

1 INCH-POUND

MIL-C-21088D(MC)

~~FEBRUARY 22, 1990~~

SUPERSEDING

MIL-C-21088C(MC)

3 May 1983

MILITARY SPECIFICATION

COAT, MAN'S: WHITE; DRESS (OFFICER'S)

This specification is approved for use by the U. S. Marine Corps, Department of the Navy, and is available for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification covers the requirements for white dress coats for men.

1.2 Classification. The coats shall be of one type in the following sizes as specified (see 6.2):

Schedule of Sizes

<u>Short</u>	<u>Regular</u>	<u>Long</u>	<u>Extra Long</u>
36	36	36	36
38	38	38	38
40	40	40	40
42	42	42	42
	44	44	44
	46	46	

1.3 Individual orders. When coats are custom tailored to an individual order this specification shall govern, except that the detailed requirements of Section 3, Table I may be modified to the extent necessary for good custom tailoring practice.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to the Commander (PSE-C), Marine Corps Systems Command, Quantico, VA 22134-5010 by using the self addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8405

DISTRIBUTION STATEMENT A
distribution is unlimited.

Approved for public release;

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2. APPLICABLE DOCUMENTS

2.1.1 Specifications, standards, and handbooks. The following specifications, standards and handbooks form a part of this specification 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).

SPECIFICATION

FEDERAL

A-A-50198	- Thread, Gimp, Cotton Buttonhole
V-T-285	- Thread, Polyester
CCC-C-446	- Cloth, Muslin, Cotton
DDD-L-20	- Label; For Clothing. Equipage, and Tentage, (General Use)
DDD-T-86	- Tape, Textile; Cotton, General Purpose (Unbleached, Bleached, or Dyed)

MILITARY

MIL-B-3461	- Buttons, Insignia, Metal, Uniform and Cap
MIL-C-41820	- Cloth, Gabardine, Polyester and Rayon

STANDARDS

FEDERAL

FED-STD-751	- Stitches, Seams and Stitchings
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MILITARY

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

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

2.1.2 Other Government publications. The following other Government publications forms a part of this specification to the extent specified herein. Unless otherwise specified, the issues shall be those in effect on the date of the solicitation.

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Department of Defense (DoD) Standard Color Card
for Sewing Threads 1968

Department of Defense (DoD) Standard Shades for Buttons 1966

(Application for copies should be addressed to the Color Association of the United States, Inc., 200 Lexington Avenue, New York, NY 10016.)

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

2.2 Non-Government publications. The following document(s) form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of 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 OF TESTING MATERIALS

ASTM D 3951 - Standard Practice for Commercial Packaging

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

(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 shall take precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption had been obtained.

3. REQUIREMENTS

3.1 Guide sample. Guide samples, when furnished, are solely for guidance and information to the contractor (see 6.3). Variation from this specification may appear in the sample, in which case this specification shall govern.

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3.2 First article approval. Unless otherwise specified (see 6.2), before production is commenced, a first article consisting of the number of finished coats specified by the procuring activity (see 6.2) shall be submitted or made available to the contracting officer or his authorized representative for approval. The approval of the first article authorizes the commencement of production, but does not relieve the contractor of the responsibility for compliance with all provisions of the specification. The first article shall be manufactured by the contractor in the same facilities to be used for the manufacture of the production items.

3.3 Materials.

3.3.1 Basic material. The basic material shall be cloth, gabardine, polyester and rayon conforming to MIL-C-41820, type III, class 1, 8.0 ounce, white shade 2400 (see 6.3).

3.3.2 Bias binding. The binding for raw edges of seams, armholes, bottom turnup, top edge of pockets, and for making the coat hanger shall be bias cut, 1-1/8 inches wide, from bleached and stiffened cotton muslin cloth conforming to type III class 3 of CCC-C-446, except the total non-fibrous material shall be between 5 and 10 percent. The bias binding shall have sized edges to prevent raveling.

3.3.3 Stay tape. The stay tape for the front edges shall be cotton, unbleached, 1/4 inch wide, conforming to type III, class 1 of DDD-T-86.

3.3.4 Thread.

3.3.4.1 Thread polyester. The polyester thread for seaming and stitching buttonholes, eyelets, hand felling and bartacks shall be white, size A, 3-ply, conforming to type I class 1 of V-T-285.

3.3.4.2 Thread cotton. The thread for basting shall be a good commercial grade.

3.3.5 Gimp. The buttonhole gimp shall be cotton thread, white (bleached), soft or glazed finish, conforming to type I or II, size 8 of A-A-50198.

3.3.6 Buttons. When specified (see 6.2), buttons shall be furnished with the coat. The buttons shall be metal, gold plated, officer design, 40- and 27-line, regular shank, conforming to type I, style 3, class A, subclass 1 of MIL-B-3461.

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3.3.6.1 Ring toggles. When buttons are furnished, ring toggles for securing insignia buttons to the coat shall conform to MIL-B-3461.

3.3.7 Hook and eyes. Hooks and eyes for closing the collar shall be No. 10 commercial type, brass, nickel plated (see Section 4, Table IV).

3.3.8 Labels. Each coat shall have combination identification-instruction label and a size label. The labels shall show good fastness to laundering.

3.3.8.1 Identification-instruction label (combined). The identification-instruction label shall conform to type IV, class 1 and 3 (combined) of DDD-L-20 and shall measure not less than 5-1/2 by 2-1/2 inches. The content and format shall be as follows:

Nomenclature (item description)
Contract number
Name of contractor
Fiber Contents Acts information

LAUNDERING AND PRESSING INSTRUCTIONS

Remove buttons.

1. Hand laundering.

- a. Launder in warm water using mild soap.
- b. Scrub soiled areas.
- c. Rinse thoroughly in clear warm water.
- d. Dry without wringing.

2. Machine laundering.

- a. Use a mild detergent.
- b. Complete washing cycle for 30 minutes in 120° to 140°F water.
- c. Rinse thoroughly in clear water.
- d. Set automatic dryer for regular fabrics and dry for 15 minutes. Remove while slightly damp and let hang dry on plastic or wooden hanger.

3. Pressing.

- a. If pressing is required, use a cool iron.

DO NOT USE SETTING ABOVE RAYON ON AUTOMATIC IRON
DO NOT USE HOT IRON

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3.3.8.2 Size label. The size label shall conform to type VI, class 2 of DDD-L-20. The label shall consist of the numerical size designation specified in 1.2 followed by the letters S, R, L or XL for Short, Regular, Long and Extra Long and the stock number as shown by the following example:

40R
Stock Number

3.4 Design. The coat shall be the unlined, single breasted, formfitting design shown in Figures 1 through 4, having a five-button closure, stand-up collar with ends to fasten in front with hooks and eyes, collar with worked eyelet in each end for branch of service insignia, shoulder straps to button, box pleated patch pockets on upper fronts with pointed flaps to button, bellows type pockets on lower fronts with pointed flaps to button, worked eyelets for all buttons, horizontal slit at waist, underarm and chesty, and center back vent and shall be without a belt.

3.5 Patterns. Standard patterns will be furnished to the contractor by the Government. The standard patterns shall not be altered in any way and shall be used only as a guide for cutting the contractor's working patterns. The contractor's working patterns shall be identical to the standard patterns., The standard patterns provide 1/4 inch allowance for seams at top and front edges of coat, and for pocket flap and shoulder strap seams; 1-inch allowance for side seams; 5/8-inch allowance for center back seam; and 3/8-inch allowance for all other seams except as otherwise specified in Table I. Standard patterns show size, seam allowances, directional lines for cutting and are marked or notched for placement and assembly of the component parts.

3.5.1 List of pattern parts. Coats shall be cut from the materials specified herein in accordance with the number of pattern parts indicated below:

Pattern nomenclature

<u>Item</u>	<u>Material: Basic</u>	<u>No. of cut parts</u>
1.	Front	2
2.	Front facing (right)	1
3.	Front facing (left)	1
4.	Side back	2
5.	Center back	2
6.	Topsleeve	2
7.	Undersleeve	2
8.	Sleeve cuff	2
9.	Collar	1
10.	Collar lining	1

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Pattern nomenclature

Item	Material: Basic	No. of cut parts
11.	Collar interlining	3
12.	Shoulder strap	4
13.	Pocket, upper	2
14.	Pocket, lower	2
15.	Pocket flap, upper	4
16.	Pocket flap, lower	4
17.	Front eyelet reinforcement	1
18.	Sword slit tab	2
19.	Welt piece	1

Shapers

Finished pocket, upper
 Finished pocket, lower
 Finished pocket flap, upper
 Finished pocket flap, lower
 Finished cuff
 Finished collar shaper

Marker

Left vent marker

3.6 Construction.

3.6.1 Manufacturing requirements. The coats shall be manufactured in strict accordance with the operations and the stitch, seam and stitching types specified in Table I. The contractor is not required to follow the exact sequence of the operations listed in Table I but all operations specified shall be used to manufacture the coat.

3.6.1.1 Stitches, seams and stitching. The stitch, seam and stitching types specified in Table I shall conform to FED-STD-751. The number of stitches per inch as specified in Table I indicates the minimum and maximum number permitted. The overedge machines shall have a knife attachment properly set to trim off frayed thread ends along the raw edge without cutting the material.

3.6.1.2 Thread breaks and end of stitching. Ends of seams and stitching produced with 301 type stitch, when not caught in other seams or stitching, shall be backtacked not less than 1/4 inch. Thread breaks (all stitch types) shall be secured by stitching back of break not less than 1/2 inch.

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3.6.2 Shade marking. The component parts of the coat cut from one piece of basic material shall be shade marked to insure a uniform shade and size throughout the garment. Any method of shade marking may be used except:

- (a) Corrosive metal fastening devices.
- (b) Sew-on shade tickets.
- (c) Adhesive-type tickets whose adhesive causes discoloration and whose adhesive mass adheres to the material upon removal of the tickets.
- (d) Any marking medium which would tend to leave a permanent mark.

3.6.3 Pressing. All pressing operations specified in Table I shall be done with a heated pressing iron or pressing machine set at medium (low) temperature (285°F maximum).

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
1	<p><u>Cutting.</u></p> <p>a. Cut coats in strict accordance with patterns furnished.</p> <p>b. Cut all materials in the direction indicated by the directional lines on the pattern. The straight edge of the sword slit tab shall be cut on the selvage.</p> <p>c. Cut all component parts of the coat from one piece of basic material, except the following parts may be cut from ends: collar interlining, front eyelet reinforcement, sword slit tabs, underply of pocket flaps and shoulder straps. The parts cut from ends shall harmonize with the rest of the coat. The sword slit welt piece shall be cut with one edge (bottom) on the selvage.</p> <p>d. Cut the bias binding 1-1/8 inches wide for binding raw edges of seams, armholes, bottom turnup, top edge of pockets, and for making the coat hanger from the material specified in 3.3.2.</p> <p>e. The use of drill holes is prohibited.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
1	<p><u>Cutting.</u> (cont'd)</p> <p>f. Dress the left vent in accordance with the shaper furnished.</p>					
2	<p><u>Replacement of damaged parts.</u></p> <p>a. Replace at time of cutting any parts containing damages, such as holes or serious weakening defects, such as smashes, multiple floats and slubs likely to develop into holes.</p> <p>b. Replace any parts damaged during the manufacturing process by needle chews which may be expected to develop into a hole, scissor or knife cuts, tears, holes, mends, or burns.</p>					
3	<p><u>Shade marking.</u></p> <p>a. Mark or ticket (see 3.6.2) all component parts cut from basic material, except those parts cut from ends (see 1.c), in order to insure uniform shade and size throughout the coat.</p> <p>b. Adhesive tickets when used shall be adhered to the inside of the coat.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
4	<u>Make coat hanger.</u> Finished appearance. The hanger shall finish smooth, uniform and flat, without distortion. The hanger shall be uniform in width and appearance. The stitching shall be uniform. a. The coat hanger shall be made from a strip of bias binding folded and stitched to finish 1/4 inch wide. b. Fold strip in half lengthwise, turning edges to inside, and seam 1/16 inch from turned edges. c. Cut the hanger 3-1/4 ± 1/4 inches long.	301	SSc-1	10-14	40/3 or A	40/3 A
5	<u>Make sword slit tab.</u> Finished appearance. The sword slit tab shall finish smooth and flat without distortion. The stitching shall be uniform. a. The sword slit tab shall be made of two plies of basic material. b. Seam the two plies together 3/16 inch from side and bottom edges. c. Turn the tab, forcing seam line out to edge and edgestitch 1/8 inch from	301 301	SSe-2 (a) SSe-2 (b)	12-16 12-16	40/3 or A 40/3 or A	40/3 A 40/3 A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
5	<p><u>Make sword slit tab.</u> (cont'd)</p> <p>seamed edges.</p> <p>d. Finished tab shall be $2\text{-}3/8 \pm 1/8$ inches long in center from bottom edge to top selvage edge and $2 \pm 1/8$ inches wide.</p>					
6	<p><u>Make upper and lower pocket flaps.</u></p> <p>Finished appearance. The pocket flaps shall be uniformly stitched and shall finish smooth and flat, without twists, gathers, puckers, pleats or raw edges and shall be uniform in shape and size in accordance with the finished pocket flap shaper. The seamed edges, corners and point of the flaps shall be well worked out. The buttonholes shall be clean cut, well made, properly positioned, well worked over the gimp to fit a 27-line insignia button, and the stitching shall be securely caught in the basic material. The gimp shall be pulled through to the underside of the buttonholes and the purling of the buttonholes shall be on the outside of the flaps.</p> <p>a. The pocket flaps shall be made of two plies of basic material.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
6	<u>Make upper and lower pocket flaps.</u> (cont'd)					
	b. Seam the two plies together 3/16 inch from the side and bottom edges and turn, working out the corners and center point.	301	SSe-2 (a)	12-16	40/3 or A	40/3 A
	c. Edgestitch the flaps uniformly 1/8 inch from the seamed edges, working the seams to the finished edges of the flap.	301	SSe-2 (b)	12-16	40/3 or A	40/3 A
	d. Press the flaps smooth and flat with a heated pressing iron or pressing machine.					
	e. Mark and trim top edge of flaps with the finished shaper so that in the finished coats the flap shall conform to the measurements shown in Table III.					
	f. Join the raw edge of flap together with overedge stitching.	503 or 504 or 505	EFd-1	8-10	40/3 or A	40/3 A
	g. Make a vertical, 3/4 inch long, eyelet-end, square-bar type buttonhole through the center of the pocket flaps, with the inside purled edge of the eyelet 5/8 \pm 1/8 inch above the center point.	Buttonhole		38 (min- imum) (per buttonhole, not including bartack)	40/3 or A	40/3 A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
6	<u>Make upper and lower pocket flaps.</u> (cont'd)					
	h. Securely bartack the end of the buttonholes and trim the ends of the gimp.	Bartack		21 per bartack (minimum)	40/3 or A	40/3 A
7	<u>Make upper pockets.</u>					
	Finished appearance. The binding shall be uniformly stitched, shall not be tight or full causing puckers, gathers or pleats. The basic material and both edges of binding shall be securely caught in the stitching. The box pleats shall be vertically centered and the folded side edges of the pleats shall be parallel. The pockets shall be uniform in shape and size in accordance with the pattern.					
	a. Fold pocket in half lengthwise and stitch the pocket 1-1/2 inches from the folded edge.	301	OSf-1	10-14	40/3 or A	40/3 A
	b. Form the box pleat with the center of the pleat in line with the stitching. Stitch across the top and bottom edge of the pleat 1/8 to 3/16 inch from the edge.	301	SSa-1 (each edge)	10-14	40/3 or A	40/3 A
	c. Press pleat in center of pocket flat and smooth.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
7	<u>Make upper pockets.</u> (cont'd)					
	d. Bind upper edge of pockets with 1-1/8 inch wide bias binding, with both edges of the binding turned under and caught in the stitching 1/16 inch from the inner folded edges.	301	BSc-1	10-14	40/3 or A	40/3 A
	e. Mark the patch pocket in accordance with the finished pocket shaper and trim the lower corners of the pocket for better turning.					
	f. Turn under sides and bottom edges at the marks and baste along the edges.	101 or Hand				
8	<u>Make lower pockets.</u>					
	Finished appearance. The binding shall be uniformly stitched, and shall not be tight or full causing puckers, gathers, or pleats. The basic material and both edges of binding shall be securely caught in the stitching. The pockets shall be uniform in shape and size in accordance with finished pocket shaper.					
	a. Bind the upper edge of the pockets with 1-1/8 inch wide bias binding, with both edges of binding turned under and caught in the stitching 1/16 inch	301	BSc-1	10-14	40/3 or A	40/3 A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
8	<p><u>Make lower pockets.</u> (cont'd)</p> <p>from the inner folded edges of the binding.</p> <p>b. Mark the pocket in accordance with the finished pocket shaper.</p> <p>c. Fold each bottom corner of pockets in accordance with the notch as indicated by the pattern. Seam the corners 3/8 inch from the diagonal edges.</p> <p>d. Spread the seams open and press smooth and flat with a heated pressing iron or pressing machine.</p> <p>e. Trim the excess material at the corners and turn the pocket, working out the corners completely. Turn under the side and bottom edges of the pockets as indicated on pattern to form the bellows, and edgestitch uniformly 1/8 inch from the folded edges.</p> <p>f. Press pockets smooth and flat with a heated pressing iron or pressing machine.</p>	<p>301</p> <p>301</p>	<p>SSa-1</p> <p>OSf-1 (each edge)</p>	<p>12-16</p> <p>12-16</p>	<p>40/3 or A</p> <p>40/3 or A</p>	<p>40/3 A</p> <p>40/3 A</p>

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
9	<u>Make shoulder straps.</u> Finished appearance. The shoulder straps shall be uniformly stitched and shall finish smooth and flat, without twists, gathers, puckers, pleats, or raw edges. The buttonholes shall be clean cut, well made, properly positioned, well worked over gimp to fit a 27-line insignia button and the stitching shall be securely caught in the basic material. a. The shoulder straps shall be made of two plies of the basic material. b. Seam the two plies together 3/16 inch from front and back edges and around collar end. Evenly trim the excess material on all edges and turn. c. Edgestitch the straps uniformly 1/8 inch from the seamed edges, working the seam line to the finished edges of the strap. d. Press the straps smooth and flat with a heated pressing iron or pressing machine. The straps shall be uniform in shape and size in accordance with the pattern.					
		301	SSe-2 (a)	12-16	40/3 or A	40/3 A
		301	SSe-2 (b)	12-16	40/3 or A	40/3 A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
9	<u>Make shoulder straps.</u> (cont'd)					
	e. Make a horizontal, 3/4 inch long, eyelet-end, square-bar type buttonhole in each strap midway between the back and front purled edges, and with the inside edges of the eyelet 5/8 \pm 1/8 inch from the collar end of the strap. The gimp shall be pulled through to the underside of the strap and securely caught in the bartack. The buttonholes shall have the purling on the outside of the straps.	Buttonhole		38 (min- imum)	40/3 or A (per buttonhole, not including bartack)	40/3 A
	f. Securely bartack the end of the buttonholes and trim the ends of the gimp.	Bartack		21 per bartack (minimum)	40/3 or A	40/3 A
10	<u>Make collar.</u>					
	Finished appearance. The completed collar shall finish smooth and flat without distortion. Edges shall be uniformly even.					
	a. The stand up collar shall be made of five pieces of basic material, consisting of one ply each for the outer collar and lining, and three plies for the interlining. The collar shall finish 2 inches wide.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
10	<u>Make collar.</u> (cont'd)					
	b. Properly position the three plies of basic material for the interlining with edges even. Quilt together from end to end with 7 to 8 rows of stitches evenly spaced, and with the top and bottom rows 3/8 to 1/2 inch from the top and bottom edges of the interlining, respectively.	301	SSv-7 or SSv-8	10-14 (each row)	40/3 or A	40/3 A
	c. Mark and trim the collar interlining in accordance with collar shaper.					
	d. Lap the upper edge of the interlining assembly approximately 1/2 inch over the inside upper edge of outer ply and seam together 1/4 inch from the raw edge of interlining. The outer ply shall extend not less than 3/4 inch at each end.	301	LSa-1	12-16	40/3 or A	40/3 A
	e. Smoothly fold the outer ply over the upper and lower edges of the interlining. Tack the portion of outer ply that is folded to inside, at the lower edge, to interlining from end to end. Stitches shall not show on the outside of collar.	Hand or 103		2-3	40/3 or A	
	or					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
10	<u>Make collar.</u> (cont'd)					
	f. The lower edge of outer ply may be basted to interlining.	Hand or 101		2-3	40/3 or A	
	g. Fold ends of outer ply to inside, over interlining, and tack to interlining with overcast stitching, turning under the upper and lower edges sufficiently so as not to be visible in the finished collar.	Hand		2-3	40/3 or A	
	h. Lap approximately 1/2 inch of the top inside edge of the collar over the top raw edge of the collar lining with the collar lining facing up. Raise stitch the lap seam at top of collar through the collar lining and edgestitch ends of collar assembly 1/8 inch from edges of top collar. The lining shall extend a minimum of 1/2 inch beyond the right end of the collar and 2-3/4 inches beyond the left end.	301	LSa-1 and SSbc-1	12-16	40/3 or A	40/3 or A
	i. Turn collar lining at the seam to the inside of the collar and press smooth and flat with a heated pressing iron or pressing machine.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
11	<u>Make collar extension tab.</u> Finished appearance. The collar extension tab shall finish smooth and flat without distortion, with uniform stitching and shall extend 3/4 to 7/8 inch beyond finished left front edge of collar. a. Fold left end of collar lining to outside, and seam to the body of top and bottom edges of the collar tab on line marked for width of collar lining. b. Slash the lining vertically from top edge to back end of top row of stitching and turn. c. Edgestitch the tab 1/8 inch from top, front and bottom edges, and continue the stitching at back of tab to top row, forming a 3/4 to 1 inch wide box stitch. The back row of stitches shall be through the two plies of the collar lining forming the tab.	301	SSe-2 (a) (each edge)	12-16	40/3 or A	40/3 A
		301	SSe-2 (b) (top and bottom edges) OSf-1 (front edge) LSbj-1 (back edge)	12-16	40/3 or A	40/3 or A
12	<u>Seam sleeve at forearm.</u> Finished appearance. The forearm seam shall finish smooth and flat without distortions and shall start and finish evenly.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
12	<u>Seam sleeve at forearm.</u> (cont'd)					
	a. Properly position the top and undersleeve and join together at the forearm with a 3/8 inch seam.	301	SSa-1	12-16	40/3 or A	40/3 A
	b. Bind the raw forearm edge of top and undersleeve together with bias binding. Both edges of the binding shall be turned under and caught in the stitching 1/16 inch from the inner folded edges.	301	BSc-1	12-16	40/3 or A	40/3 A
	c. Raise stitch the top sleeve uniformly 1/8 inch from the sleeve line with the seam allowance turned against the sleeve.	301	LSq-2 (b) (shows finished seam)	12-16	40/3 or A	40/3 A
	d. The finished edge of the seam on outside of sleeve shall be towards the back.					
13	<u>Join cuff to sleeve.</u> Finished appearance. The upper curved edge of cuffs shall be properly formed and creased and the cuffs shall be uniformly stitched to sleeves. a. Mark the sleeve in accordance with the pattern for positioning the cuff.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
13	<u>Join cuff to sleeve.</u> (cont'd)					
	b. Fold the cuff lengthwise, with the wrong side out. Stitch the point 1/8 inch from the raw edges. Turn the cuff, completely working out the point.	301	SSa-1	12-16	40/3 or A	40/3 A
	c. Turn under the upper edge of the cuff, forming the finished curved edge and point in accordance with the shape of the pattern. Press smooth and flat with a heated pressing iron or pressing machine, creasing the edge.					
	d. Position the cuff at the mark on the sleeve and stitch uniformly 1/8 inch from the upper finished edge of cuff.	301	LSd-1	12-16	40/3 or A	40/3 A
14	<u>Seam sleeve at backarm.</u>					
	Finished appearance. The backarm seam shall finish smooth and flat, without twists, gathers, puckers or pleats and shall start and finish evenly.					
	a. Join the topsleeve to the undersleeve at the backarm with a 3/8 inch seam, trimming and catching the ends of the cuff in the seam.	301	SSa-1	12-16	40/3 or A	40/3 A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
14	<u>Seam sleeve at backarm.</u> (cont'd)					
	b. Bind the raw backarm edge of top and undersleeve together with 1-1/8 inch bias binding; both edges of the binding shall be turned under and caught in the stitching 1/16 inch from the inner folded edges.	301	BSc-1	10-14	40/3 or A	40/3 A
	c. Turn sleeves right side out. Raisestitch the topsleeve uniformly 1/8 inch from the seam line with seam allowance turned against top sleeve.	301	LSq-2 (b) (shows finished seam)	12-16	40/3 or A	40/3 A
	d. The finished edge of the seam on the outside of the sleeve shall be towards the back.					
15	<u>Hem cuff.</u>					
	Finished appearance. The cuff hem shall be smooth and flat without twists, puckers, pleats or bulges that can distort the outside of the finished cuff.					
	a. Turn under lower edge of cuff 1/4 inch and seam to body of cuff 1/8 inch from the folded edge.	301	EPa-1	10-14	40/3 or A	40/3 A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
16	<p><u>Fell cuff to sleeve.</u></p> <p>Finished appearance. The bottom of the cuff shall finish smooth and flat without distortion.</p> <p>a. Turn the sleeve inside out. Turn the bottom of cuff to the inside in accordance with notches against the bottom end of sleeve, and fell upper folded edge of cuff to body of sleeve with blindstitching.</p> <p>b. Turn sleeve right side out and press the lower half smooth and flat, creasing at the backarm and forearm. The backarm crease shall be on the backarm seam.</p> <p>c. On the finished coat, the length of the cuff shall be $3-1/4 \pm 1/4$ inches at the front and backarm creased edges and $6 \pm 1/4$ inches at the point.</p>	103	EFC-1	6-8	40/3 or A	
17	<p><u>Bind facings; sew on combination identification-instruction label.</u></p> <p>Finished appearance. The binding shall be uniformly stitched; the basic material and edges of binding shall be caught in the stitching. The binding shall not be tight</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
17	<p><u>Bind facings; sew on combination identification-instruction label.</u> (cont'd)</p> <p>or full causing puckers, gathers, pleats or other distortions. The identification-instruction label shall be properly positioned and securely sewn to the right facing.</p> <p>a. Bind the raw back edge of the facings with 1-1/8 inch bias binding. Both edges of the binding shall be turned under and caught in the stitching 1/16 inch from the inner folded edge.</p> <p>b. Sew the combination identification-instruction label to the right facing with a single row of stitching 1/16 inch from each edge of the label. The end of label stitching shall be overlapped not less than 3 stitches.</p> <p>c. The label shall be positioned at the center of the facing with the lower edge approximately 4 inches above the bottom finished edges of coat.</p>					
		301	BSc-1	10-14	40/3 or A	40/3 A
		301	LSbj-1 (each edge)	10-14	40/3 or A	40/3 A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
18	<p><u>Seam dart in fronts.</u></p> <p>Finished appearance. The darts shall be properly positioned and finished without pleats, puckers or gathers.</p> <p>a. Fold and stitch chest, underarm and waist darts in accordance with marks and notches as indicated on the pattern. Lower end of chest and underarm darts and upper and lower ends of waist darts shall be well tapered to a flat point.</p> <p>b. Press the darts smooth and flat with a heated pressing iron, with the inside folded edge of the chest dart towards the armhole, the inside folded edge of the underarm dart towards the back, and the folded edge of the waist dart towards the front.</p>	301	OSf-1 (each dart)	12-16	40/3 or A	40/3 A
19	<p><u>Seam eyelet reinforcement to right front.</u></p> <p>a. Seam the eyelet reinforcement piece to inside of right front 1/16 inch from front and top edges.</p>	301	SSa-1	10-14	40/3 or A	40/3 A
20	<p><u>Make eyelets in right front.</u></p> <p>Finished appearance. The eyelets shall be well worked with the purling on</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
20	<p><u>Make eyelets in right front.</u> (cont'd)</p> <p>the outside and shall finish with a 1/8 inch diameter opening. All stitches shall be securely caught in the fabric. The second eyelet from the top shall be in line with the top edge of the upper pocket.</p> <p>a. Mark location of eyelets for removable buttons in accordance with marks indicated on pattern.</p> <p>b. Mark one eyelet at each mark through eyelet reinforcement.</p>	Eyelet		20 per eyelet (minimum)	40/3 or A	40/3 A
21	<p><u>Set upper pockets and pocket flaps.</u></p> <p>Finished appearance. The pockets and pocket flaps shall be set without twists, gathers, puckers, pleats or raw edges. The side of pockets shall not extend beyond sides of flaps. Pockets and pleats shall be parallel to the front edge of coat when buttoned. The point of the flaps shall be at the center of the pleat on the pocket. The pocket and pocket flap on the left and right fronts shall be in horizontal alignment with each other.</p>					

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
21	<p><u>Set upper pockets and pocket flaps.</u> (cont'd)</p> <p>a. Mark the fronts in accordance with the marks on the pattern for position of the upper pockets and pocket flaps.</p> <p>b. Position the overedge stitched edge of pocket flaps on outside of fronts 3/16 inch below the top marked line indicated on the pattern.</p> <p>c. Stitch pocket flaps to fronts 3/16 inch from overedge stitched edge and on the marked line.</p> <p>d. Turn down the flaps and raisestitch 1/8 inch from the seam line.</p> <p>e. Properly position upper pockets on fronts in accordance with marks on pattern, and seam to fronts uniformly 1/8 inch from side and bottom edges, securely bartacking top corners of pockets 1/8 inch from top and side edges for a distance of not less than 1/4 inch on each edge.</p>	<p>301</p> <p>301</p> <p>301</p>	<p>LSbk-2 (a)</p> <p>LSbk-2 (b)</p> <p>LSd-1 (b)</p>	<p>12-16</p> <p>12-16</p> <p>12-16</p>	<p>40/3 or A</p> <p>40/3 or A</p> <p>40/3 or A</p>	<p>40/3 A</p> <p>40/3 A</p> <p>40/3 A</p>
22	<p><u>Join backs.</u></p> <p>Finished appearance. The back seams shall start and finish evenly without gathers, pleats, puckers or raw edges.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
22	<u>Join backs.</u> (cont'd)					
	a. The back shall be made of four pieces.					
	b. Position the center back parts with edges even. Join together at the center with a 5/8 inch seam, from mark for top end of vent to top edge of back parts.	301	SSa-1	12-16	40/3 or A	40/3 A
	c. Respectively position and join the left and right side backs to the center back parts with 3/8 inch seam with notches matching.	301	SSa-1 (each seam)	12-16	40/3 or A	40/3 A
23	<u>Bind backs.</u>					
	Finished appearance. The bias binding shall be 1-1/8 inches in width. The binding shall be uniformly stitched and shall not be tight or full causing puckers, gathers, or pleats. The basic material and edges of binding shall be caught in the stitching.					
	a. Bind the raw edge of the left vent. Bind together the raw edge of the center back seam from the top edge (neck edge) down to the top end of the vent, catching the top bound edge of the left vent in the stitching. From that point continue to bind the right vent	301	BSc-1	10-14	40/3 or A	40/3 A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
23	<u>Bind backs.</u> (cont'd) only to the bottom edge of coat, with both edges of the binding turned under and caught in the stitching 1/16 inch from the inner folded edges.					
24	<u>Raisestitch back.</u> Finished appearance. All raisestitching shall be a uniform distance from the seam line. a. Raisestitch the left and right back seams uniformly 1/8 inch from left and right back seam respectively with the seam allowances turned against the center backs. b. The finished edge of the left and right back seams on the outside of the coat shall be towards the left and right side backs respectively. c. Raisestitch the left back uniformly 1/8 inch from the center back seam line, from top edge of coat to top end of vent with seam allowance turned against the left back. At that point, turn the left back vent edge to the inside of the left back in accordance with the notch and continue stitching 1/8 inch from the folded edge, to the bottom of the coat.	301	LSq-2 (b) (shows finished seam)	12-16 finished	40/3 or A	40/3 A
		301	LSq-2 (b) (center seam) (shows finished seam) OSf-1 (vent)	12-16	40/3 or A	40/3 A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
24	<u>Raisestitch back.</u> (cont'd)					
	d. Stitch and backstitch at right angles across the top end of the vent through all plies, for a distance of $1-1/2 \pm 1/8$ inches from the center back seam line.	301	LSa-1	12-16	40/3 or A	40/3 A
	e. The finished edge of the center back seam on the outside of the coat shall be towards the right side. The folded edge of the left back vent edge shall be in line with the seam line of center back seam. In the finished coat, the left back part shall overlap the right back part $3-1/2 \pm 1/4$ inches, measured at the bottom edge of the coat. The left vent shall be $1-3/4 \pm 1/8$ inches wide, measured at the bound edge of the bottom turnup.					
25	<u>Join backs and fronts.</u>					
	Finished appearance. The side seams of the coat shall be carefully joined without twists, puckers or raw edges. The seams shall start and finish evenly. The gage of stitching shall be uniform in width.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
25	<u>Join backs and fronts.</u> (cont'd)					
	a. Position the side backs and fronts with edges even and join together at the sides with a 3/8 inch seam. Spread the side seams open and press flat.	301	SSa-1	12-16	40/3 or A	40/3 A
	b. Bind the raw edges of the left and right side seam allowances separately, with both edges of the binding turned under and caught in the stitching 1/16 inch from the turned edge.	301	BSc-1	10-14	40/3 or A	40/3 A
26	<u>Shape front and mark for bottom turnup.</u>					
	a. Dress the left front in a line running from the top notch 1 inch from the front edge at the waist and in a straight line from the waist to the bottom notch as indicated by markings on the pattern. Mark the fronts and back 1-1/2 inches from the lower edge, for the bottom turnup.					
	b. In the finished coat, the left front shall overlap the right front 4 ± 1/4 inches at the bottom edge.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
27	<p><u>Bind bottom turnup.</u></p> <p>Finished appearance. The binding shall be uniformly stitched, shall not be tight or full causing puckers, gathers, or pleats; the basic material and edges of binding shall be securely caught in the stitching.</p> <p>a. Bind the raw edge of the bottom turnup with 1-1/8 inch wide bias binding, with both edges of the binding turned under and caught in the stitching 1/16 inch from the inner folded edges.</p> <p>b. The binding shall extend from the back edge of the front cutout to not less than 1/2 inch beyond the folded under left back vent edge and bound right back vent edge. The 1/2 inch extension of the binding at back edges shall be turned under when bottom turnup is stitched down.</p>	301	BSc-1	10-14	40/3 or A	40/3 A
28	<p><u>Baste facings to front.</u></p> <p>a. Properly position the left and right facings on outside of respective fronts, and baste along the front and bottom edges of facings.</p>	301	Hopper			

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
29	<u>Join facings and fronts with tape.</u> a. Seam the facings and fronts together 3/16 inch from the top, front and bottom edges to back of facing with the stay tape positioned on the inside of the front 1/8 inch from the top, front and bottom edges of the coat and caught in the stitching. b. The tape shall extend from the collar notch at the top, to the bottom back edge of the facing, and shall be sewn with slight tension.	301	SSa-1	12-16	40/3 or A	40/3 A
30	<u>Press front edges and bottom turnup.</u> a. Pull and remove basting stitches in fronts. b. Press the front edges of the coat smooth and flat with a heated pressing iron or pressing machine, removing the fullness caused by slight tension on tape. c. Turn up the bottom of the coat at the mark for the turnup and press smooth and flat with a heated pressing iron or pressing machine, creasing the bottom folded edge.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
30	<u>Press front edges and bottom turnup.</u> (cont'd) d. In the finished coat, the bottom turnup of the coat shall be uniformly $1\frac{1}{2} \pm \frac{1}{8}$ inches wide.					
31	<u>Edgestitch coat.</u> Finished appearance. The edgestitching shall be of uniform width without twisting, pleating or puckering, and shall finish flat and smooth. a. Trim the upper and lower corners of the coat and turn the facings to the inside of the fronts, forcing the seam line out to the edge, working out the corners and lapping the facings on the bottom turnup. b. Edgestitch the coat along the top, front and bottom edges from the collar notch to the back edge of the facings. Continue stitching along back edge of the facing to bound edge of bottom turnup, and from that point seam the bottom turnup to the fronts and backs through the binding, turning under the binding extension at the vent edges, and seam back ends of bottom turnup to coat.	301	SSe-2 (top front and bottom edge of facing edges) (shows finished seam) SSc-1 (bottom edge of facing) LSa-1 (back edge of facing) SSa-1 (back end of bottom turnup) EFa-1 (bottom turnup)	12-16	40/3 or A	40/3 A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
31	<p><u>Edgestitch coat.</u> (cont'd)</p> <p>c. The stitching shall be uniformly 1/8 inch from the top, front and bottom edge to the back edge of the facing and shall be made through the binding on the back edge of the facing to the top of the hem, on the bottom turnup and on the right back vent edge as close as possible to, but not on top of, the stitching attaching the binding. The stitching across the end of the bottom hem on the left back vent edge shall be superimposed on the edge stitching.</p>					
32	<p><u>Baste facings.</u> <u>(second time)</u></p> <p>Finished appearance. The fullness shall be properly and uniformly placed at back edge of facing. The lower front edges shall close flat and smooth without rolling outward.</p> <p>a. Baste facings to fronts along shoulder, armhole and back edges of facing.</p> <p>b. Trim the facing even with the armhole edge and the shoulder edge of the facing 1/2 to 5/8 inch beyond the shoulder edge of the coat.</p>	Hand				

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
33	<u>Bind shoulder ends of facing.</u> Finished appearance. The binding shall be evenly stitched, with the fabric securely caught in the stitching. The binding shall not be tight or full, causing distortion.					
	a. Bind shoulder edge of the facings with 1-1/2 inch wide bias binding, with both edges of the binding turned under and caught in the stitching 1/16 inch from the inner folded edges.	301	BSc-1	10-14	40/3 or A	40/3 A
34	<u>Set lower pockets and flaps.</u> Finished appearance. The pockets and pocket flaps shall be set without twists, gathers, puckers, pleats or raw edges. The stitching for the raised edge of the flaps shall conform to stitching for setting the pockets. The side edges of the pockets shall not be exposed beyond the sides of the flaps. The pocket and pocket flaps on the left and right side, respectively, shall be in horizontal alignment with each other. The front edge of the flap shall be in line with the front edge of the upper pocket and the lower front corner					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
34	<p><u>Set lower pockets and flaps.</u> (cont'd)</p> <p>of the lower pocket shall be 3/8 inch further back toward the side seam. Pocket and pocket flaps shall conform to the measurements shown in Table III.</p> <p>a. Mark the fronts in accordance with the marks on the pattern for position of lower pockets and pocket flaps.</p> <p>b. Position lower pocket flaps on outside of fronts with overedge stitched edge in line with marks as indicated on pattern.</p> <p>c. Seam the pocket flaps to the fronts and facing 3/16 inch from overedge stitched edge.</p> <p>d. Turn down the flaps and raisestitch 1/8 inch from the seam.</p> <p>e. Position lower pockets in accordance with marks as indicated on pattern, with lower edge of pocket to be 1-1/4 inches above bottom finished edge of coat.</p> <p>f. Seam the bellows of the pockets to fronts, through the facings, 3/8 inch from the side and bottom raw inside edges,</p>					
		301	LSbk-2 (a)	12-16	40/3 or A	40/3 A
		301	LSbk-2 (b)	12-16	40/3 or A	40/3 A
		301	LSbj-1 and LSd-1	12-16	40/3 or A	40/3 A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
34	<u>Set lower pockets and flaps.</u> (cont'd) securely tacking the top corners of the pockets 1/8 inch from top and side edges for a distance of not less than 1 inch on each edge.					
35	<u>Set sword slit tab and make opening.</u> Finished appearance. Sword slit and tab shall finish without distortion of the coat. All stitching shall be uniform and securely caught in the fabric. The sword slit shall be properly positioned. a. Mark location for sword slit on left front, 1-1/8 inches above the lower flap as indicated by mark on pattern and 1/2 inch in front of the underarm dart, for a distance of 2 inches. Mark sword slit tab 1-3/4 inches from bottom finished edge for seaming to coat. b. Position sword slit tab on outside of front with marked lines on tab and front matching. Seam tab to front at marked lines.	301	SSa-1	12-16	40/3 or A	40/3 A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
35	<u>Set sword slit tab and make opening.</u> (cont'd)					
	c. Position welt piece for lower edge of sword slit opening on outside of front with raw edge placed under sword slit tab and abutting tab seam line.					
	d. Seam welt piece to front 1/8 to 3/16 inch from raw edge through the front.	301	LSj-1	12-16	40/3 or A	40/3 A
	e. Cut opening for the sword slit midway between the seam lines joining the tab and welt piece to the front, tongue notching each end of the opening. The notches shall be cut to a sufficient depth for proper turning of the tab and welt piece, but shall not show on the outside of the finished coat.					
	f. Turn welt piece through opening to inside of coat, forming a 1/8 to 3/16 inch wide welt at lower edge of opening. Raisestitch lower edge of opening through the front welt seam and welt 1/16 inch below seam line joining welt to front.	301	SSbe-2 (b)	12-16	40/3 or A	40/3 A
	g. Stitch welt to front along side and bottom selvage edges, with the stitching to be a continuation of the raisestitching at opening,	301	LSa-1	12-16	40/3 or A	40/3 A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
35	<p><u>Set sword slit tab and make opening.</u> (cont'd)</p> <p>forming a box stitch measuring 1/2 to 3/8 inch from top to bottom and 2 \pm 1/8 inches from side to side.</p> <p>h. Turn down sword slit and raisestitch the front 1/16 inch above the joining seam line, through the tab allowance.</p> <p>i. Stitch the sides and top edge of the tab to the fronts with box stitching in the same manner as specified for the welt (see 35.g) and with the ends of the opening securely tacked.</p> <p>j. The finished sword slit opening shall be 2 \pm 1/8 inches long and 1 to 1-1/8 inches above top edge of lower pocket flaps.</p>	301	LSq-2 (shows finished seam)	12-16	40/3 or A	40/3 A
		301	LSj-1	12-16	40/3 or A	40/3 A
36	<p><u>Make buttonholes.</u></p> <p>Finished appearance. The buttonholes shall be clean cut, well made, properly positioned, well worked over gimp to fit a 40-line insignia button. The stitching shall be securely caught in the basic material. The gimp shall be pulled through to the underside of front and</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
36	<u>Make buttonholes.</u> (cont'd) the purling of the buttonholes shall be on the outside of coat. a. Mark the location for five buttonholes on left front to correspond with the eyelets in the right front. b. Make a 1-1/8 inch long horizontal, eyelet-end, square-bar type buttonhole at each of the marks, with the inside (purled) edge of the eyelet 5/8 inch from the front edge of the coat. c. Securely bartack the end of each buttonhole, catching the gimp ends on the underside and trimming the ends of the gimp.	Buttonhole		50 per button-hole (minimum) (not including bartack)	40/3 or A	40/3 A
		Bartack		21 per bartack (minimum)	40/3 or A	40/3 A
37	<u>Seam shoulders.</u> Finished appearance. The shoulder seams shall be carefully joined, uniformly stitched and shall finish smooth and flat without twists, gathers, puckers, pleats or raw edges. On the outside of the coat, the finished edge of seams shall be towards the front.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
37	<u>Seam shoulders.</u> (cont'd)					
	a. Join fronts and backs at shoulders with a $3/8$ inch seam, working in the fullness on the backs so that the shoulders may be properly shaped.	301	LSq-2 (a)	12-16	40/3 or A	40/3 A
	b. Turn the seam allowance toward the back and raisestitch $1/8$ inch from the seam line.	301	LSq-2 (b)	12-16	40/3 or A	40/3 A
38	<u>Set shoulder straps.</u>					
	Finished appearance. On the finished coat, the straps shall measure $2-3/8 \pm 1/8$ inches wide at the armhole and shall taper to $1-1/2 \pm 1/8$ inches wide in line with the eyelet end of the buttonhole. The straps shall lie smooth and flat, with the round end $1/4$ to $3/8$ inch from the lower edge of the collar.					
	a. Position the shoulder strap with the raw edge in line with the armhole and the back finished edge of the strap $1/2$ inch behind and in line with the shoulder seam. The correct position of the button shall be in alignment with shoulder strap buttonhole and when buttoned, there is no distortion of strap or shoulder.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
38	<u>Set shoulder straps.</u> (cont'd)					
	b. Seam shoulder straps to coat through the facing 1/4 inch from the armhole, trimming the straps even with the armhole.	301	SSa-1	10-14	40/3 or A	40/3 A
39	<u>Make eyelet in shoulders.</u> Finished appearance. The eyelets shall be well worked with the purling on the outside and shall finish with a 1/8 inch diameter opening. All stitches shall be securely caught in the fabric. a. Mark location of eyelet in shoulders for removable button to correspond with eyelet of buttonhole in shoulder straps, so that on the finished coat, the straps shall lie smooth and flat without twisting or bulging. b. Make one eyelet at mark on each shoulder through front only.	Eyelet		20 per eyelet (minimum)	40/3 or A	40/3 A
40	<u>Join facings to front at neckline and armhole.</u>					
	a. Join facings to fronts at neckline and at front edge of armhole with 1/8 inch seams, catching the shoulder straps in the stitching.	301	SSa-1	10-14	40/3 or A	40/3 A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
40	<u>Join facings to front at neckline and armhole.</u> (cont'd) b. Trim excess material from facing at neckline and armhole.					
41	<u>Stitch hanger and label to coat.</u> Finished appearance. The size label and coat hanger shall be properly positioned and securely stitched to the coat. a. Stitch upper edge of size label and the ends of the hanger to the inside center back of neck. b. In the finished coat, the ends of the loop shall be $1\frac{1}{2} \pm \frac{1}{8}$ inches apart when measured along the lower edge of the collar.	301	SSa-1	10-14	40/3 or A	40/3 A
42	<u>Set collar.</u> Finished appearance. The collar shall be uniform in appearance and placement shall be carefully joined to the coat without distortion. a. Mark neckline of coat on the outside $\frac{1}{2}$ inch from raw edge for proper positioning of collar.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
42	<u>Set collar.</u> (cont'd)					
	b. Position collar with lower edge lapped on the outside top edge of coat at the mark.					
	c. Seam the outer collar from end to end to the coat 1/16 to 1/8 inch from the lower edge of collar. The stitching shall not be through the collar lining.	301	LSa-1 (lower edge of collar) OSf-1 (ends of collar)	12-16	40/3 or A	40/3 A
43	<u>Set sleeves.</u>					
	Finished appearance. The sleeves shall be carefully set without twists, pleats or gathers and with the fullness properly distributed.					
	a. Position sleeves on outside of coat at armholes with backarm seam lines of sleeve matching the back seam line and with notch in topsleeve and fronts matching.					
	b. Join sleeves to coat with a 3/8 inch seam, evenly distributing the fullness around entire armhole and catching the end of the shoulder strap and armhole edge of facing in the stitching.	301	SSa-1	12-16	40/3 or A	40/3 A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
44	<u>Bind armhole.</u> Finished appearance. The binding shall be uniformly stitched and shall not be tight or full, causing puckers, gathers, or pleats. The basic material and edges of binding shall be caught in the stitching.					
	a. Bind the raw edges of armhole seam together with 1-1/8 inch wide bias binding. The edges of the binding shall be turned under and caught in the stitching. The ends of the binding shall lap each other on lower back armhole, leaving approximately 3/4 inch extension on the top end. The stitching shall be 1/16 inch from the inner folded edge of the binding.	301	BSc-1	10-14	40/3 or A	40/3 A
	b. Turn the top end of the binding to inside of armhole, lapping the top end on the opposite end. Secure to armhole with a 3/8 to 1/2 inch long bartack. The bartack shall be made on a line with the row of stitches for the binding and shall be stitched through all plies of material at the point of bartacking.	Bartack		21 per bartack (min- imum)	40/3 or A	40/3 A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
45	<p><u>Sew hook and eyes to collar.</u></p> <p>Finished appearance. The hooks and eyes shall be securely sewn and positioned to properly engage each other, effecting a flat, smooth closure at the front of collar without misalignment or gap.</p> <p>a. Securely sew two hooks to the right end of the collar and two eyes to the left end, extending slightly beyond the left end of the collar. Place one hook and eye at the top of the collar and one at the bottom, with the ends of the collar lining turned to the inside and the upper end caught in the stitching of the top hook and eye.</p>	Hand		16 per hook and eye (minimum)	40/3 or A (double thread)	
46	<p><u>Finish collar.</u></p> <p>Finished appearance. The completed collar shall be securely attached without gathers, excessive fullness or distortion in the attachments or the seams. Stitching shall be of uniform gage.</p> <p>a. Securely tack the lower corners of the collar to the coat.</p>	Hand		6-8	40/3 or A	

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
46	<u>Finish collar.</u> (cont'd)					
	b. Turn under the raw edge of collar lining at the right of the collar and position the folded edge of the lining under the hook. Fell the folded edge of lining along the end of collar.	Hand		6-8	40/3 or A	
	c. Turn under and fell the lower folded edge of collar lining to the coat from end to end.	Hand		6-8	40/3 or A	
	d. Turn back the collar extension tab, in line with the left end of collar, and fell the tab along the edge of collar, covering part of the eyes.	Hand		6-8	40/3 or A	
47	<u>Make eyelets in pockets and collar.</u>					
	Finished appearance. The eyelets shall be well worked with the purling on the outside of the pockets and collar, and shall finish with a 1/8 inch diameter opening. All stitches shall be securely caught in the fabric.					
	a. Mark location of each eyelet in each pocket for removable buttons to properly align with eyelet of buttonhole in pocket flaps so that when buttoned on the finished coat, the flaps shall be smooth and flat without					

TABLE I MANUFACTURING REQUIREMENTS

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
49	<p><u>Press coat.</u> (cont'd)</p> <p>appearance in accordance with good manufacturing procedures.</p> <p>a. Block the shoulders to remove the fullness and press shoulders smooth on a shoulder shaping machine with shoulder straps properly positioned over shoulder seam and pressed flat.</p> <p>b. Press entire armhole, removing the fullness.</p> <p>c. Block the armholes on a pressing buck, shrinking in the topsleeve.</p> <p>d. Press the collar smooth and flat.</p> <p>e. Press the fronts in the area of the chest on a body machine, shrinking and properly shaping the chest.</p> <p>f. Press the fronts and pockets smooth and flat, straightening and shaping the front edges and working the fullness towards the chest. Care shall be exercised in pressing the fronts so that the bottom edges are even.</p> <p>g. Press sides, working lower part of forepart toward the back.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
49	<p><u>Press coat.</u> (cont'd)</p> <p>h. Press the back smooth and flat, removing all fullness and lapping the left vent on the right.</p> <p>i. Press lower edge of coat smooth and flat.</p> <p>j. Press the sleeves smooth and flat, creasing at the backarm and forearm. The backarm crease shall be on the backarm seam line. The forearm crease shall extend uniformly to a point 1-1/2 inches above bottom edge of breast pockets. The top of the backarm crease shall be in line with the top of the forearm crease.</p>					
50	<p><u>Attach buttons</u> <u>(when required).</u></p> <p>a. When buttons are required for the coat, they shall be attached by inserting the shank through the eyelets on the shoulders, the pockets and left front, and securing on the inside with metal ring fasteners.</p>					

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3.7 Finished measurements. The finished coat shall conform to the measurements shown in Tables II and III.

Table II - Coat Measurements 1/

Size	Breast 2/	Back Length 3/	Sleeve Length 4/	Collar Length 5/
SHORT				
	inches	inches	inches	inches
36	37	29	17	15-1/2
38	39	29-1/4	17	16
40	41	29-1/2	17	16-1/2
42	43	29-3/4	17	17
REGULAR				
	inches	inches	inches	inches
36	37	30-1/4	18	15-1/2
38	39	30-1/2	18	16
40	41	30-3/4	18	16-1/2
42	43	31	18	17
44	45	31-1/4	18	17-1/2
46	47	31-1/2	18	18
LONG				
	inches	inches	inches	inches
36	37	31-1/2	19	15-1/2
38	39	31-3/4	19	16
40	41	32	19	16-1/2
42	43	32-1/4	19	17
44	45	32-1/2	19	17-1/2
46	47	32-3/4	19	18
EXTRA LONG				
	inches	inches	inches	inches
36	37	33	20	15-1/2
38	39	33-1/4	20	16
40	41	33-1/2	20	16-1/2
42	43	33-3/4	20	17
44	45	34	20	17-1/2

1/ Tolerance on all measurements: $\pm 3/8$ inch, except collar length $\pm 1/4$ inch. Tolerance is on 1/2 breast measurements.

2/ Breast measurement taken with coat buttoned, from folded edge to folded edge in line with pit of armhole; multiply by 2.

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- 3/ Back length measurement taken along center back seam from lower edge of collar to bottom edge of coat.
- 4/ Sleeve length measurement taken along inseam from pit of armhole to bottom edge of cuff.
- 5/ Collar length measurement taken along outside center of collar from end to end, not including extension tab.

Table III - Pocket and Flap Measurements 1/

UPPER POCKETS AND FLAPS			
Size (Short, Regular, Long, X-Long)	36-38	40-42	44-46
	<u>inches</u>	<u>inches</u>	<u>inches</u>
Length of flaps at center point	2-7/8	2-7/8	2-7/8
Length of flaps at sides	2-1/8	2-1/8	2-1/8
Width of flaps at top edge	5	5-1/4	5-1/2
Width of pockets along the top edge	4-3/4	5	5-1/4
Length of pockets; top edge to bottom edge	6-1/2	6-1/2	6-1/2
LOWER POCKETS AND FLAPS			
Size (Short, Regular, Long, X-Long)	36-38	40-42	44-46
	<u>inches</u>	<u>inches</u>	<u>inches</u>
Length of flaps at center point	3-3/4	3-3/4	3-3/4
Length of flaps at sides	2-1/4	2-1/4	2-1/4
Width of flaps at top edge	7-3/4	8-1/4	8-3/4
Width of pockets along the top edge	7-1/2	8	8-1/2
Length of pockets; top edge to bottom edge:			
Short	10-3/4	10-3/4	10-3/4
Regular	11-1/4	11-1/4	11-1/4
Long	11-3/4	11-3/4	11-3/4
X-Long	12-1/4	12-1/4	12-1/4

1/ Tolerance on all measurements: $\pm 1/8$ inch

3.8 Workmanship. The finished coats shall conform to the quality and grade of product established by this specification. The occurrence of defects shall not exceed the levels set by the applicable acceptable quality levels (AQL's).

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4. QUALITY ASSURANCE PROVISIONS

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

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

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

1. First article inspection (see 4.4).
2. Quality conformance inspection (see 4.5).

4.3 Inspection. Inspection shall be in accordance with the provisions set forth in MIL-STD-105, except where otherwise indicated herein.

4.4 First article inspection. When first article is required, inspection shall be performed on a completely fabricated coat for conformance to all provisions of this specification.

4.5 Quality conformance inspection.

4.5.1 Component and material inspection. In accordance with 4.1 above, components and materials shall be tested in accordance with all the requirements of referenced specifications, figures and standards unless otherwise excluded, amended, modified or qualified in this specification or applicable purchase document. In addition to testing provisions contained in subsidiary specifications, figures and standards, testing shall be performed on components listed in Table IV for characteristics noted.

4.5.1.1 Sampling for testing. Unless otherwise specified in subsidiary specifications, sampling shall be in accordance with the following. The lot shall be unacceptable if one or more sample units fail to meet any test requirement specified herein.

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<u>Lot size (lot unit)</u>	<u>Sample size (sample unit)</u>
800 or less	2
801 thru 22,000	3
22,001 and over	5

4.5.2 In-process inspection. Inspection shall be performed during the manufacturing of the end item to ascertain that the operations are performed as specified herein. The Government reserves the right to determine the acceptability of construction methods not performed in accordance with specified requirements for operations or subassemblies.

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Table IV - Test Methods

Components	Characteristics	Require- ments	Rqmt para.	Test method	Requirement applied to sample unit	No. Det. per S/U	Results reported as:
Hooks and eyes	Material identification	Brass	3.3.7	Std. comm'l	X	1	Pass or fail
	Finish	Nickel plated	3.3.7	Std. comm'l	X	1	Pass or fail

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4.5.3 Examination of end item. The end item shall be examined for defects listed in 4.5.3.1, 4.5.3.2 and 4.5.3.3. The sample unit shall be one coat. All defects shall be classified as indicated below:

Major defect - When seriously affecting appearance or serviceability.

Minor A defect - When affecting appearance or serviceability, but not seriously.

Minor B defect - Workmanship damages.

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

Examine	Defects		Classification	
			Major	Minor
			A	B
Material defects and workmanship damages	a. Any hole or weakening defect such as a smash, multiple float, loose slub, etc. that may develop into a hole.	101		
	b. Any scissor or knife cut, tear, mend, or needle chew likely to develop into a hole.	102		
	c. Shade bar, unsightly slub, etc. not weakening the fabric: - on outside. - on inside.	103		301

NOTE: Material defects and workmanship damages are to be classified Major or Minor A and B defects as indicated only when the condition is one which definitely weakens the structure of the garment or when it is so conspicuously located as to be clearly noticeable. Non-weakening conditions which are inconspicuous are to be classified as follows:

Material defect - No defect
Workmanship damages - Minor B defect

Shaded part	a. Any outside part shaded.	104		
Cleanness	a. Spot or stain of permanent nature.	105		

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Examine	Defects	Classification		
		Major	Minor	
		A	B	
Cleanness (cont'd)	b. Removable spot or stain clearly visible on: - outside. - inside.		201	302
	c. Thread ends not trimmed, loose thread or shade ticket not removed.			303
Components and assembly	a. Any component part or required operation omitted (unless otherwise classified herein).	106		
	b. Any operation not performed as specified (unless otherwise classified herein).			304
Cutting	a. Any part not cut in accordance with directional lines on pattern, or not cut in accordance with specification requirements: - principle part of coat. - small, hidden part.	107		305
Pressing	a. Burned or scorched.	108		
	b. Omitted or poorly pressed, affecting appearance.		202	
Seams and stitchings	a. Accuracy of seaming: 1. Part of coat caught in unrelated operation or stitching.	109		
	2. Seam twisted, puckered or pleated (unless otherwise classified herein).	110		
	3. Thread break or end of all stitchings (when not caught in another seam or stitching) not securely backtacked.		203	

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Examine	Defects	Classification		
		Major	Minor	
		A	B	
Seams and stitchings (cont'd)	b. Gage of stitching (edgestitching or raisestitching):			
	1. Irregular, i.e., unevenly gaged, or corresponding stitching not uniformly gaged.			306
	2. Not within range of gage specified, or varies more than 1/16 inch when no range of gage is specified.			307
	c. Open seam:			
	1. Seam open:			
	- 1/4 inch to 1/2 inch.			
	- more than 1/2 inch up to 1 inch.		204	308
	- more than 1 inch.	111		

NOTE: One or more broken or two or more skipped or run-off stitches (except on edgestitching or raisestitching) constitute an open seam.

d. Raw edges:				
1. On outside:				
- more than 1/8 inch up to 1/4 inch.				309
- more than 1/4 inch up to 1 inch.			205	
- more than 1 inch.	112			
2. On the inside:				
- more than 1/2 inch up to 1 inch.				310
- more than 1 inch.			206	

NOTE: Raw edge not securely caught in the stitching shall be classified as an open seam.

e. Run-off (see classification of open seams).				
f. Seam or stitch type not as specified.			207	

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Examine	Defects	Classification		
		Major	Minor	
			A	B
Seams and stitchings (cont'd)	g. Stitch tension:			
	1. Loose tension resulting in a loose seam.	113		
	2. Loose tension on edgestitching or raisestitching (recognized by loosely exposed bobbin or top thread).			311
	3. Tight tension (stitches break when normal strain is applied to the seam or stitching).	114		

NOTE: Puckering is evidence of tight tension. When puckering is evident, the seam shall be tested by exerting normal pull on the seam.

Buttonhole (applying to all buttonholes)	h. Stitches per inch (to be scored when the condition exists or major portion of seam or stitching):			
	1. Less than minimum specified (except on labels) by:			
	- 1 stitch.			
	- 2 stitches.			
	- 3 or more stitches.	115	208	312
	2. On labels, less than minimum specified.			313
	3. Any number in excess of maximum specified.		209	
	a. Stitching not securely caught in fabric, causing stitching to pull away from fabric.	116		
	b. Bartack omitted, loose or misplaced (i.e., not serving intended purpose) on one or more buttonholes.	117		
	c. Not corresponding to size of button so that it does not button properly.		210	

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Examine	Defects	Classification	
		Major	Minor
		A	B
Buttonhole (applying to all buttonholes) (cont'd)	d. One or more omitted or uncut or gimp omitted in one or more buttonholes.	211	
	e. Gimp not pulled to underside and caught by bartack.		314
	f. One or more broken, or more than two skipped stitches on: - 1 buttonhole. - 2 or more buttonholes.	212	315
	g. Poorly constructed, affecting appearance.	213	
	h. Purling finishing on the reverse side.	118	
Eyelet	a. One or more broken stitches or more than two skipped stitches: - 1 eyelet. - 2 or more eyelets.	214	316
Buttons (when required)	a. Missing, loose or broken: - 1 button. - 2 or more buttons.	215	317
Collar	a. Construction and setting:		
	1. Interlining omitted or not three ply.	119	
	2. Puckering or pleated at joining to neck or around edges.	120	
	3. Badly twisted.	121	
	4. Ends uneven in width by 1/4 inch or more.	216	
	5. Less than 1-7/8 inches or more than 2-1/8 inches wide.	217	
	6. Collar lining exposed beyond top edge of left end of outer collar.	122	
	7. Set off center of neckline by more than 1/2 inch.	218	

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Examine	Defects	Classification	
		Major	Minor
		A	B
Collar (cont'd)	8. Collar extension tab at left end of collar extending less than 3/4 inch or more than 7/8 inch beyond end of collar.	219	
	9. Boxstitching omitted on left end of undercollar.		318
	10. Eyelets on ends of collar positioned from edge less than 1-3/4 or more than 2 inches.	220	
	b. Hooks and eyes:		
	1. Any missing, bent, defective or not securely attached.	221	
	2. Not properly aligned, causing twist at collar ends when engaged.	222	
	3. Not properly positioned, causing unsightly gap between collar ends when hooked.	223	
	a. Front edge(s):		
	1. Crooked, puckered, stretched, improperly forced out or otherwise malformed.	123	
	2. Facing exposed on outside, if readily noticeable.	224	
Fronts	b. Front opening:		
	1. Buttoned fronts uneven in length by 1/2 inch or more.	225	
	2. Bottom buttonhole and button eyelet uneven from bottom edge by more than 3/8 inch.	226	
	3. Top buttonhole and button eyelet uneven distance from edge of collar by more than 1-1/8 inch.	227	

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Examine	Defects	Classification		
		Major	Minor	
			A	B
Fronts (cont'd)	4. Left front overlapping right front at bottom less than 3-3/4 or more than 4-1/4 inches.		228	
	c. Front buttonholes and button eyelets (position and alignment):			
	1. Buttonhole and eyelet not in alignment by:			
	- 1/4 inch to 3/8 inch.		229	
	- more than 3/8 inch.	124		
	2. Inside purled edge of buttonhole eyelet positioned from edge:			
	- less than 1/2 inch but not less than 3/8 inch or more than 3/4 inch but not more than 7/8 inch.			319
	- less than 3/8 inch or more than 7/8 inch.		230	
	- unevenly spaced, definitely affecting appearance (when buttoned).	125		
	3. Second buttonhole from top not in alignment with top edge of pocket flap by:			
	- 1/4 inch to 3/8 inch.			320
	- more than 3/8 inch.		231	
	4. Top buttonhole positioned less than 5/8 inch or more than 7/8 inch from top edge of front step.			321
	5. Lower 4 buttonholes unequally spaced from each other by 3/8 inch or more.		232	
	6. Eyelet not constructed through reinforcement or eyelet reinforcement omitted.		233	

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Examine	Defects	Classification	
		Major	Minor
		A	B
Fronts (cont'd)	d. Darts:		
	1. Inside folded edge of chest dart(s) not turned toward armhole or underarm dart(s) toward back or waist dart(s) toward front.		322
	2. Chest dart(s) not extending to edge of upper flap(s) by more than 3/8 inch.	234	
	e. Pocket and flaps (general):		
	1. Flaps or pockets not of uniform shape, poorly shaped or edges stitched poorly.		
	2. Side edge(s) of pocket exposed beyond end(s) of flap by:		
	- 1/16 inch up to 3/16 inch.	235	
	- 1/4 inch or more	126	
	3. End(s) of flap extending beyond side edge(s) of pocket more than 1/4 inch.	236	
	4. Buttonhole(s) not aligned with point of flap(s) by 1/4 inch or more.	237	
	5. Inside (purled) edge of buttonhole eyelets less than 1/2 inch or more than 3/4 inch from edge of flap.		323
	6. Buttonhole and corresponding button eyelet not aligned so that when buttoned, flap and pocket are distorted, definitely affecting appearance.	238	
	7. Top raw edge of flap(s) not overedge stitched before attachment.		324

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Examine	Defects	Classification	
		Major	Minor
		A	B
Fronts (cont'd)	8. Edge of pocket not securely caught in binding (i.e., binding easily pulled away from fabric).	127	
	9. Length or width of pocket or flap varying from tolerance range in Table III: - 1/8 to 1/4 inch.	128	239
	- more than 1/4 inch.		
	10. Top edge of flap on the one front out of horizontal alignment with flap on other front by: - more than 1/4 inch up to 1/2 inch.	129	240
	- more than 1/2 inch.		
	11. Bottom edge of pocket on one front out of alignment with pocket on other front by: - more than 1/4 inch up to 1/2 inch.		325
	12. Serged edge of upper pocket flap less than 1/4 or more than 1/2 inch above pocket edge or serged edge of lower pocket flap less than 1/2 or more than 3/4 inch above pocket edge.		241
	13. Upper pocket:		
	(a) Box pleat less than 1-3/8 inches or more than 1-5/8 inches wide.		242
	(b) Box pleat not stitched closed.		326
	(c) Edge not parallel with front edge of coat by: - more than 1/4 inch up to 3/8 inch.		243

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Examine	Defects	Classification		
		Major	Minor A B	
Fronts (cont'd)	(c) - more than 3/8 inch.	130		
	(d) Pleat off-center of pocket or visibly crooked.	131		
	(e) Point of flap off-center of pleat by 1/4 inch or more.		244	
	14. Lower pocket:			
	(a) Top ends of bellow improperly sewn to fronts, limiting width of pocket opening.		245	
	(b) Bottom corner seams not pressed open.			327
	(c) Lower edge positioned less than 1 inch or more than 1-1/2 inches from bottom edge of coat.		246	
	(d) Lower edge not parallel with bottom of coat by: - 1/4 inch to 3/8 inch. - more than 3/8 inch.		247	
		132		
	(e) Not parallel with left front edge of coat (when buttoned) by: - 1/4 inch to 3/8 inch. - more than 3/8 inch.		248	
		133		
	(f) Sword slit and tab: 1. Omitted. 2. Ends of opening extending beyond side edges of tab by more than 1/8 inch.		134	328

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Examine	Defects	Classification	
		Major	Minor
		A	B
Fronts (cont'd)	3. Opening less than 1-7/8 inches or more than 2-1/8 inches.	249	
	4. Positioned above top edge of lower pocket flap less than 1 inch or more than 1-1/8 inches.	250	
	5. Ornamental boxstitching around opening omitted.		329
	6. Length of tab, in center, to top selvage edge less than 2-1/4 or more than 2-1/2 inches.		330
Shoulder	a. Back part not lapped on top of fronts.	251	
Shoulder straps (construction and position)	a. Upper side of strap full or twisted affecting appearance.	252	
	b. Poorly shaped.	253	
	c. Misplaced so that when buttoned or button eyelet and buttonhole eyelet are aligned, the strap does not lie flat, i.e., bulges or twists.	254	
	d. Misplaced so that shoulder seam is exposed.	135	
	e. Rounded end less than 1/4 or more than 3/8 inch from undercollar edge.	255	

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Examine	Defects	Classification		
			Major	Minor
			A	B
Shoulder straps (construction and position) (cont'd)	f. Misplaced, i.e., one strap farther forward or back from position of other strap.	136		
	g. Back edge of strap less than 1/4 inch or more than 3/8 inch back of shoulder seam at armhole.			331
	h. Button eyelet not aligned with buttonhole eyelet, causing bulge or twist on strap or puckers on shoulder.		256	
	i. Buttonhole off-center with width of strap by: - more than 1/8 inch but not more than 1/4 inch. - more than 1/4 inch.			332
	j. Buttons not uniformly set from collar edge by: - more than 1/4 inch up to 3/8 inch. - more than 3/8 inch.	137	257 258	
	k. Width of strap at armhole less than 2-1/4 inches or more than 2-1/2 inches, or in line with eyelet end of buttonhole less than 1-3/8 inches or more than 1-5/8 inches.			333
Sleeves and armholes	a. Fullness misplaced or concentrated in one area.	138		
	b. Sleeves tight, not having roll effect at armholes.	139		
	c. Armhole stretched.	140		

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Examine	Defects	Classification	
		Major	Minor
		A	B
Sleeves and armholes (cont'd)	d. Distance between sleeve backarm seam and seam joining center back to side body piece uneven at armhole by 1/4 inch or more.	259	
	e. Cuff hem at bottom of sleeve less than 1-3/8 inches or more than 1-5/8 inches wide.	260	
	f. Top sleeve not lapped on undersleeve in raisestitching of forearm and back arm seams.	261	
	g. Sleeve too far front, i.e., front edge of sleeve more than 1-1/2 inches forward from center of lower pocket flap button.	141	
	h. Sleeve too far back, i.e., front edge of sleeve more than 1-1/2 inches back from center of lower pocket flap button.	142	
	i. Hang of sleeves in opposite directions, i.e., one sleeve in front and other to the back of the center of lower flap button by more than 1-1/2 inches.	262	
	j. Cuffs:		
	1. Poorly shaped or left and right shaped unevenly.	143	
	2. More than 3-1/2 inches or less than 3 inches wide at front and back creases.	263	
	3. More than 6-1/4 inches or less than 5-3/4 inches high at point.	264	

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Examine	Defects	Classification	
		Major	Minor
		A	B
Back	a. Left center back not lapped on top of right center back in raisestitching of center back seam.		334
	b. Right or left center back not lapped on top of side backs in raisestitching.	265	
	c. Right or left side back not lapped on top of front at side seams.	144	
	d. Vent opening:	145	
	- left vent edge stretched, causing vents to spread open.		335
	- row of stitching across top of vent opening stitched for a distance of less than 1-3/8 inches or more than 1-5/8 inches.		
	- left vent edge crooked, affecting appearance.	266	
	- bottom turnup exposed and visible on left vent edge.		336
	- left vent 1/4 inch or more shorter than right vent.	267	
	- left back vent edge overlapping right back vent edge at bottom of coat less than 3-1/4 inches or more than 3-3/4 inches.		337
	- left back vent edge turned under at the bound edge of the bottom turnup less than 1-5/8 inches or more than 1-7/8 inches.		338

4.5.3.2 Detailed defects applicable to specific parts on inside of coat. Detailed defects applicable to specific parts on inside of coat shall be classified as follows:

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Examine	Defects	Classification		
		Major	Minor	
		A	B	
Hanger	a. Ends of loop less than 1-1/4 inches or more than 1-3/4 inches apart.			339
Eyelet reinforcement and front facing	a. Measured along lower edge of collar front eyelet reinforcement or front facing short, tight or twisted (score only if the condition causes excessive fullness on outside of front).	146		
Label	a. Size label:	147	268	
	1. Omitted, incorrect, or illegible.			
	2. Insecurely caught in stitching to back of neck.			340
	3. Off-center by more than 1/2 inch.			
	b. Combination identification-instruction label:	148		
	1. Omitted, incorrect or illegible.			341
	2. Not stitched on one or more sides to right facing.			342
Seam binding	3. Positioned less than 3 inches or more than 5 inches from finished bottom edge of coat.			
	a. Seam edge not securely caught in binding (i.e., binding pulls away from fabric easily).		269	
	b. Binding tight, causing edge or seam to curl and not lie flat, or puckers on outside of coat.		270	
Bottom edge and hem	a. Hem less than 1-3/8 inches or more than 1-5/8 inches wide.			343

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Examine	Defects	Classification	
		Major	Minor
		A	B
Bottom edge and hem (cont'd)	b. Irregular in width, causing irregular bottom edge.		271
	c. Hem twisted, puckered, or pleated (score if definitely affecting outside appearance).		272

4.5.3.3 Finished measurements. Any measurement deviating from the nominal dimensions and tolerance specified in Table II shall be classified as a size measurement defect. Sleeve lengths uneven by 1/2 inch or more shall be classified as a size measurement defect.

4.5.4 Examination of packaging. An examination shall be made to determine compliance with packaging, packing and marking requirements of section 5. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully prepared for delivery with the exception that it need not be sealed. 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.

<u>Examine</u>	<u>Defect</u>
Markings (exterior and interior)	Omitted, incorrect, illegible, of improper size, location, sequence or method of application.
Materials	Any component missing. Any component damaged, affecting serviceability.
Workmanship	Inadequate application of components, such as incomplete closure of case liner, container flaps; loose strapping, and inadequate stapling. Bulging or distortion of containers.
Weight and content (exterior and interior)	Number per container is more or less than required; net weight exceeds requirement.

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5. PACKAGING

5.1 Preservation and packaging. Preservation and packaging shall be in accordance with ASTM D 1351.

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

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 coats described herein are intended for wear by male officers of the United States Marine Corps.

6.2 Ordering data. Procurement documents should specify the following:

- (a) Title, number and date of specification.
- (b) Sizes required (see 1.2).
- (c) Whether first article is required (see 3.2).
- (d) Number of coats in the first article (see 3.2).
- (e) Whether buttons are required (see 3.3.6).

6.3 First article. When a first article is required, it shall be inspected and approved under the appropriate provisions of FAR 52.209 and the requirements of this specification. The sample(s) presented for inspection may be first articles, pre-production samples, first production of sample(s) taken from the first lot depending on the contractor's history and will be as directed by the Contracting Officer. The Contracting Officer should include specific instructions in all acquisition instruments regarding arrangements for selection, inspection, and approval of the first article.

6.4 Standard samples and shade samples. For information regarding the availability of standard samples and standard shades specified, address inquiry to acquiring activity issuing the invitation for bids.

6.5 Acceptance criteria. The acceptance criteria as specified in the contract or purchase order shall be binding.

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6.6 Figures. Figures 1 through 4 show general design of the coats with assembly details and measurements. In the event of conflict between these figures and the text of this specification, the text of this specifications shall govern.

6.7 Subject term (keyword) listing.

Dress
Man's
Officer's
Polyester/Rayon
White

Preparing Activity:
Navy - MC
Project No. 8405-N260

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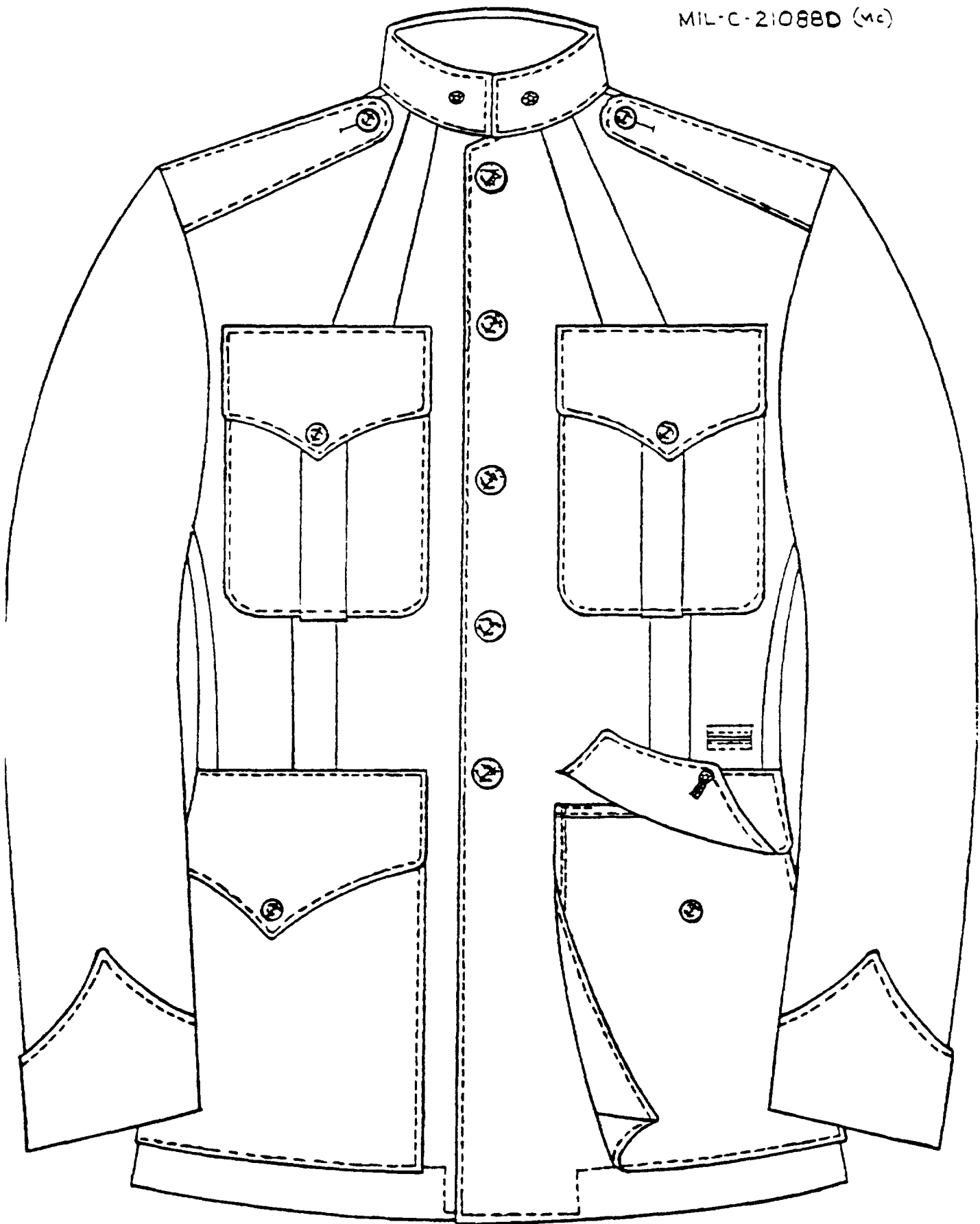


FIGURE 1. COAT, MAN'S: WHITE, DRESS
(OFFICER'S, U.S.M.C.)

10-11-10880-42

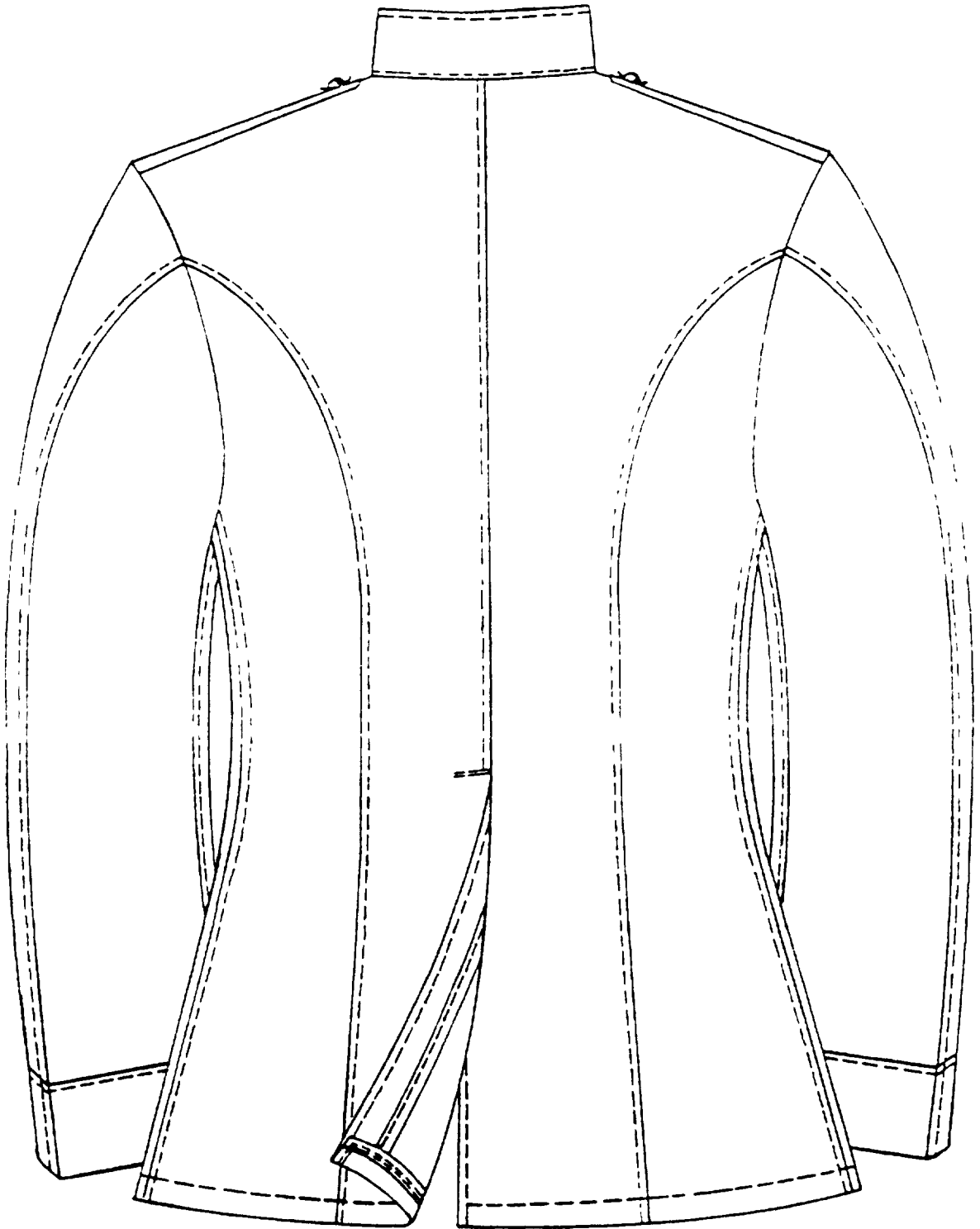


FIGURE 2. COAT, MAN'S: WHITE, DRESS
(OFFICERS, USMC)

MIL-C-210880 (MC)

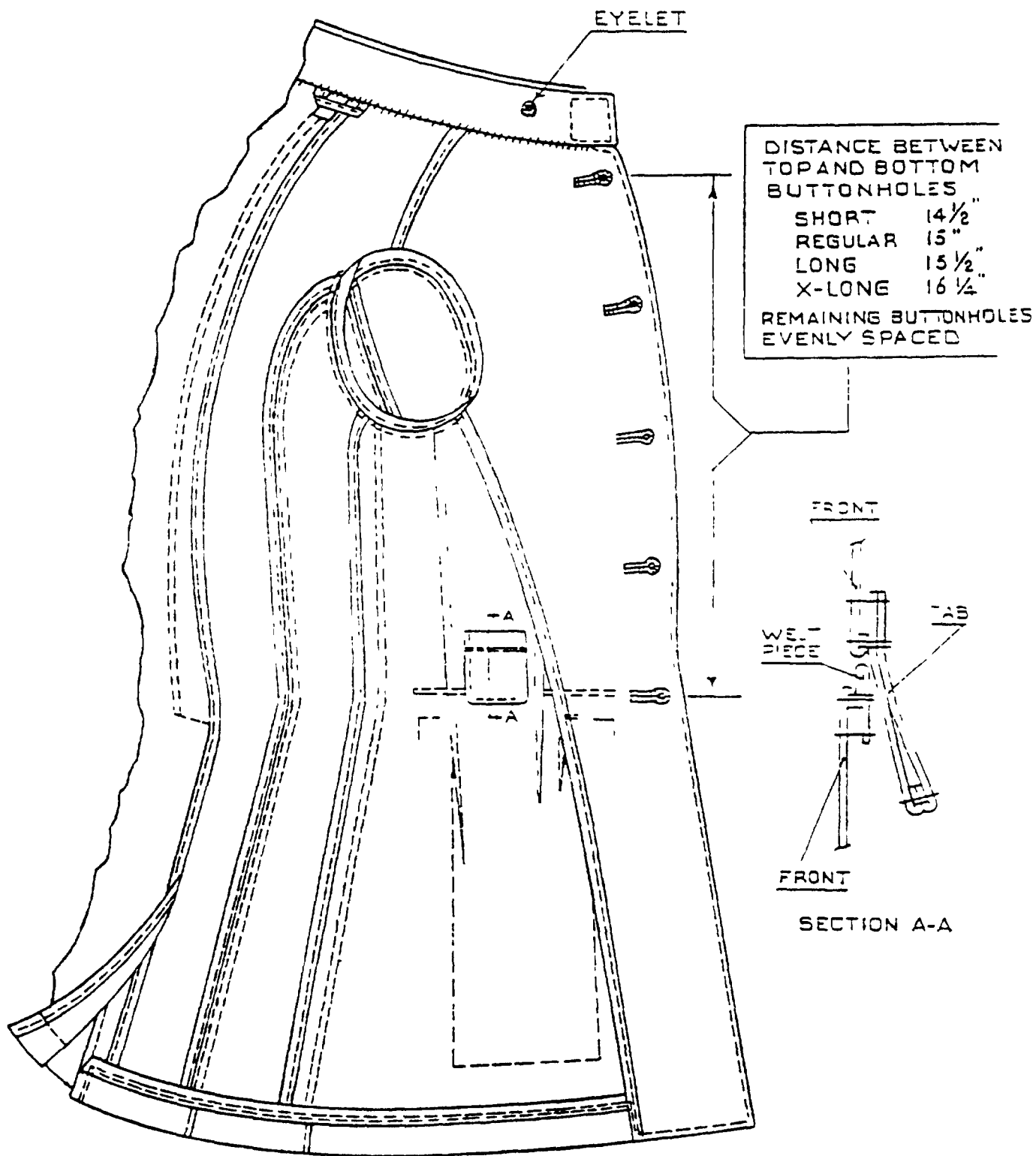


FIGURE 3. COAT, MAN'S WHITE, DRESS
(OFFICERS USMC)

MIL-0-21068D

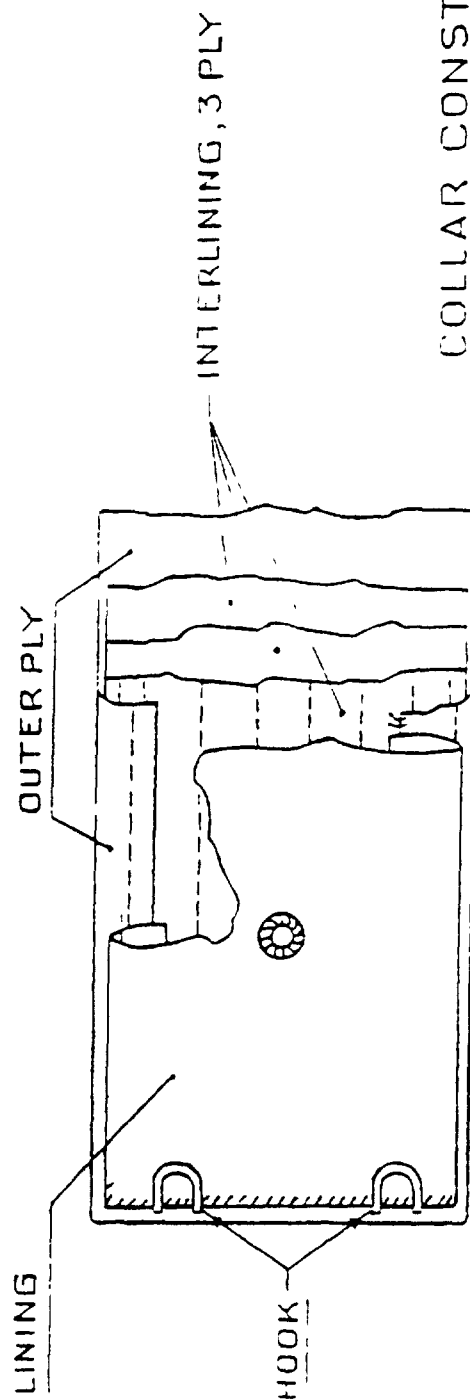
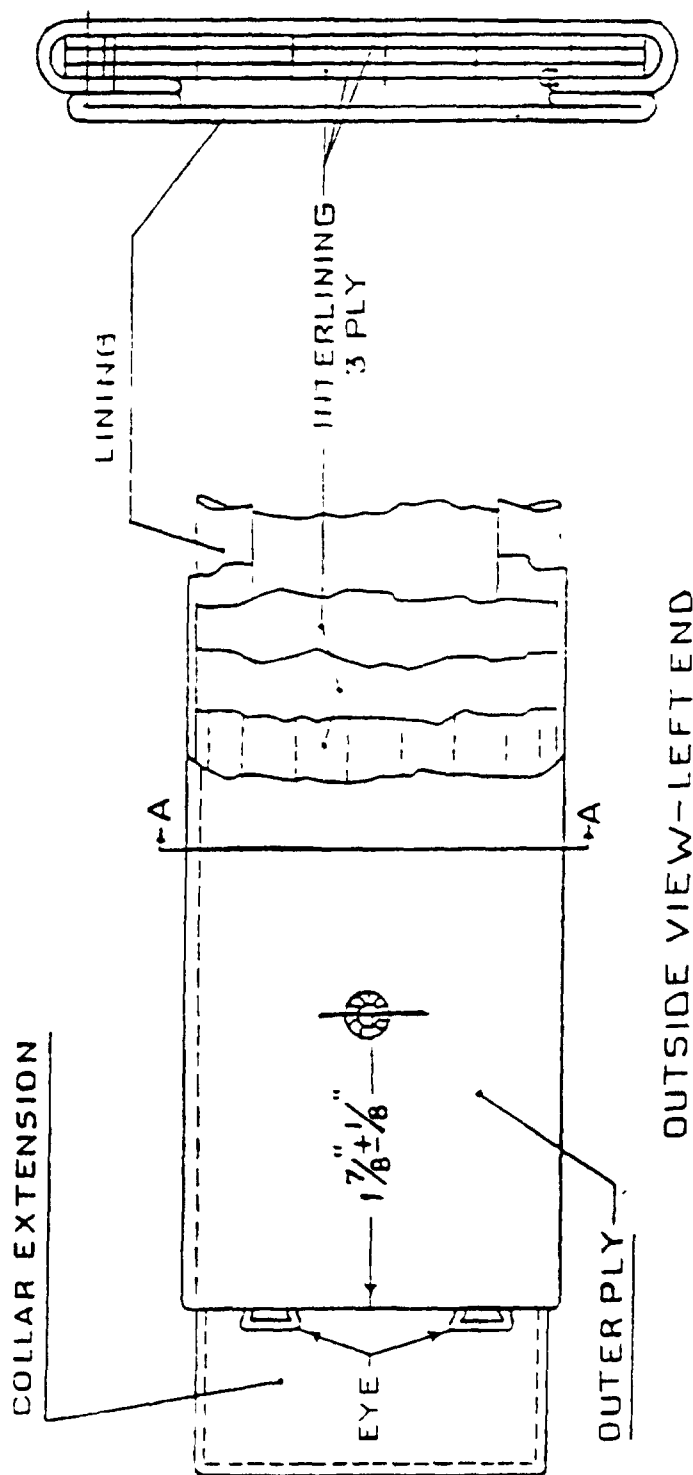


FIGURE 4 COAT, MAN'S: WHITE, PRESS (OFFICER'S U.S.M.C)

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

INSTRUCTIONS

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

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

I RECOMMEND A CHANGE:

1 DOCUMENT NUMBER
MIL-C-21088D(MC)

2 DOCUMENT DATE (YYMMDD)
22 February 1995

I. DOCUMENT TITLE

COAT, MAN'S: WHITE; DRESS (OFFICER'S)

I. NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)

REASON FOR RECOMMENDATION

II. 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)

III. PREPARING ACTIVITY

a. NAME

b. TELEPHONE (include Area Code)
(1) Commercial
(2) AUTOVON
(703) 640-4584 278-4584

COMMENT

ADDRESS (include Zip Code)

PHONE

TELETYPE

IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT
The Standardization Office
1403 Falls Church, VA 2204-3466
AUTOVON 289-3411