists of the following:
  - a. Deviations & Additional Information, Cap, Service, Cadet, UQC-S-01-83 (20 May 83), dtd 13 December 2017, 2 pages
  - b. Deviation and Additional Information, Cap, Service, Cadet, UQC-S-01-83 (20 May 83), dtd 31 August 2015, 1 page
  - c. Deviations & Additional Information, Cap, Service, Cadet, UQC-S-01-83 (20 May 83), dtd 19 February 1991, 1 page
  - d. Bar Code Labels Characteristics, dtd 12/10/97, 2 pages
  - e. Purchase Description for Cap, Service, Cadet, UQC S-01-83, 20 May 1983, 17 pages
  - f. Figure 1: Cap, Service, Cadet, Uniform, Gray, Three Quarter View, UQC S-01-83, 20 May 1983, 1 page
  - g. Figure 2: Cap, Service, Cadet, Uniform, Gray, Side view, UQC S-01-83, 20 May 1983, 1 page
  - h. Figure 3: Cap, Service, Cadet, White, Three Quarter View, UQC S-01-83, 20 May 1983, 1 page
  - i. Figure 4: Cap, Service, Cadet, White, Side View, UQC S-01-83, 20 May 1983, 1 page
  - j. Dress cap evaluation table, UQC-S-01-83 (20 May 83), dtd 13 December 2017, 4 pages

2. **Government Furnished Materials**

<b>Material</b>	<b>Used For:</b>
<b>Gray cloth</b>	<b>Gray cap</b>
<b>Buttons</b>	<b>Gray cap, White cap</b>
<b>Insignia</b>	<b>Gray cap, White cap</b>
<b>Gold straps</b>	<b>White cap</b>

All items not identified as Government Furnished Material (GFM) shall be provided by the contractor.

Deviations & Additional Information  
Cap, Service, Cadet  
UQC S-01-83 (20 May 83)

Federal specification V-T-276 has been cancelled and replaced with A-A-52094.

Federal specification V-T-295 has been cancelled and replaced with A-A-59826.

Federal specification TT-E-489, dated March 7, 1994 is hereby cancelled. Master Painters Institute, Reference #9, Alkyd, Exterior, Gloss, (MPI Gloss Level 6) and Reference #94, Alkyd, Exterior, Semi-gloss, (MPI Gloss Level 5) may be used for future procurements of this commodity.

Federal specification TT-L-58, dated 26 October 1978, is hereby cancelled. Future acquisition for this material should refer to A-A-3003.

Federal specification CCC-C-700 dated September 15, 1986 is hereby cancelled, and replaced by A-A-59517.

Federal Specification DDD-B-1199, dated December 1, 1971, is hereby cancelled. Future acquisitions for this item should refer to Commercial Item Description A-A-52067; Binding, Textile, Cotton, Bias-Cut.

Federal Specification PPP-B-636 dated July 12, 1981 is hereby cancelled and replaced with ASTM D5118, Standard Practice for Fabrication of Fiberboard Shipping Boxes, and ASTM D1974, Standard Practice for Method of Closing, Sealing, and Reinforcing Fiberboard Shipping Containers.

Federal Specification PPP-B-F-320 dated October 27, 1970 including Interim Federal Specification PPP-F-00320E dated January 4, 1911 is hereby cancelled and replaced with ASTM D4727, Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Out Shapes.

MIL-S-3577 has been cancelled with no replacement.

Federal specification CCC-C-700J dated September 15, 1986 is hereby cancelled and replaced by A-A-59517, CLOTH, COATED, VINYL COATED (ARTIFICIAL LEATHER).

Para 3.3.3.1 Inner body band. Class 1. Federal Specification L-P-390, dated 10 August 1971, is inactivated for new design and is no longer used, except for replacement purposes. Future acquisition for this product, when used in new design, should refer to ASTM D 4976, "STANDARD SPECIFICATION FOR POLYETHYLENE PLASTICS MOLDING AND EXTRUSION MATERIALS".

Para 3.3.8 Cotton warp and rayon filling cloth or monofilament filling cloth. MIL-C-43675, has been replaced by A-A-52086.

Para 3.3.7.2 Front Stiffener Class 2. MIL-C-43920 has been replaced with A-A-52108.

Federal Specification V-T-276, dated October 19, 1976, is hereby cancelled.  
Future acquisitions for this item should refer to Commercial Item Description A-A-52094, Thread, Cotton.

V-T-295, dated 01 August 1985, is hereby cancelled. Future acquisitions should refer to Commercial Item Description A-A-59826, Thread, Nylon.

Para 3.3.22 Nylon grommet. Federal Specification H-S-951, dated August 12, 1976, is hereby cancelled without replacement.

Para 4.2.1.1 Component and material inspection. FED-STD-191 NOT 1, dated 21 June 1990, is hereby inactive for new design.

Para 4.2.1.1 Component and material inspection. This notice to the cancellation notice for FED-STD-406 is issued to correct the number for a referenced ASTM Test Method. On page 1, under the ASTM Test Method Number for numbers 1082 and 1083, delete "D 2440" and substitute "D 2240".

Para 4.2.1.1 Component and material inspection. FED-STD-601, dated 12 April 1955, with Change Notice 7, dated 17 August 1976, is inactive for new design, and is no longer used, except for replacement purposes.

Deviation & Additional Information

Cap, Service, Dress, Cadet

UQC-S-01-83 (20 May 1983)

1. Para. 3.3.12.2 **Chin Strap.** The contractor shall obtain, procure the chin strap for the Class II Caps Class 2 IAW the Government provided specifications and shall be applied to, packaged and shipped with each cap.
2. Para. 3.3.19 **Buttons.** The contractor shall procure and provide the Buttons & Button Keepers for the caps IAW Government provided specifications and shall be applied to and shipped with each cap.
3. Para. 3.3.20 **Insignia.** The contractor shall procure & provide the Cadet insignia IAW the Government provided specifications and shall be applied to and shipped with each cap.
4. **New Label/Label information requirement.** Effective immediately there shall be a new requirement for the contractor to provide manufacturing & contract information on an existing label or a new label that shall be durable and expected to stay on the cap for at least 18 months. The printed information shall consist of the month and year of manufacture and the contract number associated with the item. Thus meaning the number of the contract for which this specific item was provided for.
5. **New Warranty.** The contractor shall provide a warranty against manufacturing defects, poor workmanship, defective components, excluding any Government provided components for a period of 18 months from the date of delivery of the items from the referenced contract. The contractor shall provide a replacement cap for any caps/items found to be defective and/or covered under the warranty and to provide for the replacement at no further cost to the government.
6. This deviation is effective immediately and will affect and is applicable to any current actions already started or in progress.
7. The above referenced changes are the only changes to the deviation dated 19 February 1991. All other requirements in that document are still applicable and in force.



Michael A Saathoff  
Chief, Supply/Supply Management Officer  
ASC/LRC-Cadet Service Div., Supply

19 February 1991

Deviations & Additional Information  
Cap, Service, Cadet  
UQC-S-01-83 (20 May 83)

Para 3.3.1 Basic Material Class 1. The wool elastique cloth (19 oz.) will be supplied to vendor by Cadet Services Division (.167 yards per cap).

Para 3.3.3.2 Inner Body Band Class 2. As a substitute, the Class 1 inner body band (natural or white) or a plastic simulated wood pulp body band may be used.

Para 3.3.9.1 and 3/3/9.2 Cotton Thread Class 1 (gray cap) and Class 2 (white cap) should use black and white thread respectively, not white and black as stated.

Para 3.3.12.1 Chin Strap Class 1. Add: See Figure 1 for shape and placement of loops.

Para 3.3.12.2 Chin Strap Class 2. Chin straps for Class 2 caps will be supplied to vendor by Cadet Services Division.

Para 3.3.19 Buttons. Buttons will be supplied to vendor by Cadet Services Division.

Para 3.3.20 Insignia. Insignia will be supplied to vendor by Cadet Services Division.

Para 3.3.22 Nylon Grommet. An ethyl vinyl acetate "D" shaped grommet may be used as a substitute for the nylon grommet.

Para 3.6.7 Make Band & Para 3.6.8 Join Band to Quarters.  
add: NOTE - Any references to braid are for Class 1 cap only.

Para 3.6.10.2 a. Change title from "Make Crown Welt and Join Quarters to Crown Class 2" to "Join quarters to Crown Class 2."

b. Delete last two sentences of paragraph. 1/16" wire grommet is not required in Class 2 cap.

**Bar Code Labels Characteristics:**

1. 3 of 9 format.
2. Be affixed to each item so that it can be read without opening the package.
3. Be easily removed by the customer.
4. Remain intact while warehoused.
5. Size of label should be large enough to be read but not massive. Size will be relative to size of item. Estimated size: 2 1/4" x 3 1/4"
6. Label on carton, if possible. Label obviously displayed.
7. Each Bar Code should contain the following:  
  
    BARCODE (with Start & Stop Characters of \* )  
    STOCK NUMBER  
    DESCRIPTION  
    SIZE ( IF APPLICABLE )
8. A sample label for format is attached.
9. Must submit sample of your label for acceptability.



\*840501Y50Q356\*

CAP, DRESS GRAY

SIZE: 6 7/8

UNIFORM QUALITY CONTROL

PURCHASE DESCRIPTION

FOR

CAP, SERVICE, CADET

1. SCOPE

1.1 Scope. This purchase description covers the Uniform Service Cap for wear by Cadets of the United States Military Academy.

1.2 Classification. The caps shall be of one type in the following classes and sizes:

Class 1 - CADET, GRAY  
Class 2 - CADET, WHITE

Schedule of Sizes

6-3/8	7	7-5/8
6-1/2	7-1/8	7-3/4
6-1/4	7-1/4	7-7/8
6-3/4	7-3/8	
6-7/8	7-1/2	

2. APPLICABLE DOCUMENTS

2.1 The following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of this purchase description to the extent specified herein:

SPECIFICATIONS :

FEDERAL

V-T-276	- Thread, Cotton
V-T-295	- Thread, Nylon
TT-E-489	- Enamel, Alkyd, Gloss (For Exterior and Interior Surfaces)
TT-L-58	- Lacquer, Spraying, Clear and Pigmented (General Interior Use)
CCC-C-700	- Cloth, Coated, Vinyl Coated (Artificial Leather)
DDD-B-1199	- Binding, Textile, Cotton, Bias-Cut
PPP-B-636	- Box, Fiberboard
PPP-F-320	- Fiberboard: Corrugated and Solid, Sheet Stock (Container Grade), and Cut Shades



May 1983

## MILITARY

MIL-C-368 - Cloth, Satin, Rayon and Cloth, Twill, Rayon  
MIL-B-1563 - Buttons, Insignia and Findings (USMA)  
MIL-S-3577 - Sweatband, Headwear: Leather  
MIL-C-82252 - Cloth, Broadcloth, Wool, and Wool Synthetic

## PURCHASE DESCRIPTION

QMC P/DES 277 - Cloth, Wool, Elastique, Cadet Gray (USMA)

## STANDARDS

### MILITARY

MIL-STD-129 - Marking for Shipment and Storage

(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.)

2.2 Other publications. The following document forms a part of this purchase description to the extent specified herein. Unless otherwise indicated, the issue in effect on date of invitation for bids or request for proposal shall apply.

### STANDARD COLOR CARD OF AMERICA

(Application for copies should be addressed to the Color Association of the United States, Inc., 200 Madison Avenue, New York, NY 10016.)

## 3. REQUIREMENTS

3.1 Guide sample. Samples, when furnished (see 6.3), are solely for guidance and information to the supplier. Variation from the purchase description may appear in the sample in which case the purchase description shall govern.

3.2 Uniformity of production. The materials, component items, and the finished cap shall meet or exceed the minimum requirements for the item as specified in this purchase description.

### 3.3 Materials.

3.3.1 Basic material. Class 1. The basic material for the body of the cap shall be cadet gray (USMA), wool elastique cloth, conforming to Type II, 19 oz. of QMC P/DES 277. The crown and the quarters shall be laminated to a polyester/cotton drill fabric, weighing 4.0 ounces per square yard  $\pm$  10 percent. A water-base latex adhesive shall be used to permanently bond the fabrics so that no delamination will occur during normal use.

In addition, the fusible interlining shall have a peel strength of 20 ounces per inch when tested as specified in Table IV of paragraph 4.2.1.2.

3.3.2 Basic material. Class 2. The basic material shall be vinyl coated cloth (artificial leather) conforming to Class 7, untreated, white, of CCC-C-700, with the following exceptions:

- a. The widths of the base and coated cloths are not required.
- b. The commercial designation of the base cloth shall be 3.7 ounces per square yard.
- c. The weight of the coated cloth shall be 15.0 ounces per square yard (minimum).
- d. The coating weight shall be 12.0 ounces per square yard (minimum).

3.3.3 Inner body band.

3.3.3.1 Inner body band. Class 1. The inner body band shall be of high density (linear) polyethylene plastic material meeting the requirements of Type III, Class H, grades 1 or 2 of L-P-390, except that low temperature brittleness, dielectric constant, dissipation factor and thermal stress cracking resistance properties shall not apply. The band shall be extruded, stripped split or cut  $2 \pm 1/16$  inch wide with a thickness of  $.030 \pm .002$  inch. The band shall be perforated by punching or other means in a repetitive pattern as approximated by the standard sample with the diameter of the holes as shown by the standard sample. Not less than a  $3/8$  inch margin at top and bottom of band shall remain unperforated.

3.3.3.2 Inner body band. Class 2. The material for the inner body band shall be composed of a high alpha cellulose wood pulp sheet impregnated with an oil-resistant and perspiration-resistant synthetic rubber binder and shall conform to the requirements specified in Table II.

Table II. Material for Inner Body Band

Characteristics	Requirements
Thickness	0.05 (plus 0.003 or minus 0.002) inch
Weight	1.4 (plus or minus 0.15) pounds per square inch
Tearing strength	
Machine direction	800 grams, minimum
Cross direction	1,000 grams, minimum
Tensile strength	
Machine direction	110 pounds per inch of width, minimum
Cross direction	60 pounds per inch of width, minimum
Resistance to accelerated aging	No evidence of embrittlement or stiffening and no development of stickiness or delamination
Resistance to water	No evidence of shrinkage or warping (tolerance of plus or minus 1 percent)

### 3.3.4 Braid.

3.3.4.1 Braid. Class 1. The cap braid shall be flat, mohair, conforming to the following requirements.

Color: The color shall be black and shall show good fastness to water, light and dry cleaning.

Width: 1-3/4 inches (full).

Warp: 22 spools of 2 ends of 40/2 mercerized cotton.

Braiding: 89 carriers, 2 ends per carrier, 2/30 mohair.

Picks: 24

Weave: 2 over - 2 under

Weight: Not less than 7 pounds per gross yard.

3.3.4.2 Braid. Class 2. The band shall be 1-3/4 - 2 inches wide, made of white vinyl flat, simulated braid in accordance with good commercial practice.

### 3.3.5 Lining.

3.3.5.1 Lining. Class 1. The material for lining the cap quarters and front stiffener shall be black rayon lining material conforming to Class 1 or 2 of MIL-C-368. The material for lining the cap crown shall be black rayon lining material.

3.3.5.2 Lining. Class 2. The material for lining the cap crown and front stiffener shall be white rayon lining material conforming to Class 1 or 2 of MIL-C-368.

### 3.3.6 Binding.

3.3.6.1 Binding. Class 1. The material for top edge of front stiffener, sweat-band reinforcing strip, binding or inner body band, and reinforcing the joining seam of the sidequarters lining shall be 1 inch wide, black, bias cut, cotton cambric, conforming to Type I, Class 1 or 2 of DDD-B-1199, and for reinforcing the haircloth to front joining seam shall be black, bias-cut, cotton twill, conforming to Type IV, Class 2 of DDD-B-1199.

3.3.6.2 Binding. Class 2. The material for top edge of inner body band shall be 1 inch wide, vinyl coated cloth (artificial leather), conforming to Class 7, untreated, white, of CCC-C-700.

### 3.3.7 Front stiffener.

3.3.7.1 Front stiffener. Class 1. The front stay shall be of high density (linear) polyethylene plastic material meeting the requirements of Type III, Class H, grades 1 or 2 of L-P-390, except that low temperature brittleness, dielectric constant, dissipation factor and thermal stress cracking resistance properties shall not apply. The stay shall be extruded.

3.3.7.2 Front stiffener. Class 2. The front stay shall be cotton warp and rayon for front stay and shall conform to MIL-C-43675. When the alternate monofilament filling cloth is used, the fabric shall conform to Type I of MIL-C-43920.

3.3.8 Cotton warp and rayon filling cloth or monofilament filling cloth. The cotton warp and rayon filling cloth for front stay shall conform to MIL-C-43675. When the alternate monofilament filling cloth is used, the fabric shall conform to Type I of MIL-C-43920.

3.3.9 Thread.

3.3.9.1 Cotton thread. Class 1. The thread for seaming and stitching shall be cotton, machine, mercerized, sizes A and O, conforming to Type IC2 of V-T-276. The color shall be white, shade AA, cable no. 66043 of the United States Army Color Card.

3.3.9.2 Cotton thread. Class 2. The thread for seaming and stitching shall be cotton, machine, mercerized, sizes A and O conforming to Type IC2 of V-T-276. The color shall be black shade AA, cable no. 65005 of the United States Army Color Card.

3.3.9.3 Nylon thread. Class 1. The thread for tacking front stiffener to band, joining visor to cap, tacking welt ends, felling lining and attaching sweatband shall be nylon, Type IV, size C, conforming to Table IV of V-T-295. The thread color shall be black, shade AA, cable no. 66043 of the United States Army Color Card except that for attaching sweatband it shall be brown to match the shade of the sweatband.

3.3.9.4 Nylon thread. Class 2. The thread for tacking front stiffener to band, joining visor to cap, tacking welt ends, felling lining and attaching sweatband shall be nylon, Type IV, size C, conforming to Table IV of V-T-295. The thread color shall be white, shade AA, cable no. 65005 of the United States Army Color Card except that for attaching sweatband it shall be brown to match the shade of the sweatband.

3.3.10 Marking. Each cap shall be identified by a size marking, supplier's marking and linen name label or card.

3.3.10.1 Size marking. The size marking shall be legibly stamped, embossed, or may be gummed commercial paper label. The whole numbers shall be not less than 1/4 inch in height and fractions not less than 1/8 inch in height. The size marking shall be positioned on the outside of the sweatband 3/8 to 1/2 inch from top edge of the right or left of the back seam.

3.3.10.2 Supplier marking. The supplier will mark the cap with size and date in letters 1/4 inch in height.

3.3.10.3 Adhesive shade tickets. Adhesive shade tickets, when used for shade marking, shall be paper with a thermo-activated adhesive on one side that will withstand steam blocking operations. Adhesive shall not discolor the material, and no adhesive mass shall adhere to the material upon removal of the ticket.

3.3.11 Visor.

3.3.11.1 Visor. Class 1 and Class 2 Caps. The visor shall consist of three pieces of material, which shall be laminated, pressed and molded to form.

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3.3.11.2 Top piece. The top ply shall be poromeric material. It shall be black, homogenous polyurethane reinforced with polyester and shall contain no free plasticizer. It shall be  $60 \pm 5$  mils thick and shall have a shiny leather finish on top side.

3.3.11.3 Center piece. The plumper paper shall be a high alpha cellulose wood pulp paper which has been wet-web saturated with 10 to 15 percent by weight chloroprene latex. The saturated paper shall have a bone dry weight of  $0.62 \pm 0.062$  pounds per square yard and a thickness of  $0.022 \pm 0.003$  inch. Testing shall be as specified in 4.2.1.

3.3.11.4 Bottom piece. The bottom piece shall be leather, corrected grain cattlehide, Hatters' Green, shade 245, 5.5 to 6.5 ounces, conforming to Type II of MIL-L-43541.

3.3.11.5 Lamination. The three pieces shall be laminated with pyroxylin cement or latex to produce a permanent bond, and placed together, firmly pressed and molded to shape.

3.3.11.6 Binding. The visor shall be bound with .012 gauge, black, plastic (vinyl) binding,  $3/16$  inch on the top and  $1/4$  inch on the underside.

### 3.3.12 Chin strap.

3.3.12.1 Chin strap. Class 1. The cap shall be fitted with a poromeric black material. It shall be  $60 \pm 5$  mils thick,  $5/8 \pm 1/16$  inch wide. The edges and face finished with embossed or beaded line. On each end there shall be a  $3/16 \pm 1/16 - 1/32$  inch aperture, and the center shall be equidistant from the sides, and  $5/16 \pm 1/32$  inch from end of each strap shall be provided with a rounded end loop, cut in one piece. The loop shall be closed with one non-corrosive staple on the underside, forming a loop on each end of the strap.

3.3.12.2 Chin strap. Class 2. The chin straps shall conform to Class 2 of UQC S-9-0. The chin straps shall be 3.0 to 4.0 ounce leather, conforming to Type I of MIL-L-43541. The strap shall be made in two parts, each  $5/8$  inch in width and 10 to  $10 - 1/8$  inches in length and shall be adjustable.

### 3.3.13 Sweatband.

3.3.13.1 Sweatband. Class 1. The leather for the sweatband shall be sheerskin, dyed a brown shade,  $1 - 5/8 (+ 1/8, -0)$ , inches wide, conforming to MIL-S-3577.

3.3.13.2 Sweatband. Class 2. The sweatband shall be of leather,  $1 - 5/8 (+ 1/8, -0)$  inches wide, conforming to MIL-S-3577, dyed a brown shade. The sweatband shall be perforated by punching or other means in a repetitive pattern with 5 to 6 large holes and 25 to 30 smaller holes per three inches in linear band. A  $5/16$  inch margin at top and bottom of band shall remain unperforated.

3.3.14 Crown support. The crown support shall consist of a steel wire inclosed in a nylon grommet conforming to the following requirements when tested as specified in 4.2.1

3.3.15 Steel wire. The steel wire shall be spring steel  $5/16 \pm 1/16$  inch wide and  $0.020 \pm 0.005$  inch thick, cut to required size to fit snugly, without distortion to the cap. The wire shall be completely covered with white ethyl cellulose, cellulose propionate or cellulose acetate propionate coating. The coupling shall be  $1 \pm 1/8$  inches long and zinc or cadmium coated to withstand 25 hours of the salt spray test.

3.3.16 Polyethylene film. The material for the crown protector piece, the card holder, welt lining strip and binding top edge of haircloth reinforcement piece shall be cut from clear polyethylene film, polished finish and .0040 inch thick.

3.3.17 Eyelets.

3.3.17.1 Eyelets. Class 1. The eyelets shall be brass and enameled black. Prior to coating, the eyelets shall be cleaned, degreased and prepared for enameling, using a phosphoric acid-detergent type of solution, followed by rinsing and drying. The eyelets shall be coated with lacquer, conforming to Type II, Class 1 of TT-L-58, or enamel, conforming to Class A or B of TT-E-489.

3.3.17.2 Eyelets. Class 2. The eyelets shall be brass and enameled white. Prior to coating, the eyelets shall be cleaned, degreased and prepared for enameling, using a phosphoric acid-detergent type of solution, followed by rinsing and drying.

3.3.18 Washer. The washer for backing the front insignia eyelet shall be brass and shall fit over the eyelet and be clinched.

3.3.19 Buttons. The buttons for the cap shall be cap, cadet, 25-line (U.S.M.A.), conforming to Type II, Class 6 of MIL-B-1563.

3.3.20 Insignia. The insignia for the cap shall be cap, cadet, uniform (U.S.M.A.), conforming to Type I, Class 2 of MIL-B-1563.

3.3.21 Tie bow. The tie bow shall be  $1/4$  inch braided rayon ribbon, dyed a brown shade to harmonize with color of sweatband.

3.3.22 Nylon grommet. The grommet for white cap only shall be composed of nylon filling yarns and cotton warp yarns braided to form a grommet, approximately  $3/4$  inch in diameter. The filling yarns shall be of clear nylon monofilament,  $0.012 \pm 0.0005$  inch thick in diameter, conforming to Class N, Type II of H-S-951, except the cut length designation shall not apply. The warp yarns shall be  $12 \pm 1/2$  count singles carded cotton. The grommet shall be made on a 44 or 48 carrier braider, with carriers braiding in pairs with a 1/1 weave with one 0.012 inch diameter nylon monofilament end per carrier; or a 24 carrier braider with carriers braiding in pairs on a 1/1 weave with two 0.012 inch diameter nylon monofilament ends per carrier. Not less than eight warps of 2 ends each of cotton yarn shall be intermittently spaced around the circumference interlacings. There shall be not less than 8 picks per inch in the relaxed state. The ends of the grommet shall be joined by the use of wood or cork plugs, laminated paper rings, or other suitable material to insure proper closure of the grommet.

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3.3.23 Crown welt. The material for the crown welt (see 3.3.16) shall be black wool facing cloth, conforming to Type I, Class 4 of MIL-C-82252.

3.4 Design. The cap shall be U.S.M.A. service cap model, conforming in style and shade to the sealed standard and as shown by figures.

3.5 Figures. Figures are furnished for information purposes only. To the extent of any inconsistencies between the written purchase description and the figures, the written purchase description shall govern.

3.6 Manufacturing operations requirements. The cap shall be made in accordance with the standard sample and the operations listed herein. The exact sequence need not be followed.

3.6.1 Thread breaks and ends of seams. Ends of all seams and stitching, when not caught in other seams or stitching, shall be backtacked not less than 1/4 inch. Thread breaks shall be secured by stitching back of each end not less than 1/2 inch. The ends of a continuous line of stitching shall be overlapped not less than 1/2 inch.

3.6.2 Cutting. Cut the crown piece with the length in the direction of the warp and the quarters across the warp. Cut the body band with or across the warp, 3 inches in width and 3/4 inch longer than the circumference of the inner body band. Cut the crown protector piece for size 6-3/8, 8-3/4 inches long and 7-3/4 inches wide, and each of the remaining cap sizes in lengths and widths of 1/8 inch increments, and cut the card holder 4 by 2 inches. Cut the crown lining of bonded lining material with the length in the direction of the warp and the size of the crown. Cut the quarters lining on the bias 6 inches wide and of sufficient length for each individual size. Cut the haircloth for front quarters reinforcement on the bias 1-7/8 inches wide and 3 inches longer than the two front quarters. Cut the welt of cadet gray cloth and the strip of polyethylene film used in the attachment of the visor 1-5/16 inches wide and 1 inch longer than the length of the visor. Cut the welt of brown cotton cloth and the strip of polyethylene film used in the attachment of the visor 1-5/16 inches wide and 1 inch longer than the length of the visor. Cut the fiberboard for reinforcing the visor welt 1/4 inch wide and the length of the welt piece. Cut the cotton warp and rayon cloth or monofilament filling stiffening so that the rayon filling shall be vertical in the finished stiffener. Cut the braid the length of the body band. Cut the polyethylene plastic material for the front stiffener in the warp direction.

3.6.3 Make front stiffener. Class 1. Position the high density linear polyethylene and synthetic haircloth with the 1 inch twin wire centered between the plies with a 3/8 inch twin wire on each edge with the top edge of the twin wires 1/4 to 3/8 inch below the top edge of the two plies of stiffener. Seam together with three rows of stitching - one row through the center of the 1 inch wire and one row 1/8 inch from each side through the middle of the 3/8 inch stiffener. Position strip of 1 inch bias binding on the front and back of the front stiffener with the top edge of the strips extending 1/4 to 3/8 inch above the top edge of stiffener and seam strips to stiffener 1/4 to 3/8 inch below the top edge through the stiffener and a second row through the binding only. The front stiffener shall measure 4-1/2 + 1/4 inches wide at the top, 2-3/4 + 1/4 inches wide at bottom, and 4 + 1/4 inches high at center. The top of stiffener shall conform to the curvature of the crown and the bottom shall be straight.

3.6.3.1 Make front stiffener. Class 2. Position the high density linear polyethylene and synthetic haircloth with the 1 inch twin wire centered between the plies and with the top edge of the twin wire  $1/4$  to  $3/8$  inch below the top edge of the two plies of stiffener. Seam together with three rows of stitching - one row through center of twin wire and one row  $1/8$  inch from each side edge of stiffener. Position strip of 1 inch bias binding on the front and back of the front stiffener with the top edge of the strips extending  $1/4$  to  $3/8$  inch above top edge of stiffener and seam strips to stiffener  $1/4$  to  $3/8$  inch below the top edge through the stiffener and a second row through the binding only. The front stiffener shall measure  $3 + 1/4$  inch at the top,  $1-1/2 + 1/4$  inch wide at bottom, and  $4 + 1/4$  inches high at center. The top of stiffener shall conform to the curvature of the crown and the bottom shall be straight.

3.6.4 Make inner body band. Fold a strip of bias binding over each edge and one end of the inner plastic body band and stitch  $1/4$  to  $5/16$  inch from edge catching both edges of the binding. A  $3/8$  inch twin wire will be sewn in 1 inch from the top edge. Overlap the ends of the inner body band 1 inch with the bound end on inside of band and seam together with a row of stitching on each end of band, 3 to 5 inches in length. The inner body band shall be  $2-1/4 (+ 1/16, -0)$  inches in width and cut to proper length for each size of cap.

3.6.5 Make crown. Center the crown protector piece on the crown lining and stitch around the circumference  $1/8 + 1/16$  inch from edge. Position the card holder on the crown protector piece with the bottom edge  $2-1/4 + 1/8$  inches from the front at center and stitch on three sides  $1/16$  to  $1/8$  inch from edge, leaving one of the 2-inch ends open for insertion of card. The stitching shall be through the crown protector piece and crown lining. The finished crown lining shall be fitted smoothly and evenly onto the crown piece and basted.

3.6.6 Join quarters. Join quarters of cap and press the seams open and flat with pressing iron.

3.6.7 Make band. Position braid on band with the top edge of braid  $1/8 (+ 1/16, -0)$  inch from top edge of band and seam to band with stitching  $1/32$  to  $1/16$  inch from each edge of braid. Join ends of band, catching the ends of braid in the stitching. Press seam open and flat with a pressing iron.

3.6.8 Join band to quarters. Join top edge of band to bottom edge of quarters, catching the top edge of the braid in the stitching.

3.6.9 Make reinforcements for quarters. Bind top edge of haircloth reinforcement piece with polyethylene strip. Press on haircloth to front edge of quarter.

3.6.10 Make crown welt and join quarters to crown.

3.6.10.1 Make crown welt and join quarters to crown. Class 1. Fold a strip of black facing material  $1/2$  to  $5/8$  inch wide and single stitch  $1/16$  from welt edge. Position welt on crown edge and seam to crown  $1/16$  from edge. Position quarters on crown with welt in between, and outer edges even and single stitch around edge through welt and crown. Position twill binding on front quarters  $1/8$  inch from



edge of crown and seam  $1/16$  to  $1/8$  inch from edge through all plies. With haircloth inserted under twill binding, seam wadding to crown through all plies to circumference of cap. Center the front stiffener on the quarters with the wide part of front stiffener even with edge of wadding and seam through all plies. Seam the quarters lining to the crown on the underside, keeping the outer edges even, with stitching through all plies. Turn lining over the seam and stitch through seam allowance. Cut  $1/16$  inch wire grommet to proper length with the ends abutted and clamped. Insert wire grommet between the crown and inside welt.

3.6.10.2 Make crown welt and join quarters to crown. Class 2.

a. The crown shall be joined to the front and the two sides with not more than a  $1/4$  inch seam. The seams shall be pressed open with a heated iron or pressing machine.

b. The seam shall be stitched on each side  $1/16$  inch around the crown, catching on the bottom the folded tape or shall be stitched with a double needle, catching the folded tape on the underside. The ends of the double stitching shall extend 1 inch beyond the end of the tape. With haircloth pressed on to fused material of the main cloth, seam to crown through all plies to circumference of cap. Center the front stiffener on the quarters with the wide part of front stiffener even with edge and seam through all plies. Seam the quarters lining to the crown on the underside, keeping the outer edges even, with stitching through all plies. Turn lining over the seam and stitch through seam allowance. Cut  $1/16$  inch wire grommet to proper length with the ends abutted and clamped. Insert wire grommet between the crown and inside welt.

3.6.11 Insert inner body band and tack front stiffener. Insert inner body band into cap, pull bottom of band tightly over bottom edge of inner body band and stitch through braid  $1/32$  (+  $1/32$ , -0) inch from bottom edge of braid, catching the inner body band in the stitching. The bottom edge of braid shall finish  $1/8$  inch (+  $1/16$ , -0) from bottom edge of band. Tack front stiffener to band through braid, adjacent to band and quarters joining seam, not through quarters.

3.6.12 Make visor welt and attach to visor. Cut a strip of the basic fabric  $1 + 1/8$  inches longer than the visor and  $1-5/16 + 1/8$  inches wide. Fold strip in half lengthwise over the strip of  $1/4$  inch fiberboard. Fold a strip of the polyethylene film in half lengthwise and seam to one side of the welt strip. Position completed welt on the underside of visor with the polyethylene film strip next to visor and the folded edge of fabric  $1/4 + 1/16$  inch from unfinished edge of the visor and stitch through visor.

3.6.13 Set visor. Position the visor so that the center is in alignment with center front seam of cap. The angle between the front cap and visor shall be 140 degrees. Join the visor to cap  $1/16$  inch from bottom edge of braid through welt, visor and cap by stitching with 16 to 20 stitches. The ends of the stitching shall be securely tacked. The visor shall finish  $1-7/8 + 1/8$  inches wide at center. Each welt end shall be stitched to the end and ends held down with button socket posts.

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3.6.14 Finish lining. Turn in the bottom of lining and fell to cap  $1/2$  inch above the bottom edge of band, forming 7 to 9 pleats.

3.6.15 Set eyelets. Position one eyelet in front of cap, centered on the front seam of quarters and  $13/16 + 1/16$  inch above top edge of braid, measured to center of eyelet. The eyelet shall be inserted through cap and stiffener and backed with a brass washer. Position two eyelets on each side of cap midway between the crown seam and band seam with each eyelet  $1 + 1/8$  inch on each side of the side quarter seam and clinched through cap, wadding and lining.

3.6.16 Attach chin strap and buttons. Punch a small hole in each side of cap through inner body band and cap  $9-1/2 + 1/8$  inches each side of center front measured from center of cap to center of punch hole and  $3/8 (+ 1/16, -0)$  inch from bottom edge of cap measured from outer edge of button to cap edge. Insert the button socket post and staple two black metal staples to the inner body band. The chin strap shall be snugly fitted and buttons shall be screwed into the posts so that the button insignia is in an upright position.

3.6.17 Make sweatband and set into cap. About the ends of the sweatband and join with a row of zigzag stitching, catching the tie bow at the upper edge, and reinforced with a strip of 1 inch bias binding on the underside of the sweatband. Fell the sweatband into the cap, so that the stitching shall not be visible on outside of cap, and the sweatband shall not be exposed below the bottom edge of cap. The seam shall be at the center back of cap. The sweatband shall finish  $1-5/8$  inches in width.

3.6.18 Attach front insignia and insert roll grommet. Attach the insignia to front of cap, positioned so that insignia is upright for white cap only. Insert roll grommet into crown of cap. The size of cap shall be checked.

3.6.19 Clean cap. Trim thread ends. Remove loose threads, spots and stains. When shade tickets are used, they shall be removed without injury to the material.

3.6.20 Cap measurements. The height of cap at front (measured at the point where band joins visor to bottom edge of welt) shall be 4 inches. The width of quarters at side seam (measured from top of braid to bottom edge of welt) shall be  $2-1/8$  inches. The width of quarters at back seam (measured from top edge of band to bottom edge of welt) shall be  $2-1/4$  inches. The width of the finished band shall be  $1-3/4$  inches. The length of visor (measured on upper side) shall be  $1-7/8$  inches. The angle of the visor (taken between the front of cap and the visor) shall be  $140 \pm 5$  degrees. The crown shall finish  $9-3/4$  inches long and  $9-1/4$  inches wide for size 6-3/8, with the lengths and widths increased by  $1/8$  inch increments for each subsequent cap size. Tolerance on all measurements shall be  $\pm 1/8, -0$  inch.

3.6.21 Grommet measurements. For a size 6-3/8, the head measurement shall be  $20-1/8 + 1/4$  inches, the cut length of the roll grommet shall be  $26-1/4 (+ 3/8, - 1/8)$  inches and the cut length of uncovered wire grommet shall be  $31-1/2 \pm 1/8$  inches. The head measurements shall be increased by  $3/8$  inch increments for each subsequent cap size except for size 7-7/8 which shall be  $21-5/8$  inches.

The roll grommet lengths shall be increased by 3/8 inch increments for each subsequent size. The uncovered wire grommet lengths shall increase to 32 inches for size 6-3/4 and increase by 1/2 inch increments for every other cap size.

#### 4. QUALITY ASSURANCE PROVISIONS

4.1 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 in the contract or order, the supplier may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by 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.

4.1.1 Certificates of compliance. Where certificates of compliance are submitted, the Government reserves the right to check test such items to determine the validity of the certification.

#### 4.2 Quality conformance inspection.

4.2.1 Sampling and inspection provisions. Sampling and inspection shall be performed in accordance with MIL-STD-657.

4.2.1.1 Component and material inspection. In accordance with 4.1 above, components and materials shall be tested in accordance with all the requirements of referenced specifications, drawings and standards unless otherwise excluded, amended, modified or qualified in this specification or applicable purchase document. In addition, testing shall be performed on components listed in Table IV for characteristics noted. Wherever applicable, tests shall be conducted in accordance with methods prescribed in FED-STD-191 as listed in Table IV, except that the results of the physical testing of the polyethylene obtained under testing conditions defined in FED-STD-406 or FED-STD-601 will be acceptable, except in the case of dispute. In dispute cases, tests shall be conducted with both the specimen and test apparatus under standard conditions as defined in FED-STD-191. Except where otherwise specified, all testing requirements apply to the sample unit. All test reports shall contain the individual values utilized in expressing the final results.

4.2.1.2 Sampling for testing. Unless otherwise specified in subsidiary specifications, sampling shall be in accordance with Table III. The lot shall be unacceptable if one or more sample units fail to meet any test requirement specified. The unit for expressing the lot sizes and sample unit for testing each component shall be in accordance with applicable subsidiary specifications and as follows:

Table III.

<u>Component</u>	<u>Lot size expressed as</u>	<u>Sample unit for testing</u>
Inner body band (polyethylene)	Each	7 each
Sweatband	Each	7 each
Visors	Each	3 each
Eyelets	Gross	15 each
Washer (eyelet)	Gross	10 each
Sweatband reinforcement strip (cotton print or sheeting cloth, coated or uncoated)	Yards	1 yd. linear
Cotton warp and monofilament nylon filling cloth (when applicable)	Yards	1/4 yd. full width
Crown support	Each	1 each

Table IV. Test methods. Class 1

<u>Component</u>	<u>Characteristic</u>	<u>Requirement paragraph</u>	<u>Test method or procedure</u>
Fusible Interlining fused to basis cloth	Adhesion	3.3.1	5951
Material for inner body band	Width	3.3.3	5020
	Thickness	3.3.3	5030
	Finish	3.3.3	Visual 2/
	Stiffness	3.3.3	4.3.1
	Bending	3.3.3	4.3.2
Sweatband	Width	3.3.13	5020
	Margin	3.3.13	Manual 2/
Visor binding	Material identification	3.3. 11.6	4/
	Width	3.3. 11.6	Visual 2/
Eyelets	Material identification	3.3. 17	4/
	Finish	3.3. 17	Visual 2/
	Color	3.3. 17	Visual 2/
	Dimension	3.3. 17	Manual 2/
Washers	Material identification	3.3. 18	4/

Table IV. Test methods. Class 1 (Continued)

Component	Characteristic	Requirement paragraph	Test method
Cotton warp and monofilament nylon cloth (when applicable)	Weight	3.3.9	5041
	Threads per inch:	3.3.9	
	- warp		5050
	- filling		5050
	Weave	3.3.9	Visual
	Stiffness	3.3.9	5202
Polyethylene, high density (for inner body band)	Width	3.3.3	2121 (FED-STD-601)
	Thickness	3.3.3	2011 (FED-STD-601)
	Stiffness	3.3.3	4.3.1
Linear polyethylene or polypropylene	Material identification	3.3.3	1/
	Color	3.3.3	Visual 3/
	Thickness	3.3.3	2011 (FED-STD-601)
Visor	No. of layers	3.3.11	Count 3/
	Construction	3.3.11	Visual 3/
	Plumper paper:	3.3.11	
	- Material identification		1/
	- Weight		4.3.2
	- Thickness		173 (UU-P-31)
Crown support	Steel wire	3.3.14	
	Material identification	3.3.14	1/
	Dimensions	3.3.14	Measurement 3/
	Coating identification	3.3.14	1/
	Coating color	3.3.14	Visual 3/
	Coupling size	3.3.14	Measurement 3/
	Coupling coating	3.3.14	1/
	Corrosion resistance	3.3.14	811 (FED-STD-151)
Grommet	Identification of nylon	3.3.22	1530 4/
	Identification of cotton	3.3.22	1200
	Diameter	3.3.22	Visual 2/
	Number of carriers	3.3.22	Count 3/
	Ends per carrier	3.3.22	Count 3/
	Warps	3.3.22	Count 3/
	Picks per inch	3.3.22	Count 3/

1/ Five (5) determinations shall be made from each sample unit and the results reported as the average of the five determinations to the nearest 0.01 ounce per square foot.

2/ One determination shall be made from each sample unit and the results reported as "pass" or "fail". All failures to be described.

3/ One determination shall be made from each sample unit and the results reported to the nearest whole number.

4/ Unless otherwise specified, a certificate of compliance shall be submitted and will be acceptable for the stated characteristics.

#### 4.3 Tests.

4.3.1 Polyethylene inner body band stiffness. The band shall be tested for stiffness at room temperature according to FED-STD-311, method 4211, using a span length of 1.0 inch, a moment weight of 1.0 inch-pounds and measuring the load at 20° on the angular deflection scale.

4.3.1.1 Perforated band. The test piece shall be a section of the band, 1 inch  $\pm$  0.005 inch wide, 4 inches long and the thickness of the band. It shall be cut from the center part of the band containing perforations and the cut edges may contain perforations. The thickness shall be measured to an accuracy of  $\pm$  0.001 inch, using method B of ASTM D 374-68 at not less than five points distributed both across the width of the sample and along its length, and the average thickness recorded for each test piece.

4.3.2 Polyethylene inner body band bending test. The test is run on five four-inch long pieces of the perforated band. Each piece shall be bent across its width at least 180° around a metal test mandrel, a round metal bar measuring 1/8 inch in diameter. The piece shall be pressed firmly against the mandrel and the bend made at the location of the perforations. Each piece shall be examined for cracks, both while bent and after removing from the test. The test shall be run at 0°F. The specimen shall be straightened to its original position after removal from the mandrel. All samples and the test mandrel shall be kept in a cold box at a temperature of 0  $\pm$  30°F for not less than four hours before the test. The test shall be run in the cold box, and the samples and mandrel handled only with heavy gloves so as to prevent warming of the samples during the test.

4.3.3 Visor stiffness. The stiffness of the visor shall be tested as follows:

4.3.3.1 Specimen. The specimen shall be 1 inch by 5 inches and shall be cut from the middle section of the visor, not including the skived edge.

4.3.3.2 Apparatus. The apparatus used shall be as specified in Method 4211 of FED-STD-311.

4.3.3.3 Procedure. Place the weight on the pendulum, to give bending moment of 5 inch-pounds and adjust the pin to give a 2 inch span. One end of the specimen shall be clamped in the jaws of the machine with the top side of the visor in position to rest against the pin. The free end of the specimen shall extend 1-1/2 inches beyond the pin. The apparatus shall be operated until the free end of the specimen just makes contact with the pin. Both pointers shall be adjusted to zero. The apparatus shall be operated until the angle pointer shows that the leather has been bent through an angle of 20°. At that instant, the percent of maximum bending moment as indicated by the other pointer is recorded. The force required to bend the leather is calculated by dividing the bending moment by the span.

4.3.3.4 Report. The force in pounds required to bend the leather through an angle of  $20^{\circ}$  shall be reported.

4.3.4 Visor bond strength. The visor bond strength shall be tested as follows:

4.3.4.1 Specimen. The specimen shall be 1 inch by 5 inches. The specimen used in the stiffness test shall be used. The top and bottom layers of the leather shall be separated for a distance of 2 inches from one end of the specimen.

4.3.4.2 Apparatus. The machine shall be of such capacity that the reading made will fall into that part of the scale which is accurate to within one-quarter pound. The speed of the moving jaws shall be  $10 \pm 2$  inches per minute. The machine shall be adjusted to record instantaneous load by removing any automatic limiting device.

4.3.4.3 Procedure. The separated ends of the specimen shall be clamped in the jaws of the machine with the jaws approximately 1 inch apart. The machine shall be started and the pieces of leather shall be pulled apart for a distance of 1 inch. At that instant, the load on the machine shall be read and recorded.

4.3.4.4 Report. The report shall state the load, in pounds per inch, required to separate the two pieces of leather.

4.4 End item examination. The finished caps shall be visually examined to assure that caps contain no defects that will affect serviceability or appearance.

## 5. PREPARATION FOR DELIVERY

5.1 Packaging. Packaging shall be level A or C, as specified (see 6.2).

5.1.1 Level A. Each cap shall be placed in a fiberboard box conforming to style RSC, type CF (variety SW) or SF, class domestic, minimum grade 125 of PPP-B-636. The inside dimensions of each fiberboard box shall be  $11\text{-}3/4$  inches in length,  $11\text{-}3/4$  in width and 6 inches in depth. Each box shall have the void areas around the cap filled with crumpled 10 pound basis weight (24 by 36-480) regular bleached tissue paper so as to immobilize the cap within the box.

5.1.2 Level C. Caps shall be packaged to afford adequate protection against physical damage during shipment from the supply source to the first receiving activity. The supplier may use his standard practice when it meets this requirement.

5.2 Packing. Packing shall be level B or C as specified (see 6.2).

5.2.1 Level B. Twenty-four caps, of one size only, packaged as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC, type CF (Variety SW) or SF, class domestic, grade 275 of PPP-B-636. Level A packages shall be packed flat three in length, two in width, and four in depth within a shipping container. Inside dimensions of each shipping container shall approximate 37 inches in length,  $24\text{-}3/4$  inches in width, and 26 inches in depth. Approximate dimensions are furnished as a guide only. Each shipping container shall be closed

in accordance with method II as specified in the appendix of PPP-B-636. Toward the end of the contract or when there are less than the required amount of the same size, mixed sizes may be packed within the same shipping container.

5.2.1.1 When specified (see 5.2), the shipping container shall be a grade V3e or V3s fiberboard box fabricated in accordance with PPP-B-636 and closed in accordance with the appendix of the container specification. The shipping container material may also be grade V4s of PPP-P-320.

5.2.2 Level C. Caps, packaged as specified in 5.1, shall be packed in a manner to insure carrier acceptance and safe delivery at destination at the lowest transportation rate for such supplies. Containers shall be in accordance with rules or regulations of carriers applicable to the mode of transportation.

5.3 Marking. In addition to any special marking required by the contract or order, interior packages and shipping containers shall be marked in accordance with MIL-STD-129.

5.3.1 Labels, mixed sizes. Each shipping container packed with mixed sizes, shall have securely attached to the end and side, directly under the printing or stenciling, a white paper label 5 by 4 inches with the words "MIXED SIZES" plainly stamped or printed thereon, and under these words shall be legibly stamped or printed the correct quantity and sizes contained therein.

## 6. NOTES

6.1 Intended use. The cap covered by this purchase description is intended for wear by Cadets of the United States Military Academy.

6.2 Ordering data. Procurement documents should specify the following:

- a. Title, number and date of this purchase description.
- b. Size(s) required (see 1.2).
- c. Selection of applicable levels of packaging and packing (see 5.1 and 5.2).
- d. When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.1.1).

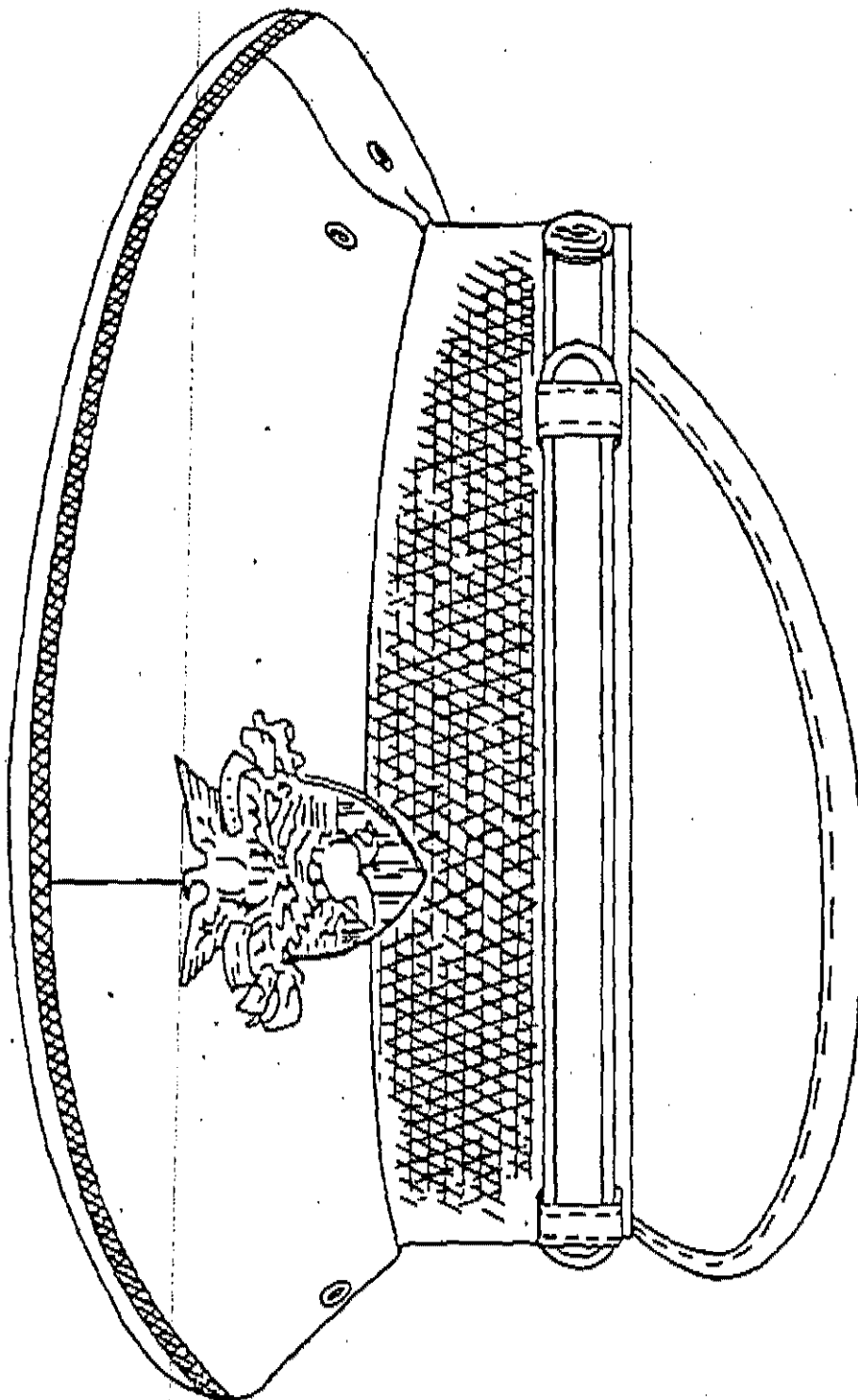
6.3 For access to the standard sample of the end item, address the procuring office issuing the invitation for bids.

Preparing activity:

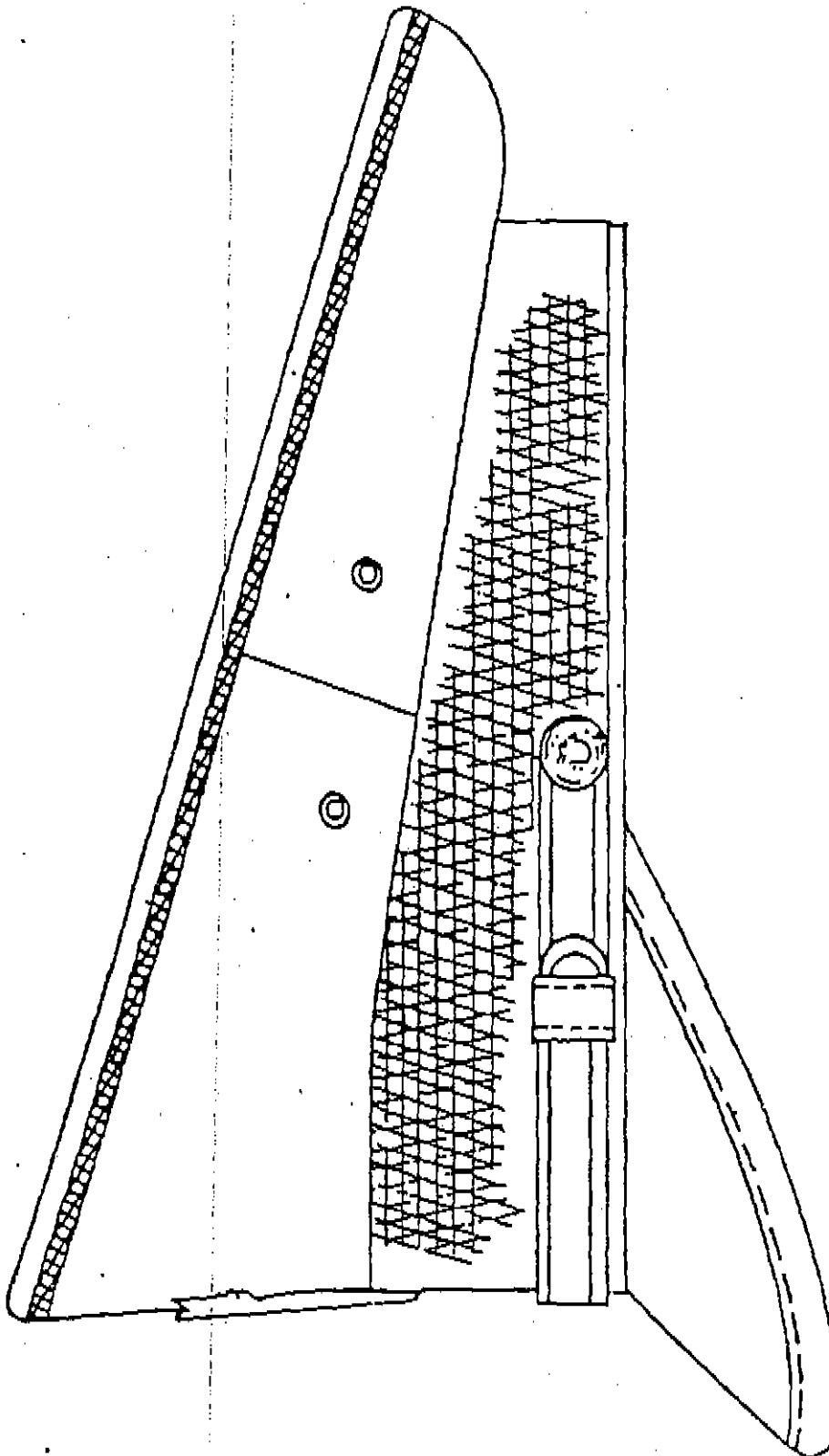
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Project No. 8405-P006

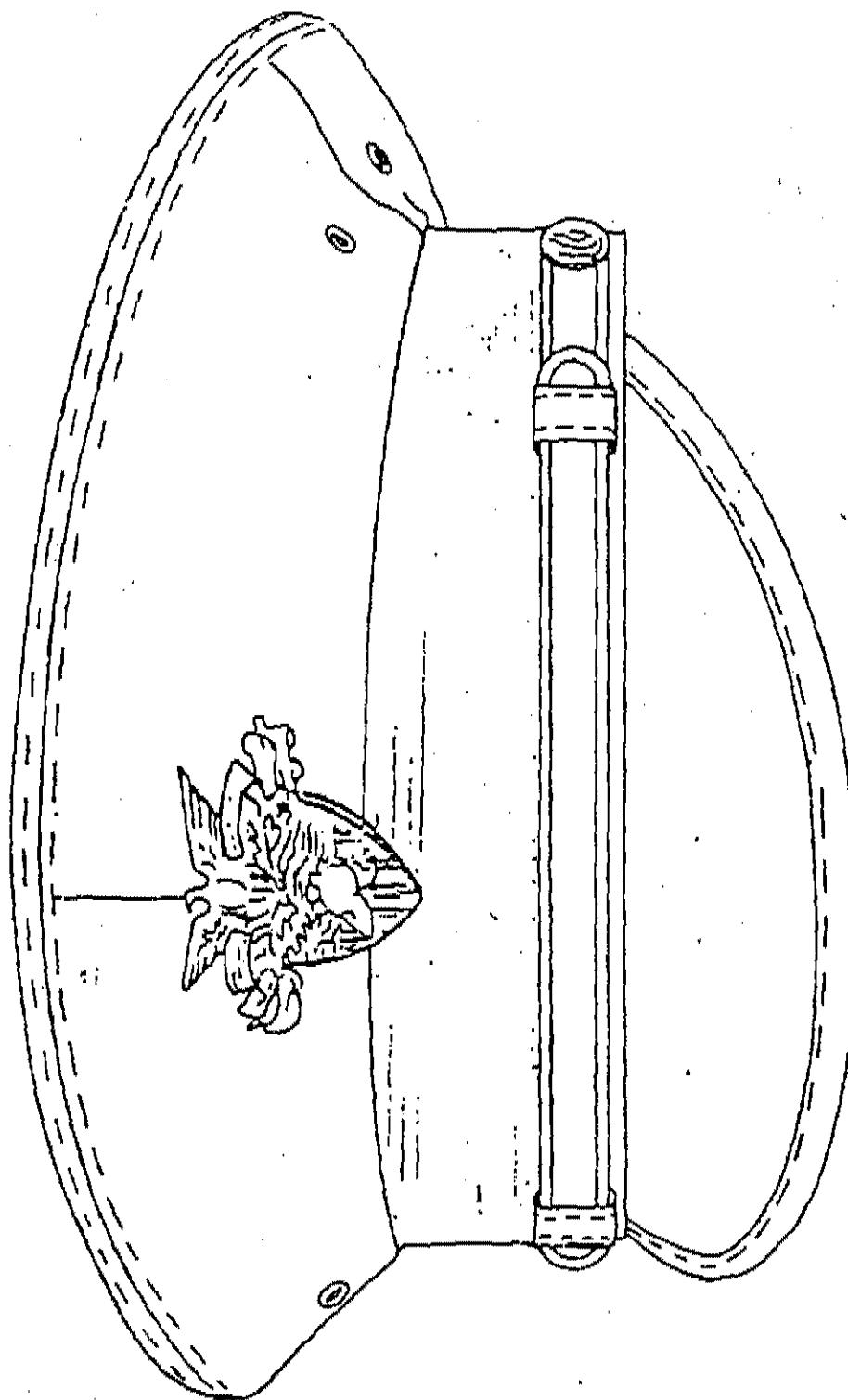




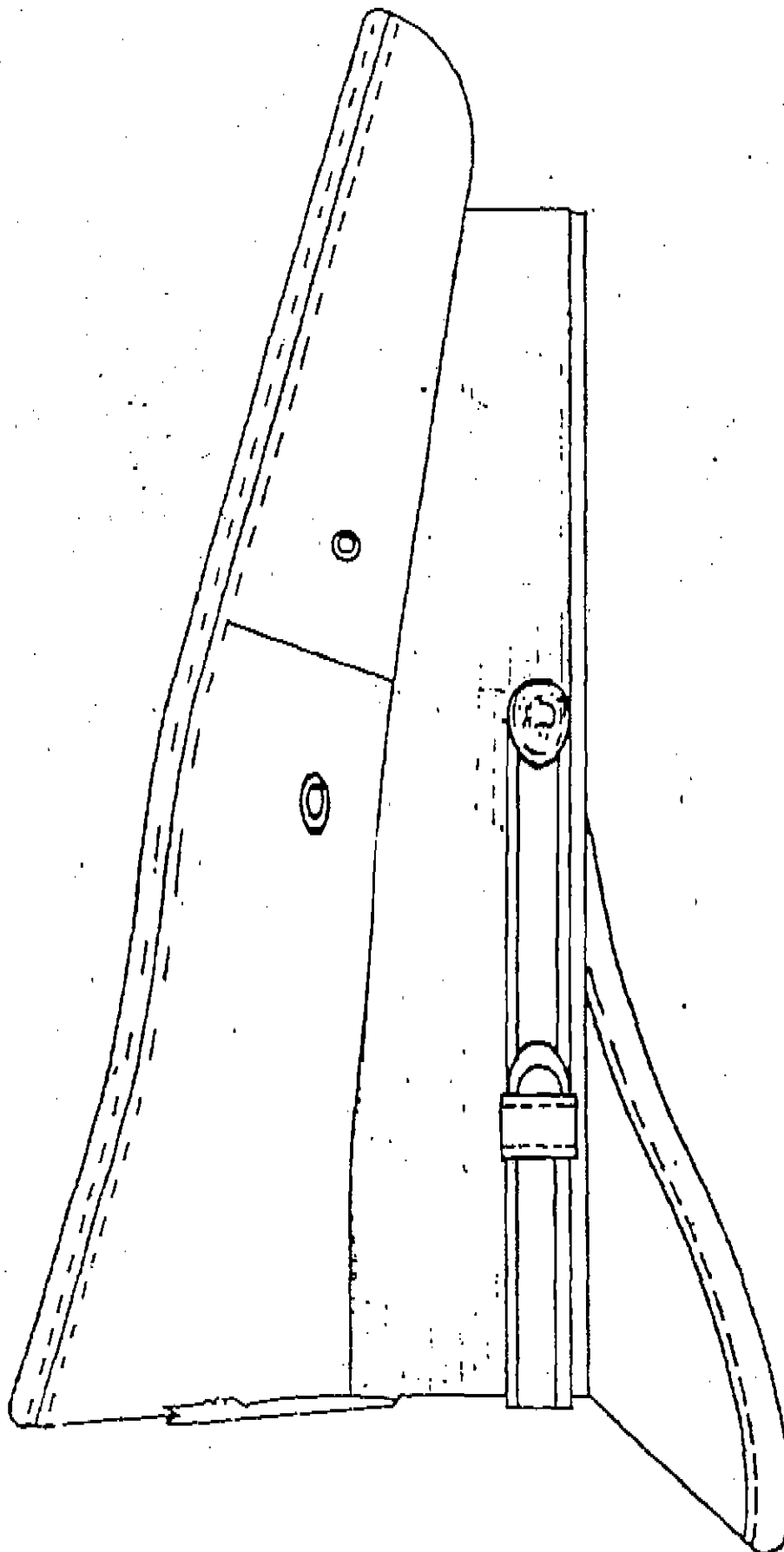
THREE QUARTER VIEW  
FIGURE 1: CAP, SERVICE, CADET, UNIFORM, GRAY



*SIDE VIEW*  
*FIGURE 2: CAP, SERVICE, CADET, UNIFORM, GRAY*



THREE QUARTER VIEW  
FIGURE 3: CAP, SERVICE, CADET, WHITE



*SIDE VIEW*  
*FIGURE 4: CAP, SERVICE, CADET, WHITE*

Dress Cap Evaluation. The Government reserves the right to perform inspections when deemed necessary to assure supplies and services conform to prescribed requirements.

EXAMINATION	DEFECT	CLASSIFICATION	
		Major	Minor
Basic Material	Any basic material is not in accordance with the specification.	X	
	Component part omitted, not cut as specified, distorted, full, tight or twisted; any part of cap caught in any unrelated row of stitching.	X	
	Hole, cut, tear, smash, burn, drill hole, run, thin place, dye streak, color not as specified, mis-weave, knot or slubs.	X	
	Any finished measurement not as specified.	X	
	Wrong shade of thread	X	
	Permanent fold, pleat, or crease in fabric	X	
Inner Body Band Class 1	Omitted.	X	
	Is not of high density (linear) polyethylene plastic material meeting the requirements of Type III, Class H, grades 1 or 2 of L-P-390, . The band is not extruded, stripped split or cut 2 + 1/16 inch wide with thickness of .030 +/- .002 inch.	X	
Inner Body Band Class 2	The material is not composed of a high alpha cellulose wood pulp sheet impregnated with an oil-resistant and perspiration-resistant and synthetic rubber binder.	X	
	Does not conform to the requirements specified in Table II.	X	
Braid Class 1	Is not flat, mohair, does not conform to the following requirements: Color: The color shall be black and shall show good fastness to water, light and dry cleaning. Width: 1 ¾ inches (full) Warp: 22 Spools of 2 ends of 40/2 mercerized cotton, Braiding: 89 carriers, 2 ends per carrier, 2/30 mohair. Picks: 24 Weave: 2 over – 2 under Weight: Not less than 7 pounds per gross yard.	X	
Braid Class 2	Is not 1 ¾ - 2 inches wide, made of white vinyl flat, simulated braid in accordance with good commercial practice.	X	
Lining Class 1	Material is not black rayon (includes lining of cap crown)	X	
Lining Class 2	Material is not white rayon (includes cap crown and front stiffener)	X	

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DRESS CAP EVALUATION TABLE

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EXAMINATION	DEFECT	CLASSIFICATION	
		Major	Minor
Polyethylene film	Does not conform to 3.3.16 in specification or omitted.		X
Eyelet	Tight, puckered, or pleated at belting ribbon sweatband joining.	X	
	Not specified type or color.	X	
	Bottom edge of sweatband: Exposed below the bottom of the cap or visible on the outside of cap.	X	
	Tight causing puckering of the cap.	X	
Eyelets. Class 1	Does not conform to 3.3.17.1 in specification.		X
Eyelets. Class 2	Does not conform to 3.3.17.2 in specification.		X
Nylon grommet	Does not conform to 3.3.22 in specification.		X
Crown Welt	Does not conform to 3.3.23 in specification.	X	
Seams and stitching	Accuracy of seaming:		
	1. Seam puckered (unless other-wise classified).	X	
	2. Seam irregular, pleated or wavy.	X	
	3. Part of cap caught in any unrelated operation or stitching.	X	
	Ends of all seams and stitching, when not caught in other seams or stitching, are not back tacked at least ¼ inch.		X
	Thread breaks not secured by stitching back of each end less than ½ inch.		X
	Ends of a continuous line of stitching are not overlapped less than ½ inch.		X
	Not specified shade or two or more shades of thread used on same cap, affecting appearance.		X
Cleanness	Any spot or stain: On outside	X	
Barcode Label	Omitted	X	

# DRESS CAP EVALUATION TABLE

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Cleanness (CONT)	On inside. Any marking exposed or visible on outside.	X	
	Thread ends on outside not trimmed or loose threads not removed.		X
Component and assembly	Any defective component.	X	
	Any component part omitted.	X	
	Any required operation omitted or improperly performed.	X	
Material defect and workmanship damages	A weakening defect, which may develop into a hole.	X	
	Shade bar, slub, dye or finishing streak, or any other material defect on outside of cap.	X	
	Cut, tear, mend, burn or needle chew that may develop into a hole.	X	
	Hole.	X	
	Ruptured fibers in the line of sewing (usually caused by broken blunt or hooked needles), affecting appearance or serviceability.	X	
	NOTE 1: Material defects and workmanship damages are to be classified as indicated above only when the condition is one which definitely weakens the fabric or when it is so conspicuously located as to be clearly noticeable.		
	NOTE 2: One (1) Major constitutes a failure, and Three (3) Minor defects equals one (1) Major which constitutes a failure.		