INCH POUND

MIL-DTL-6279M
December 9, 2003

SUPERSEDING
MIL-P-6279L
15 January 1993

DETAILED 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.

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

Extra-extra small
Extra small
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 Supply Center Philadelphia, Clothing and Textiles Directorate, Attn: DSCP-COCT, 700 Robbins Ave Philadelphia, PA 19111-5096 or visit this website; http://www.dodssp.daps.mil

AMSC N/A FSC 8415

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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 Acquisition Streamlining and Standardization Information System (ASSIST) database and supplement thereto, cited in the solicitation (see 6.2).

SPECIFICATIONS

FEDERAL

A-A-55127	Batting
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
A-A-55634	Zippers (Fasteners, Slide Interlocking)
V-T-295	Thread, Nylon
KK-L-2004	Leather, Cattlehide, Deerskin and Horsehide, Chrome Tanned

MILITARY

MIL-B-371	Braid, Textile, Tubular
MIL-C-484	Cloth, Wind Resistant Oxford, Cotton, Quarpel Treated
MIL-C-3735	Cuffs, Knit, Wrist and Ankle, and Cloth, Knitted
MIL-C-3924	Cloth, Oxford, Cotton Warp and Nylon Filling, Quarpel Treated
MIL-C-6590	Cloth, Pile (Synthetic Mouton, Knitted)
MIL-F-10884	Fasteners, Snap
MIL-C-18387	Cloth, Twill Cotton, Fire Retardant Treated
MIL-C-43824	Cloth, Synthetic Fur, Knitted
MIL-DTL-32075	Label, for Clothing Equipage, and Tentage, (General Use)

STANDARDS

FEDERAL

FED-STD-311	Leather, Methods of Sampling and Testing

MILITARY

MIL-STD-1916	DOD Preferred Method for Acceptance of Product
MIL-STD-129	Marking for Shipment and Storage
MIL-HDBK-774	Palletized Unit Loads
MIL-STD-2073-1	DOD Material Procedures for Development and Application of Packaging Requirements

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ANSI/ASCQ Z1.4 Sampling Procedures and Tables for Inspection of Attributes (For all inquirers please contact the American National Standards Institute, 25 West 43rd Sreet4th Floor, New York, NY 10036). Website address http://www.ansi.org.

(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 these documents are those cited in the solicitation or contract.

AMERICAN SOCIETY FOR TESTING AND MATERIAL (ASTM)

ASTM D-3951	Standard Practice for Commercial Packaging.
ASTM D-1974	Fiberboard Boxes, Methods of Closing, Sealing, and Reinforcing
ASTM D-5118	Boxes, Fiberboard Shipping, Fabrication of
ASTM D-6193	Stitches and Seams
ASTM D-6199	Wood Members for Containers and Pallets

(For all inquires please contact the American Society for Testing and Materials, 100 Barr Harbor, West Conshohocken, PA 19428-2959.) Website address http://www.astm.org.

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 herin, the text of this document takes place precedence. Nothing in this document however, supercedes applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 First article. When specified, (see 4.2), 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 Type I of MIL-C-484, or class 2 MIL-C-43191. (NOTE: When MIL-C-43191 is used, infrared reflectance does not apply). The color shall be Sage Green (1509)

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3.2.2 Interlining. The fabric for the interlining shall be batting, Type II, Class 4, Style A, Cover B of A-A-55127. 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 be of the following:

-Rayon or cotton satin cloth conforming to type 1 of A-A-52074 with the back side designated as the face.

OR

-80% wool/20% nylon cloth, weighing 16.5 ounces per square yard, style number 9215-1555 or equal.

The color of all fabrics shall approximate the outer shell.

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, cloth drill cotton

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 be a good match to the shade of the outer-shell fabric. The thread shall be a step 3-4 on the AATCC gray scale for color change. The thread shall be a good match to colorfastness to light at 20 standard fading hours and colorfasteness to wet-dry cleaning and to perspiration when tested IAW V-T-295.

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 be a good match to the shade of the outer shell fabric. The thread shall be a good match to colorfasteness to light, wet-dry cleaning and to perspiration when tested in accordance with A-A-52094.

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). A 3 or 4 pile denier fiber is also acceptable for the Type I cloth provided this cloth meets all the requirements for Type I.

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 ± 1/8 inch. The color of the tipping or impregnation shall be transparent or approximate the shade of the outer shell fabric.

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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.

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 FED-STD-311 of Method 2150:

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 colorfasteness to crocking shall be 3-4 gray scale for color change when tested in accordance with FED-STD-311 of Method 3031.

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 A-A-55634. The chain shall be brass or aluminum with a short pull tab to accommodate a 3/4 inch wide thong. The finish of the metal parts shall be black chemical finish if brass or colored anodized finish if aluminum. The lengths of the slide fasteners shall conform to Table II.

TABLE I. *Slide fasteners*

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

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

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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 100% polyester and dyed cotton 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.

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 closure 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 hood 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 the 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 ASTM D-6193. 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 longer (under thread) 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.

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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).

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 typing, overlapping, or backstitches are used to secure the ends of the stitching.

3.4.5 Threads 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 constructions 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.

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

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TABLE III. *Pattern parts*

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
Reinforcement Pocket Flap	2
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

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TABLE III. *Pattern parts* - Continued.

Lining (see 3.2.3)	
Front	2
Back	1
Topsleeve	2
Undersleeve	2
Pocketing (see 3.2.4)	
Muff Pocket	2
Lower Pocket	2
Protective Flap/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 operations requirements specified in Table IV. The contractor is not required to follow the exact sequence of operations 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

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Btnhl	-	Buttonhole
Incl	-	Including
Dbl	-	Double
Auto	-	Automatic

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			

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
	linings and hanger which mouton be cut from ends. 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 expecting to develop into a hole), scissor or knife cuts, tears, holes, mends, or burns. h. Cut the synthetic fur Knit cloth in the direction of the wales (lengthwise) 3 ±1-1/4inch wide and as required by			

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
	the length of the cowl. There 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 of adhesive on the material after tickets are removed. No metal fastening shall be used.			
3.	FRONTS – OUTER SHELL 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.	301	LSd-1 or BSc-1	10-12
	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	SSv-2	10-12

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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.			
	c. Cut the opening for the pockets. Tongue notch each corner.	301	LSq-2 (b)	10-12
	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	SSa-1	10-12
	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	LSq-2 (b)	10-12
	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	SSa-1	10-12
	g. Sew around the pocketing with a single row of stitching 1/2 inch from the edge.	brtck		28 per brtck
	h. Bartack the corners of the pocket openings with a 7/8 inch bartack at each end.			
	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			

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
4.	studs and eyelets on the facing to correspond to the button snaps. LOWER POCKETS AND POCKET FLAPS a. The flaps shall incorporate a reinforced button snap and a socket with a center of the socket 3/4 inch from the finished edge, reinforcement pocket flap shall be sewn centered on the lower pocket flap. b. Position the flaps to the flap facings with reinforcement pocket flap piece superimposed on flap pieces, contoured to bottom shape and stitch around sides and bottom with 1/4 inch seam, catching the reinforcement pocket flap piece 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. 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 raised 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 pocket to correspond	301 or 401 301	SSe-3 (a) SSe-3 (b)	10-12 10-12

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
	with the button snap and the socket on the flap.	301	LSd-1	10-12
	e. Fold and sew the facings to the pocketing material.	301	LSq-2 (a)	10-12
	f. Sew the flaps on the fronts, at the drill marks, with a single row of stitching.	301	SSbe-2 (a)	10-12
	g. Sew the pocketing on the fronts, at the drill marks, with a single row of stitching.			
	h. Cut the opening for the pockets. Tongue notch the corners.	301	SSbe-2 (b)	10-12
	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	SSa-1	10-12
	j. Tongues at the corners shall be seen to the pocketing on the inside.	301	SSa-1	10-12
	k. Sew around the edge of the pocketing with a 1/2 inch seam.	brtck		28 per brtck
	l. Bartack the corners of the pocket opening with a 1/2 inch bartack.	301	LSq-2(b)	10-12
	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.			

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
	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	10-12
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 10-12
	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
	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	301	SSv-2	10-12

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
6.	double row of stitching, 7/8 to 1 inch gage. SLEEVE – OUTER SHELL 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 5- 3/4 ± 1/4 inches long and 3-1/2 ± 1/8 inches wide, excluding width measurement shall be taken across the top of the pocket.			
	a. Hem the top opening of the pencil compartment in accordance with notches, and sew with a double row of stitching, 1/4 inch gage, with the first row of stitching 1/16 to 1/8 inch from the top edge.	301	EFa-2	10-12
	b. Fold the pencil pocket at the lower notches to form the two lower openings, and sew with a double row of stitching, 1/4inch gage, 1/16 to 1/8 inch from the edge.	301	Osf-2	10-12
	c. Fold the opening to the center notches, tacking each side edge with a single row of	301	SSa-1	10-12

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
	stitching (optional). d. Slit the fold through the center to make pencil pass-through. The pencil compartment may be made in two pieces.	301	LSd-2	10-12
	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	SSv-1	10-12
	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.	Brtck		28 per brtck
	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.	301	SSa-1	10-12
	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	LSq-2 (a)	10-12
	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 (b)	10-12

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
	j. Turn and raise stitch the pocket with a single row of stitching 1/16 inch from the edge of the pocket.	301	LSb-1	10-12
	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	LSd-1 or LSa-1 and LSa-1	10-12
	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	SSa-1	10-12
	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.			
7.	JOIN – SLEEVES			
	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	10-12
		301 or 401	LSc-2	6-8

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
	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. NOTE: Elbow patches and reinforcement pieces may be pre-hemmed prior to attaching to sleeves with the stitching 1/16 inch from folded edge.	301 or 401	LSd-1	10-12
	c. Turn-under raw edge of cuff reinforcement piece and stitch to outside or face side bottom of sleeve, in accordance with the notches, 1/16 from folded edge.	301 or 401	LSc-2	6-8
	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 or 401	LSq-3 (a) and LSq-3(b)	10-12
	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, or as an alternate, join sleeve to front and back with a double lapped double stitched seam with the front and back overlapping the sleeve 1/4 to 5/16 inch gage, 1/16 inch from edge.	301 301	LSc-2 LSC-2	6-8 6-8
	PREPARE HOOD – OUTER			

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
8.	SHELL 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 1/16 inch from the edge all around. A second row of stitching shall be sew 1/4 inch from the edge for the hole reinforcement.	301	SSa-2	10
	d. 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	10-12
	b. Thread a 46 inch drawstring through the leather reinforcement patches and hood tunnel loop. Knot each end of			

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
	the drawstring approximately 2 inches from the threaded or the tipped end. c. Prepare the front hood strap 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 5/8 to 3/4 inch in width. e. Insert the 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. g. Prepare a back hood 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, turning the end of the strap, folding and stitching. The strap shall finish 5/8 to 3/4 inch in width, or as an alternate, the end of the strap that is threaded thru the buckle may be finished by “turning” edge of strap up 3/8 inch and again on itself 3/8 inch and	301 301 301	EFp-2 LSd-1 EFp-2 and EFb-2	10-12 10-12 10-12

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
	secure it with a bartack.	301	LSd-1	10-12
	h. Insert the strap over the third bar from the square end of the buckle so that the finished end is on top and is extending approx 1-1/2 inches, with the hem of the finished edge facing the remainder of the strap. Turn the end of the 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.			
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)	10-12
	b. Raise stitch seam on the hood with a single row of stitching 1/4 inch from the edge.	301	LSq-2 (b)	10-12
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).	301 or 401	SSv-4	10-12
	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-1	10-12
	b. Place a single row of			

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
	stitching 1 inch from the edge of the protective fly on the side opposite that of the loops.	301	SSa-1	10-12
	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	SSe-2 (a)	10-12
	d. Join the fly pieces together with a single row of stitching 1/2 inch from the edge, on the top and the bottom.	301	SSe-2 (b)	10-12
12.	e. Turn and raise stitch the fly pieces with a single row of stitching 1/4 inch from the edge. PREPARE INNER PROTECTIVE FLY The inner fly shall be fabricated from two plies of outer-shell fabric and one ply of interlining cloth.	301 or 401	SSe-2 (a)	10-12
	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	SSe-2 (b)	10-12
	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	SSv-4	10-12
	c. Quilt the fly through and through with four rows of parallel stitching with the two			

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
13.	center rows equidistant from each other and from the out-side rows JOINING OUTER PROTECTIVE FLY a. Sew the protective fly to the left front of the outer shell in accordance with the notch marks on the pattern and finish joining to the hood seam with a 1/2 inch seam.	301	SSa-1	10-12
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. b. 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 the parka shall be even on the right and left fronts. c. 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	301 301 Auto Mchne	SSa-1 SSa-1	10-12 10 minimum

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
15.	box or triangular stitching.			
	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	10-12
16.	PREPARE LININGS	301 or 401 or 502	SSa-1	6-8
	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	SSv-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-4	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	LSbj-1	10-12
	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 or 401	EFp-2	10-12
	e. Make the hanger of outer-shell fabric to finish 1/2 inch			

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
	wide and 3-1/2 inches long.	301	LSd-2	10-12
	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	brtck 515 or 516 or 517	LSd-1 SSa-2	28 per brtck 10-12
	g. Join the side seams by overedging and seaming the raw edges together in one operation.	301 or 401	SSa-1	6-8
	h. SLEEVE LININGS. Sew all interlining pieces and the respective lining 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.	515,516, or 517	SSa-2	10-12
	i. JOIN SLEEVE LINING. Join the sleeve inseam by over-edging and seaming the raw together in one operation.	515,516, or 517	SSa-2	10-12
	j. Join the sleeves to arm hole by overedging and seaming the raw edges together in one operation.	515,516, or 517	SSa-2	10-12
	k. Join the elbow seam by overedging and seaming the raw edges together in one operation.	301	SSa-2	10-12
	l. REINFORCEMENT PIECES FOR WAIST DRAWCORD. Sew two 1 inch square leather			

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
	reinforcement pieces, centered at the drill marks, with a single row of stitching 1/16 inch from the edge all around. A second row of stitches shall be sewn 1/4 inch from the edge to reinforce the hole. The leather reinforcement pieces shall be on the nylon lining.			
	m. Punch a hole through the center of the reinforcement patches and the lining and the fabric.			
	n. Thread and free ends of the drawcord through the holes in 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.	502 or 503	SSa-1	6-10
	o. Serge the prefolded raw edges of the wristlets.	301	SSa-2	10-12
17.	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.	501	SSa-1	9
	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.	301 or 401	SSa-1	10

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
	c. 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	LSd-1 and SSa-1	10
	d. 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	SSa-1	6-10
	e. Join the cowl flap to the mouton lining with a single row of stitching 3/8 inch from the edge.			
18.	JOINING			
	JOINING HOOD TO LINING	301	LSq-2(a)	10-12
	a. Join the fur hood to the neckline lining with a single row of stitching 1/4 to 1/2 inch from the edge.	301	LSq-2 (b)	10-12
	b. Turn and raise stitch seam on the lining with a single row of stitching 1/4 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.			
	c. JOIN LININGS. Join the bottom of sleeve linings to the	301	SSe-2 (a)	10-12

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
	outer-shell, catching the sleeve reinforcement strip at the wrist, with a 1/2 inch seam.	301	SSe-2 (a)	10-12
	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	SSa-1	10-12
	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.			
19.	f. Turn the parka right side out.			
	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)	10-12
		301	SSc-1	10-12
		301	SSe-2 (b)	10-12
		301	SSc-1	10-12
	b. Raise stitch bottom of the sleeves 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	SSv-4	10-12
	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	301	SSa-1	10-12

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
20.	positioned 1/4 to 3/4 inch from the outer edge of cowl. 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.	501 or 301	SSa-1	10-12
	SEW FUR TRIMMING a. Sew pleats to conform to the shape of the cowl of the hood.	501	SSa-1	9
	b. Sew the mouton strip to the bottom edge of the fur trimming, on the right side, with a fur machine.	301	SSa-1	9
	c. Attach the synthetic fur trimming to the shape of the cowl with a single row for stitching 1/8 to 1/4 inch from the edge, all around , including the edges of the mouton strip. The fur trimming shall extend to and finish at the end of the inner protective fly, right side. The ends of the stitching shall be backstitched 1/2 inch at the top edge and the lower edge of the fur trimming on each side of the slide fastener. There shall be no more than a 1/2 inch open seam on each side of the slide fastener scoops. As an option, the fur strips may be basted approximately 1/2 inch from the edges, catching the long hair of the fur and holding them away from the edges, to facilitate the stitching of the fur to the hood. After the fur is	301	SSa-1	9

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
	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. e. The mouton strip shall butt the mouton hood lining.	301	SSa-1	9
21.	PLACEMENT OF STUDS, SOCKET, SNAPS AND EYELETS OUTER PROTECTIVE FLY			
22.	Set a button snap and a socket on the lower end of the fly at the joining seam. INNER PROTECTIVE FLY			
23.	Set a stud and an eyelet on the inner protective fly to correspond with the snap and socket on the outer protective fly.			
	BUTTONS Sew four 45-line buttons on the right front of the parka at the drill marks. The top two buttons shall be through all plies and secured with stay buttons, the remaining buttons shall be sewn through the front and the outer ply of the hanging pocket only.	101 or 301 or hand		22 per button 16 per button 4-6 per button (double thread)

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NO.	OPERATION	STCH TYPE	SEAM/STCH TYPE	STITCHES PER INCH
24.	All buttons shall be backed with stay buttons and wrapped to form a shank, and the ends of the thread shall be tacked off. CLEANING a. All loose ends of thread shall be trimmed, and loose thread shall be removed.			
25.	b. Remove all soil or spots c. Remove the shade-marking tickets. FASTENING Close the slide fastener, fasten the snap fasteners, and button parka.			

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

Table V. *Finished measurements (in inches)*

Measurements 1/	Extra Extra Small	Extra Small	Small	Medium	Large	Extra Large	Extra Extra Large	Tol. ±

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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 MIL-DTL-32075. 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 fasteness 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/

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

2/ The contractor shall include the applicable information.

3.9.1 Label /Tab. Each parka shall be individually bar-coded with the type VIII, Class 17 Label/Tag of MIL-DTL-32075. This label/tag shall be located so that it is completely visible on the folded/packaged parka and shall cause no damage to the item.

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).

4. QUALITY ASSURANCE PROVISIONS

4.1. 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.

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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 4.4.2.1.

4.4 Quality conformance inspection. Sampling for inspection shall be performed in accordance with MIL-STD-1916, 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.

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

TABLE VI. *Defects specified*

Defect	Major	Minor
1.MATERIAL DEFECTS AND DAMAGES		
Any smash, multiple float or loose slub	101	
Cut, tear, mend, burn, needle chew, or hole	102	
Misweave, area of poor dye penetration, dyestreak, broken or missing yarn, visible mend, thin place, or		

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Defect	Major	Minor
shade bar 1/	103	201
2. CLEANLINESS		
Any spot, streak, or stain of a permanent nature on any portion of a garment which be visible when parka is worn		202
Removable spot, streak, or stain on outside of parka		203
Thread ends not trimmed throughout parka		204
Any holding or basting threads visible on outside of the finished parka when applicable		205
3. COMPONENT AND ASSEMBLY		
Any defective component 1/	104	206
Any component part omitted 1/	105	207
Any required operation omitted or improperly performed 1/	106	208
4. DRAWCORD		
Any drawcord omitted	107	
Any drawcord caught in hem or tunnel stitching restricting use of drawcord	108	
Any end not heat seared		209
Any end not knotted		210
Any drawcord insufficient in length	109	
Any barrel lock omitted		211
Not caught in center bartack when specified		212
5. SLIDE FASTENER		
Any part of slide fastener bent, broken, otherwise defective	110	
Not closing as specified	111	
Length and type not as specified	112	
Parka part stitched too close to metal chain, not permitting slider to pass		213
Color not as specified		214
Thong not as specified		215
6. SNAP FASTENERS		
Any part of assembly missing, mismated, broken, cracked, bent, not securely clinched, affecting function		

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Defect	Major	Minor
- two or more snap fasteners	113	
- one snap fastener		216
One or more clinched too tightly cutting surrounding fabric	114	
Loose, i.e., socket or stud spins freely or wobbles in connection portions		217
One or more having rough or sharp edge	115	
7. SEAMS AND STICHING		
Not specified seam or stitch type		218
Missing, broken or skipped stitches 1/	116	219
Seam twisted, puckered, or pleated 1/	117	220
Part of parka caught in any unrelated operation or stitching 1/	118	221
Color of thread not as specified		222
Thread breaks or ends of stitching, when not caught in other seams or stitching backtacked less than ¼ inch		223
Gage of stitching uneven or not as specified		224
8. STITCH TENSION		
Loose tension in any area:		
- more than 1 inch but not more than 2 inches		225
- more than 2 inches	119	
Tight tension (stitches break when normal strain is applied to the seam or stitching)	120	
Missing, broken, or skipped stitches 1/	121	226
9. OPEN SEAM		
A break in a line of stitching or continuous skipped or runoff stitches (except on edge, top, or raise stitching) shall constitute an open seam.		
Opean seam over 1/8 to and including ¼ inch		227
Open seam over ¼ inch	122	
10. BARTACKS		
Missing, insecure, or misplaced, not serving intended purpose		
- less than two bartacks		228
- three or more bartacks	123	

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Defect	Major	Minor
11. BUTTONS AND STAY BUTTONS		
Not specified size, type, or color.		
Missing, loose or broken		
- one button		229
- two or more buttons	124	
- one or more stay buttons.		230
Shank wrapping omitted, loose or insecure on one or more buttons.		231
12. CUTTING		
Any component part not cut in accordance with directional lines on patterns or specified requirements		232
13. LABELS		
Combination size, identification, and instruction label.		
- missing or size marking omitted, incorrect, or illegible	125	
- information (other than size) missing, incorrect or illegible		233 234
- not stitched on four side to lining		
When information is not incorporated in (combination, size, identification, and instruction labels) missing, incorrect, or illegible		235
BAR-CODED HANG TAG/LABEL		
(1) Bar code omitted or not readable by scanner		236
(2) Human-readable interpretation (HRI) omitted or illegible		237 238
(3) Not visible on folded/packaged item	126	
(4) Causes damage to parka		
14. SHADED PARTS		
Outside parts shaded (visible when garment is worn) 1/	127	239
Lining and inside parts (not visible when garment is worn)		240

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1/ The defect shall be classified as major, when it seriously affects the serviceability or appearance, otherwise it shall be classified as a minor defect.

4.4.2.2 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.

4.4.3 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 ANZI/ASQC Z1.4.

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 ANZI/ASQC Z 1.4

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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.

5. PACKAGING

5.1 Packaging. For acquisition purposes, the packaging requirements shall be as specified in the contract or order (see 6.2). When packaging of materiel is to be performed by DoD or in-house contractor personnel, these personnel need to contact the responsible packaging activity to ascertain packaging requirements. Packaging requirements are maintained by the Inventory Control Point's packaging activities within the Military Service or Defense Agency, or within the military service's system commands. Packaging data retrieval is available from the managing Military Department's or Defense Agency's automated packaging files, CD-ROM products, or by contacting the responsible packaging activity.

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 14° to -65 by personnel of Department of Defense.

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 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.

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6.5 Subject term (key word) listing.

Clothing, extreme cold weather
Hooded garment
Protective clothing

6.6 Equal Item. Prior to the use of an "Equal Item", the contractor shall submit the item with supporting data to the contracting officer for subsequent approval or disapproval by the responsible military agency (see 3.2.4).

Custodians:

Air Force- 11
Army- GL

Review activities:

Army- MD
Air Force- 82

Preparing activity:

DLA - CT

Project No. 8415-0244

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FIGURE 1. Front view

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FIGURE 2. Back view, hood up

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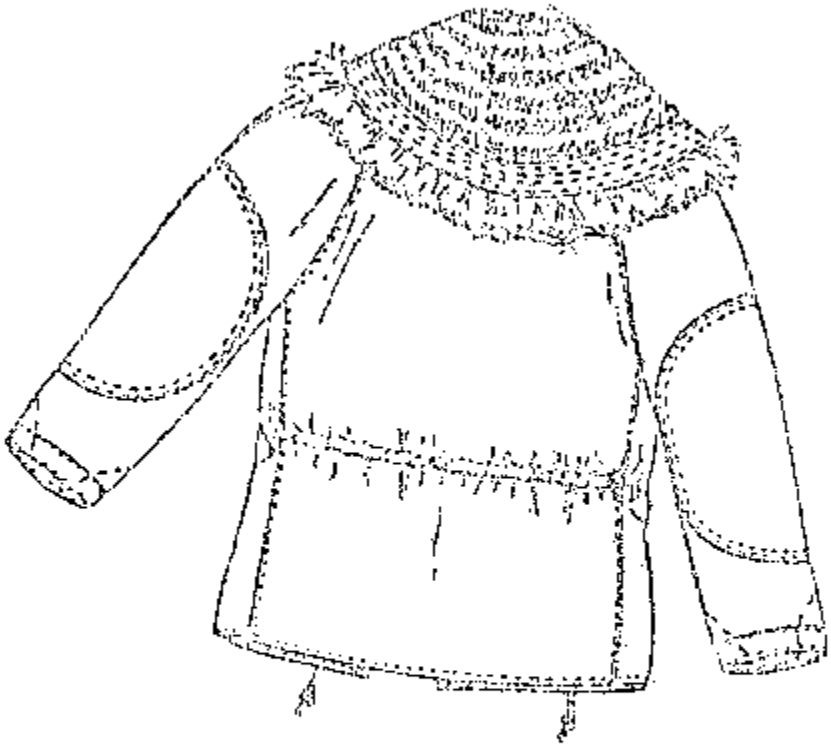

FIGURE 3. Back view, hood down

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