

INCH-POUND
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SUPERSEDING
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5 December 1989

GLOVES, MEN'S AND WOMEN'S, LEATHER, LIGHT DUTY

This specification is approved for use by all departments and agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This purchase description covers the requirements for the U.S. Marine Corps Men's and Women's Leather Light Duty Gloves. This item is intended for wear by male and female military personnel of the Department of Defense with utility uniforms. The gloves are intended for light duty work. They may be worn alone; or for additional warmth under cold conditions they may be worn with an insert.

1.2 Classification. The gloves will be in the following sizes.

Schedule of sizes

1
2
3
4
5

Comments, suggestions, or questions on this document should be addressed to: Defense Supply Center Philadelphia, Clothing and Textiles Directorate, Attn: DPSC-FQS, 700 Robbins Avenue, Philadelphia, PA 19111-5092. Since contact information can change, you may want to verify the currency of this address information by using the ASSIST Online database at www.dodssp.daps.mil.

AMSC N/A.

FSC 8415

DISTRIBUTION STATEMENT A

*Approved for public release;
distribution is unlimited.*

2. APPLICABLE DOCUMENTS

2.1 General. The documents listed in this section are specified in sections 3 or 4 of this specification. This section does not include documents cited in other sections of this specification or recommended for additional information or as examples. While every effort has been made to ensure the completeness of this list, document users are cautioned that they must meet all specified requirements cited in sections 3 or 4 of this specification, whether or not they are listed.

2.2 Government documents.

2.2.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents shall be cited in the solicitation or contract (see 6.1).

FEDERAL STANDARDS

FED-STD-311 Leather Methods of Sampling and Testing

COMMERCIAL ITEM DESCRIPTIONS

A-A-59826 Thread, Nylon

DEPARTMENT OF DEFENSE SPECIFICATIONS

MIL-DTL-32075 Label, For Clothing, Equipment and Tentage (General Use)
MIL-L-40051 Leather, Cattlehide, for Gloves
MIL-B-543 Buckles, Tongueless and Web Strap
MIL-T-43566 Tape, Textile, Cotton or Polyester, General Purpose,
Natural or In Colors

(Copies of these documents are available online at <http://assist.daps.dla.mil/quicksearch/> or from the Standardization Document Order Desk, 700 Robbins Avenue, Bldg. 4D, Philadelphia, PA 19111-5094.)

2.3 Non-Government standards and other publications. The following document(s) form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those cited in the solicitation or contract (see 6.1).

AMERICAN SOCIETY FOR QUALITY (ASQ)

ASQC Z1.4 Sampling Procedures and Table for Inspection by
Attributes (DoD adopted)

(Copies for these documents are available online at <http://www.asq.org/> or from American Society for Quality, P.O. Box 3005, 611 North Plankinton Ave, Milwaukee, WI 53201.)

AMERICAN SOCIETY FOR TESTING AND MATERIALS

ASTM-B633
ASTM-D6193

Zinc on Iron and Steel, Electrodeposited Coatings of
Stitches and Seams

(Copies of these documents are available on line at <http://www.astm.org> or from ASTM International, 100 Barr Harbor Drive, West Conshohocken, PA 19428-259.)

2.4 Order of precedence. Unless otherwise noted herein or in the contract, in the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 First article. When specified, (see 6.1), a sample shall be subjected to first article inspection (see 6.2), in accordance with 4.2.

3.2 Design. The gloves shall conform to Nationwide Glove Co Inc.'s "Flexor Glove" or equal. The gloves shall be unlined leather, wing thumb, inseam sewn, with a buckle strap closure on the back of the wrist and a snaphook and D-ring system at the gauntlet for attaching the gloves to each other. The finger portion of the glove shall be comprised of two superimposed four-pointed star-shaped pattern pieces where each point comprises a finger part. Each finger portion pattern piece shall have an inner cutout of substantially rectangular shape. The pieces shall be joined together around their outer peripheries such that one pattern piece forms the palm side of the finger portion and the other pattern piece forms the back side of the finger portion. The pattern piece comprising the back side shall have longer finger parts than the pattern piece comprising the palm side before the pieces are joined together around their outer peripheries. The finger parts of the pattern piece comprising the back side shall be shortened by folding a part thereof upon itself to form a tuck which extends across the width of each finger part and so that the length of each finger part will be made substantially equal in length to each corresponding finger part of the pattern piece forming the palm side. The tucks shall be located at the first inter-phalangeal joints of the finger. The thumb piece shall be tucked in the same manner as the fingers. The widths of the finger parts corresponding to the finger portions of the two pattern pieces shall be equal such that when the pieces are joined at their peripheries, the junction between the pattern pieces will extend along the line of non-extension for each finger, i.e., at the neutral axis extending along the length of each finger, such that the seam will not compress or stretch upon flexing of the finger. The seam on the back of the glove which joins the back of the fingers to the back of the hand shall have an inserted welt, 3/16 to 1/4 inch wide. The welt shall not be caught in the side seam closing. The seam on the palm side of the glove which joins the palm side of the finger to the palm side of the hand shall be covered with a palm patch of leather which extends approximately from below the fingers to the thumb crotch and to the seam on each side of the hand. The glove shall extend approximately 2 inches beyond the wrist and the gauntlet shall be hemmed. The gloves shall be available in five incremental sizes to fit the 5th percentile female through the 95th percentile male in the Marine Corps population.

3.3 Materials and components. The materials and components shall conform to applicable specifications, standards, drawings, and patterns required herein.

3.3.1 Basic Material.

3.3.1.1 Leather. The gloves shall be made of full grain, chrome tanned cattlehide conforming to type I, class a or b, treatment A of MIL-L-40051 except that the thickness shall be as such as to produce finished gloves with a leather thickness not less than 2 ounces nor more than 3 ounces. The leather shall be treated with an approved water resistance compound (see 6.4). After the water resistant compound has been applied, the leather shall not be exposed to soaps, detergents, wetting agents, or surfactants. The color of the leather shall be black.

3.3.2 Buckles. The buckles shall be 2-bar, tongueless, lip type conforming to type II, style 3, class 3, size 5/8 inch of MIL-B-543. 3.3.3 Tape. The tape for the loop and buckle strap shall be 5/8 inch wide conforming to type I, class 3 of MIL-T-43566, except that the dyed tape shall show an AATCC Chromatic Transference Scale rating for crocking not lower than 1.5 for wet crocking and 3.5 for dry crocking. The color of the tape shall closely match the color of the gloves.

3.3.4 D-ring and snaphook. The D-Ring shall conform to Albest Part # WD 6X6-14 DB or equal. The snaphook shall conform to Albest Part # WHO207-24BD or equal. The finish for both the D-ring and snaphook shall be phosphate treated zinc plate conforming to type III, class 2 of ASTM-B-633, followed by bake enameling. The enamel shall conform to Master Painters Institute Reference #8, exterior alkyd, flat, MPI gloss level 1, reference #9, exterior alkyd enamel gloss, MPI gloss level 6, reference #47, interior alkyd, semi-gloss MPI gloss level 5, reference #48, interior alkyd, gloss, MPI gloss level 6, reference #49, interior alkyd, flat, MPI gloss level 1, reference #51, interior alkyd, eggshell, MPI gloss level 3 or reference #94, exterior alkyd, semi-gloss, MPI gloss level 5. The color shall be black.

3.3.5 Thread. The thread for sewing the gloves shall be nylon, matching the shade of the leather, and conforming to type I, class B, size E of AA-59826 or type II, with approved class B nonwicking finish, size E of AA-59826.

3.3.6 Labels.

3.3.6.1 Identification-size label. Each glove shall have a combination identification-size label conforming to type VI, class 4 of MIL-DTL-32075, and the label shall show fastness to laundering transference as specified therein.

3.3.6.2 Instruction slip. A printed slip of thin paper containing instructions as indicated below shall be inserted in each right hand glove:

INSTRUCTIONS

Gloves shall be worn alone or with inserts
Fit gloves snugly but not tightly over the inserts

Adjust strap for fit

Gloves are available in five sizes: 1, 2, 3, 4, 5

Dry gloves and glove inserts away from extreme heat or flame

The gloves are water resistant treated, but are not waterproof

3.4 Recycled, recovered, or environmentally preferable materials. Recycled, recovered, or environmentally preferable materials should be used to the maximum extent possible provided that the material meets or exceeds the operational and maintenance requirements, and promotes economically advantageous life cycle costs.

3.5 Construction.

3.5.1 Patterns. The Government will provide a complete set of patterns, including all sizes, 1 through 5, (see 6.1) which show size, directional lines, placement marks, and notches for assembly. The patterns generally provide for a 1/8 inch seam allowance. The Government pattern shall be used to create a working pattern. The government pattern shall not be altered. Minor modifications are permitted to the working pattern where necessary when using automatic equipment or to accommodate a manufacturing process. These modifications shall not alter the dimensional, serviceability, or appearance requirements cited in this specification. Commercial patterns may be used in lieu of government furnish patterns. Minor modifications are permitted to accommodate automation; however the design and measurements of the government-furnished pattern must be maintained for both the working, and commercial patterns.

3.5.1.1 Pattern Parts. The component parts of the glove shall be cut from materials as specified and in accordance with the number of parts required as specified in Table I.

TABLE I. Glove Pattern Parts

Material	Piece Name	Cut Parts
Basic Material	Back	Cut 2
Basic Material	Finger Back	Cut 2
Basic Material	Finger Palm	Cut 2
Basic Material	Palm	Cut 2
Basic Material	Palm Patch	Cut 2
Basic Material	Thumb Back	Cut 2

3.5.2 Stitches, seams, and stitching. All stitches, seams, and stitching types used in construction of this glove shall conform to ASTM-D-6193. The minimum and maximum number of stitches per inch shall be as specified in Table II. The use of sewing machines with trimmer attachments shall not be permitted. Ends of all seams and stitching shall be backstitched or overstitched not less than 3/8 inch when not caught in other seams and stitchings. Thread tension shall be maintained so there will be no loose tension resulting in a loose bobbin or top thread or excessively tight stitching resulting in puckering of the material sewn.

TABLE II. Stitching

Operation	Stitch Type	Stitches Per Inch
Topstitch, single needle stitch, straight stitch, or double stitch	301	9-11
Baste	301	6-8
Bartack	Bartack	28 stitches, ½ inch long

3.5.3 Repairs of type 301 stitching. Repairs of stitching shall be as follows:

- a. When thread breaks or bobbin run-outs occur during sewing, the stitching shall be repaired by restarting the stitching a minimum of ½ inch back of the end of the stitching.
- b. Thread breaks or two or more consecutive skipped or run-off stitches noted during inspection of the item shall be repaired by over-stitching. The stitching shall start a minimum of ½ inch back of the defective area, continue over the defective area, and continue a minimum of ½ inch beyond the defective area onto the existing stitching. Loose or tight stitching shall be repaired by removing the defective stitching without damaging the material and restitching in the required manner. ^{1/}

^{1/} When making the above repairs, the ends of stitching are not required to be backstitched.

3.6 Finished Dimensions. The finished measurements shall be as shown in Table III:

TABLE III. Finished Dimensions (Inches)

Size	Overall Length ^{1/}	Width ^{2/}
1	9	4-5/8
2	9-3/8	4-3/4
3	10	4-7/8
4	10-3/8	5-1/8
5	10-7/8	5-1/4
Tolerance	+/- 3/8	+1/4 -1/8

^{1/} The glove length shall be measured from tip of the middle finger to the edge of the cuff, with hand side facing up.

^{2/} The glove width shall be gently stretched out and measured along the lower edge of the leather welt, with hand back side facing up.

3.7 Workmanship. The finished gloves shall be free from loose thread, foreign matter, and irregular defects that can adversely affect usage or durability. The finished gloves shall be uniform in quality, free from defects that adversely affect form, fit or function and those defects specified in Table IV.

3.8 Pairing. The gloves shall be matched, paired, and tacked together with a plastic barb just below the hem approximately ½ inch from closing seam.

4. VERIFICATION

4.1 Classification of inspections. The inspection requirements specified herein are classified as follows:

1. First article inspection (see 4.2).
2. Conformance inspection (see 4.4).

4.2 First article inspection. A first article inspection when required (see 4.1) shall consist of the examinations and tests specified in Table IV. The first article inspection shall be unacceptable if the requirements in Table IV are not met.

4.3 First article samples. Unless otherwise specified in the procurement document, first article samples shall be provided. The sample size will be specified in the procurement document. The lot size shall be expressed in units of gloves. The sample unit shall be one glove and the selection shall be pairs.

4.3.1 Materials and components inspection. In accordance with 4.1, components and materials shall be inspected 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 to testing provisions specified in referenced documents, components shall be tested for the characteristics specified in this specification. Tests shall be conducted with both the specimen and test apparatus under standard conditions as defined in the various ASTM test methods. All requirements are applicable to the sample unit. All test reports shall contain the individual values utilized in expressing final results. The lot shall be unacceptable if one or more sample units fail to meet any test requirement specified. Unless otherwise specified in subsidiary specifications, sampling shall be as follows conforming to FED-STD-311: 15 eight inch swatches taken from lot sizes of up to 25,000 sq ft.

4.4 Conformance inspection. In accordance with 4.1, conformance inspection shall include the examination specified in 4.3.1. Sampling for inspection shall be performed in accordance with ASQC Z1.4.

4.4.1 Conformance inspection samples. Sampling for conformance inspection shall be performed in accordance with ASQC Z1.4 (see 6.2). The sample unit shall be one pair and the lot shall be expressed in pairs.

4.5 Examinations and tests.

4.5.1 In-process examination. Visual and dimensional examinations shall be made at any point or during any phase of the manufacturing process to determine whether construction details which cannot be examined in the finished product are in accordance with requirements specified in section 3. Materials and components, which can be classified, as a defect in accordance with Table IV shall be removed from production.

4.5.2 Visual examination. The end item shall be visually examined for compliance to 3.2. The gloves shall be examined for defects in shade, design, material, construction, and workmanship, with defects classified in accordance with Table IV. The lot size shall be expressed in units of gloves. The sample unit shall be one glove and the selection shall be pairs. Defects for pairing shall be classified as a single defect. The inspection level shall be II and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 2.5 for major defects and 6.5 for total combined major and minor defects.

TABLE IV. End Item Visual Defects

Examine	Defect	Classification	
		Major	Minor
Pairing	Not properly mated (i.e, right and left not of the same size)	101	
	Not tacked together		201
Color	Not specified color, color not uniform, or shaded parts clearly noticeable		202
	Buckle not coated with black enamel		203
Design	Not as specified	102	
Cleanness	Spots or stains clearly noticeable affecting appearance		204
Material, (leather)	Hole (except a pinhole or needle hole), cut, tear, or rip	103	
	Three or more pinholes or needle holes		205
	Not full grain	104	
	Not soft and pliable	105	
	Grain damage or imperfections: -seriously affecting serviceability or appearance	106	
	-affecting serviceability or appearance, but not seriously (not applicable to minute surface break provided the condition or frequency of same does not have serious effect on appearance)		206
	Deep open scratch	107	
	Deep wrinkles seriously affecting serviceability or appearance	108	
	Wrinkles affecting serviceability or appearance, but not seriously		207
	Scar or abraded area: -seriously affecting serviceability or appearance	109	
	-affecting serviceability or appearance, but not seriously		208
Brittle, bony area, grub, tick marks, open veins or thin spot: -seriously affecting serviceability		110	
	-affecting serviceability, but not seriously		209
	Flesh side of leather not smooth or contains loose		210

	flesh in excess of 1 square inch in total area Loose or spongy leather Flanky leather:	111	
	-seriously affecting serviceability or appearance -affecting serviceability, but not seriously Leather improperly cut (i.e., excessive stretch in length direction of glove)	112 113	211
Tape	Not type specified Hole, cut, tear, or rip Multiple floats, smashes, slubs, or other forms of misweave	114	212 213
Construction and workmanship; general (applicable to all components unless otherwise indicated herein)	Component misplaced, operation omitted, or operation not properly performed Component missing Component not securely affixed Workmanship damage (e.g., scissor or knife cut) Mend in leather (i.e., patch – not applicable to restitched seam repair) Needle chews likely to develop into a hole Buckle has sharp burr or metal sliver Buckle will not function properly	115 <u>1</u> / 116 117 118 119 120 121	214 215
Seams and stitching	Open seam: -in single stitched seam (except wrist hem) -in both rows of a double stitched seam -in one row of a double stitched seam -in wrist hem -not repaired as specified (when applicable) NOTE: A seam shall be classified as open when one or more stitches joining a seam are broken or when two or more consecutive skipped or run-off stitches occur. Not specified seam type Not specified stitch type Row of stitching omitted Loose stitch tension resulting in a loosely secured seam Tight stitch tension resulting in cutting of leather or breaking of stitches when normal pull is applied Ends of stitching not secured as specified Gage of stitching irregular or not as specified, affecting appearance Part caught in unrelated row of stitching One or two stitches per inch less than specified Three or more stitches per inch less than specified	122 123 124 125 126 127 128 129 130	216 217 218 219 220 221

	Not backstitched where required More than the specified maximum number of stitches per inch: -damaging leather -not damaging leather	131	222 223
Assembly detail	Glove not neatly laid off Not lapped seam or inseam construction where specified Finger distorted, or twisted affecting comfort of wearer or seam of little finger may come in contact with object. Thumb welt not completely caught in seam Buckle strap and adjusting strap not sewn in alignment causing malformation when strap is tightened Insufficient stretch to prevent constriction or bending across knuckles when fingers are doubled to form a fist Thread ends not trimmed throughout glove Not properly trimmed or finished causing discomfort to user (e.g., lump or bulk in finger inseam because leather was not properly trimmed) Not constructed with specified number of pieces of leather Difference in overall length between front and back of glove is more than 1/8 inch Any component full, tight, or twisted	132 133 134 135 136 137	224 225 226 227 228
Label and instruction slip	Omitted, incorrect, illegible, or misplaced; size and identification label not securely sewn in wrist hem		229

1/ Any construction defect that results in a malformed glove such as a twisted finger or thumb resulting in any seam lying in the palmar area of the finger or thumb is a major defect. When a finger or thumb is twisted and the seam is rotated to at least 45 degrees from the vertical and does not lie in the palmar area, it is a minor defect.

4.5.3 End item dimensional examination. The gloves shall be examined for conformance to the thickness of finished glove leather in paragraph 3.3.1.1 and to the dimensions specified in table III. Any dimension not within the specified tolerance shall be classified as a defect. The lot size shall be expressed in units of gloves. The sample unit shall be one glove and the selection shall be by pairs. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units shall be 4.0.

NOTE: Each leather part of the glove shall be checked for thickness (i.e., thumb, body of glove, fingers and welts where feasible). Any of these parts that are not within the required thickness range shall constitute a defect.

4.5.4 Certification. The contractor shall certify and maintain substantiating evidence that the product offered meets the salient characteristics and requirements of this Purchase Description,

that an approved compound has been used to treat the leather for water resistance, and that the product conforms to the producer's own drawings, specifications, standards, and quality assurance practices. The Government reserves the right to require proof of such conformance prior to first delivery, and thereafter as may be otherwise provided for under the provisions of the contract. The contractor shall submit a certificate of compliance stating the following:

- a. That an approved compound has been used to treat the leather for water resistance.

5. PACKAGING

5.1 Packaging. For acquisition purposes, the packaging requirements shall be as specified in the contract or order (see 6.1). When packaging of materiel is to be performed by DoD or in-house contractor personnel, these personnel need to contact the responsible packaging activity to ascertain packaging requirements. Packaging requirements are maintained by the Inventory Control Point's packaging activities within the Military Service or Defense Agency, or within the military service's system commands. Packaging data retrieval is available from the managing Military Department's or Defense Agency's automated packaging files, CD-ROM products, or by contacting the responsible packaging activity.

6. NOTES

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

6.1 Acquisition requirements. Acquisition documents should specify the following:

- a. Title, number and date of this document, including any amendments.
- b. Types, classes and sizes required (see 1.2).
- c. National stock number.
- d. Applicable Government patterns and drawings, including revisions (see 3.5.1).
- e. When first article sample is required (see 4.2 and 6.2).
- f. Number of first article inspection samples (see 4.3)
- g. Issue of DODISS to be cited in the solicitation and, if required, the specific issue of individual documents referenced (see 2.2 and 2.3).
- h. Packaging requirements (see 5.1)

6.2 First article. When first article inspection (see 4.2) is required, the contracting officer should provide specific guidance to offerors whether the item(s) should be first article sample, a first production item, or a standard production item from the contractor's current inventory, and the number of items to be tested as specified in 4.3. Invitations for bids should provide that the Government reserves the right to waive the requirement for samples for first article inspection to those bidders offering a product which has been previously acquired or tested by the Government and that bidders offering such products, who wish to rely on such production or test, must furnish evidence with the bid that prior Government approval is presently appropriate for pending contract. Bidders should not alternate submit bids unless specifically requested to do so in the solicitation.

6.3 Shelf life. This specification covers items where shelf life is a consideration. Specific shelf-life requirements should be specified in the contract or purchase order. The shelf-life codes are contained in the Federal Logistics Information System Total Item Record. Additive information for shelf-life management may be obtained from DoD 4140.27-M Shelf-life Management Manual, or the designated shelf-life Points of Contact (POC). The POC should be contacted in the following order: (1) the Inventory Control Points (ICPs), and (2) the DoD Service and Agency administrators for the DoD Shelf-life Program. Appropriate POCs for the DoD Shelf-Life Program can be contacted through the DoD Shelf-Life Management website: <http://shelflife.hq.dla.mil/>.

6.4 Water resistant treatment. The water resistant treatment consists of the co-application of an emulsified fluorocarbon and a modified melamine hydrophobe type of resistant. Approval of such components and combinations is the responsibility of the U.S. Army Natick Research, Development, and Engineering Center, Natick, MA 01760-5014, and is based on more extensive tests, including those for toxicity, which are not set forth in this document. Because of the time necessary to conduct full evaluation (approximately 6 months), only those chemical treatment already approved and so listed in the invitation for bids or requests for proposal shall be considered acceptable for the related procurement.

List of approved water resistant compounds:

FC-236 A/B – a two part combination water and oil repellent chemical for leather. Part A is a water soluble fluorochemical. Part B is a fluorochemical resin emulsion employing MIBK as a carrier solvent.

FC-3560/FC-3567 – a two part combination water and oil repellent chemical for leather. FC-3560 is a water soluble fluorochemical. FC-3567 is a fluorochemical resin emulsion employing a non-flammable emulsifier (1%) containing no methyl isobutyl ketone.

NOTE: MIBK has been shown to be a respiratory irritant and carries an OSHA standard for air of 100 PPM, time weighted average (TWA). Care must be taken by leather processors to adhere to this standard when using FC-236 A/B.

Supplier for the above compounds: 3-M Company

6.5 Suggested Sources.

Buckle:

Albest Metal Stamping Corp.
One Kent Avenue
Brooklyn, NY 11211-1014
Part #BB340-10BD

Tape:

Lea & Sachs, Inc.
1267 Rand Road
Des Plaines, IL 60016

D-Ring:
Albest Metal Stamping Corp.
One Kent Avenue
Brooklyn, NY 11211-1014
Part # WD 6X6-14 DB

Snaphook:
Albest Metal Stamping Corp.
One Kent Avenue
Brooklyn, NY 11211-1014
Albest Part # WHO207-24BD

Approved Water Resistant compounds (FC-3564, FC-236 A/B, FC-3560/3567, and FX-3573):
3M Corporation, Protective Division
St. Paul, MN 55144-1000

6.6 Subject Term (key word) listing.

Gloves
Leather
Water resistant

MILITARY INTERESTS:

Custodians

Navy – MC

Review Activities

Navy – MC

User Activities

Navy – MC

PREPARING ACTIVITY:

Navy – MC

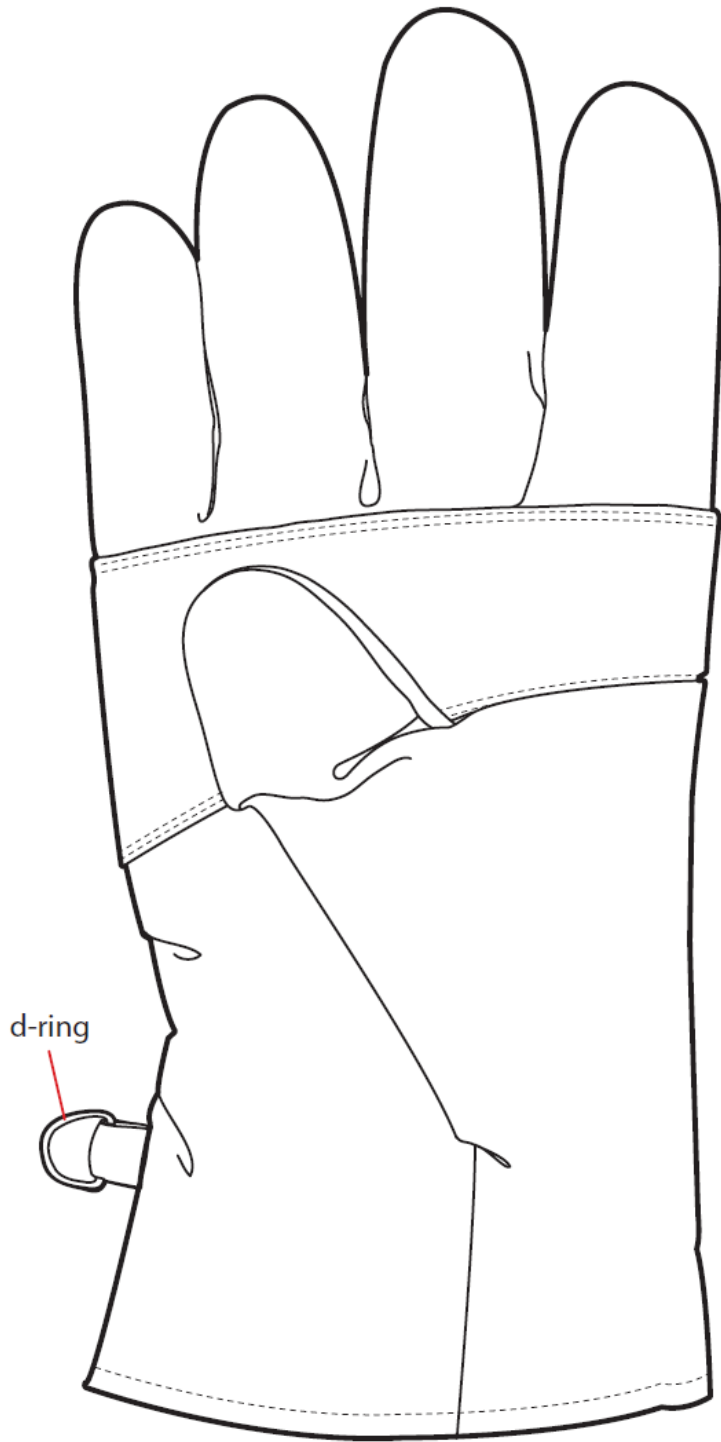


FIGURE 1. GLOVE, PALM VIEW

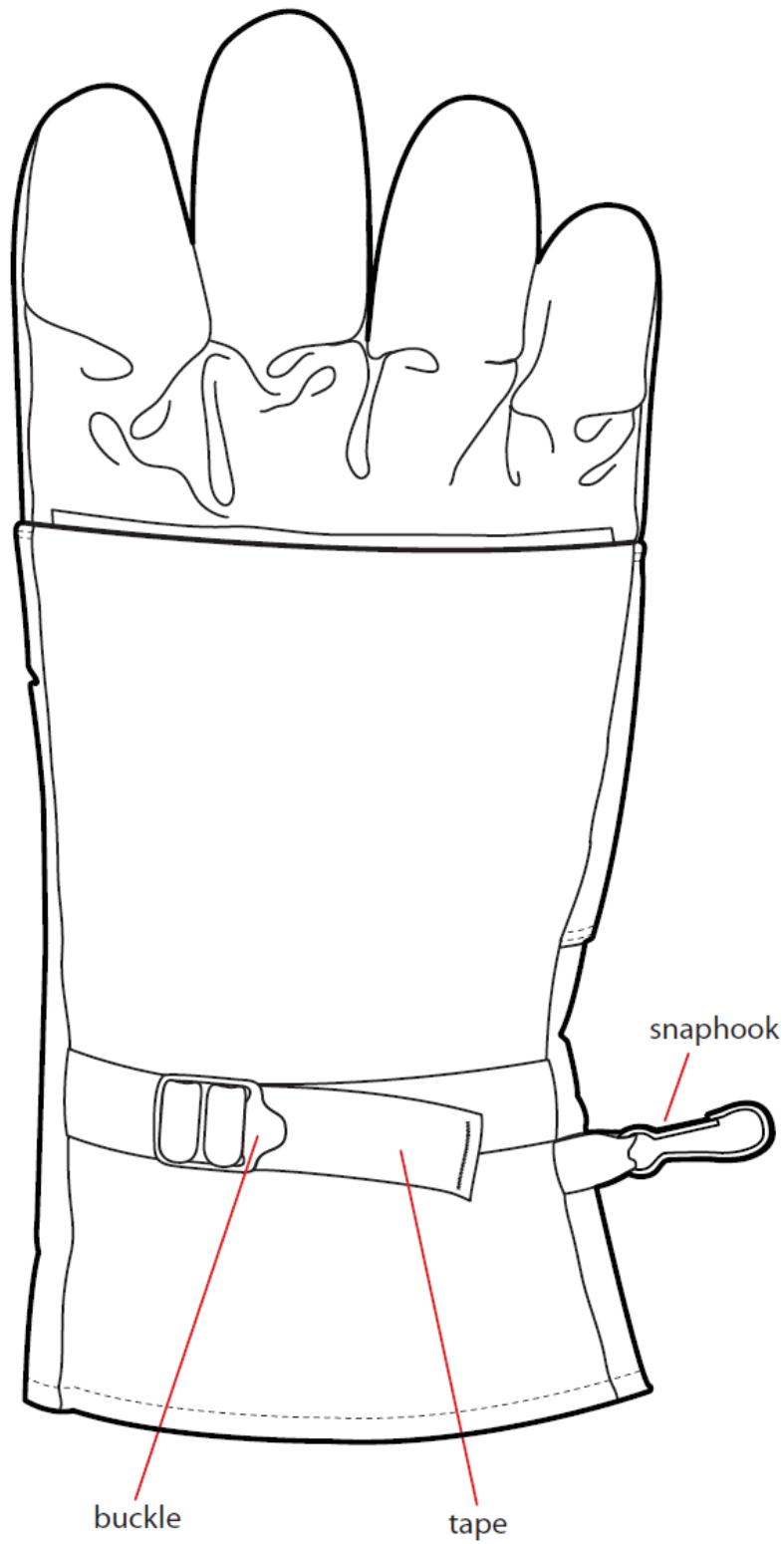


FIGURE 2. GLOVE, BACK VIEW

Note: Snaphook shall be used on corresponding glove to attach to D-ring when not in use