

INCH POUND

MIL-J-83388E

18 June 1992

SUPERSEDING

MIL-J-83388D

5 April 1988

## MILITARY SPECIFICATION

### JACKET, FLYER'S, COLD WEATHER

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

#### 1. SCOPE

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

1.2 Classification. The jackets shall be furnished in one of the following types or sizes as specified (see 6.2):

#### Schedule of sizes

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

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

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

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Defense Personnel Support Center, Clothing and Textiles Directorate, Attn: DPSC-FSSD, 2800 South 20th Street, Philadelphia, PA 19101-8419, by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8415

DISTRIBUTION STATEMENT A.

Approved for public release;  
distribution is unlimited.

## 2. APPLICABLE DOCUMENTS

2.1 Government documents.

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

## SPECIFICATIONS

## FEDERAL

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

## MILITARY

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

MIL-J-83388E

MIL-C-83242

Cord, Aromatic Polyamide,  
Nonmelting

STANDARDS

FEDERAL

FED-STD-191

Textile Test Methods

FED-STD-751

Stitches, Seams, and Stitchings

MILITARY

MIL-STD-105

Sampling Procedures and Tables  
for Inspection by Attributes

MIL-STD-129

Marking for Shipment and Storage

MIL-STD-147

Palletized Unit Loads

MIL-STD-2073-1

DOD Materials Procedures for  
Development and Applications of  
Packaging Requirements

MIL-STD-2073-2

Packaging Requirement Codes

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

2.1 Non-Government Publications. The following document(s) form a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DoD adopted shall be those listed in the issue of the DODISS cited in the solicitation (see 6.2).

NATIONAL MOTOR FREIGHT TRAFFIC ASSOCIATION, INC., AGENT

National Motor Freight Classification

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

UNIFORM CLASSIFICATION COMMITTEE, AGENT

Uniform Freight Classification

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

THE COLOR ASSOCIATION OF THE UNITED STATES

Department of Defense Standard Shades For Sewing Threads

Department of Defense Standard Shades For Buttons

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

AMERICAN SOCIETY FOR TESTING AND MATERIALS

ASTM D 3951 Standard Practice for Commercial Packaging

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

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

2 2 Order of precedence In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained

3 REQUIREMENTS

3 1 First article When specified, (see 6 2), a sample shall be subjected to first article inspection, in accordance with 4 3

3 2 Materials

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

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

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

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

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

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

Cut Length 1/

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

1/ The measurement of the cut length is in inches

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

TABLE I. Slide fasteners.

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

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

TABLE II. Width of waistband material.

| Size of Jacket    | Width (Inches) in Direction of<br>Course of Material <u>1/</u> |
|-------------------|----------------------------------------------------------------|
| 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.

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

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

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

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

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

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

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

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

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

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

3.4 Manufacturing operations requirements. The jacket and/or hood shall be manufactured in accordance with operation requirements specified in Table IV. The contractor is not required to follow the exact sequence of operations provided the finished jacket and/or hood is identical to that produced by following the sequence as listed in Table IV. Minor modifications are permitted where necessary when using automatic equipment. These modifications shall not alter the dimensional, serviceability or appearance requirements cited in the specification. The operations numbered 28 to 38 are for the manufacturing of the hood only.

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

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

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

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

3.5 Patterns. The standard patterns used to cut the working patterns shall be furnished by the Government (see 6.3). The working patterns shall be identical to the Government patterns. Neither the Government patterns nor the working patterns shall be altered in any way, except that additional notches for use during construction are permitted on the working patterns. Also, minor modifications are permitted where necessary when using automatic equipment. These modifications shall not alter the dimensional, serviceability or appearance requirements cited in the specification. Standard patterns shall show size, directional lines, placement marks, and notches for assembly. Unless otherwise specified, the patterns provide a seam allowance of 1/2 inch.

TABLE III. Pattern parts.

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

TABLE III. Pattern parts.

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

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

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

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

TABLE IV. Sewing operations.

| No. | Description of Operation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Stch<br>Type | Seam/<br>Stch<br>Type | Stch<br>Per<br>In |
|-----|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|-----------------------|-------------------|
| 1.  | <p><u>Cut.</u></p> <p>(a) Cut the parts of the jacket and hood in strict accordance with the patterns. The cloth shall be laid in uniform lengths, with care taken in spreading the material so that the plies shall not be stretched or full and so that one side of the lay shall be even. The patterns shall be laid in accordance with the directional lines (warp direction).</p> <p>(b) All parts made of the basic fabric shall be cut from one piece of material, except for parts that may be cut from ends. The following jacket and hood parts may be cut from ends, hood front panel lining, hood side panel lining, hood center panel lining, hanger, flap lining, and the undercollar. Parts cut from ends shall approximate the shade of the other parts of the jacket.</p> <p>(c) Except for the sleeve linings, all parts of the quilted lining shall be cut from one piece of material. The sleeve linings may be cut from ends but shall match each other. The quilted lining shall be cut so that the exposed side of the quilted lining shall be sage green. The use of ends for the two piece bottom edge and two underplies of the cowl flap is permitted provided that there is a match in the shade of the material.</p> |              |                       |                   |
| 2.  | <p><u>Shade mark.</u></p> <p>(a) Except for parts cut from ends, all parts of the basic fabric and the quilted lining shall be marked, ticketed, or banded 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.</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |              |                       |                   |

TABLE IV. Sewing operations. - (Continued)

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

TABLE IV. Sewing operations. - (Continued)

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

TABLE IV. Sewing operations. - (Continued)

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

TABLE IV. Sewing operations. - (Continued)

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

TABLE IV. Sewing operations. - (Continued)

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

TABLE IV. Sewing operations. - (Continued)

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

TABLE IV. Sewing operations. - (Continued)

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

TABLE IV. Sewing operations. Continued

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

TABLE IV. Sewing operations. - (Continued)

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

TABLE IV. Sewing operations. - (Continued)

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

TABLE IV. Sewing operations. - (Continued)

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

TABLE IV. Sewing operations. - (Continued)

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

TABLE IV. Sewing operations. - (Continued)

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

TABLE IV. Sewing operations. - (Continued)

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

TABLE IV. Sewing operations. - (Continued)

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

TABLE IV. Sewing operations. - (Continued)

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

TABLE IV. Sewing operations. - (Continued)

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

TABLE IV. Sewing operations. - (Continued)

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

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

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

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

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

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

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

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

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

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

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

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

TABLE V. Finished measurements.

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

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

#### 4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements (examinations and tests) as specified herein. Except as otherwise specified in the contract or purchase order, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to ensure supplies and services conform to prescribed requirements.

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

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

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

1. First article inspection (see 4.3)
2. Quality conformance inspection (see 4.4)

4.3 First article inspection. The first article, submitted in accordance with 3.2, shall be inspected as specified in 4.1 for compliance with design, construction, workmanship and dimensional requirements.

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

4.4.1 Component and material inspection. In accordance with 4.1 above, components and materials shall be tested in accordance with all the requirements of referenced specifications, drawings, and standards unless otherwise excluded, amended, modified, or qualified in this specification or applicable procurement documents. The unit for expressing lot size and sample size for testing materials and components shall be as specified in the applicable subsidiary documents. In addition to the examinations and tests specified in the applicable subsidiary documents referenced herein, materials and components shall be tested as specified in Table VI. The sample size for the tests specified in Table VI shall be as specified in Table VII.

TABLE VI. Testing of materials and components.

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

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

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

TABLE VII. Sample Unit.

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

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

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

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

Examine

Defect

Marking (exterior  
interior)

Omitted, incorrect, illegible, of and  
improper size, location, sequence, or  
method of application.

MIL-J-83388E

Materials Any component missing, damaged, or not as specified.

Workmanship Inadequate, application of components, such as: incomplete closure of container flaps, loose strapping, improper taping, inadequate stapling, bulged or distorted container

Content Number of boxes per shipping container is more or less than required. Size shown on one or more items not as specified on shipping container 1/

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

TABLE VIII. Classification of Defects.

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

TABLE VIII. Classification of Defects. - (Continued)

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

TABLE VIII. Classification of Defects. - (Continued)

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

TABLE VIII. Classification of Defects. - (Continued)

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

TABLE VIII. Classification of Defects. - (Continued)

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

TABLE VIII. Classification of Defects. - (Continued)

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

TABLE VIII. Classification of Defects. - (Continued)

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

TABLE VIII. Classification of Defects. - (Continued)

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

TABLE VIII. Classification of Defects. - (Continued)

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

TABLE VIII. Classification of Defects. - (Continued)

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

TABLE VIII. Classification of Defects. - (Continued)

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

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

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

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

## 5. PACKAGING

5.1 Preservation. Preservation shall be level B or C or Industrial, as specified (see 6.2).

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

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

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

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

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

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

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

5.2.1 Level B. Twelve jackets of one size only, preserved as specified in 5.1.1, shall be packed as specified in 5.2.2, except that the fiberboard container shall be class weather-resistant, grade V3c or V3, of PPP-B-636.

5.2.1.1 Level B (Hood). Thirty hoods of one size, preserved as specified in 5.1.1, shall be packed as specified in 5.2.2, except that the fiberboard container shall be weather resistant, Grade V3c or V3s, of PPP-B-636. In addition, each container shall be reinforced with flat non-metallic strapping or tape banding in accordance with the appendix to PPP-B-636.

5.2.2 Level C. Twelve jackets of one size only, preserved as specified in 5.1.1, shall be packed in a fiberboard container constructed and closed to conform to type CF or SF, class domestic, variety SW, grade 275, style RSC-L of PPP-B-636. The inside dimensions of the container shall be approximately 20 inches by 16 inches by 24 inches.

5.2.2.1 Level C (Hood). Thirty hoods of one size, preserved as specified in 5.1.1 shall be packed within a fiberboard container constructed and closed to conform to type CF or SF, class domestic, variety SW, grade 275, style OSC of PPP-B-636. The inside dimensions of the container shall be approximately 23-1/2 by 15 by 15 inches. The bagged hoods shall be placed in the container as follows:

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

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

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

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

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

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

## 6. NOTES

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

6.1 Intended use. The jacket is intended to be worn in moderate to cold temperatures.

6.2 Acquisition requirements. Acquisition documents should specify the following:

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

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

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

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

6.6 Subject term (Key Word) listing.

Hood, fur trimmed  
Coat, Low temperature  
Quilted lining

Custodian:  
Air Force - 82, 99  
Navy - AS

Preparing activity:  
DLA-CT

Review Activity:  
DLA-CT

Project No.  
8415-0863

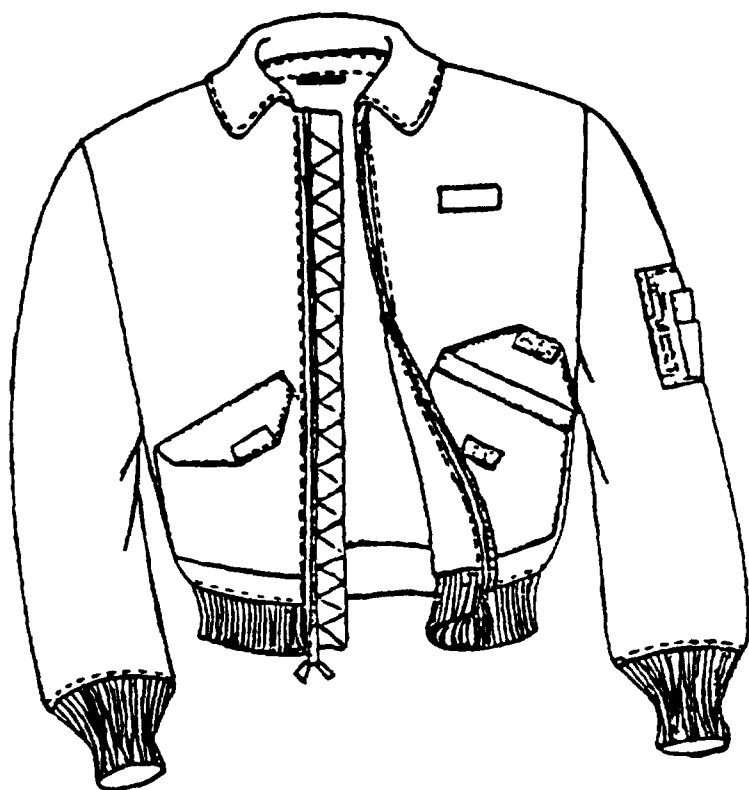


FIGURE 1.

Front view of jacket (without hood).

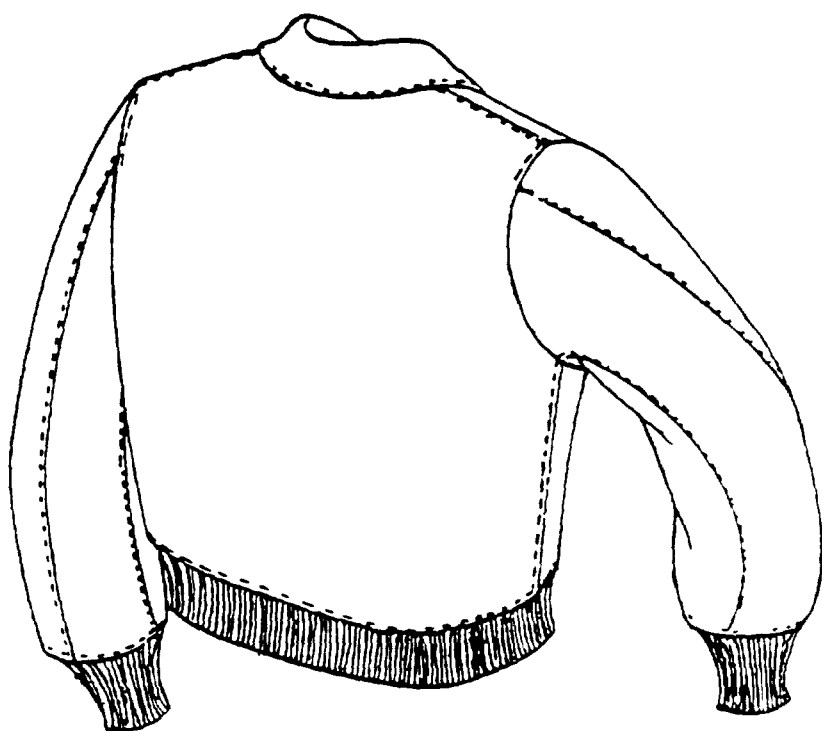


FIGURE 2.

Rear view of jacket (without hood).

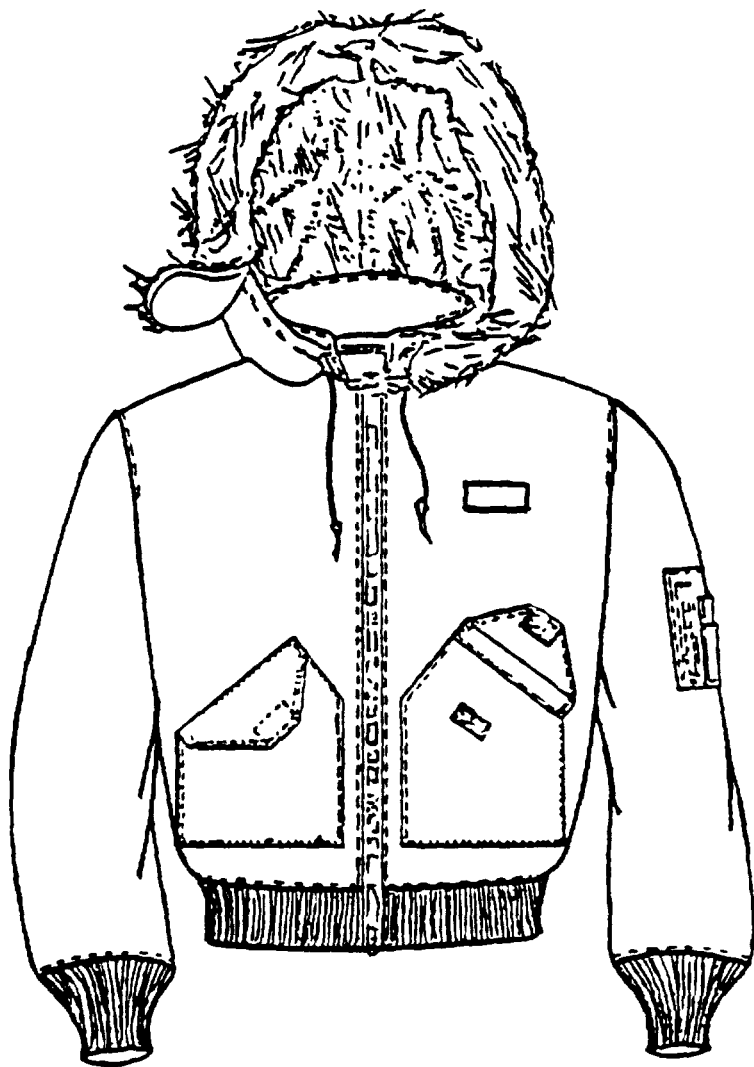


FIGURE 3.

Jacket, front view, with hood attached.

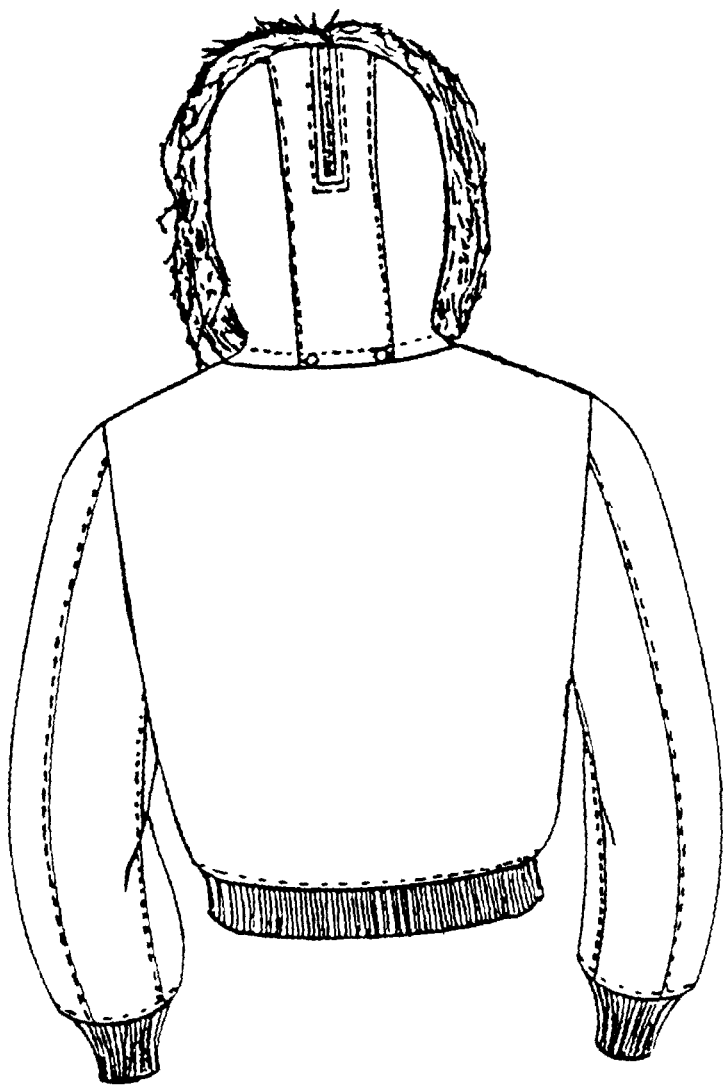


FIGURE 4.

Jacket, rear view, with hood attached.

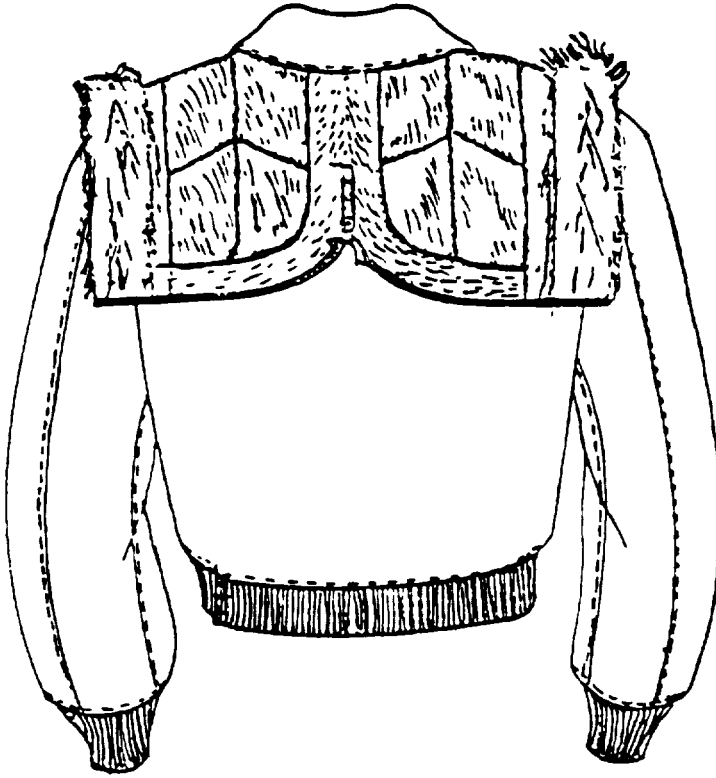


FIGURE 5

Jacket, rear view, with hood attached and opened.

# STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

## INSTRUCTIONS

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

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

|                                                                                                                           |  |                                                                                                                                                     |                                         |
|---------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------|
| <b>I RECOMMEND A CHANGE:</b>                                                                                              |  | 1. DOCUMENT NUMBER<br>MIL-J-82388E                                                                                                                  | 2. DOCUMENT DATE (YYMMDD)<br>92 June 18 |
| 3. DOCUMENT TITLE<br>JACKET, FLYER'S COLD WEATHER                                                                         |  |                                                                                                                                                     |                                         |
| 4. NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.) |  |                                                                                                                                                     |                                         |
| 5. REASON FOR RECOMMENDATION                                                                                              |  |                                                                                                                                                     |                                         |
| 6. SUBMITTER                                                                                                              |  |                                                                                                                                                     |                                         |
| a. NAME (Last, First, Middle Initial)                                                                                     |  | b. ORGANIZATION                                                                                                                                     |                                         |
| c. ADDRESS (Include Zip Code)                                                                                             |  | d. TELEPHONE (Include Area Code)                                                                                                                    | 7. DATE SUBMITTED (YYMMDD)              |
|                                                                                                                           |  | (1) Commercial                                                                                                                                      |                                         |
|                                                                                                                           |  | (2) AUTOVON (if applicable)                                                                                                                         |                                         |
| 8. PREPARING ACTIVITY                                                                                                     |  |                                                                                                                                                     |                                         |
| a. NAME                                                                                                                   |  | b. TELEPHONE (Include Area Code)                                                                                                                    |                                         |
| DLA - CT                                                                                                                  |  | (1) Commercial<br>(215) 737-8105                                                                                                                    | (2) AUTOVON<br>(DSN) 444-8105           |
| c. ADDRESS (Include Zip Code)                                                                                             |  | IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT                                                                                               |                                         |
| DEFENSE PERSONNEL SUPPORT CENTER<br>2800 S. 20th St. (DPSC-FSSD/Bldg. 12-3-D)<br>Philadelphia, PA 19101-8419              |  | Defense Quality and Standardization Office<br>5203 Leesburg Pike Suite 1403 Falls Church VA 22041 3466<br>Telephone (703) 756 2340 AUTOVON 289-2340 |                                         |