MIL-J-83382C
30 October 1981
SUPERSEDING
MIL-J-83382B(USAF)
2 May 1978

MILITARY SPECIFICATION

JACKET, FLYER'S, MEN'S, SUMMER, FIRE RESISTANT, CWU-36/P

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 flight jacket. The jacket is designated CWU-36/P.

1.2 Sizes. The jacket shall be furnished in one of the following sizes as specified (see 6.2):

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

2. APPLICABLE DOCUMENTS

* 2.1 Government documents

* 2.1.1 Specifications, standards, and drawings. Unless otherwise specified, the following specifications, standards, and drawings 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-F-106	Fasteners, Slide, Interlocking.
V-T-276	Thread, Cotton
CCC-C-426	Cloth, Drill, Cotton
DDD-L-20	Label: for Clothing, Equipage, and Tentage, (General Use)
PPP-B-636	Boxes, Shipping, Fiberboard

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: ASD/ENESS, Wright-Patterson AFB, OH 45433, 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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PPP-T-45	Tape, Gummed, Paper, Reinforced and Plain, for Sealing and Securing

MILITARY

MIL-C-3735	Cuffs, Knit, Wrist and Ankle; and Cloth, Knitted
MIL-W-5664	Webbing, Textile, Elastic, Cotton
MIL-F-21840	Fastener Tapes, Hook and Pile, Synthetic
MIL-C-81814	Cloth, Twill, Aramid, High Temperature Resistant
MIL-T-83193	Thread, Aramid, Spun Staple
MIL-C-83242	Cord, Aromatic Polyamide, Nonmelting
MIL-C-83450	Cloth, Meta-Aramid Warp, Meta-Aramid/Para-Aramid Filling, Meta-Aramid/Novoloid Filling, Napped

STANDARDS

FEDERAL

FED-STD-4	Glossary of Fabric Imperfections
FED-STD-191	Textile Test Methods
FED-STD-751	Stitches, Seams, and Stitchings

MILITARY

MIL-STD-105	Sampling Procedures and Tables for Inspection by Attributes
MIL-STD-129	Marking for Shipment and Storage

DRAWINGS

AIR FORCE

70238	Patterns, Jacket, Flying, Men's, Summer, Fire Resistant, CWU-36/P, Miscellaneous, All Sizes
70239	Patterns, Jacket, Flying, Summer, Fire Resistant, CWU-36/P, Size Small
70240	Patterns, Jacket, Flying, Men's, Summer, Fire Resistant, CWU-36/P, Size Medium
70241	Patterns, Jacket, Flying, Men's, Summer, Fire Resistant, CWU-36/P, Size Large
70242	Patterns, Jacket, Flying, Men's, Summer, Fire Resistant, CWU-36/P, Size Extra Large
70243	Patterns, Jacket, Flying, Men's, Summer, Fire Resistant, CWU-36/P, Size Extra Extra Large

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

* 2.1.2 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 Materials

3.1.1 Basic fabric. The material for the outer shell, the hanger, and the slide fastener thong shall conform to MIL-C-81814 and shall be USAF Color Shade No. 1565 (see 6.3).

3.1.2 Lining. The lining shall conform to type I of MIL-C-83450 except that the shade of the lining shall approximate the shade of the basic fabric.

* 3.1.3 Collar interlining. The material for the collar interlining shall conform to type I, class 2 of CCC-C-426.

3.1.4 Thread. Unless otherwise specified herein, the thread for all sewing operations shall conform to MIL-T-83193. As an option, cotton thread may be used for attaching and topstitching the knitted cloth. The cotton thread shall conform to type IA3, ticket No. 30, 3 ply of V-T-276 and shall match the color of the basic fabric.

* 3.1.5 Elastic webbing. The elastic webbing for the back shall be class 1, 1 inch wide, minimum of 0.035 inch thick, color optional of MIL-W-5664.

3.1.6 Slide fasteners. The slide fasteners shall conform to the requirements of V-F-106 and of table 1 of this specification. The chain and any other metal components except the latch and spring of the automatic slider of the slide fastener shall be brass with a black chemical finish. The slide fastener tapes shall be a high temperature resistant, nonmelting polyamide and shall be dyed so that the color of the tapes will approximately match the color of the basic fabric. The tape shall not shrink more than 2 percent in the direction of the warp. The slider on the slide fastener for the front opening shall have a long tab pull with a 1/2-inch-wide thong that is fabricated from the basic fabric. The slider on the slide fastener for the cigarette and pencil pocket shall have a short tab pull.

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

* 3.1.8 Fastener tape. Except for the fastener tape for the nameplate, the fastener tape shall be 1 inch wide. The fastener tape for the nameplate shall be 2 inches wide. The fastener tape shall conform to type I, class 1 of MIL-F-21840. The color of the fastener tape shall approximate the color of the basic fabric.

* 3.1.9 Cord beading. The cord beading in the edges of the slide fastener covers shall conform to type I of MIL-C-83242.

* 3.1.10 Fusible interlining. The fusible interlining shall conform to Style No. SF 134 (manufactured by the Pellon Corporation; 1120 Avenue of the Americas; New York, New York 10036), or equal.

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TABLE I. Slide fasteners.

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

TABLE II. Width of waistband material.

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

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

* 3.2 Design. The jacket shall be lined, shall be single breasted, shall have a bias-cut back, and shall have a straight center front opening with a slide fastener closure. The jacket shall have a cigarette and pencil pocket on the left sleeve and two front (patch) pockets that have envelope storm flaps. The cigarette and pencil pocket shall have a bellows-style cigarette compartment with a covered vertical slide fastener closure, on the forward side, the full length of the pocket and four pencil compartment openings, two upper and two lower. Closure of the flaps of the front pockets shall be effected with hook and pile fastener tape. The jacket shall have a knitted wristlet on each sleeve and shall have a knitted waistband.

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3.3 Construction. The jacket shall be constructed in accordance with table III, however, the manufacturer will not be required to follow the exact sequence of operations as listed therein.

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

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

3.3.1.2 Sewing tolerances. A tolerance of plus or minus 1/16 inch will be permitted for 1/4-inch-gage and 5/16-inch-gage stitching. A tolerance of plus 0 or minus 1/8 inch will be permitted for 3/8-inch-gage stitching. A tolerance of plus or minus 1/16 inch will be permitted for raise seam 1/4-inch gage. A tolerance of plus 1/32 or minus 0 inch will be permitted for stitching 1/16 inch from the edge. Unless otherwise specified herein, a tolerance of plus or minus 2 stitches per inch will be permitted for stitches per inch.

3.3.2 Corded beading in slide fastener covers. The edges of the slide fastener covers shall have a cord beading. The outer beaded cloth edges of the slide fastener closures shall be flush with the slide fastener scoops. The scoops, when locked together, shall be completely concealed by the beaded covers.

* 3.3.3 Cutting. The jacket shall be cut from the materials specified herein in accordance with the pattern parts that are listed in table IV.

3.4 Patterns. The manufacturer's working-patterns shall be identical in size and shape to the applicable patterns referenced on Drawings 70238 through 70243. Unless otherwise specified on the drawings, the patterns provide a seam allowance of 1/2 inch.

3.5 Finished measurements. The finished measurements of the jacket shall conform to table V. The finished measurements of the jacket shall be taken as follows: Measure the back length, at the center of the back, from the bottom of the undercollar seam to the bottom above the knit. Measure the 1/2 chest at the base of the armhole, with the slide fastener closed, from folded edge to folded edge. Measure the sleeve inseam, along the underarm seam, from the armhole to the seam above the knit.

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TABLE III. Sewing operations.

	No.	Description of Operation	Stitch Type	Seam and Stitch Type	Stitches Per Inch
*	1	Cut parts			
*		(a) Lay the cloth in uniform lengths, taking care to spread the material so that the plies will not be stretched or full and so that one side of the lay will be even. Lay the patterns in accordance with the directional lines (warp direction) indicated on the patterns.			
*		(b) Cut the parts of the jacket in strict accordance with the patterns. Unless otherwise specified herein, cut all parts of the basic fabric from one piece of material. The hanger, the flap linings, and the undercollar may be cut from ends of the basic fabric provided the parts approximate the shade of the parts that are cut from the basic fabric. Unless otherwise specified herein, cut the parts of the lining from one piece of material and so that the satin face will be on the outside of the lining. The sleeve linings may be cut from ends provided the sleeve linings match each other.			
*		(c) Cut the elastic webbing for the back to conform to the following length: 19-1/4 inches for the size small, 20 inches for the size medium, 20-3/4 inches for the size large, 21-1/2 inches for the size extra large, or 22-1/4 inches for the size extra extra large.			

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TABLE III. Sewing operations. - Continued

	No.	Description of Operation	Stitch Type	Seam and Stitch Type	Stitches Per Inch
*	2	Shade mark parts			
		(a) Mark, ticket, or bundle all parts of the basic fabric and of the lining, except parts cut from ends, to insure a uniform shade and size throughout the jacket. The marking may be any method except adhesive-type tickets that will leave traces of paper or adhesive on the material after the tickets are removed or metal fastening devices.			
*	3	Replace damaged or defective parts			
		(a) Take care during the spreading, cutting, and manufacturing operations to exclude or replace any material that contains material defects or workmanship damages that could affect the appearance or serviceability of the jacket.			
	4	Make two front pockets			
*		(a) Fold the top slanted end of each pocket to the inside 1-3/4 inches. Join with a single row of stitching 1/16 inch from the top folded edge.	301	OSf-1	12
		(b) Turn the raw edge under 1/4 inch, and join with a single row of stitching 1/16 inch from the folded edge.	301	LSd-1	12

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TABLE III. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitch Type	Stitches Per Inch
*	(c) Join one piece of the hook fastener tape, 1 inch by 2 inches, to the outer side of each pocket at the marked location, with a single row of stitching 1/16 inch from the edge on all four sides.	301	LSbj-1	12
*	(d) Join one piece of pile fastener tape, 1 inch by 2 inches, to the underside of each flap at the marked location with a single row of stitching 1/16 inch from the edge on all four sides.	301	LSbj-1	12
*	(e) Join each flap at the ends, the top, and the slanted sides, with a single row of stitching 1/4 inch from the edge, with the face sides together.	301	SSe-3(a)	12
	(f) Turn and raise with a double row of stitching 1/16 inch from the folded edge 1/4-inch gage.	301	SSe-3(b)	
*	(g) Join each pocket flap to the fronts at the marked location with a single row of stitching.	301	LSbj-1	12
*	(h) Turn the raw edges of each pocket flap under 1/4 inch, and sew with a single row of stitching 1/16 inch from the folded edge.	301	LSd-1	12
	(i) Turn the pocket raw edges under 1/2 inch at the sides and the bottom. Join with a single row of stitching 1/16 inch from the folded edges, ending the stitching 1/2 inch below the flap joining seam.	301	LSd-1	12

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TABLE III. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitch Type	Stitches Per Inch
*	(j) Fold the top extended raw edge of each pocket to the inside 1/2 inch, and join to the pocket flap across the ends with a double row of stitching 1/16 inch from the folded edge 1/4-inch gage.	301	SSa-2	12
*	(k) Fold each pocket flap down, and raise with a single row of stitching 1/8 inch from the folded edge.	301	LSq-2(b)	12
5	Join fastener tape for nameplate			
	(a) Position a 2-inch by 4-inch piece of pile fastener tape for the nameplate above the left front pocket at the pattern marks; join on all four sides 1/16 inch from the edge with a single row of stitching.	301	LSbj-1	12
	(b) Affix a 2-inch by 4-inch piece of hook fastener tape, for use as a mounting for the wearer's nameplate, to the pile fastener tape.			
* 6	Join fusible interlining and elastic webbing to back			
*	(a) Position the strips of the fusible interlining on the back (basic fabric). Press the strips of the fusible interlining in accordance with the recommendations of the manufacturer of the fusible interlining.			

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TABLE III. Sewing operations. - Continued

	No.	Description of Operation	Stitch Type	Seam and Stitch Type	Stitches Per Inch
*		(b) With the back laid out flat, join the piece of the elastic webbing at the notches in the armhole 1/4 inch from the edge.	301	SSa-1	12
*	7	Make and attach cigarette and pencil pocket			
		(a) Hem the top opening of the pencil compartment, in accordance with the notches, with a double row of stitching, with the first row of stitching 1/16 to 1/8 inch from the top edge, 1/4-inch gage.	301	EFa-2	12
*		(b) Fold the pencil compartment 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 notch, tacking each side edge with a single row of stitching (optional).	301	SSa-1	12
*		(d) Slit the fold through the center to make the pencil pass-through, or the pencil compartment may be made in two pieces.			
*		Note: The front and the rear openings of the pencil compartment shall be 7/8 inch (plus or minus 1/8 inch) wide.			

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TABLE III. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitch Type	Stitches Per Inch
	(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) Place a single row of stitching centered between the front and the back edge the entire length of the pencil compartment to separate the openings.	301	SSa-1	12
*	(g) Bartack the ends of all pencil compartment openings with the bartack superposed on the inner row of double stitching and on the center row of stitching.	bar-tack		28 stitches per bartack
*	Note: The bartack shall be 3/8 to 1/2 inch long.			
	(h) Fold the forward side of the cigarette compartment and the slide fastener tape cover. Insert the cord in the fold and stitch close to the cord with a single row of stitching.	301	EFa-1	12
	(i) Form a 3/4-inch bellows by joining the two bottom corners with a single row of stitching 1/4 inch from the end.	301	LSb-2	12
*	(j) Sew the slide fastener tape to the forward side of the cigarette and pencil pocket with a double row of stitching 1/8-inch to 1/4-inch gage 1/4 inch from the edge of the scoops with the beaded edge covering the scoops.	301	LSb-2	12

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TABLE III. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitch Type	Stitches Per Inch
	(k) Position the slide fastener cover on the opposite slide fastener tape with the beaded edge covering the scoops, and join with a single row of stitching 1/4 inch from the edge of the scoops.	301	SSa-1	12
*	(l) Position the cigarette and pencil pocket on the left sleeve at the drill marks. Turn the raw edges under 3/8 inch, and sew with a single row of stitching 1/16 inch from the folded edge.	301	LSd-1	12
*	(m) Place a second row of stitching 1/4 inch from the edge and across the top of the cigarette and pencil pocket.	301	SSv-1	12
	(n) Bartack across each end of the slide fastener on the inner row of stitching with a 1/2-inch-wide bartack.	bar-tack		28 stitches per bartack
*	Note: The finished cigarette and pencil pocket shall be 5-3/4 inches (plus or minus 1/4 inch) long by 3-1/2 inches (plus or minus 1/4 inch) wide, including the slide fastener tape. The width measurement shall be taken across the top of the cigarette and pencil pocket.			
8	Make sleeves			
*	(a) Join each elbow seam with a single row of stitching 1/2 inch from the edge.	301 or 401	LSq-2(a)	12

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TABLE III. Sewing operations. - Continued

	No.	Description of Operation	Stitch Type	Seam and Stitch Type	Stitches Per Inch
		(b) Turn and raise, with the topsleeve overlapping the undersleeve, with a single row of stitching 1/4 inch from the edge.	301	LSq-2(b)	12
		OR			
*		(c) As an option to No. 8(a) and 8(b) join each elbow seam of the sleeve with a double-lapped, double-stitched seam 3/16-inch to 5/16-inch gage.	301 or 401	LSc-2	12
*		(d) Join each sleeve inseam with a single row of stitching 1/2 inch from the edge.	301 or 401	LSq-2(a)	12
		(e) Turn and raise stitch with a single row of stitching 1/4 inch from the edge.	301	LSq-2(b)	12
*		(f) In lieu of No. 8(d) and 8(e), each sleeve inseam may be joined with a double-lapped, double-stitched seam 3/16-inch to 5/16 inch-gage.	301	LSc-2	12
	9	Join shoulders			
*		(a) Join each front to the back, at the shoulders, with a single row of stitching 1/2 inch from the edge.	301 or 401	LSq-2(a)	12

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TABLE III. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitch Type	Stitches Per Inch
	(b) Turn and raise stitch, with the back overlapping the fronts, with a single row of stitching 1/4 inch from the folded edge.	301	LSq-2(b)	12
	OR			
*	(c) As an option to No. 9(a) and 9(b), join each shoulder seam with a double-lapped, double-stitched seam 3/16-inch to 5/16-inch gage.	301 or 401	LSc-2	12
10	Insert corded beading in front opening			
	(a) Fold the front edge to the inside at the pattern marks. Insert the cord in the fold, and stitch close to the cord with a single row of stitching. The beaded edges shall be flush with each other when attached to the closed slide fastener. The beading shall end at the lower fold notch.	301	EFa-1	12
11	Join side seams			
*	(a) Join each side seam with a single row of stitching 1/2 inch from the edge.	301 or 401	LSq-2(a)	12
*	(b) Turn and raise on each front with a single row of stitching 1/4 inch from the folded edge.	301 or 401	LSq-2(b)	12

OR

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TABLE III. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitch Type	Stitches Per Inch
	(c) As an option to No. 11(a) and 11(b), each side front may be joined with a double-lapped, double-stitched seam 3/16-inch to 5/16-inch gage.	301 or 401	LSc-2	12
12	Attach sleeves			
*	(a) Join the sleeves to the armholes, with a single row of stitching 1/2 inch from the edge, catching the elastic webbing in the seam.	301 or 401	LSq-2(a)	12
	(b) Turn and raise on the fronts and the backs with a single row of stitching 1/4 inch from the folded edge.	301	LSq-2(b)	12
* 13	Make collar			
	(a) Quilt the undercollar leaf to the interlining with a series of diagonal stitching. The points of the diagonal stitching shall terminate at the edge of the collar, and the points of the stitching shall be approximately 3 inches apart at the top edge and 2-3/4 inches apart at the bottom edge of the collar.	301	SSv-1	12
	OR			
	(b) As an option to No. 13(a), the undercollar may be quilted to the interlining with six rows of evenly spaced stitching.	406	SSv-1	12

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TABLE III. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitch Type	Stitches Per Inch
	(c) Quilt the undercollar stand to the interlining with five rows of horizontal stitching, approximately 1/4 inch apart, centered in the stand.	301 or 401	SSv-5	12
	(d) Join the undercollar stand to the leaf with a single row of stitching 1/4 inch from the edge.	301 or 401	LSq-2(a)	12
	(e) Turn and raise stitch, with the stand overlapping the leaf, with a single row of stitching 1/16 inch from the edges.	301	LSq-2(b)	12
	(f) Join the topcollar to the undercollar with a single row of stitching 1/4 inch from the edge.	301 or 401	SSe-2(a)	12
	(g) Turn; force out the edges.			
14	Make hanger			
#	(a) Make the hanger.	301	EFp-2	12
#	Note: The finished hanger shall be 1/2 inch (plus or minus 1/4 inch) wide by 3-1/2 inches (plus or minus 1/4 inch) long.			
# 15	Join shoulders of lining			
#	(a) Join the backs to the fronts, at the shoulders of the the lining, with a single row of stitching 1/2 inch from the edge.	301 or 401	LSq-2(a)	12

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TABLE III. Sewing operations. - Continued

	No.	Description of Operation	Stitch Type	Seam and Stitch Type	Stitches Per Inch
		(b) Turn and raise stitch, the lining at the shoulders, with the fronts overlapping the backs, with a single row stitching 1/4 inch from the folded edge.	301	LSq-2(b)	12
		OR			
*		(c) As an option to No. 15(a) and 15(b), join each shoulder seam of the lining with a double-lapped, double-stitched seam 3/16-inch to 5/16-inch gage.	301 or 401	LSc-2	12
*	16	Join sleeve lining			
*		(a) Join each elbow seam of the sleeve lining with a single row of stitching 1/2 inch from the edge.	301 or 401	LSq-2(a)	12
		(b) Turn and raise, with the undersleeve lining overlapping the topsleeve lining, with a single row of stitching 1/4 inch from the edge.	301	LSq-2(b)	12
		OR			
*		(c) As an option to No. 16(a) and 16(b), join each elbow seam of the sleeve lining with a double-lapped, double-stitched seam 3/16-inch to 5/16-inch gage.	301 or 401	LSc-2	12
*		(d) Join the inseam of each sleeve lining with a single row of stitching 1/2 inch from the edge.	301 or 401	LSq-2(a)	12

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TABLE III. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitch Type	Stitches Per Inch
*	(e) Turn and raise stitch each sleeve lining with a single row of stitching 1/4 inch from the edge.	301	LSq-2(b)	12
*	(f) In lieu of No. 16(d) and 16(e), the inseam of each sleeve lining may be joined with a double-lapped, double-stitched seam 3/16-inch to 5/16-inch gage.	301	LSc-2	12
	(g) Join the sleeve linings to the armholes with a single row of stitching 1/2 inch from the edge.	301 or 401	LSq-2(a)	12
	(h) Turn and raise on the fronts and the backs of the sleeve lining with a single row of stitching 1/4 inch from the folded edge.	301	LSq-2(a)	12
	OR			
*	(i) As an option to No. 16(g) and 16(h), each sleeve lining may be attached with a double-lapped, double-stitched seam 3/16-inch to 5/16-inch gage.	301 or 401	LSc-2	12
* 17	Join side seams of lining			
*	(a) Join each side seam of the lining with a single row of stitching 1/2 inch from the edge.	301 or 401	LSq-2(a)	12
	(b) Turn and raise on the backs of the lining with a single row of stitching 1/4 inch from the folded edge.	301 or 401	LSq-2(b)	12

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TABLE III. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitch Type	Stitches Per Inch
	OR			
*	(c) As an option to No. 17(a) and 17(b), each side seam of the lining may be joined with a double-lapped, double-stitched seam 3/16-inch to 5/16-inch gage.	301 or 401	LSc-2	12
* 18	Prepare waistband			
*	(a) Sew the outer shell extension facing pieces to each end of the knitted waistband with a single row of stitching 1/2 inch from the edge.	301	LSq-2(a)	12
*	(b) Turn and raise stitch, with the outer shell overlapping the knitted waistband, with a single row of stitching 1/4 inch from the edge.	301	LSq-2(b)	12
* 19	Attach waistband			
	(a) Sew one side of the waistband to the bottom of the outer shell with a single row of stitching 1/2 inch from the edge.	301	SSa-1	12
	(b) Attach the opposite edge of the waistband to the bottom of the lining with a single row of stitching 1/2 inch from the edge.	301	SSa-1	12

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TABLE III. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitch Type	Stitches Per Inch
	(c) With the jacket turned inside out, join the outer shell, the lining, and the waistband between the extension pieces with a single row of stitching 1/2 inch from the edge.	301	SSa-1	12
* 20	Attach wristlets			
*	(a) Sew each prefolded knitted wristlet to the bottom of the lining and outer shell sleeve terminal with a single row of stitching 1/2 inch from the edge.	301	SSa-1	12
* 21	Join slide fastener to right front			
	(a) Position the right slide fastener tape, with the slider attached, on the right front with the front beaded edge even with the scoops; join with a single row of stitching 1/4 inch fron the edge of the scoops. Start 1/4 to 3/8 inch from the bottom notch.	301	SSa-1	12
* 22	Join slide fastener to left front			
	(a) Join the slide fastener to the left front, with the front beaded edge even with the scoops, with a single row of stitching 1/4 inch from the edge of the scoops.	301	LSq-2(a)	12
	(b) Turn and raise stitch with a single row of stitching 1/4 inch from the edge.	301	LSq-2(b)	12

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TABLE III. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitch Type	Stitches Per Inch
	(c) Join the slide fastener to the left front lining with a single row of stitching 1/4 inch from the edge of the scoops.	301	LSq-2(a)	12
	(d) Turn and raise stitch with a single row of stitching 1/4 inch from the edge.	301	LSq-2(b)	12
* 23	Attach hanger			
	(a) Position the hanger on the back panel of the lining, centered 1 inch down from the neck opening raw edge, and join with a 1/2-inch-wide bartack.	bar-tack		28 stitches per bartack
* 24	Attach labels			
	(a) Position the top of the combination identification and size label directly below the hanger. Position the top of the instruction label so that it will be centered, not more than 1/2 inch below, the bottom of the combination identification and size label. Sew the combination identification and size label and the instruction label on all four sides to the lining with a single row of stitching 1/16 inch from the edge. The top of the instruction label may be caught in the stitching of the bottom of the combination identification and size label.	301	LSbj-1	12

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TABLE III. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitch Type	Stitches Per Inch
* 25	Turn jacket			
*	(a) Raise stitch around each wristlet on the outer shell with a single row of stitching 1/4 inch from the fold.	301	LSq-2(a)	12
	(b) Join the outer shell to the lining at the front opening. Position the beaded edge on the slide fastener with the beaded edges butting when the slide fastener is closed; join with a single row of stitching 1/4 inch from the edge of the scoops.	301	SSa-1	12
* 26	Attach collar			
	(a) Join the undercollar to the neck opening with a single row of stitching 3/8 inch from the edge.	301	SSa-1	12
	(b) Turn the raw edge of the topcollar under 3/8 inch, and join with a single row of stitching 1/16 inch from the folded edge.	301	LSd-1	12
	(c) Raise stitch around the collar with a single row of stitching 1/4 inch from the edge.	301	SSe-2(b)	12
* 27	Raise stitch above waistband			
*	(a) Raise stitch across the bottom of the jacket, 1/4 inch above the knitted waistband, with a single row of stitching.	301	SSq-2(a) (shows finished seam)	12

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TABLE III. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitch Type	Stitches Per Inch
* 28	Make thong			
	(a) Fabricate the thong for the slide fastener for the front opening so that the finished thong will be 1/2 inch wide by 3 inches long.	301	EFp-2	12
	(b) Pull the thong through the hole in the top slider tab pull so that the ends of the thong will be even. Bartack at the bottom, at the center, and at the end of the slider tab pull, across the 1/2-inch width.	bar-tack		28 stitches per bartack
	(c) Bartack the closed end of the slide fastener with a 7/8-inch-wide bartack.	bar-tack		28 stitches per bartack
* 29	Clean jacket			
	(a) Trim all thread ends. Remove all loose thread ends.			
	(b) Remove all spots, stains, and shade tickets without damage to the fabric.			

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TABLE IV. Pattern parts.

Materials	Pattern Parts 1/	Cut Parts
Basic fabric (see 3.1.1)	Front	2
	Back	1
	Topsleeve	2
	Undersleeve	2
	Cigarette pocket	1
	Cigarette pocket slide fastener cover	1
	Pocket flap	4
	Pencil pocket	1
	Patch pocket	2
	Topcollar	1
	Undercollar	1
	Collar stand	2
	Waistband extension facing	2
	Slide fastener thong	1
	Hanger	1
Lining (see 3.1.2)	Front	2
	Back	1
	Topsleeve	2
	Undersleeve	2
Collar interlining (see 3.1.3)	Undercollar	1
	Collar stand	1
Fusible interlining (see 3.1.10)	Side strip	2
	Bottom strip	1
	Shoulder strip	2
	Neck strip	1

1/ A pocket location marker will be included.

TABLE V. Finished measurements.

Size of Jacket	Finished Measurements in Inches 1/ 2/		
	Back Length	1/2 Chest	Sleeve Inseam
Small	21-1/2	23-1/4	16
Medium	22-1/4	25-1/4	16-1/4
Large	23	27-1/4	16-1/2
Extra large	23-3/4	29-1/4	16-3/4
Extra extra large	24-1/4	31-1/4	17

1/ The tolerances for the finished measurements shall be plus 3/8 or minus 5/8 inch for the back length, plus or minus 1/2 inch for the 1/2 chest, and plus 1/4 or minus 3/8 inch for the sleeve inseam.
2/ The finished measurements shall be taken as specified in 3.5.

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* 3.6 Labels. Each jacket shall have a combination identification and size label and an instruction label. The labels shall have colorfastness to both laundering and dry cleaning. The combination identification and size label shall conform to type VI, classes 1 and 2 of DDD-L-20 except that the specification number shall be included on the label. The instruction label shall conform to type VI, class 3 of DDD-L-20 and shall contain the following information:

Instruction Label

This jacket is made of fire resistant material. No other special flame resistant treatment is required.

The jacket may be dry cleaned or may be laundered by machine or hand. DO NOT STARCH. Ironing or pressing is not necessary.

3.7 Workmanship. The jacket shall be manufactured in a thoroughly workmanlike manner.

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

* 4.2.1 Materials and components. Materials and components shall be examined and tested in accordance with all of the applicable subsidiary documents referenced herein to the extent applicable. The unit for expressing the lot size and the sample size for testing the materials and the components shall be as specified in the applicable subsidiary documents. In addition to the examinations and the tests specified in the applicable subsidiary documents referenced herein, the tape specified in 3.1.6 for the slide fastener shall be tested for shrinkage. The test for shrinkage shall be in accordance with method 5556 of FED-STD-191 (cotton procedure for five launderings). The sample size for testing the tape shall be as specified in table VI.

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TABLE VI. Sample size.

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

4.2.2 End item. The end item shall be examined as specified in 4.2.2.1 and 4.2.2.2. The sample unit for these examinations shall be one jacket.

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

* 4.2.2.2 Examination of finished measurements. The end item shall be measured as specified in 3.5. The inspection level for the examination of the finished measurements shall be S-3 of MIL-STD-105. The acceptable quality level for the examination of the finished measurements shall be 4.0 dhu for defects (one class). Each finished measurement of the end item that deviates from the finished measurement specified in table V shall be classified as a finished measurement defect. Sleeve lengths uneven 1/2 inch or more shall be classified as a finished measurement defect.

* 4.3 Examination of preparation for delivery. Shipping containers fully prepared for delivery shall be examined, for the defects listed in table VIII, to determine compliance with the packaging, packing, and marking requirements that are specified herein. The sample unit for this examination shall be one shipping container fully prepared for delivery. The lot size shall be the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 of MIL-STD-105. The acceptable quality level shall be 2.5 dhu for defects (one class).

5. PACKAGING

5.1 Preservation and packaging. Preservation and packaging shall be level A or C as specified (see 6.2).

5.1.1 Level A. Each jacket shall be folded to approximately 20 inches by 16 inches. Four folded jackets shall be placed in a box that conforms to type CF, class domestic, style RSC, minimum bursting strength of 200 pounds per square inch of PPP-B-636. The outside dimensions of the box shall be approximately 20 inches by 16 inches by 6 inches. The box shall be closed by applying tape that conforms to PPP-T-45.

5.1.2 Level C. The jacket shall be packaged one per unit container in accordance with the manufacturer's commercial practice.

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TABLE VII. Classification of defects.

Defect	Major	Minor A	Minor B
Bartacks			
One bartack missing, insecure, or misplaced not serving intended purpose			X
Two bartacks missing, insecure, or misplace not serving intended purpose		X	
Three or more bartacks missing, insecure, or misplaced not serving intended purpose	X		
* Any bartack less than specified length or width			X
Cleanness			
Indelible ink shade stamping exposed on outside or spots or stains of permanent nature		X	
Removable spot or stain clearly noticeable		X	
Thread ends not trimmed or one or more shade ticket not removed			X
Component and assembly			
Any component defective	X		
Any component missing	X		
Any required operation omitted or improperly performed	X		
Cutting			
Any component not cut in accordance with directional lines on patterns or specified requirements	X		
Material defects and workmanship damages			
Any weakening material defect such as hole, cut, tear, smash, burn, multiple float, large drill hole, or needle chew that might develop into hole	X		
Outside of jacket containing fuzz balls; slubs or knots (exceeding limits shown on figure 1 of FED-STD-4); knitting runs; needle chews; drill holes; or other similar defects not expected to develop into hole		X	
Inside of jacket containing fuzz balls; slubs or knots (exceeding limits shown on figure 1 of FED-STD-4); knitting runs; needle chews; drill holes; or other similar defects not expected to development into hole			X

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TABLE VII. Classification of defects. - Continued

Defect	Major	Minor A	Minor B
Basic fabric containing two or more contiguous missing or broken picks and attendant surface defects	X		
Basic fabric containing two or more contiguous skin backs or missing end running entire length of major part	X		
Basic fabric containing any shade bar	X		
Color of basic fabric not as specified	X		
Seams and stitchings			
Seam twisted, pleated, or badly puckered 1/		X	
Part of jacket caught in any unrelated operation or stitching	X		
Thread(s) used on outside not same shade or not satisfactorily matching shade of jacket		X	
Thread breaks or end(s) of stitching, if not caught in other seams or stitchings, not securely backstitched or tacked as specified		X	
* Gage of edge, top, or raise stitching irregular, that is, unevenly gaged or corresponding stitchings not uniformly gaged, affecting appearance		X	
Gage of edge, top, or raise stitching not within range of gage specified or varies more than 1/16 inch if no range is specified			X
Open seam over 1/8 inch but not over 1/4 inch on joining seam 2/			X
Open seam over 1/4 inch on joining seam 2/		X	
Stitches skipped or broken over 1/4 inch but not over 1/2 inch on edge, top, or raise stitching when seam is seamed, turned, and stitched 2/			X
Stitches skipped or broken over 1/2 inch on edge, top, or raise stitching when seam is seamed, turned, or stitched 2/		X	
Raw edges on outside over 1/8 inch but not over 1/4 inch 3/			X
Raw edges on outside over 1/4 inch 3/		X	
Raw edges on inside over 1/2 inch but not over 1 inch 3/		X	

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TABLE VII. Classification of defects. - Continued

Defect	Major	Minor A	Minor B
Raw edges on inside over 1 inch 3/	X		
Run-offs on joining seams, if resulting in open seam 2/			
Run-offs on edge, top, or raise stitching, if not resulting in open seam (outside only), over 1/2 inch but not over 1 inch			X
Run-offs on edge, top, or raise stitching, if not resulting in open seam (outside only), over 1 inch		X	
Stitch or seam type not as specified		X	
Loose stitch tension, resulting in loose seam	X		
Loose stitch tension on edge, top, or raise stitching, recognized by loose exposed loops of top or lower thread		X	
Tight tension 2/			
One or two stitches per inch less than minimum specified 4/			X
Three stitches per inch less than minimum specified 4/		X	
Four or more stitches per inch less than minimum specified 4/	X		
One or more stitches per inch more than maximum specified 4/		X	
Shaded parts			
Outside parts (visible when jacket is worn) shaded		X	
Lining and inside parts (not visible when jacket is worn) badly shaded			X
Slide fasteners			
Slide fastener not specified type, size, or style or any part of assembly omitted, bent, or broken	X		
Any portion of jacket or slide fastener tape puckered, twisted, or pleated at slide fastener tape joining seam when slide fastener is open or closed		X	
Interference with movement of any slider	X		
Any slider not closed in specified direction		X	

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TABLE VII. Classification of defects. - Continued

Defect	Major	Minor A	Minor B
Thong not attached to slider for front opening as specified		X	
Slide fastener covering			
Edges of slide fastener covering overlapping more than 1/16 inch or gapping more than 1/16 inch when slide fastener is closed		X	
Cord beading omitted in slide fastener covering	X		
Cord beading not sewn taut in slide fastener covering		X	
Fronts			
Front pockets 1/2 inch or more out of alignment with each other		X	
Fronts sagging, twisted, or bulging across chest or caused by tightness of lining		X	
Back overlapping front at side seam			X
Hook fastener tape on top of flap more than 1/4 inch out of alignment with pile fastener tape on front		X	
* Hook fastener tapes reverse, that is, pile portion on front and hook portion on underside of flap			X
Waistband			
Waistband not specified width		X	
Waistband twisted in attachment to bottom of jacket, affecting appearance		X	
Sleeves			
Sleeves sagging, twisted, bulging, or short causing shortness, tightness, or incorrect positioning of lining		X	
Back part of sleeve overlapping forepart of sleeves at inseams			X
Back part of sleeve overlapping forepart of sleeves at elbow seam		X	
Sleeve overlapping body parts at joining seam	X		
Wristlets not specified class or color		X	

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TABLE VII. Classification of defects. - Continued

Defect	Major	Minor A	Minor B
wristlets twisted in attachment to sleeve bottom, affecting appearance		X	
Pencil and cigarette pocket less than 5-1/2 inches or more than 6 inches long		X	
Pencil and cigarette pocket (including slide fastener tape) less than 3 inches or more than 4 inches wide		X	
Pencil and cigarette pocket set on crookedly, affecting appearance		X	
Hem of opening of pencil and cigarette pocket stitched with only one row of stitching			X
Pencil compartment piece not double-stitched along front and back edges		X	
Slide fastener not on forward side of finished pencil and cigarette pocket	X		
Ends of slide fastener tapes of pencil and cigarette pocket not turned under	X		
Front and top edges of pencil and cigarette pocket and tape not double stitched to sleeve		X	
Slide fastener stitched to pencil and cigarette pocket with slider closing downward		X	
* Elastic webbing in back panel			
* Elastic webbing omitted	X		
* Elastic webbing in back panel stitched too tightly, causing puckering on back, affecting appearance		X	
* Elastic webbing twisted on back		X	
Hanger			
End(s) of hanger not securely stitched as specified		X	
Finished hanger less than 3-1/4 inches long or more than 3-3/4 inches long			X
Hanger less than 3/8 inch or more than 5/8 inch wide			X
Hanger 1 inch or more off center with center of back			X
Hanger stitched and bartacked through outer shell		X	

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TABLE VII. Classification of defects. - Continued

Defect	Major	Minor A	Minor B
Fastener tape			
Fastener tape (except wearer's nameplate) not specified size		X	
Fastener tape (except wearer's nameplate) misplaced not serving intended purpose	X		
Hooks or pile flattened or missing from any fastener tape area up to 25 percent		X	
Hooks or pile flattened or missing from any fastener tape area 25 percent or more	X		
Fastener tape for wearer's nameplate missing	X		
Fastener tape for wearer's nameplate not specified size	X		
Fastener tape for wearer's nameplate misplaced more than 1/2 inch		X	
Stitching omitted on one or more edges of pile fastener tape for wearer's nameplate		X	
Label			
Size label missing, incorrect, or illegible	X		
Information (except size) on label incomplete, incorrect, or illegible		X	
Label misplaced or off center of back more than 1/2 inch			X
Stitching omitted on one or more edges of label		X	

1/ Some puckering is an inherent characteristic in joining seams and stitching of cloth parts. This normal puckering shall not be classified as a defect.
2/ A break in a line of stitching (except on edge, top, or raise stitching), run-offs on joining seams (if resulting in an open seam), and tight tension (stitches breaking when normal strain is applied to seam or stitching) shall be classified as open seams.
3/ A raw edge shall be classified as such when it occurs along an edge required to be turned under but the edge is securely caught in the stitching. If the edge is not securely caught in the stitching, the defect shall be classified as an open seam.
4/ Stitches per inch shall be classified as a defect only when the condition exists on the major portion of the seam or stitching.

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* TABLE VIII. Examination of preparation for delivery.

Examine	Defect
Marking	Marking omitted; incorrect; illegible; or improper size, location, sequence, or method application
Materials	Any component missing
	Any component damaged, affecting serviceability
Workmanship	Inadequate application of components such as incomplete closure of container flaps, loose strapping, or inadequate stapling
	Bulging or distortion of container
Content	Number per intermediate container more or less than required

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

* 5.2.1 Level A. Sixteen jackets of one size, packaged as specified, shall be packed in a box that is 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 approximately 24 inches by 20 inches by 16 inches. Toward the end of the contract or if the quantity of the jackets of the same size is less than the quantity of the jackets that is required per shipping container, mixed sizes (see 5.3.1) may be packed within the same shipping container.

* 5.2.2 Level B. Sixteen jackets of one size, packaged as specified, shall be packed in a box that is constructed and closed to conform to type CF or SF, class domestic, style RSC of PPP-B-636. The inside dimensions of the box shall be approximately 24 inches by 20 inches by 16 inches. Toward the end of the contract or if the quantity of the jackets of the same size is less than the quantity of the jackets that is required per shipping container, mixed sizes (see 5.3.1) may be packed within the same shipping container. The shipping container shall be closed in accordance with method II of PPP-B-636.

5.2.3 Level C. Jackets packaged as specified shall be packed in a manner to ensure acceptance by the carrier and safe delivery to destination at the lowest transportation rate for such supplies. The 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, unit packages, intermediate packages, and shipping containers shall be marked in accordance with MIL-STD-129.

5.3.1 Mixed sizes. White paper labels 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 labels shall be 5 inches by 4 inches. The labels shall have the words "mixed sizes" plainly printed thereon; under these words shall be printed the quantity and size of the jackets contained therein.

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6. NOTES

6.1 Intended use. The jacket covered by this specification is intended to be worn, as a utility jacket with the CWU-27/P coveralls, in temperature of 50 degrees Fahrenheit and above.

6.2 Ordering data. Procurement documents should specify the following:

(a) Title, number, and date of this specification

(b) Size required (see 1.2)

(c) Selection of applicable levels of preservation and packaging and packing (see 5.1 and 5.2)

6.3 Samples. Samples of color shades should be obtained from the procuring activity or as directed by the contracting officer.

6.4 Figures. Figures 1 and 2 show general style of the jacket and are furnished for information only. In the event of conflict between the text and the figures, the text shall apply.

6.5 Changes from previous issue. The margins of this specification are marked with asterisks to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were made. This was done as 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 - 11
Navy - NU

Reviewer:
Air Force - 99

User:
Air Force - 45

Preparing activity:
Air Force - 11

Project No. 8415-0243

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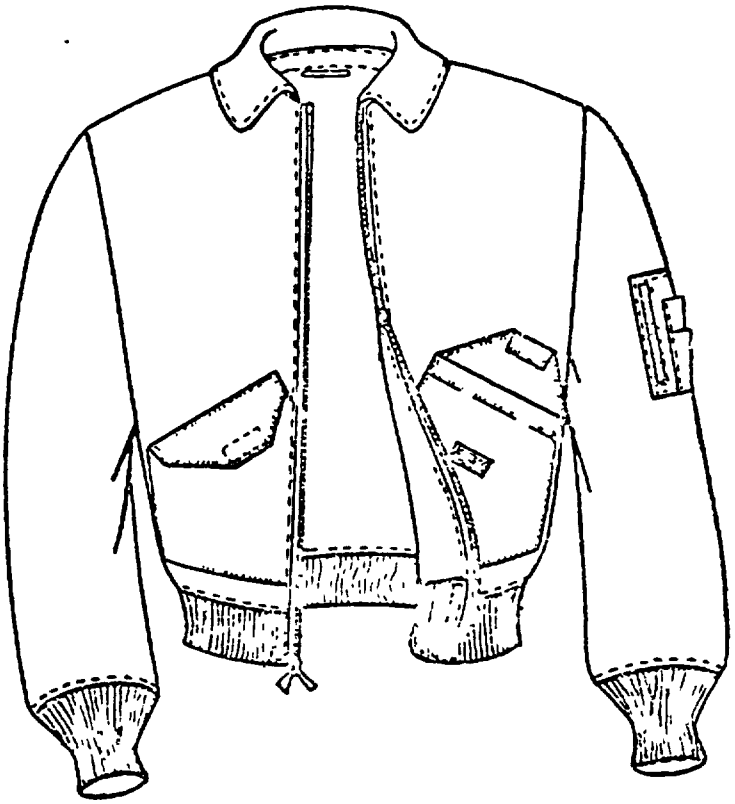

FIGURE 1. Jacket, front view.

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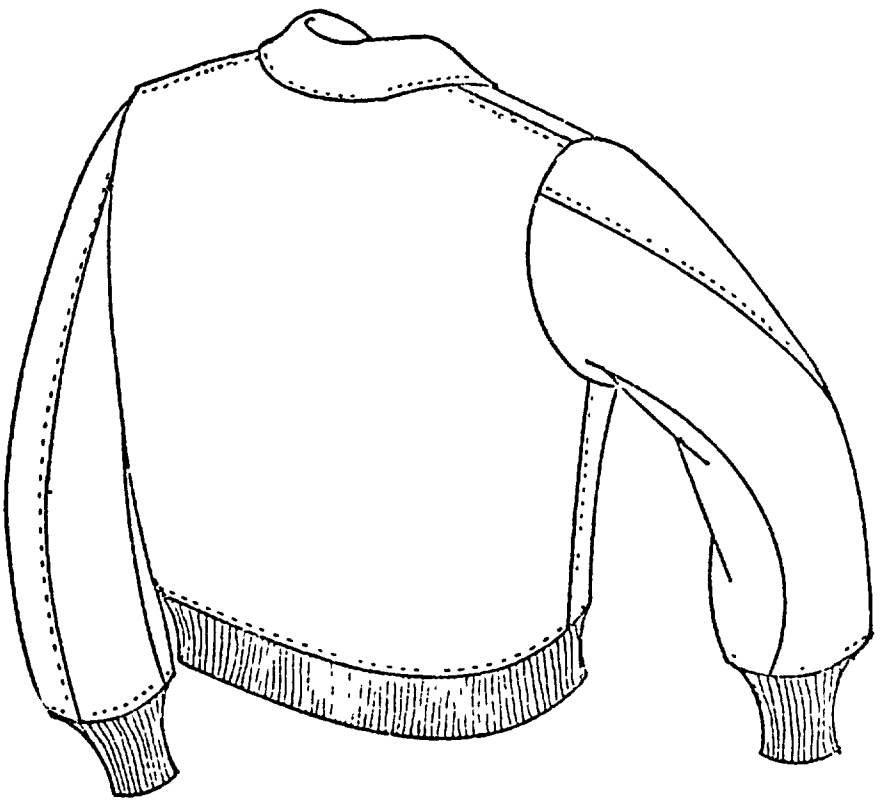

FIGURE 2. Jacket, rear view.

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