

MIL-C-14635A

26 November 1975

SUPERSEDING

MIL-C-14635

25 August 1967

## MILITARY SPECIFICATION

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### COVER, PERSONNEL IDENTIFICATION TAG

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

#### 1. SCOPE

1.1 Scope. This specification covers one type and size of plastic (plasticized polyvinyl chloride) cover sized to fit over the standard personnel identification tag. The cover can be irreversibly marked with the individual's spectacle prescription.

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#### 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

- PPP-B-636 - Boxes, Shipping, Fiberboard
- PPP-B-676 - Boxes, Setup

#### STANDARDS

##### FEDERAL

- FED-STD-356 - Commercial Packaging of Supplies and Equipment
- FED-STD-601 - Rubber: Sampling and Testing

FSC 8465

MILITARY

- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
- MIL-STD-129 - Marking for Shipment and Storage

DRAWING

U.S. ARMY NATICK DEVELOPMENT CENTER

- 4-1-481 - Cover, Identification Tag, Personnel

(A miniature copy of Drawing 4-1-481, identified as figure 1, is attached for information purposes only.)

(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 documents form a part of this specification to the extent specified herein. Unless a specific issue is identified, the issue in effect on date of invitation for bids or request for proposal shall apply:

American Society for Testing and Materials Standards

D 568 - Flammability of Flexible Plastics

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.)

(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 Standard sample. Unless otherwise specified (see 6.2), a sample of the finished cover shall be furnished the supplier for matching the shade of flesh color and finish of the cover only.

3.2 First article. When specified (see 6.2), the supplier shall furnish samples for first article inspection and approval (see 4.3, 6.2 and 6.4).

3.3 Materials. Materials shall conform to the referenced specifications and the requirements specified herein.

- \* 3.3.1 Plasticized polyvinyl chloride. The plasticized polyvinyl chloride composition shall be non-toxic (see 3.5) and self-extinguishing, when tested as specified in 4.4.1.1. When tested as specified in 4.4.1.1, the material (after curing) shall be soft flexible elastomeric plastic falling within the requirements specified in table I.

TABLE I. Plasticized polyvinyl chloride

	Minimum	Maximum
Tensile strength	2300 p.s.i	2550 p.s.i.
Elongation	335 percent	450 percent
Tensile stress (100 percent)	725 p.s.i.	875 p.s.i.
Tear resistance	225 p.i. (pounds per inch of thickness)	300 p.i.

3.3.1.1 Color. After curing, the polyvinyl chloride shall be flesh colored approximating the shade of the standard sample (see 3.1).

- \* 3.4 Construction. Tag covers shall be molded in accordance with the details and dimensions of Drawing 4-1-481. All lettering on the faces of the cover shall be raised, shall be legible in the end product, and shall be as shown on Drawing 4-1-481 (see 6.3). All excess material shall be removed in final processing. The finished cover shall be capable of being irreversibly marked with a standard Government ball point pen. It is essential that heavy pressure be applied when marking with the ball point pen. Marking shall remain legible after washing when tested as specified in 4.4.3. At the option of the supplier, core pins may be used to support the spacer plates in the mold, provided the core pin holes do not interfere with the prescription marking areas on the covers.

3.5 Health hazard. The finished covers shall be non-toxic. When the plastic material is tested as specified in 4.4.1.1, there shall be no evidence of inflammation or other adverse skin reaction on the human test subjects. The supplier shall provide for the performance of the test by, or under the supervision of a doctor of medicine.

3.5.1 Patch test certificate. A certificate or certificates for each lot of tag covers being delivered shall be forwarded to the procuring activity by the supplier to the effect that the covers are non-toxic and meet the requirements of 3.5. The certificate(s) shall contain a record of the patch test performed, a listing of the test subjects by name and the results of each 24 hour observation made for each subject. The record of the test and

the observation shall be certified by the doctor of medicine who performed or supervised the testing. In addition, the certificate shall include the supplier's statement that the samples used for testing are from the same batch of polyvinyl chloride used for molding the tag covers. When inspection is performed at the source, the supplier shall furnish a copy of the certificate(s) to the cognizant Government inspector.

3.6 Finish. The finish of the covers shall match the finish on the standard sample (see 3.1).

- \* 3.7 Workmanship. The covers shall conform to the quality of product established by this specification, and the occurrence of defects shall not exceed the applicable acceptable quality levels.

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

1. First article inspection (see 4.3).
2. Quality conformance inspection (see 4.4).

- \* 4.3 First article inspection. When required (see 6.2), the first article submitted in accordance with 3.2 shall be inspected as specified in 4.4.2.1.1, 4.4.2.1.2 and 4.4.3.1 for compliance with design, construction, workmanship, dimensional and marking requirements.

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

4.4.1 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.

\* 4.4.1.1 Testing of components. The plasticized polyvinyl chloride shall be tested for the characteristics listed in table II. The lot size for the plasticized polyvinyl chloride shall be expressed in units of one pound. Except for toxicity, the sample unit shall be four pieces and each piece shall be 6 inches by 6 inches by 0.025 inch and the sample size shall be as follows:

<u>Lot size (pounds)</u>	<u>Sample size</u>
800 or less	2
801 to 22,000	3
22,001 and over	5

Except for toxicity and the self-extinguishing test, the results shall be expressed as the lot average. All test reports shall contain the individual values utilized in expressing the final results. There shall be no failure to meet the specified requirements.

TABLE II. Component testing

<u>Characteristic</u>	<u>Requirement paragraph</u>	<u>Test method</u>
Self-extinguishing test	3.3.1	<u>1/</u>
Tensile strength	3.3.1	4111 <u>2/</u>
Percent elongation	3.3.1	4121 <u>2/</u>
Tensile stress	3.3.1	4131 <u>2/</u>
Tear resistance	3.3.1	4211 <u>2/</u>
Toxicity test	3.5	<u>3/</u>

1/ Self-extinguishing test. Each batch of polyvinyl chloride shall be tested in accordance with ASTM D 568. If the flame is extinguished before reaching the gage mark, report the material as "self-extinguishing by this test". The results shall be reported as pass or fail.

2/ Testing shall be in accordance with FED-STD-601.

3/ Toxicity test. One half-inch squares 0.08 inch thick of each batch of plasticized polyvinyl chloride material used to fabricate the covers shall be applied to the skin of at least 10 human test subjects by adhesive plaster for 72 hours. The skin test areas shall be examined every 24 hours for evidence of inflammation or other adverse skin reactions. If the material unduly irritates the skin, the test patch shall be removed immediately.

4.4.1.1.1 Certification. Polyvinyl chloride may be accepted on the basis of a supplier's certification of compliance for material identification and self-extinguishing requirements specified in 3.3.1. A certification of compliance is acceptable for the toxicity requirements specified in 3.5, provided the test data specified in 3.5.1 are attached. Certification shall be required for each batch of material used.

\* 4.4.2 Inspection of the end item.

4.4.2.1 Examination of the end item. The end item shall be examined for visual and dimensional defects, for count of covers and for preparation for delivery defects in accordance with the classification of defects set forth in 4.4.2.1.1 through 4.4.2.1.4. The inspection levels and the acceptable quality levels (AQLs) shall be as specified in 4.4.2.1.5. The sample unit for examination in 4.4.2.1.1 and 4.4.2.1.2 shall be one completely fabricated cover.

4.4.2.1.1 Visual examination of the covers. The finished covers shall be examined for defects listed in table III.

TABLE III. Visual examination

<u>Examine</u>	<u>Defect</u>
Design and construction	Varies from design or construction shown on specified drawing.
Workmanship	Not clean. Objectionable odor. Edges not smooth, i.e., rough edges. Details of lettering missing or not completely molded. Excessive flash not removed. Hole missing. Surfaces contain voids, pockets or any other defect clearly noticeable.
Finish	Not finished as specified, i.e., does not match the finish and color of the standard sample.

4.4.2.1.2 Examination for defects in dimensions. Any dimension not within the specified tolerance shall be classified as a defect.

4.4.2.1.3 Examination for count of covers in interior containers. Covers packaged for shipment shall be examined to determine conformance with package markings and specified quantity. The sample unit for this examination shall be one box (interior package). Any box containing less than the specified or marked quantity of covers shall be classified as a defect.

4.4.2.1.4 Examination of preparation for delivery requirements. An examination shall be made to determine that packaging, packing and marking comply with section 5 requirements. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully prepared for delivery with the exception that it need not be closed. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot size shall be the number of shipping containers in the end item inspection lot.

<u>Examine</u>	<u>Defect</u>
Marking (exterior and interior)	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application.
Materials	Any component missing. Any component damaged, affecting serviceability.
Workmanship	Inadequate application of components, such as, incomplete closure of container flaps, improper taping, loose strapping. Bulged or distorted container.
Content	Number of interior packages is more or less than required.

4.4.2.1.5 Inspection levels and AQLs. The inspection levels and the AQLs expressed in defects per hundred units shall be as follows:

<u>Examination paragraph</u>	<u>Inspection level</u>	<u>AQL</u>
4.4.2.1.1	I	4.0
4.4.2.1.2	S-3	2.5
4.4.2.1.3	S-1	4.0
4.4.2.1.4	S-2	2.5

4.4.3 Testing of the end item. Testing of the completely fabricated cover shall be performed in accordance with 4.4.3.1 for the marking test characteristic specified in 3.4. The sample unit shall be one cover. The inspection level shall be S-1 and the AQL shall be 6.5 defects per hundred units. The requirement is applicable to the individual unit with one determination per sample unit. The results shall be reported as pass or fail.

4.4.3.1 Marking test. The finished cover shall be marked by applying heavy pressure with the standard Government ball point pen and allowed to dry for 10 minutes. The cover shall then be washed by hand with detergent and water for 1 minute, rinsed and dried. The marking shall then be examined to determine compliance with the requirements of 3.4.

## 5. PREPARATION FOR DELIVERY

- \* 5.1 Packaging. Packaging shall be level A or commercial, as specified (see 6.2).
  - \* 5.1.1 Level A. Two hundred covers shall be arranged on edge in two rows of one hundred each and packaged in a snug-fitting set-up paperboard box conforming to type I, variety 1, class A, style 1, 2 or 3 of PPP-B-676. A divider made of the same paperboard as the body of the box shall be positioned vertically between the rows.
  - \* 5.1.2 Commercial. Covers shall be packaged in accordance with FED-STD-356.
- \* 5.2 Packing. Packing shall be level A, B or commercial, as specified (see 6.2).
  - \* 5.2.1 Level A. Seventy two hundred covers (36 intermediate packages), 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 in accordance with method III, waterproofed in accordance with method V and reinforced as specified in the appendix of the container specification.
  - \* 5.2.2 Level B. Seventy two hundred covers (36 intermediate packages), packaged as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC, type CF (variety DW) or type SF, class domestic of PPP-B-636. Each shipping container shall be closed in accordance with method II as specified in the appendix of PPP-B-636.
    - \* 5.2.2.1 When specified (see 6.2), the shipping container shall be grade V3c, V3s, or V4s, fabricated and closed in accordance with method III as specified in the appendix of PPP-B-636.



\* 5.2.3 Commercial. Covers, packaged as specified in 5.1, shall be packed in accordance with FED-STD-356.

\* 5.3 Marking.

5.3.1 Military (levels A and B). In addition to any special marking required by the contract or order, shipping containers shall be marked in accordance with MIL-STD-129.

5.3.2 Commercial. In addition to any special marking required by the contract or order, shipping containers shall be marked in accordance with FED-STD-356.

6. NOTES

6.1 Intended use. The tag cover is intended to be fitted over one standard identification tag and be irreversibly marked with the individual's spectacle prescription.

\* 6.2 Ordering data. Procurement documents should specify the following:

- (a) Title, number and date of this specification.
- (b) When a standard sample will not be furnished (see 3.1).
- (c) When a first article is required (see 3.2).
- (d) Selection of applicable levels of packaging and packing (see 5.1 and 5.2).
- (e) When weather resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).

\* 6.3 Raised lettering (see 3.4). Lettering on the cover raised 0.010 inch (with a tolerance of + 0.005, - 0.000 inch) is suggested in molding of the tag covers (see Drawing 4-1-481).

\* 6.4 First article. When a first article is required, it shall be inspected and approved under the appropriate provisions of ASPR 7-104.55. The first article should be a preproduction sample. The first article should consist of one finished cover from each cavity in the mold. The contracting officer should include specific instructions in all procurement instruments regarding arrangements for examination, test and approval of the first article.

\* 6.5 The margins of this specification are marked with an asterisk to indicate where changes (additions, corrections, modifications, 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 irrespective of the marginal notations and relationship to the last previous issue.

MIL-C-14635A

**Custodians:**

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**DOCUMENT IDENTIFIER AND TITLE**

MIL-C-14635A - COVER, PERSONNEL IDENTIFICATION TAG

**NAME OF ORGANIZATION AND ADDRESS**

**CONTRACT NUMBER**

**MATERIAL PROCURED UNDER A**

DIRECT GOVERNMENT CONTRACT     SUBCONTRACT

**1. HAS ANY PART OF THE DOCUMENT CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE?**

A. GIVE PARAGRAPH NUMBER AND WORDING.

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