

**INCH-POUND**

MIL-STD-1612B  
17 October 1988  
SUPERSEDING  
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18 April 1980

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



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## MIL-STD-1612B

## FOREWORD

1. This Military Standard is approved for use by all Departments and Agencies of the Department of Defense.

2. Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Officer in Charge, Navy Clothing and Textile Research Facility, 21 Strathmore Road, Natick, Ma 01760-2490 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

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

Specification

MIL-G-1007

MIL-G-41817

MIL-G-83150(USAF)

Title

Gloves, Women's

Gloves, Men's, Cloth, Dress, White

Gloves, Cloth, Nylon Knitted (Women's Dress)

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## 1. SCOPE

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

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

## 2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

## STANDARD

## MILITARY

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

(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from the Naval Publications and Forms Center, (ATTN: NPODS), 5801 Tabor Avenue, Philadelphia, PA 19120-5099.)

2.2 Order of precedence. In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable law and regulations unless a specified exemption has been obtained.

## 3. DEFINITIONS

3.1 Fabric defects. The fabric defect definitions applicable to the standard are described in FED-STD-1491. Fabric defects shall be clearly visible when examined at a distance of 3 feet.

3.2 Knots and slubs. Only knots and slubs that exceed the limits specified in the basic cloth specification and are clearly visible when examined at a distance of 3 feet shall be scored as defects in evaluating quality of glove.

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3.3 Quality assurance terms and procedures. Quality assurance terms and procedures, when applicable, shall be in accordance with MIL-STD-105 and MIL-STD-109.

3.4 Open seam. The seam shall be classified open when one or more stitches joining a seam are broken or runoff, or when two or more continuous skipped or runoff stitches occur.

## 4. GENERAL REQUIREMENTS

4.1 This standard contains the provisions for end item examination, dimensional examination, and packaging inspection for cloth dress gloves. This standard assigns to the listed defects point values of 1, 2, or 3 depending on degree of severity. The higher point values are assigned to those defects having more detrimental effect on the appearance or serviceability of the item.

## 5. DETAILED REQUIREMENTS

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

a. The point value of 3 and 2 point defects exceeds the applicable maximum acceptable point value.

OR

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

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

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

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5.3 Packaging Inspection. An examination shall be made to determine that packaging, packing, and marking requirements are in compliance with Section 5 of the appropriate glove specification. Defects listed below shall be scored one point. The sample size for this examination shall be five shipping containers fully prepared for delivery with the exception that they need not be closed. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot shall be unacceptable if one or more points are scored for this examination.

<u>Examine</u>	<u>Defect</u>
Marking (exterior and interior)	Omitted, incorrect, illegible, or improper size, location, sequence, or method of application.
Materials	Any component missing, damaged, or not as specified.
Workmanship	Inadequate application of components, such as: incomplete closure of container, flaps, loose strapping, improper taping, inadequate stapling, or open and non-continuous heat sealed seams of polyethylene bag. Bulging or distorted container.
Content	Number of intermediate packages per shipping container is more or less than required.  Number of pairs of gloves per intermediate package is more or less than required. <u>1/</u>

1/ For this defect, two intermediate packages shall be examined from each shipping container in the sample.

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

5.5 Initiation of inspection. Normal inspection will be used at the start of inspection unless otherwise directed by the procurement quality assurance element administering the contract.

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

5.7 Switching procedures.

5.7.1 Normal to tightened. When normal inspection is in effect, tightened inspection shall be instituted when two out of five consecutive lots have been rejected on original inspection (e.i., ignoring resubmitted lots for this procedure).

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

5.7.3 Normal to reduced. When normal inspection is in effect, reduced inspection shall be instituted providing that all of the following conditions are satisfied:

a. The preceding 10 lots have been on normal inspection and none have been rejected on original inspection; and

b. The total number of points for 3 and 2 point defects in the samples from the preceding 10 lots is equal to or less than sixty percent of the total maximum acceptable point values for 3 and 2 point defects from the preceding 10 lots; and

c. The total number of points for 3, 2 and 1 point defects in the sample from the preceding 10 lots is equal to or less than seventy-five percent of the total maximum acceptable point values for 3, 2, and 1 point defects from the preceding 10 lots; and

d. Production is at a steady rate; and

e. Reduced inspection is considered desirable by the procurement quality assurance element administering the contract.

5.7.4 Reduced to normal. When reduced inspection is in effect, normal inspection shall be instituted if any of the following occur on original inspection:

a. A lot is rejected; or

b. A lot is considered acceptable but exceeds the applicable first value (see 1/ to Table I); or

c. Production becomes irregular or delayed; or

d. Other conditions warrant that normal inspection be reinstated.

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Table I - Sampling provisions for Cloth Dress Gloves

	Lot Size	Sample Size	Maximum Acceptable Point Values	
			3 & 2 Point Defects	3, 2, & 1 point Defects
Normal Inspection	Up thru 50	13	6 points	11 points
	51 thru 150	20	8 points	15 points
	151 thru 280	32	13 points	22 points
	281 thru 500	50	18 points	32 points
	501 thru 1200	80	24 points	44 points
	1201 thru 3200	125	33 points	63 points
	3201 thru 10,000	200	48 points	91 points
	10,001 thru 39,000	315	68 points	131 points
	39,001 and over	500	99 points	190 points
Tightened Inspection	Up thru 50	13	4 points	8 points
	51 thru 150	20	7 points	13 points
	151 thru 280	32	9 points	18 points
	281 thru 500	50	13 points	26 points
	501 thru 1200	80	20 points	39 points
	1201 thru 3200	125	29 points	58 points
	3201 thru 10,000	200	42 points	85 points
	10,001 thru 39,000	315	62 points	125 points
	39,001 and over	500	92 points	183 points
			3 & 2 point defects 1/	
Reduced Inspection	Up thru 280	13	4-11 points	16 points
	281 thru 500	20	7-13 points	20 points
	501 thru 1200	32	11-18 points	27 points
	1201 thru 3200	50	15-22 points	36 points
	3201 thru 10,000	80	22-29 points	49 points
	10,001 thru 39,000	125	31-37 points	65 points
	39,001 and over	200	46-53 points	96 points

1/ If the first value is exceeded but the second value has not been exceeded, accept the lot but reinstate normal inspection (see 5.7.4b). The second value is the maximum acceptable point value.

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6. NOTES

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

6.1 Intended use. This standard obtains requirements for evaluating quality of cloth dress gloves.

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

\* 6.3 Changes from previous issue. The margins of this standard are marked with an asterisk to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous issue.

\* 6.4 Subject term (key word) listing.

Gloves, Dress, Defects of  
Gloves, Dress, Inspection of  
Gloves, Dress, Quality of

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Table II - Classification of defects

	<u>Point Value</u>
<b>I. <u>MATERIAL DEFECTS AND DAMAGE</u></b>	
a. Hole, cut, tear, smash, burn, needle chew, scorched area, or open place	3
b. Knot or slub (see 3.2) on outside	1
c. Loose yarn, snagged thread, float, drop stitch, visible mend, missing yarn, broken yarn, thin place, knitted in waste, shade bar, dye streak, split stitch, area of no dye penetration, and tacking defect; more than 1/2 inch (largest dimension in any direction) on outside	2
<b>II. <u>SHADED PARTS</u></b>	
a. Any part shaded or variation in shade within a part:	
1. On outside	3
2. On inside	1
<b>III. <u>CLEANNES</u></b>	
a. Spot or stain on outside (largest dimension in any direction):	
1. Up to 1/4 inch, inclusive	1
2. More than 1/4 inch	2
b. Thread ends - on outside:	
1. More than one but not more than three not trimmed to less than 1/2 inch	1
2. More than three not trimmed to less than 1/2 inch	2
c. Two or more shade or size tickets not removed	1
d. Surplus material on seams not trimmed throughout glove	1
e. Any size or shade marking on outside, score as spot or stain (see IIIa)	

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Table II - Classification of defects

	<u>Point Value</u>
IV. <u>CUTTING</u>	
- Any component part not cut in accordance with specified pattern, directional lines on patterns, or not in accordance with specification requirements	3
V. <u>COMPONENTS AND ASSEMBLY</u>	
a. Any component part or operation omitted (unless otherwise classified herein)	3
b. Any component not as specified	3
c. Any component part, tight, twisted, distorted, pleated, or full (unless otherwise classified herein)	2
d. Any operation not as specified (unless otherwise classified herein)	2
VI. <u>SEAMS AND STITCHING</u>	
a. Accuracy of seaming:	
1. Seam puckered	2
2. Seam irregular, pleated, or wavy	2
3. Any part of glove caught in an unrelated operation	2
4. Ends of stitching produced with 301 stitch type, when not caught in other seams or stitching, backtacked less than specified	1
5. Ends of stitching produced with 401 stitch type, when not caught in other seams or stitching, not having chain extending beyond each end	2
6. Ends of stitching produced with 401 stitch type, when not caught in other seams or stitching, having chain extending less than 1/2 inch or more than 3/4 inch beyond each end	1
7. Thread breaks (all stitch types) stitched less than 1/2 inch beyond each end of break	1
b. Gage of stitching and seam allowance:	
1. Stitching irregular, not within range specified, or varies more than 1/16 inch when no range is specified (score only when condition exists on more than half the length of seam)	1
2. Width of seam allowance varies more than 1/16 inch from allowance specified (score only when condition exists on more than half the length of seam)	2

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Table II - Classification of defects

<u>VI. SEAMS AND STITCHING CONT</u>	<u>Point Value</u>
c. Open seam or stitching (see 3.4):	
1. On all seams, except pointing or hem stitching	3
d. Runoff, skipped, or broken stitches:	
1. On joining seam - when resulting in an open seam, use "Open seam or stitching" classification	
2. On pointing stitching:	
(a) - one skipped or broken stitch	1
(b) - two or three skipped or broken stitches	2
(c) - four or more skipped or broken stitches	3
3. On hem stitching:	
(a) - up to 1/4 inch, inclusive	1
(b) - more than 1/4 inch	2
e. Seam and stitch type:	
1. Not specified seam or stitch type	2
2. Any line of stitching omitted	3
3. Any line of stitching misplaced or not beginning or ending when specified	1
4. Looper thread of 401 stitch type on outside (outseam constructed glove)	3
f. Stitch tension:	
1. Loose tension resulting in a loose seam	3
2. Loose tension on hem or pointing stitching, resulting in loosely exposed thread	2
3. Tight tension (stitches break when normal strain is applied in the direction of the seam or stitching)	3
g. Stitches per inch (to be scored only when the condition exists on the major portion of seam or stitching):	
1. Less than the minimum	2
2. More than the maximum	1
h. Stitches or "V" points for attaching elastic webbing:	
1. For Zig-Zag stitching - stitch type 304:	
(a) - less than the minimum	2
(b) - more than the maximum	1
2. For Zig-Zag stitching - stitch type 301:	
(a) - less than the minimum	2
(b) - more than the maximum	1
3. For Zig-Zag stitch pattern - stitch type 301:	
(a) - less than 15 "V" points	2
(b) - more than 20 "V" points	1

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Table II - Classification of defects

	<u>Point Value</u>
VII. <u>THREAD</u>	
a. Color other than specified or mismatched for shade with the base fabric:	
1. On outside	2
2. On inside	1
VIII. <u>ELASTIC WEBBING</u>	
a. Omitted	3
b. Misplaced, loose, not positioned or attached as specified	2
c. Finished relaxed length less than 1-3/4 inches or more than 2-1/4 inches	1
d. Tacking at one or both ends of the webbing omitted or insecure	1
IX. <u>THUMB, FINGERS, AND FOURCHETTE</u>	
a. Thumb type other than specified	3
b. Fingers formed without specified fourchette	3
c. Any fourchette spliced	3
d. Any one finger or thumb twisted or poorly shaped	2
X. <u>HEM</u>	
a. Twisted or pleated	2
b. Puckered	1
c. Finished width not as specified	1

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Table II - Classification of defects

	<u>Point Value</u>
<b>XI. <u>VENT FACING</u></b>	
a. Omitted	3
b. Misplaced, loose, not positioned or attached as specified	2
c. Spliced	2
d. Twisted or not lying flat	2
e. Improperly joined, causing vent facing to pull away from base fabric	2
<b>XII. <u>IDENTIFICATION AND SIZE LABEL</u></b>	
a. Omitted, incorrect, or illegible	
1. On one glove	1
2. On both gloves	2
b. Misplaced	1
c. Cloth label, when applicable, not attached as specified or stitching through the printing	1
d. Color of the marking ink not as specified or not of a contrasting color to the base fabric	1
<b>XIII. <u>INSTRUCTION LABEL</u></b>	
a. Missing, incorrect, or illegible	2
b. Size of the label or lettering not as specified	1
c. Color of the inscription printing not as specified	1
d. Not inserted in right hand glove only	1
<b>XIV. <u>PAPER INSERTS</u></b>	
a. Omitted	2
b. Size of the inserts not as specified	1
c. Corners of the inserts not rounded	1

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Table II - Classification of defects

	<u>Point Value</u>
<b>XIV. <u>PAPER INSERTS (Cont'd)</u></b>	
d. Inscription on the printed insert incorrect or illegible	2
e. Size of the lettering on the printed insert not as specified	1
f. Color of the inscription printing other than specified	1
g. Printed insert not placed in right hand glove only	1
<b>XV. <u>FINISHING</u></b>	
- Gloves not layed-off, i.e., pressing omitted or poorly shaped	2
<b>XVI. <u>PAIRING</u></b>	
a. Mismatched, i.e., two gloves of different sizes or two gloves for the same hand	3
b. Mislabeled, i.e., two gloves of same size with different sizes on labels	1
c. Unevenness in length of fingers, thumb, or overall length of the two gloves:	
1. Up to 1/4 inch, inclusive	1
2. More than 1/4 inch up to 3/8 inch, inclusive	2
3. More than 3/8 inch	3
d. Pair not tacked together or not tacked as specified	1
e. Tacking insecure (less than 2 stitches)	1
f. Tacking too tight, i.e., not permitting gloves to pull apart without tearing fabric	2

Custodian:  
 Navy - NU  
 Army - GL  
 Air Force - 11

Preparing Activity:  
 Navy - NU

Project No. 8440-0181

Review activities:  
 Navy - MC  
 Army - GL  
 Air Force - 99, 82

User activity:  
 Navy - CG