

MIL-L-1522C

14 May 1968

SUPERSEDING

MIL-L-1522B

12 February 1965

MILITARY SPECIFICATION

LEASH, DOG, COTTON WEBBING, LONGE TYPE

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

1. SCOPE

1.1 This specification covers one type of dog leash with swivel eye snaphook.

* 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

V-T-285	- Thread, Polyester
FF-R-556	- Rivets, Solid, Small; Rivets, Split, Small; Rivets, Tubular, Small; and Caps, Rivets; General Purpose
QQ-W-405	- Wire, Steel, Carbon and Alloy, (For Cold Heading and Cold Forging)
UU-P-268	- Paper, Kraft, Untreated, Wrapping
DDD-L-20	- Label; for Clothing, Equipage and Tentage, (General Use)
PPP-B-636	- Box, Fiberboard
PPP-F-320	- Fiberboard, Corrugated and Solid, Sheet Stock (Container Grade) and Cut Shapes

MILITARY

MIL-F-495	- Finish, Chemical, Black, for Copper Alloys
MIL-W-530	- Webbing and Tape, Textile, Cotton, General Purpose, Natural or in Colors
MIL-C-13924	- Coating, Oxide, Black, for Ferrous Metals
MIL-S-43403	- Snaphooks, 3/4-inch Swivel Eye, With Pivot Closure

FSC 3770

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-147 - Palletized and Containerized Unit Loads
40" and 48" 4-Way (Partial) Pallet Skids
Runners, or Pallet-Type Base

DRAWING

ARMY NATICK LABORATORIES

2-4-59 - Leash, Dog, Cotton Webbing, Longe Type

(Figure 1 is a miniature reproduction of Drawing No. 2-4-59 and is attached for information 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.)

3. REQUIREMENTS

* 3.1 First article.- Unless otherwise specified (see 6.2), before production is commenced, a sample leash covered by 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 applicable 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 Materials.-

3.2.1 Webbing, textile, cotton.- Cotton webbing shall be olive drab shade No. 7 and shall conform to type III, class 4, 5/8-inch width of MIL-W-530.

- * 3.2.2 Thread, polyester.- Thread shall conform to type I or II, class 1, sub-class A, shade S-1 (Cable No. 66022), size FF of V-T-285. The dyed thread shall show fastness to weathering equal to or better than the standard shade sample. When no standard shade sample is available the dyed thread shall show good fastness to weathering.
- * 3.2.3 Snaphook, swivel eye with pivot closure.- The snaphook shall conform to type I of MIL-S-43403.
- * 3.2.4 Rivets and caps.- The tubular rivets shall conform to type XII, class 1, grade E or F, 9/64 inch nominal diameter of FF-R-556, except that grade E rivets and caps shall be fabricated from a low-carbon steel No. 1006 to 1012 with wire annealed in process in accordance with QQ-W-405. Caps required for grade F rivet shall conform to type II cap of FF-R-556. Grade E rivets and caps shall have a black oxide coating conforming to class 1 of MIL-C-13924. Grade F rivets and caps shall have a black chemical finish as specified in MIL-F-495. The length of the rivets shall be such as to provide a secure clinch.
- * 3.3 Construction.- Construction shall conform to the drawing listed in section 2 and as specified herein. The leash shall be fabricated from one piece of webbing.
- * 3.3.1 Stitching, machine.- All stitching shall conform to type 301 of Fed. Std. No. 751 with 6 to 8 stitches per inch. Thread breaks shall be overstitched not less than 1-inch. Thread tension shall be maintained so that there will be no loose stitching. All thread ends shall be trimmed. Any design of stitching cited in this specification may be performed with an automatic machine provided at least 3 or more tying, overlapping or back stitches are used to secure the ends of stitching.
- * 3.3.1.1 Stitching ends.- Stitching at the ends shall be overstitched not less than 1 inch on stitch type 301, except where ends are turned under in a hem, held down by other stitching or where stitching is performed automatically. When stitch patterns such as box, box with cross-stitch, "W" stitching or straight line tacking are performed automatically, at least 3 or more tying, overlapping or back-stitches shall be used to secure the ends of stitching.
- * 3.3.2 Webbing ends.- One half inch of the ends of the webbing shall be resin coated or impregnated to prevent unraveling (see 6.3).
- * 3.4 Marking.- All marking shall conform to DDD-L-20. The identification marking shall conform to type IV, class 5 and shall be applied in the location shown on the drawing. The letters "US" shall be applied in the size characters and in the location shown on the drawing and shall conform to type IV, class 9. Fastness shall be as specified for class 5.

- * 3.5 Workmanship.- Webbing shall be clean and shall not have holes, cuts, frayed or scalloped edges. All metal components shall be free of burrs or sharp edges.

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 for the defects listed in table I and dimensions specified.
- * 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.- 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.
- * 4.3.2 End product inspection.- The lot shall consist of all completely fabricated leashes offered for inspection at one time. The sample unit shall be one completely fabricated leash. The inspection level and acceptable quality levels (AQL's) shall be as specified in 4.3.2.3.
- * 4.3.2.1 Visual examination.- The completely fabricated leash shall be examined for defects in table I.

* TABLE I.- Classification of defects for visual characteristics

Examine	Defect	Classification	
		Major	Minor
Webbing	Any hole or cut	X	
	Frayed or scalloped edges		X
	Ends not coated or impregnated as required	X	

* TABLE I.- Classification of defects for visual characteristics (cont'd)

Examine	Defect	Classification	
		Major	Minor
Snaphook and rivets	Broken, malformed, burrs or sharp edges	X	
Stitch type	Wrong stitch type	X	
Stitch tension	Loose, resulting in an exposed bobbin or top thread		X
Stitches per inch	Less than minimum specified:		
	- one stitch		X
	- two or more	X	
	One or more stitches in excess of maximum specified	X	
Boxstitching	One or more required rows of stitching omitted (except on boxstitching)	X	
	Incomplete:		
	- one row of stitching omitted		X
	- two or more rows of stitching omitted	X	
	Any boxstitching less than specified length by more than 1/8 inch		X
Thread breaks	Overstitched less than 1-inch		X
Component and assembly	Any component part not fabricated of applicable referenced material	X	
Construction details			
Body	Webbing not continuous, i.e., spliced	X	
	Edges of folded ends uneven by more than 1/16-inch		X
	Ends improperly folded, i.e., both ends folded on one side of leash		X
Hardware	One or both rivets not capped	X	
	Capped end not on side of body specified on Drawing 2-4-59		X

* TABLE I.- Classification of defects for visual characteristics (cont'd)

Examine	Defect	Classification	
		Major	Minor
Construction details (cont'd)			
Hardware (cont'd)	One or both rivets set off center line of body by more than 1/8-inch	X	
	Spring portion of snap loose or defective, causing spring to jam	X	
	Body of snap fails to rotate freely	X	
Marking	Omitted, incorrect, illegible, misplaced or size characters not as specified		X

* 4.3.2.2 Dimensional examination.- Any dimension not within the specified requirements shall be classified as a defect.

* 4.3.2.3 Inspection levels and AQL's.- The inspection level and AQL's expressed in terms of defects per hundred units shall be as follows:

<u>Examination</u>	<u>Inspection level</u>	<u>AQL's</u>
For defects applicable to table I	II	2.5 Major 6.5 Totals, major, and minor defect combined
For defects applicable to 4.3.2.2	S-3	6.5 One class

* 4.3.3 Examination of preparation for delivery requirements.- An examination shall be made to determine that packaging, packing and marking requirements are in compliance with section 5 of this specification. Defects shall be scored in accordance with table II. The sample unit shall be one shipping container fully prepared for delivery. The lot shall be the number of shipping containers offered for delivery at one time. The inspection level shall be S-2 and the AQL, expressed in terms of defects per hundred units, shall be 2.5.

* TABLE II.- Examination of preparation for delivery

<u>Examine</u>	<u>Defects</u>
Marking	Omitted, incorrect, illegible, of improper size, location, sequence or method of application
Workmanship	Inadequate application of components, such as: contents of container not completely covered top or bottom
Contents	Content is more or less than required

- * 4.3.4 Examination of shipping containers.-- When shipping containers are required to be in accordance with PPP-B-636, examination for closure, water-proofing and reinforcing shall be made in accordance with the appendix of that specification.

5. PREPARATION FOR DELIVERY

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

- * 5.1.1 Level A.-- Each leash shall be tightly coiled starting with the snap hook end. The coiled leash shall be secured from unwinding and slipping by tying with cotton tape or twine.

5.1.2 Level C.-- Leashes shall be packaged to afford adequate protection against deterioration and damage during shipment from the 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.-- Fifty leashes, packaged as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to grade V2s, style RSC-L of PPP-B-636. The inside of each fiberboard shipping container shall be fitted with a taped liner conforming to type CF, variety DW, grade V15c of PPP-F-320. Each shipping container shall have the contents completely covered on the top and bottom with a sheet of 30-pound minimum basis weight kraft paper conforming to grade B of UU-P-268. Each shipping container shall be closed, waterproofed, and reinforced with flat strapping or tape banding in accordance with the appendix of the container specification.

* 5.2.2 Level B.- Fifty leashes, packaged as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC-L, type CF, variety SW or SF, class domestic, grade 275 of PPP-B-636. The inside of each fiberboard shipping container shall be fitted with a taped liner conforming to type CF, class domestic, variety SW, grade 275 or PPP-B-636. Each fiberboard shipping container shall have the contents completely covered on the top and bottom with a sheet of 30-pound minimum basis weight kraft paper conforming to grade B of UU-P-268. Each fiberboard shipping container shall be closed in accordance with method II as specified in the appendix of the container specification.

* 5.2.2.1 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 box specification. The shipping container material may also be grade V4s of PPP-F-320.

5.2.3 Level C.- Leashes 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 Palletization.- Leashes packed as specified shall be palletized in accordance with load type I of MIL-STD-147 except that for overseas shipment the over-all height of the load shall not exceed 43 inches. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding means K and L. Container patterns shall be in accordance with the appendix of MIL-STD-147. Interlocking of loads shall be effected by reversing the pattern of each course. If the container is of a size which does not conform to any of the container patterns specified in MIL-STD-147, the container pattern used shall be approved by the contracting officer.

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

6. NOTES

6.1 Intended use.- The leash covered by this specification is used in the training of dogs.

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

- (a) Title, number and date of this specification.
- (b) Stock number.
- (c) When first article (preproduction sample) is not required (see 3.1).

(d) Selection of applicable levels of packaging and packing (see 5.1 and 5.2).

(e) When weather resistant fiberboard containers are required for level B packing (see 5.2.2.1).

* 6.3 For coating or impregnating the ends of the webbing, cellulose acetate or cellulose acetate butyrate will meet the requirements of 3.3.2.

* 6.4 Asterisks.- The margins of this specification 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 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.

Custodians:

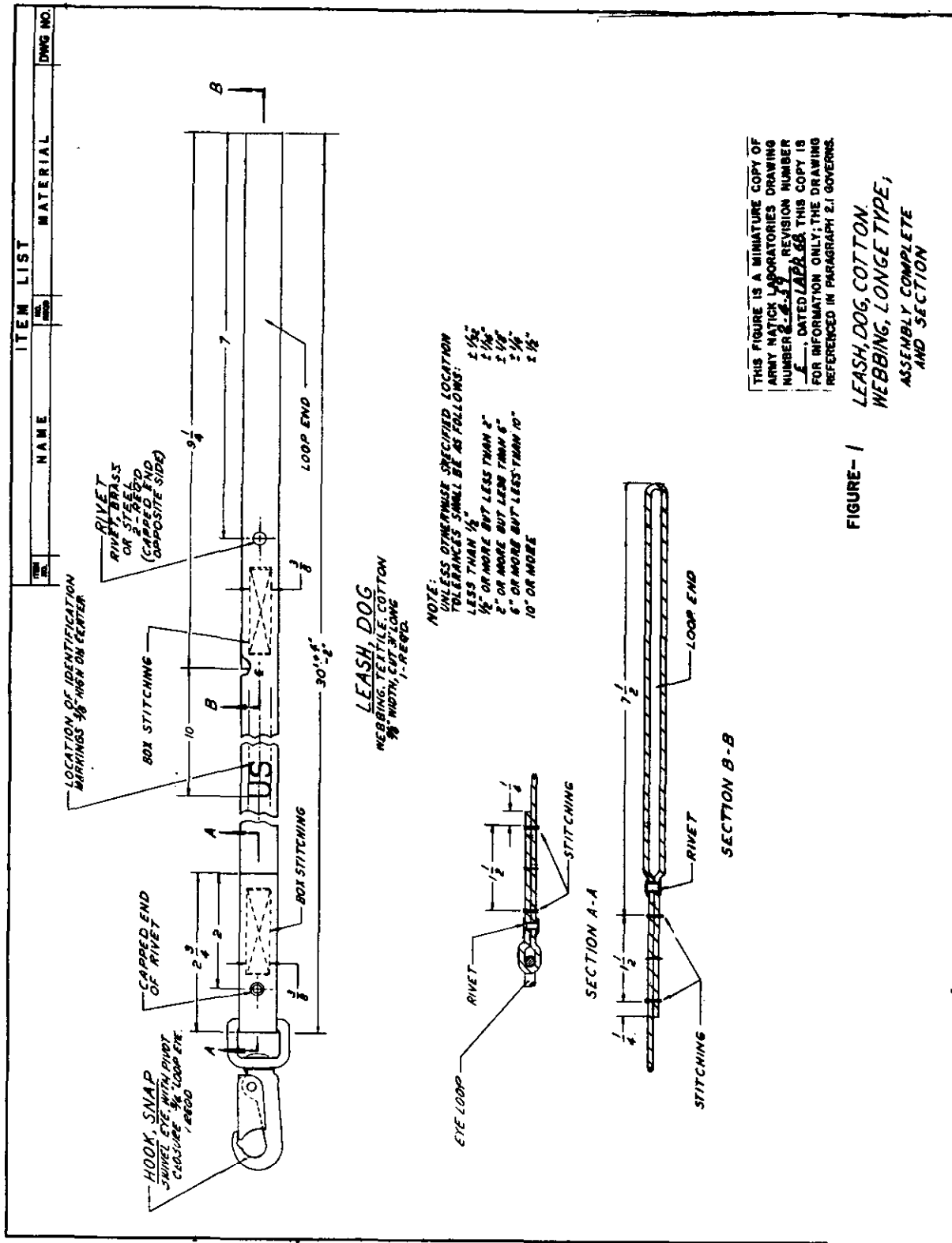
Army - GL
Air Force - 84

Preparing activity:

Army - GL
Project No. 3770-0077

Review activities:

Army - MD, ME
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SPECIFICATION ANALYSIS SHEET		Form Approved Budget Bureau No. 22-R255
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. Comments and suggestions submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or serve to amend contractual requirements.		
SPECIFICATION Leash, Dog, Cotton Webbing, Longe Type - MIL-L-1522C		
ORGANIZATION		
CITY AND STATE	CONTRACT NUMBER	
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 - Optional)		DATE

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