INCH POUND

MIL-J-83388E
18 June 1992
SUPERSEDING
MIL-J-83388D
5 April 1988

MILITARY SPECIFICATION

JACKET, FLYER'S, COLD WEATHER

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

1. SCOPE

1.1 Scope. This specification contains the requirements for the CWU-45/P cold weather flyer's jacket and hood, detachable.

1.2 Classification. The jackets shall be furnished in one of the following types or sizes as specified (see 6 2):

Schedule of sizes

Small	34 - 36
Medium	38 - 40
Large	42 - 44
Extra large	46 - 48
Extra extra large	50 - 52

1.2.1 The hoods shall be furnished in one of the following sizes as specified (see 6.2):

Small, Medium, Large, Extra large, Extra extra large.

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-FSSD, 2800 South 20th Street, Philadelphia, PA 19101-8419, by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A FSC 8415

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2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6 2)

SPECIFICATIONS

FEDERAL

A-A-52085	Cloth, Drill Cotton
A-A-52094	Thread, Cotton
V-B-871	Button, Sewing Hole, and Button, Staple (Plastic)
V-F-106	Fastener, Slide, Interlocking.
KK-L-2004	Leather, Cattlehide, Deerskin, and Horsehide, Chrome Tanned
NN-P-71	Pallet, Material Handling, Wood, Stringer Construction 2 Way and 4 Way (Partial)
DDD-L-20	Label; for Clothing, Equipage, and Tentage, (General Use)
PPP-B-636	Boxes, Shipping Fiberboard
PPP-T-45	Tape, Gummed, Paper, Reinforced and Plain, for Sealing and Securing

MILITARY

MIL-C-3735	Cuffs, Knit, Wrist and Ankle, and Cloth, Knitted
MIL-W-5664	Webbing, Textile, Elastic, Cotton
MIL-C-6590	Cloth, Pile (Synthetic Mouton, Knitted)
MIL-P-15011	Pallet, Material Handling, Wood, Post Construction, 4 Way Entry
MIL-F-21840	Fastener Tapes, Hook and Loop, Synthetic
MIL-C-43774	Cloth, Plain or Pajama Check Weave, Aramid
MIL-C-43824	Cloth, Synthetic Fur, Knitted
MIL-T-44100	Thread, Pararamid, Spun Intermediate Modulus
MIL-B-81813	Batting, Aramid or Novoloid Fiber, Quilted
MIL-C-81814	Cloth, Twill, Aramid, High Temperature Resistant

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MIL-C-83242	Cord, Aromatic Polyamide, Nonmelting

STANDARDS

FEDERAL

FED-STD-191	Textile Test Methods
FED-STD-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 Unit Loads
MIL-STD-2073-1	DOD Materials Procedures for Development and Applications of Packaging Requirements
MIL-STD-2073-2	Packaging Requirement Codes

(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).

2.1 Non-Government Publications. The following document(s) 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 (see 6.2).

NATIONAL MOTOR FREIGHT TRAFFIC ASSOCIATION, INC., AGENT

National Motor Freight Classification

(Applications for copies should be addressed to the American Trucking association, ATTN: Traffic Department, 1616 P Street, N.W., Washington, DC 20036-1404).

UNIFORM CLASSIFICATION COMMITTEE, AGENT

Uniform Freight Classification

(Applications for copies should be addressed to the Uniform Classification Committee, Room 1106, 222 South Riverside Plaza, Chicago, Illinois 60606-5808).

THE COLOR ASSOCIATION OF THE UNITED STATES

Department of Defense Standard Shades For Sewing Threads

Department of Defense Standard Shades For Buttons

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(Applications for copies should be addressed to the Color Association of the United States, 409 W 44th St., New York, NY 10016-0927).

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).

2 2 Order of precedence In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable 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, in accordance with 4 3

3 2 Materials

3 2 1 Basic material (Jacket) The material for the outer shell, the hanger, and the fastener thong, shall conform to MIL-C-81814 and shall be USAF color shade No 1565 (see 6 3)

3 2 1 1 Basic material (Hood) The material for the outer shell, the hanger, and the fastener thong, shall conform to MIL-C-81814 and shall be USAF color shade No 1565 (see 6 3)

3 2 2 Quilted lining. The material for the quilted lining shall conform to MIL-B-81813, except that the color shall be sage green conforming to USAF color shade No 1565 (see 6 3) The cover cloth shall be as specified in MIL-C-43774, except that the yarns per inch filling shall be 69 (minimum) and the shrinkage shall not exceed 3 0 percent in either the warp or filling directions One side of the quilted lining may be natural provided that the natural color side of the quilted lining shall face the outer shell material in the finished jacket

3 2 3 Collar interlining The material for the collar interlining and stand shall conform to type I, class 2 of A-A-52085

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3.2.4 Thread. The thread for all stitches, seams and stitchings shall conform to size T-35 of MIL-T-44100, unless otherwise specified herein. As an option, cotton thread may be used for attaching and top stitching the knitted cloth. The cotton thread shall conform to type I, ticket No. 30, 3 ply of A-A-52094 The thread shall match the color of the basic material (see 3 2.1).

3 2.5 Elastic webbing. The elastic webbing for the biasback retention shall be type I or II, class 1, 1 inch wide, minimum of 0.035 inch thick, color optional, of MIL-W-5664. The cut length shall be as follows:

	Cut Length 1/
Small	18-3/4
Medium	19-1/2
Large	20-7/8
Extra Large	21-3/4
Extra Extra Large	23

1/ The measurement of the cut length is in inches

3 2.6 Slide fasteners. The slide fasteners shall conform to requirements of V-F-106 and of Table I of this specification The chain and any other metal components except the automatic slide fastener shall be brass with a black chemical finish The slide fastener tapes shall be a high temperature resistant, nonmelting polyamide and shall be dyed so that the color of the tapes shall approximately match the color of the basic fabric (see 3 2 1) The tapes shall not shrink more than 2 percent in the direction of the warp The slider on the slide fastener for the front opening shall have a long tab pull with a 1/2 inch-wide thong that is fabricated from the basic fabric. The sliders on the slide fasteners for the hood separation and for the utility and pencil pocket of the jacket shall have short tab pulls The size of the hole of the pull tab used on the pencil pocket shall not exceed 3/16 inch As an alternate, a pull tab without any hole may be used

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TABLE I. Slide fasteners.

Application Slide Fastener	Specification V-F-106 Type	Style	Size	Length (Inches)
Size small jacket				
Front opening	IV	8	MH	21-1/2
Hood separation	I	3	M	16-1/2
Utility and pencil pocket	I	3	M	4-3/4
Size medium jacket				
Front opening	IV	8	MH	22
Hood separation	I	3	M	17
Utility and pencil pocket	I	3	M	4-3/4
Size large jacket				
Front opening	IV	8	MH	22-1/2
Hood separation	I	3	M	17-1/2
Utility and pencil pocket	I	3	M	4-3/4
Size extra large jacket				
Front opening	IV	8	MH	23
Hood separation	I	3	M	18
Utility and pencil pocket	I	3	M	4-3/4
Size extra extra large jacket				
Front opening	IV	8	MH	23-1/2
Hood separation	I	3	M	18-1/2
Utility and pencil pocket	I	3	M	4-3/4

3.2.7 Wristlets and waistband. The wristlets shall conform to type IV, class 2, size 2 of MIL-C-3735. The material for the waistband shall be the width specified in Table II and conform to type IV, class 3 of MIL-C-3735. The wristlets and the material for the waistband shall be USAF color shade No. 1525 (see 6.3).

TABLE II. Width of waistband material.

Size of Jacket	Width (Inches) in Direction of Course of Material 1/
Small	24
Medium	25
Large	26
Extra large	27
Extra extra large	28

1/ A tolerance of plus or minus 1/2 inch will be permitted.

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3.2.8 Hood lining. The lining for the hood shall be sage green and conform to type II of MIL-C-6590.

3.2.9 Drawstrings. The drawstring cord for the hood of the jacket shall conform to type III of MIL-C-83242 and be dyed to match the color of the basic fabric (see 3.2.1). Each drawstring shall be 23 inches (± 1 inch) long. The ends of the drawstrings shall be tipped or impregnated with cellulose acetate or cellulose acetate butyrate. The length of the tipping or impregnate shall be 5/8 inch (± 1/8 inch).

3.2.10 Drawstring reinforcements. The leather for the drawstring reinforcements of the jacket shall conform to type I, class 2; 1-1/2 to 3-1/4 ounces of KK-L-2004, color black.

3.2.11 Buttons. The buttons for attaching the hood to the jacket shall conform to type II, class D, styles 20 and 21, size 30 line of V-B-871 and shall be Shade Green AD, Cable 62012, in accordance with the DOD Standard Shades for Buttons.

3 2.12 Hood trimming. The trimming for the hood of the jacket shall conform to MIL-C-43824. The fur strips shall be 2 inches wide, and the length required shall be as specified in Table IV.

3.2.13 Fastener tape. The fastener tape shall be 1 inch wide, except the loop and hook fastener tape for the nameplate shall be 2 inches wide. The fastener tapes shall conform to Type II, class 1 of MIL-F-21840. The color of the fastener tape shall approximate the color of the basic fabric.

3.2.14 Cord beading The material used for the cord beading in the edges of the slide fastener covers shall conform to type I of MIL-C-83242.

3.2.15 Fusible interlining. The fusible interlining strips used on the back for stabilizing during the sewing operation shall be style No. SF 134 (manufactured by the Pellon Corporation, 1120 Avenue of the Americans, New York, NY 10036) or an equal.

3.3 Design. The design of the jacket is as follows: The jacket shall be single breasted; shall have a bias cut back; and shall have a straight center front opening with a slide fastener closure. The jacket shall have a utility and pencil pocket on the left sleeve and two front (patch) pockets that have envelope storm flaps. Closure of the utility and pencil pocket shall be effected by slide fasteners. Closure of the flaps of the front pockets shall be effected with hook and loop fasteners tape. The jacket shall have an outer shell, a quilted lining, wristlets, and a waistband that are made of high temperature resistant, aromatic polyamide material. When specified, the jacket shall have a detachable hood (See 6.2). The design of the hood is as follows: The hood shall be detachable from the jacket. The hood shall have a synthetic fur ruff, a simulated furlike knitted

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mouton lining, and an outershell of a high temperature resistant, aromatic polyamide material. The hood separation shall be accomplished by a slide fastener, and the hood shall have a drawstring adjustment.

3.4 Manufacturing operations requirements. The jacket and/or hood shall be manufactured in accordance with operation requirements specified in Table IV. The contractor is not required to follow the exact sequence of operations provided the finished jacket and/or hood is identical to that produced by following the sequence as listed in Table IV. 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. The operations numbered 28 to 38 are for the manufacturing of the hood only.

3.4.1 Stitches, seams, and stitchings. Stitches, seams and stitchings used in the construction of the jacket and/or hood shall conform to FED-STD-751. Whenever two or more methods, seams, or stitches are specified for the same operation, any one of them may be used. All seams shall start and finish evenly. Seam allowances shall be maintained so that raw edges run-offs, twists, pleats, puckers, or open seams shall not result. Thread tensions shall be maintained so that there shall be no tight or loose tension. The looper thread (under thread) of stitch type 401 shall be on the inside of the jackets and hood.

3 4.1.2 Thread breaks and ends of seams. Thread breaks (all stitch types) shall be secured by stitching back of each end not less than 1/2 inch. Skipped stitches or thread breaks of stitch type 401 may be repaired using stitch type 301, if not caught in other seams or stitchings, shall be backtacked not less than 1/4 inch The ends of a continuous line of stitching (except on labels) shall be overlapped not less than 1/2 inch The ends of stitching on labels shall be overlapped not less than three stitches

3.4.1.3 Sewing tolerances. A tolerance of ± 1/16 inch shall be permitted for 1/4 inch gage and 5/16 inch gage stitching. A tolerance of plus 0 (zero) or minus 1/8 inch shall be permitted for 3/8 inch gage stitching. A tolerance of plus 0 (zero) or minus 1/16 inch shall be permitted for raise seam 1/4 inch gage. A tolerance of plus 1/32 or minus 0 (zero) inch shall be permitted for stitching 1/16 inch from the edge.

3.4.1.4 Automatic stitching. Automatic stitching machines may be used to perform any of the required stitch patterns provided the requirements for the stitch pattern, stitches per inch, and size and type of thread are met and at least three or more tying, overlapping, or back stitches are used to secure the ends of stitchings.

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3.5 Patterns. The standard patterns used to cut the working patterns shall be furnished by the Government (see 6.3). The working patterns shall be identical to the Government patterns. Neither the Government patterns nor the working patterns shall be altered in any way, except that additional notches for use during construction are permitted on the working patterns. Also, 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. Standard patterns shall show size, directional lines, placement marks, and notches for assembly. Unless otherwise specified, the patterns provide a seam allowance of 1/2 inch.

TABLE III. Pattern parts.

Material	Pattern Part	Parts Cut
Basic fabric (see 3.2.1)	Front	2
	Back	1
	Topsleeve	2
	Undersleeve	2
	Utility pocket	1
	Pocket flap	4
	Waistband extension facing	2
	Pencil pocket	1
	Pocket	2
	Topcollar	1
	Undercollar	1
	Protective fly	1
	Cowl flap	4
	Hood front panel	2
	Hood side panel	2
	Hood center panel	1
	Throat tab	2
	Hood bottom edge	2
	Cowl edge interlining	2
	Hood slide fastener cover	2
	Utility pocket piping or cover	1
	Hanger	1
	Pull tab	1
	Top collar stand	1
	Undercollar stand	
Quilted lining (see 3.2.2)	Front	2
	Back	1
	Topsleeve	2
	Undersleeve	2
	Pocket lining	2
	Protective fly	1

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TABLE III. Pattern parts.

Material	Pattern Part	Parts Cut
Interlining (see 3.2.3)	Collar	1
	Collarstand	1
Hood lining (see 3.2.8)	Hood front panel	2
	Hood side panel	2
	Hood center panel	1
Fusible interlining (see 3.2.15)	Side strip	2
	Bottom strip	1
	Shoulder strip	2
	Neck strip	1

3.6 Cutting of jacket components. The pattern parts as specified in Table III and paragraph 3.5 shall be used for cutting of the jacket and/or hood components The jacket and/or hood components shall be cut from the materials as specified herein.

3.7 Abbreviations in Table of Operations. The abbreviations used in Table IV are as follows:

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

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TABLE IV. Sewing operations.

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
1.	Cut. (a) Cut the parts of the jacket and hood in strict accordance with the patterns The cloth shall be laid in uniform lengths, with care taken in spreading the material so that the plies shall not be stretched or full and so that one side of the lay shall be even. The patterns shall be laid in accordance with the directional lines (warp direction). (b) All parts made of the basic fabric shall be cut from one piece of material, except for parts that may be cut from ends. The following jacket and hood parts may be cut from ends, hood front panel lining, hood side panel lining, hood center panel lining, hanger, flap lining, and the undercollar. Parts cut from ends shall approximate the shade of the other parts of the jacket. (c) Except for the sleeve linings, all parts of the quilted lining shall be cut from one piece of material. The sleeve linings may be cut from ends but shall match each other. The quilted lining shall be cut so that the exposed side of the quilted lining shall be sage green. The use of ends for the two piece bottom edge and two underplies of the cowl flap is permitted provided that there is a match in the shade of the material.			
2.	Shade mark. (a) Except for parts cut from ends, all parts of the basic fabric and the quilted lining shall be marked, ticketed, or bundled to insure a uniform shade and size throughout the jacket. The marking may be any method except adhesive type-tickets that will leave traces of paper or adhesive on the material after the tickets are removed or metal fastening devices.			

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TABLE IV. Sewing operations. - (Continued)

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
3.	Replacement of defective components. (a) During the spreading, cutting, and manufacturing process, components having material defects or damages that are classified as defects in 4 4 2.1 shall be removed from production and replaced with non-defective and properly matched components.			
4.	Make two front pockets (a) Position the quilted pocket lining to the face side of the pocket outer shell, between the notches at the top with the raw edges even Join with a single row of stitching 1/8 inch from the top raw edge	301	SSa-1	10-12
	(b) Join one piece of hook fastener tape, 1 inch by 2 inches, to the outer side of the pockets at the marked locations, with a single row of stitching 1/16 inch from the edge on all four sides	301	LSbj-1	10-12
	(c) Turn the lining to the inside of the pocket along fold line and join with a single row of stitching 1/16 inch from the folded edge, and raise stitch with a single row of stitching 1/16 inch from the pocket top folded edge	301 301	SS1-1 and Osf-1	10-12 10-12
	(d) Join one piece of loop fastener tape, 1 inch by 2 inch, to the inside of the flaps at the marked location with a single row of stitching 1/16 inch from the edge on all four sides.	301	LSbj-1	10-12
	(e) Join the flaps at the ends, the bottom and the slanted sides with a single row of stitching 1/4 inch from the edge, with face sides together	301	SSe-3 (a)	10-12
	(f) Turn and raise stitch with a double row of stitching 1/16 inch from the folded edge, 1/4 inch gage	301	SSe-3 (b)	10-12

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TABLE IV. Sewing operations. - (Continued)

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
	(g) Join the pocket flaps to the fronts, positioning the top of pocket flaps at the marked locations on fronts with bottom of pocket flaps facing downwards, stitching along "turn under" line marked on pocket flap pattern, with a single row of stitching.	301	LSbj-1	10-12
	(h) Fold the pocket flaps upwards and stitch along the stitch line marked on pattern with a single row of stitching.	301	LSd-1	10-12
	(i) Turn the pocket raw edges under 1/2 inch at the sides and the bottom, catching the pocket lining. Join with a double row of stitching 1/16 inch from the folded edge 1/4 inch gage, inching the stitching up to the pocket flaps.	301	LSd-2	10-12
	(j) Fold the top slanted raw edges of the pocket to the inside 1/2 inch, and join to the pocket flap across the ends with a double row of stitching 1/16 inch from the folded edge, 1/4 inch gage	301	SSa-2	10-12
	(k) Fold the pocket flap down, and raise stitch with a single row of stitching 1/8 inch from the folded edge	301	LSq-2 (b)	10-12
5	Join fastener tape for nameplate (a) Position a 2 inch by 4 inch piece of loop fastener tape for the nameplate above the left front pocket at the pattern marks Join on all four sides with a single row of stitching 1/16 inch from the edge.	301	LSbj-1	10-12
	(b) Affix a 2 inch by 4 inch piece of hook fastener tape to the loop fastener tape for use as a mounting for the wearer's nameplate			

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TABLE IV. Sewing operations. - (Continued)

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
6.	Join fusible strips to back and elastic webbing.			
	(a) Position the fusible interlining strips on the back (basic fabric). Press interlining strips in accordance with the recommendations of the manufacturer of the fusible material.			
	(b) With the back laid out flat, join the 1-inch wide piece of elastic webbing in accordance with the marks on the pattern 1/4 inch from the edge.	301	SSa-1	10-12
7.	Make and attach utility and pencil pocket. The utility and pencil pocket shall have a bellows-style utility compartment with a covered vertical slide fastener closure, on the forward side, the full length of the pocket and four pencil compartment openings, two upper and two lower The front and rear openings shall be 7/8 inch (± 1/8 inch) wide. The finished pocket shall be 5-3/4 inches (± 1/4 inch) long by 4 inches (± 1/4 inch) wide, including the slide fastener tape and cover The width measurement shall be taken across the top of the pocket. The top of the pencil pocket shall finish approximately 3/8 inch from top of the finished utility pocket.			
	(a) Hem the top opening of the pencil compartment in accordance with the notches, with a double row of stitching with the first row of stitching 1/16 to 1/8 inch from the top edge, 1/4 inch gage.	301	EFa-2	10-12
	(b) Fold the pencil pocket matching the notches and sew with a double row of stitching, 1/4 inch gage, 1/16 to 1/8 inch from the folded edge.	301	OSf-2	10-12
	(c) Fold the opening to the center notch, tacking each side edge with a single row of stitching.	301	SSa-1	10-12

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TABLE IV. Sewing operations. - (Continued)

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
	(d) Slit the fold, at the bottom, through the center to make the pencil pass-through. NOTE: The pencil pocket may be made in two pieces. When a two piece pattern is used the cut line is midway between the two notches.			
	(e) Join the pencil compartment to the utility compartment with a double row of stitching 1/4 inch gage 1/16 to 1/8 inch from the edge along both sides, in accordance with the bottom notches, with the bottom edges even.	301	LSd-2	10-12
	(f) Place a single row of stitching centered between the front and the back edge of the entire length of the pencil compartment to separate the openings.	301	SSa-1	10-12
	(g) Bartack the ends of all pencil compartment openings with the bartack superimposed on the inner row of double stitching and on the center row of stitching. The bartack shall be 3/8 to 1/2 inch long.	brtck		28 stch per brtck
	(h) Fold the forward side of the utility compartment and the slide fastener tape cover. Insert the cord in the folds and stitch close to the cord with a single row of stitching.	301	EFa-1	10-12
	(i) Form a 3/4 inch bellows by joining the two bottom corners with a single row of stitching 1/4 inch from the end.	301	SSa-1	10-12
	(j) Sew the slide fastener tape to the forward side of the pocket with a double row of stitching 1/8 inch to 1/4 inch gage, 1/4 inch from the edge of the scoops with the beaded edge covering the scoops.	301	LSb-2	10-12

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TABLE IV. Sewing operations. - (Continued)

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
	(k) Position the slide fastener cover on the opposite slide fastener tape with the beaded edge covering the scoops and join with a single row of stitching 1/4 inch from the edge of the scoops.	301	SSa-1	10-12
	(l) Position the pocket on the left sleeve at the drill marks. Turn the raw edges under 3/8 inch, and sew with a single row of stitching 1/16 inch from the folded edge.	301	LSd-1	10-12
	(m) Place a second row of stitching 1/4 inch from the front edge and across the top of the pocket.	301	SSv-1	10-12
	(n) Bartack across top end of the slide fastener on the inner row of stitching and across the bottom end of the slide fastener with a 1/2 inch long bartack	brtck		28 stch per brtck
8.	Make sleeves.			
	(a) Join the elbow seam with a safety stitch, 1/2 inch gage.	515, 516, 517 or 518	SSa-2	10- 12
	(b) Turn and raise stitch, with the top sleeve overlapping the undersleeve, with a single row of stitching 1/4 inch from the edge.	301	LSq-2 (b)	10-12
	OR			
	(c) As an option to No. 8(a) and 8(b), join the elbow seam of the sleeve with a double-lapped, double-stitched seam 3/16 inch to 5/16 inch gage.	301 or 401	LSc-2	10-12
9.	Join shoulders.			
	(a) Join the fronts to the back at the shoulders, with a 1/2 inch gage safety stitch.	515, 516, 517 or 518	SSa-2	10-12

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TABLE IV. Sewing operations. - (Continued)

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
	(b) Turn and raise stitch, with the back overlapping the fronts, with a single row of stitching 1/4 inch from the folded edge.	301	LSq-2 (b)	10-12
	OR			
	(c) As an option to No. 9(a) and 9(b), join the fronts to the back at the shoulder with a double-lapped, double-stitched seam 3/16 inch to 5/16 inch gage.	301 or 401	LSc-2	10-12
10.	Make protective fly.			
	(a) Fold the protective fly inside out. Position the interlining on the protective fly even with the fold and the ends. Join across the ends with a single row of stitching 1/2 inch from the edge.	301	SSe-2 (a)	10-12
	(b) Turn and raise stitch with a single row of stitching 1/4 inch from the edge on all four sides.	301	SSe-2 (b) and OSf-1	10-12
	(c) Quilt the protective fly through and through with a single row of diagonal stitching with the points of the stitching approximately 3 inches apart.	301	SSa-1	10-12
	OR			
	(d) As an option to No. 10(c) quilt the fly, through and through, with four rows of equally spaced parallel stitching.	301	SSv-4	10-12
11.	Attach sleeves			
	(a) Join the sleeves to the armholes with a single row of stitching 1/2 inch from the edge catching the elastic webbing in the seam.	301 or 401	LSq-2 (a)	10-12
	(b) Turn and raise stitch on the fronts and backs, from the elbow seam to the front armhole notch or approximately 3 inches from the shoulder seam, with a single row of stitching 1/4 inch from the folded edge. Alignment of sleeve seams	301	LSq-2 (b)	10-12

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TABLE IV. Sewing operations. - (Continued)

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
	shall not be staggered by more than 1/4 inch			
12.	Join side seams and sleeve inseams			
	(a) Join the side seams and sleeve inseams, from the sleeve terminals to the bottom of the fronts, with a single row of stitching 1/2 inch from the edge	301 or 401	LSq-2 (a)	10-12
	(b) Turn and raise stitch, with the front overlapping the back at the side seams, with a single row stitching 1/4 inch from the folded edge	301	LSq-2 (b)	10-12
	OR			
	(c) As an option to No. 12(a) and 12(b), join the side seams and the sleeve inseams with a double-lapped, double-stitched seam 3/16 inch to 5/16 inch gage.	301 or 401	LSc-2	10-12
13.	Make collar.			
	(a) Quilt the undercollar leaf to the interlining with a series of diagonal stitching. The points of the diagonal stitching shall terminate at the edge of the collar, and the points of the stitching shall be approximately 3 inches apart at the top edge and 2-3/4 inches apart at the bottom edge of the collar.	301	SSv-1	10-12
	OR			
	(b) As an option to operation 13(a) the undercollar may be quilted to the interlining with 6 rows of evenly spaced stitching.	406	SSv-1	10-12
	(c) Quilt the undercollar stand to the interlining with five or six rows of horizontal stitching, approximately 1/4 inch apart, centered in the stand.	301 or 401	SSv-5	10-12

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TABLE IV. Sewing operations. Continued

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
	(d) Join the undercollar stand to the undercollar and the topcollar stand to the topcollar with a single row of stitching 1/4 inch from the edge.	301 or 401	LSq-2 (a)	10-12
	(e) Turn and raise stitch, with the stand overlapping the collar, with a single row of stitching 1/16 inch from the edges.	301	LSq-2 (b)	10-12
	(f) Join the topcollar to the undercollar with a single row of stitching 1/4 inch from the edge.	301 or 401	SSe-2 (a)	10-12
	(g) Turn and force out the edges.			
14.	Make hanger.			
	(a) Make the hanger of the basic fabric. The finished hanger shall be 1/2 inch (± 1/8 inch) wide by 3-1/2 inches (± 1/4 inch) long The stitching shall be 1/16 inch from each folded edge.	301	EFp-2	10-12
15	Join shoulders of quilted lining.			
	(a) Join the fronts to the backs, at the shoulders of the quilted lining, with a single row of stitching 1/2 inch from the edge.	301 or 401	SSa-1	10-12
	OR			
	Joining may be performed on a safety-stitch machine which stitches and overlocks in one operation.	515 or 516 or 517 or 518	SSa-2	10-12
	(b) Open the seam joining the shoulders of the quilted lining and raise stitch with a double row of stitching 1/8 inch from each folded edge.	301 or 401	SSz-2	10-12
16.	Join sleeves of quilted lining.			
	(a) Join the topsleeves to the under-sleeves at the elbow seam of the quilted lining with a single row of stitching 1/2 inch from the edge.	301 or 401	SSz-2	10-12

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TABLE IV. Sewing operations. - (Continued)

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
	OR			
	Joining may be performed on a safety-stitch machine which stitches and over-locks in one operation.	515 or 516 or 517 or 518	SSa-2	10-12
	(b) Open the seam joining the topsleeve to the undersleeve at the elbow of the quilted lining and raise stitch 1/8 inch from each edge.	301 or 401	SSz-2	10-12
17	Join side seam of quilted lining (a) Join the side seams of the quilted lining, from the sleeve terminal to the bottom edge, with a single row of stitching 1/2 inch from the edge	301 or 401	SSa-1	10-12
	OR			
	Joining may be performed on a safety-stitch machine which stitches and over-locks in one operation	515 or 516 or 517 or 518	SSa-2	10-12
	(b) Open the side seams and raise stitch with a double row of stitching 1/8 inch from each edge.	301 or 401	SSz-2	10-12
	(c) Join the sleeves to the armholes of the quilted lining with a single row of stitching 1/2 inch from the edge	301 or 401	SSa-1	10-12
	(d) Open the seam and raise stitch, with a double row of stitching 1/8 inch from the edge.	301	SSz-2	10-12
18.	Prepare waistband. (a) Sew the outer shell extension facing pieces to each end of the knit waistband with a single row of stitching 1/2 inch from the edge.	301	LSq-2 (a)	10-12
	(b) Turn and raise stitch, with the outer shell overlapping the knit waist-band, with a single row of stitching 1/4 inch from the edge.	301	LSq-2 (b)	10-12

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TABLE IV. Sewing operations. - (Continued)

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
19.	Attach waistband and corded beading.			
	(a) Sew one side of the waistband to the bottom of the outer shell with a single row of stitching 1/2 inch from the edge.	301	SSa-1	10-12
	(b) Fold the front edge to the inside at the pattern marks. Insert the cord in the fold and stitch close to the cord with a single row of stitching. The beaded edges shall be flush with each other when attached to the closed slide fastener	301	EFa-1	10-12
	(c) Attach the opposite edge of the waistband to the bottom of the quilted lining with a single row of stitching 1/2 inch from the edge.	301	SSa-1	10-12
	(d) With the jacket turned inside out, join the outer shell, the quilted lining, and the waistband (between the extension pieces) with a single row of stitching 1/2 inch from the edge.	301	SSa-1	10-12
20	Attach wristlets			
	(a) Sew the prefolded knit wristlet to the bottom of the quilted lining and outer shell sleeve terminal with a single row of stitching 1/2 inch from the edge.	301	SSa-1	10-12
21.	Join slide fastener to protective fly.			
	(a) Position the right slide fastener tape, with the slider attached, on the protective fly with the raw edge even with the tape edge and join with a single row of stitching 1/4 inch from the edge of the scoops.	301	SSa-1	10-12
22.	Join assembled slide fastener and protective fly.			
	(a) Join the assembled slide fastener and protective fly to the right front quilted lining with a single row of stitching 1/4 inch from the edge of the scoops.	301	LSq-2 (a)	10-12

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TABLE IV. Sewing operations. - (Continued)

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
	(b) Join the slide fastener to the left front quilted lining with a single row of stitching 1/4 inch from the edge of the scoops. NOTE: The zipper shall be positioned 3/8 inch to 1/2 inch from the bottom of the collar.	301	LSq-2 (a)	10-12
23.	Attach hanger. (a) Position the hanger on the back panel of the quilted lining, centered 1 inch down from the neck opening raw edge and join with a single row of stitching 1/16 inch from the edge forming a 3/8 inch by 3/8 inch box and "X" stitch or 1/2 inch-long bartack.	301 brtck	SSa-1	10-12 28 stch per brtck
24.	Attach jacket label. Position the top of the combination identification, size, and care instruction label directly below the hanger and sew on all four sides to the quilted lining, with a single row of stitching, 1/16 inch from the edge.	301	LSbj-1	10-12
25	Turn jacket. (a) Raise stitch around the wristlets on the outer shell with a single row of stitching 1/4 inch from the fold.	301	SSbg-3 (c)	10-12
	(b) Join the outer shell to the quilted lining at the front opening. Position the beaded edge on the slide fastener with the beaded edges butting when the slide fastener is closed joining with a single row of stitching 1/4 inch from the edge of the scoops. The fronts shall be even (1/4 inch tolerance) at top and bottom with slide fastener fully engaged.	301	SSa-1	10-12
	(c) Join the outer shell to the lining at the neck opening with a single row of stitching 1/8 to 1/4 inch from the edge.	301	SSa-1	10-12

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TABLE IV. Sewing operations. - (Continued)

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
26.	Attach collar.			
	(a) Join the undercollar to the neck opening with a single row of stitching 3/8 inch from the edge.	301	SSa-1	10-12
	(b) Turn the raw edge of the topcollar under 3/8 inch, and join with a single row of stitching 1/16 inch from the folded edge.	301	LSd-1	10-12
	(c) Raise stitch around the collar with a single row of stitching 1/4 inch from the edge.	301	SSe-2 (b)	10-12
27.	Raise stitch above knit waistband.			
	(a) Raise stitch across the bottom of the jacket, 1/4 inch above the knit waistband, between waistband extension, with a single row of stitching.	301	SSq-2 (a) (shows finish seam)	10-12
28.	Join hood lining (mouton).			
	(a) Join the front panels to the side panels of the hood lining with a 1/8 inch seam on a fur machine.	501	SSa-1	9
	(b) Join the center panel to the side panels of the hood lining with a 1/8 inch seam on a fur machine.	501	SSa-1	9
29.	Prepare cowl flaps.			
	(a) Join the cowl interlining strip to the cowl flaps, in accordance with the drill marks, with a single row of stitching 1/4 inch from the edge.	301 or 401	SSa-1	10-12
	(b) Join the cowl flaps to the mouton lining with a single row of stitching 1/2 inch from the edge.	301 or 401	LSq-2 (a)	10-12
	(c) Turn and raise stitch cowl strip with a single row of stitching 1/4 inch from the edge.	301 or 401	LSq-2 (b)	10-12
	(d) Join the hood bottom edges at the center back with a single row of stitching 1/2 inch from the edge.	301 or 401	SSz-3 (a)	10-12

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TABLE IV. Sewing operations. - (Continued)

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
	(e) Open the seam and raise stitch with a double row of stitching 1/4 inch from each folded edge.	301 or 401	SSz-3	10-12
	(f) Join the back bottom facing to the mouton lining with a single row of stitching 1/2 inch from the edge.	301 or 401	LSq-2 (a)	10-12
	(g) Turn and raise stitch with a single row of stitching 1/8 inch from the edge.	301 or 401	LSq-2 (b)	10-12
	(h) Fold the material for the corded beading on the edges of the slide fastener cover lengthwise. Insert the corded beading in the fold and stitch close to the corded beading with a single row of stitching so that the beaded edges shall be flush with each other when the slide fastener is closed.	301	SSa-1	10-12
	(i) Position the slide fastener cover on the slide fastener tapes, with the beaded edge covering the scoops and join with a single row of stitching 1/4 inch from the edge of the scoops	301	SSa-1	10-12
	(j) Position the hood center panel (mouton) cut-out on the slide fastener tape opposite the cover 5/16 inch from the scoops and join with a single row of stitching 1/16 inch from the edge all around the cut-out. The slide fastener shall be attached without excessive length of tape put in at any point.	301	SSa-1	10-12
30.	Prepare hood outer shell.			
	(a) Join the front panels to the side panels of the hood with a single row of stitching 1/2 inch from the edge	301 or 401	LSq-2 (a)	10-12
	(b) Turn and raise stitch the seams on the front panel of the hood with a single row of stitching 1/4 inch from the edge.	301 or 401	LSq-2 (b)	12-14
	(c) Join the side panels to the center panel of the hood with a single row of stitching 1/2 inch from the edge.	301 or 401	LSq-2 (a)	10-12

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TABLE IV. Sewing operations. - (Continued)

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
	(d) Turn and raise stitch the seam on the center panel of the hood with a single row of stitching 1/4 inch from the edge.	301 or 401	LSq-2 (b)	12-14
	(e) Sew two 1 inch-square leather reinforcement pieces to each end of the front panel of the hood, centered at the drill marks, with a single row of stitching 1/16 inch from the edge all around to the face side of the material. Sew a second row of stitching 1/4 inch from the edge to reinforce the hole.	301	LSbj-2	8-10
	(f) Punch a 1/4 inch-diameter hole through the center of each leather reinforcement and the hood outer shell.			
31.	Join cowl to hood.			
	(a) Sew the cowl shell to the hood front panel, in accordance with the notches, with a single row of stitching 1/2 inch from the edge.	301 or 401	LSq-2 (a)	10-12
	(b) Turn and raise stitch on the cowl with a single row of stitching 1/4 inch from the edge.	301 or 401	LSq-2 (b)	10-12
	(c) Split the cowl and center panel of the hood up to 1/2 inch from the drill mark.			
	(d) Position and bartack a 23 inch long drawstring to each panel seam, 1/2 inch upward from the cowl seam, on the inside, 1/2 inch from the end of the drawstring with a 1/2 inch-long bartack.	brtck		28 stch per brtck
	(e) Thread the free ends of the drawstrings through the holes in the leather reinforcement openings. Knot each free end of the drawstring approximately 2 inches from the tipped end.			

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TABLE IV. Sewing operations. - (Continued)

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
	(f) Join a 1 inch by 3 inch piece of loop fastener tape to the left side of the hood outer shell, centered over the cowl flap seam and 1-1/8 inches from the lower finished edge	301	SSa-1	10-12
	(g) Join a 1 inch by 1 inch piece of loop fastener tape to the right front panel, 1 inch from the cowl flap seam and approximately 4-3/4 inches up from the bottom finished edge angled so that it matches the 1 inch by 1 inch hook fastener tape on the throat tab when attached to the hood	301	SSa-1	10-12
32.	Attach Hood Label Position an identification size, and care instruction label on one side of the center joining seam of the hood facing the seam 1/2 inch from the buttonhole and stitched 1/16 inch from the edge	301	SSa-1	10-12
33	Join hood outer shell to hood lining (a) Join the hood outer shell to the hood lining with a single row of stitching 1/2 inch from the edge	301	Lsq-2 (a)	10-12
	(b) Turn and raise stitch with a single row of stitching 1/4 inch from the edge	301	Lsq-2 (b)	10-12
	(c) Make a second row of stitching 1 inch from the bottom edge of the hood and the cowl.	301	SSa-1	10-12
	(d) Join the outer shell to the hood slide fastener by folding 3/8 inch from the inside and join with a single row of stitching 1/16 inch from the folded edge at the sides and the closed end.	301	LSd-1	10-12
	(e) Bartack the closed end of the slide fastener with a 7/8 inch-long bartack	brtck		42 brtck

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TABLE IV. Sewing operations. - (Continued)

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
	(f) Make a channel for the drawstring by stitching 1 inch from the cowl seam extending from the center panel to approximately 1/2 inch above the top of the leather reinforcement piece	301	SSa-1	10-12
	(g) Quilt the cowl with a single row of diagonal stitching, through and through, with the converging points approximately 3 inches apart.	301	SSv-1	10-12
34.	Prepare throat tab.			
	(a) Join the throat tab with a single row of stitching 1/4 inch from the edge.	301 or 401	SSe-2 (a)	10-12
	(b) Turn and raise stitch with a single row of stitching 1/4 inch from the edge.	301 or 401	SSe-2 (b)	10-12
	(c) Join 1 inch by 1 inch piece of the hook fastener tape to the throat tab (outside) at the pattern marks, with a single row of stitching 1/16 inch from the edge on all four sides.	301	LSbj-1	10-12
	(e) Join a 1 inch-wide piece of the loop fastener tape, across the end pf the cowl and the left front panel on the inside, with a single row of stitching 1/16 inch from the edge on all four sides. The length from the edge of the cowl to the bottom edge of the front panel shall be approximately 5-1/2 inches long.	301	LSj-1	10-12
	(f) Join a 1 inch-wide piece of the hook fastener tape, across the end of the cowl and the right front panel on the outside, with a single row of stitching 1/16 inch from the edge approximately 5-1/2 inches long.	301	LSbj-1	10-12
35.	Attach throat tab.			
	(a) Turn the raw edge of the throat tab under 1/4 inch and center it on the cowl and front panel seam, the bottom folded end on the stitching 1 inch from the end of the cowl, and join with a double row of stitching, 1/16 inch from the folded edge,	301	LSd-2	10-12

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TABLE IV. Sewing operations. - (Continued)

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
	1/4 inch gage. The 1 inch by 1 inch piece of the hook fastener tape shall face down to match the 1 inch by 1 inch piece of the loop fastener tape positioned on the left front panel.			
36.	Attach fur strips to cowl. (a) Position the fur strips onto the right and left sides of the cowl so that the fur strips will be 1/8 inch from the front edge of the cowl and 3/4 inch from the slide fastener scoops and so that the fur strip on the right-hand side of the cowl will be 1/8 inch from the bottom edge of the cowl and will butt the top edge of the loop fastener tape on the left side of the cowl Stitch the fur strips, with the hair bent inwards, to the cowl with a single row of stitching 1/8 inch from the edge of all four sides.	301	SSa-1	10-12
37	Make buttonholes in hood. (a) Mark and make four, straight type buttonholes 1/2 inch from the bottom edge of the hood to fit the 30-line buttons and securely tack the ends Position the buttonholes so that a buttonhole is centered (± 1/8 inch) across each front and side panel joining seam and so that two buttonholes are positioned on the center panel 3/8 inch (± 1/8 inch) from the side panel and center panel joining seam.	button hole		52 stch per button hole

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TABLE IV. Sewing operations. - (Continued)

No.	Description of Operation	Stch Type	Seam/ Stch Type	Stch Per In
38.	Attach buttons (when jacket and hood are procured together).			
	(a) Sew four 30-line buttons on the collar stand, 1/2 inch from the seam which joins the stand to the jacket, matching the placement of the buttonholes in the hood. The buttons shall be tightly wrapped to form a shank with the ends of the thread tacked off.	101 or 301 or hand		22 stch per button or stch 16 stch per button or 4-6 stch per button w/dbl thread
39.	Make thong.			
	(a) Fabricate the thong for the slide fastener, for the front opening, so that the finished thong shall be 1/2 inch wide by 3 inches long. Stitching shall be 1/16 to 1/8 inch from the edge.	301	EFp-2	10-12
	(b) Pull the thong through the hole in the top slider tab pull so the ends of the thong shall be even. Bartack at the bottom, the center, and at the end of the thong, across the 1/2 inch width.	brtck	SSc-1	28 stch per brtck
40.	Clean jacket.			
	(a) Trim all thread ends. Remove all loose thread ends.			
	(b) Remove all spots, stains, and shade tickets without damage to the fabric.			
41.	Prepare hood for packaging (when hood is procured separately from the jacket).			
	(a) Insert the four buttons for attaching the hood to the jacket in a paper envelope (3.3.6)			
	(b) Use a string to attach the envelope containing the buttons to the slide fastener loop on the hood.			

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3.8 Jacket Labels. Each jacket shall have one label which contains the identification, size, and care instructions The identification, size, and care instruction label shall have colorfastness to dry cleaning, shall conform to type VI, class 14 of DDD-L-20, and shall contain the following care information:

This jacket is made of fire resistant material. No other special resistant treatment is required DRY CLEAN ONLY. DO NOT STARCH. Ironing or pressing is not necessary.

3.8.1 Hood Labels. The hood shall have a combination identification, size, and a care instruction label. The label shall be located as specified in Table IV. The label shall conform to DDD-L-20, type VI, class 14. Each label shall be 1-1/4 by 2 inches and contain the following information:

- Hood, Flyers, Cold Weather, Aramid
- Contract 1/
- Name of Manufacturer 1/
- NSN 1/
  DRY CLEAN ONLY

1/ This information is to be entered by the manufacturer.

3.9 Figures. Figures 1 thru 5 show the general style of the jacket with or without hood are furnished for information only In the event of any conflict between the written specification and the figures, the written specification shall govern

3.10 Finished measurements. The finished measurements of the jacket and/or hood shall conform to Table V. The finished measurements of the jacket and/or hood shall be taken, with the garment laying flat and slide fastener closed, as follows:

Back length. Measure down from the center of the back starting from the bottom of the undercollar seam to the top of the knit waistband seam.

1/2 chest. Measure across at the base of the armhole, from folded edge to folded edge.

Sleeve inseam. Measure along the underarm seam, from the armhole to the seam above the knit cuff.

Neck length. Measure the length of the hood's neck length at the bottom, on the inside neck length from finished edge to finished edge.

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TABLE V. Finished measurements.

	Finished Measurements in Inches			
Size of Jacket Size of Hood	Back Length	1/2 Chest	Sleeve Length	Neck Length
Small	21-3/4	22-1/2	20-3/4	19-3/4
Medium	22-1/4	24-1/2	21	21-1/4
Large	22-3/4	26-1/2	21-1/4	22
Extra large	23-1/4	28-1/2	21-1/2	23-1/4
Extra extra large	23-3/4	30-1/2	21-3/4	24-1/4
Tolerances	+ 3/8, -5/8	± 1/2	± 3/8	± 1/4

3.11 Workmanship. The finished jackets and/or hoods shall conform to the quality of product established by this specification The occurrence of defects shall not exceed the applicable acceptable quality levels.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the 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.

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4.1.2 Certificate of compliance. Where certificates of compliance are submitted, the Government reserves the right to check test such items to determine the validity of the certification.

4.2 Classification of inspection. 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 2, shall be inspected as specified in 4 1 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.

4.4.1 Component and material inspection. In accordance with 4 1 above, components and materials shall be tested in accordance with all the requirements of referenced specifications, drawings, and standards unless otherwise excluded, amended, modified, or qualified in this specification or applicable procurement documents. The unit for expressing lot size and sample size for testing materials and components shall be as specified in the applicable subsidiary documents. In addition to the examinations and tests specified in the applicable subsidiary documents referenced herein, materials and components shall be tested as specified in Table VI. The sample size for the tests specified in Table VI shall be as specified in Table VII.

TABLE VI. Testing of materials and components.

Characteristic of Material of Components	Test Method
Tape for slide fastener (see 3.2.6)	
Shrinkage	5556 of FED-STD-191 (cotton procedure for 5 launderings)
Flaming Time	5903 of FED-STD-191 1/
Glow Time	5903 of FED-STD-191 1/
Char Length	5903 of FED-STD-191 1/
Compound for ends of drawstrings of jacket (see 3.2.9)	
Identification of Compound	1/

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1/ A certificate of compliance shall be acceptable for this requirement.

4.4.2 Examination of the end item. Examination of the end item shall be in accordance with 4.4.2.1 through 4.4.2.2. The sample unit for these end item examinations of the jackets shall be one jacket including hood.

TABLE VII. Sample Unit.

Lot Size (Units)	Sample Unit
800 or less	2
801 to 22,000 inclusive	3
22,001 or more	5

4.4.2.1 Visual examination. The end items shall be visually examined for defects. The inspection level for this visual examination shall be II of MIL-STD-105. The acceptable quality level for this visual examination shall be 2.5 defects per 100 units (dhu) for major defects, 15.0 dhu for major and minor A defects, and 40.0 dhu for major and minor A and minor B defects. The defects found during this visual examination shall be classified as specified in Table VIII.

4.4.2.2 Examination of finished measurements. The end item shall be measured as specified in 3.10. The inspection level for this examination of the finished measurements shall be S-3 of MIL-STD-105. The acceptable quality level for the examination of the finished measurements shall be 4.0 dhu for defects (one class). Each finished measurement of the end item deviating from the finished measurement specified in Table V shall be classified as a finished measurement defect. Sleeve lengths uneven 1/2 inch or more shall be classified as a finished measurement defect.

4.4.3 Examination of packaging requirements. An examination shall be made to determine that packaging, packing, and marking comply with Section 5 requirements of this specification. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully prepared for delivery. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot size shall be on the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 and the acceptable quality level (AQL) shall be 2.5 defects per hundred units in accordance with MIL-STD-105.

Examine	Defect
Marking (exterior interior)	Omitted, incorrect, illegible, of and improper size, location, sequence, or method of application.

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

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

TABLE VIII. Classification of Defects.

Defect	Major	Minor A	Minor B
Bartack			
One bartack missing, insecure, or misplaced not serving intended purpose			X
Two bartacks missing, insecure or misplaced not serving intended purpose.		X	
Three or more bartacks missing, insecure or misplaced not serving intended purpose.	X		
Any bartack less than specified length			X
Buttons			
Buttons not specified size, type, or color			X
One button missing, loose, or broken.		X	
Two or more buttons missing, loose, or broken	X		
Any button more than 1/4 inch out of alignment with buttonhole.		X	
Shank wrapping omitted on one button			X
Shank wrapping omitted on two or more buttons		X	
Buttonholes in the jacket			
One or more buttonholes omitted or added.	X		
Buttonhole stitches not caught in fabric, causing stitches to pull away from fabric	X		

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TABLE VIII. Classification of Defects. - (Continued)

Defect	Major	Minor A	Minor B
One or more broken stitches in two or more buttonholes.	X		
One or more broken stitches in one buttonhole.		X	
More than two skipped stitches in one or more buttonholes.		X	
Ragged edges in any buttonhole affecting appearance.			X
Any buttonhole uncut.			X
End of one buttonhole insecurely tacked		X	
End of two buttonholes insecurely tacked.	X		
Cleanness			
Indelible ink shade stamping exposed on outside or spots or stains of permanent nature.		X	
Removable spot or stain clearly noticeable.		X	
Threads ends not trimmed or one or more shade tickets not removed.			X
Component and assembly			
Any component defective.	X		
Any component missing.	X		
Any required operation omitted or improperly performed.	X		
Cutting			
Any component not cut in accordance with directional lines on patterns or specified requirements.	X		
Material defects and workmanship damages			
Any weakening material defects such as hole, smash, multiple floats, or slub, which might develop into hole (except quilted lining and knitted fabric).	X		
Slubs or any other similar nonweaking material defects on outside of jacket (except quilted lining and knitted fabric).		X	

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TABLE VIII. Classification of Defects. - (Continued)

Defect	Major	Minor A	Minor B
Slubs, or any other similar nonweaking material defects on inside of jacket (except quilted lining and knitted fabric).			X
Large drill hole, cut, tear, mend, or needle chew that might develop into hole (except quilted lining and knitted fabric).	X		
Ruptured fibers in line of sewing (usually caused by broken, blunt, or hooked needles) affecting appearance or serviceability (except quilted lining and knitted fabric)	X		
Any mend, darn or patch on outside.	X		
Mend, darn or patch on inside more than 1/2 inch in any dimension.	X		
Basic fabric containing two or more contiguous missing or broken picks or ends or two contiguous stripbacks.	X		
Knitted material containing any broken yarn, dropped stitch, run or abrasion mark resulting in a weakened area.	X		
Basic fabric containing one missing or broken pick or end.		X	
Synthetic fur or mouton containing any cut, hole, tear, mend, bare spot or thin place.	X		
Synthetic fur or mouton exhibiting an uncleanness or objectionable odor.	X		
Drawstrings of the jacket weakened by broken or fraying strands.		X	
Quilted lining containing any hole, scissor or knife cut, tear, burn, or needle chew that may develop into a hole.	X		
Quilted lining containing any weakening defect such as smash, multiple float, or loose slub that may develop into a hole.		X	
Quilted lining containing darn or mend.		X	
Quilted lining containing exposed drill hole.			X

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TABLE VIII. Classification of Defects. - (Continued)

Defect	Major	Minor A	Minor B
One or more rows of quilting stitching omitted in quilted lining.	X		
More than 1-1/2 inches of broken or missing quilting stitches in quilted lining.		X	
Batting in quilted lining uneven resulting in thick or thin place.	X		
One or more laps of batting of quilted lining.	X		
One or more piecing or splicing of covering of batting of quilted lining.	X		
Any area of quilted lining evidencing complete bobbin change.	X		
Seams and stitchings			
Seam twisted, pleated, or badly puckered 1/.		X	
Part of jacket caught in any unrelated operation or stitching.	X		
Thread(s) used on outside not same shade or not satisfactorily matching shade of jacket.		X	
Thread breaks or end(s) of stitching, if not caught in other seams or stitchings not securely backstitched or tacked as specified.		X	
Gage of edge, top, or raise stitching irregular, i.e., unevenly gaged or corresponding stitching not uniformly gage, affecting appearance.		X	
Gage of edge, top, or raise stitching not within range of gage specified or varies more than 1/16 inch if no range is specified.			X
Open seam 1/8 inch but not over 1/4 inch on joining seam 2/.			X
Open seam over 1/2 inch 2/.	X		
Open seam over 1/4 inch up to 1/2 inch 2/.		X	
Open seam over 1/4 inch on the joining seam.		X	

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TABLE VIII. Classification of Defects. - (Continued)

Defect	Major	Minor A	Minor B
Stitches skipped or broken over 1/4 inch but not over 1/2 inch on edge, top, or raise stitching, when seam is seamed, turned and stitched 2/.			X
Stitches skipped or broken over 1/2 inch on edge, top, or raise stitching, when seam is seamed, turned and stitched 2/.		X	
Raw edges on outside over 1/8 inch but not over 1/4 inch 3/.			X
Raw edges on outside over 1/4 inch 3/.		X	
Raw edges on inside over 1/2 inch but not over 1 inch 3/		X	
Raw edges on inside over 1 inch 3/.		X	
Run offs on joining seams, if resulting in open seam 2/.	X		
Run-offs on edge, top, or raise stitching if not resulting in open seam (outside only), over 1/2 inch but not over 1 inch			X
Run-offs on edge, top, or raise stitching, if not resulting in open seam (outside only), over 1 inch.		X	
Stitch or seam type not as specified.		X	
Loose stitch tension, resulting in loose seam.	X		
Loose stitch tension on edge, top, or raise stitching, recognized by loose exposed loops of top or lower thread.		X	
Tight tension 2/			X
One or two stitches per inch less than minimum specified 4/.			X
Three stitches per inch less than minimum specified 4/.		X	
Four or more stitches per inch less than minimum specified 4/	X		

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TABLE VIII. Classification of Defects. - (Continued)

Defect	Major	Minor A	Minor B
One or more stitches per inch more than maximum specified 4/.		X	
Shaded parts			
Outside parts (visible when jacket is worn) shaded.		X	
Lining and inside parts (not visible when jacket is worn) badly shaded.			X
Slide fasteners			
Slide fasteners not specified type, size, or style or any part of assembly omitted, bent, or broken.	X		
Any portion of jacket or slide fastener tape puckered, twisted, or pleated at slide fastener tape joining seam when slide fastener is open or closed.		X	
Interference with movement of any slide.	X		
Any slide fastener, except slide fastener for front opening, not entirely covered by flap	X		
Any slide fastener not closed in specified direction.		X	
Thong not attached to slider for front opening as specified.		X	
Slide fastener coverings			
Edges of slide fastener coverings overlapping more than 1/16 inch or gaping more than 1/16 inch when slide fastener is closed.		X	
Cord beading omitted in slide fastener covering	X		
Cord beading not sewn taut in slide fastener covering.		X	
Drawstrings of the jacket			
Drawstrings not specified type, size, or color.		X	
End(s) of drawstrings not tipped or impregnated		X	
Length of tipped or impregnated ends of drawstrings less than 1/2 inch or more than 3/4 inch.			X

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TABLE VIII. Classification of Defects. - (Continued)

Defect	Major	Minor A	Minor B
Drawstrings less than 22 inches long or more than 24 inches long.		X	
Drawstrings not inserted through one or both holes more than 2 inches continuous length.			X
One or both free ends of drawstrings not knotted.			X
Drawstrings not securely bartacked to panel seam.		X	
Hood for the jacket			
Side panel overlapping front panel of hood.			X
Fur strips not positioned on cowl as specified.		X	
Stitching around fur strips less than 1/8 inch from edge.		X	
Natural lay of fur not upwards.		X	
Side panels overlapping crown of hood.			X
Any part of lining tight, short, or twisted, causing fullness or twist on outside of hood.		X	
Rows of quilting stitches on cowl spaced more than 3 inches apart at pointed ends.			X
Leather reinforcement pieces stitched to hood with only one row of stitching around edges.			X
Throat tab more than 1/4 inch out of alignment.		X	
Bald spots, cuts, holes, or tears in leather 5/.		X	
Slide fastener tapes set on too tightly causing excessive bulging on opening, affecting appearance.		X	
Length of slide fastener less than specified.		X	
Collar excessive fullness or puckering.	X		
Excessive fullness or puckering in the under collar.		X	

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TABLE VIII. Classification of Defects. - (Continued)

Defect	Major	Minor A	Minor B
Collar excessive fullness or puckering in collar.	X		
Excessive fullness or puckering in under collar.		X	
Fronts			
Front pockets 1/2 inch or more out of alignment with each other.		X	
Converging points of diagonal stitching of inner fly spaced less than 2-1/2 inches or more than 3-1/2 inches apart at points (if applicable).			X
Front sagging, twisted, or bulging across chest, or caused by tightness of lining.		X	
Back overlapping front at side seam.			X
Loop fastener tape on flap more than 1/4 inch out of alignment with hook fastener tape on pocket.		X	
Fastener tapes reversed, i.e., pile portion on pocket and hood portion on underside of flap.	X		
Fronts uneven at top or bottom (with slide fastener fully engaged) by more than 1/4 inch.		X	
Protective fly quilting stitching not through all plies.		X	
Waistband			
Waistband not specified width or length.		X	
Waistband twisted in attachment to bottom of jacket, affecting appearance.		X	
Sleeves			
Sleeves sagging, twisted, bulging, or short causing shortness, tightness, or incorrect positioning of lining.		X	
Back part of sleeve overlapping forepart of sleeves at inseams.			X
Back part of sleeve overlapping forepart of sleeves at elbow seam.		X	

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TABLE VIII. Classification of Defects. - (Continued)

Defect	Major	Minor A	Minor B
Sleeve overlapping body parts at joining seam	X		
Alignment of sleeve seams staggered more than 3/8 inch.		X	
Wristlets not specified class or color.		X	
Wristlets twisted in attachment to sleeve bottom, affecting appearance.		X	
Pencil and utility pocket less than 5-1/2 inches or more than 6 inches long.		X	
Pencil and utility pocket (including slide fastener tape) less than 3-3/4 inches or more than 4-1/4 inches wide		X	
Pencil and utility pocket set on crookedly, affecting appearance.		X	
Hem of opening of pencil and utility pocket stitched with only one row of stitching.			X
Pencil compartment piece not double-stitched along front and back edges.		X	
Slide fastener not on forward side of finished pencil and utility pocket.	X		
Ends of slide fastener tapes of pencil and utility pocket not turned under.	X		
Front and top edges of pencil and utility pocket and tape not double stitched to sleeve		X	
Slide fastener stitched to pencil and utility pocket with slider closing downward.		X	
Elastic in back panel			
Elastic webbing omitted.	X		
Elastic webbing in back panel stitched too, tightly causing puckering on back, affecting appearance		X	
Elastic webbing twisted on back.		X	

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TABLE VIII. Classification of Defects. - (Continued)

Defect	Major	Minor A	Minor B
Hanger			
End(s) of hanger not securely stitched as specified.		X	
Finished hanger less than 3-1/4 inches long or more than 3-3/4 inches long.			X
Hanger less than 3/8 inch wide or more than 5/8 inch wide.			X
Hanger 1 inch or more off center with center of back.			X
Hanger stitched and bartacked through outer shell.		X	
Fastener tape			
Hook fastener tape more than 1/4 inch out of alignment with loop fastener tape		X	
Fastener tape (except wearer's nameplate) not specified size.		X	
Fastener tape (except wearer's nameplate) misplaced not serving intended purpose.	X		
Hooks or loops flattened or missing from any fastener tape area up to 25 percent.		X	
Hooks or loops flattened or missing from any fastener tape area 25 percent or more.	X		
Fastener tape for wearer's nameplate missing.	X		
Fastener tape for wearer's nameplate not specified type.	X		
Fastener tape for wearer's nameplate misplaced more than 1/2 inch		X	
Stitching omitted on one or more edges of loop tape for wearer's nameplate.		X	
Label			
Size on label missing, incorrect, or illegible.	X		
Information (except size) on label incomplete, incorrect, or illegible.		X	

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TABLE VIII. Classification of Defects. - (Continued)

Defect	Major	Minor A	Minor B
Label misplaced or off center of back more than 1/2 inch.			X
Stitching omitted on one or more edges of label.		X	

1/ Some puckering is an inherent characteristic in joining seams and stitching of cloth parts. This normal puckering shall not be classified as a defect

2/ A break in a line of stitching (except on edge, top, or raise stitching), run-offs of joining seams (if resulting in an open seam), and tight tension (stitches breaking when normal strain is applied to seam or stitching) shall be classified as an open seam

3/ A raw edge shall be classified as such when it occurs along an edge required to be turned under but the edge is securely caught in the stitching. If the edge is not securely caught in the stitching, the defect shall be classified as an open seam

4/ Stitches per inch shall be classified as a defect only when the condition exists on the major portion of the seam or stitching.

5/ Small holes or bald spots that can only be seen by parting the hair down to the leather shall not be classified as defects.

4.4.4 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.

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Examine	Defect
Finished dimensions specified	Length, width, or height exceeds maximum requirements.
Palletization	Pallet pattern not as specified. Interlocking of loads not as specified. Load not bonded with required straps as specified.
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 B or C or Industrial, as specified (see 6.2).

5.1.1 Level B or C. Each jacket shall be folded to approximately 20 inches by 16 inches. Three folded jackets shall be placed in a box conforming to type CF, class domestic, Style RSC, grade 200, of PPP-B-636. The outside dimensions of the box shall be approximately 20 inches by 16 inches by 6 inches. The box shall be closed by applying tape conforming to PPP-T-45.

5.1.1.1 Level B or C (Hood). The front opening (hook and loop) for each hood shall be fully closed, and the hood slide fastener shall be fully closed

a. Lay the hood in a flat position.

b. The approximate size of the flat hood shall be 13 by 14-1/2 inches.

Each folded hood shall be packaged in a clear polyethylene bag of 0.00125 (± .00025 inch) film. Closure of the bag shall be effected by heat seal. Prior to heat sealing the bag, a paper label, containing applicable unit package marking (see 5.3), shall be inserted in the bag. The label shall be placed so that it is visible and readable As an alternate a pressure sensitive label can be applied on the outside of the bag. One corner of each bag shall contain a hole, 1/4 inch in diameter, to allow excess air to escape. As an alternate, the final closure of the bag may accomplished by use of a tuck or reverse flap The approximate flat size of the polyethylene bag shall be 13 by 17 inches.

5.1.2 Industrial. The jacket including the hood shall be packaged one per unit container in accordance with ASTM-D-3951.

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5.1.2.1 Industrial (Hood). The hoods shall be packaged in accordance with ASTM-D-3951.

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

5.2.1 Level B. Twelve jackets of one size only, preserved as specified in 5.1.1, shall be packed as specified in 5 2 2, except that the fiberboard container shall be class weather-resistant, grade V3c or V3, of PPP-B-636.

5.2.1.1 Level B (Hood). Thirty hoods of one size, preserved as specified in 5.1 1.1, shall be packed as specified in 5.2 2.1, except that the fiberboard container shall be weather resistant, Grade V3c or V3s, of PPP-B-636. In addition, each container shall be reinforced with flat non-metallic strapping or tape banding in accordance with the appendix to PPP-B-636.

5.2.2 Level C. Twelve jackets of one size only, preserved as specified in 5.1.1.1, shall be packed in a fiberboard container constructed and closed to conform to type CF or SF, class domestic, variety SW, grade 275, style RSC-L of PPP-B-636. The inside dimensions of the container shall be approximately 20 inches by 16 inches by 24 inches.

5.2.2.1 Level C (Hood). Thirty hoods of one size, preserved as specified in 5.1.1.1 shall be packed within a fiberboard container constructed and closed to conform to type CF or SF, class domestic, variety SW, grade 275, style OSC of PPP-B-636 The inside dimensions of the container shall be approximately 23-1/2 by 15 by 15 inches. The bagged hoods shall be placed in the container as follows:

a. In two equal tiers.

b. The hoods shall be parallel to the end panels of the container.

c. Every other hood shall be in a reverse position to the one on the top. The contents of each container shall be completely covered on the top, bottom and sides of with commercially acceptable kraft paper. The body joint and the top and bottom flaps shall not contain any metal fastenings or stitches. Each container shall be constructed and closed in accordance with the appendix to PPP-B-636.

5.2.3 Industrial. Jackets of one size only, packaged as specified in 5.1.2.1, shall be packed in accordance with ASTM-D-3951.

5.2.3.1 Industrial (Hood). Hoods, packaged as specified in 5.1.2, shall be packed in accordance with ASTM-D-3951.

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5.2.4 Palletization. When specified, (see 6.2), items packed as specified shall be palletized on a 4-way entry, wing-type pallet in accordance with load type 1a of MIL-STD-147. If the container is of a size which does not conform to any of the patterns specified in MIL-STD-147, the pallet used shall first be approved by the contracting officer.

5.3 Marking. In addition to a special marking required by the contractor purchase order, unit packages, intermediate (when specified), and shipping containers and palletized unit loads shall be marked in accordance with MIL-STD-129.

5.4 MIL-STD-2073. When specified (see 6.2), preservation and packing shall be in accordance with MIL-STD-2073-1 and MIL-STD-2073-2.

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 jacket is intended to be worn in moderate to cold temperatures.

6.2 Acquisition requirements. Acquisition documents should specify the following:

a. Title, number and date of this specification.
b. Issue of DODISS to be cited in the solicitation and, if required, the specific issue of individual documents referenced (see 2.1.1).
c. Types, and sizes required (see 1.2)
d. When first article inspection is required, (see 3.1) the item shall be tested and should be a first article sample. The contracting officer should include specific instructions in acquisition documents regarding arrangement for examinations, quantity, and testing and approval.
e. Selection of applicable levels of preservation and packing (see 5.1 and 5.2).
f. When palletization is required (see 5.2.4).

6.3 Samples and patterns. For access to shade samples and patterns, address the procuring activity issuing the invitations for bids.

6.4 Recycled materials. It is encouraged that recycled materials be used when practical as long as the materials meet the requirements of this specification.

6.5 Changes from previous issue. Asterisks are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.

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6.6 Subject term (Key Word) listing.

Hood, fur trimmed
Coat, Low temperature
Quilted lining

Custodian:
Air Force - 82, 99
Navy - AS

Review Activity:
DLA-CT

Preparing activity:
DLA-CT

Project No.
8415-0863

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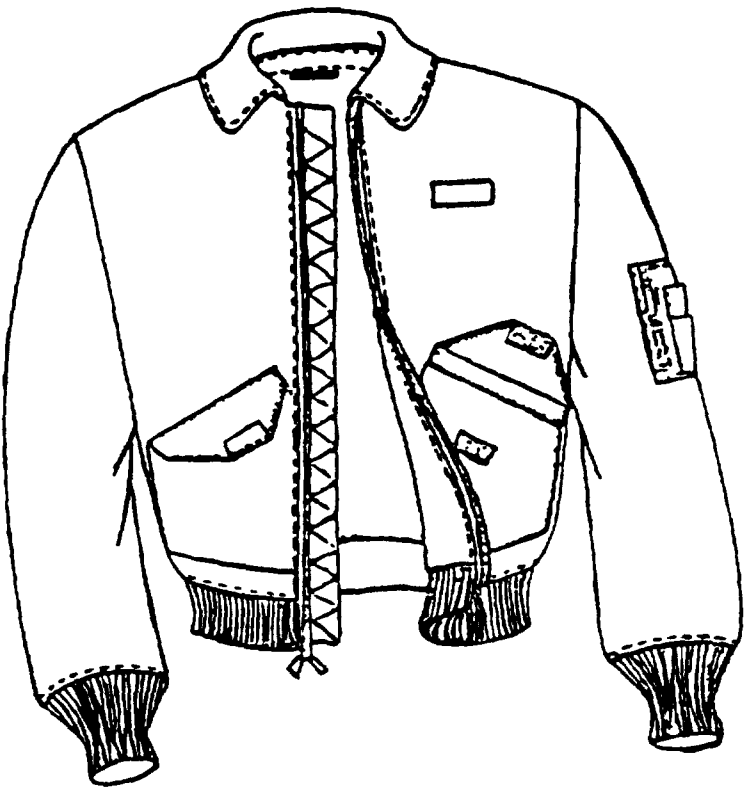

FIGURE 1.

Front view of jacket (without hood).

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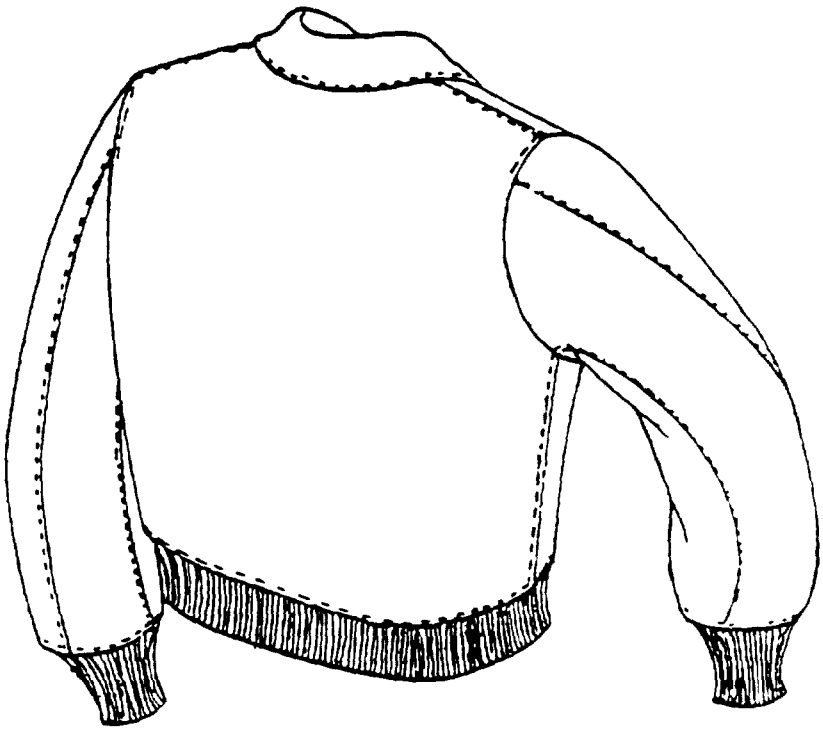

FIGURE 2.

Rear view of jacket (without hood).

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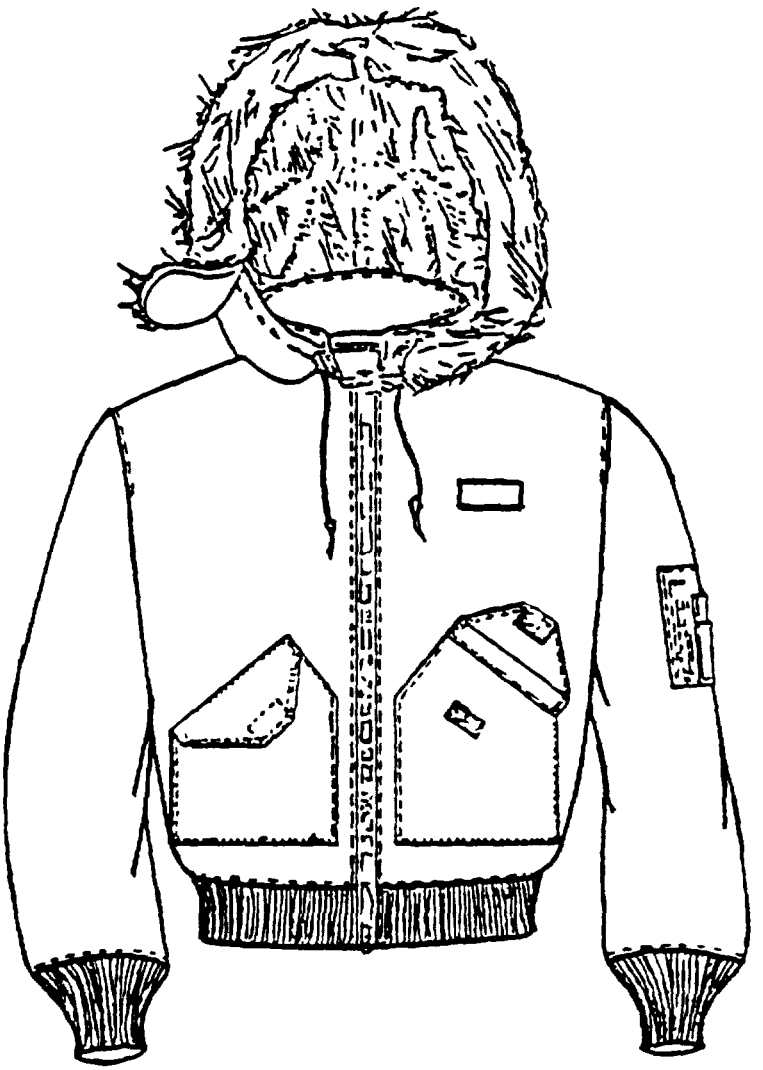

FIGURE 3.

Jacket, front view, with hood attached.

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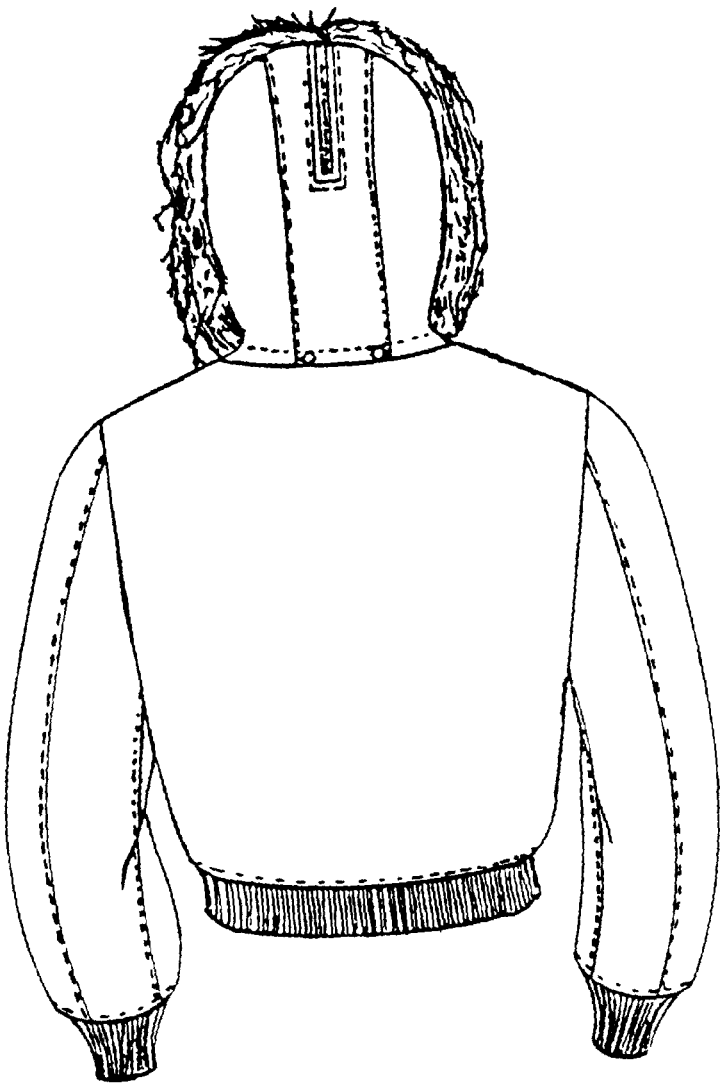

FIGURE 4.

Jacket, rear view, with hood attached.

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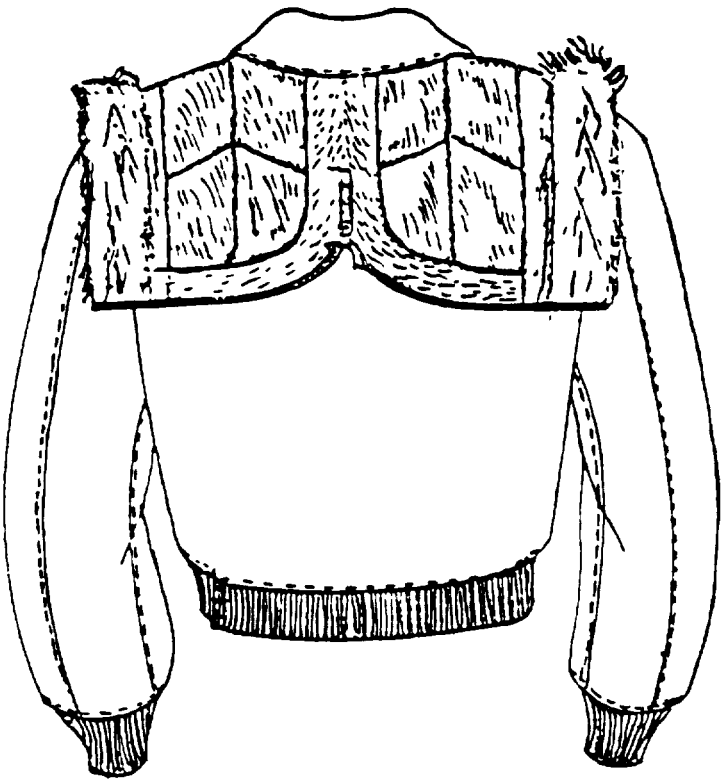

FIGURE 5

Jacket, rear view, with hood attached and opened.

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3. DOCUMENT TITLE
JACKET, FLYER'S COLD WEATHER

4. NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible Attach extra sheets as needed)

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