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MILITARY SPECIFICATION

SHOE REPAIR SHOP, EQUIPMENT

This specification is mandatory for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope.- This specification covers shoe repair shop equipment.

* 1.2 Classification.- Shoe repair shop equipment shall consist of the following types and sizes of equipment as specified (see 6.2):

Type I - Shoe finishing machine

Size A - 7 1/2 foot length
Size B - 11 foot length

Type II - Shoe stitching machine
Type IV - Shoe soling press, laminated
Type V - Sewing machine, industrial shoe patching (see 3.4.1 and 3.10.4)
Type VI - Skiving and beveling machine, shoe sole, hand operated
Type VII - Heel removing and heel reducing machine, hand operated
Type VIII - Stand, cobbler's last, with lasts, floor type

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 specification to the extent specified herein:

SPECIFICATIONS

FEDERAL

CC-M-636	-	Motors, Alternating Current, (Fractional Horsepower).
KK-B-211	-	Belting; Round, Leather.
OO-S-256	-	Sewing Machines, Industrial.
TT-P-664	-	Primer, Coating, Synthetic, Rust Inhibiting, Lacquer Resisting.
MMM-A-260	-	Adhesive, Water Resistant (For Sealing Waterproofed Paper).
PPP-B-601	-	Boxes, Wood, Cleated-Plywood.

PPP-B-621	Boxes, Wood, Nailed and Lock-Corner.
PPP-B-636	Box, Fiberboard.
PPP-B-1055	Barrier Material, Waterproofed, Flexible.
PPP-F-320	Fiberboard; Corrugated and Solid, Sheet Stock (Container Grade), and Cut Shapes.
PPP-T-45	Tape, Gummed, Paper, Reinforced and Plain, for Sealing and Securing.
PPP-T-60	Tape: Pressure-Sensitive Adhesive, Waterproof, for Packaging and Sealing.

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MIL-C-104	Crates, Wood; Lumber and Plywood Sheathed, Nailed and Bolted.
MIL-P-116	Preservation, Methods Of.
MIL-B-121	Barrier Material, Greaseproofed, Waterproofed, Flexible.
MIL-L-10547	Liners, Case and Sheet, Overwrap; Water-VaporProof or Waterproof, Flexible.
MIL-E-15090	Enamel, Equipment, Light Gray (Formula No. 11).

STANDARDS

FEDERAL

Fed. Std. No. 751 - Stitches, Seams, and Stitchings.

MILITARY

MIL-STD-105 -	Sampling Procedures and Tables for Inspection by Attributes.
MIL-STD-129 -	Marking for Shipment and Storage,
MIL-STD-130 -	Identification Marking of U. S. Military Property.
MIL-STD-461 -	Electromagnetic Interference Characteristics, Requirements for Equipment.
MIL-STD-462 -	Electromagnetic Interference Characteristics, Measurement Of.

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

* 2.2 Other publications.- The following documents form a part of this specification to the extent specified herein. Unless otherwise indicated, the issue in effect on date of invitation for bids or request for proposal shall apply.

UNDERWRITERS' LABORATORIES, INC. (UL)

Standard No. 1 - Conduit, Flexible Steel.
Standard No. 4 - Armored Cable.
Standard No. 6 - Conduit, Rigid Metallic.
Standard No. 44 - Wire and Cables, Rubber-Insulated.
Standard No. 62 - Flexible Cord and Fixture Wire.
Standard No. 83 - Wire, Thermoplastic-Insulated.
Standard No. 514 - Outlet Boxes and Fittings.
Standard No. 797 - Electrical Metallic Tubing.

(Application for copies should be addressed to the Underwriters Laboratories, Inc., 207 East Ohio Street, Chicago, Illinois 60611; Walt Whitman Road, Melville, Long Island, N. Y. 11749; or 1655 Scott Boulevard, Santa Clara, California 95050.)

NATIONAL FIRE PROTECTION ASSOCIATION (NFPA)

Standard No. 70 (1965)- National Electrical Code.

(Application For copies should be addressed to the National Fire Protection Association, 60 Batterymarch Street, Boston, Massachusetts 02110.)

(Technical society and technical association specifications and standards are generally available for reference from libraries. They are also distributed among technical groups and using Federal agencies.)

3. REQUIREMENTS

3.1 First article.- Unless otherwise specified (see 6.2), before production is commenced, a sample of the finished commodity procured under this specification shall be submitted or made available to the contracting officer or his authorized representative for approval in accordance with 4.2. The approval of the preproduction sample authorizes the commencement of production but does not relieve the supplier of responsibility for compliance with all provisions of this specification. The preproduction sample shall be manufactured in the same facilities to be used for the manufacture of the production items.

* 3.2 Standard products.- Each item of equipment, including accessories, shall be a current standard product of an established manufacturer except for such deviations from the manufacturer's commercial product as may be required by the specification.

* 3.3 Standards ccmpliance.- Electrical components shall comply with the following UL standards: fittings-Standard No. 514; armored cable-Standard No. 4; flexible cord and fixture wire-Standard No. 62; thermo-plastic-insulated wire-Standard No. 83; rubber insulated wire-Standard No. 44; and conduit or tubing-Standards No. 1, 6, or 797, as applicable. The installation of electrical components for each machine shall conform to NFPA Standard No. 70, the "National Electrical Code".

* 3.3.1 Certification.- Prior to approval of the first article, or if none is submitted, prior to approval of the first shipment, the supplier shall submit satisfactory evidence to the contracting officer or his authorized representative that the electrical components he proposes to furnish under this specification meet the requirements of UL standards, as applicable.

* 3.3.1.1 UL and NFPA.- Acceptable evidence of meeting the applicable requirements of specified UL standards shall be the UL label or a photostatic copy of the UL listing card for the components being offered or a certified test report from a recognized independent testing laboratory acceptable to the Government, indicating that the electrical materials and components offered have been tested and conform to applicable UL standards. Acceptable evidence of meeting the requirements of NFPA Standard No. 70-1965 shall be the manufacturer's certified statement that the installation of electrical components conform to applicable requirements.

* 3.4 Materials and components.- Materials and components shall conform to the applicable referenced specifications, standards, and requirements specified hereinafter. When materials are not definitely specified, they shall be of the type and quality used by the manufacturer in his standard commercial product.

3.4.1 Electrical equipment.- The machines shall be furnished complete with motors, driving mechanism, manual starters, heaters and all other components, as applicable, required to complete the assembly and meet the test in 4.5.1. Unless otherwise specified (see 6.2) types I and II, electrically operated machines, shall be suitable for operation on a 3 phase, 4 wire, 120/208 volt, 60 cycle, alternating current (a.c.) power source. When an electrically operated type V machine is specified (see 6.2), it shall be suitable for operation on a single phase, 115 volt, 60 cycle, a.c. power source.

* 3.4.1.1 Motors.- Motors shall conform to CC-M-636, Motor inclosure shall be either drip proof or splash proof. They shall be continuous duty in 40 Centigrade (C,) ambient without exceeding 40 C. allowable temperature rise. All motors shall conform to class A insulation requirements. The speed shall be constant speed type. Windings for a.c. motors shall be squirrel cage for 3-phase supply and squirrel cage split phase or capacitor for single phase supply, Winding for d.c. motors shall be shunt.

3.4.1.1.1 Horsepower.- Rated horsepower shall be the same as motors furnished by the supplier in his regular commercial machine.

3.4.1.2 Motor starters.- Motor starters shall be across-the-line heavy-duty type, with push button or toggle switch, to completely make or break all electrical connections to the motor. When the machine motor is not equipped with overload protection, the starters shall be furnished with a built-in overload protective device. The starter inclosure shall be metal and shall conform to a commerical type I inclosure.

* 3.4.2 Electromagnetic compatibility.- Equipment procured for Army shall be designed and equipped for electromagnetic competibility in accordance with Class IIB of MIL-STD-461 (see 4.5.2.) When specified (see 6.2), equipment procured for Air Force shall be in accordance with Class IIB of MIL-STD-461 (see 4.5.2).

3.5 Design and Construction.- All moving parts shall show no evidence of undue vibration, noise, or overheating of bearings, and the starting and stopping device shall operate smoothly and positively when subJected to the operational test specified in 4.5.1.

3.5.1 Lubrication.- oil or grease fittings shall be incorporated in accessible locations for use in lubricating bearings, as required. Pressure oil lubrication shall not be used for motor bearings.

3.5.2 Clutches.- Clutches shall be engaged by a pedal conveniently located for operation from a standing position.

3.5.3 Belt drives.- Machines furnished with belt drives shall be provided with means for adjusting belt tension. Round belts shall be waterproofed leather conforming to KK-B-211. V-belts shall be composition rubber and fabric of the type normally furnished in commercial practice.

3.5.4 Machine bases.- The base supports on all machines shall be of malleable iron, cast iron, or steel, and of rigid construction. Holes shall be provided not less than one-half inch diameter to receive anchor bolts, except as specified in 3.10.1.

3.5.5 Safety devices.- Exposed belts, shafts, pulleys, gears, and other moving parts hazardous to operators shall be fully inclosed and guarded in- so far as practicable, so as to prevent operator contacting same. Guards shall be of malleable iron, steel, sheet metal, or wire mesh. All parts of the guard shall be rigid, and secured so as to be removable without disassembling operating parts of the machine. Guards fitted over parts requiring frequent adjustment shall be hinged or shall be removable without the need for tools.

* 3.5.6 Wiring.- Wiring shall comply with NFPA Std. No. 70. Wires shall be completely installed in flexible or rigid zinc-coated conduit or shall be armored flexible cable. All connections shall be made between motors, starters, and switches. Parts shall be installed on the machines with sufficient slack to prevent breakage due to vibration.

* 3.6 Tools.- Tools and wrenches necessary for the proper service, maintenance, and adjustment of the equipment shall be furnished where specified under detail requirements.

3.7 Equipment manual.- The supplier shall furnish with each machine an equipment manual. Manual contents and distribution shall be as specified in the contract or order (see 6.2).

3.8 Identification plates.- Each machine shall bear an identification plate conforming to the requirements of MIL-STD-130. The plate shall be installed on and furnished as part of the machinery or equipment for which it is intended.

3.9 Finish.- The equipment shall be finished in accordance with the manufacturer's regular commercial practice. Finish shall not be blistered, chipped, or peeled.

3.10 Detailed requirements.-

* 3.10.1 Type I, shoe finishing machine.- The finishing machine shall be a dustless, single unit model, electric motor driven. Power shall be transmitted from the electric motors to the attachments by means of V-belt drive. All shafts shall be balanced and quiet running in self-aligning bearings. The frame shall be of malleable iron or steel and so fastened and braced to the leg that the assembled machine is rigid. The legs shall be of malleable iron, cast iron, or steel with at least one 5/8 inch hole in each foot for anchor bolts. A hood shall be provided above the finisher shaft, the length of the machine. Each finishing machine shall be provided with a conveniently located rack to hold forepart cutters and the burnishing irons.

3.10.1.1 Suction system.- A suction system shall be Incorporated in the machine and shall have a capacity sufficient to carry off all dust and leather particles produced during operation of the machine. The suction blower shall be connected to an independent electric motor and shall be provided with a separate "on" and "off" push button switch. The dust collected by the suction system shall be exhausted into a conveniently located receptacle which may be detached for emptying or be so constructed as to be easily cleaned out.

* 3.10.1.2 Type I, size A.- In addition to requirements of 3.10.1 and 3.10.1.1, the machine with all attachments installed shall not exceed 7 1/2 feet in length. The attachments shall be as tabulated in Table I and mounted from left to right in the order listed.

TABLE I - Type I, size A shoe finishing machine

Item No.	Nomenclature	Required
1	Cutter, forepart.	1
2	Heel trimmer with shank sander and wire brush attachment.	1

TABLE I - Type I, Size A shoe finishing machine (cont'd)

Item No.	Nomencalture	Quantity Required
3	Grinder attachment.	1
4	Heel breaster.	1
5	Scouring Wheel, flat surface 1-3/8 inch width by 5 inch diameter (with metal Protective edge when specified (see 6.2)).	1
6	Bottom sander 4-1/2 inch width.	1
7	Scouring wheel, flat surface, 1-3/8 inch width by 5 inch diameter (with metal protective edge when specified (see 6.2)).	1
8	Brush, shank, 1-1/2 inch width by 8 inch diameter.	2
9	Iron, edge, sole and heel.	1

* 3.10.1.3 Type 1, size B.- In addition to requirements of 3.10.1 and 3.10.1.1, the machine with all attachments installed shall not exceed 11 feet in length. The attachments, unless otherwise specified (see 6.2), shall be as tabulated in Table II and mounted either left to right or right to left in the order listed, as specified (see 6.2).

TABLE II - Type I, size B shoe finishing machine

Item No.	Nomenclature	Quantity Required
1	Cutter, forepart.	1
2	Heel trimmer with shank sander and wire brush attachment.	1
3	Grinder attachment.	1
4	Heel breaster.	1
5	Scouring wheel, flat surface, 1-3/8 inch width by 5 inch diameter (with metal protective edge when specified (see 6.2)).	2
6	Brush, burnishing.	1
7	Bottom sander, 4 inch width.	1
8	Bottom leveler, 4 inch width.	1
9	Scouring wheel, flat surface, 1-3/8 inch width by 5 inch diameter (with metal protective edge, when specified (see 6.2)).	1

TABLE II - Type I, size B shoe finishing machine (cont'd)

Item No.	Nomenclature	Quantity Required
10	Brush, burnishing.	1
11.	Brush shank, 1-1/2 inch width by 8 inch diameter.	1
12	Iron, edge, sole and heel.	1

3.10.2 Type II, sole stitching machine.- The sole stitching machine shall be a heavy-duty, self-contained, curved-needle type, electric motor driven machine designed for stitching outer soles to shoes with a type 301 stitch conforming to Fed. Std. No. 751. An electrically heated wax pot equipped with thermostatic heat control shall be incorporated in the machine. The stitching machine shall be connected to the motor by a belt and shall contain a clutch designed to allow the stopping of its operation at any time while the motor is running. The machine shall be set so its speed does not exceed 350 revolutions per minute (r.p.m.) One set of special tools and wrenches required for operation and adjustment shall be furnished with each machine.

3.10.3 Type IV, shoe soling press.- The shoe soling press shall be a laminating, floor mounted, rotary, 5 pair capacity machine with electrically heated pads (see 6.3). Pressure shall be applied by a handwheel controlling cross arm and pressure screws.

3.10.3.1 Accessories.- The following equipment shall be included with the sole press:

10 pair men's lasts - sizes 6-7-8-9-11DP, 7-8-9-10-12Ds
1 pair men's adJusters
12 pair women's lasts - sizes 3-5-7-10C, 4-6GG, 3-4-5-6-8-9MC } When specified (see 6.2)
6 pair toe plates for women's lasts - sizes 4-6-8C, 8GG, 7-10MC } When specified (see 6.2)
2 pair toe plate thumb screws
1 cement pot and brush
1 wire brush
5 feet rubber welter
1 hand wire rougher
1 welt brush

3.10.4 Type V, sewing machine, industrial shoe batching.- The patching machine shall be a cylinder bed, single needle machine conforming to type IV, style A, class 5 of OO-S-256. The machine shall produce a lock stitch type

301 conforming to Fed. Std. No. 751. Unless otherwise specified (see 6.2), the shoe patching machine shall be foot power operated by a foot treadle.

3.10.4.1 Work space.- A clear work space ranging between 12-1/4 inches and 14-1/2 inches or a clear work space of 17-1/2 inches as specified (see 6.2), shall be provided at the right of the center line of the needle bar.

3.10.5 Type VI, skiving and beveling machine . - The skiving and beveling machine shall be a combination skiver, beveler, leather cutter, and welt roller. The machine shall be a hand operated, bench type machine, designed to skive, bevel, cut soles, trim soles, and roll welts, as required to repair or rebuild shoes.

3.10.5.1 Adjustment.- Machines shall have an adjustable gage to permit the cutting of standard widths or pieces up to 9 inches.

3.10.6 Type VII, heel removing and heel reducing machine.- Heel remover and heel reducing machine shall be a bench type, manually operated machine capable of removing or reducing heels manually on all type shoes.

3.10.7 Type VIII, stand, cobbler's last, with lasts.- The stand and lasts shall conform to requirements hereinafter specified.

3.10.7.1 Stand.- The stand shall be for floor mounting and shall incorporate a swivel type last holder with clamp screw and a shoe last knockout wedge.

3.10.7.2 Lasts.- Unless otherwise specified (see 6.2), the quantity and sizes or lasts Furnished with the stand shall be two No. 7, two No. 9 and two No. 10.

* 3.11 Workmanship.- The shoe repair ma.chines and related equipment shall be free from defects or blemishes. All nuts shall be drawn tight. All wiring shall be free from cuts, shall not be abraded, improperly joined or loose at terminals. Insulation shall not be excessively stripped from wire. All surfaces that might interfere with the operation or movement of the shoes being stitched shall be smooth and free from sharp edges and projections.

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.

4.2 First article inspection.- When a preproduction sample is required, it shall be examined in accordance with 4.4.1 and 4.4.2 and tested in accordance with 4.5.1 and 4.5.2, as applicable.

4.3 Inspection.- Sampling for inspection shall be performed in accordance with MIL-STD-105, except where otherwise indicated hereinafter.

4.3.1 Component and material inspection.- In accordance with 4.1 above, components and materials shall be inspected and 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.

4.3.1.1 Material examination.- In addition to the inspection in 4.3.1, an examination shall be made to determine that the components in Table III conform to the requirements indicated, as applicable.

TABLE 111 - Material examination

Component	Requirement	Requirement Paragraph
Machine bases	Material	3.5.4
Guards	Material	3.5.5
Legs (type I machines)	Material	3.10.1
Frame (type I machines)	Material	3.10.1

4.4 End product inspection.- The inspection lot shall be all items of one type (and size, if applicable) offered for inspection at one time. The sample unit shall be one completely assembled item.

4.4.1 Visual examination.- The completely assembled end item shall be examined for completeness of assembly, defects in design, construction, workmanship, finish, and marking and to assure that the end item is manufactured in accordance with specified requirements. The inspection level shall be II and the AQL shall be 6.5 expressed in terms of defects per hundred units.

* 4.4.2 Dimensional examination.- Examination shall be made for compliance with dimensions specified herein. The inspection level shall be II and the AQL shall be 6.5 expressed in terms of defects per hundred units.

* 4.4.3 Testing of the end product.- Each production unit shall be tested in accordance with 4.5.1 with no evidence of failure. In addition, when a preproduction sample is not required, the initial production unit shall be tested in accordance with 4.5.2, with no evidence of failure.

4.4.4 Examination of preparation for delivery.- Examination shall be made to determine that preservation, packaging, packing, and marking requirements of section 5 of this specification are complied with. Any deviation from specified requirements shall be cause for rejection.

4.5 Tests.-

4.5.1 Operational test.- Type V machines shall be tested in accordance with OO-S-256. Types I, II, IV, and VII machines shall be operationally tested for not less than 10 minutes. Electrically operated machines shall be connected to a power source having characteristics similar to those specified. The test shall be conducted with actual material or items of use and shall include the accomplishment of all the shoe repair operations for which the machine was designed and shall meet the requirements specified in 3.5.

4.5.2 Electromagnetic compatibility tests.- When electromagnetic compatibility is required, the preproduction sample or initial unit of production shall be tested by the supplier in accordance with test methods CE03 and RE02 of MIL-STD-462. The Government reserves the right to witness tests performed by the supplier or his private testing organization. The supplier shall furnish the Contracting Officer for approval the Interference Control Plan, the EMI/EMC Test Plan and the Electromagnetic Compatibility Test Report required by MIL-STD-461. Upon approval of the test report by the Contracting Officer and provided all other requirements of the specification are met, the preproduction sample or initial unit of production as applicable, shall be used as a model for all production units.

5. PREPARATION FOR DELIVERY

5.1 Preservation and packaging.- Preservation and packaging shall be level A or C as specified (see 6.2).

5.1.1 Level A.- Type V machines shall be preserved and packaged in accordance with the level A requirements of OO-S-256. All other types shall be preserved and packaged as specified herein. Preservation shall be in accordance with material and method requirements of MIL-P-116, as hereinafter specified.

5.1.1.1 Disassembly.- All projecting, detachable components shall be disassembled from the equipment when such will reduce the cube of the pack or is required to prevent damage to the equipment. Projecting, disassembled

handles may be reassembled onto type VI machines in such a manner as not to project, All hardware removed during disassembly shall be replaced in the machine or disassembled component, or placed in a cotton cloth bag and the bag secured to the machine or disassembled component. Disassembly shall not be such as to require special skills in reassembly.

5.1.1.2 Matchmarking.- Cloth shipping tags shall be securely attached to the disassembled components and the mating parts of the machine. Tags shall be matchmarked to facilitate reassembly. Matchmaking shall not be required for types VII and VIII equipment.

5.1.1.3 Preservation.- (See 6.5).

* 5.1.1.3.1 Mechanical components and tools.- All exposed, uncoated, ferrous metal surfaces of the equipment, including disassembled components, accessories, and tools, shall be cleaned process C-1 and thoroughly dried. All noncontacting surfaces (surfaces that do not contact other surfaces in operation), cleaned as specified, shall be coated with type P-1 preservative. All contacting surfaces (surfaces that contact other surfaces in operation), cleaned as specified, shall be coated with type P-6 preservative. All such preserved surfaces that may contact other surfaces or packaging and packing material, except those coated with type P-1 preservative, shall be covered or wrapped with greaseproof barrier material conforming to type I or II, grade A of MIL-B-121. Barrier material shall be secured with twine made of jute, sisal, manila, or cotton, or with tape conforming to type II, grade A of PPP-T-45, or heat sealed when heat sealable barrier material is used.

5.1.1.3.2 Motors.- All openings into electrical motors shall be sealed with tape conforming to class 1 or 3, color optional of PPP-T-60.

5.1.1.3.3 Belts and pulleys.- Uncoated ferrous metal surfaces of pulleys shall be coated with primer conforming to TT-P-664, the primer dried, and belts replaced or packaged with disassembled components. All installed belts shall have the tension relieved.

5.1.1.3.4 Instruction manual.- Instruction manual shall be prepared method IC-1 and secured to the machine or packaged in the same box as the detached components, tools, and accessories.

5.1.1.4 Packaglng.-

5.1.1.4.1 Securing.- Parts of each machine that are free to move shall be secured in a fixed position to prevent movement or vibration while in transit.

5.1.1.4.2 Type VII machine.- Each type VII machine shall be packaged in a snug-fitting fiberboard box conforming to style optional, type CF or SF,

class domestic of PPP-B-636. Fiberboard inserts shall be used to immobilize and isolate the contents. Each box shall be securely closed in accordance with the appendix of the box specification.

5.1.1.4.3 Detached components, tools, and accessories.- Detached components, tools, and accessories shall be packaged in a snug-fitting fiberboard or nailed wood box conforming to style optional, type CF or SF, class domestic of PPP-B-636, except that weight limitation shall not be exceeded, or class 1, style 2 or 4 of PPP-B-621, respectively. Contents shall be cushioned, blocked, or braced within the box to prevent movement while in transit. Each box shall be securely closed in accordance with the appendix of the applicable box specification.

5.1.2 Level C.- Equipment shall be preserved and packaged to afford adequate protection against corrosion, deterioration and damage during shipment from supply source to the first receiving activity. The supplier may use his standard practice when it meets these requirements.

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

5.2.1 Level A.-

* 5.2.1.1 Types I and II.- Each type I or II machine, preserved and packaged as specified in 5.1, shall be packed in a crate conforming to Type I, class 1 or 2, style a of MIL-C-104. The box containing detached components, tools, and accessories shall be waterproofed as specified in 5.2.1.7 and secured in an unused portion of ‘he crate. Contents shall be anchored in accordance with the appendix of the crate specification.

* 5.2.1.2 Type IV.- Each type IV press, preserved and packaged as specified in 5.1, shall be packed in a cleated plywood or nailed wood shipping container conforming to overseas type, type 3 load of PPP-B-601, or class 2, style 2 or 4, type 3 load of PPP-B-621, respectively. Shipping containers shall be provided with skids as specified in the applicable container specification. The contents shall be remobilized by means of lumber blocking and bracing or with a minimum of 3 carriage bolts passing through the bottom of the container and skids. The lumber blocking end bracing shall not depend on end-grain nailing alone, but supplemental supporting cleats shall be provided to reinforce and prevent splitting of the blocking and bracing. Cushioning material shall be used between the lumber blocking and the press. The contents of each shipping container shall be waterproofed as specified in 5.2.1.7. Each shipping container shall be closed and strapped in accordance with the appendix. of the applicable container specification.

* 5.2.1.3 Type V.- Type V machines, preserved and packaged as specified in 5.1, shall be packed in accordance with the level A requirements of OO-S-256.

* 5.2.1.4 Type VI.- Each type VI machine, preserved and packaged as specified in 5.1, shall be packed as specified in 5.2.1.2, except that skids are not required when contents are immobilized with lumber blocking and bracing. Each shipping container shall be provided with a type I or II, grade B or C sealed case liner conforming to MIL-L-10547.

* 5.2.1.5 Type VII.- Three type VII machines, preserved and packaged as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC, grade V2s of PPP-B-636. Each shipping container shall be closed, waterproofed by means of tape, and reinforced with flat strapping or tape banding in accordance with the appendix of the container specification.

5.2.1.6 Type VIII.- The type VIII stand with lasts, preserved and packaged as specified in 5.1, shall be packed in the most compact manner in a snug-fitting cleated plywood or nailed wood shipping container conforming to overseas type, type 3 load of PPP-B-601, or class 2, style 2 or 4, type 3 load of PPP-B-621, respectively. Lumber blocking and bracing shall be used, as necessary, to immobilize the contents within the shipping container. The blocking and bracing shall not depend on end-grain nailing alone but supplemental supporting cleats shall be provided to reinforce and prevent splitting of the blocking and bracing. Each shipping container shall be provided with a type I or II, grade B or C sealed case liner conforming to MIL-L-10547. Each shipping container shall be closed and strapped in accordance with the appendix of the applicable container specification.

* 5.2.1.7 Waterproofing.- Each type I, II and IV machine shall be covered with a full-height shroud made of waterproof barrier material conforming to class E-2, H-1, H-5, or M of PPP-B-1055. All seams of the shroud shall be sealed with a 3/4 inch minimum width seam of water-resistant adhesive conforming to MMM-A-260. Fiberboard boxes containing detached components, tools, and accessories shall be wrapped with waterproof barrier material and the wrap sealed as specified for shrouds herein. Each interior (see 5.1.1.4.3) nailed wood box containing detached components, tools, and accessories shall be provided with a type I or II, grade C case liner conforming to MIL-L-10547.

5.2.2 Level B.-

5.2.2.1 Types I and II.- Each type I or II machine, preserved and packaged as specified in 5.1, shall be packed as specified in 5.2.1.1, except that waterproofing shall not be required.

* 5.2.2.2 Type IV.- Each type IV press, preserved and packaged as specified in 5.1, shall be packed as specified in 5.2.1.2, except that shipping containers shall conform to domestic type, style A or B of PPP-B-601, or class 1, style 2 or 4, type 3 load of PPP-B-621; waterproofing of contents shall not be required.

5.2.2.3 Type V.- Type V machines, preserved and packaged as specified in 5,1, shall be packed in accordance with the level B requirements of OO-S-256.

* 5.2.2.4 Type VI.- Each type VI machine, preserved and packaged as specified in 5.1, shall be packed as specified in 5.2.2.2, except that skids are not required when contents are immobilized with lumber blocking and bracing.

* 5.2.2.5 Type VII.- Unless otherwise specified (see 5.2.2.5.1), three type VII machines, preserved and packaged as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC, type CF, variety SW or SF, class domestic, grade 275 of PPP-B-636. Closure shall be in accordance with method II of the appendix of the container specification.

* 5.2.2.5.1 When specified (see 6.2), the shipping container shall be a grade V3c 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-F-320.

5.2.2.6 Type VIII.- The type VIII stand, together with lasts, preserved and packaged as specified in 5.1, shall be packed in the most compact manner in a snug-fitting cleated plywood or nailed wood shipping container conforming to domestic type, style A or B of PPP-B-601, or class 1, style 2 or 4, type 3 load of PPP-B-621. Lumber blocking and bracing shall be used, as necessary, to immobilize the contents within the shipping container. The blocking and bracing shall not depend on end-grain nailing alone but supplemental supporting cleats shall be provided to reinforce and prevent splitting of the blocking and bracing.

5.2.3 Level C.- Equipment, preserved and 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.

6. NOTES

6.1 Intended use.- Shoe repair shop equipment covered by this specification is intended for use in the repair of shoes and combat boots, by the armed forces.

6.2 Ordering data. - Procurement documents should specify the following:

(a) Title, number, and date of this specification.
(b) Type and name of item and size required (see 1.2).
(c) When first article (reproduction sample) is not required (see 3.1).
(d) Electrical characteristics, if other than specified (see 3.4.1).
(e) When electromagnetic compatibility is required for Air Force use (see 3.4.2).
(f) Equipment manual contents and distribution (see 3.7).
(g) When metal protective edge for scouring wheel is required (see tables I and II).
(h) Mounting of attachments (i.e., left to right or right to left) for type I, size B shoe finisher and list of attachments if other than in table II (see 3.10.1.3).
(i) When women's lasts and toe plates for shoe soling press are required (see 3.10.3.1).
(j) When shoe patching machine is for electrical operation (see 3.10.4 and 3.4.1).
(k) Work space required for shoe patching machine (see 3.10.4.1).
(l) Quantity and size of shoe lasts, if other than specified (see 3.10.7.2).
(m) Selection of applicable levels of preservation and packaging, and packing (see 5.1 and 5.2).
(n) When weather-resistant fiberboard is required for level B pack (see 5.2.2.5.1).

6.3 The following manufacturer's item has previously met the requirements for the shoe soling press specified in 3.10.3:

Manufacturer	Manufacturer's Part No.
Lamac Process Company	Heated, No. 57A

The above is furnished only to indicate a possible source of supply. Other manufacturers' items which conform to the specified requirements will be acceptable.

6.4 Electromagnetic compatibility.- The contracting officer should submit a copy of the Interference Control Plan, the EMI/EMC Test Plan, and the -test report required (see 4.5.2) to the Commanding General, U. S. Army Electronics Command, Attn: AMSEL-RD-GF, Fort Monmouth, New Jersey, for approval.

6.5 Preservation.- The method of preservation referred to in 5.1.1.3 is similar to method I of MIL-P-116.

6.6 Supersession data.- The type III shoe nailing machine and the type VIII, style 1 stand have been eliminated by this revision. The type I, size B finishing machine has been added to this revision.

6.7 The margins of this specification have been q arked 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 suppliers are cautioned to evaluate the requirements of this document based on the entire content as written irrespective of the marginal notations and relationship to the last previous issue.

Custodians:

Army - GL
Air Force - 84

Review activities:

Army - EL, MC
Air Force - 84, 85

Preparing activity:

Army - GL

Project No. 3520-0020

"to detach this form, cut along this line"

SPECIFICATION ANALYSIS SHEET

Form Approved
Budget Bureau No. 119-R004

INSTRUCTIONS

This sheet is to be filled out by personnel either Government or contractor, involved in the use of the specification in procurement of products for ultimate use by the Department of Defense. This sheet is provided for obtaining information on the use of this specification which will insure that suitable products can be procured with a minimum amount of delay and at the least cost. Comments and the return of this form will be appreciated. Fold on lines on reverse side, staple in corner, and send to preparing activity.

SPECIFICATION
Shoe Repair Shop, Equipment MIL-S-1123E

ORGANIZATION	CITY AND STATE

CONTRACT NO	QUANTITY OF ITEMS PROCURED	DOLLAR AMOUNT
		$

MATERIAL PROCURED UNDER A

☐ DIRECT GOVERNMENT CONTRACT ☐ SUBCONTRACT

1 HAS ANY PART OF THE SPECIFICATION CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE?

A GIVE PARAGRAPH NUMBER AND WORDING.

B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES

2 COMMENTS ON ANY SPECIFICATION REQUIREMENT CONSIDERED TOO RIGID

3 IS THE SPECIFICATION RESTRICTIVE?

☐ YES ☐ NO IF "YES", IN WHAT WAY?

4. REMARKS *(Attach any pertinent data which may be of use in improving this specification. If there are additional papers, attach to form and place both in an envelope addressed to preparing activity)*

SUBMITTED BY *(Printed or typed name and activity)*	DATE

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