MILITARY SPECIFICATION

PARKA, EXTREME COLD WEATHER, ATTACHED HOOD N-2B

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-2B

1 2 Classification Parka shall be of and furnished in the following sizes, as specified (see 6 2)

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

1 2 1 Part number Specification part number for sizes described in this specification will be formulated as shown in paragraph 6 2

2 APPLICABLE DOCUMENTS

*2 1 Government documents

*2.1.1 Specifications, standards, and handbooks Unless otherwise specified, the following specifications, standards, and handbooks of the issue listed in that issue of the Department of Defense Index of Specifications and Standards (DoDISS) specified in the solicitation form a part of this specification to the extent specified herein

SPECIFICATIONS

FEDERAL

V-B-871	Button, Sewing Hole, and Button, Staple, (Plastic)
V-F-106	Fasteners, 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
CCC-C-440	Cloth, Cheesecloth, Cotton, Bleached and Unbleached

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, Texas 78241 by using the self addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

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SPECIFICATIONS

FEDERAL

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-3735	Cuffs, Knit, Wrist And Ankle, and Cloth, Knitted
MIL-C-4294	Cloth, Twill, Nylon
MIL-C-6590	Cloth, Pile (Synthetic Mouton, Knitted)
MIL-C-8797	Cloth, Taffeta, Nylon Face Wool Back And Cloth, Satin, Rayon Face Wool Back
MIL-F-10884	Fasteners, Snap
MIL-B-41826	Batting, Synthetic Fibers, Polyester (Quilted And Unquilted)
MIL-C-43824	Cloth, Synthetic Fur, Knitted

STANDARDS

Federal

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

(Copies of specifications, standards, handbooks, drawings, and publications required by manufacturers in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting officer)

2.2 Other publications. The following document(s) form a part of this specification to the extent specified herein. The issues of the documents which are indicated as DoD adopted shall be the issue listed in the current DoDISS and the supplement thereto, if applicable

Federal Trade Commission

Wool Products Labeling Act of 1939

(Application for copies should be addressed to the Federal Trade Commission, 6th Street and Pennsylvania Ave. NW, Washington DC 20580.)

*2.2.1 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein, the text of this specification shall take precedence.

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3. REQUIREMENTS

3.1 Data. Unless otherwise specified in the contract or order, no data are required by this specification or any of the documents listed in Section 2 (see 6.2).

3.2 Materials.

3.2.1 Outer shell. The material for the outer shell shall conform to type II, class C of MIL-C-4294 except the pH of water extract shall be between 5.5 and 9.5.

*3.2.2 Interlining. The fabric for the interlining shall be batting, synthetic fibers: polyester, quilted, conforming to type 4, class 3, style A of MIL-B-41826 except that the covering material shall conform to type I, class 2 of CCC-C-440.

3.2.3 Lining. The material for the lining shall conform to type I, class A of MIL-C-4294, except, the pH of water extract shall be between 5.5 and 9.5.

3.2.4 Pocketing. The material for the pocketing shall conform to type II of MIL-C-8797, except that the standard fading hours shall be ten.

3.2.5 Drill. The drill used as the interlining in the outer protective flap of the parka shall conform to type I, class 2 of CCC-C-426

3.2.6 Thread.

*3.2.6.1 Nylon thread. Unless otherwise specified, the thread for all sewing shall conform to type I or II, size E or B of V-T-295. The thread shall match the shade of the outer-shell material. The thread shall show good colorfastness to light at 20-standard fading hours and good colorfastness to wet-dry cleaning and perspiration.

3.2.6.2 Cotton thread. The thread for stitching and top stitching the knitted fabric may be cotton thread conforming to type IA3, ticket No. 30, 3-ply of V-T-276. The thread shall match the shade of the outer-shell material.

*3.2.7 Hood trimming. The synthetic fur knitted cloth strip for the hood trimming shall be 3 inches wide and conform to class 2 of MIL-C-43824 except the color shall be white.

*3.2.8 Hood lining. The hood lining shall be synthetic mouton conforming to type 1 of MIL-C-6590 except that the ground fabric may be constructed of either cotton or polyester yarn. The color of the mouton shall approximate USAF Shade #1530.

*3.2.9 Wristlets and waistband. The material for the wristlets shall conform to type I, class 2, size 2 of MIL-C-3735. The material for the waistband shall conform to class 3 of type I of MIL-C-3735, and the width shall be as specified in Table I.

*3.2.10 Drawstrings and loops. The drawstrings for adjusting the hood and the loops on the parka front closure shall conform to type II, class 2 of MIL-B-371. The braid shall be dyed to match USAF color shade No. 1514. The

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end of the braid shall be tipped or impregnated with cellulose acetate or cellulose acetate butyrate to prevent raveling. (Ends that are sewn need not be tipped.) The length of the tipping or impregnation shall be 5/8 inch (±1/8 inch). The color of the tipping or impregnation shall be transparent or shall match the shade of the outer-shell material. The length of the drawstring shall be 23 inches (± 1 inch).

TABLE I. Width of wasteband (inches).

Size of Parka	Width in direction of courses	Tolerance Plus or Minus
Small	24	1/2
Medium	25	1/2
Large	26	1/2
Extra large	27	1/2
Extra extra large	28	1/2

3.2.11 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 match USAF color shade No. 1511.

*3.2.12 Leather. The leather for the reinforcement pieces and the slide-fastener thongs shall conform to type I, class 2, 2.75 ounces of KK-L-2004 except that colorfastness to crocking shall be fair. The thongs shall be 5 inches long, 3/8 inch wide. The thongs shall be folded on center to finish 2.5 ±1/8 inch long. The color of the leather shall be black.

3.2.13 Snap fasteners. The snap fasteners shall conform to style 2, finish No. 2 of MIL-F-10884, except that the accelerated weathering tests for enamel coating is not required. The color of the visible portion of the fastener shall match the shade of the outer-shell fabric.

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

3.2.15 Slide fasteners. The slide fasteners shall conform to Tables II and III and to V-F-106. The chain shall be brass, aluminum, or zinc alloy, with a long 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 a natural cronak finish, or equal, if zinc alloy, black chemical finish if brass, and a colored anodized finish if aluminum. The length of the slide fastener shall conform to Table III.

*3.2.15.1 Color of tape. The tape shall be vat dyed sage green USAF color shade No. 1511 (see 6.3), and shall show at least fair colorfastness to light and good colorfastness to weathering only.

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TABLE II. Slide fasteners.

Location	Type	Style	Size	Length
Front opening	IV	8	MHS	See Table III
Hood separation	I	3	LMS 1/	See Table III
Cigarette pocket	I	3	LMS 2/	5 inches

1/ The tape shall be 3/4 inch (+1/16, -1/32 inch) wide, and the maximum thickness of the tape shall be 0.030 inch.

2/ The tape shall be 9/16 inch (±1/32 inch) wide.

TABLE III. Length of slide fasteners (in inches)

Size	Front opening	Length hood separation
Small	29-1/2	22
Medium	30	22-1/2
Large	30-1/2	23
Extra large	31	23-1/2
Extra extra large	31-1/2	24

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*3.3 Color. Unless otherwise specified, the color of the components of the parka shall be in accordance with the following (see 6.3):

Outer shell and lining - sage green USAF color shade No 1511
Knit wool - sage green USAF color shade No. 1525
Pocketing, cloth wool napped - sage green USAF color shade No. 1529
Mouton, synthetic - sage green USAF color shade No. 1530
Fur, synthetic - natural white

*3.4 Design. The parka shall be single-brested, shall have a nylon outer shell and nylon lining, and shall be interlined with quilted batting. The parka shall have a straight, front center opening with a slide-fastener closure. A combination cigarette-pencil pocket with a slide-fastener closure shall be located on the left sleeve. A protective flap running the full course of the slide fastener shall be installed over and beneath the front opening slide fastener. The outer flap shall have loops installed to match the buttons located on the right front of the parka. The parka shall incorporate a parka-type hood that is lined with mouton, is trimmed with cloth synthetic knitted fur around the face, and has a slide-fastener separation directly up the center. The waistband and sleeve terminals shall be knit wool. The parka shall have two, welt-type, slash pockets with pass-throughs and snap-fastener closures and two-piece, raglan-type sleeves interlined with quilted batting fabric and lined with nylon.

3.5 Construction. The parka shall be constructed in accordance with Table IV, but the manufacturer is not required to follow the exact sequence of operations as listed therein.

3.5.1 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, 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 parka.

3.5.1.1 Thread breaks and end of seams. Ends of all seams and stitchings, when not caught in other seams or stitchings, shall be securely backstitched not less than 1/4 inch. Thread breaks (all stitch types) shall be secured by stitching back of break not less than 1/2 inch. Skipped stiches or thread breaks (stitch type 401) may be repaired using stitch type 301.

*3.6 Patterns. Standard patterns will be furnished by the government. Standard patterns shall be used by the manufacturer to cut working patterns which shall be identical to the standard patterns. The standard patterns and working patterns shall not be altered in any way.

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TABLE IV. Manufacturing Requirements

No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
1	Cutting. The parka shall be cut in accordance with patterns that show size, shape, placement of pockets, and notches for proper assembly of all parts. Replace at the time of cutting any part containing shade bars, holes, or weakening defects such as smashes, multiple floats, loose slubs, etc., likely to develop into a hole. 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. (a) Outer shell. The nylon twill material shall be cut face up or down. Each ply of material shall be laid with the face of the material against the back of the next ply below, or as an alternate method, the material 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 material on the outer side of the garment. The face side of the material shall be that side of which the twill line runs from the lower left-hand corner to the upper right-hand corner. (b) Except for the inside pocket facings, the hanger, under ply of right protective fly and the under ply of the outer-protective left fly, which may be cut from ends, all outer shell parts shall be cut from one piece of material. (c) Interlining. Cut the quilted batting with directional lines of pattern lying in lengthwise direction.			

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TABLE IV. Manufacturing Requirements

No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
	(d) Lining. All component parts of the nylon material shall be cut from one piece of material, and the material shall be cut face up or down. Each ply of the material shall be laid with the face of the cloth against the back of the next ply 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. (e) Patterns shall be laid in the direction of the warp in accordance with directional lines on patterns for each component part of the parka. (f) Cut the synthetic fur knit cloth in the direction of the wales (lengthwise) 3 + 0.25 inch wide and as required by the length of the cowl. There shall be no piecing. (g) Cut the hood lining, flap interlining and pockets, from the specified materials in accordance with patterns furnished. NOTE: Hood parts may be cut in either the warp or filling directions.			
2	Shade marking. Except for those parts cut from ends as indicated in operation No. 1(b), all component parts shall be marked or ticketed to insure a uniform shade and proper assembly throughout the garment. The pile, drill, and pocketing shall not be shade marked, but shall be bundled or ticketed to insure proper assembly and size control.			

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TABLE IV. Manufacturing Requirements

No	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
3	Pockets. The two front slash pockets shall be 7/8 inch (±1/8 inch) welt type with a 7 1/2 inch (±1/4 inch or -1/2 inch) opening.			
	(a) Position the welt so that the fold line of welt is superimposed on the fold of pocketing indicated by pattern. Fold and sew the welt pieces to the wool-napped side of the larger pocketing, with a single row of stitching. The selvage need not be turned in.	301	LSd-1	12
	(b) Fold the facing pieces approximately 1/2 inch over the raw edge of the pass-through opening of the smaller pocketing and stitch 3/16 to 1/4 inch from the edge, catching all piles 1/16 inch from the edge. The finished portion of the facing shall be finished on the napped side	301	BSf-2(b) (shows finished seam)	12
	(c) Fold and stitch the remainder of the facing pieces to the wool-napped side of the pocketing with a single row of stitching, 1/16 inch from the edge The selvage edge shall not be turned in	301	LSd-1	12
	(d) Fold the pass-through facing, with the folded edge toward the armhole and sew on the fronts at the drill marks with a single row of stitching.	301	LSD-1	12
	(e) Sew the welt and the pocket piece on the fronts at the drill marks, with the raw edge of the pocketing toward the raw edge of the folded pass-through facing.	301	LSq-2(a)	12
	(f) Cut the openings for the pockets. Tongue notch the ends.			

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TABLE IV. Manufacturing Requirements

No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
	(g) Turn the pocketing through the slit, double over at the front edge for reinforcement to form a 7/8 inch welt. Raise stitch the bottom of the welt through the front and the pocketing with a single row of stitching, 1/16 inch from the edges through the welt and the facing. Sew the tongues at the corner to the welt through the ends of the pass-through facing on the inside with a single row of stitching.	301	LSq2(b)	12
	(h) Raise stitch through the ends of the welt and through the fronts at the pass-through facing joining seam with a single row of stitching, 1/16 inch from the edge.	301	LSq-2(b)	12
	(i) Place the bound pocketing 1/2 inch from the welt top stitching and sew around the pocketing with a single row of stitching, 1/2 inch from the edge.	301	SSa-1	12
	(j) Bartack the corners of the pocket opening with a 7/8 inch bartack at each end.	304		42 per bartack
	(k) Stamp the button and the socket, centered with a 1/8 inch tolerance, on the welt of the pocket openings. Stamp the stud and the eyelet on the pass-through facing to correspond to button snap on the welt.			
4	Joining - outer shell. Join the back seam with a single row of stitching, 1/2 inch from the edge. The left back shall finish on top of the right back.	301 or 401	LSq-2(a)	12
	(a) Turn and raise with a single row of stitching, 1/4 inch from the edge.	301 or 401	LSq-2(b)	12

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TABLE IV. Manufacturing Requirements

No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
	(b) Join the side seams with a single row of stitching, 1/2 inch from the edge.	301 or 401	LSq-2(a)	12
	(c) Turn and raise the side seam with a single row of stitching, 1/4 inch from the edge, the back overlapping the front.	301 or 401	LSq-2(b)	12
	NOTE: In lieu of seam type indicated on operations 4, 4a, 4b and 4c, the joining may be performed with a double-lapped seam 1/4 to 5/16 inch gauge - 301 or 401; LSc-2, 12 stitches.			
5	Pencil and cigarette pocket. The pocket shall be made of outer-shell material and shall consist of a bellows-style cigarette compartment with a vertical fastener closure on the forward side of 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 inch (±1/8 inch) wide. The pocket shall finish 5 3/4 inches long and 3 1/2 inches wide, including the slide-fastener tape. The width measurement 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 top 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. Tacking of each edge with a single row of stitching is optional.	301	SSa-1	12

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TABLE IV. Manufacturing Requirements

No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
	(d) Slit the fold through the center to make the 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 edges even.	301	Lsd-2	12
	(f) To separate the openings, place a single row of stitching, between the front and the back edges the entire length of the pencil compartment.	301	SSv-1	12
	(g) Bartack the top ends of all pencil compartment openings with bartacks superimposed on the inner row of double stitching and on the center row of stitching. Bartacks shall be 3/8 to 1/2 inch long.	304		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) Attach 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) Raise stitch the pocket with a single row of stitching, 1/16 inch from the edge of the pocket.	301	LSq-2(b)	12
	NOTE: In lieu of operation 5(i) and 5(j), the front edge of the pocket may be folded under 1/4 to 3/8 inch and stitched 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 fastener is closed.	301	LSd-1	12

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TABLE IV. Manufacturing Requirements

No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
	(k) Attach 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 to 3/8 inch, and stitch to the back edge with a single row of stitching, 1/16 inch from the edge. The fastener tape shall be turned under at the top and the bottom ends only.	301	LSd-1 and LSa-1	12
	(l) 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
	(m) Attach the leather thong by pulling through the hole in the slider, fold in center and sew with a single row of stitching up the center.	301 Automatic machine	SSa-1	10 20 stitches minimum
6	Join sleeves.			
	(a) Sew the inseam of the sleeve with a single row of stitching, 1/2 inch from the edge.	301 or 401	LSq-2(a)	12
	(b) Turn and raise the inseam with a single row of stitching, 1/4 inch from the seamline, with the fore part of the sleeve overlapping the back part of the sleeve.	301 or 401	LSq-2(b)	12
	or			
	(c) In lieu of the seam type indicated in operation No. 6(a) and 6(b), join the sleeve inseam with the topsleeve overlapping the undersleeve with a double-lapped seam sewn with a double row of stitching 1/4 inch to 5/16 inch gage and 1/16 inch from the folded edge.	301 or 401	LSc-2	12

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TABLE IV. Manufacturing Requirements

No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
	(d) Join the sleeve to the front and the back with a single row of stitching, 1/2 inch from the edge.	301 or 401	LSq-2(a)	12
	(e) Turn and raise with a single row of stitching, 1/4 inch from the edge, with the back and the fronts overlapping the sleeve.	301 or 401	LSq2(b)	12
	(f) Sew the sleeve outseam with a single row of stitching, 1/2 inch from the edge.	301 or 401	LSq-1(a)	12
	(g) Turn and raise the elbow seam with a single row of stitching, 1/4 inch from the seamline, with the fore part of the sleeve overlapping the back part of the sleeve.	301 or 401	LSq-2(b)	12
	(h) Sew the prefolded knit wristlet to the bottom of the sleeve with a single row of stitching, 1/2 inch from the edge.	301	SSa-1	8
	NOTE: In lieu of seam type indicated on operations 6d, 6e, 6f and 6g, the joining may be performed with a double-lapped seam 1/4 to 5/16 inch gauge - 301 or 401; LSc-2; 12 stitches.			
7	Prepare wool knit bottom band. Sew the knit facings to each end of the link material, on the open, with a single row of stitching, 1/2 inch from the edge.	301	LSq-2(a)	8
	(a) Turn and raise the seam with a single row of stitching, 1/4 inch from the edge, with the outer shell overlapping the knit material.	301 or 401	LSq-2(b)	8

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TABLE IV. Manufacturing Requirements

No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
	(b) Attach the knit bottom band. Fold the knit bottom band lengthwise and stitch plies of the knit to the bottom of the outer shell with a single row of stitching, 1/2 inch from the edge. The stitching shall start and finish approximately 1 1/2 inches from the facing extension seam. Continue stitching of the bottom outer shell to one ply of knit (unsewn portion) and to the one ply of knit facing extension pieces.	301	SSa-1	8
8	Prepare hood - outer shell. Join the front panels to the side panel with a single row of stitching, 1/2 inch from the edge.	301	LSa-2(a)	12
	(a) Turn and raise the seams on the front panels with a single row of stitching, 1/4 inch from the edge.	301 or 401	LSq-2(b)	12
	(b) Join the side panels to the center hood panel with a single row of stitching, 1/2 inch from the edge.	301 or 401	LSq-2(a)	12
	(c) Turn and raise the seam on the center hood panel with a single row of stitching, 1/4 inch from the edge.	301 or 401	LSq-2(b)	12
	(d) 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, 1/8 inch from the edge all around. A second row of stitching to reinforce the hole shall be sewn 1/4 inch from the edge. An automatic (or double-needle) machine may be used to produce the two rows of stitching simultaneously. NOTE: In lieu of seam type indicated on operations 8, 8a, 8b and 8c, the joining may be performed with a double-lapped seam 1/4 to 5/16 inch gauge - 301 or 401; LSc-2, 12 stitches.	301	SSa-2	10

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No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
	(e) Punch a 1/4 inch hole through the center of the patches and the outer shell.			
	(f) Stamp on one stud portion of the snap-fastener assembly on each seam of the back center panel of the outer shell of the hood through a reinforcement piece as indicated by the marks on the patterns.			
9	Sew the cowl outer shell to the hood with a single row of stitching, 1/2 inch from the edge.	301	SSa-1	12
	(a) Split the cowl and the center panel of the hood up to 1/2 inch from the drill mark and tongue notch the end of the split.			
	(b) Position and bartack a 23 inch drawstring to each panel seam, 1/2 inch upward from the cowl seam, on the inside.	304		28 per bartack
	(c) 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 beaded or tipped end.			
10	Join hood to parka. Sew the hood to the parka with a single row of stitching, 1/2 inch from the edge.	301 or 401	LSq-2(a)	12
	(a) Raise seam on the hood with a single row of stitching, 1/2 inch from the edge.	301 or 401	LSq-2(b)	12

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TABLE IV. Manufacturing Requirements

No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
11	Outer fly. The outer fly shall be fabricated from two plies of outer-shell material and one ply of cotton drill.			
	(a) Position interlining to outer shell. Place a single row of stitching 1 inch from the edge of the protective fly on the side opposite that of the loops.	301	LSs-2	12
	(b) 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
	(c) Join the fly pieces together with a single row of stitching, 1/4 inch from the edge.	301	SSe-2(a)	12
	(d) Turn and raise 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 material and one ply of quilted batting cloth.			
	(a) Join the two plies of outer-shell material to the one ply of quilted batting with a single row of stitching, 1/2 inch from the edge, on the top, along the side, and the bottom.	301	SSe-2(a)	12
	(b) Turn and raise with a single row of stitching, 1/4 inch from the edge, on the top, the bottom, and the outer side.	301	SSe-2(b)	12

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TABLE IV. Manufacturing Requirements

No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
13	Joining outer protective fly. Sew the protective fly to the left forepart of the outer shell in accordance with the notches at the waistband with a single row of stitching, 1/2 inch from the edge.	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 at the notches with a single row of stitching, 1/2 inch from the edge. The slide-fastener tape shall be exposed approximately 1/4 inch. (a) The slide fastener shall be attached without excessive length of tape put in any point. The tape at the top shall be turned under and finished with no raw edges exposed. The finished bottom of the jacket shall be even on the right and the left fronts.	301	SSa-1	12
	(b) Attach the leather thong by pulling through the hole in the slider, fold in center and sew with a single row of stitching up the center.	301 or Automatic machine	SSa-1	10 20 stitches minimum
15	Joining inner protective fly. Sew the inner protective fly to the right forepart; continue sewing the front of the hood and the cowl approximately 3/4 inch from the top raw edge of the cowl pieces in accordance with the marks with a single row of stitching, 1/2 inch from the edge.	301	SSa-1	12

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TABLE IV. Manufacturing Requirements

No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
16	Make hanger. Make one hanger fabricated from outer-shell material. The size of the hanger shall finish 1/2 inch wide and 3 1/2 inches long.	301	EFp-2 or SSc-1 and OSf-1	12
17	Prepare linings. Sew all quilted batting interlining pieces and the respective nylon 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 and LSr-2(a)	7
	(a) Make a second row of stitching on the front and the backs, 2 inches above the first stitching at the bottom, through the two layers.	301	SSv-1	12
	(b) Quilt the front edge left side of the lining and the interlining with 4 rows of parallel stitching 1/2 inch apart.	301	SSv-1	12
	(c) Make pass-throughs. Mark the position of the facing on the right and the left lining fronts, as indicated by the patterns.			
	(d) Place the facing pieces on the lining at the drill mark and sew through the linings, the interlinings, and the facing pieces with a single row of stitching, 1/4 inch from the edge, on each facing.	301	BSf-2(a)	12
	(e) Cut the pocket openings through the linings and the interlinings between the two rows of the stitching of the pocket facings to the inside lining. The ends of the cut shall be tongue notched.			
	(f) The facings shall be turned to the inside, forming a cord edge 1/4 inch wide on each side, and single stitched on the facing, 1/8 inch from the edge all around.	301	BSf-2(b)	12

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TABLE IV. Manufacturing Requirements

No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
	(g) Bartack the corners of the pass-through openings with 1/2 inch bartack	304		28 per bartack
	(h) Join linings. Join the back seam with a single row of stitching, 1/2 inch from the edge.	301 or 401	SSz-3(a)	12
	(i) Turn and raise back seam open, 1/8 inch on each side of the seam, with a single or double needle.	301 or 401	SSz-3(b)	12
	(j) Attach label. Sew the label to the lining along all four edges with a single row of stitching, 1/16 to 3/16 inch from the edge, approximately 1 1/2 inches (±1/4 inch) from the neck stitching, directly below the hanger.	301	SSa-1	12
	(k) Attach hanger. Position the hanger at the center of the 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 a bartack at each end with the ends turned under may be used in lieu of stitching.	301 or 304	LSd-2 or LSd-1	12 or 28 per bartack
	(m) Join the side seam with a single row of stitching, 1/2 inch from the edge.	301 or 401	SSz-3(b)	12
	(n) Turn and raise side seam open, 1/8 inch on each side of the seam, with a single or double needle.	301 or 401	SSz-3(b)	12
	(p) Join sleeve linings. Sew all quilted batting interlining pieces and the respective nylon 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	7

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TABLE IV. Manufacturing Requirements

No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
	(q) Join sleeve lining. Join the inseam of the sleeve with a single row of stitching, 1/2 inch from the edge.	301 or 401	SSz-3(a)	12
	(r) Turn and raise inseam open, 1/8 inch on each side of the inseam, with a single or double needle.	301 or 401	SSz-3(b)	12
	(s) Join the sleeves to the armholes with a single row of stitching, 1/2 inch from the edge.	301 or 401	SSz-3(b)	12
	(t) Spread seam open (except portion of sleeve lining where the quilted batting is cut out) and raise stitch all around on the armhole, 1/8 inch on each side of the seam.	301 or 401	SSz-3(b)	12
	(u) Join the elbow with a single row of stitching, 1/2 inch from the edge.	301	SSz-3(a)	12
	(v) Turn and raise elbow seam open, 1/8 inch on each side of the seam, with a single or double needle.	301 or 401	SSz-3(b)	12
	NOTE: In lieu of seam type indicated on operations 16h, 16i, 16m, 16n, 16q, 16r, 16s, 16t, 16u and 16v, joining may be performed with a safety stitch machine which joins and overlocks in one operation.			
18	Prepare hood lining. 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 center hood piece to the side panels with a 1/8 inch seam on a fur machine.	501	SSa-1	9

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TABLE IV. Manufacturing Requirements

No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
	(b) Prepare cowl flap. Sew the quilted batting strip to the outer-shell material with a single row of stitching, 1/4 inch from the edge all around.	301	SSa-1 LSr-2(a)	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	7
	(d) Split the cowl flap and the mouton lining at the center back panel 1/2 inch from the lower drill mark, and tongue notch the end of the split. The edges of the split on the furred side shall be faced on their entire length with the slide-fastener reinforcement piece. Stitch edge of the reinforcement piece to the split edges of the mouton lining (SSa-1) 1/4 inch from the edge. Turn under the bottom and side edges of the reinforcement piece, and stitch through all plies 1/16 inch from the folded edge.	301	SSa-1 and LSd-1	12
	(e) Insert the slide fastener so that the slider is at the top of the cowl when the fastener is closed. Sew the slide fastener with a single row of stitching, 3/8 inch from the edge. The slide-fastener tape shall be exposed approximately 1/4 inch. When attaching the slide fastener, the excess tape at the top shall be turned under and finished with no raw edges exposed, or the slide fastener may be stitched through the slide-fastener reinforcement piece and the mouton prior to joining the outer shell of the hood to the mouton lining.	301 301	SSj-1 SSa-1	12 12
	(f) Attach the leather thong by pulling through the hole in the slider, fold in center and sew with a single row of stitching up the center.	301 Automatic machine	SSa-1	10 20 stitches minimum

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TABLE IV. Manufacturing Requirements

No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
	(g) The slide fastener shall be attached without excessive length of tape put in at any point.			
19	Joining hood. Join the hood to the lining with a single-row of stitching, 1/2 inch from the edge.	301	LSq-2(a)	12
	(a) Turn and raise seam on the lining with a single row of stitching, 1/4 inch from the edge.	301	LSq-2(b)	12
	(b) Joining linings. Join the linings to the outer shell at the wrist with a single row of stitching, 1/2 inch from the edge.	301	SSq-2(a)	8
	(c) Join the bottom of the lining to the unsewn portion of the knit waistband and knit facing extension piece; continue the stitching of the bottom of the lining to the bottom of the parka with a single row of stitching, 1/2 inch from the edge.	301	SSa-1	8
	(d) Join the linings to the outer shell on both sides of the fronts, the cowl, and the hood 1/2 inch from the edge, leaving an opening in the hood for turning. The tongue notches (hood split) of the outer shell, the quilted batting reinforcement piece shall be turned in and caught in the stitching. (The quilted batting tongue notch may be trimmed.)	301	SSq-2(a)	12
	(e) Join the mouton hood fronts to the outer-shell hood fronts with a single row of stitching, 3/8 inch from the edge.	301	SSq-2(a)	12
	(f) Turn the parka right side out.			

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TABLE IV. Manufacturing Requirements

No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
20	Finishing. Raise fronts of the parka beginning at the hood (both sides of slide fastener) and finishing at the bottom of the waistband with a single row of stitching, turn the raw edges of the opening under in raising operation. The raise stitches on the front of the parka and the cowl pieces shall be 1/4 inch from the edge. The raise stitching on both sides of the split opening of the hood and the ends of the bridge stop shall be made with a double row of stitching, 1/4 inch gage, 1/16 inch from the edge. The tongue notches at the end of the split opening shall be turned under and caught in the stitching.	301	SSe-2(b) and SSq-2(b)	12
	(a) Raise the bottom of the parka with a single row of stitching, 1/4 inch from the edge.	301	SSq-2(b)	8
	(b) Raise the bottom of the sleeves with a single row of stitching, 1/4 inch from the edge.	301	SSq-2(b)	8
	(c) Stamp one snap socket on each outer side of the cowl in accordance with the drill marks. The snap socket shall correspond to the snap stud on the hood.			
	(d) Make the tunnel to form a 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

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TABLE IV. Manufacturing Requirements

No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
21	Prepare synthetic fur trimming. Sew darts on the synthetic for trimming with a fur machine.	501	SSa-1	9
	(a) Sew the mouton strip to the bottom edge of the synthetic fur trimming on the right side. The mouton strip shall butt the mouton lining.	501	SSa-1	9
	(b) Attach the synthetic fur trimming to the cowl with a single row of stitching, 1/8 inch from the edge all around including the mouton strip. The fur synthetic trimming shall extend to and finish at the end of the inner protective fly.	301	SSa01	9
	(c) Sew a second row of stitching 1/2 inch in from the fur edge on the ends of the synthetic fur piece, except on the right side of the front opening, with the hair bent away from the fastener chain and caught in the stitching to prevent obstruction of the slide fastener.	301	SSa-1	9
22	Finish pockets. Join the bound edge of the inner lining to the bound edges of the pocket with a single row of stitching, 1/8 inch from the edge.	301	SSa-1	12
	(a) Join the opposite bound edge of the pocket to the outer shell at the back edge of the pass-through facing and front with a single row of stitching, 1/8 inch from the edge.	301	SSa-1	12

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TABLE IV. Manufacturing Requirements

No.	Description of Operation	Stitch Type	Seams and Stitch Type	Stitches per inch
	(b) Snaps. Stamp on two studs and sockets to the bottom of the parka front closure in accordance with the drill marks.			
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 and shall be sewn through the outer shell and the lining. All buttons shall be tightly wrapped to form a shank, and the ends of the thread shall be tacked off. On sizes where a button (if sewn through all the plies) would restrict the use of the pocket. The buttons shall be sewn through the front and the outer ply of the hanging pocket only.	101 301 Hand		22 stitches 16 stitches 4 to 6 stitches (double thread)
24	Clean parka. All thread ends shall be trimmed and loose thread ends shall be removed. (a) Remove all spots, stains, and shade tickets. (b) Shade tickets shall be removed without damage to fabric. (c) Physical obstructions. The mouton lining at the left front end of the hood shall be trimmed back to a point where the nap cannot reach the fastener chain even when brushed toward it.			
25	Sewing tolerances. The sewing tolerances shall be +0, -1/16 inch for raise seam 1/4 inch gage, +1/32, -0 inch for 1/16 inch from the edges, and ±2 stitches for stitches per inch. NOTE: The letters "l" and "o" are not used to designate subparagraphs in this table because of their similarity to the numbers "1" and "0".			

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

Material	Pattern Part	No. to be cut
Cloth, nylon, type II, class C	Left front	1
	Right front	1
	Left topsleeve	1
	Right topsleeve	1
	Undersleeve	2
	Protective fly (right)	2
	Slide-fastener reinforcement	1
	Front hood panel	2
	Side hood panel	2
	Center hood panel	1
	Hood cowl	2
	Outer protective fly (left)	2
	Pencil pocket	1
	Cigarette pocket	1
	Knit facing	2
	Muff pocket binding	4
	Muff pocket facing	6
	Hanger	No pattern
Cloth, wool nap back synthetic fiber face, type II	Muff pocket - under	2
	Muff pocket - welt	2
Nylon lining, type I, class A	Front	2
	Back	2
	Topsleeve	2
	Undersleeve	2
Quilted batting	Front	2
	Back	2
	Topsleeve	2
	Undersleeve	2
	Protective fly (right)	1
	Cowl	1
Drill, type I, class 2	Protective fly (left)	1
Mouton, type II of MIL-C-6590	Front hood panel	2
	Side hood panel	2
	Center hood panel	1
	Right side hood piece	1
Synthetic fur strip	Left cowl	1
	Right cowl	1

3.7 Finished measurements. The finished measurements of the parka shall conform to Table V.

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TABLE V. Finished measurements (inches)

Measurement 1/	Size					Tolerance	
	Small	Medium	Large	Extra Large	Extra Extra Large	Plus	Minus
Back length	21	21 1/2	22	22 1/2	23	3/8	5/8
1/2 chest	23	25	27	29	32 1/2	1/2	1/2
1/2 bottom	21 1/4	23 1/4	25 1/4	27 1/4	29 1/4	1/2	1/2
Sleeve inseam	16 1/4	16 1/2	16 3/4	17	17 1/4	1/4	3/8

1/ NOTE:

(a) The measurement of the back length shall be taken at the center of the back from the bottom of undercollar seam to the bottom above the knit.

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

(c) The measurement of the 1/2 bottom shall be taken with the slide fastener closed from folded edge to folded edge at the bottom above the knit, or the measurement may be taken with the parka unfastened and spread open from end to end at slide fastener at the bottom of the knit.

(d) The measurement of the sleeve inseam shall be taken along the underarm seam, from the armhole to the seam above the knit.

3.8 Identification of product. Each parka shall have an identification label and shall be marked in accordance with the Wool Products Labeling Act of 1939.

*3.8.1 Label. The combination size, identification and instruction label shall conform to type VI, class 14 of DDD-L-20.

*3.8.1.1 Instructions. The instruction portion of the label shall contain the following information

Dry Clean Only.
Do not tumble dry hood with synthetic fur trimming.

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3.8.2 Wool contents. The legend required by the Wool Products Labeling Act of 1939 may be included in the identification label.

3.9 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 or functionability.

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 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.

4.2 Inspection for quality conformance. Unless otherwise indicated hereinafter, sampling for inspection shall be in accordance with MIL-STD-105.

4.2.1 Testing of components. Except that this specification shall govern in the event of conflict, testing of components shall be made in accordance with the applicable subsidiary specifications and drawings referenced herein in the extent specified.

4.2.1.1 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 specification or applicable purchase 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

4.2.1.2 Testing criteria. The unit for expressing lot sizes and the sample unit for testing each component shall be in accordance with applicable subsidiary specifications.

4.2.1.3 Certificate of compliance. The tipping or impregnation compound specified in 3.2.10 may be accepted on the basis of a suppliers certificate of compliance.

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4.2.2 Examination of end item. The end item shall be examined for defects. Except for defects with an asterisk (*) in the classification column, defects found during examination shall be classified in accordance with 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 a minor A defect when affecting appearance or serviceability, but not seriously.

*4.2.2.1 General defects. General defects shall be classified as follows.

	Classification		
	Major	Minor	
		A	B
Bartacks			
(a) Missing insecure, or misplaced not serving intended purpose:			
- one or two bartacks		X	
- three or more bartacks	X		
(b) Length			
- Less than 3/8 inch (except for pocket openings and pass-throughs)			X
- less than 7/8 inch for pocket openings		X	
- less than 1/2 inch for pass-throughs		X	
Buttons and stay buttons			X
(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
Cleanness			
(a) Indelible ink shade stamping exposed on outside or spots and stains of permanent nature	(*)		
(b) Removable spot or stain, clearly noticeable		X	
(c) Thread ends not trimmed or one or more shade tickets not removed			X
Component and assembly			
(a) Any defective component	(*)		
(b) Any component part omitted	(*)		
(c) Any required operation omitted or improperly performed	(*)		

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	Classification		
	Major	Minor	
		A	B
Cutting			
(a) Any component part not cut in accordance with directional lines on patterns or specified requirement	(*)		
Drawstring			
(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
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) Wool content label (when information is not incorportated in identification label) missing, incorrect, or illegible			X
Material defects and workmanship damages			
Material defects and workmanship damages which are inconspicuous and do not definitely weaken the material shall not be classified as defects. When the condition definitely weakens the material or when the condition does not weaken the material but is conspicuous when the parka is worn, the material defects and workmanship damages shall be classified as:			
(a) Any weakening material defects such as a hole, smash, multiple float, loose slub, etc., that might develop into a hole	(*)		
(b) Shade bars, unsightly slubs, or other nonweakening material defects:			
- on outside of garmet	(*)		
- on inside of garmet			X
(c) Large drill hole, cut, tear, mend, burn, or needle chew that might develop into a hole.	(*)		

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	Classification		
	Major	Minor	
		A	B
(d) Ruptured fibers in the line of sewing (usually caused by broken, blunt, or hooked needles) affecting appearance or serviceability		X	
(e) Drawstrings weakened by broken or fraying strands		X	
Seams and stitching			
(a) Accuracy of seaming:			
(1) Seam twisted, pleated, or badly puckered (Some puckering is an inherent characteristic in joining seams and stitching of nylon cloth parts. This normal puckering shall not be classified as a defect)	(*)		
(2) Part of the garmet caught in any unrelated operation or stitching	(*)		
(3) Thread(s) used on outside not same shade or not satisfactorily matching shade of garmet		X	
(4) Thread breaks or end(s) of stitching, when not caught in other seams or stitching, not securely backstitched		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 continuously skipped or runoff stitches (except on edge, top, or raise stitching) shall constitute an open seam.			
On joining seams:			
- over 1/8 inch to and including 1/4 inch			X
- over 1/4 inch to and including 1 inch		X	
- over 1 inch	X		
(d) Stitches skipped or broken (on edge, top, or raise stitching when seam is seamed, turned, and stitched)			
- over 1/8 inch to and including 1/2 inch			X
- over 1/2 inch		X	

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	Classification		
	Major	Minor	
		A	B
(e) Raw edges A raw edge shall be classified a 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.			
(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) Run-offs			
(1) Run-offs on joining seams, when resulting in an open seam, shall be scored as an open seam.			
(2) On edge, top, or raise stitching when not resulting in open seam (outside only)·			
- over 1/2 inch to and including 1 inch			X
- over 1 inch		X	
(g) Stitch or seam type not as specified		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.			
- 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
Shaded parts			
(a) Outside parts shaded (visible when garmet is worn)	(*)		
(b) Lining and inside parts (not visible when garmet is worn) badly shaded			X

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	Classification		
	Major	Minor	
		A	B
Slide fasteners			
(a) Not type or size specified	(*)		
(b) Garment part stitched too close to metal chain not permitting slider to pass	X		
(c) Top end of fastener tapes not turned under when stitched		X	
(d) Leather thong not securely stitched to pull tab			X
Snap fasteners (applying to all snap fasteners)			
(a) Missing, mismated, not securely clinched, or otherwise defective affecting function			
- one fastener		X	
- two or more fasteners	X		
(b) One or more clinched too tightly, i.e., cutting surrounding fabric	X		
(c) Rough or sharp edges on one or more studs or sockets		X	

*4.2.2 2 Detailed defects. Detailed defects shall be classified as follows:

	Classification		
	Major	Minor	
		A	B
Outside of parka			
Hood			
(a) Side panels overlapping front panels			X
(b) Side panels overlapping center hood panel			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) Tunnel reinforcement leather pieces stitched to hood with one row of stitching around edges		X	
(f) Stitching forming tunnel less than 3/4 inch or more than 1 1/4 inches from the cowl seam			X
(g) Tunnel badly twisted in stitching, affecting appearance		X	

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	Classification		
	Major	Minor	
		A	B
(h) Drawstrings·			
- less than 22 inches long		X	
- not inserted through one or both holes			X
- one or both free ends not knotted			X
- not securely bartacked to panel seam		X	
(i) Synthetic fur strip:			
(1) Fur strip not extending to within 3/8 inch from front end of inner protective fly or edge of cowl		X	
(2) Stitching around fur strip less than 1/8 inch from edge			X
(3) Second row of stitching at the ends less than 3/8 inch from edge			X
(4) Hair not caught in stitching to prevent obstruction of slide fastener		X	
(j) Slide fastener·			
- tapes set on too tightly causing excessive bulging on opening, affecting appearance		X	
- length less than speified in Table III by more than 1/2 inch		X	
(k) Sanp fasteners (stud).			
- out of horizontal alignment by 1/2 inch or more			X
- one or both studs not clinched through panel joining seam		X	
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
(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) Knitted waistband			
- badly twisted		X	
- irregular in width by 1/2 inch or more		X	

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	Classification		
	Major	Minor	
		A	B
(g) Slide fastener·			
- tapes set on too loosely or too tightly, causing excessive bulging or opening, affecting appearance		X	
- length less than specified in Table III by more then 1/2 inch		X	
(h) Slash pockets·			
- width of welt less than 3/4 inch or more than 1 inch			X
- length of welt less than 7 or more than 7 3/4 inches		X	
- out of alignment with each other by 1/2 inch or more		X	
- sockets and studs not aligned, causing excessive bulge or twist on pocket opening when snapped in		X	
- sockets off-center with center of welt so rim extends beyond edge or beyond seam		X	
(i) Fronts sagging, twisted, or buldging across chest caused by tightness or lining or interlining	(*)		
(j) Front overlapping back at side seam			X
Back			
(a) Right back overlapping left back at center seam			X
Sleeves			
(a) Sagging, twisted, bulging, or short, causing shortness tightness, or incorrect positioning of lining or interlining	(*)		
(b) Back part of sleeve overlapping forepart of sleeve at inseams			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 wirstlets·			
- not specified type or color		X	
- twisted in the attachment to sleeve bottom, affecting appearance		X	
(f) Pencil and cigarette pockets			
- length less than 5 1/2 inches or more than 6 inches		X	
- width (including slide-fastener tape) less than 3 1/4 inches or more than 3 3/4 inches		X	
- set on crookedly, affecting appearance		X	
- hem of pencil-pocket opening stitched with one row of stitching			X
- front and back pencil openings less than 3/4 inch wide			X

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	Classification		
	Major	Minor	
		A	B
(f) Pencil and cigarette pockets: (cont)			
- pencil compartment piece not double-stitched along front and back edges			X
- slide fastener not finishing toward front		X	
- ends of fastener tape not turned under		X	
- top edge of pocket and tape not double-stitched to sleeve		X	
- one or both pencil point protectors omitted		X	
- fastener stitched to pocket with slider closing downward		X	
Inside of parka			
(a) Hanger:			
- end(s) not securely stitched or bartacked		X	
- finishing less than 3 inches or more than 4 inches long			X
- less than 3/8 inch wide			X
- off-center with center of back by 1 inch or more			X
- stitchted and bartacked through outer shell		X	
(b) Label:			
- positioned less than 1 1/4 inches below neck seam			X
- off-center with hanger by 1/2 inch or more			X
- stitched through outer shell		X	
(c) Body linings:			
- 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
- quilting stitching along left front not uniform or not properly gauged			
- pass-through opening not aligned with slash opening, causing twist or fullness on outside of parka	(*)		

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4.2.2.3 Finished measurement defects. Any measurement for the back length, the 1/2 chest, the 1/2 bottom, and the sleeve inseam deviating from the finished measurement specified in Table V 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.

4.2.2.4 Acceptable quality levels and inspection levels. The inspection levels shall be II of MIL-STD-105 for 4.2.2.1 and 4.2.2.2 and S-3 of MIL-STD-105 for 4.2.2.3. The acceptable quality level for 4.2.2.1 and 4.2.2.2 shall be 2.5 defects per 100 units for major defects, 15.0 defects per 100 units for major and minor A defects, and 40.0 defects per 100 units for major and minor A and B defects. The acceptable quality level for 4.2.2.3 shall be 4.0 defects per 100 units for defects (one class).

4.3 Packaging Inspection. An examination shall be made to determine if packaging, packing, and marking requirements of Section 5 have been met. The lot size shall be the number of shipping containers in the end items inspection lot. The inspection level shall be S-2 of MIL-STD-105, and the acceptable quality level shall be 2.5 defects per 100 units. The sample unit shall be one sealed shipping container fully packaged. Shipping containers fully packaged shall be examined for defects of closure and shall be scored as follows

Examine	Defect
Marking	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, inadequate stapling. Bulging or distortion of container Polyethylene bag not sealed.
Content	Number per intermediate container is more or less than required.

5. PACKAGING

*5.1 Packaging requirements. Packaging shall be level A or commercial, as specified (see 6.3).

*5.1.1 Level A. Each parka shall be neatly folded to approximately 20 inches in width and 16 inches in length. The folded parka shall be inserted into a snug-fitting clear polyethylene film bag of 0.00125 inch thickness (+ 20 percent). The bag shall be formed with heat sealed seams that are straight, continuous and parallel to each other and the formed edges of the bag. One corner of each bag shall contain a hole, approximately 1/4 inch in diameter, to allow excess air to escape. The bag closure shall be effected by heat sealing with the seal made as close as possible to the open end. As an alternate, the final closure of the bag may be accomplished by means of a tuck or reverse flap.

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*5.1.2 Level commercial. The parkas shall be packaged in accordance with the manufacturer's commercial practice.

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

*5.2.1 Level A. Four parkas of one size, packaged as specified in 5.1 shall be packed in a box constructed, closed, and reinforced to conform to type CF or SF, class Weather-resistant, grade V3c or V3s, style RSC of PPP-B-636. The inside dimensions of the box shall be 24 by 20 by 16 inches. Toward the end of the contract or when there is less than the required number of parkas of the same size required per shipping container, mixed sizes may be packed within the same shipping container (see 5.3.2).

*5.2.2 Level B. Four parkas of one size, packaged as specified in 5.1 shall be packed in a box constructed to conform to type CF (variety DW) or SF, class domestic, grade 275, style RSC of PPP-B-636. The inside dimensions of the container shall be 24 by 20 by 16 inches. Toward the end of the contract or when there is less than the required number of parkas of the same size required per shipping container, mixed sizes may be packed within the same shipping container (see 5.3.2). Closure of each container shall be in accordance with Method II of PPP-B-636.

*5.2.3 Level commercial. Parkas packaged as specified shall be packed in a manner to insure acceptance by the carrier and safe delivery to destination at the lowest transportation rate for such supplies. Containers shall be in accordance with the rules of carriers or regulations applicable to the mode of transportation.

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

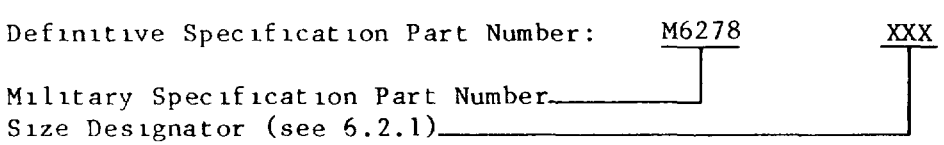
5.3.1 Additional marking. Before sealing the polyethylene bag (see 5 1.1) a paper label shall be placed in the bag so that it is readable through the bag. The label shall be printed black on white and shall contain the stock number, the nomenclature, specification part number, and the quantity of parkas contained therein.

5.3.2 Mixed sizes. A white paper label shall be securely attached to the end and the side of each shipping container that is packed with mixed sizes (see 5.2.1 and 5.2.2). The label shall be 5 inches by 4 inches and shall have the words "mixed sizes" plainly printed thereon and under these words shall be printed correct quantity and size of parkas contained therein.

6. NOTES

6.1 Intended use. The parka covered by this specification is intended for use in very cold temperatures by ground crew personnel carrying tools with belt and security police personnel wearing holsters.

6.2 Definitive specification part number. The specification part number is a definitive part number which will be formulated to identify each size covered by this specification. The part number will be formulated as follows:



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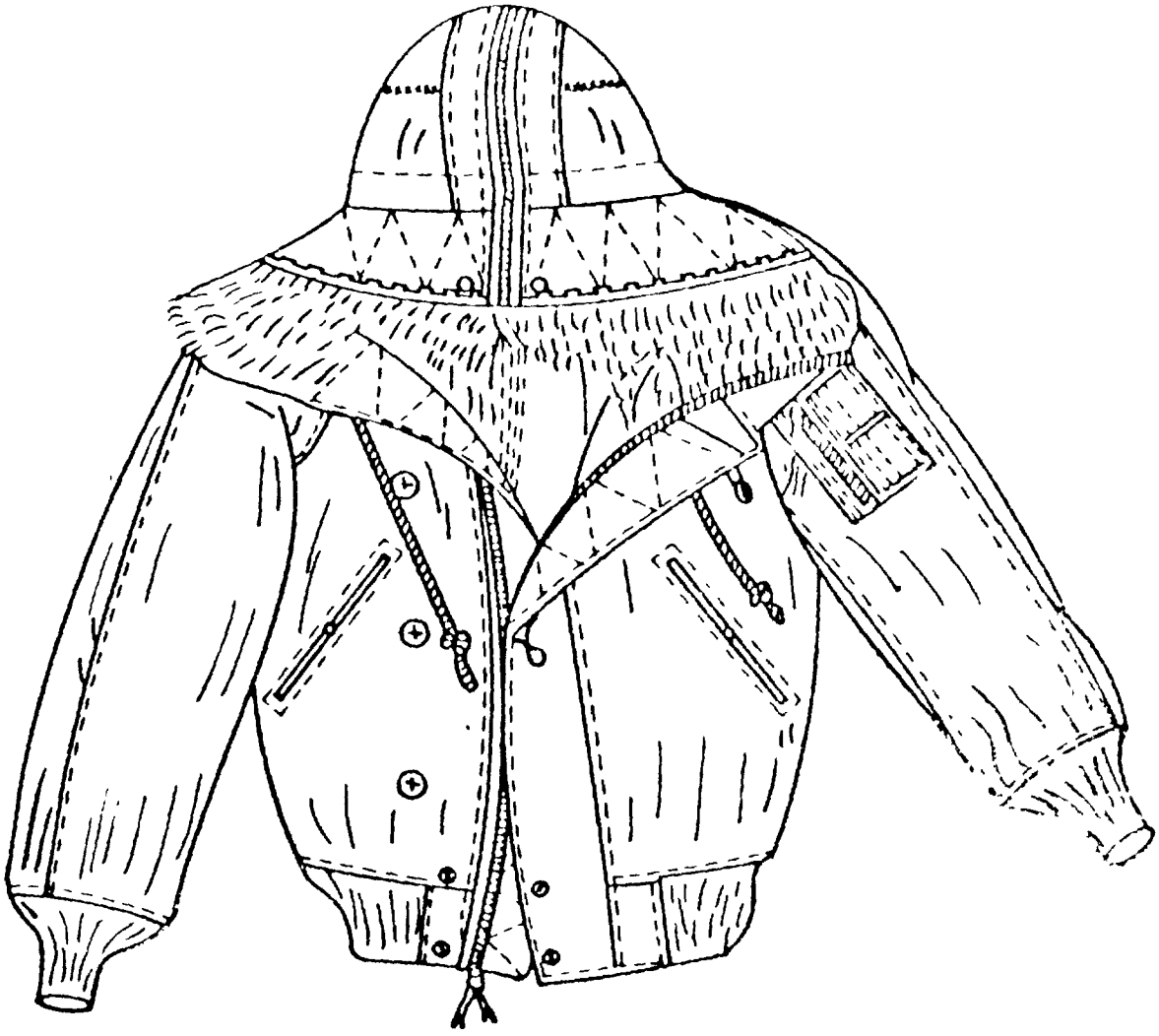

FIGURE 1. PARKA, FRONT VIEW

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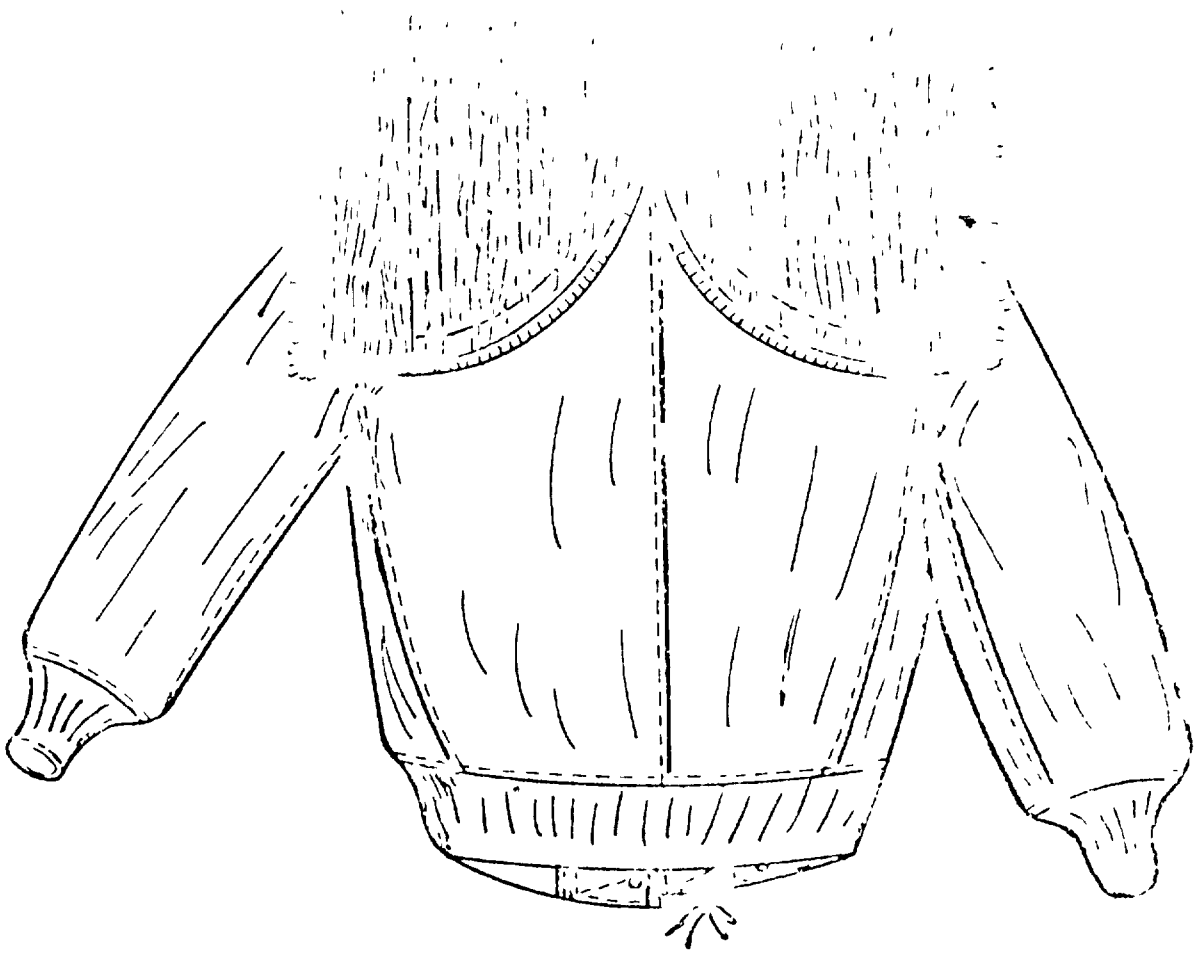

FIGURE 2. PARKA, HOOD DOWN, BACK VIEW

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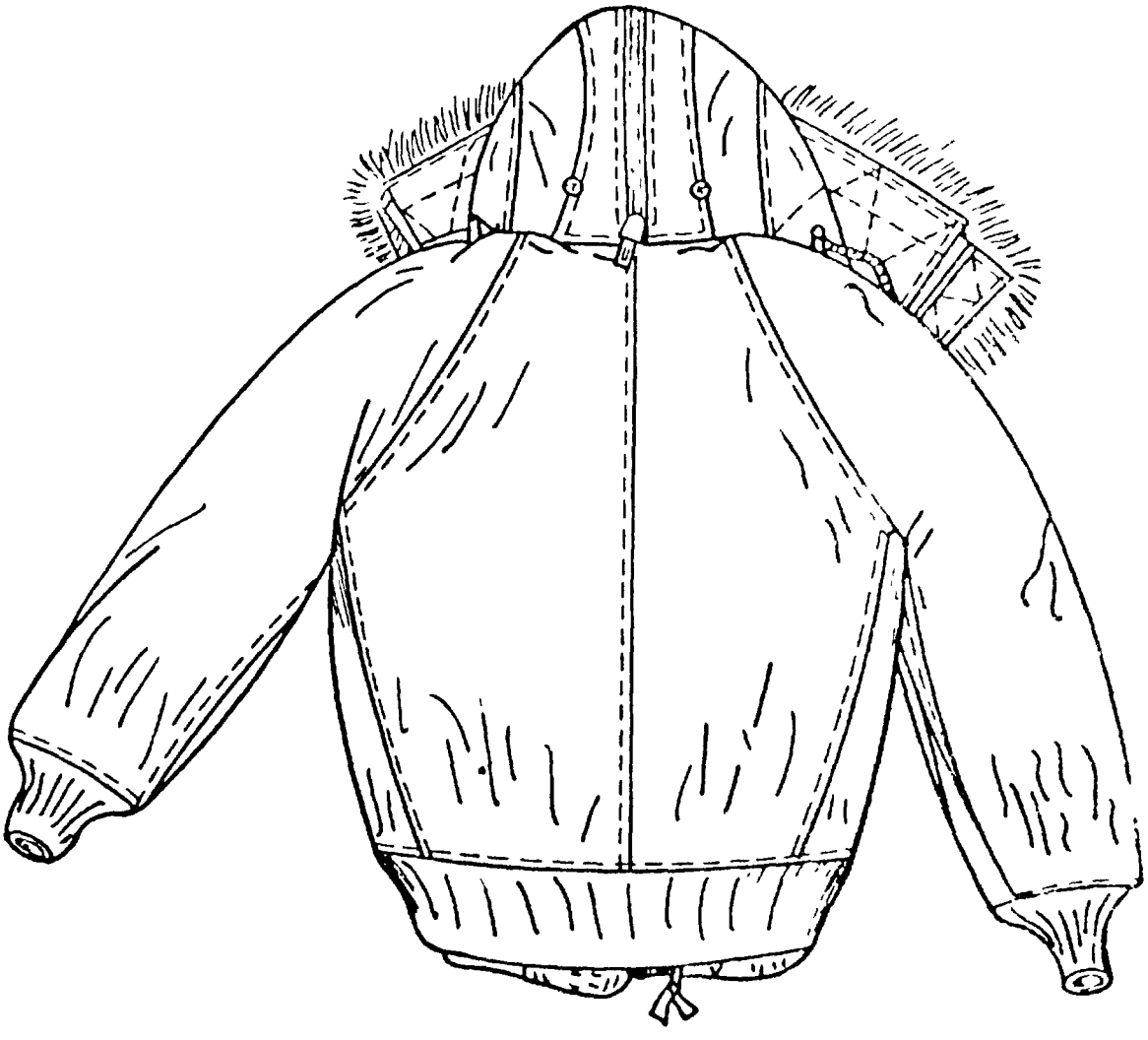

FIGURE 3. PARKA, HOOD UP, BACK VIEW

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6.2.1 Size Designator. A three position field used to designate the required sizes. (See Table VI.)

Table VI.

Size Designator	Remarks
S	Small
M	Medium
L	Large
EL	Extra Large
EEL	Extra Extra Large

6.3 Ordering data. Procurement documents should specify

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

b. Definitive specification part number by size (see 5.3).

c. Data requirements (see 3.1)

d. Applicable level of preservation, packaging, and packing (see 5.1 and 5.2).

6.4 USAF color shades. A sample of USAF color shades may be obtained from the procuring activity or as directed by the contracting officer.

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

6.6 Changes from previous issue. The margins of this specification are marked with an asterisk to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and 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:
Army - GL
Air Force - 99

Review Activities:
Army - MD
DLA - CT

User Activity:
Air Force - 45

Preparing Activity:
Air Force - 82

Project No. 8415-0266

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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

1 DOCUMENT NUMBER	2 DOCUMENT TITLE
MIL-P-6278	PARKA, EXTREME COLD WEATHER, ATTACHED HOOD N-28

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)*

DD FORM 82 MAR 1426

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