MILITARY SPECIFICATION

PARKA, EXTREME COLD WEATHER, TYPE N-3B

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

1. Scope

1.1 Scope. This specification covers one type of parka with attached hood, designated type N-3B.

1.2 Classification. Parkas shall be furnished in the following sizes, as specified (see 6.2).

Extra-extra small
Extra small
Small
Medium
Large
Extra large
Extra-extra large

2. APPLICABLE DOCUMENTS

* 2.1 Government documents.

* 2.1.1 Specifications and standards. The following specifications and standards form a part of this specification 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.

SPECIFICATIONS

FEDERAL

A-A-1492	Tape, Gummed, paper, plain.
V-B-871	Button, Sewing Hole, and Button, Staple (Plastic).
V-F-106	Fastener, Slide, Interlocking.
V-T-276	Thread, Cotton.
V-T-295	Thread, Nylon
KK-L-2004	Leather, Cattlehide, Deerskin and Horsehide, Chrome Tanned.
CCC-C-426	Cloth, Cotton, Drill

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: the Engineering Division, San Antonio ALC/MMEDO, Kelly AFB, TX 78241 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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DDD-L-20	Label, for Clothing Equipage, and Tentage, (General Use).
PPP-B-636	Box, Shipping, Fiberboard.

MILITARY

MIL-B-371	Braid, Textile, Tubular
MIL-C-484	Cloth, Wind Resistant Oxford, Cotton, Quarpel Treated.
MIL-C-3735	Cuffs, Knit, Wrist and Ankle, and Cloth, Knitted.
MIL-C-3924	Cloth, Oxford, Cotton Warp and Nylon Filling, Quarpel Treated.
MIL-C-6590	Cloth, Pile (Synthetic Mouton, Knitted).
MIL-F-10884	Fasteners, Snap.
MIL-C-11065	Cloth, Flannel, Wool and Nylon, 16 Ounce, Shrink Resistant.
MIL-C-18387	Cloth, Twill Cotton, Fire Retardant Treated.
MIL-B-41826	Batting, Synthetic Fibers, Polyester, (Quilted and Unquilted).
MIL-C-43191	Cloth, Wind Resistant Sateen, Cotton and Nylon.
MIL-C-43824	Cloth, Synthetic Fur, Knitted.

STANDARDS

FEDERAL

FED-STD-311	Leather, Methods of Sampling and Testing.
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-794	Parts and Equipment, Procedures for Packaging of.

* (Copies of specifications, standards, Drawings, publications, and other Government documents required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting activity.)

* 2.1.2 Other Government documents, drawings, and publications. The following other Government documents, drawings, and publications form a part of this specification to the extent specified herein. Unless otherwise specified, the issues shall be those in effect on the date of the solicitation.

DRAWING

AIR FORCE

64B2251	Parka, Extreme Cold Weather Type N-3B.

2.2 Other publications. The following document forms a part of this specification 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 specified in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS shall be the issue of the non-government documents which is current on the date of the solicitation.

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AMERICAN SOCIETY FOR TESTING AND MATERIAL (ASTM)

ASTM D-3951-82 Packaging, Commercial.

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

LAWS AND REGULATIONS

Rules and regulations under the Wool Product Labeling Act of 1939.

(Application for copies should be addressed to the Superintendent of Documents, Government Printing Office, Washington DC 20402.)

JUSTIFICATION: The information required by this Act is required in 3.6, pg 27.

2.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein (except for associated detail specifications, specification sheets or MS standards), the text of this specification shall take precedence. Nothing in this specification, however, shall supersede applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

* 3.1 First article. When specified, sample parkas shall be subjected to first article inspection (see 4.3 and 6.3).

* 3.1.1 Outer shell. The fabric shall be class 2 of MIL-C-3924, type I of MIL-C-484, or class 2 of MIL-C-43191. (NOTE: When MIL-C-43191 is used, infrared reflectance does not apply.) When MIL-C-3924 is used, the maximum average air permeability shall be 5.0. The color shall be Sage Green (1509).

* 3.1.2 Interlining. The fabric for the interlining shall be batting, type IV, style A, MIL-B-41826, except that the dimensional stability test does not apply.

* 3.1.3 Lining. The fabric for the lining shall conform to MIL-C-18387, shade 1524 except fire retardant, air permeability, cubic feet of air/minute/square foot at 1/2 inch water pressure, and stiffness requirements do not apply.

3.1.4 Pocketing. The fabric for the inner ply of pocketing shall conform to MIL-C-11065, color OG-108.

3.1.5 Drill. The fabric for the interlining in the outer protective flap of the parka shall conform to type I, class 2 of CCC-C-426.

3.1.6 Thread.

3.1.6.1 Nylon. Except for stitching the knitted fabric, the thread for all sewing shall conform to type I or II, class 1, size B of V-T-295. The thread shall match the shade of the outer-shell fabric. The thread shall show good colorfastness to light at 20 standard fading hours and colorfastness to wet-dry cleaning and to perspiration.

3.1.6.2 Cotton. The thread for stitching the knitted fabric shall conform to type IA3, ticket No. 30, 3 ply of V-T-276. The thread shall match the shade of the outer shell fabric. The thread shall show good colorfastness to light, wet-dry cleaning and to perspiration, as specified in the paragraph of V-T-276 titled, Testing of the End Item.

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3.1.7 Hood.

3.1.7.1 Trimming. The hood trimming shall conform to Class 2 of MIL-C-43824 except that the color shall be white.

* 3.1.7.2 Hood lining. The lining shall conform to Type II or Type I of MIL-C-6590 except that the ground fabric shall be synthetic.

* 3.1.7.2.1 Color. The color of the synthetic mouton shall be a good approximation of the approved shade of sage green (see 6.4).

3.1.8 Wristlets. The wristlets shall conform to type I, class 2, size 2 of MIL-C-3735.

3.1.9 Drawstrings and loops. The drawstrings for the hood, the waist adjustments, and the loops on the front closure of the parka shall conform to type II, class 2 of MIL-B-371. The braid shall match the color of the outer-shell fabric. Each drawstring shall be 46 inches long. The ends of the drawstrings shall be tipped or impregnated with cellulose acetate or cellulose acetate butyrate to prevent raveling. The sewn ends need not be tipped. The length of the tipping or impregnation shall be approximately 5/8 $\pm$ 1/8 inch. The color of the tipping or impregnation shall be transparent or approximate the shade of the outer-shell fabric.

3.1.10 Buttons. The buttons shall conform to type II, class D of V-B-871. The front buttons shall be style 20 or 21, size 45 line; the stay buttons shall be style 15, size 18 line. The color of the buttons shall approximate the color of the outer-shell fabric.

* 3.1.11 Leather reinforcement and thongs. The leather used for the reinforcing pieces and the slide fastener thongs shall conform to type III, class 2, selection KK-L-2004, except that the maximum chloroform extract shall not exceed 25 percent, and not less than 80 percent of the specimen tested shall have a minimum stitch tear strength of not less than the values specified below for the thickness ranges shown when tested in accordance with method 2150 of FED-STD-311:

Thickness Range (Ounces)	Stitch Tear Value (Minimum)
Up to 2-1/2	15 lb
Over 2-1/2	25 lb

3.1.11.1 The color of the leather shall be black. The colorfastness to crocking shall be good when tested in accordance with method 3031 of FED-STD-311.

3.1.11.2 The dimensions for the slide fastener thong shall be 3 by 5/8 by 1/4 inches taper cut length.

3.1.12 Snap fasteners. The snap fasteners shall conform to style 2, finish 2 of MIL-F-10884, except that the accelerated weathering test for enamel coating is not required. The color of the exposed portion of the fastener shall approximate the shade of the outer-shell fabric.

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3.1.13 Pencil point protectors. A metal or a plastic pencil point protector shall be placed in the pencil pocket at the bottom of each of the small sections.

3.1.14 Slider. A 4-bar, friction-type, steel or brass slider with a black finish and suitable for a 3/4 inch wide strap shall be provided for adjusting the hood.

3.1.15 Slide fasteners. All slide fasteners shall conform to Table I and to V-F-106. The chain shall be brass, aluminum, or zinc alloy with a short pull tab to accommodate a 3/8 inch wide thong. The tape shall be cotton or cotton warp and nylon filling. The finish of the metal parts shall be natural chromate finish if zinc alloy, black chemical finish if brass, or colored anodized finish if aluminum. The lengths of the slide fasteners shall conform to Table II.

TABLE I. Slide Fasteners.

LOCATION	TYPE	STYLE	SIZE	LENGTH
Front opening	IV	8	MHS	Table II
Cigarette pocket	I	3	LMS 1/	5 inches

1/. The tape shall be 9/16 $\pm$ 1/32 inch wide.

TABLE II. Length of slide fastener.

SIZE	LENGTH (INCHES)
Extra extra small	24-1/2
Extra small	25
Small	25-1/2
Medium	26
Large	26-1/2
Extra large	27
Extra extra large	27-1/2

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3.1.15.1 Color of tape. The tape shall be vat dyed to approximate the shade of the outer-shell material before oxidizing treatment is applied. Darker shades of the treated tapes will be acceptable provided that the shade of the tape before treatments and after dry cleaning meets the preceding requirements.

3.2 Color. Unless otherwise specified, the color of the components of the parka shall be sage green in accordance with the following USAF shade numbers (see 6.4)

Cloth for outer shell	1511
Cloth for lining	1524
* Knitted wool cloth	1525
Wool nap cloth for pocketing	OG-108
Synthetic mouton cloth	5130

3.3 Design. The parka shall be single-breasted. The front closure of the parka shall be a slide fastener, and beneath the slide fastener there shall be a protective flap running the full course of the slide fastener. Another protective flap with a loop and a button closure shall be positioned over the slide fastener. The parka shall incorporate a parka-type, mouton-lined hood with fur face trimming. The size of the hood shall be adjustable by means of a 4-bar, friction-type slider, a takeup strap, and tunneled drawstrings. The waist of the parka shall be adjusted by tunneled drawstrings. The parka shall incorporate two welt-type slash pockets constructed of the outer-shell fabric and closed by snap fasteners. The parka shall also have two lower inside hanging pockets with flaps and snap-fastener closures. Reinforcement patches constructed of outer-shell fabric shall be provided at the elbows of the sleeves.

3.4 Construction. The parka shall be constructed in accordance with table III, however, the exact sequence of operations as listed therein need not be followed.

3.4.1 Stitches, seams, and stitchings. Stitches, seams, and stitchings used in the construction of the parka shall conform to FED-STD-751. Wherever two or more methods of seams or stitches are specified for the same operation, any one of them may be used. Where stitch type 401 is used, the looper (underthread) shall be on the inside of the garment.

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* 3.4.1.1 Type 301 stitching. 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. Ends of a continuous line of stitching shall overlap not less than 1/2 inch. 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 inbedded in the materials sewed.

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

a. When thread breaks, skipped stitches, run-offs, or bobbin runouts occur during sewing, the stitching shall be repaired by restarting the stitch a minimum of 1/4 inch back of the end of the stitching (see NOTE).

b. Except for prestitching, thread breaks, or two or more consecutive skipped or run-off stitches noted during inspection of the item shall be repaired by overstitching. The stitching shall start a minimum of 1/4 inch in back of the defective area, continue over the defective area, and continue a minimum of 1/4 inch beyond the defective area onto the existing stitching. Loose or excessively tight stitching shall be repaired by removing the defective stitching without damaging the materials, and restitching in the required manner (see NOTE).

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

3.4.1.3 Types 401, 501, 502, 503, 515, 516, and 517 stitching. Thread tension shall be maintained so that there will be no loose or excessively tight stitching resulting in puckering of the materials sewn. 301 stitching may be used to repair 401 stitching.

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

3.4.1.5 Thread ends. All thread ends shall be trimmed to 1/4 inch maximum length.

3.4.1.6 Stitches per inch. Unless otherwise specified, a tolerance of plus 2 or minus 1 stitch per inch is permitted.

3.4.1.7 Bartacking. Bartacking shall be 1/2 $\pm$1/6 inch long, 1/8 $\pm$1/32 inch wide and shall contain 28 stitches (minimum). Bartacks shall be free from thread breaks and loose stitching.

3.4.2 Patterns. The manufacturer's working patterns shall be identical in size and shape to the patterns referenced on Drawing 64B2251.

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3.4.2.1 List of pattern parts. The components of the parka shall be cut from materials, as specified herein in accordance with pattern parts required.

PATTERNS PART	NO. TO BE CUT
Outer shell (see 3.1.1)	
Front	2
Back	1
Undersleeve	2
Topsleeve	2
Front Flap	2
Protective Fly	2
Elbow Patch	2
Cuff Reinforcement Piece	2
Tunnel Piece	1
Pencil Pocket	1
Cigarette Pocket	1
Pocket Welt and Facing Lower	4
Pocket Welts Facing-Muff	4
Lower Pocket Flap	4
Hood Facing for Mouton, Left Side	1
Front Hood Strap	1
Back Hood Strap	1
Hood Front Panel	2
Hood Side Panel	2
Hood Center Panel	1
Cowl for Hood	2
Loop for Retaining Hood Draw Cord (No pattern, see operation 1.a)	1
Hanger (No pattern, see operation 21)	1
Interlining (see 3.1.2)	
Front	2
Back	1
Topsleeve	2
Undersleeve	2
Protective Fly	1
Muff-Pocket	2
Lower Pocket	2
Cowl for Hood	1
Lining (see 3.1.3)	
Front	2
Back	1
Topsleeve	2
Undersleeve	2
Pocketing (see 3.1.4)	
Muff Pocket	2
Lower Pocket	2

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Drill (see 3.1.5)

Flap Liner	1

Trimming-Fur (see 3.1.7.1)

Cowl Edge	1

Hood Lining (see 3.1.7.2)

Neck Piece	1
Hood Center Piece	1
Hood Front Panel	2
Hood Side Panel	2

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TABLE III. Sewing Operations

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
1.	CUTTING. The material shall be cut in accordance with patterns that show size, shape, directional lines for cutting, placement of pockets, and notches for proper assembling of all parts. The directional lines for cutting mouton shall not apply.			
*	a. OUTER SHELL. The fabric shall be cut face up or down. Each ply of material shall be laid with the face of the cloth against the back of the next ply below, or as an alternate method, the cloth may be laid face to face. When material is spread face up, no stain producing marking agent shall be used in marking the top ply. The finished parka shall have the face side of the outer-shell fabric on the outer side of the garment. The inside of the roll shall be considered the face side of the material. Cut a 2-1/4 by 2-1/4 inch piece of basic cloth for the loop for retaining the hood draw cord.			
*	b. Except the pocket facings, tunnel, hood loop for cord, hood straps, hood facing for synthetic mouton left side, flap linings and hanger which may be cut from ends, all parts of the outer shell shall be cut from one piece of material.			
*	c. INTERLINING. Cut the quilted fabric by laying each section of the pattern up or down in the direction of the warp, that is, each section of the pattern may be placed with the directional line, pointing in opposite warpwise directions			

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TABLE III. Sewing Operations (Cont's)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	d. DRILL. The cotton drill fabric shall be cut as specified for the outer-shell fabric in operation 1.a.			
	e. HOODLINING. Synthetic mouton shall be marked on the reverse side from the pile side, and the cut shall be made at right angle to the back through the pile.			
	f. At the time of cutting, replace any part containing shade bars, holes, or weakening defects such as smashes, multiple floats, and loose slubs, which are likely to develop into a hole.			
	g. Replace any part damaged during the manufacturing process by needle chews which may be expected to develop into a hole, scissor or knife cuts, tears, holes, mends, or burns.			
	h. Cut the synthetic fur knit cloth in the direction of the wales (lengthwise) 3 ± 1-1/4 inch wide and as required by the length of the cowl. There shall be no piecing.			

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TABLE III. Sewing Operations (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	1. Cut the wool/nylon flannel pocketing in accordance with patterns furnished.			
2.	SHADE MARKING. Except those parts cut from ends as indicated in operation 1b, all component parts shall be marked or ticketed to insure proper assembly of sizes and uniform shade throughout the garment.			
	FRONTS - OUTER SHELL			
3.	POCKETS. The two front slash pockets shall be 7/8 $\pm$ 1/8 inch welt type with 10-1/2 + 1/4 or -1/2 inch opening. Pockets shall finish 9 inches deep.			
*	a. Fold and sew the welt and facing pieces to the pocketing material. The selvage edge need not be turned in. The welt pieces shall extend sufficiently beyond the pocketing.	301	LSd-1 or BSc-1	12
	b. Sew the two pocket pieces on the fronts, at the drill marks, with a double row of stitching.	301	SSv-2	12
	c. Cut the opening for the pockets. Tongue notch each corner.			
	d. Turn the pocketing through the slit; double over at the front the edge for reinforcement to form a 7/8-inch welt. Raise stitch the bottom of the welt with a single row of stitching 1/16 inch from the edge. Sew the tongues at the corners to the welt on the inside, through the welt and the facing with a single row of stitching. The front shall overlap the welt.	301 301	LSq-2(b) SSa-1	12 12

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TABLE III. Sewing Operations (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	e. Raise stitch seam joining the faced pocket piece to the front and the ends of the welt with a single row of stitching 1/16 inch from the edge. The front shall overlap the faced pocket piece.	301	LSq-2(b)	12
	f. Sew around the pocketing with a single row of stitching 1/2 inch from the edge.	301	SSa-1	12
	g. Bartack the corners of the pocket openings with a 7/8-inch bartack at each end.	bartack		28 per bartack
	h. Stamp on two button and the snap sockets, centered with a 1/8-inch tolerance, 3-1/4 inches from each end of the pocket opening. Stamp the studs and the eyelets on the facing to correspond to the button snaps on the welt.			
4.	LOWER POCKETS			
	a. POCKET FLAPS. The flaps shall incorporate a button snap and a socket located at the center with the center of the socket 3/4 inch from the finished edge.			
	b. Sew the flap to the flap lining with a 1/4 inch seam.	301 or 401	SSe-3(a)	12
	c. Turn the flap and edge stitch with a double row of stitching 1/4 inch gage, with outside row of stitching 1/16 inch from edge.	301	SSe-3(b)	12

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TABLE III. Sewing Operations (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	d. POCKETS. The two lower front pockets shall be reinforced on each end with a leather triangular-shaped reinforcement piece. The opening shall be in accordance with the drill marks, and the top of the pocket shall be raised and sewn with a single row of stitching 1/4 inch from the edge. The depth of the pocket shall be 9 $\pm$ 1/2 inch. A stud and an eyelet shall be stamped on the parka to correspond with the button snap and the socket on the flap.			
*	e. Fold and sew the facings to the pocketing material.	301	LSd-1	12
	f. Sew the flaps on the fronts, at the drill marks, with a single row of stitching.	301	LSq-2(a)	12
	g. Sew the pocketing on the fronts, at the drill marks, with a single row of stitching.	301	LSq-2(a)	12
	h. Cut the opening for the pockets. Tongue notch the corners.			
	i. Place the pocketing through the slit, double over at the lower edge of the pocket and raise stitch with a single row of stitching 1/16 inch from the edge through the pocketing and the outer shell, forming a 1/2 inch welt.	301	LSq-2(b)	12
	j. Tongues at the corners shall be sewn to the pocketing on the inside.	301	SSa-1	12
	k. Sew around the edge of the pocketing with a 1/2 inch seam.	301	SSa-1	12

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TABLE III. Sewing Operations (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	m. Bartack the corners of the pocket opening with a 1/2-inch bartack.	Bartack		28 Per Bartack
	n. Sew across the top of the flap of the parka through the pocketing with a single row of stitching 1/16 inch from the edge.	301	LSq-2(b)	12
	p. The corners of the pocket openings shall be reinforced. Cut a 1-1/4 inch square piece of leather through the center to form a triangle. Place the long side of the triangular-cut leather piece parallel with the edges of the pocket flap, and sew all around with a single row of stitching of 1/8 to 1/16 inch from the edge. The leather pieces shall cover the stitching on each end of the pocket.	301	SSa-1	10
* 5.	Alternate Method, join the front and back side seams with a single row of stitching 1/2 inch from the edge with the front overlapping the back raise stitch 1/4 to 5/16 inch gauge, 1/16 inch from the folded edge.	401 or 301	SSa and LSq3b	6-8 12 6-8 12
*	a. Join the front and the back seams with a double lapped seam with the front overlapping the back 1/4 to 5/16 inch gauge, 1/16 inch from folded edge.	301 or 401	LSq-2(b) LSc-2	12 6-8
	b. Position and bartack a 46-inch drawstring to each back side seam of jacket (outer shell) at the notches. The free ends of the drawstring shall face toward the front opening.	bartack		28 per bartack
*	c. Turn the ends of the waist tunnel strip in, and stitch the strip with draw cord inserted across the back between the double row of stitching, 7/8 to 1-inch gage.	301	SSv-2	12

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TABLE III. Sewing Operations (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	SLEEVE - OUTER SHELL			
6.	PENCIL AND CIGARETTE POCKET. The pocket shall be made of outer-shell fabric and shall consist of a bellows-style cigarette compartment, with a vertical fastener closure on the forward side the full length of the pocket and a pencil compartment with four openings, two upper and two lower. The front openings and the rear openings shall be 7/8 ± 1/8 inch wide. The pocket shall finish approximately 5-3/4 inches long and 3-1/2 inches wide, including the slide-fastener tape. The width measurements shall be taken across the top of the pocket.			
	a. Hem the top opening of the pencil compartment in accordance with notches, and sew with a double row of stitching, 1/4 inch gage, 1/16 to 1/8 inch from the edge.	301	EFa-2	12
	b. Fold the pencil pocket at the lower notches to form the two lower openings, and sew with a double row of stitching, 1/4 inch gage, 1/16 to 1/8 inch from the edge.	301	OSf-2	12
	c. Fold the opening to the center notches. Tacking of each edge with a single row of stitching is optional.	301	SSa-1	12
	d. Slit the fold through the center to make pencil pass-through, or the pencil pocket may be made in two pieces.			
	e. Join the pencil compartment to the cigarette 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 notches and the drill marks, with the bottom edge even.	301	LSd-2	12

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TABLE III. Sewing Operations (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	f. Place a single row of stitching between the front edge and the back edge the entire length of the pencil compartment to separate openings.	301	SSv-1	12
	g. Bartack the top ends of all pencil compartment openings, with the bartacks superposed on the inner row of double stitching and on the center row of stitching. Bartacks shall be 3/8 to 1/2 inch long.	Bartack		28 per Bartack
	h. Form a 3/4 inch bellows by joining the two bottom corners with a single row of stitching 1/4 inch from the edge.	301	SSa-1	12
*	i. Seam the slide fastener tape to the forward side of the pocket with a 1/4 inch seam. The slider shall be at the top of the pocket when the fastener is closed.	301	LSq-2(a)	12
*	j. Turn and raise stitch the pocket with a single row of stitching 1/16 inch from the edge of the pocket.	301	LSq-2(b)	12
*	k. Position the front edge of the slide fastener tape to the left sleeve at the drill marks; turn the raw edge of the pocket under 1/4 inch, and stitch all sides with a single row of stitching 1/16 inch from the edge. The slide fastener tape shall be turned under at the top and bottom ends.	301	LSd-1 LSa-1	12
*	m. In lieu of 6.i and 6.j (optional), fold under the front edge of the pocket 1/4 to 3/8 inch, and stitch to the back of the slide-fastener tape 1/16 inch from the folded edge. The slider shall be at the top of the pocket when the slide fastener is closed.	301	LSb-1	12

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TABLE III. Sewing Operations (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
*	n. A second row of stitching shall be placed 1/4 inch from the front edge of the tape and across the top of the pocket.	301	SSa-1	12
	JOIN - SLEEVES			
7.	SLEEVE REINFORCEMENT PATCHES. Turn under raw edge of sleeve patches 1/2 inch and attach to sleeve with a double row of stitching, 1/4 inch gage.	301	LSd-2	12
*	a. Join the sleeve outseam with a double lapped seam with the top sleeve overlapping the under-sleeve, 1/4 to 5/16 inch gage, 1/16 inch from the folded edge.	301 or 401	LSc-2	6-8
	NOTE: Sleeve patches and reinforcement pieces may be pre-hemmed prior to attaching to sleeves with the stitching 1/16 inch from folded edge.			
	b. Turn under raw edge of sleeve reinforcement piece and stitch to bottom of sleeve, in accordance with the notches, 1/16 inch from folded edge.	301 or 401	LSd-1	12
	c. Join the inseams with a double lapped seam with the top sleeve overlapping the undersleeve 1/4 to 5/16 inch gage, 1/16 inch from folded edge.	301	LSc-2	6-8
*	d. Join sleeve to front and back with a 1/2 seam, with front and back overlapping the sleeve raise raise stitch 1/4 inch to 5/16 inch gauge, 1/16 from folded edge.	401 or 301	SSa-1 and LSq3b	12
	PREPARE HOOD - OUTER SHELL			
* 8.	Join the front panel to the side panel with a double lapped seam, 1/4 to 5/16 inch gage, 1/16 inch from the folded edge.	401	LSc-2	6-8

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TABLE III. Sewing Operations (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
*	a. Join the side panels to the crown with a double lapped seam 1/4 to 5/16 inch gage, 1/16 inch from folded edge	301 or 401	LSc-2	6-8
	b. Sew two 1 inch square leather reinforcement pieces to each end of the front panel, centered at the drill marks, with a single row of stitching 1/16 inch from the edge all around. A second row of stitching shall be sewn 1/4 inch from the edge for the hole reinforcement.	301	SSa-2	10
	c. Punch a 1/4 inch hole through the center of the patches and the outer shell.			
9.	Sew the cowl outer shell to the hood in accordance with the notches, with a single row of stitching 1/2 inch from the edge, catching a hood tunnel loop. The loop shall be centered on the hood center panel.	301	SSa-1	12
	a. Thread a 46 inch drawstring through the leather reinforcement patches and hood tunnel loop. Knot each end of the drawstring approximately 2 inches from the threaded or the tipped end.			
	b. Prepare the takeup straps in accordance with the patterns.			
	c. Fold side raw (long) edges, and join edge to edge with a single row of stitching 1/16 inch from the edge; the strap shall finish 4-1/2 inches in length by 5/8 to 3/4 inch in width.	301	EFp-2	12
	d. Insert the 4-1/2 inch strap over the second bar from the square end of the buckle so that the top side end of the strap extends approximately 1/2 inch beyond the underside end.			

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TABLE III. Sewing Operations (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	e. Fold the long end over the short end approximately 1/2 inch and attach to the hood, at the first drill mark from the cowl, with a single row of stitching 1/16 inch from the edge, forming a 1/2-inch box.	301	LSd-1	12
	f. Prepare a 10-inch strap in accordance with patterns; fold side raw (long) edges; join edge to edge with a single row of stitching 1/16 inch from the edge all around with one end of the strap finished clean. The strap shall finish 5/8 to 3/4 inch in width.	301	EFp-2	12
	g. Turn the end of the 10-inch strap under 1/2 inch and attach to the hood at the second drill mark from the cowl with a single row of stitching 1/16 inch from the edge, forming a 1/2-inch box.	301	LSd-1	12
10.	JOIN HOOD TO PARKA. Sew the hood to the parka with a single row of stitching 1/2 inch from the edge.	301	LSq-2(a)	12
	a. Raise stitch seam on the hood with a single row of stitching 1/4 inch from the edge.	301	LSq-2(b)	12
	PREPARE OUTER AND INNER PROTECTIVE FLY			
11.	OUTER FLY. The outer fly shall be fabricated from two plies of outer-shell fabric and one ply of cotton drill.			
	a. Join one ply of the outer-shell fabric to the cotton drill with four rows of parallel stitching with the two center rows equidistant from each other and from the outside rows.	301 or 401	SSv-4	12
	b. Place a single row of stitching 1 inch from the edge of the protective fly on the side opposite that of the loops.	301 or 401	SSv-1	12

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TABLE III. Sewing Operations (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	c. Prepare four loops, fabricated from cotton braid, 3-1/2 inches long. Fold the loops in half and attach to the protective fly, at the notch marks, with a single row of stitching.	301	SSa-1	12
	d. Join the fly pieces together with a single row of stitching 1/2 inch from the edge, on the top and the bottom.	301	SSe-2(a)	12
	e. Turn and raise stitch the fly pieces with a single row of stitching 1/4 inch from the edge.	301	SSe-2(b)	12
12.	INNER FLY. The inner fly shall be fabricated from two plies of outer-shell fabric and one ply of cloth.			
*	a. Join the two plies of the outer-shell fabric to the one ply of quilted cloth, with a single row of stitching 1/2 inch from the edge, on the top along the side and bottom.	301 or 401	SSe-2(a)	12
	b. Turn and raise stitch with a single row of stitching 1/4 inch from the edge.	301	SSe-2(b)	12
	c. Quilt the fly through and through with four rows of parallel stitching with the two center rows equidistant from each other and from the outside rows.	301	SSv-4	12
13.	JOINING OUTER PROTECTIVE FLY. Sew the protective fly to the left forepart of the outer shell in accordance with the notch, and finish joining to the hood seam with a 1/2-inch seam.	301	SSa-1	12
14.	ATTACH SLIDE FASTENER TO OUTER SHELL. Attach the slide fastener to the right and the left front edges of the outer shell approximately 1/2 inch below the raw edge cowl piece with a single row of stitching, 1/2 inch seam. The slide-fastener tape shall be exposed approximately 1/4 inch.	301	SSa-1	12

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TABLE III. Sewing Operations (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	a. The slide fastener shall be attached without excessive length of tape put in at any one point. The tape at the top shall be turned under and finished with no raw edges exposed. The finished bottom of parka shall be even on the right and left fronts.			
	b. Attach a leather thong to the hole in the slider and sew around the top, the bottom, and the sides with a single row of stitching 1/8 inch from the edge, or the thong shall be securely stitched with a crossed box or triangular stitching.	301 automatic machine	SSa-1	10 minimum 28 stitches
15.	JOINING INNER PROTECTIVE FLY. Sew the inner protective fly to the right forepart of the outer-shell fabric in accordance with the marks, with a single row of stitching 1/2 inch from the edge.	301	SSa-1	12
	PREPARE LININGS			
*16.	Sew all pile interlining pieces and the respective lining pieces together all around edges with a single row of stitching 1/4 inch from the edge, in accordance with the notches.	301 or 401 or 502	SSa-1	6-8 6-8
	a. Make a second row of stitching on the fronts and the backs 2 inches above the stitching at the bottom through the two layers.	301 or 401	SSv-1	6-8
	* b. Quilt the front edge, left side of the lining and the interlining, with four rows of through and through parallel stitching, 1/2 inch gage.	301 or 401	SSv-4	6-8
	c. ATTACH LABEL: Position the label at the center of the neck and sew to the lining along all four edges with a single row of stitching 1/16 to 3/16 inch from the edge, 1-1/2 inches (± 1/4 inch) from the neck seam.	301	LSd-1	12
	d. Make the hanger of outer-shell fabric to finish 1/2 inch wide and 3-1/2 inches long.	301	EFp-2	12

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TABLE III. Sewing Operations (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	e. ATTACH HANGER. Position the hanger at the center of neck directly above the label and sew through the interlining and the lining only with a double row of stitching 1/4 inch apart at each end, or bartack may be used at each end in lieu of stitching with the ends turned under.	301 bartack	LSd-2 LSd-1	12 28 per bartack
	f. Join the side seams by overedging and seaming the raw edges together in one operation.	515, 516	SSa-2	12
*	g. SLEEVE LININGS. Sew all pile interlining pieces and the respective lining pieces together, all around the edges, with a single row of stitching 1/4 inch from the edge, in accordance with the notches.	301 or 401	SSa-1	6-8
	h. JOIN SLEEVE LININGS. Join the sleeve inseam by overedging and seaming the raw edges together in one operation	515, 516 or 517	SSa-2	12
*	i. Join the sleeves to arm hole by overedging and seaming the raw edges together in one operation.	515, 516 or 517	SSa-2	12
	j. Join the elbow seam by overedging and seaming the raw edges together in one operation.	515, 516 or 517	SSa-2	12
	k. REINFORCEMENT PIECES FOR WAIST DRAWSTRING. Sew two 1-inch square leather reinforcement pieces, centered at the drill marks, with a single row of stitching 1/16 inch from the edge all around. A second row of stitches shall be sewn 1/4 inch from the edge to reinforce the hole. The leather reinforcement pieces shall be on the nylon lining.	301	SSa-2	10
*	l. Punch a hole through the center of the reinforcement patches and the lining and the pile fabric.			

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TABLE III. Sewing Operations (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	m. Thread the free ends of the drawstrings through the holes in the leather reinforcement openings; knot each free end of the drawstrings approximately 2 inches from the beaded or the tipped ends, leaving the drawstrings on the inside of the garment.			
	n. Serge the prefolded raw edges of the wristlets.	502 or 503	SSa-1	6-10
*	o. Attach the wristlets, at the notches, to the nylon side of the sleeve lining, stitching through and through the nylon and the pile with a double row of stitching.	301	SSa-2	12
	PREPARE HOOD LINING			
17.	Join the front panels to the side panels with a 1/8 inch seam on a fur machine.	501	SSa-1	9
	a. Join the crown to the side panels with a 1/8 inch seam on a fur machine.	501	SSa-1	9
*	b. PREPARE COWL FLAP. Sew the quilted batting strip to the outer-shell fabric, along back edge of cowl strip, with a single row of stitching 1/4 inch from the edge all around. Position the nylon protective pieces on the fur side of the mouton at the left end of the hood. Turn under the back edge of the protective piece and stitch the back and the front edge to the mouton.	301 or 401 301	SSa-1 LSd-1 and SSa-1	6-8 6-8
	c. Join the cowl flap to the mouton lining with a single row of stitching 3/8 inch from the edge.	301	SSa-1	6-10
	JOINING			
18.	JOINING HOOD			
	a. Join the fur hood to the neckline lining with a single row of stitching 1/2 inch from the edge.	301	LSq-2(a)	12

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TABLE III. Sewing Operations (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	b. Turn and raise stitch seam on the lining with a single row of stitching 3/8 inch from the edge. Justification. The joining seam is 1/2 inch wide. If the raise stitching is 1/2 inch from the edge, the turned seam can be missed in the stitching.	301	LSq-2(b)	12
	c. JOIN LININGS. Join the bottom of sleeve linings to the outer-shell, catching the sleeve reinforcement strip at the wrist, with a 1/2 inch seam.	301	SSe-2(a)	12
	d. Join the linings to the outer shell with a 1/2-inch seam all around, leaving an opening at the bottom for turning.	301	SSe-2(a)	12
	e. Join the mouton hood (cowl) fronts to the outer shell hood fronts at the center position for a distance of approximately 4 to 6 inches, with a single row of stitching 3/8 inch from the edge.	301	SSa-1	12
	f. Turn the parka right side out.			
	FINISHING			
19.	Raise stitch fronts of the parka, starting at the bottom circling the parka and finishing at the starting point, with a single row of stitching 1/4 inch from the edge. The parka shall be clean finished at the opening. Close bottom turn through as jacket is raised.	301	SSe-2(b)	12
		301	SSc-1	12
	a. Raise stitch bottom of the sleeves with a single row of stitching 1/4 inch from the edge.	301	SSe-2(b)	12
	b. Quilt the entire length of cowl with four rows of parallel stitching 1/2 to 3/4 inch apart, with the outer row of stitching positioned 1/4 to 3/4 inch from edge of cowl.	301	SSv-4	12

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TABLE III. Sewing Operations (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	c. Make the tunnel to form the channel for the drawstring by stitching 1 inch from the cowl seam and terminating at the outer side of the leather reinforcement pieces.	301	SSa-1	12
*20.	Sew pleats to conform to the shape of the cowl of the hood.	501 or 301	SSa-1	12
	a. Sew the mouton strip to the bottom edge of the fur trimming, on the right side, with a fur machine.	501	SSa-1	9
*	b. Attach the synthetic fur trimming to the shape of the cowl with a single row of stitching 1/8 inch from the edge, all around, including the edges of the mouton strip. The fur trimming shall extend to and finish at the end of the inner protective fly, right side. The ends of the stitching shall be backstitched 1/2 inch at the top edge and the lower edge of the fur trimming on each side of the slide-fastener. There shall be no more than a 1/2 inch open seam on each side of the slide-fastener scoops. As an option, the fur strips may be basted approximately 1/2 inch from the edges, catching the long hair of the fur and holding them away from the edges, to facilitate the stitching of the fur to the hood. After the fur is attached, remove the basting stiches.	301	SSa-1	9
	c. Sew a second row of stitching 1/2 inch from the edge on the end of the fur piece, at the left side front opening, with the hair bent away from the slide-fastener chain and caught in the stitching to prevent obstructing the slide fastener.	301	SSa-1	9
	d. The mouton strip shall butt the mouton hood lining.			
	PLACEMENT OF STUDS, SOCKET, SNAPS, AND EYELETS			
21.	OUTER PROTECTIVE FLY. Stamp a button snap and a socket on the lower end of the fly at the seam joining.			

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TABLE III. Sewing Operations (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
22.	INNER PROTECTIVE FLY. Stamp a stud and an eyelet on the inner protective fly to correspond with the snap and the socket on the outer protective fly.			
*23.	BUTTONS. Sew four 45-line buttons on the right front of the parka at the drill marks. The buttons shall be reinforced by stay buttons. The button shall be sewn through the front and the outer ply of the hanging pocket only. All buttons shall be tightly wrapped to form a shank, and the ends of the thread shall be tacked off. Justification: It is difficult to sew buttons through the outer shell and lining restricts the use of the pocket opening on most sizes.	101 or 301 or hand		22 per button 16 per button 4 - 6 per button (double thread)
24.	CLEANING a. All loose ends of thread shall be trimmed, and loose thread shall be removed. b. Remove all soil or spots. c. Remove the shade-marking tickets.			
25.	FASTENING. Close the slide fastener, fasten the snap fasteners, and button parka.			
26.	NOTE: The letters "l" and "o" are not used to designate subparagraphs in this table because of their similarity to the numerals "1" and "0."			

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3.5 Finished measurements. Finished measurements shall conform to Table IV.

*TABLE IV Finished measurements (in inches).

Measurements 1/	Size							Tolerance	
	Extra Extra Small	Extra Small	Small	Medium	Large	Extra Large	Extra Extra Large	Plus	Minus
Back length	32-3/4	33-1/4	33-3/4	34-1/4	34-3/4	35-1/4	35-3/4	3/4	3/4
1/2 chest	23-1/4	25	26-3/4	28-1/2	30-1/4	32	33-3/4	3/4	3/4
Sleeve inseam	18	18-1/4	18-1/2	18-3/4	19	19-1/4	19-1/2	1/2	1/2

1/ The measurement of the back length shall be taken at the center of the back from the bottom of the hood seam to the finished bottom of the parka.

The measurement for the 1/2 chest shall be taken, with the slide fastener closed, from the folded edge to the folded edge at the base of the armhole.

* The measurement for the sleeve inseam shall be taken along the underarm seam from the armhole to the finished bottom.

* 3.6 Combination size, identification, and instruction label. Each parka shall have a combination size, identification, and instruction label conforming to type VI, class 14 of DDD-L-20. The label shall be securely sewn to the lining of each parka and shall be not less than 1-5/16 inches wide by 3 inches long. The label shall show fastness to dry cleaning and shall contain the following information

Size XXS (example) 1/
Stock No 8415-00-000-0000 (example) 2/
Parka, extreme cold weather type N-3B
Contract No. DLA-100-00-0-0000 (example) 2/
Wool products act (information as applicable) 2/
DRY CLEAN ONLY
DO NOT TUMBLE DRY HOOD WITH SYNTHETIC FUR TRIMMING.
Contractor's name 2/

1/ The sizes (extra extra small, extra small, small, medium, large, extra large, and extra extra large) may be abbreviated as follows XXS, XS, S, M, L, XL, and XXL.

2/ The contractor shall include the applicable information.

* 3.7 Workmanship. The parka shall be constructed in a thoroughly workmanlike manner. The finished parka shall be clean and free from any defects that might affect appearance of functionability.

3.8 Reclaimed materials. The use of reclaimed materials shall be encouraged to the maximum extent possible.

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 as specified herein. Except as otherwise specified

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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 assure supplies and services conform to prescribed requirements.

4.1.1 Responsibility for compliance. All items must 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 assuring that all products and supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling in quality conformance does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to acceptance of defective material.

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

a. First article inspection (see 4.3).

b. Quality conformance inspection (see 4.4).

4.3 First article inspection. When a first article is required (see 6.3), it shall be examined for the defects specified in 4.4.3. The presence of any defect shall be cause for rejection of the first article.

4.4 Quality conformance inspection. Unless otherwise specified, sampling for inspection shall be performed in accordance with MIL-STD-105.

4.4.1 Component and material inspection. In accordance with 4.1, components and materials shall be tested in accordance with all requirements of referenced specifications, drawings, and standards unless otherwise excluded, amended, modified, or qualified in this document. Unless otherwise specified in subsidiary specifications, the following sampling provisions for testing shall apply and the lot shall be unacceptable if one or more units fail to meet any requirements specified:

Lot size (units)	Sample size
800 or less	2
801 to 22,000 inclusive	3
22,001 and over	5

4.4.1.1 Testing criteria. Except for the 4-bar, friction-type slider (see 3.1.14), the unit expressing lot sizes and the sample unit for testing each component shall be in accordance with applicable subsidiary specifications. The lot size shall be expressed as a gross, and the sample unit for testing shall be 15 sets for the 4-bar, friction-type slider.

4.4.2 Examination of end items. The parka shall be examined for the defects listed in 4.4.2.1, 4.4.2.2, and 4.4.2.3. Except for those defects with an asterisk in the classification column, defects found during this examination shall be classified as indicated in 4.2.2.1, 4.2.2.2, and 4.2.2.3. Defects with an asterisk in the classification column shall be classified as a major defect when affecting appearance or serviceability seriously and as minor A defect when affecting appearance or serviceability but not seriously.

4.4.2.1 General defects. General defects shall be classified as follows

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	Classification		
		Minor	
	Major	A	B
1. BARTACKS			
a. Missing, insecure, or misplaced, not serving intended purpose			
- one bartack			X
- two bartacks		X	
- three or more bartacks	X		
2. BUTTONS AND STAY BUTTONS			
a. Not specified size, type, or color			X
b. Missing, loose, or broken			
- one button		X	
- two or more buttons	X		
- one or more stay buttons			X
c. Shank wrapping omitted, loose, or insecure on one or more buttons			X
3. CLEANNESS			
a. Indelible ink shade stamping exposed on outside or spots and stains of permanent nature.		*	
b. Any spot or stain clearly noticeable			
- on outside	X		
- on inside		X	
c. Thread ends not trimmed or one or more shade tickets not removed			X
4. COMPONENT AND ASSEMBLY			
a. Any required operation omitted unless otherwise classified herein		*	
b. Any component part omitted		*	
5. CUTTING			
a. Any component part not cut in accordance with directional lines on patterns or specified requirements		*	

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	Classification		
	Major	Minor A	Minor B
6. DRAWSTRINGS			
a. Not specified type, size, or color		X	
b. End(s) not tipped or impregnated		X	
c. Length of tipped (or impregnated) ends less than 1/2 inch			X
7. LABELS			
a. Combination size, identification, and instruction label.			
- missing or size marking omitted, incorrect, or illegible	X		
- information (other than size) missing, incorrect or illegible			X
- not stitched on four sides to lining			X
b. When information is not incorporated in (combination, size, identification, and instruction labels) missing, incorrect, or illegible			X
8. MATERIAL DEFECTS AND WORKMANSHIP DAMAGES. Material defects and workmanship damages shall be classified as indicated when the condition definitely weakens the fabric. If the defect does not weaken the fabric but is conspicuous when the garment is worn, it shall be classified as indicated. Material defects or workmanship damages that are inconspicuous and definitely do not weaken the fabric shall not be classified as defects.			
a. Any weakening defect such as a hole, smash, multiple float, and loose slub		*	
b. Shade bars, unsightly slubs affecting appearance			
- on outside of garment		*	
- on inside of garment			X
c. Drill hole, cut, tear, mend, burn, or needle chew that may develop into a hole		*	
d. Ruptured fibers in the line of sewing affecting appearance or serviceability		X	
e. Drawstrings weakened by broken or fraying strands.		X	

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	Classification		
	Major	Minor A	Minor B
9. SEAMS AND STITCHING			
a. Accuracy of seaming			
(1) Seam twisted, puckered, or pleated	*		
(2) Part of parka caught in any unrelated operation or stitching	*		
(3) Thread(s) used on outside not same shade or not satisfactorily matching shade of parka		X	
(4) Thread breaks or end(s) of stitching, when not caught in other seams or stitching backtacked less than 1/4 inch		X	
b. Gage of stitching (edge, top, or raise stitching)			
(1) Irregular, i.e., unevenly gaged or corresponding stitchings not uniformly gaged, affecting appearance		X	
(2) Not within range of gage specified or varies more than 1/16 inch when no range is specified			X
c. Open seam. A break in a line of stitching or continuous skipped or runoff stitches (except on edge, top, or raise stitching) shall constitute an open seam.			
(1) Open seam over 1/8 inch to and including 1/4 inch			X
(2) Open seam over 1/4 inch		X	
d. Stitches skipped or broken (on edge, top, or raise stitching when seam is seamed, turned, and stitched)			
- over 1/4 inch to and including 1/2 inch			X
- over 1/2 inch		X	
e. Raw edges. A raw edge is 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, it shall be scored as an open seam.			

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	Classification		
		Minor	
	Major	A	B
(1) On outside			
- over 1/8 inch to and including 1/4 inch			X
- over 1/4 inch		X	
(2) On inside			
- over 1/2 inch to and including 1 inch			X
- over 1 inch		X	
f. Runoffs			
(1) On joining seams, when resulting in an open seam, score as open seam.			
(2) On edge, top, or raise stitching when not resulting in an open seam (outside only)			
- over 1/2 inch to and including 1 inch			X
- over 1 inch		X	
g. Not specified stitch or seam type		X	
h. Stitch tension. Puckering is evidence of tight tension. When puckering is evident, the seam shall be tested by exerting normal pull in the lengthwise direction of seam or stitching.			
(1) Loose tension, resulting in a loose seam	X		
(2) Loose tension on edge, top, or raise stitching, recognized by loosely exposed loops of top or lower thread		X	
(3) Tight tension (stitches break when normal strain is applied to seam or stitching) shall be scored as an open seam.			
i. Stitches per inch (to be scored only when the condition exists on major portion of seam or stitching			
(1) Less than minimum number permitted by minus tolerances by			
- one or two stitches			X
- three stitches		X	
- four or more stitches	X		
(2) One or more stitches in excess of maximum number permitted by plus tolerance			X
10. SHADED PARTS			
a. Outside parts shaded (visible when garment is worn)		*	

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	Classification		
	Major	Minor A	Minor B
b. Lining and inside parts (not visible when garment is worn)			X
11. SLIDE FASTENERS			
a. Not specified type or size		*	
b. Parka part stitched too close to metal chain, not permitting slider to pass	X		
c. Top end of slide-fastener tapes not turned under when stitched		X	
d. Leather thong not securely stitched to pull tab			X
12. SNAP FASTENERS (APPLYING TO ALL SNAP FASTENERS)			
a. Missing, mismated, not securely clinched, or otherwise defective, affecting function - one snap fastener - two or more snap fasteners	X	X	
b. One or more clinched too tightly, i.e., cutting surrounding fabric	X		
c. Rough or sharp edges or one or more studs or sockets		X	

4.4.2.2 Detailed defects. Detailed defects applicable to specific parts shall be classified as follows:

	Classification		
	Major	Minor A	Minor B
1. HOOD			
a. Side panels overlapping front panels			X
b. Side panels overlapping crown			X
c. Fronts or backs lapped on hood at neck joining seam		X	
d. Lining tight, short, or twisted, causing fullness or twist on outside of hood		*	
e. Spacing between rows of quilting stitches on cowl varying by more than 1/4 inch			X

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	Classification		
		Minor	
	Major	A	B
f. Tunnel reinforcement leather pieces stitched to hood with one row of stitching around edges		X	
g. Stitching forming tunnel less than 3/4 inch or more than 1-1/4 inches in the portion paralleling cowl seam			X
h. Tunnel badly twisted in stitching, affecting appearance		X	
i. Drawstrings			
(1) Less than 45-1/2 inches long, unknotted		X	
(2) Not inserted through one or both holes			X
(3) One or both free ends not knotted			X
j. Fur strip			
(1) Not extending to within 3/8 inch from front end of inner protective fly or edge of cowl		X	
(2) Stitching around strip less than 1/8 inch from edge			X
(3) Second row of stitching at left front less than 3/8 inch from edge			X
k. Hood takeup strap			
(1) Buckle omitted or defective, affecting function	X		
(2) Strap less than 5/8 inch wide		*	
(3) Short strap less than 1-1/2 inches in length when stitched		X	
(4) Long strap less than 8 inches when stitched		X	
(5) Tunnel loop omitted		X	
(6) Protective pieces on left side of mouton omitted	X		
2. FRONTS			
a. Buttons and loops out of alignment, causing an excessive bulge when buttoned		X	
b. Buttons out of vertical alignment by 3/8 inch or more			X

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	Classification		
	Major	Minor A	Minor B
c. Stitches on one or both lower buttons caught through hanging pockets restricting use of pocket	X		
d. Loops			
- unequally spaced by more than 3/8 inch		X	
- ends of one or more not securely caught in stitching	X		
- one or more too small, not permitting button to enter	X		
- too long not engaging button securely	X		
e. Snap fasteners on lower end of fly not aligned, causing noticeable bulge or twist when fly is closed		X	
f. Slide fastener			
(1) Tapes set on too loosely or too tightly, causing excessive bulging on opening, affecting appearance		X	
(2) Lengths less than specified in Table II of specification by more than 1/2 inch		X	
g. Slash pockets			
(1) Width of welt less than 3/4 or more than 1 inch			X
(2) Length of welt less than 10 or more than 10-3/4 inches		X	
(3) Bartacks at ends less than 3/4 inch long		X	
(4) Out of alignment with each other by 1/2 inch or more		X	
(5) Sockets and studs not aligned, causing excessive bulge or twist on pocket opening when snapped in		X	
(6) Sockets off-center with center of welt so that rim extends beyond edge or beyond seam		X	
(7) Sockets less than 3 or more than 3-1/2 inches from ends of welts (measured from center of sockets)		X	
h. Spacing between parallel stitching on outer fly through interlining varying by more than 1/4 inch			X
i. Spacing between parallel stitching on inner fly through interlining varying by more than 1/4 inch			X
j. Fronts sagging, twisted, or bulging across chest, caused by tightness of lining or interlining	*		

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	Classification		
		Minor	
	Major	A	B
k. Lower pockets			
(1) Triangular-cut leather reinforcement piece omitted at one or both corners of opening		X	
(2) Depth less than 8-1/2 or more than 9-1/2 inches		X	
(3) Socket off-center of flap by more than 1/4 inch or positioned less than 3/8 or more than 7/8 inch from bottom edge (measurement made from center fasteners)		X	
3. SLEEVES			
a. Sagging, twisted, bulging, or short, caused by shortness, tightness, or incorrect positioning of lining or interlining		*	
b. Back part of sleeve overlapping forepart of sleeve at inseam			X
c. Back part of sleeve overlapping forepart of sleeve at elbow seam		X	
d. Sleeve overlapping body parts at joining seam	X		
e. Knitted wristlets			
(1) Not specified type or color		X	
(2) Twisted in the attachment to sleeve bottom, affecting appearance		X	
(3) Overedge stitching omitted at top edge of one or both wristlets		X	
f. Pencil and cigarette pockets			
(1) Length less than 5-1/2 or more than 6 inches		X	
* (2) Width (including slide-fastener tape) less than 3-1/4 inches. Justification according to the pocket pattern and slide fastener together, the pocket will measure more than 3-3/4 inches.		X	
(3) Set on crookedly, affecting appearance		X	
(4) Hem of pencil-pocket openings stitched with one row of stitching			X

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	Classification		
		Minor	
	Major	A	B
(5) Front or back pencil opening less than 3/4 inch or more than 1 inch wide			X
(6) Pencil compartment piece not double-stitched along front and back edges		X	
(7) Slide fastener not finishing toward front	X		
(8) Ends of slide-fastener tapes not turned under	X		
(9) Top edge pocket and tape not double-stitched to sleeve		X	
(10) Pencil point protector omitted in one or both pockets		X	
(11) Slide fastener stitched to pocket with the slider closing downward		X	
g. Sleeve reinforcement piece			
(1) Twisted or full		X	
(2) Stitched with one row of stitching		X	
h. Sleeve terminal reinforcement strip			
(1) Omitted on one or both sleeves		X	
(2) Ends not terminating at inseam			X
4. BACK			
a. Front overlapping back at side seams			X
5. INSIDE OF PARKA			
a. Hanger			
(1) End(s) not securely stitched and bartacked		X	
(2) Finishing less than 3 or more than 4 inches long			X
(3) Less than 3/8 inch wide			X
(4) Off-center with center of back by 1 inch or more			X
(5) Stitched through outer shell		X	

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	Classification		
		Minor	
	Major	A	B
b. Label			
(1) Positioned less than 1-1/4 inches below neck seam			X
(2) Off-center with hanger by 1/2 inch or more		X	
(3) Stitched through outer shell		X	
c. Body linings			
(1) Stitching across bottom through nylon lining and pile fabric less than 1-1/2 inches or more than 2-1/2 inches from bottom			X
d. Waist tunnel stitching			
(1) Less than 3/4 or more than 1-1/8 inches wide		X	
(2) Rows of stitching irregular in width or crooked		X	
(3) Not extending to within 1/4 inch of both side seams			X
(4) Back excessively puckered or badly twisted by stitching		X	
e. Waist drawstrings less than 45 or more than 47 inches long		X	
f. Tunnel reinforcement leather pieces stitched to lining with one row of stitching		X	

4.4.2.3 End item dimensional examination. Any finished measurement deviating from the measurements specified in Table IV shall be classified as a finished measurement defect. Sleeve lengths uneven by 1/2 inch or more shall be classified as a finished measurement defect.

4.4.2.4 Inspection levels and acceptable quality level (AQL). The inspection level for 4.4.2.1 and 4.4.2.2 shall be II of MIL-STD-105, and the inspection level for 4.4.2.3 shall be S-3 of MIL-STD-105. The AQL for 4.4.2.1 and 4.4.2.2 shall be 2.5 defects per hundred units (dhu) for major defects, 15.0 dhu for major and minor A defects, and 40.0 dhu for major and minor A and B defects. The AQL for 4.4.2.3 shall be 4.0 dhu for defects (one class).

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4.4.3 Inspection of packaging. An examination shall be made to determine that the preservation, 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 packaged except that it need not be sealed. Defects of closure listed below shall be examined on shipping containers fully packaged. The lot size shall be the number of shipping containers in the end item inspection lot. 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.

Examine	Defect
Marking (exterior and interior)	Omitted, incorrect, illegible, of improper size, location, sequence, or method of application.
Materials	Any component missing. Any component damaged, affecting serviceability.
Workmanship	Inadequate application of components, such as incomplete closure of case liners, container flaps loose strapping, or inadequate stapling. Bulging or distortion of containers.
Contents	Number of parkas per container is more or less than required. Size shown on one or more parkas not as specified in intermediate or outer container 1/.

1/ For these defects, one container in the sample shall be examined.

4.4.4 Palletization examination. An examination shall be made to determine that the 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 inspection lot. The inspection level shall be S-1 and the AQL, expressed in terms of defects per hundred units, shall be 6.5.

Examine	Defect
Finished dimensions	Length, width, or height exceeds specified maximum requirement.
Palletization	Pallet patterns not as specified. Interlocking of loads not as specified. Load not bonded with the number of straps specified.
Weight	Exceeds maximum load limits.
Marking	Omitted, incorrect, illegible, of improper size, location, sequence, or method of application.

5. PACKAGING

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5.1 Preservation. Preservation shall be level A, C or Commercial, as specified:

5.1.1 Level A. Each parka shall be folded to approximately 20 inches in width by 16 inches in length. During the folding operation, approximately 1/4 ounce of napthalene flakes shall be evenly distributed within the hood (when natural mouton is used). Each parka shall be placed in a corrugated fiberboard container. The container shall be approximately 20 inches in length, 16 inches in width, and 6 inches in depth and shall conform to type CF, * class domestic, style RSC, minimum bursting strength 200 pounds per square inch (psi) of PPP-B-636. The containers shall be sealed with tape conforming to A-A-1492.

5.1.2 Level C. The level C preservation for parkas shall conform to the MIL-STD-794 requirements for this level. or...

5.1.3 Commercial. The commercial/industrial preservation of parkas shall be in accordance with the requirements of ASTM D 3951.

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

5.2.1 Level A. Four parkas of one size and type only, packaged as specified in 5.1.1, shall be packed in an exterior-type shipping container conforming to type CF-SF, class weather-resistant, grade V3c or V3s, style RSC of PPP-B-636. Closure and strapping shall be in accordance with the appendix of the container specification. The inside dimensions of the container shall be 24 inches long by 20 inches wide by 16 inches deep. Toward the end of the contract or when there are less than the number of the same size required per container, mixed sizes (see 5.3.1) may be packed in the same shipping container.

5.2.2 Level B. Four parkas of one size and type only, packaged as specified in 5.1.1, shall be packed in an exterior container conforming to type CF of SF, class domestic, style RSC, minimum bursting strength 275 psi of PPP-B-636. The inside dimensions of the container shall be 24 inches in length, 20 inches in width, and 16 inches in depth. Containers shall be closed in accordance with method II of PPP-B-636. Toward the end of the contract or when there are less than the number of the same size required per container, mixed sizes (see 5.3.1) may be packed in the same shipping container.

* 5.2.3 Level C. The level C packing for parkas shall conform to the MIL-STD-794 requirements for this level. or...

5.2.4 Commercial. The preserved parkas shall be packed in accordance with the requirements of ASTM M 3951.

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

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5.3.1 Labels, mixed sizes. Each shipping container packed with mixed sizes (see 5.2.1 and 5.2.2) shall have white paper labels, 3 by 4 inches in size, securely attached to the end and side. The words "MIXED NSN'S" shall be plainly stamped or printed on the labels. Under these words, the correct quantity and NSN's contained therein shall be legibly printed or stamped.

5.4 Palletization. Unitized loads, commensurate with the level of packing specified in the contract or order, shall be palletized in accordance with MIL-STD-147. Palletized loads shall be uniform in size and quantities to the greatest extent possible. If the container is of a size which does not conform to any of the pallet patterns specified in MIL-STD-147, the pallet pattern used shall first be approved by the contracting officer.

6. NOTES

6.1 Intended use. The type N-3B parka covered by this specification is intended to be worn in the very cold temperature zone by personnel of Department of Defense.

6.2 Ordering data.

6.2.1 Acquisition requirements. Acquisition documents should specify the following:

a. Title, number, and date of this specification.

b. Size required (see 1.2).

c. When first article sample is required (see 3.1, 4.3 and 6.3).

d. Selection of applicable levels of preservation and packaging and packing.

e. When palletization is required (see 5.4).

6.3 First article. When a first article sample 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 or initial production item. The contracting officer should specify the appropriate type of first article and the number of units to be furnished.

6.4 Figures. Figures 1, 2 and 3 show general style and are for information only.

6.5 USAF color shades. Samples of USAF color shades may be obtained from the procuring activity or as directed by the contracting officer.

6.6 Subject term (key word) listing.

Clothing, extreme cold weather
Hooded garment
Parka, extreme cold weather, type N-3B
Protective clothing

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6.7 Changes from previous issue. The margins of this specification are marked with asterisks (or vertical lines) to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous issue.

Custodians:
Air Force - 99
Army - GL

Review activities:
Air Force - 11
Army - MD
DLA - CT

User activity.
AF - 45

Preparing activity:
Air Force - 82

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FIGURE 1 Front view

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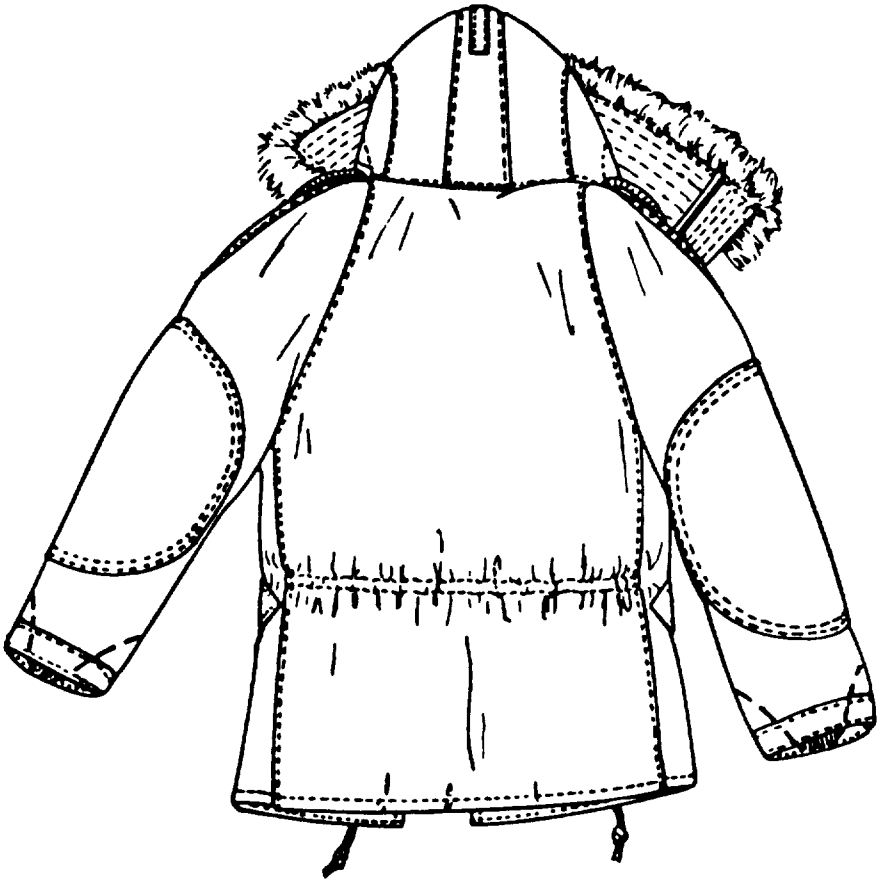

FIGURE 2. Back view, hood up

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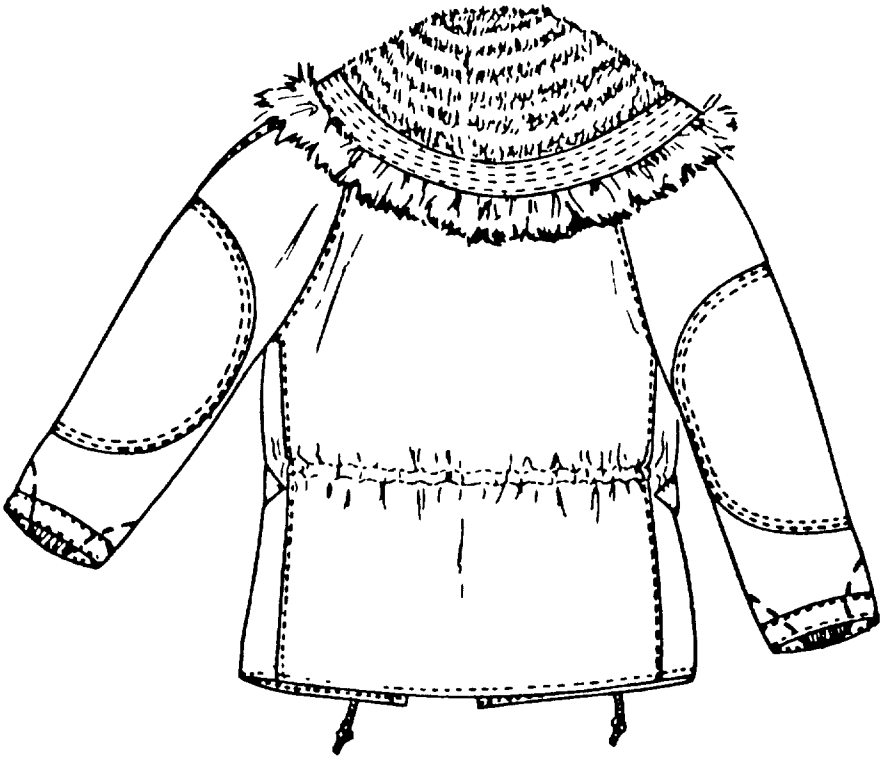

FIGURE 3 Back view, hood down

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NOTE This form may not be used to request copies of documents, nor to request waivers, deviations, or clarification of specification requirements on current contracts Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document*(s)* or to amend contractual requirements

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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions – Reverse Side)

1 DOCUMENT NUMBER	2 DOCUMENT TITLE
MIL-P-6279K	Parka, Extreme Cold Weather, Type N-3B

3a NAME OF SUBMITTING ORGANIZATION	4 TYPE OF ORGANIZATION *(Mark one)*
	☐ VENDOR
	☐ USER
b ADDRESS *(Street, City, State, ZIP Code)*	☐ MANUFACTURER
	☐ OTHER *(Specify)* _____

5 PROBLEM AREAS

a. Paragraph Number and Wording

b. Recommended Wording

c. Reason/Rationale for Recommendation

6 REMARKS

7a NAME OF SUBMITTER *(Last First, MI)* – Optional	b WORK TELEPHONE NUMBER *(Include Area Code)* – Optional
c MAILING ADDRESS *(Street City State ZIP Code)* – Optional	8 DATE OF SUBMISSION *(YYMMDD)*

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