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MIL-C-44048G  
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 SUPERSEDING  
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## MILITARY SPECIFICATION

### COATS, CAMOUFLAGE PATTERN, COMBAT

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

#### 1. SCOPE

1.1 Scope. This specification covers camouflage pattern, single-breasted combat coats.

1.2 Classification. The coat shall be of the following types and sizes as specified (see 6.2):

Type I	-	Woodland camouflage pattern cotton/nylon twill cloth
Type II	-	Deleted (see 6.8)
Type III	-	Woodland camouflage pattern, ripstop cotton cloth
Type IV	-	Deleted (see 6.8)
Type V	-	Deleted (see 6.8)
Type VI	-	Woodland camouflage pattern, nylon/cotton ripstop
Type VII	-	Desert camouflage pattern, nylon/cotton ripstop

<p>Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Defense Personnel Support Center, Clothing and Textiles Directorate, Attn: DPSC-FQSD, 2800 South 20th Street, Philadelphia, PA 19145-5099, by using the Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.</p>
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AMSC N/A

FSC 8415

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Schedule of Sizes

<u>X-Small</u>	<u>Small</u>	<u>Medium</u>	<u>Large</u>	<u>X-Large</u>
	XX-Short	XX-Short		
X-Short	X-Short	X-Short	X-Short	
Short	Short	Short	Short	
Regular	Regular	Regular	Regular	Regular
	Long	Long	Long	Long
	X-Long	X-Long	X-Long	

## 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 shall be 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).

SPECIFICATIONS

## FEDERAL

- A-A-203 - Paper, Kraft, Untreated
- A-A-50198 - Thread, Gimp, Cotton, Buttonhole
- A-A-50199 - Thread, Polyester Core, Cotton-, or Polyester-Covered
- A-A-52094 - Thread, Cotton
- V-B-871 - Button, Sewing Hold, and Button, Staple, (Plastic)
- V-T-285 - Thread, Polyester
- DDD-L-20 - Label: For Clothing, Equipage and Tentage (General Use)
- PPP-B-636 - Boxes, Shipping, Fiberboard

## MILITARY

- MIL-L-35078 - Loads, Unit: Preparation of Semiperishable Subsistence Items; Clothing, Personal Equipment and Equipage; General Specification For
- MIL-C-43468 - Cloth, Camouflage Pattern, Wind Resistant Poplin, Cotton
- MIL-C-44031 - Cloth, Camouflage Pattern: Woodland, Cotton and Nylon
- MIL-C-44296 - Cloth, Fusibles
- MIL-C-44411 - Insect Repellent, Permethrin
- MIL-C-44436 - Cloth, Camouflage Pattern, Wind Resistant Poplin, Nylon/Cotton Blend

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STANDARDS

FEDERAL

- FED-STD-595 - Colors Used in Government Procurement
- FED-STD-751 - Stitches, Seams, and Stitchings

MILITARY

- MIL-STD-105 - Sampling Procedures and Table for Inspection by Attributes
- MIL-STD-129 - Marking for Shipment and Storage
- MIL-STD-147 - Palletized Unit Loads
- MIL-STD-731 - Quality of Wood Members for Containers and Pallets
- MIL-STD-2073-1 DoD Material Procedures for Development and Application of Requirements

(Unless otherwise indicated, copies of Federal and military specifications, standards and handbooks are available from the Standardization Documents Order Desk, Bldg. 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.)

2.2 Non-Government publications. The following documents form a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DoD-adopted shall be those listed in the issue of the DODISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of the documents cited in the solicitation (see 6.2).

AMERICAN ASSOCIATION OF TEXTILE CHEMISTS AND COLORISTS

- AATCC Photographic Comparative Rating of Single and Double Needle Seams (Method 88B, two photos)

(Applications for copies should be addressed to the AATCC National Headquarters, P.O. Box 12215, Research Triangle Park, NC 27709-2215.)

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

- D 3951 - Standard Practice for Commercial Packaging

(Applications for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103-1187.)

(Non-Government standards and other publications are normally available from the organizations that prepare or distribute the documents. These documents also may be available in or through libraries or other informational services.)

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2.3 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 laws and regulations unless a specific exemption has been obtained.

### 3. REQUIREMENTS

3.1 First article. When specified (see 6.2), a sample shall be subjected to first article inspection (see 6.3) in accordance with 4.3.

3.2 Samples. Samples, when furnished, are solely for guidance and information to the contractor (see 6.4). Variations from this specification may appear in the sample, in which case this specification shall govern.

3.3 Material. The use of recycled material is encouraged when practicable as long as it meets the requirements of this specification.

#### 3.3.1 Basic material

3.3.1.1 For type I coat. The basic material shall be cotton/nylon twill cloth printed in a woodland camouflage pattern conforming to class 1 of MIL-C-44031.

3.3.1.2 For type III coat. The basic material shall be cotton ripstop poplin cloth printed in a woodland camouflage pattern conforming to type II of MIL-C-43468.

3.3.1.3 For type VI coat. The basic material shall be nylon/cotton ripstop printed in a woodland camouflage pattern conforming to class 1 of MIL-C-44436.

3.3.1.4 For type VII coat. The basic material shall be nylon/cotton ripstop printed in a desert camouflage pattern conforming to class 4 of MIL-C-44436.

3.3.2 Pencil pocket. The cloth for the pencil pocket shall be camouflage pattern basic material, ground shade cloth, or printed seconds cloth. Ground shade cloth shall be dyed in conformance with class 1 of MIL-C-44031 for type I coats, type III of MIL-C-43468 for type III coats, class 1 of MIL-C-44436 for type VI coats and class 4 of MIL-C-44436 for type VII coats. Ground shade cloth shall meet the physical, mechanical, and dimensional requirements of the respective finished fabric. Printed seconds shall be cloth which has been rejected only for defects pertaining to color, infrared reflectance, or camouflage print patterns, cited in MIL-C-44031 for type I coats, MIL-C-43468 for type III coats, and MIL-C-44436 for types VI and VII coats.

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3.3.3 Cloth, fusible, interlining collar, cuffs, and pocket flaps. The material for interlining the collar, cuffs, and pocket flaps of the type I, III and VI coats shall conform to bonding strength and type V, class 3, adhesive dot application, style B of MIL-C-44296.

3.3.3.1 Fusing press operating procedure and conditions. A single layer of fusible interlining shall be fused to a single layer of basic material on a dry, electrically-heated fusing press which has the capacity of controlling and retaining pressure, dwell time, and temperature for a minimum of 8 hours. Pair or sandwich fusing, which can create differential shrinkage, and uneven bonding shall not be permitted. A steam sourced fusing press shall not be allowed for any initial fusing operations.

For optimum results, the fusible material manufacturer's recommendations for fusing dwell time, pressure, and temperature, based upon the fusing equipment used and the basic material being fused, shall be utilized. The temperature used in fusing shall not exceed 340°F, and shall not cause an objectionable color change or staining of the basic fabric. Basic preproduction and production maintenance procedures, including a fusing press information chart, shall be required to ensure proper fusing press performance relative to temperature control, unevenness in pressure head or roller content, dwell time, cleanliness, and bonding strength.

The fusing process shall be controlled to ensure that the fused plies of material show no sign of bubbling or delamination initially or after three launderings. Results of the production maintenance procedures shall be recorded on Figure 2.

#### 3.3.4 Thread and gimp

3.3.4.1 Thread. The thread shall be cotton- or polyester-covered, polyester core, type I or type II of A-A-50199, ticket Nos. 30, 2 or 3-ply; 50, 2-ply, or 70, 2-ply, except that the cotton thread conforming to type I of A-A-52094, ticket No. 70, 2-ply may be used to serge the facings and fly. As an alternate, polyester thread conforming to type IV or V of V-T-285, size 40 may be substituted for sizes 50 and 70 of A-A-50199, and size 60 may be substituted for size 30 of A-A-50199. The thread shall be dyed Camouflage Green 483 approximating Color Chip 34094 of FED-STD-595 for types I, III, and VI coats, and Khaki P-1, C.A. 66019 for type VII coats.

3.3.4.2 Gimp. The cotton gimp for reinforcing buttonholes shall conform to type I or II, size No. 8 of A-A-50198 and shall be Camouflage Green 483 approximating Color Chip 34094 of FED-STD-595 for types I, III, and VI coats, and Khaki P-1, C.A. 66019 for type VII coats. It shall conform to type I or II of A-A-50198.

3.3.4.3 Colorfastness. The dyed thread and gimp shall show fastness to laundering equal to or better than the standard sample. When no standard sample is available, the dyed thread and gimp shall show "good" fastness to laundering.

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3.3.5 Labels. Each coat shall have a class 2 size label, and either a class 15 combination-identification and instruction label, or separate class 1 identification and class 3 instruction labels conforming to type VI of DDD-L-20; also a type VIII, class 17 label/tag bar code for personal clothing items as specified in DDD-L-20 and referenced in 3.3.5.2 below. The label color for types I, III, and VI shall be Medium Green, Cable No. 70034, 70130, or 70131. The label for type VII shall be Khaki, Cable No. 70188. The labels shall show fastness to laundering. The legend for the class 2 size label shall be as specified in 3.3.5.1. The instruction, or the combination label, as applicable, shall include the following information:

Type I - Coat, Woodland Camouflage Pattern; Combat  
 Type III - Coat, Hot Weather, Woodland Camouflage Pattern;  
 Combat  
 Type VI - Coat, Hot Weather, Woodland, Camouflage Pattern; Combat  
 Type VII - Coat, Desert Camouflage Pattern; Combat

1. Wear outside of trousers
2. Adjust closures to ventilate; avoid overheating of body.
3. Machine washing. Use Permanent Press Cycle. Wash in warm water with mild detergent.
4. Hand washing. Wash in warm water using mild detergent. DO NOT WRING OR TWIST. Rinse in clean warm water.
5. DO NOT USED CHLORINE BLEACH OR STARCH.
6. Dry at low heat (Do not exceed 130°F). After drying, tumble at room temperature for 10 minutes. Remove immediately from dryer. To drip dry, remove from water and place on rust-proof hanger.

DO NOT REMOVE THIS LABEL

For type VII coats only, the following shall be included on the label:

7. This garment has been treated with a permanent insect repellent in accordance with MIL-I-44411.

3.3.5.1 Size label legend. The legend shall be printed with not less than 10 point characters. The legend for each size of coat shall contain the following information as applicable.

<u>X-Small - X-Short</u>	<u>X-Small - Short</u>	<u>X-Small - Regular</u>
Height: From 59 to 63	Height: From 63 to 67	Height: From 67 to 71
Chest: Up to 33	Chest: Up to 33	Chest: Up to 33
Stock No.	Stock No.	Stock No.
NATO Size 5060/7484	NATO Size 6070/7484	NATO Size 7080/7484

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<u>Small - XX-Short</u> Height: Up to 59 Chest: From 33 to 37 Stock No. NATO Size 4050/8494	<u>Small - X-Short</u> Height: From 59 to 63 Chest: From 33 to 37 Stock No. NATO Size 5060/8494	<u>Small - Short</u> Height: From 63 to 67 Chest: From 33 to 37 Stock No. NATO Size 6070/8494
<u>Small - Regular</u> Height: From 67 to 71 Chest: From 33 to 37 Stock No. NATO Size 7080/8494	<u>Small - Long</u> Height: From 71 to 75 Chest: From 33 to 37 Stock No. NATO Size 8090/8494	<u>Small - X-Long</u> Height: Above 75 Chest: From 33 to 37 Stock No. NATO Size 9000/8494
<u>Medium - XX-Short</u> Height: Up to 59 Chest: From 37 to 41 Stock No. NATO Size 4050/9404	<u>Medium - X-Short</u> Height: From 59 to 63 Chest: From 37 to 41 Stock No. NATO Size 5060/9404	<u>Medium - Short</u> Height: From 63 to 67 Chest: From 37 to 41 Stock No. NATO Size 6070/9404
<u>Medium - Regular</u> Height: From 67 to 71 Chest: From 37 to 41 Stock No. NATO Size 7080/9404	<u>Medium - Long</u> Height: From 71 to 75 Chest: From 37 to 41 Stock No. NATO Size 8090/9404	<u>Medium - X-Long</u> Height: Above 75 Chest: From 37 to 41 Stock No. NATO Size 9000/9404
<u>Large - X-Short</u> Height: From 59 to 63 Chest: From 41 to 45 Stock No. NATO Size 5060/0414	<u>Large - Short</u> Height: From 63 to 67 Chest: From 41 to 45 Stock No. NATO Size 6070/0414	<u>Large - Regular</u> Height: From 67 to 71 Chest: From 41 to 45 Stock No. NATO Size 7080/0414
<u>Large - Long</u> Height: From 71 to 75 Chest: From 41 to 45 Stock No. NATO Size 8090/0414	<u>Large- X-Long</u> Height: Above 75 Chest: From 41 to 45 Stock No. NATO Size 9000/0414	
<u>X-Large - Regular</u> Height: From 67 to 71 Chest: Above 45 Stock No. NATO Size 7080/1424	<u>X Large - Long</u> Height: From 71 to 75 Chest: Above 45 Stock No. NATO Size 8090/1424	

3.3.5.2 Label/tag. Each item shall be individually bar-coded with a paper tag for personal clothing items. The paper tag shall be standard bleached sulfate having a basis weight of 100 pounds. The paper used for the tags shall have a smooth finish to accept thermal transfer and direct printing. The tags shall have a hole and shall be attached adjacent to or through the top buttonhole of the left front fly of each item by a fastener, clearly legible and readable by a scanner. The bar coding element shall be a 13 digit national stock number (NSN).

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The bar code type shall be a medium to high code density and shall be located so that it is completely visible on the item when it is folded and/or packaged as specified and so that it causes no damage to the item.

3.3.6 Buttons. The buttons shall be type II, class D, style 26, 30-line, conforming to V-B-871. The buttons shall have a dull finish and the color shall be shade Olive Green BP, Cable 62016 for types I, III, and VI coats, and Tan AJ, Cable 62028 for type VII coats.

3.4 Design. The coat is a single-breasted coat style design, with collar, four-patch bellows-type pockets with flaps, a straight-cut bottom, elbow patches, suppressed waist, and cuffed sleeves.

3.5 Figures. Figures 1 and 2 are furnished for information purposes only. When inconsistencies exist between the written specification and the figures, the written specification shall govern.

3.6 Patterns. Standard patterns, which provide an allowance of 3/8 inch for single needle and 1/2 inch for shoulder, back arm, sleeve setting, and side and underarm seams, except as otherwise indicated, will be furnished by the Government. Standard patterns shall not be altered in any way and are to be used only as a guide for cutting the contractor's working patterns. The working patterns shall be identical to the Government patterns. Minor modifications are permitted where necessary when using automatic equipment. These modifications shall not alter the dimensional, serviceability, or appearance requirements cited in the specification.

3.6.1 List of pattern parts. The component parts of the coat shall be cut from materials specified in accordance with pattern parts indicated in Table I.

TABLE I. List of pattern parts

Basic material	Nomenclature	Pattern parts abbreviations <u>4/</u>	Cut parts
Cotton/nylon twill cloth, cotton rip-stop cloth, or nylon/cotton rip-stop poplin cloth	Front	FRONT	2
	Back	BACK	1
	Collar	COLLAR	2
	Collar (one piece) <u>1/</u>	CL 1P	1
	Top sleeves	TOP SLEEVE	2
	Top sleeve alternate	TOP SLV ALT	2
	Undersleeve	UNDER SLEEVE	2
	Undersleeve alternate	UND SLV ALT	2



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TABLE I. List of pattern parts (contd.)

Basic material	Nomenclature	Pattern parts abbreviations <u>4/</u>	Cut parts
Cotton/nylon twill cloth, cotton rip-stop cloth, or nylon/cotton rip-stop poplin cloth (contd.)	Breast pocket	BRST POCKET	2
	Breast pocket flap	BRS PKT FLAP	2
	Breast pocket flap tab	BR PK FL TB	2
	Breast pocket flap and tab (one piece) <u>2/</u>	BR P F T 1P	2
	Pencil pocket	PENCIL PCKT	1
	Lower pocket	LOWER PCKT	2
	Lower pocket flap	LWR PKT FLP	2
	Lower pocket flap tab	LWR PLT FL TB	2
	Lower pocket flap and tab (one piece) <u>2/</u>	LW P F T 1P	2
	Top sleeve elbow patch	TP SL ELB P	2
	Undersleeve elbow patch	UN SL ELB P	2
	Elbow patch (one piece) <u>3/</u>	ELBOW PATCH	2
	Cuff tab	CUFF TAB	2
	Cuff	CUFF	2
	Left front fly	LFT FRT FLY	1
	Top sleeve cuff	TP SLV CFF	2
	Undersleeve cuff	UND SLV CFF	2
Fusible interlining (types I, III, and VI coats only)	Collar <u>1/</u>	COLLAR FUS	1
	Breast pocket flap	BR PK FL FS	2
	Breast pocket flap and tab (one piece) <u>2/</u>	BR P F T 1P	2
	Lower pocket flap	LWR PKT FLP	2
	Lower pocket flap and tab (one piece) <u>2/</u>	LW P F T FS	2
	Collar (one piece) (types I, III, and VI only)	CLR IP FUS NR	1
	Undersleeve cuff	UND SLV CF FS	2
Top sleeve cuff	TOP SLV CFF	2	

1/ When alternate one-piece collar is used, disregard separate collar piece.

2/ When alternate one-piece breast pocket flap and tab, and lower pocket flap and tab pattern pieces are used, disregard separate flap and tab pieces. NOTE: Tabs are not fused.

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- 3/ When alternate one-piece elbow patch is used, disregard top and undersleeve patches.
- 4/ These are the abbreviations used on the actual pattern parts.

3.7 Stitches, seams, and stitchings. Stitch, seam, and stitching types specified in Table II are those covered by FED-STD-751. Whenever two or more methods, seams, or stitching types are given for the same part of the operation, any one of them may be used. When stitch type 401 is used, the looper (underthread) shall be on the inside of the coat. Unless otherwise specified, double needle stitching shall be 3/16 to 1/4 inch gage with the outer row of stitching 1/16 inch from the edge, on the outside of the coat. The guides and knives to the overedge machines shall be set to trim only the ravelled ends of the fabric. Seam allowances shall be maintained with seams sewn so that raw edges, runoffs, twists, pleats, puckers, or open seams shall not result. All seams shall start and finish evenly. Seams required to be worked out, and having a depth between the fold of 1/8 inch or more, shall be considered a defect.

3.7.1 Type 301 stitching. The ends of all stitching shall be backstitched or overstitched not less than 1/4 inch except where ends are turned under or caught in other seams or stitching. The ends of continuous lines of stitching shall be overlapped not less than 1/2 inch except on labels where a minimum of a three stitch overlap is required. Thread tensions shall be maintained so that there will be no loose stitching resulting in loose bobbin or top thread, or excessively tight stitching resulting in puckering of the materials sewn. The lock shall be imbedded in the materials sewn.

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

- a. When thread breaks or bobbin run-outs occur during stitching, the stitching shall be repaired by restarting the stitching a minimum of 1/2 inch back at the end of the stitching. 1/
- b. Thread breaks or two or more consecutive skipped or runoff stitches noted during inspection of the item shall be repaired by overstitching. The stitching shall start a minimum of 1/2 inch in back of the defective area and continue over the defective area to a minimum of 1/2 inch beyond the defective area onto the existing stitching. Loose or excessively tight stitching without damaging the materials and restitching in the required manner. 1/

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

3.7.1.2 Types 401, 502, 503, and 504 stitching. Thread tension shall be maintained so that there will be no loose stitching. All repairs shall be in accordance with 3.7.1.1a and 3.7.1.1b. Stitch type 401 may be repaired with stitch type 301 except for eyelets.

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3.7.2 Stitches per inch. The minimum and maximum number of stitches per inch shall be as specified in Table II.

3.7.3 Buttonholes

3.7.3.1 Eyelet-end tapered bar. The buttonholes in the pocket flaps and tabs, cuffs, and left front fly shall be eyelet-end tapered bar type, worked-over gimp specified in 3.3.4.2 with not less than four tacking stitches at the bar end catching gimp ends (not counting crossover stitch). The purling shall be between tab and flap plies and front facing and front plies. Left front lapel buttonhole purling shall be on the outside of the coat. The cut lengths shall be 3/4 to 7/8 inch, unless otherwise indicated in Table II. The buttonholes shall be clean cut with the stitching securely caught in the fabric.

3.7.4 Eyelets. Eyelets for the pockets shall be sewn with purling on the outside with a 3/16 to 1/4 inch diameter finished opening. The width or bight of stitching around the eyelet shall be no less than 1/16 inch. The eyelet stitching shall have at least four overlapping stitches.

3.7.5 Bartacks. Bartacks shall measure 3/8 to 5/8 inch long and be free from thread breaks and loose stitching.

3.8 Manufacturing operations requirements. The coat shall be manufactured in accordance with operation requirements specified in Table II. The contractor is not required to follow the exact sequence of operations provided the finished coat is identical to that produced by following the sequence as listed in Table II. Any basting or holding stitching required to facilitate manufacture is permissible, provided the thread is removed or does not show in the finished coat, except for elbow patches and pockets, which may be prehemmed. Minor modifications are permitted where necessary when using automatic equipment. These modifications shall not alter the dimensional, serviceability or appearance requirements cited in the specification.

3.9 Use of automated apparel equipment. Automated apparel equipment may be used to perform any of the operations specified in Table II, providing that the seam and stitch type are as specified, and the finishing component conforms to the required configuration. When a Government-furnished shaper pattern is forwarded, the component shall conform to that pattern.

3.10 Abbreviations in table of operations. The abbreviations used in Table II are as follows:

Stch	-	Stitch	Mchne	-	Machine	Btnhl	-	Buttonhole
In	-	Inch	Brtck	-	Bartack	Incl	-	Including
Ndl	-	Needle	Comrcl	-	Commercial	Dbl	-	Double
Bob	-	Bobbin	Smlr	-	Similar			
Lpr	-	Looper	Btn	-	Button			

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TABLE II - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
1.	<p><u>Cut coat.</u></p> <p>a. Cut coat in strict accordance with patterns furnished which show size, shape, directional lines, placement of pockets, and notches for the proper assembling of all parts.</p> <p>b. Cut top collar with long dimension across the material. The undercollar may be cut in the warp or filling direction. When option to cut one-piece collar is used, the long dimension shall be across the material. For type III only, the collar may be cut in either the warp or filling direction.</p> <p>c. Cut all parts of the coat out of one piece of material except the undercollar, pencil pocket, pocket flap tabs, and left front fly, which may be cut from ends.</p> <p>d. Cut the fusible interlining in the same direction as the parts to be fused.</p>				
2.	<p><u>Replace damaged parts.</u></p> <p>Care shall be exercised during the spreading, cutting, and manufacturing operations to assure that material defects and damages as classified in 4.4.4.1 are excluded and replaced with nondefective material.</p>				
3.	<p><u>Mark and bundle.</u></p> <p>a. Mark or bundle cut parts of the coat to insure a uniform size, uniformity of shades, and proper assembly throughout the coat.</p>				

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TABLE II - CONSTRUCTION OF COAT (contd.)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
3.	<p><u>Mark and bundle.</u> (cont'd.)</p> <p>b. Any method of marking may be used except:</p> <ul style="list-style-type: none"> <li>(1) Metal fastening devices</li> <li>(2) Sew-on tickets</li> <li>(3) Adhesive-type tickets which leave traces of adhesive on the material after removal of the tickets</li> </ul> <p>c. The use of an ink pad numbering machine, rubber stamp, or pencil will be acceptable provided the numbers do not show through the outside of the coat.</p> <p>d. Identify test swatches (basic material and fusible interlining) that represent every 1000 or 2000 reduced inspection units of production (see 4.4.3.1).</p>				
4.	<p><u>Fuse (types I, III, and VI coats only)</u> (see 3.3.3.1).</p> <p>a. Position collar interlining centered on the top collar with all the edges 1/8 inch from the top collar edges. Fuse the fusible to the top collar.</p> <p>b. Position fusible centered on both breast and lower pocket flaps with all edges set back 1/8 inch from flap edges. Fuse the fusible to the flaps. (The tab is not fused.)</p> <p style="text-align: center;">or</p>				

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TABLE II - CONSTRUCTION OF COAT (contd.)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
4.	<p><u>Fuse (types I, III, and VI coats only (see 3.3.3.1). (contd.)</u></p> <p>c. When using the alternate one piece flap and tab construction, position fusible with all edges set back 1/8 inch from the flap edges Fuse the fusible to the flaps. (The tab is not fused.)</p> <p><u>NOTE:</u> Fused lots shall be allowed to cool to the touch prior to bundle tying or testing.</p>				
5.	<p><u>Label.</u></p> <p>Sew labels to coat on all four sides with stitching not more than 3/16 inch from edge of label. Stitching shall not be through writing on label. Position label as follows:</p> <p>(1) <u>Identification label.</u> On inside of left front with the label stitching covered by lower pocket</p> <p>(2) <u>Size.</u> On center back, 1/2 to 3/4 inch down from the collar joining seam or top edge may be caught securely in the undercollar joining seam. The label shall be toward the wearer in the finished coat and centered (<math>\pm</math> 1 inch off the center tolerance).</p> <p>(3) <u>Instruction.</u> On inside of right front with the label stitching covered by the lower pocket.</p> <p>(4) <u>Combination identification and instruction label.</u> (see 3.3.5) Attach as specified in (3) above.</p> <p>(5) <u>Bar code label/tag.</u> Label/tag shall be attached as specified in 3.3.5.2.</p>	301	LSbj-1	10- 14	50 50

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TABLE II - CONSTRUCTION OF COAT (contd.)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR	
6.	<u>Make left front fly.</u>					
	a. Fold left front fly in half lengthwise, and seam top and bottom edges.	301 or	SSe-2(a)	10- 14	50	50
		401	SSe-2(a)	10- 14	50	50 or 70
	b. Turn, work out corners, and stitch top and bottom edges 3/16 to 1/4 inch from edge. Continue stitching along front folded edge maintaining gage of stitching.	301	SSe-2(b) and OSf-1	10- 14	50	50
	or					
	c. Fold left front fly in half lengthwise, turn in raw edges at ends of fly, and stitch top, front and bottom edges, 1/8 to 3/16 inch from the turned edges.	301	SSc-1 and OSf-1	10- 14	50	50
	d. Make four buttonholes in left front fly as indicated on by marks on pattern, with the inside front edge of each eyelet 5/8 to 3/4 inch from the front edge.	Btn- hl		52- 56 per btn- hl	30	50
7.	<u>Make facings.</u>					
	<u>Finished appearance:</u> The fronts shall be even in length with the facings neither tight, short, twisted, nor too full. The lapel steps shall be even in length. Front edge of left front fly shall not be exposed on the outside of the coat.					

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TABLE II - CONSTRUCTION OF COAT (contd.)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
7.	<u>Make facings.</u> (contd.)					
	a. Seam top edge of each lapel, slash seam allowance at collar notch, turn, work out corners, and single stitch beginning at collar notch 3/16 to 1/4 inch from edge; continue across step and down front edge to the bottom of the coat 3/16 to 1/4 inch from the front edge.	301 and 301	SSe-2  OSf-1	10- 14  10- 14	50  50	50  50
	b. Turn under back edge of right facing and single stitch through front, 1/16 to 1/8 inch from turned edge.	301	EFb-1	10- 14	50	50
	or					
	c. Overedge stitch back edge of right facing and stitch through front 1/8 to 1/4 inch from edge.	503 or  504 and 301	EFd-1 and  EFa-1	6- 10  10- 14	50 or 70  50	50 or 70  50
	d. Mark the position and make buttonhole in the left lapel parallel with the top edge, as indicated on pattern, with the inside edge of the eyelet 5/8 to 3/4 inch from front edge of coat.	Btn- hl		52- 56 per btn- hl	30, 50, or 70	50 or 70
	e. Superimpose left front fly on left facing, as indicated on pattern, with back edges of left fly and facing even.					
	f. Turn under back edge of left facing and stitch through front, 1/16 to 1/8 inch from turned edge.	301	EFb-1	10- 14	50	50
	or					



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TABLE II - CONSTRUCTION OF COAT (contd.)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
7.	<u>Make facings.</u> (contd.)					
	g. Overedge stitch fly and facing together. The overedge stitching shall extend the entire length of the facing.	503 or	SSa-1 and	6- 10	50 or 70	50 or 70
		504	EFa-1	6- 10	50 or 70	50 or 70
	h. Single stitch left facing through front 1/8 to 1/4 inch from back edge of facing.	301	EFa-1	10- 14	50	50
	and					
i. Tack or bartack left front fly to front of coat with three vertical tacks, 1/4 to 1/2 inch long, position at top and bottom edge of fly with the third tack centered between the two middle buttonholes $\pm$ 1/4 inch. The tacks or bartacks shall be superimposed on the edge stitching of front of coat.	301 or	SSa-1	10- 14	50	50	
	Br- tck		28 per br- tck	50	50	
8.	<u>Make breast and lower pocket flaps.</u>					
	a. Fold tab, back to back, on tab foldline. Make two vertical buttonholes in each tab, as indicated by pattern, with inside of eyelet 3/8 to 1/2 inch from bottom folded edge. The purling shall finish on the narrow width side of tab.	Btn- hl		52- 56 or btn- hl	30 or 50	50
	b. Align inner (narrow) edges of flap and tab. Stitch through one ply of flap and both plies of tab 1/4 to 3/8 inch from flap edge. The buttonhole purling shall face the flap.	301	LSb-1	10- 14	50	50

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TABLE II - CONSTRUCTION OF COAT (contd.)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
8.	<u>Make breast and lower pocket flaps.</u> (contd.)					
	c. Fold opposite raw edge of flap (fabric face to face) even with raw edge of tab enclosing tab within the fold, and stitch raw edges.	301	SSe-2(a)	10- 14	50	50
	d. Turn flap and tab right side out, force out corners and edges. Stitch side edges and bottom 3/16 inch from the edges. Bottom edge of buttonhole tab shall not be caught in the bottom edge stitching.	301	SSe-2(b)  and  OSf-1	10- 14	50	50
	e. Overedge stitch the top raw edges of each pocket flap.	503 or 504	EFd-1	6- 10	50 or 70	50 or 70
	f. Fold top edge of left breast pocket flap 1/4 to 5/16 inch and double stitch forming pencil pocket opening (see 13.d.).  or	301	EFa-2	10- 14	50	50
	g. Fold buttonhole tab portion of flap, as indicated by marks on pattern (fabric back to back) and make two vertical buttonholes in each tab, as indicated by pattern, with inside edge of eyelet 3/8 to 1/2 inch from bottom folded edge.	Btn- hl		52- 56 per btn- hl	30 or 50	50
	h. Fold tab on tab fold line (fabric face to face). Fold opposite raw edge of flap (fabric face to face), even with raw edge of tab enclosing tab within the fold, and stitch side raw edges.	301	SSe-2(a)	10- 14	50	50

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TABLE II - CONSTRUCTION OF COAT (contd.)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR	
8.	<p><u>Make breast and lower pocket flaps.</u> (contd.)</p> <p>i. Turn flap and tab right side out and force out corners and edges. Stitch bottom and side edges 3/16 to 1/4 inch from edge. Turn flap and tab again (to finished position with the raw edges hidden) and work out the corners and edges. Bottom edge of buttonhole tab shall not be caught in the bottom edge stitching.</p> <p>j. Double stitch, 3/16 to 1/4 inch gage, the top folded edge of the left breast pocket at pencil opening (see 13.f.).</p>	301	SSe-2(b)  and  OSf-1	10-  14	50	50
9.	<p><u>Hem sleeve and make cuff.</u></p> <p>a. Turn in bottom edge of sleeve 1/4 to 3/8 inch with the raw edge turned in and stitch 1/16 to 1/8 inch from edge.</p> <p>b. Slash front of gusset at bottom of sleeve, as indicated on pattern; turn edge to inside with the raw edge turned in and single stitch 1/16 to 1/8 inch from edge.</p> <p style="text-align: center;">or</p> <p>c. Slash front of gusset at side corner of sleeve, and overedge stitch raw edge prior to operation "a" above.</p> <p>NOTE: When this operation is used, bottom side edge shall be trimmed 1/2 to 5/8 inch to nothing at top corner.</p>	301  301	EFb-1  EFb-1	10- 14  10- 14	50  50	50  50
		502 or 503 or 504	EFa-1	10- 14	50	50

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TABLE II - CONSTRUCTION OF COAT (contd.)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
9.	<u>Hem sleeve and make cuff.</u> (contd.)					
	d. Join cuff facing to cuff along top, bottom and pointed edges, turn, work out points and edges and stitch 3/16 inch from edges.	301	SSe-2(a)	10- 14	50	50
	or					
	e. Join cuff facing to cuff along top, bottom and pointed edges; turn, work out points and edges and stitch 3/16 inch from edges.					
	f. Make buttonhole in center of pointed end of each cuff with the inside of eyelet 5/8 to 3/4 inches from pointed end.	Btn- hl		52- per btn- hl	30 or 50	30 or 50
10.	g. Fold undersleeve cuff in half and stitch 3/16 inch from edges.	301	OSf-1	10- 14	50	50
	<u>Make collar.</u>					
	a. Seam plies of collar around outside edges; trim corners, turn, work out points and edges and single stitch 3/16 to 1/4 inch from edge.	301 or	SSe-2(a)	10- 14	50	50
		401 and	SSe-2(a)	10- 14	50	70
		301	SSe-2(b)	10- 14	50	50
	or					
	b. When collar is cut in one piece, fold collar in half lengthwise and stitch side edges; trim corners, turn, work out points and edges, and stitch 3/16 to 1/4 inch from side and top edges.	301 or	SSe-2(a)	10- 14	50	50
		401 and	SSe-2(a)	10- 14	50	or 70
		301	SSe-2(b) and OSf-1	10- 14 10- 14	50	50

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TABLE II - CONSTRUCTION OF COAT (contd.)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	THREAD	
				STCH IN	NDL BOB/ LPR
10.	<u>Make collar.</u> (contd.)				
	c. The collar shall finish 2-1/2 ± 1/8 inches wide at the collar points (for types I, III, and VI coats only).				
11.	<u>Make breast and lower pockets.</u>				
	<u>Finished appearance:</u> The bellows portion of the pockets should finish even with the edge of the pocket. The bellows portion of each pocket shall face toward the side seam/arm of the coat and should not extend beyond the edge of the pocket.				
	a. Make one 3/16 to 1/4 inch sewn eyelet at the bottom bellows part of each breast pocket. The eyelets shall be positioned as indicated by marks on pattern.	401 or		19- 24 per eye- let	50 or 70
		502 or		26- 32 per eye- let	50 or 70
		503		26- 32 per eye- let	50 or 70
	b. Hem top of each pocket, as indicated on pattern, and stitch 1/16 to 1/8 inch from edge.	301	EFb-1	10- 14	50 50

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TABLE II - CONSTRUCTION OF COAT (contd.)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
11.	<u>Make breast and lower pocket.</u> (contd.)					
	c. Seam the two edges of the cut-out corners of the breast pockets; turn seam toward bottom of pocket and raise stitch 1/16 to 1/8 inch from joining seams.	301 or 401	LSq-2(a)	10- 14	50	50
		401	LSq-2(a)	10- 14	50 or 70	50
	or	301	LSq-2(b)	10- 14	50	50
	d. Stitch the corners of the breast pockets with two rows of stitching 1/16 to 3/32 inch apart.	301 or 401	SSa-2	10- 14	50	50
		401	SSa-2	10- 14	50 or 70	50
	e. Fold inside and outside edges of bellows (back side of lower pockets and back side and bottom of breast pockets), as indicated by pattern, and stitch 1/16 to 1/32 inch from folded edges.	301	OSf-1	10- 14	50	50
f. Raw edges of pockets may be prehemmed prior to attachment to coat. The back and bottom edges of breast pockets and the back edges of lower pockets may be turned under 3/8 inch and stitched 1/16 to 1/8 inch from edge.	301	EFa-1	8- 10	50	50	
12.	<u>Make and attach pencil pocket.</u>					
	a. Turn in top edge of pocket as indicated by marks on pattern and stitch 1/8 to 1/4 inch from raw edge.	301	EFa-1	10- 14	50	50

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TABLE II - CONSTRUCTION OF COAT (contd.)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
12.	<u>Make and attach pencil pocket.</u> (contd.)					
	b. Turn in side and bottom edges of pocket; position to left front, as indicated on pattern, and stitch 1/16 to 1/8 inch from edge.	301	LSd-1	10- 14	50	50
13.	<u>Sew on pockets and flaps.</u>					
	a. Turn in raw edges of pockets 3/8 inch, if not prehemmed (see 11.f.), position as indicated by pattern, and stitch back and bottom of breast and lower pockets to fronts 1/16 to 1/8 inch from turned-in edges. Stitching shall superimpose prehemming stitching when this option selected. Do not catch bellows in the stitching. The bellows on the breast pockets and lower pockets shall face the side seam/arm hole of the coat. The bellows portion of the pockets should finish even with the pockets edge.	301	LSd-1	10- 14	50	50
	b. Stitch the turned-in front and bottom edges of lower pockets to fronts 1/16 to 1/8 inch from edge, continuing the stitching along bottom back edge of pocket catching the corner of the bellows for not less than 1/4 inch nor more than 3/4 inch. Stitch the turned-in front edge of breast pocket to fronts 1/16 to 1/8 inch from edge, continuing the stitching along the bottom of pocket catching the corner of the bellows for not less than 1/4 inch nor more than 3/4 inch.	301	LSd-1	10- 14	50	50

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TABLE II - CONSTRUCTION OF COAT (contd.)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR	
13.	<p><u>Sew on pockets and flaps.</u> (contd.)</p> <p style="text-align: center;">or</p> <p>c. Operations 13.a. and 13.b. may be performed as one operation on the breast and lower pockets. When using the single operation, the front bottom corner of each breast pocket or back bottom corner of each lower pocket shall be backtacked through the bellows and the pocket for not less than 1/4 inch. The crossover stitch from the bellows to the pocket should finish under the backtack to preclude any weak spot in this area.</p> <p>d. Turn in top edge of flaps; position folded edge above pockets on lines indicated on pattern, and stitch with two rows of stitching 3/16 to 1/4 inch apart, leaving the seam on the left breast pocket flap open 1-1/4 to 1-1/2 inches at center of flap. Both rows of stitching on the left flap shall be a continuation of the stitching in operation 8.f.</p> <p style="text-align: center;">or</p> <p>e. Position flap (except left breast pocket flap) above pockets so that the line of stitching will be aligned with the lines indicated on pattern. Stitch to fronts 3/16 to 1/4 inch from raw edges. Turn flaps down and raise stitch with two rows of stitching 3/16 to 1/4 inch apart.</p> <p style="text-align: center;">or</p>	<p>301</p> <p>301</p> <p>301</p> <p>or</p> <p>401</p> <p>301</p>	<p>LSD-1</p> <p>LSD-2</p> <p>LSbk-3(a)</p> <p>LSbk-3(a)</p> <p>LSbk-3(b)</p>	<p>10-14</p> <p>10-14</p> <p>10-14</p> <p>10-14</p> <p>10-14</p>	<p>50 50</p> <p>50 50</p> <p>50 50</p> <p>50 or 70</p> <p>50 50</p>	



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TABLE II - CONSTRUCTION OF COAT (contd.)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
13.	<u>Sew on pockets and flaps.</u> (contd.)					
	f. When operations 8g. through j. are used: Position top folded edge of flaps above pockets on lines indicated on pattern, and stitch with the two rows of stitching 3/16 to 1/4 inch apart, leaving the seam on the left breast flap open 1-1/4 to 1-1/2 inches at center of flap. Both rows of stitching on the left flap shall be a continuation of the stitching in operation 8.j. The raw edges inside the flap and tab shall be caught in the stitching.	301	OSf-2	10- 14	50	50
	g. Bartack pockets and flaps as follows: Do no catch bellows in the bartacks.  (1) At each end of the pocket, superimpose bartack over line of stitching  (2) Left breast flap, at each end of pencil opening, positioned vertically	Br- tck		21- 28 per br- tck	50	50
14.	<u>Join shoulder seam.</u>					
	Join fronts to back at shoulder with the back over fronts, with a double-lapped and double-stitched seam.	301 or 401	LSc-2	10- 14	50	50 or 70

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TABLE II - CONSTRUCTION OF COAT (contd.)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
15.	<u>Make sleeves.</u>					
	a. Elbow patches may be prehemmed by turning under top, bottom, and front edges (for top sleeve patch) or back edges (for undersleeve patch), and stitch 1/16 to 1/8 inch from turned edges.	301	EFa-1	8- 10	50	50
	or					
	b. Turn in top of undersleeve patch edges as specified in operation 15.a. and position on sleeves, as indicated on pattern.					
	and					
	c. Join patches to sleeves with a double row of stitching with outside row 1/16 to 1/8 inch from turned edges of patch. The outside row shall superimpose prehemming stitching when this option is selected.	301	LSd-2	10- 14	50	50
	d. If alternate one-piece elbow patch is used, the patch shall be positioned as indicated by marks on pattern after back arm seam is joined.	301	LSd-2	10- 14	50	50
16.	<u>Set in sleeve.</u>					
	Set sleeves to coat with double-lapped and double-stitched seams, with fronts and back lapping sleeves.	301 or 401	LSc-2  LSc-2	10- 14  10- 14	50  50 50	50  or 70

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TABLE II - CONSTRUCTION OF COAT (contd.)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
17.	<u>Join cuffs to sleeve.</u>					
	a. Join underside of undersleeve cuff to undersleeve.	301	SSa-1	10- 14	50	50
	b. Turn undersleeve cuff to finished position; turn in top and back raw edges and stitch to undersleeve 1/16 to 1/8 inch from folded edge.	301	LSbj-1	10- 14	50	50
	and					
	Fold undersleeve cuff in half and topstitch across width of cuff 3/16 inch from the folded edge.	301	OSf-1	10- 14	50	50
	c. Join underside of top sleeve cuff to top sleeve.	301	SSa-1	10- 14	50	50
	d. Turn top sleeve cuff to finished position; turn in top raw edges and stitch to top sleeve 1/16 to 1/8 inch from folded edge.	301	LSbj-1	10- 14	50	50
	e. Superimpose top end of top-sleeve cuff on gusset and stitch plies together 1/16 to 1/8 inch from edge of gusset across the width of the cuff. The edges of the cuff and gusset shall not be out of alignment by more than 1/8 inch.	301	LSbj-1	10- 14	50	50
	f. Place a vertical bartack at the top and bottom of the tab end of cuff, superimposed on the stitching joining the cuff to the sleeve.	Br- tck		21- 28 per br- tck	50	50
	or					

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TABLE II - CONSTRUCTION OF COAT (contd.)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
17.	<u>Join cuffs to sleeve.</u> (contd.)					
	g. Turn up bottom of sleeves as indicated on pattern with raw edge turned in and stitched 1/16 to 1/8 inch from the edge. Hem shall finish 2-1/2 to 2-3/4 inches in width.	301	EFb-1	10- 14	50	50
	h. Fold in top and bottom edges of cuff 3/8 inch. Place cuff on sleeve with back raw edge even with underarm seam. Stitch bottom folded edge of cuff to bottom of sleeve 1/16 to 1/8 inch from edge, continuing across cuff (securing cuff and cuff facing to sleeve) and along top folded edge of cuff 1/16 to 1/8 inch from the edge.	301	LSd-1	10- 14	50	50
	i. Place a vertical bartack at the top and bottom of the tab end of cuff, superimposed on the stitching joining the tab end of the cuff to the sleeve. Align tack 3/8 to 1/2 inch may be used in lieu of the bartack.	Br- tck  or 301		21- 28 per br- tck	50	50
18.	<u>Join side and sleeve seams.</u>					
	a. Join side seams and underarm seams in one continuous operation with double-lapped and double-stitched seams with fronts lapping backs.	301  or	LSc-2	10- 14	50	50
	When sleeves are hemmed, catch back raw edges of cuff in sleeve joining operation. Finished cuff stitching and bottoms of undersleeves and top sleeve shall not be out of alignment by more than 1/8 inch.	401	LSc-2	10- 14	50	50 or 70

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TABLE II - CONSTRUCTION OF COAT (contd.)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
18.	<u>Join side and sleeve seams.</u> (contd.)					
	b. Sleeves shall be bartacked 1/8 inch from bottom of finished sleeve with a horizontal bartack positioned across sleeve joining seam.	Br- tck		21- 28 per br- tck	50	50
19.	<u>Set collar.</u>					
	a. Seam undercollar to neck of coat with the seaming at ends of the collar not more than 1/8 inch below top edge of lapel. When size label is caught in seam, it shall be caught securely.	301	SSa-1	10- 14	50	50
	b. Turn in bottom edge of top collar and single stitch to neck of coat 1/16 to 1/8 inch from edge, with the stitching not more than 1/8 inch from undercollar joining seam.	301	LSb-1	10- 14	50	50
20.	<u>Hem bottom.</u>					
	a. Turn up bottom, with the raw edge turned in single stitch 1/16 to 1/8 inch from folded edge with the stitching continuing across ends of hem. Hem shall finish 5/8 ± 1/8 inch wide and the ends shall not extend beyond front edges of coat.	301	EFb-1 and SSa-1	10- 14	50	50
	b. In lieu of stitching across ends of hem, vertical bartacks may be substituted in line with vertical stitching and shall cross the horizontal stitching.	Br- tck		21- 28 per br- tck	50	50

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TABLE II - CONSTRUCTION OF COAT (contd.)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR	
21.	<p><u>Attach buttons.</u></p> <p>Attach buttons to coat as follows:</p> <p>(1) Five buttons on right front positioned 1 to 1-1/4 inches from finished front edge (measurement taken from center of buttons) and corresponding to the eyelet ends of buttonholes in left front and front fly.</p> <p>(2) Two buttons on each pocket to correspond with the eyelet end of flap buttonholes.</p> <p>(3) Three buttons on each cuff. The first button shall conform to the cuff buttonhole with sleeve in finished position. The center of the second button shall be 4-1/4 ± 1/8 inch from first button and 1-1/2 ± 1/8 inch from bottom of sleeve. The third button on under-sleeve cuff with the center button 2 ± 1/8 inches from second button and 1-1/2 ± 1/8 inches from bottom of sleeve.</p>	<p>101</p> <p>or</p> <p>301</p>		<p>14- 16 per btn</p> <p>14- 16 per btn</p>	<p>30</p> <p>30</p>	<p>30</p> <p>30</p>
22.	<p><u>Clean coat.</u></p> <p>a. Trim all ends of stitching to 1/2 inch maximum length throughout (inside and outside) and remove loose threads from the coat.</p> <p>b. Remove all spots, stains, and visible shade or size markings.</p>					

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3.11 Finished measurements. The finished measurements shall be as shown in Table III.

TABLE III. Finished measurements (inches)

	XX-Short	X-Short	Short	Regular	Long	X-Long	Tolerance
Half chest <u>1/</u>							
X-Small	--	20-1/4	20-1/4	20-1/4	--	--	+ 3/4
Small	22-1/4	22-1/4	22-1/4	22-1/4	22-1/4	22-1/4	+ 3/4
Medium	24-1/4	24-1/4	24-1/4	24-1/4	24-1/4	24-1/4	+ 3/4
Large	--	26-1/4	26-1/4	26-1/4	26-1/4	26-1/4	+ 3/4
X-Large	--	--	--	28-1/4	28-1/4	--	+ 3/4
Back length <u>2/</u>							
X-Small	--	27-3/8	28-3/8	29-7/8	--	--	+ 3/4
Small	26-7/8	27-7/8	28-7/8	30-3/8	31-3/4	33-1/8	+ 3/4
Medium	27-3/8	28-3/8	29-3/8	30-7/8	32-1/4	33-5/8	+ 3/4
Large	--	28-7/8	29-7/8	31-3/8	32-3/4	34-1/8	+ 3/4
X-Large	--	--	--	31-7/8	33-1/4	--	+ 3/4
Sleeve length <u>3/</u>							
X-Small	--	22-1/4	23-1/4	24-1/4	--	--	+ 1/2
Small	21-3/4	22-3/4	23-3/4	24-3/4	25-3/4	26-3/4	+ 1/2
Medium	22-1/4	23-1/4	24-1/4	25-1/4	26-1/4	27-1/4	+ 1/2
Large	--	23-3/4	24-3/4	25-3/4	26-3/4	27-3/4	+ 1/2
X-Large	--	--	--	26-1/4	27-1/4	--	+ 1/2

1/ With coat buttoned, in line with pit of armhole measure from folded edge to folded edge.

2/ Along center back measure from undercollar seam to bottom edge of coat.

3/ Fold sleeve along the underarm seam, measure along folded edge of the top sleeve from shoulder seam to the bottom of the sleeve cuff.

3.12 Workmanship. The finished coats shall conform to the quality of product established by this specification and the occurrence of defects shall not exceed the applicable point values and quality levels.

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## 4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements (examinations and tests) as specified herein. Except as otherwise specified in the contract or purchase order, the contractor 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 ensure supplies and services conform to prescribed requirements.

4.1.1 Responsibility for compliance. All items shall meet all requirements of sections 3 and 5. The inspection set forth in this specification shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the contractor of the responsibility of ensuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations, is an acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to accept defective material.

4.1.2 Responsibility for dimensional requirements. Unless otherwise specified in the contract or purchase order, the contractor is responsible for ensuring that all specified dimensions have been met. When dimensions cannot be examined on the end item, inspection shall be made at any point, or at all points in the manufacturing process necessary to ensure compliance with all dimensional requirements.

4.1.3 Certificate of compliance. Where certificates of compliance are submitted, the Government reserves the right to inspect 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. The first article, submitted in accordance with 3.1, shall be inspected as specified in 4.4.4.1 and 4.4.4.2 for compliance with design, construction, workmanship and dimensional requirements.

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



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4.4.1 Component and material inspection. In accordance with 4.1, components and materials shall be tested in accordance with all the requirements of referenced documents unless otherwise excluded, amended, modified, or qualified in this specification or applicable procurement documents.

4.4.2 Certification. When printed or dyed seconds are used, the contractor shall furnish a certificate of compliance indicating that they meet the requirements of 3.3.2.

4.4.3 Preproduction equipment test. Prior to production, check that the equipment, after a period of warm up, is set at the proper temperature pressure, and dwell time is in accordance with the manufacturer's recommendations.

4.4.3.1 In process testing. During production, the following testing shall be followed. The preproduction test should be performed every day after the equipment has been warmed up. The bond strength test shall be done once a day, once a shift. The bond strength after laundering test shall be performed once a week.

4.4.4 Point count inspection (see 6.6)

4.4.4.1 End item visual examination. The end items shall be examined for the defects listed in Table IV and the assessment of penalty points shall be as indicated therein. Sampling and acceptance criteria shall be as specified in 4.4.4.1.1. Material defects and damages shall be clearly visible when examined at a distance of 3 feet.

TABLE IV. End item visual defects

Examine	Defect	Point value
Material defects and damage	Any hole, cut, tear, smash, burn, drill hole <u>1</u> /, scorched area, multiple float, or open place:	
	a. On outside <u>2</u> / (longest dimension in any direction):	
	-Up to 1/4 inch inclusive	2
	-More than 1/4 inch	3
	b. On inside <u>3</u> / (longest dimension in any direction):	
	-Up to 1/4 inch inclusive	1
	-More than 1/4 inch	2
	Misweave, dyestreak, broken or missing yarn, visible mend, thin place, or shade bar greater than 1/4 inch	1
	Loose yarn or coarse yarn on outside	1

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TABLE IV. End item visual defects (contd.)

Examine	Defect	Point value
Material defects and damage (contd.)	Needle chew on outside (largest dimension in any direction):	
	-Up to 1/2 inch inclusive	2
	-More than 1/2 inch	3
	Poor or no dye penetration:	
	-Up to 1/4 inch in zone A	1
	-Up to 1/4 inch in zone B or C	-
	-More than 1/4 to 1/2 inch in zone A	2
	-More than 1/4 to 1/2 inch in zone B or C	1
	-More than 1/2 inch in all zones	3
Shaded part	Variation in shade within an outside part	1
NOTE:	Parts suspected as being shaded shall be examined at a distance of 3 feet against the background of the other parts and the colors of the garment. When the shade difference is readily discernible under these examined conditions, it shall be scored as a shaded part.	
	Any part required to be cut from one piece of material, shaded	2
Cleanness	Spot or stain on outside 1/4 inch or more (largest dimension in any direction)	1
	Five or more thread ends of more than 1/2 inch on the outside, or nine or more thread ends of more than 1/2 inch on the inside	1
	Two or more shade tickets not removed	1
	Any size or shade marking on outside 1/4 inch or more	1
	More than 10 loose threads of 1 inch or more throughout (inside and outside)	1

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TABLE IV. End item visual defects (contd.)

Examine	Defect	Point value
Components and assembly	Any component part or required operation omitted (unless otherwise classified herein)	3
	Any component not as specified	3
	Any component part twisted, distorted, pleated, misshaped, tight, or full (unless otherwise classified herein)	2
	The edge of any component part required to be forced out having folds of more than 1/8 inch (unless otherwise classified herein)	1
	Any operation not as specified	3
Cutting	Any component part not cut in accordance with specified pattern or directional lines on patterns, or not in accordance with requirements	3
Seams and stitching	Accuracy of seaming:	
	a. Seam irregular, twisted, pleated, or wavy	1
	NOTE: Pleats shall be scored when they exceed 1/4 inch in length and 1/16 inch in depth of fold.	
	b. Seam puckered (score only when on major portion of seam) <u>4</u> /	1
	c. Any part of coat caught in an unrelated operation or stitching	2
	d. End of stitching when not caught in other seams or stitching, backtacked less than 1/4 inch	1
	e. Thread break (all stitch types) stitched less than 1/2 inch beyond each end of break	1
	f. Ends of a continuous line of stitching overlapped less than 1/2 inch (except label stitching)	1
	g. Ends of stitching on label overlapped with less than three stitches	1

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TABLE IV. End item visual defects (contd.)

Examine	Defect	Point value	
Seams and stitching (contd.)	Gage of stitching and seam allowance:		
	a. Irregular, i.e. unevenly gaged, or corresponding stitchings not uniformly gaged (to be scored only when condition exists on more than 1/2 the length of the seam)	1	
	b. Width not as specified or not within range of gage specified or varies more than 1/16 inch when no range is specified	1	
	c. Edge or raised stitching sewn too close to edge resulting in damage to cloth	2	
	d. Seam allowance not as specified or varies more than 1/8 inch (to be scored only when condition exists on more than 1/2 the length of the seam):	2	
	Open seam (all seams):		
	a. Up to 1/2 inch inclusive	1	
	b. More than 1/2 to 3/4 inch inclusive	2	
	c. More than 3/4 inch	3	
	NOTE:	One or more broken stitches or two or more continuous skipped or runoff stitches on joining seam constitute an open seam. On double stitched seams, a seam is considered open when one or both sides of seam is open.	
	Raw edges:		
	a. On outside:		
	-Up to 1/2 inclusive	1	
	-More than 1/2 to 3/4 inch inclusive	2	
-More than 3/4 inch	3		
b. On inside (except overedge edge):			
-More than 1 inch	1		
c. On overedged edge:			
-1 to 2 inches inclusive	1		
-More than 2 to 3 inches inclusive	2		
-More than 3 inches	3		

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TABLE IV. End item visual defects (contd.)

Examine	Defect	Point value
Seams and stitching (contd.)	Exposed under pocket flaps and sleeve tab	
	-1/4 to 1 inch inclusive	1
	-More than 1 inch	2
	Raw edge on inside or outside of coat caused by excessive seam allowance protruding from a double-lapped, double-stitched seam	1
	Run-offs:	
	Edge or raised stitching:	
	-1/4 to 1/2 inch inclusive	1
	-More than 1/2 inch	2
	Seam and stitch type:	
	a. Not specified seam or stitch type	2
	b. Looper thread on outside (when 401 stitch type is used)	3
	c. Any line of stitching omitted	3
	Stitch tension:	
	a. Loose tension, resulting in a loose seam:	
	-Up to 1/2 inch inclusive	1
	-More than 1/2 up to 3/4 inch inclusive	2
	-More than 3/4 inch	3
b. Loose tension on raised or edge stitching resulting in exposed loose thread	1	
c. Tight tension (stitches break when normal strain is applied in the direction of the seam or stitching)	3	
Stitches skipped or broken:		
a. 1/4 to 1/2 inclusive	1	
b. More than 1/2 inch	2	

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TABLE IV. End item visual defects (contd.)

Examine	Defect	Point value
Seams and stitching (contd.)	Stitches per inch (to be scored only when condition exists on major portion of seam):	
	a. All seams, except stitching of labels and overedge stitching:	
	-Less than the minimum	2
	-More than the maximum	1
	b. Stitching of label and overedge stitching, two or more stitches less than specified	1
Buttonholes and eyelets	One or more omitted, added, not specified type, or not finished as specified	3
	Gimp omitted, uncut buttonhole, or ends of gimp not pulled through to underside	1
	Ragged edge, incomplete stitching, stitching not securely caught in fabric	2
	One or more broken stitches or two or more skipped stitches in one or more buttonholes	1
	Buttonhole stitching extending beyond bartack; stitches per buttonhole less than minimum specified	1
	Finished cut length not as specified	1
	End of buttonhole tacked with less than four stitches per bar (see 3.7.3):	
	a. One buttonhole	1
	b. Two or more buttonholes	2
	Buttons (one or more)	Missing, broken, defective, not attached as specified, or insecurely sewn
Stitching and locked at end of cycle (tug at loose end of thread when accessible, to determine if it will ravel)		1

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TABLE IV. End item visual defects (contd.)

Examine	Defect	Point value
Bartacks or tack (one or more)	Missing, insecure, misplaced, not specified size or type, or not serving intended purpose	2
Collar	Top collar tight, causing collar to curl	2
	Fullness or puckers on top collar	2
	Tight at joining to neck, causing puckers or pleats on front or back	2
	Corner of pointed end poorly shaped or not of uniform size or shape	2
	Edge uneven	1
	Twisted	2
	Points uneven in length:	
	-1/4 to 1/2 inch inclusive	1
	-More than 1/2 inch	2
	Ends of undercollar joining seam overlapping top of lapel more than 1/8 inch	1
	Width of collar ends on Types I, III, and VI coats only, less than 2-3/8 inches wide or more than 2-5/8 inches wide	2
Fronts	Stitching of top collar joining seam more than 1/8 inch above or below stitching of undercollar joining seam for a distance of more than 2 inches	1
	Lengths of fronts:	
	-Uneven by more than 1/4 inch at bottom when button	2
-Uneven by 1/4 inch or more at neck, when buttoned	2	
	Front buttons and left fly button-holes out of alignment, causing a noticeable bulge or twist on fronts when buttoned	2

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TABLE IV. End item visual defects (contd.)

Examine	Defect	Point value	
Fronts (contd.)	Lapel and left fly buttonholes (position):		
	a. Buttonhole less than 5/8 inch or more than 3/4 inch from edge	2	
	b. Left fly buttonhole 1/2 inch or more from equal spacing	2	
	c. Left fly buttonhole constructed with the purling on the reverse side (facing wearer) of left fly	2	
	d. Lapel buttonhole not parallel with top edge of lapel	1	
	e. Lapel buttonhole constructed with the purling on inside of facing	1	
	Front buttons (position measured to center of button):		
	a. Button less than 7/8 inch or more than 1-1/4 inches from edge	2	
	b. Buttons 3/8 inch or more out of vertical alignment	2	
	Lapel steps uneven by more than 1/4 inch	2	
	Pocket and flaps	Construction and position:	
		a. Edges of pocket pleated or twisted in stitching	1
		b. Double row of stitching omitted at pencil opening of left breast pocket flap	1
		c. Pencil opening omitted in left breast pocket flap	2
d. Raw edge of pocket hems not turned in		2	
e. Pocket flap tab tight, causing fullness, twisting, or curling of pocket flap		2	
f. Flap attached crookedly, i.e. distance between sides of pocket and underside of opened flap vary more than 1/4 inch		2	
g. Bellows portion of breast and lower pocket positioned toward front center of coat		2	



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TABLE IV. End item visual defects (contd.)

Examine	Defect	Point value	
Pocket and flaps (contd.)	h. Pocket or flap poorly shaped	2	
	i. Pocket or flap out of alignment at any corresponding point from pocket to pocket flap to flap by more than 3/8 inch (measure vertically from bottom of coat)	2	
	j. Front edge of breast or lower pocket not parallel to front edge of coat by 3/8 or more	2	
	k. Breast pocket and/or lower pockets unequal in width or height by more than 3/8 inch	2	
	l. Flap not covering front or back edge of pocket by 3/16 inch or more	2	
	m. Bottom folded edge of pocket flap button tab caught in edge stitching of pocket flap, affecting function	3	
	n. Pocket flaps not uniform in width and length from pocket to pocket by more than 1/8 inch	1	
	Button and buttonhole:		
	a. Button not corresponding with eyelet end of buttonhole, causing pocket to be pulled up, or flap to bulge or twist when buttoned	2	
	b. Buttonhole not vertically positioned on button tab	3	
c. Constructed with purling on the underside of button tab	2		
Pencil pocket:			
a. Hem less than 1/2 inch or more than 5/8 inch wide	1		
b. Edge exposed beyond side or bottom edge of pocket	3		
c. Opening less than 1-1/4 inches or more than 1-1/2 inches	1		
Bellows	Bellows exposed beyond edges of pocket 1/8 to 1/4 inch	1	
	Bellows exposed beyond edges of pocket more than 1/4 inch	2	

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TABLE IV. End item visual defects (contd.)

Examine	Defect	Point value
Sleeves	Sleeves reversed, i.e., right sleeve in left armhole, left sleeve in right armhole	3
	Sleeve puckered or pleated at joining to armhole	2
	Sleeve tight at armhole, causing puckers, or pleats on fronts or back at armhole seam	2
	Sleeve backarm seams unequal distance from shoulder seams by more than 3/4 inch	1
	Elbow patches reversed, i.e., top patch on undersleeve patch on top sleeve	2
	Sleeve hem stitching exposed above cuff	2
	Sleeve gusset	Bottom hem less than 1/4 inch or more than 3/8 inch wide
Constructed with hem on outside of sleeve		2
Cuffs	Reversed, i.e., buttonhole end on undersleeve and buttons on top sleeve	3
	Buttonhole end of cuff extending unevenly by more than 1/4 inch	1
	Cuff twisted or finished with excessive fullness	2
	Cuff uneven in width by:	
	-1/8 to 1/4 inch inclusive	1
	-more than 1/4 inch	2
	Pointed ends poorly shaped	2
	Cuff buttonhole and buttons (position):	
	Inside edge of eyelet less than 1/2 inch or more than 5/8 inch from pointed end of cuff	1
	Buttonhole off center from point of cuff:	
-1/8 to 1/4 inch inclusive	1	
-more than 1/4 inch	2	
First button not aligned with eyelet end of cuff buttonhole	1	

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TABLE IV. End item visual defects (contd.)

Examine	Defect	Point value
Cuffs (contd.)	Second button less than 4-1/8 inches or more than 4-3/8 inches from first button or more than 1/4 inch out of alignment with first button (measurements taken from center of buttons)	1
	Third button less than 1-7/8 inches or more than 2-1/8 inches from second button or more than 1/4 inch out of alignment with second button (measurements taken from center of buttons)	1
Shoulder, armhole, underarm, side seams, and back and front arm sleeve seams	Front lapped on back at shoulder seams	1
	Back lapped on front at side seams	1
	Undersleeve lapped on top sleeve at back arm or front arm seams	1
	Sleeve lapped on front or back at armhole seam	2
Labels	Size:	
	a. Missing, incorrect, or illegible	2
	b. Top edge of label less than 1/2 inch or more than 3/4 inch below collar joining seam (when not caught in collar stitching)	1
	c. Not positioned as specified	1
	d. Not stitched on four sides	1
	e. More than 1 inch off center	2
	Identification:	
	a. Missing, incorrect, or illegible	2
	b. Label stitching not covered by lower left pocket	2
	c. Not stitched on four sides	1
	Instruction or combination identification and instruction:	
	a. Missing, incorrect, or illegible	3
	b. Label stitching not covered by lower right pocket	2
	c. Not stitched on four sides	1
Bar code label/tag	a. Bar code omitted or not readable by scanner	2
	b. Human-readable interpretation (HRI) omitted or illegible	2
	c. Not visible on folded, packaged item	2
	d. Causes damage to the item	3

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TABLE IV. End item visual defects (contd.)

Examine	Defect	Point value
Front facings	Twisted, causing twist on fronts	2
	Tight or short, causing fullness on fronts	2
	Front puckered or pleated by stitching on back edge of facing through front	1
	Back edge of right facing not turned under or overedged	3
	Back edge of left facing and fly not turned under or overedge stitched together	3
	Lapel steps uneven by more than 1/4 inch	2
	Left fly	Construction and position:
a. Fly twisted or puckered		2
b. Fly exposed beyond edge of left front		2
c. Tacking of left fly not superimposed on edge stitching of left front		1
Bottom hem	Stitching across ends of hem omitted or insecure	1
	Twisted	2
	Width less than 1/2 inch or more than 3/4 inch	2
	Irregular i width by 1/4 inch or more	1
	Bottom of coat pleated or puckered at stitching, forming hem	3
	One or both hem ends extending more than 1/8 inch beyond front edge of coat	2
	Fusing (Types I, III, and VI coats only)	Bubbling or delamination on fused components
Any strike through or bleed through		2
Any resin transfer:		
-On any fused component		2
-On any non-fused component		3
Color fading of fused parts, i.e., fused parts shaded from rest of garment	2	

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- 1/ Drill hole - This defect should not be scored when visible on the inside of the coat, provided that the component as attached to outside of coat fully covers the drill hole.
- 2/ The "outside" is any part of the coat that is visible when the completely buttoned and closed coat is examined.
- 3/ The "inside" is any part of the coat that is not visible when the completely buttoned and closed coat is examined.
- 4/ Seams suspected of being puckered shall be examined at a distance of 3 feet in comparison with the AATCC Photographic Comparative Rating (see 2.2) for seams. Puckering on a major portion of the suspected seam that equals or is worse than rating 3 for single needle seams or double needle seams shall be scored as a puckered seam.

4.4.4.1.1 Sampling and acceptance for visual examination. The sampling and acceptance criteria shall be as specified in Table V and 4.4.4.1.2 through 4.4.4.1.4.4. The lot size unit and the sample unit shall be one coat. The lot shall be unacceptable if:

a. The point value for 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 acceptable point value.

TABLE V. Sampling and acceptance criteria for visual examination

	Lot size	Sample size	Maximum acceptable point values	
			3 & 2 <u>1/</u> point defects	3, 2 & 1 point defects
Normal inspection	Up thru 500	50	13 points	25 points
	501 thru 1200	80	19 points	31 points
	1201 thru 3200	125	27 points	43 points
	3201 thru 10,000	200	38 points	63 points
	10,001 and over	315	58 points	93 points
Tightened inspection	Up thru 500	50	7 points	16 points
	501 thru 1200	80	12 points	25 points
	1201 thru 3200	125	18 points	37 points
	3201 thru 10,000	200	28 points	57 points
	10,001 and over	315	41 points	85 points

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TABLE V. Sampling and acceptance criteria for visual examination  
(contd.)

	Lot size	Sample size	Maximum acceptable point values	
			3 & 2 <u>1/</u> point defects	3, 2 & 1 point defects
Reduced inspection	Up thru 1200	32	7-14 points	24 points
	1201 thru 3200	50	12-18 points	30 points
	3201 thru 10,000	80	16-21 points	38 points
	10,001 and over	125	23-28 points	43 points

1/ If the first value is exceeded but the second value has not been exceeded, accept the lot but reinstate normal inspection (see 4.4.4.1.4.3b). The second value is the maximum acceptable point value.

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

4.4.4.1.3 Continuation of inspection. Normal, tightened, or reduced inspection shall continue unchanged on successive lots except where switching procedures in 4.4.4.1.4 require to change.

4.4.4.1.4 Switching procedures

4.4.4.1.4.1 Normal to tightened. When normal inspection is in effect, normal inspection shall be instituted when five consecutive lots have been considered acceptable on original inspection.

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

a. The preceding ten 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 ten lots is equal to or less than 60 percent of the total maximum acceptable point values for 3 and 2 point defects from the preceding ten lots; and

c. The total number of points for 3, 2, and 1 point defects in the sample from the preceding ten lots is equal to or less than 75 percent of the total maximum acceptable point values for 3, 2, and 1 point defects from the preceding ten lots; and

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- d. Production is at a steady rate; and
- e. Reduced inspection is considered desirable by the procurement quality element administering the contract.

4.4.4.1.4.3 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 V); or
- c. Production becomes irregular or delayed; or
- d. Other conditions warrant that normal inspection be instituted.

4.4.4.2 Dimensional examination. The appropriate number of coats, as specified below, shall be examined for conformance to the finished measurement requirements specified in 3.11. When a measurement deviates from a dimension and tolerance specified, the coat shall be penalized one point. Each coat shall also be penalized one point when the sleeves are uneven in length by 1/2 inch or more. The lot shall be unacceptable if the total point value resulting from this examination exceeds the maximum acceptable point value specified below. Each size of coat present in the lot shall be represented in the sample selected for this examination. The lot size unit and the sample unit shall be one coat.

<u>Lot size</u>	<u>Sample size</u>	<u>Maximum acceptable point values</u>
Up thru 500	8	0
501 to 3,200	13	1
3,201 thru 35,000	20	2
35,001 and up	32	3

4.4.5 Packaging examination. The fully packaged end items shall be examined for the defects listed below. The lot size shall be expressed in units of shipping containers. The sample unit shall be one shipping container fully packaged. The inspection level shall be S-2 and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 2.5.

<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, damaged, or not as specified.

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Workmanship	Inadequate, application of components, such as: incomplete closure of container flaps, loose strapping, improper taping, inadequate stapling bulged or distorted container.
Content	Number of items per shipping container is more or less than required. Size shown on one or more items not as specified on shipping container. <u>1/</u>

1/ For this defect, one item from each shipping container in sample shall be examined.

4.4.6 Palletization examination. An examination shall be made to determine that palletization complies with the section 5 requirements. Defects shall be scored in accordance with the list below. The sample unit shall be one palletized unit load fully packaged. The lot size shall be the number of palletized unit loads in the end item inspected lot. The inspection level shall be S-1, and the acceptable quality level (AQL) expressed in terms of defects per hundred units, shall be 6.5 in accordance with MIL-STD-105.

<u>Examine</u>	<u>Defect</u>
Finished dimensions	Length, width, or height exceeds specified maximum requirements.
Palletization	Pallet pattern not as specified. Interlocking of loads not as specified. Load not bonded.
Weight	Exceeds maximum load limits.
Marking	Omitted, incorrect, illegible, of improper size, location, sequence, or method of application.

## 5. PACKAGING

5.1 Preservation. Preservation shall be level A, C, or Commercial as specified (see 6.2).

5.1.1 Level A. Each coat shall be preserved to the MIL-STD-2073 requirements for this level. Each coat shall be laid flat with the front up. The sleeves shall be folded at right angles across the chest one on top of the other.



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For the larger sizes, it may be necessary to adjust the sides in order to attain the desired width of approximately 23 inches. The bottom edge of the coat shall first be folded over a few inches and the coat then folded in half so the length measures approximately 14-1/2 inches.

5.1.2 Level C. Each coat shall be preserved to the MIL-STD-2073 requirements for this level. Each coat shall be laid flat with the front up. The sleeves shall be folded at right angles across the chest one on top of the other. For the larger sizes, it may be necessary to adjust the sides in order to attain the desired width of approximately 23 inches. The bottom edge of the coat shall first be folded over a few inches and the coat then folded in half so the length measures approximately 14-1/2 inches.

5.1.3 Commercial. Each coat shall be preserved in accordance with the applicable requirements of ASTM D 3951.

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

5.2.1 Level A. Thirty coats of one size only for Type I, and thirty-five coats of one size only for Types III, VI and VII, preserved as specified in 5.1, shall be packed in exterior-type shipping container that conforms to PPP-B-636, overseas type. The closure of the shipping container shall be in accordance with the appendix of the applicable shipping container specification.

5.2.2 Level B. Thirty coats of one size only for Type I, and thirty-five coats of one size only for Types III, VI and VII, preserved as specified in 5.1, shall be packed in exterior-type shipping container that conforms to PPP-B-636, overseas type. The closure of the shipping container shall be in accordance with the appendix of the applicable shipping container specification, except that the inspection shall be in accordance with 4.4.5.

5.2.3 Level C. Thirty coats of one size only for Type I, and thirty-five coats of one size only for Types III, VI and VII, preserved and packaged as specified in 5.1, shall be packed in accordance with the requirements of MIL-STD-2073-1.

5.2.4 Commercial. Coats, preserved as specified in 5.1, shall be packed in accordance with ASTM D 3951.

5.3 Palletization. When specified (see 6.2), coats packed as specified shall be palletized on a 4-way entry pallet in accordance with load type 1a of MIL-STD-147. Pallet types shall be type I (4-way entry), type IV, or type V in accordance with MIL-STD-147. Pallets shall be fabricated from wood groups I, II, III, or IV, of MIL-STD-731. Each prepared load shall be bonded with straps in accordance with bonding means C and D or film bonding means F or G. Pallet pattern shall be number 3 in accordance with the appendix of MIL-STD-147.

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5.4 Marking. In addition to any special marking required by the contract or purchase order, shipping containers and palletized unit loads shall be marked in accordance with MIL-STD-129 or ASTM D 3951 as applicable.

## 6. NOTES

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

6.1 Intended use. The coats are for wear by military personnel of the Department of Defense as an outer garment; Type I in foliated areas, Type VI in hot humid foliated areas, and Type VII in desert areas.

6.2 Acquisition requirements. Acquisition documents should specify the following:

- a. Title, number and date of this specification
- b. Types, classes and sizes required (see 1.2)
- c. Issue of DODISS to be cited in the solicitation and, if required, the specific issue of individual documents referenced (see 2.1.1 and 2.2).
- d. When a first articles is required (see 3.1).
- e. Selection of applicable levels of preservation and packing (see 5.1 and 5.2).
- f. Type and class of unit load required (see 5.2.1).
- g. When palletization is required (see 5.3).

6.3 First article. When a first article is required, it shall be inspected and approved under the appropriate provisions of FAR 52.209-4. The first article should be a preproduction sample. The contracting officer should specify the appropriate type of first article and the number of units to be furnished. The contracting officer should include specific instructions in all acquisitions documents regarding arrangements for selection, inspection, and approval of the first article.

6.4 International standardization agreement. Certain provisions of this specification are the subject of international standardization agreement as cited in NATO, STANAG, No. 2333. When amendment, revision, or cancellation of this specification is proposed that will modify the international agreement concerned, the preparing activity will take appropriate action through international standardization channels, including departmental standardization offices, to change the agreement or make other appropriate accommodations.

6.5 Point count system. This specification contains the requirements for a point count system for sampling and inspection of the end item. For the visual examination, point values of 1, 2 or 3 are assigned to the listed defects depending on severity. The higher point values are assigned to those defects having a more detrimental effect on the appearance or serviceability of the items.

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6.6 Bonding strength dispute procedure. In case of a dispute, the average of the first 3 inches of the five highest bonding strength peaks from a chart recording on a CRE Tensile Tester, running at 12 inches/minute, shall determine the bonding strength. If splitting is observed, then just the highest peak shall be regarded as the bonding strength.

6.7 Temperature strip. Suggested source for temperature strips are as follows:

MRCINC, Reatec Division, telephone number (215) 687-4300  
Paper Thermometer Co., telephone number (603) 547-2034

Also, each fusible manufacturer supplies their own brand of temperature strips.

6.8 Supersession data. The type II desert camouflage pattern (6 color), cotton/nylon twill coat, type IV desert camouflage pattern (3 color), cotton/nylon twill cloth coat, and type V desert camouflage pattern (3 color), cotton poplin cloth coat have been deleted since they are no longer required.

6.9 Subject term (key word) listing

Battle dress uniform  
Clothing  
Desert  
Tropical  
Utility  
Woodland

6.10 Changes from previous issue. Marginal notations are not used in this revision to identify changes with reference to the previous issue due to the extensiveness of the changes.

Custodians:

Army - GL  
Navy - NU  
Air Force - 45

Preparing activity:

DLA - CT  
Project No. 8415-0960

Review activities:

Army - MD  
Navy - MC  
Air Force - 82, 99, 32

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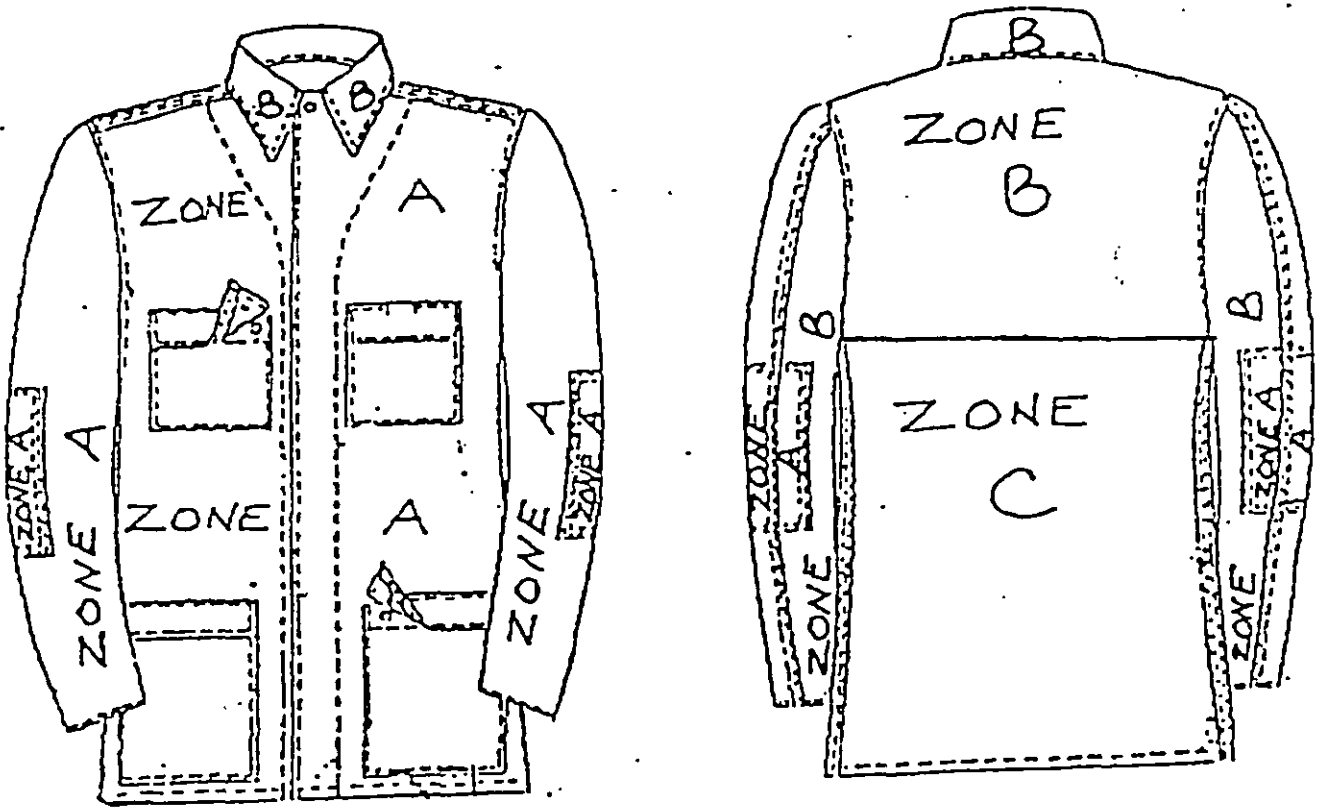


FIGURE 1. COAT, CAMOUFLAGE PATTERN, COMBAT  
(TYPES I, III, VI AND VII)

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CONTRACT # - \_\_\_\_\_ FUSING PRESS SETTINGS TEMPERATURE °F(°C) \_\_\_\_\_  
 RECOMMENDED BY FUSIBLE  
 CONTRACTOR - \_\_\_\_\_ MFG. \_\_\_\_\_ PRESSURE, PSI (BAR) \_\_\_\_\_  
 QAR NAME \_\_\_\_\_ STYLE NO.: \_\_\_\_\_ DWELL TIME. SEC \_\_\_\_\_

CHART A

DATE DD/MM/YY	INITIAL DAILY TEST (AFTER MACHINE WARM UP)		(4 HOURS LATER)		FUSING PRESS CLEANLINESS (ONCE DAILY)
MS MT-P-DT / /	T TE	ES	T TE	ES	AI: _____
MS MT-P-DT / /	T TE	ES	T TE	ES	AI: _____
MS MT-P-DT / /	T TE	ES	T TE	ES	AI: _____
MS MT-P-DT / /	T TE	ES	T TE	ES	AI: _____
MS MT-P-DT / /	T TE	ES	T TE	ES	AI: _____
MS MT-P-DT / /	T TE	ES	T TE	ES	AI: _____

MIN RQMT: 2 LBS. (907 GMS)/INCH OR SPLIT

PRESSURE EVENNESS, BONDING STRENGTH TEST ONCE WEEKLY

DATE \_\_\_\_\_ AI \_\_\_\_\_

DWELL TIME SET, TEST ONCE WEEKLY

ATE \_\_\_\_\_ AI \_\_\_\_\_

PRINTING SCALE CALIBRATION TEST ONCE WEEKLY

ATE \_\_\_\_\_ AI \_\_\_\_\_

CHART B (NORMAL INSPECTION)

REPRESENTATIVE PRODUCTION UNITS/1000	DATE DD/MM/YY	PROD. LOT A	BS AFTER 3 LAUNDER.	APPEAR AFTER 3 LAUNDER.	AI
1 - 1,000	/ /				
1,001 - 2,000	/ /				
2,001 - 3,000	/ /				
3,001 - 4,000	/ /				
4,001 - 5,000	/ /				
5,001 - 6,000	/ /				
6,001 - 7,000	/ /				
7,001 - 8,000	/ /				
8,001 - 9,000	/ /				
9,001 - 10,000	/ /				

MIN RQMT: 1.5 LBS (680 GMS)/INCH OR SPLIT GOOD

CHART B (REDUCED INSPECTION)

REPRESENTATIVE PRODUCTION UNITS/2000	DATE DD/MM/YY	PROD. LOT A	BS AFTER 3 LAUNDER.	APPEAR AFTER 3 LAUNDER.	AI
1 - 2,000	/ /				
2,001 - 4,000	/ /				
4,001 - 6,000	/ /				
6,001 - 8,000	/ /				
8,001 - 10,000	/ /				
10,001 - 12,000	/ /				
12,001 - 14,000	/ /				
14,001 - 16,000	/ /				
16,001 - 18,000	/ /				
18,001 - 20,000	/ /				

MIN RQMT: 1.5 LBS (680 GMS)/INCH OR SPLIT GOOD

- AI - AUTHORIZED TO VERIFY CONTRACTORS TESTS
- BS - BONDING STRENGTH/IN., AVE.
- DT - DWELL TIME
- MS - MACHINE SETTING
- MT - MACHINE TEMPERATURE
- P - PRESSURE
- T - TIME
- TE - TEMPERATURE
- APPEAR - APPEARANCE

FIGURE 2. FUSING PRESS MAINTENANCE/BONDING STRENGTH CHECK CHARTS - ONE WEEK PRE-PRODUCTION (CHART A) REPRESENTATIVE PRODUCTION (CHART B)

# STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

## INSTRUCTIONS

1. The preparing activity must complete blocks 1, 2, 3, and 8. In block 1, both the document number and revision letter should be given.
2. The submitter of this form must complete blocks 4, 5, 6, and 7.
3. The preparing activity must provide a reply within 30 days from receipt of the form.

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<b>I RECOMMEND A CHANGE:</b>	1. DOCUMENT NUMBER MIL-C-44048G	2. DOCUMENT DATE (YYMMDD) 950202
3. DOCUMENT TITLE Coats, Camouflage Pattern, Combat		
4. NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)		
5. REASON FOR RECOMMENDATION		
6. SUBMITTER		
a. NAME (Last, First, Middle Initial)	b. ORGANIZATION	
c. ADDRESS (Include Zip Code)	d. TELEPHONE (Include Area Code)	7. DATE SUBMITTED (YYMMDD)
	(1) Commercial (2) AUTOVON (if applicable)	
8. PREPARING ACTIVITY		
a. NAME Defense Personnel Support Center ATTN: DPSC-FQSD (12-3-C)	b. TELEPHONE (Include Area Code)	(1) Commercial (2) AUTOVON
	215-737-81 5	444-8105
c. ADDRESS (Include Zip Code) 2800 South 20th Street Philadelphia, PA 19145-5099	IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT: Defense Quality and Standardization Office 5203 Leesburg Pike, Suite 1403, Falls Church, VA 22041-3466 Telephone (703) 756-2340 AUTOVON 289-2340	