INCH POUND

MIL-P-6279L
15 January 1993
SUPERSEDING
MIL-P-6279K
15 March 1987

MILITARY SPECIFICATION

PARKA, EXTREME COLD WEATHER, TYPE N-3B

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

1. SCOPE

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

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 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.

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

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

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

2. APPLICABLE DOCUMENTS

2.1 Government Documents.

2.1.1 Specifications, 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 shall be those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

SPECIFICATIONS

FEDERAL

A-A-52074	Cloth, Satin, Lining Material
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
V-T-295	Thread, Nylon
KK-L-2004	Leather, Cattlehide, Deerskin and Horsehide, Chrome Tanned
DDD-L-20	Label, for Clothing Equipage, and Tentage, (General Use)
PPP-B-636	Boxes, Shipping, Fiberboard

MILITARY

MIL-B-371	Braid, Textile, Tubular
MIL-C-484	Cloth, Wind Resistant Oxford, Cotton, Quarpel Treated
MIL-C-3735	Cuffs, Knit, Wrist and Ankle, and Cloth, Knitted
MIL-C-3924	Cloth, Oxford, Cotton Warp and Nylon Filling, Quarpel Treated

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

MIL-C-6590	Cloth, Pile (Synthetic Mouton, Knitted)
MIL-F-10884	Fasteners, Snap
MIL-C-11065	Cloth, Flannel, Wool and Nylon, 16 Ounce, Shrink Resistant.
MIL-C-18387	Cloth, Twill Cotton, Fire Retardant Treated
MIL-B-41826	Batting, Synthetic Fibers, Polyester, (Unquilted and Quilted)
MIL-C-43191	Cloth, Wind Resistant Sateen, Cotton and Nylon
MIL-C-43824	Cloth, Synthetic Fur, Knitted

STANDARDS

FEDERAL

FED-STD-311	Leather, Methods of Sampling and Testing
FED-STD-751	Stitches, Seams, and Stitching

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-731	Quality of Wood Members for Containers and Pallets
MIL-STD-2073-1	DOD Material Procedures for Development and Application of Packaging Requirements
MIL-STD-2073-2	Packaging Requirement Code

(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.)

2.2 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. Unless otherwise specified, the issues of documents not listed in the DODISS shall be the issues of the documents cited in the solicitation (see 6.2).

AMERICAN SOCIETY FOR TESTING AND MATERIAL (ASTM)

ASTM D-3951	Standard Practice for Commercial Packaging

Source: https://assist.dla.mil Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

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

RULES AND REGULATIONS UNDER THE TEXTILE FIBER PRODUCTS IDENTIFICATION ACT

(Copies may be obtained without charge from the Federal Trade Commission, Washington, DC 20580-0001).

(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.)

2.3 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), sample parkas shall be subjected to first article inspection in accordance with 4.3 and 6.3.

3.2 Materials. It is encouraged that recycled and reclaimed materials be used when practical as long as it meets the requirements of this document.

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

3.2.2 Interlining. The fabric for the interlining shall be batting, type VIII, class 9, Style A, Cover B, MIL-B-41826, except that the dimensional stability test does not apply.

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

3.2.4 Pocketing. The fabric for the inner ply of pocketing shall conform to MIL-C-11065, color OG-108. As an alternate, a rayon or cotton satin cloth conforming to Type I of A-A-52074, color natural, may be used. If the alternate is used, the back side of the cloth shall be designated as the face.

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

3.2.5 Protective flap. The fabric for the interlining in the outer protective flap of the parka shall conform to type I, class 2 of A-A-52085.

3.2.6 Thread.

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

3.2.6.2 Cotton. The thread for stitching the knitted fabric shall conform to type I, ticket No. 30, 3 ply of A-A-52094. The thread shall match the shade of the outer shell fabric. The thread shall show good colorfastness to light, wet-dry cleaning and to perspiration.

3.2.7 Hood.

3.2.7.1 Trimming. The hood trimming shall conform to MIL-C-43824 except that the color shall be white.

3.2.7.2 Hood lining. The lining shall conform to Type I or Type II of MIL-C-6590 except that the ground fabric shall be synthetic. The color of the synthetic mouton shall be a good approximation of the approved shade of sage green (AF Shade 1530).

3.2.8 Wristlets. The wristlets shall conform to type I, Class 2, size 2 of MIL-C-3735. The color shall be AF Shade 1525.

3.2.9 Drawcord and loops. The drawcord for the hood, the waist adjustments, and the loops on the front closure of the parka shall conform to type II, class 2 of MIL-B-371. The braid shall match the color of the outer-shell fabric. Each drawcord shall be 46 inches long. The ends of the drawcord shall be tipped or impregnated with cellulose acetate or cellulose acetate butyrate to prevent raveling. The length of the tipping or impregnation shall be approximately 5/8 $\pm$ 1/8 inch. The color of the tipping or impregnation shall be transparent or approximate the shade of the outer-shell fabric.

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

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

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

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

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

3.2.11.2 Slide fastener thongs. The dimensions for the finished slide fastener thong shall be 1-1/2 inches long by 3/4 inches (at center) wide by 1/4 inches taper cut length.

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

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

3.2.14 Slide fasteners. All slide fasteners shall conform to Table I and to V-F-106. The chain shall be brass, aluminum, or zinc alloy with a short pull tab to accommodate a 3/4 inch wide thong. The finish of the metal parts shall be natural chromate finish if zinc alloy, black chemical finish if brass, or colored anodized finish if aluminum. The lengths of the slide fasteners shall conform to Table II.

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE I. Slide Fasteners.

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

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

TABLE II. Length of slide fastener.

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

3.2.14.1 Slide fastener tape.. The tape shall be cotton or cotton warp/nylon filling and vat dyed to approximate the shade of the outer-shell material before oxidizing treatment is applied. Darker shades of the treated tapes will be acceptable provided that the shade of the tape before treatments and after dry cleaning meet the specified color requirements.

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

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

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

3.4.1 Type 301 stitching. Ends of all stitching shall be backstitched or overstitched not less than 1/4 inch except where ends are turned under or caught in other seams or stitching. Ends of a continuous line of stitching shall overlap not less than 1/2 inch. Thread tensions shall be maintained so that there will be no loose stitching resulting in loose bobbin or top thread or excessively tight stitching resulting in puckering of the materials sewn. The locks shall be imbedded in the materials sewn.

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

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

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

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

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

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

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

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

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

3.4.7 Patterns. Standard patterns to be used to cut working patterns will 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 allowed 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. The standard patterns provide an allowance of 3/4 inch for all seams except sleeve inseam which shall be 1/2 inch. Unless otherwise indicated in Table IV, seams shall be in accordance with these seam allowances.

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

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

Table III

PATTERN PARTS	NO. TO BE CUT
Outer shell (see 3.2.1)	
Front	2
Back	1
Undersleeve	2
Topsleeve	2
Front Flap	2
Protective Fly	2
Elbow Patch	2
Cuff Reinforcement Piece	2
Tunnel Piece	1
Pencil Pocket	1
Utility Pocket	1
Lower Pocket Welts and Facing	4
Muff Pocket Welts and Facing	4
Lower Pocket Flap and Facing	4
Hood Facing for Mouton, Left Side	1
Front Hood Strap	1
Back Hood Strap	1
Hood Front Panel	2
Hood Side Panel	2
Hood Center Panel	1
Cowl for Hood	2
Loop for Retaining Hood Drawcord (No pattern, see operation 1a)	1
Hanger(No pattern, see operation 21)	1
Interlining (see 3.2.2)	
Front	2
Back	1
Topsleeve	2
Undersleeve	2
Protective Fly	1
Muff-Pocket	2
Lower Pocket	2
Cowl for Hood	1
Lining (see 3.2.3)	
Front	2
Back	1
Topsleeve	2
Undersleeve	2

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

Table III

PATTERN PARTS	NO. TO BE CUT
Pocketing (see 3.2.4)	
Muff Pocket	2
Lower Pocket	2
Cloth Drill (see 3.2.5)	
Flap Liner	1
Trimming-Fur (see 3.2.7.1)	
Cowl Edge	1
Hood Lining (see 3.2.7.2)	
Neck Piece	1
Hood Center Panel	1
Hood Front Panel	2
Hood Side Panel	2

3.6 Manufacturing Operations Requirements. The parka 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 that the finished item is identical to that provided by following the sequence as listed in Table IV.

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
Auto - Automatic

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
1.	CUTTING The material shall be cut in accordance with patterns that show size, shape, directional lines for cutting, placement of pockets, and notches for proper assembling of all parts. The directional lines for cutting mouton shall not apply. a. OUTER SHELL. The fabric shall be cut face up or down. Each ply of material shall be laid with the face of the cloth against the back of the next ply below, or as an alternate method, the cloth may be laid face to face. When material is spread face up, no stain producing marking agent shall be used in marking the top ply. The finished parka shall have the face side of the outer-shell fabric on the outer side of the garment. The inside of the roll shall be considered the face side of the material. Cut a 2-1/4 inch by 2-1/4 inch piece of basic cloth for the loop for retaining the hood drawcord. b. All parts of the outer shell shall be cut from one piece of material, except the pocket facings, tunnel, hood facing for synthetic mouton left side, flap linings and hanger which may be cut from ends.			

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	c. INTERLINING. Cut the quilted fabric by laying each section of the pattern up or down in the direction of the warp, that is, each section of the pattern may be placed with the directional line pointing in opposite warpwise directions. d. DRILL CLOTH. The cotton cloth drill fabric shall be cut as specified for the outer-shell fabric in operation 1a. e. HOOD LINING. Synthetic mouton shall be marked on the reverse side from the pile side, and the cut shall be made at right angle to the back through the pile. f. At the time of cutting, replace any part containing shade bars, holes, or weakening defects such as smashes, multiple floats, and loose slubs, which are likely to develop into a hole. g. Replace any part damaged during the manufacturing process by needle chew (which may be expected to develop into a hole), scissor or knife cuts, tears, holes, mends, or burns. h. Cut the synthetic fur knit cloth in the direction of the wales (lengthwise) 3 $\pm$ 1-1/4 inch wide and as required by the length of the cowl. There			

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	shall be no piecing. i. Cut the wool/nylon flannel pocketing in accordance with patterns furnished.			
2.	SHADE MARKING a. Except those parts cut from ends as indicated in operation 1b, all component parts shall be marked, ticketed or bundled to insure proper assembly of sizes and uniform shade throughout the garment. b. The marking may be any method except adhesive type tickets that will leave traces of paper or adhesive type tickets that will leave traces of paper or adhesive on the material after tickets are removed. No metal fastenings shall be used.			
	FRONTS - OUTER SHELL			
3.	UPPER POCKETS AND WELTS The two front slash pocket welts shall finish 7/8 ± 1/8 inch wide with 10-1/2 + 1/4 or -1/2 inch opening. Pockets shall finish 9 inches deep. a. Fold and sew the welt and facing pieces to the pocketing material. The selvage edge need not be turned in. The welt pieces shall extend sufficiently beyond the pocketing.	301	LSd-1 or BSc-1	12

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	b. Sew the two pocket pieces on the fronts, at the drill marks, with a double row of stitching.	301	SSv-2	12
	c. Cut the opening for the pockets. Tongue notch each corner.			
	d. Turn the pocketing through the slit; double over at the front edge for reinforcement, to form a 7/8 inch welt. Raise stitch the bottom of the welt with a single row of stitching 1/16 inch from the edge.	301	LSq-2(b)	12
	e. Sew the tongues at the corners to the welt on the inside, through the welt and the facing with a single row of stitching. The front shall overlap the welt.	301	SSa-1	12
	f. Raise stitch the seam joining the faced pocket piece to the front and the ends of welt with a single row of stitching 1/16 inch from the edge. The front shall overlap the faced pocket piece.	301	LSq-2(b)	12
	g. Sew around the pocketing with a single row of stitching 1/2 inch from the edge.	301	SSa-1	12
	h. Bartack the corners of the pocket openings with a 7/8 inch bartack at each end.	brtck		28 per brtck

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	i. Stamp two buttons and snap sockets, centered on each welt with a 1/8 inch tolerance, 3-1/4 inches from each end of the pocket opening. Stamp the studs and the eyelets on the facing to correspond to the button snaps.			
4.	LOWER POCKETS AND POCKET FLAPS			
	a. The flaps shall incorporate a button snap and a socket with the center of the socket 3/4 inch from the finished edge.			
	b. Sew the flaps to the flap facings around sides and bottom with a 1/4 inch seam.	301 or 401	SSe-3(a)	12
	c. Turn the flap and edge stitch with a double row of stitching 1/4 inch gage, with outside row of stitching 1/16 inch from edge.	301	SSe-3(b)	12
	d. The two lower front pockets shall be reinforced on each end with a leather triangular-shaped reinforcement piece. The opening shall be in accordance with the drill marks, and the top of the pocket shall be raise stitched with a single row of stitching 1/4 inch from the edge. The depth of the pocket shall be 9 (± 1/2) inches. A stud and an eyelet shall be stamped on the			

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	pocket to correspond with the button snap and the socket on the flap.			
	e. Fold and sew the facings to the pocketing material.	301	LSd-1	12
	f. Sew the flaps on the fronts, at the drill marks, with a single row of stitching.	301	LSq-2(a)	12
	g. Sew the pocketing on the fronts, at the drill marks, with a single row of stitching.	301	SSbe-2(a)	12
	h. Cut the opening for the pockets. Tongue notch the corners.			
	i. Place the pocketing through the slit, double over at the lower edge of the pocket and raise stitch with a single row of stitching 1/16 inch from the edge through the pocketing and the outer shell, forming a 1/2 inch welt.	301	SSbe-2(b)	12
	j. Tongues at the corners shall be sewn to the pocketing on the inside.	301	SSa-1	12
	k. Sew around the edge of the pocketing with a 1/2 inch seam.	301	SSa-1	12
	l. Bartack the corners of the pocket opening with a 1/2 inch bartack.	brtck		28 per brtck

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	m. Sew across the top of the flap of the parka through the pocketing with a single row of stitching 1/16 inch from the edge. The outershell shall overlap the pocket flap.	301	LSq-2(b)	12
	n. The corners of the pocket openings shall be reinforced. Cut a 1-1/4 inch square piece of leather diagonally through the center to form a triangle. Place the long side of the triangular-cut leather piece parallel with the edges of the pocket flap, and sew all around with a single row of stitching of 1/8 to 1/16 inch from the edge. The leather pieces shall cover the stitching on each side of the pocket.	301	SSa-1	10
5.	JOINING OUTERSHELL			
	a. Join the front and back side seams with a single row of stitching 1/2 inch from the edge with the front overlapping the back. Raise stitch 1/4 to 5/16 inch gauge, 1/16 inch from the folded edge.	301 or 401	LSq-3(a) and LSq-3(b)	6-8 12
	or			
	b. Join the front and the back seams with a double lapped seam with the front overlapping the back 1/4 to 5/16 inch gauge, 1/16 inch from folded edge.	301 or 401	LSc-2	6-8

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ SEAM TYPE	STITCHES PER INCH
	c. Position and bartack a 46-inch drawcord to each side seam of jacket (outershell) at notches. The free ends of the drawstring shall face toward the front opening.	brtck		28 per brtck
	d. Turn the ends of the waist tunnel strip in, and stitch the strip with drawcord inserted across the back between the double row of stitching, 7/8 to 1 inch gage.	301	SSv-2	12
	SLEEVE - OUTER SHELL			
6.	PENCIL AND UTILITY POCKET			
	The pocket shall be made of outer-shell fabric and shall consist of a bellows-style utility compartment, with a vertical slide fastener closure on the forward side the full length of the pocket and a pencil compartment with four openings, two upper and two lower. The front openings and the rear openings shall be 7/8 ± 1/8 inch wide. The pocket shall finish approximately 5-3/4 ± 1/4 inches long and 3-1/2 inches wide, including the slide-fastener tape. The width measurements shall be taken across the top of the pocket.			
	a. Hem the top opening of the pencil compartment in accord-ance with notches, and sew with	301	EFa-2	12

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	a double row of stitching, 1/4 inch gage, with the first row of stitching 1/16 to 1/8 inch from the top edge.			
	b. Fold the pencil pocket at the lower notches to form the two lower openings, and sew with a double row of stitching, 1/4 inch gage, 1/16 to 1/8 inch from the edge.	301	OSf-2	12
	c. Fold the opening to the center notches, tacking each side edge with a single row of stitching (optional).	301	SSa-1	12
	d. Slit the fold through the center to make pencil pass-through. The pencil compartment may be made in two pieces.			
	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 notches and the drill marks, with the bottom edges even.	301	LSd-2	12
	f. Place a single row of stitching centered between the front edge and the back edge the entire length of the pencil compartment to separate openings.	301	SSv-1	12

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	g. Bartack the top ends of all pencil compartment openings, with the bartacks superimposed on the inner row of double stitching and on the center row of stitching. Bartacks shall be 3/8 to 1/2 inch long.	Brtck		28 per brtck
	h. Form a 3/4 inch bellows by joining the two bottom corners with a single row of stitching 1/4 inch from the edge.	301	SSa-1	12
	i. Seam the slide fastener tape to the forward side of the pocket with a 1/4 inch seam. The slider shall be at the top of the pocket when the fastener is closed.	301	LSq-2(a)	12
	j. Turn and raise stitch the pocket with a single row of stitching 1/16 inch from the edge of the pocket.	301	LSq-2(b)	12
	k. As an alternate to 6.i and 6.j, fold under the front edge of the pocket 1/4 to 3/8 inch, and with slide fastener face side up, stitch front edge to the left side of the slide-fastener tape 1/16 inch from the folded edge. The slider shall be at the top of the pocket when the slide fastener is closed.	301	LSb-1	12

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	l. Stitch the front edge of the slide fastener tape to the left topsleeve at the drill marks. Turn the raw edge of the pocket under 1/4 inch, and stitch all sides with a single row of stitching 1/16 inch from the edge. The slide fastener tape shall be turned under at the top and bottom ends.	301	LSd-1 or LSa-1 and LSa-1	12
	m. A second row of stitching shall be placed 1/4 inch from the front edge of the tape and across the top of the pocket.	301	SSa-1	12
	JOIN - SLEEVES			
7.	ELBOW PATCHES			
	a. Turn under raw edges of elbow patches 1/2 inch and attach to sleeve with a double row of stitching, with the first row of stitching 1/16 inch from turned edge, with a 1/4 inch gage.	301	LSd-2	12
	b. Join the sleeve outseam with a double-lapped seam with the top sleeve overlapping the under-sleeve, 1/4 to 5/16 inch gage, 1/16 inch from the folded edge.	301 or 401	LSc-2	6-8
	NOTE: Elbow patches and reinforcement pieces may be prehemmed prior to attaching to sleeves with the stitching 1/16 inch from folded edge.			

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	c. Turn under raw edge of cuff reinforcement piece and stitch to bottom of sleeve, in accordance with the notches, 1/16 inch from folded edge.	301 or 401	LSd-1	12
	d. Join the inseams with a double lapped seam with the top sleeve overlapping the under-sleeve 1/4 to 5/16 inch gage, 1/16 inch from folded edge.	301	LSc-2	6-8
	e. Join sleeve to front and back with a 1/2 inch seam, with front and back overlapping the sleeve, raise stitch 1/4 inch to 5/16 inch gage, 1/16 inch from folded edge.	301 or 401	LSq-3(a) and LSq-3(b)	12
	PREPARE HOOD - OUTER SHELL			
8.	JOIN PANELS			
	a. Join the front panel to the side panel with a double lapped seam, 1/4 to 5/16 inch gage, 1/16 inch from the folded edge.	401	LSc-2	6-8
	b. Join the side panels to the center panel with a double lapped seam 1/4 to 5/16 inch gage, 1/16 inch from folded edge.	301 or 401	LSc-2	6-8
	c. Sew two 1 inch square leather reinforcement pieces to each end of the front panel, centered at the drill marks, with a single row of stitching	301	SSa-2	10

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	1/16 inch from the edge all around. A second row of stitching shall be sewn 1/4 inch from the edge for the hole reinforcement. c. Punch a 1/4 inch hole through the center of the patches and the outer shell.			
9.	SEW HOOD			
	a. Sew the cowl outer shell to the hood in accordance with the notches, with a single row of stitching 1/2 inch from the edge, catching a hood tunnel loop. The loop shall be centered on the hood center panel.	301	SSa-1	12
	b. Thread a 46 inch drawstring through the leather reinforcement patches and hood tunnel loop. Knot each end of the drawstring approximately 2 inches from the threaded or the tipped end. c. Prepare the takeup straps in accordance with the patterns.			
	d. Fold side raw (long) edges, and join edge to edge with a single row of stitching 1/16 inch from the edge. The strap shall finish 4-1/2 inches in length by 5/8 to 3/4 inch in width.	301	EFp-2	12

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	e. Insert the 4-1/2 inch strap over the second bar from the square end of the buckle so that the top side end of the strap extends approximately 1/2 inch beyond the underside end.			
	f. Fold the long end over the short end approximately 1/2 inch and attach to the hood, at the first drill mark from the cowl, with a single row of stitching 1/16 inch from the edge, forming a 1/2 inch box.	301	LSd-1	12
	g. Prepare a 10-inch strap in accordance with patterns; fold side raw (long) edges; join edge to edge with a single row of stitching 1/16 inch from the edge all around with one end of the strap finished clean. The strap shall finish 5/8 to 3/4 inch in width.	301	EFp-2	12
	h. Turn the end of the 10-inch strap under 1/2 inch and attach to the hood at the second drill mark from the cowl with a single row of stitching 1/16 inch from the edge, forming a 1/2 inch box.	301	LSd-1	12

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
10.	JOIN HOOD TO PARKA			
	a. Sew the hood to the parka with a single row of stitching 1/2 inch from the edge.	301	LSq-2(a)	12
	b. Raise stitch seam on the hood with a single row of stitching 1/4 inch from the edge.	301	LSq-2(b)	12
11.	PREPARE OUTER PROTECTIVE FLY			
	The outer fly shall be fabricated from two plies of outer-shell fabric (see 3.2.1) and one ply of cotton drill (see 3.2.5).			
	a. Join one ply of the outer-shell fabric to the cotton drill with four rows of parallel stitching with the two center rows equidistant from each other and from the outside rows.	301 or 401	SSv-4	12
	b. Place a single row of stitching 1 inch from the edge of the protective fly on the side opposite that of the loops.	301 or 401	SSv-1	12
	c. Prepare four loops, fabricated from cotton braid, 3-1/2 inches long. Fold the loops in half and attach to the front flap, at the notch marks, with a single row of stitching.	301	SSa-1	12

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	d. Join the fly pieces together with a single row of stitching 1/2 inch from the edge, on the top and the bottom.	301	SSe-2(a)	12
	e. Turn and raise stitch the fly pieces with a single row of stitching 1/4 inch from the edge.	301	SSe-2(b)	12
12.	PREPARE INNER PROTECTIVE FLY The inner fly shall be fabricated from two plies of outer-shell fabric and one ply of interlining cloth.			
	a. Join the two plies of the outer-shell fabric to the one ply of interlining cloth, with a single row of stitching 1/2 inch from the edge, on the top, along the side and bottom.	301 or 401	SSe-2(a)	12
	b. Turn and raise stitch with a single row of stitching 1/4 inch from the edge on top, along the sides and bottom.	301	SSe-2(b)	12
	c. Quilt the fly through and through with four rows of parallel stitching with the two center rows equidistant from each other and from the outside rows.	301	SSv-4	12
13.	JOINING OUTER PROTECTIVE FLY. a. Sew the protective fly to left front of the outer shell in accordance with the notch marks on the pattern and finish	301	SSa-1	12

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	joining to the hood seam with a 1/2 inch seam.			
14.	ATTACH SLIDE FASTENER TO OUTER SHELL			
	a. Attach slide fastener to the right and the left front edges of the outer shell approximately 1/2 inch below the raw edge cowl piece with a single row of stitching, 1/2 inch seam. The slide fastener tape shall be exposed approximately 1/4 inch.	301	SSa-1	12
	a. The slide fastener shall be attached without excessive length of tape put in at any one point. The tape at the top shall be turned under and finished with no raw edges exposed. The finished bottom of parka shall be even on the right and left fronts.			
	b. Attach a leather thong to the hole in the slider and sew around the top, the bottom, and the sides with a single row of stitching 1/8 inch from the edge, or the thong shall be securely stitched with a crossed box or triangular stitching.	301 Auto Mchne	SSa-1	10 minimum
15.	JOINING INNER PROTECTIVE FLY.			
	Sew the inner protective fly to the right front of the outer-shell fabric in accordance with the marks on the patterns, with a single row of stitching 1/2 inch from the edge.	301	SSa-1	12

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
16.	PREPARE LININGS			
	a. Sew all batting interlining pieces and the respective lining pieces together all around the edges with a single row of stitching 1/4 inch from edge, in accordance with the notches.	301 or 401 or 502	SSa-1	6-8
	b. Make a second row of stitching on the fronts and the backs 2 inches above the stitching at the bottom through the two layers.	301 or 401	SSv-1	6-8
	c. On left side of parka, quilt the front edge of the lining and the interlining, with four rows of through and through parallel stitching, 1/2 inch gage.	301 or 401	SSv-4	6-8
	d. ATTACH LABEL. Position the label at the center of the neck and sew to the lining along all four edges with a single row of stitching 1/16 to 3/16 inch from the edge, 1-1/2 inches (± 1/4 inch) from the neck seam.	301	LSbj-1	12
	e. Make the hanger of outer-shell fabric to finish 1/2 inch wide and 3-1/2 inches long.	301 or 401	EFp-2	12
	f. ATTACH HANGER. With the ends turned under, position the hanger at the center of neck directly above the label and sew through the interlining and the lining only with a double row of stitching 1/4 inch apart at each end, or bartack may be used in lieu of stitching.	301 brtck	LSd-2 LSd-1	12 28 per brtck

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	g. Join the side seams by overedging and seaming the raw edges together in one operation.	515 or 516 or 517	SSa-2	12
	h. SLEEVE LININGS. Sew all interlining pieces and the respective lining pieces together, all around the edges, with a single row of stitching 1/4 inch from the edge, in accordance with the notches.	301 or 401	SSa-1	6-8
	i. JOIN SLEEVE LININGS. Join the sleeve inseam by overedging and seaming the raw edges together in one operation.	515, 516 or 517	SSa-2	12
	j. Join the sleeves to arm hole by overedging and seaming the raw edges together in one operation.	515, 516 or 517	SSa-2	12
	k. Join the elbow seam by overedging and seaming the raw edges together in one operation.	515, 516 or 517	SSa-2	12
	l. REINFORCEMENT PIECES FOR WAIST DRAWCORD. Sew two 1 inch square leather reinforcement pieces, centered at the drill marks, with a single row of stitching 1/16 inch from the edge all around. A second row of stitches shall be sewn 1/4 inch from the edge to reinforce	301	SSa-2	10

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	the hole. The leather reinforcement pieces shall be on the nylon lining.			
	m. Punch a hole through the center of the reinforcement patches and the lining and the fabric.			
	n. Thread the free ends of the drawcord through the holes in the leather reinforcement openings. Knot each free end of the drawcord approximately 2 inches from the headed or the tipped ends, leaving the drawcord on the inside of the garment.			
	o. Serge the prefolded raw edges of the wristlets.	502 or 503	SSa-1	6-10
	p. Attach the wristlets, at the notches, to the nylon side of the sleeve lining, stitching through and through the nylon and the pile with a double row of stitching.	301	SSa-2	12
17.	PREPARE HOOD LINING			
	a. Join the front panels to the side panels with a 1/8 inch seam on a fur machine.	501	SSa-1	9
	b. Join the crown to the side panels with a 1/8 inch seam on a fur machine.	501	SSa-1	9

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	b. PREPARE COWL FLAP. Sew the quilted batting strip to the outer-shell fabric, along back edge of cowl strip, with a single row of stitching 1/4 inch from the edge all around.	301 or 401	SSa-1	10
	c. Position the nylon protective pieces on the fur side of the mouton at the left end of the hood. Turn under the back edge of the protective piece and stitch the back and the front edge to the mouton.	301	LSd-1 and SSa-1	10
	d. Join the cowl flap to the mouton lining with a single row of stitching 3/8 inch from the edge.	301	SSa-1	6-10
	JOINING			
18.	JOINING HOOD TO LINING			
	a. Join the fur hood to the neckline lining with a single row of stitching 1/2 inch from the edge.	301	LSq-2(a)	12
	b. Turn and raise stitch seam on the lining with a single row of stitching 3/8 inch from the edge. NOTE: The joining seam is 1/2 inch wide. If the raise stitching is 1/2 inch from the edge, the turned seam may be missed in the stitching.	301	LSq-2(b)	12

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	c. JOIN LININGS. Join the bottom of sleeve linings to the outer-shell, catching the sleeve reinforcement strip at the wrist, with a 1/2 inch seam.	301	SSe-2(a)	12
	d. Join the linings to the outer shell with a 1/2 inch seam all around, leaving an opening at the bottom for turning.	301	SSe-2(a)	12
	e. Join the mouton hood (cowl) fronts to the outer shell hood fronts at the center position for a distance of approximately 4 to 6 inches, with a single row of stitching 3/8 inch from the edge.	301	SSa-1	12
	f. Turn the parka right side out.			
19.	TOP STITCH PARKA			
	a. Raise stitch fronts of the parka, starting at the bottom circling the parka and finishing at the starting point, with a single row of stitching 1/4 inch from the edge. The parka shall be clean finished at the opening. Close bottom turn through as parka is raise stitched.	301	SSe-2(b)	12
		301	SSc-1	12
	b. Raise stitch bottom of the sleeves with a single row of stitching 1/4 inch from the	301	SSe-2(b)	12

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	edge. The parka shall be clean finished at the opening. Close bottom turn through as parka is raise stitched.	301	SSc-1	12
	c. Quilt the entire length of cowl with four rows of parallel stitching 1/2 to 3/4 inch apart, with the outer row of stitching positioned 1/4 to 3/4 inch from the edge of cowl.	301	SSv-4	12
	d. Make the tunnel to form the channel for the drawstring by stitching 1 inch from the cowl seam and terminating at the outer side of the leather reinforcement pieces.	301	SSa-1	12
20.	SEW FUR TRIMMING			
	a. Sew pleats to conform to the shape of the cowl of the hood.	501 or 301	SSa-1	12
	b. Sew the mouton strip to the bottom edge of the fur trimming, on the right side, with a fur machine.	501	SSa-1	9
	c. Attach the synthetic fur trimming to the shape of the cowl with a single row of stitching 1/8 inch from the edge, all around, including the edges of the mouton strip. The fur trimming shall extend to and finish at the end of the inner protective fly, right side. The ends of the stitching shall be backstitched 1/2 inch at the top edge and the	301	SSa-1	9

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
	lower edge of the fur trimming on each side of the slide-fastener. There shall be no more than a 1/2 inch open seam on each side of the slide-fastener scoops. As an option, the fur strips may be basted approximately 1/2 inch from the edges, catching the long hair of the fur and holding them away from the edges, to facilitate the stitching of the fur to the hood. After the fur is attached, remove the basting stitches.			
	d. Sew a second row of stitching 1/2 inch from the edge on the end of the fur piece, at the left side front opening, with the hair bent away from the slide-fastener chain and caught in the stitching to prevent obstructing the slide fastener.	301	SSa-1	9
	e. The mouton strip shall butt the mouton hood lining.	301	SSa-1	9
	PLACEMENT OF STUDS, SOCKET, SNAPS, AND EYELETS			
21.	OUTER PROTECTIVE FLY			
	Set a button snap and a socket on the lower end of the fly at the joining seam.			

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE IV. Sewing Operations (Cont'd)

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STITCHES PER INCH
22.	INNER PROTECTIVE FLY Set a stud and an eyelet on the inner protective fly to correspond with the snap and the socket on the outer protective fly.			
23.	BUTTONS Sew four 45-line buttons on the right front of the parka at the drill marks. The buttons shall be sewn through the front and the outer ply of the hanging pocket only. All buttons shall be tightly wrapped to form a shank, and the ends of the thread shall be tacked off. NOTE: It is difficult to sew buttons through the outer shell and lining restricts the use of the pocket opening on most sizes.	101 or 301 or hand		22 per button 16 per button 4-6 per button (double thread)
24.	CLEANING a. All loose ends of thread. shall be trimmed, and loose thread shall be removed. b. Remove all soil or spots. c. Remove the shade-marking tickets.			
25.	FASTENING Close the slide fastener, fasten the snap fasteners, and button parka.			

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

3.8 Finished measurements. Finished measurements shall conform to Table V.

TABLE V. Finished measurements (in inches).

Measurements 1/	Size							
	Extra Extra Small	Extra Small	Small	Medium	Large	Extra Large	Extra Extra Large	Tol. +/-
Back length	32-3/4	33-1/4	33-3/4	34-1/4	34-3/4	35-1/4	35-3/4	3/4
1/2 Chest	23-1/4	25	26-3/4	28-1/2	30-1/4	32	33-3/4	3/4
Sleeve inseam	18	18-1/4	18-1/2	18-3/4	19	19-1/4	19-1/4	1/2

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

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

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

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

Size: XXS (example) 1/
Stock No.: 8415-00-000-0000 (example) 2/
Parka, Extreme Cold Weather Type N-3B
Contract No.: DLA100-00-0-0000 (Example) 2/
Wool products act (information as applicable) 2/
DRY CLEAN ONLY
DO NOT TUMBLE DRY HOOD
Contractor's name: 2/

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

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

2/ The contractor shall include the applicable information.

3.10 Workmanship. The finished parkas shall conform to the quality of product established by this specification. The occurrence of defects shall not exceed the applicable quality levels (AQL).

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

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements (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 assure supplies and services conform to prescribed requirements.

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

4.1.2 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.

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

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

a. First article inspection (see 4.3).

b. Quality conformance inspection (see 4.4).

4.3 First article inspection. The first article, submitted in accordance with 3.2, for compliance with design, construction, workmanship and dimensional requirements shall be examined for the defects specified in 4.4.3.

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

Lot size (units)	Sample size
800 or less	2
801 to 22,000	3
22,201 and over	5

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

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

4.4.2.1 General defects. General defects shall be classified as follows:

Source: https://assist.dla.mil Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE VI. Classification of Defects.

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

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE VI. Classification of Defects.

Defect	Major	Minor A	Minor B
5. CUTTING			
a. Any component part not cut in accordance with directional lines on patterns or specified requirements		*	
6. DRAWCORD			
a. Not specified type, size, or color.		X	
b. End(s) not tipped or impregnated		X	
c. Length of tipped (or impregnated) ends less than 1/2 inch			X
7. LABELS			
a. Combination size, identification, and instruction label. - missing or size marking omitted, incorrect, or illegible	X		
- information (other than size) missing, incorrect or illegible			X
- not stitched on four sides to lining			X
b. When information is not incorporated in (combination, size, identification, and instruction labels) missing, incorrect, or illegible			X
8. MATERIAL DEFECTS AND WORKMANSHIP DAMAGES.			
Material defects and workmanship damages shall be classified as indicated when the condition definitely weakens the fabric. If the defect does not weaken the fabric but is conspicuous when the garment is worn, it shall be classified as indicated. Material defects or workmanship damages that are inconspicuous and definitely do not weaken the fabric			

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE V.. Classification of Defects.

Defect	Major	Minor A	Minor B
shall not be classified as defects.			
a. Any weakening defect such as a hole, smash, multiple float, and loose slub		*	
b. Shade bars, unsightly slubs affecting appearance - on outside of garment		*	
- on inside of garment			X
c. Drill hole, cut, tear, mend, burn, or needle chew that may develop into a hole		*	
d. Ruptured fibers in the line of sewing affecting appearance or serviceability		X	
e. Drawcord weakened by broken or fraying strands.		X	
9. SEAMS AND STITCHING			
a. Accuracy of seaming			
(1) Seam twisted, puckered, or pleated		*	
(2) Part of parka caught in any unrelated operation or stitching		*	
(3) Thread(s) used on outside not same shade or not satisfactorily matching shade of parka		X	
(4) Thread breaks or end(s) of stitching, when not caught in other seams or stitching backtacked less than 1/4 inch		X	

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE VI. Classification of Defects.

Defect	Major	Minor A	Minor B
b. Gage of stitching (edge, top, or raise stitching)			
(1) Irregular, i.e., unevenly gaged or corresponding stitchings not uniformly gaged, affecting appearance		X	
(2) Not within range of gage specified or varies more than 1/16 inch when no range is specified			X
c. Open seam. A break in a line of stitching or continuous skipped or run-off stitches (except on edge, top, or raise stitching) shall constitute an open seam.			
(1) Open seam over 1/8 inch to and including 1/4 inch			X
(2) Open seam over 1/4 inch		X	
d. Stitches skipped or broken (on edge, top, or raise stitching when seam is seamed, turned, or stitched)			
- over 1/4 inch to and including 1/2 inch			X
- over 1/2 inch		X	
e. Raw edges. A raw edge is classified as such when it occurs along an edge required to be turned under, but the edge is securely caught in the stitching. If the edge is not securely caught in the stitching, it shall be scored as an open seam.			
(1) On outside			
- over 1/8 inch to and including 1/4 inch			X
- over 1/4 inch		X	

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE VI. Classification of Defects.

Defect	Major	Minor A	Minor B
e. Raw edges (cont'd)			
(2) On inside -over 1/2 inch to and including 1 inch			X
- over 1 inch		X	
f. Runoffs			
(1) On joining seams, when resulting in an open seam, score as open seam			
(2) On edge, top, or raise stitching when not resulting in an open seam (outside only) - over 1/2 inch to and including 1 inch			X
- over 1 inch		X	
g. Not specified stitch or seam type		X	
h. Stitch tension. Puckering is evidence of tight tension. When puckering is evident, the seam shall be tested by exerting normal pull in the lengthwise direction of seam or stitching			
(1) Loose tension, resulting in a loose seam	X		
(2) Loose tension on edge, top, or raise stitching, recognized by loosely exposed loops of top or lower thread		X	
(3) Tight tension (stitches break when normal strain is applied to seam or stitching) shall be scored as an open seam			

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE VI. Classification of Defects.

Defect	Major	Minor A	Minor B
i. Stitches per inch (to be scored only when the condition exists on major portion of seam or stitching			
(1) Less than minimum number permitted by minus tolerances by			
- one or two stitches			X
- three stitches		X	
- four or more stitches	X		
(2) One or more stitches in excess of maximum number permitted by plus tolerance			X
10. SHADED PARTS			
a. Outside parts shaded (visible when garment is worn)		*	
b. Lining and inside parts (not visible when garment is worn)			X
11. SLIDE FASTENERS			
a. Not specified type or size		*	
b. Parka part stitched too close to metal chain, not permitting slider to pass	X		
c. Top end of slide-fastener tapes not turned under when stitched		X	
d. Leather thong not securely stitched to pull tab			X
12. SNAP FASTENERS (APPLYING TO ALL SNAP FASTENERS)			
a. Missing, mismated, not securely clinched, or otherwise defective,			

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE VI. Classification of Defects.

Defect	Major	Minor A	Minor B
affecting function -one snap fastener -two or more snap fasteners	X	X	
b. One or more clinched too tightly, i.e., cutting surrounding fabric	X		
c. Rough or sharp edges or one or studs or sockets		X	

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

TABLE VI. Classification of Defects.

Defect	Major	Minor A	Minor B
1. HOOD			
a. Side panels overlapping front panels.			X
b. Side panels overlapping crown			X
c. Fronts or backs lapped on hood at neck joining seam		X	
d. Lining tight, short, or twisted, causing fullness or twist on outside of hood		*	
e. Stitches on cowl varying by more than 1/4 inch			X
f. Tunnel reinforcement leather pieces stitched to hood with one row of stitching around edges		X	

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE VI. Classification of Defects.

Defect	Major	Minor A	Minor B
g. Stitching forming tunnel less than 3/4 inch or more than 1-1/4 inches in the portion paralleling cowl seam			X
h. Tunnel badly twisted in stitching, affecting appearance		X	
i. Drawstrings			
(1) Less than 45-1/2 inches long, unknotted		X	
(2) Not inserted through one or both holes			X
(3) One or both free ends not knotted			X
j. Fur strip			
(1) Not extending to within 3/8 inch from front end of inner protective fly or edge of cowl		X	
(2) Stitching around strip less than 1/8 inch from edge			X
(3) Second row of stitching at left front less than 3/8 inch from edge			X
k. Hood takeup strap			
(1) Buckle omitted or defective, affecting function	X		
(2) Strap less than 5/8 inch. wide		*	

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE VI. Classification of Defects.

Defect	Major	Minor A	Minor B
(3) Short strap less than 1-1/2 inches in length when stitched		X	
(4) Long strap less than 8 inches when stitched		X	
(5) Tunnel loop omitted		X	
(6) Protective pieces on left side of mouton omitted	X		
2. FRONTS			
a. Buttons and loops out of alignment, causing an excessive bulge when buttoned		X	
b. Buttons out of vertical alignment by 3/8 inch or more			X
c. Stitches on one or both lower buttons caught through hanging pockets restricting use of pocket	X		
d. Loops			
- unequally spaced by more than 3/8 inch		X.	
- ends of one or more not securely caught in stitching	X		
- one or more too small, not permitting button to enter	X		
- too long not engaging button securely	X		
e. Snap fasteners on lower end of fly not aligned, causing noticeable bulge or twist when fly is closed appearance		X	

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE VI. Classification of Defects.

Defect	Major	Minor A	Minor B
(1) Tapes set on too loosely or too tightly, causing excessive bulging on opening, affecting appearance		X	
(2) Lengths less than specified in Table II of specification by more than 1/2 inch		X	
g. Slash pockets			
(1) Width of welt less than 3/4 or more than 1 inch			X
(2) Length of welt less than 10 or more than 10-3/4 inches		X	
(3) Bartacks at ends less than 3/4 inch long		X	
(4) Out of alignment with each other by 1/2 inch or more		X	
(5) Sockets and studs not aligned, causing excessive bulge or twist on pocket opening when snapped in		X	
(6) Sockets off-center with center of welt so that rim extends beyond edge or beyond seam		X	
(7) Sockets less than 3 or more than 3-1/2 inches from ends of welts measured from center of sockets)		X	
h. Spacing between parallel stitching on outer fly through interlining varying by more than 1/4 inch.			X

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE VI. Classification of Defects.

Defect	Major	Minor A	Minor B
i. Spacing between parallel stitching on inner fly through interlining varying by more than 1/4 inch			X
j. Fronts sagging, twisted, or bulging across chest, caused by tightness of lining or interlining		*	
k. Lower pockets			
(1) Triangular-cut leather reinforcement piece omitted at one or both corner of opening		X	
(2) Depth less than 8-1/2 or more than 9-1/2 inches		X	
(3) Socket off-center of flap by more than 1/4 inch or positioned less than 7/8 inch from bottom edge (measurement made from center fasteners)		X	
3. SLEEVES			
a. Sagging, twisted, bulging, or short, caused by shortness, tightness, or incorrect positioning or lining		*	
b. Back part of sleeve overlapping forepart of sleeve at inseam			X
c. Back part of sleeve overlapping forepart of sleeve at elbow seam		X	
d. Sleeve overlapping body parts at joining seam	X		
e. Knitted wristlets			

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE VI. Classification of Defects.

Defect	Major	Minor A	Minor B
(1) Not specified type or color		X	
(2) Twisted in the attachment to sleeve bottom, affecting appearance		X	
(3) Overedge stitching omitted at top edge of one or both wristlets		X	
f. Pencil and utility pockets			
(1) Length less than 5-1/2 or more than 6 inches		X	
(2) Width (including slide-fastener tape) less than 3-1/4 inches. Justification according to the pocket pattern and slide fastener together, the pocket will measure more than 3-3/4 inches		X	
(3) Set on crookedly, affecting appearance		X	
(4) Hem of pencil-pocket openings stitched with one row of stitching			X
(5) Front or back pencil opening less than 3/4 inch or more than 1 inch wide			X
(6) Pencil compartment piece not double stitched along front and back edges		X	
(7) Slide fastener not finishing toward front	X		
(8) Ends of slide-fastener tapes not turned under	X		

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE VI. Classification of Defects.

Defect	Major	Minor A	Minor B
(9) Top edge pocket and tape not double-stitched to sleeve		X	
(10) Slide fastener stitched to pocket with the slider closing downward		X	
g. Sleeve reinforcement piece			
(1) Twisted or full		X	
(2) Stitched with one row of stitching		X	
h. Sleeve terminal reinforcement strip			
(1) Omitted on one or both sleeves		X	
(2) Ends not terminating at inseam			X
4. BACK			
a. Front overlapping back at side seams			X
5. INSIDE OF PARKA			
a. Hanger			
(1) End(s) not securely stitched or bartacked		X	
(2) Finishing less than 3 or more than 4 inches long			X

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE VI. Classification of Defects.

Defect	Major	Minor A	Minor B
(3) Less than 3/8 inch wide			X
(4) Off-center with center of back by 1 inch or more			X
(5) Stitched through outer shell		X	
* (6) Tight lining			X
b. Label			
(1) Positioned less than 1-1/4 inches below neck seam			X
(2) Off-center with hanger by 1/2 inch or more		X	
(3) Stitched through outer shell		X	
c. Body linings			
(1) Stitching across bottom through nylon lining and pile fabric less than 1-1/2 inches or more than 2-1/2 inches from bottom			X
d. Waist tunnel stitching			
(1) Less than 3/4 or more than 1-1/8 inches wide		X	
(2) Rows of stitching irregular in width or crooked		X	
(3) Not extending to within 1/4 inch of both side seams			X
(4) Back excessively puckered or badly twisted by stitching		X	

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

TABLE VI. Classification of Defects.

Defect	Major	Minor A	Minor B
e. Waist drawstrings less than 45 or more than 47 inches long		X	
f. Tunnel reinforcement leather pieces stitched to lining with one row of stitching		X	

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

4.4.2.4 Inspection levels and acceptable quality level (AQL). The inspection level for 4.4.2.1 and 4.4.2.2 shall be II of MIL-STD-105, and the inspection level for 4.4.2.3 shall be S-3 of MIL-STD-105. The AQL for 4.4.2.1 and 4.4.2.2 shall be 1.0 defects per hundred units (dhu) for major defects, 4.0 dhu for major and minor A defects, and 15.0 dhu for major and minor A and B defects. The AQL for 4.4.2.3 shall be 1.0 dhu for defects (one class).

4.4.3 Examination of packaging requirements. An examination shall be made to determine that the 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 prepared for delivery. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot size shall be the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 and the acceptable quality level (AQL), shall be 1.0 defects per hundred units in accordance with MIL-STD-105.

Source: https://assist.dla.mil Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

Examine	Defect
Marking (exterior and interior)	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application.
Materials	Any component missing, damaged,. or not as specified serviceability.
Workmanship	Inadequate application of components, such as: incomplete closure of container flaps, loose strapping, improper taping, inadequate stapling bulged or distorted container.
Contents	Number of parkas per shipping container is more or less than required. Size shown on one or more parkas not as specified on shipping container. 1/

1/ For this defect, one parka from each shipping container shall be examined.

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 4.0 in accordance with MIL-STD-105.

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

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

5. PACKAGING

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

5.1.1 Level B. Each parka shall be folded to approximately 20 inches in length by 16 inches in width. Closure shall be in accordance with the appendix of the box specification.

5.1.2 Commercial. The industrial preservation of parkas shall be in accordance with the requirements of ASTM D-3951.

5.2 Packing. Packing shall be B or Commercial, as specified (see 6.2).

5.2.1 Level A. Four parkas of one size and type only, packaged as specified in 5.1.1, shall be packed in an exterior-type shipping container conforming to type CF-SF, class weather-resistant, grade V3c or V3s, style RSC of PPP-B-636. Closure and strapping shall be in accordance with the appendix of the container specification. The inside dimensions of the container shall be 24 inches long by 20 inches wide by 16 inches deep.

5.2.2 Level B. Four parkas of one size and type only, packaged as specified in 5.1.1, shall be packed in an exterior container conforming to type CF of SF, class domestic, style RSC-L minimum bursting strength 275 psi of PPP-B-636. The inside dimensions of the container shall be 24 inches in length, 20 inches in width, and 16 inches in depth. Containers shall be closed in accordance with method II of PPP-B-636.

5.2.3 Commercial. The preserved parkas shall be packed in accordance with the requirements of ASTM D-3951.

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

5.4 Palletization. Parkas packed as specified in 5.2 shall be palletized on a 4-way entry pallet in accordance with load type Ia of MIL-STD-147. Pallets shall be fabricated from wood groups I, II, III or IV of MIL-STD-731. Each prepared load shall be bonded with straps in accordance with bonding means C and D or film bonding means F or G. Pallet pattern shall be number 90 in accordance with the appendix of MIL-STD-147.

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

Source: https://assist.dla.mil Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

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

6.2 Acquisition requirements. Acquisition documents must 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 and 2.2).

c. Sizes required (see 1.2).

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

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

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

6.5 Subject term (key word) listing.

Clothing, extreme cold weather
Hooded garment
Protective clothing

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

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

Custodians:

Air Force - 99
Army - GL

Review activities:

Air Force - 11
Army - MD
Air Force - 82

User activity:

Air Force - 45

Preparing activity:

DLA - CT

Project No. 8415-0864

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

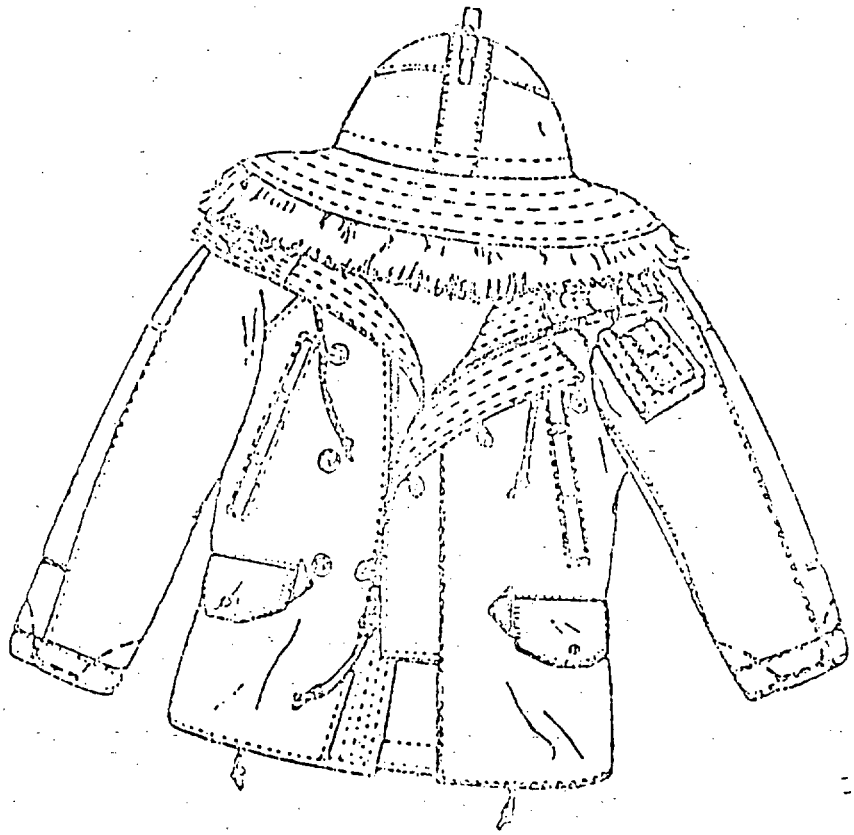

Figure 1. Front View
Parka, Extreme Cold Weather, Type N-3B

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.



Figure 2. Back View, Hood Up
Parka, Extreme Cold Weather, Type N-3B

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

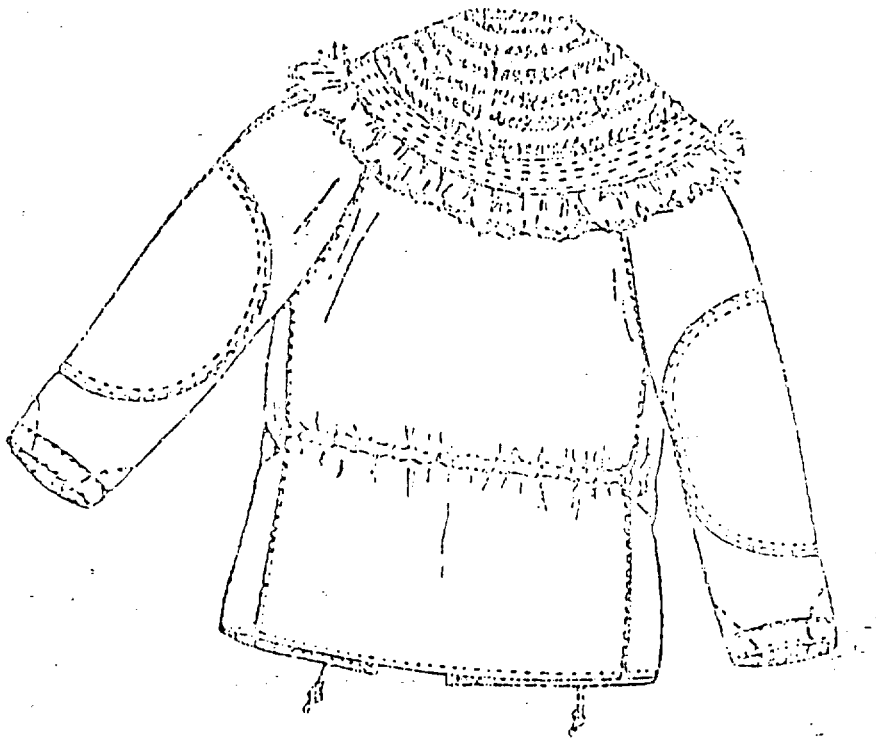

Figure 3. Back View, Hood Down
Parka, Extreme Cold Weather, Type N-3B

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.

STANDA :IZATION 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.

I RECOMMEND A CHANGE:	1. DOCUMENT NUMBER MIL-P-6279L	2. DOCUMENT DATE (YYMMDD) 93-01-15

3. DOCUMENT TITLE
PARKA, EXTREME COLD WEATHER, TYPE N-3B

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)* (1) Commercial (2) AUTOVON *(If applicable)*	7. DATE SUBMITTED *(YYMMDD)*

8. PREPARING ACTIVITY

a. NAME Defense Personnel Support Center ATTN: DPSC-FSSD (12-3-D)	b. TELEPHONE *(Include Area Code)* (1) Commercial 215-737-8105	(2) AUTOVON 444-8105
c. ADDRESS *(Include Zip Code)* 2800 South 20th Street P. O. Box 8419 Philadelphia, Pennsylvania 19101-8419	IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT: Defense Quality and Standard zation Office 5203 Leesburg Pike, Suite 1403, Falls Church, VA 22041-3466 Telephone (703) 756-2340 AUTOVON 289-2340	

DD Form 1426, OCT 89

Source: https://assist.dla.mil -- Downloaded: 2026-11-23T00:01Z
Check the source to verify that this is the current version before use.