

INCH-POUND

MIL-C-2202H
20 March 1990
SUPERSEDING
MIL-C-2202G
2 December 1981

MILITARY SPECIFICATION

COVERALLS, MEN'S, COTTON, SATEEN

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

1. SCOPE

1.1 Scope. This specification covers the requirements for the manufacturing of two types of men's cotton sateen coveralls.

1.2 Classification. The coveralls shall be of the following types and sizes, as specified (see 6.2):

Type I - Olive Green 107

Sizes: Small, Medium, Large,
X-Large, XX-Large

Type II - White

Sizes: XXX-Small, XX-Small, X-Small, Small,
Medium, Large, X-Large, XX-Large

2. APPLICABLE DOCUMENTS

2.1 Government documents.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Officer in Charge, Navy Clothing and Textile Research Facility, 21 Strathmore Road, Natick, MA 01760-2490 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. Approved for public release, distribution is unlimited.

MIL-C-2202H

* 2.1.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents shall be those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

SPECIFICATIONS

FEDERAL

- V-T-276 - Thread, Cotton
- * NN-P-71 - Pallet, Material Handling, Wood, Stringer Construction, 2 Way and 4 Way (Partial)
- DDD-L-20 - Label; For Clothing, Equipage and Tentage (General Use)

MILITARY

- MIL-C-3735 - Cuffs, Knit, Wrist and Ankle, and Cloth, Knitted
- MIL-C-10296 - Cloth, Sateen, Cotton
- * MIL-P-15011 - Pallet, Material Handling, Wood, Post Construction, 4 Way Entry
- MIL-B-17757 - Boxes, Shipping, Fiberboard (Modular Sizes)
- MIL-F-21840 - Fastener Tape, Hook and Loop, Synthetic
- MIL-T-43548 - Thread, Polyester Core: Cotton-, Rayon-, or Polyester Covered
- MIL-T-43566 - Tape, Textile, Cotton, General Purpose, Natural or in Colors

STANDARDS

FEDERAL

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

MILITARY

- * MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
- MIL-STD-129 - Marking for Shipment and Storage
- * MIL-STD-147 - Palletized Unit Loads
- MIL-STD-1668 - Provisions for Evaluating Quality of Cloth Coveralls
- * MIL-STD-2073-1 - DOD Materials Procedures for Development and Application of Packaging Requirements
- * MIL-STD-2073-2 - Packaging Requirement Codes

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

MIL-C-2202H

* 2.1.2 Other Government documents, drawings, and publications. The following other Government documents, drawings, and publications form a part of this document to the extent specified herein. Unless otherwise specified, the issues are those cited in the solicitation.

U.S. POSTAL MANUAL

(Copies of the manual may be obtained from the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402-0001.)

* 2.2 Non-Government publications. The following document(s) form a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DOD adopted shall be those listed in the issue of the DODISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of the documents cited in the solicitation (see 6.2).

NATIONAL MOTOR FREIGHT TRAFFIC ASSOCIATION, INC., AGENT

National Motor Freight Classification

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

UNIFORM CLASSIFICATION COMMITTEE, AGENT

Uniform Freight Classification

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

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

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

3. REQUIREMENTS

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

MIL-C-2202H

3.2 First article. When specified the contractor shall furnish sample unit(s) for first article inspection and approval (see 4.3 and 6.2).

3.3 Material. It is encouraged that recycled material be used when practical as long as it meets the requirements of this document.

3.3.1 Basic material.

3.3.1.1 Type I coverall. The basic material shall be a cotton sateen, dyed Olive Green 107, conforming to class 1 of MIL-C-10296.

3.3.1.2 Type II coverall. The basic material shall be a cotton sateen, bleached white, conforming to class 2 of MIL-C-10296.

3.3.2 Cuffs, wrist and ankle (Type II coverall). The cuffs shall be aramid, natural shade or white, conforming to type IV, class 1, size 1 for ankle cuffs and type IV, class 2, size 2 for the wrist cuffs of MIL-C-3735.

3.3.3 Thread.

3.3.3.1 Thread, polyester, cotton-covered. The thread for seaming and stitching shall be a polyester core, cotton-covered or rayon-covered thread conforming to ticket No. 30 and 50, 2 or 3 ply of MIL-T-43548. The color of the thread shall approximate the color of the basic material of the appropriate type coverall. The use of polyester-covered polyester core thread is not allowed.

3.3.3.1.1 Colorfastness. The dyed thread shall show colorfastness to laundering and light equal to or better than the standard sample when tested as specified in MIL-T-43548. As a limit of acceptability, or when no standard is available, the dyed thread shall show a minimum of "good" colorfastness to laundering and light when tested as specified in MIL-T-43548.

3.3.3.2 Thread, cotton. As an alternate, a cotton thread, conforming to V-T-276, may be used for stitching and seaming. The color of the thread shall approximate the color of the basic material of the appropriate type coverall. The types and sizes of the thread shall be as follows:

<u>Coverall</u>	<u>Use</u>	<u>Type</u>	<u>Ticket No.</u>	<u>Ply</u>
Type I	Seaming	IA3	30, 50	3
Type II	Seaming	IA2	30, 50	3

3.3.3.2.1 Colorfastness. The dyed thread shall show colorfastness to laundering and light equal to or better than the standard sample when tested as specified in V-T-276. As a limit of acceptability, or when no standard sample is available, the dyed thread shall show a minimum of "good" colorfastness to laundering and light when tested as specified in V-T-276.

* 3.3.4 Label. Each coverall shall have a combination identification/size/instruction label conforming to type VI, class 14 of DDD-L-20. Label inscription shall show fastness to laundering. Inscription of label shall be as specified below:

MIL-C-2202H

Name of Item: Coveralls, Men's, Cotton, Sateen, Type I (Example)
Fiber Content: 100% Cotton
Contract No: DLA-100-00-0-0000 (Example)
Stock No: 8405-00-000-0000 (Example)
Size: Medium (Example)
Name of Contractor:
Name of Manufacturer: (If other than contractor)

Laundrying Instructions

FASTEN ALL FASTENER TAPES BEFORE LAUNDERING

Hand or Machine Wash, Hot
Tumble Dry, Medium

OR

Use NAVEDTRA 414-01-45-81, Formula II:
Hot Formula without Bleach (140°F)

3.3.5 Tape, cotton. The cotton tape used as an alternate for the waist and leg tabs on the type I coverall shall be 1-1/4 inch in width, dyed Olive Green 107, conforming to type I, class 3 of MIL-T-43566, except that colorfastness to crocking and weathering are not required.

3.3.6 Tape, fastener. The fastener tape for the coverall shall conform to type II, class 1 of MIL-F-21840. The width of both the hook and loop portions of the tape shall be 1 inch wide. The color shall approximate the shade of the basic material (see 3.3.1.1 and 3.3.1.2).

* 3.4 Design. The type I coverall shall be one piece, with a protective hook and loop fastener flap type front closure, shirt style collar, one breast patch pocket with flap, two front patch pockets, one hip pocket, one rule pocket, a pass thru pocket, adjustment tabs on sleeves and adjustment straps on waist and legs (see Figure 1). The type II coverall shall be one piece with a hook and loop fastener type front fly closure and knitted wristlets and cuffs. The type II coverall shall be pocketless (see Figure 2).

3.4.1 Figures. The figures are furnished for information purposes only. When any inconsistencies between the written specification and the figures exist, the written specification shall govern.

* 3.5 Patterns. Standard patterns to be used to cut working patterns will be furnished by the Government (see 6.3). The working patterns shall be identical to the Government patterns. Neither the Government patterns nor the working patterns shall be altered in any way, except that additional notches for use during construction are permitted on the working patterns. Minor modifications are permitted where necessary when using automatic equipment. These modifications shall not alter the appearance, serviceability, or dimensional requirements cited in the specification. Unless otherwise specified in Table I seam allowances shall be as follows:

All double needle joining seams - 1/2 inch
Facings to fronts - 1/4 inch
All other seams - 3/8 inch

MIL-C-2202H

* 3.5.1 List of pattern parts. The component parts of the coveralls shall be cut from the basic material in accordance with the pattern parts indicated below:

Material	Pattern Parts	Cut Parts
Shirt (Type I)	Back (one piece)	1
	or	
	Back (two pieces)	2
	Front	2
	Collar (top and under)	2 <u>1/</u>
	Topsleeve	2
	Undersleeve	2
	or	
	Sleeve (one piece)	2
	Protective flap	1
	Lapel facing	2
	Breast pocket	1
	Breast pocket flap	2
Trousers (Type I)	Back	2
	Front	2
	Front pocket	2
	Hip pocket	1
	Rule pocket	1
	Leg and waist tabs	4 <u>2/</u>
	Pass-thru flap	2
	Welt	2
Shirt (Type II)	Back (one piece)	1
	or	
	Back (two pieces)	2
	Front	2
	Collar (top and under)	2 <u>1/</u>
	Topsleeve	2
	Undersleeve	2
	or	
	Sleeve (one piece)	2
	Front facings	2
Trousers (Type II)	Back	2
	Front	2
Templates (Type I)	Finished breast pocket	
	Finished breast pocket flap	
	Right front inside fastener location marker	
	Front fastener tape location marker	
	Leg tab location marker (front and back)	

1/ Pattern may be cut in one piece, see operation 5e.

2/ A cotton tape may be used as an alternate, see operation 15e.

MIL-C-2202H

3.6 Construction.

3.6.1 Stitch, seam and stitching types. Stitch, seam and stitching types specified in Table I shall conform to FED-STD-751. Wherever two or more methods for seam or stitch types are given for the same part of the operation, any one may be used. Where stitch type 401 is used, the looper (underthread) shall be on the inside of the coveralls. Seam allowances shall be maintained with seams sewn so that no raw edges, runoffs, twists, pleats, or open seams will result. Unless otherwise specified, top or edge stitching shall be 1/16 to 1/8 inch from edge, hook and loop fastener tape stitching shall be 1/16 to 1/8 inch from edge of tape, and all double needle stitching shall be 1/4 inch gauge with the row of stitching next to the folded edge not more than 1/16 to 1/8 inch from edge. Where 515, 516 or 519 are specified, the cover thread shall be the same type as the looper thread, the lock or chainstitch portion shall be 3/8 inch from the raw edge and the bight of the overedge stitch portion shall be 3/16 to 1/4 inch.

3.6.2 Stitches per inch. The minimum and maximum number of stitches per inch shall be as specified in Table I.

3.6.3 Thread breaks and ends of seams. Ends of all seams and stitchings when not caught in other seams or stitching shall be backtacked not less than 3/8 inch. The ends of a continuous line of stitching shall be overlapped not less than 1/2 inch. Thread breaks (all stitch types) shall be repaired by stitching not less than 1/2 inch beyond each end of the break. Skipped stitches or 401 stitch type thread breaks may be repaired by using 301 stitch type.

3.7 Manufacturing operations requirements. The coveralls shall be manufactured in accordance with the operation requirements specified in Table I. The contractor is not required to follow the exact sequence of operations. 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.

3.7.1 Shade and size marking. The component parts shall be marked, ticketed, or bundled to insure a uniform shade and size throughout the coverall. Any method of shade and size marking may be used except:

1. Corrosive metal devices.
2. Sew-on shade tickets.
3. Adhesive type tickets whose adhesive causes discoloration or whose adhesive mass adheres to the material upon removal of the tickets.

MIL-C-2202H

* 3.7.2 Abbreviations in table of operations. The abbreviations used in Table I are as follows:

Stch	-	Stitch
in	-	inch
Ndl	-	Needle
Bob	-	Bobbin
Lpr	-	Looper
Mchne	-	Machine
Brck	-	Bartack
Comrc1	-	Commercial
smlr	-	similar
Btnhl	-	Buttonhole
incl	-	including
dbl	-	double
chnstch	-	chainstitch

MIL-C-2202H

TABLE I - CONSTRUCTION OF COVERALLS

No.	Operation	Stch	Seam/	Stch	Thread	
		Type	Stch type	in	Ndl	Bob/ Lpr
1.	<u>Cut coveralls.</u>					
	a. Cut material face to face, that is, the face of one ply of material shall be over and against the face of the next ply below. The filling side shall be considered the face of the material and finish on the outside of the coverall.					
	b. Cut the coveralls in strict accordance with patterns furnished which show size, directional lines, shape and placement of pockets, also notches for the proper assembling of all parts. Directional lines shall be placed in the warp direction of the material. The directional lines on the fronts and backs of trouser parts may vary from the warp direction by not more than 1-1/2 inch. Measurements shall be taken from the top and bottom of the directional line on pattern to selvage edge of the fabric and the difference between the two measurements shall not exceed 1-1/2 inch.					
	c. Cut the topcollar across the width of the material. The undercollar may be cut on the straight or across the width of the material.					
	d. Cut all component parts of the garment from one piece of material except the hanger, welt pattern, pass thru flap, waist tabs, leg tabs, undercollar, and protective flap which may be cut from ends. Parts cut from ends shall approximate the shade of the garment.					
2.	<u>Replacement of defective components.</u>					
	During the spreading, cutting and manufacturing process, components having material defects or damages that are classified as defects in MIL-STD-1668 shall be removed from production and replaced with non-defective and properly matched components.					
3.	<u>Shade and size marking. (see 3.7.1)</u>					
	a. All parts shall be marked, ticketed or bundled to insure a uniform shade, size and proper assembly throughout the garment, except those parts cut from ends which shall approximate the shade of the material.					

MIL-C-2202H

TABLE I - CONSTRUCTION OF COVERALLS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
	b. The use of ink pad numbering machine, rubber stamp or pencil is acceptable provided the numbers do not show through the outside of the coveralls. Wherever possible, numbers shall be covered by the seam allowance.					
4.	<u>Attach label (Type I and II).</u>					
	a. Center combination identification/size/instruction label on the inside of the back with the top edge of label parallel to and 1/4 to 1/2 inch below top raw edge of back. Stitch all four sides of label. Stitching shall not be through the printing.	301	LSbj-1	10-14	30	30
	OR					
	b. Label may be positioned by stitching both sides and bottom edge so that the top of label will be caught in the collar joining seam (see operation 25).					
5.	<u>Make collar (Type I and II).</u>					
	a. Seam topcollar to undercollar along outer edge and around ends.	301 or 401	SSa-1	10-14	30	30 50
	b. Turn collar, work out points, and double stitch 1/4 inch gage.	301	SSe-3(b)	10-14	30	30
	OR					
	c. Turn collar, work out points, and single stitch 3/16 to 1/4 inch from edge.	301	SSe-2(b)	10-14	30	30
	OR					
	d. Fold collar edges on a creasing machine and double stitch 1/4 inch gage or single stitch 1/16 to 1/8 inch from edge.	301	SSc-2 or SSc-1	10-14	30	30
	e. When collar is cut in one piece, fold collar in half lengthwise and stitch ends. Trim corners, turn collar, work out points, and double stitch outer edge and ends 1/4 inch gage or single stitch 3/16 to 1/4 inch from edge.	301	SSe-2(b) and OSf-1 or 2	10-14	30	30

MIL-C-2202H

TABLE I - CONSTRUCTION OF COVERALLS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
6.	<u>Make pockets (Type I only).</u>					
	a. Hem the diagonal edge of the front trouser pockets, hip pocket, and rule pocket with the raw edge turned in and single stitch 1/16 to 1/8 inch from folded inner edge. Hem shall finish 3/8 to 1/2 inch wide.	301 or 401	EFb-1	10-14	30	30 50
*7.	<u>Attach loop fastener tape and make flap for breast pocket (Type I only).</u>					
	a. Position loop fastener tape to underside of pocket flap. The edge of the tape shall be 3/4 (+ 1/8) inch from outer raw edges. Stitch top, bottom, and sides of loop fastener tape. The tape shall be 4 inches long.	301	LSbj-1	8-12	30	30
	b. Position plies of flap face to face and stitch 3/8 inch from the sides and outer raw edges. Turn to finished position.	301 or 401	SSe-3(a)	8-12	30	30 50
	c. Double stitch sides and outer edges of flap.	301	SSe-3(b)	8-12	30	30
	NOTE: The loop fastener tape shall not be caught in inner row of double stitching.					
*8.	<u>Attach hook fastener tape to breast pocket (Type I only).</u>					
	a. Fold hem over according to marks on patterns and stitch lower folded edge. Hem shall finish 1 to 1-1/4 inch wide.	301	EFb-1	8-12	30	30
	b. Place hook fastener tape even with top folded edge of hem on breast pocket and centered on hem as not to be caught by inner row of double stitching, according to marks on pattern. The tape shall be 4 inches long.					
	c. Stitch hook fastener tape along both sides and top and bottom edges.	301	LSbj-1	8-12	30	30
*9.	<u>Attach breast pocket to front (Type I only).</u>					
	a. Position pocket on upper left front according to marks on patterns. Fold under the sides and bottom edges of pocket 3/8 inch and double stitch 1/4 inch gauge with the outer row of stitching 1/16 inch from the folded edges.	301 or 401	LSd-2	8-12	30	30

MIL-C-2202H

TABLE I - CONSTRUCTION OF COVERALLS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
	b. Place two vertical 3/8 (+ 1/16) inch bartacks, superimposed on the inner row of stitching at the top of pockets.	Brck		28 per brck	30	30
*10.	<u>Attach breast pocket flap to front (Type I only).</u>					
	NOTE: The distance between the finished pocket and finished flap (top of pocket and lower row of flap stitching) shall be 1/2 (+1/8) inch.					
	a. Clip notch of pencil pocket opening, turn opening in and stitch 1/4 inch gauge, from notch on pattern across pencil pocket opening to shorter end of flap, with the outer row of stitching 1/16 to 1/8 inch from the folded edge at pencil pocket opening.	301	SSc-2 and SSa-2	8-12	30	30
	b. Position flap on upper left front as indicated by marks on pattern, and stitch from notch ends of pencil pocket opening to both ends of flap, 1/4 inch from raw edge. The distance between top of pocket and flap edge shall be 3/4 (+ 1/16) inch. The flap shall be centered over the pocket.	301	Similar to LSs-2(a)	8-12	30	30
	c. Turn flap down and topstitch from pencil pocket to long end of flap, 1/16 to 1/8 inch from folded edge using a double stitch with a 1/4 inch gauge, leaving pencil pocket opening free. The loop of the fastener tape shall match the hook portion on the pocket.	301	Similar to LSs-2(a)	8-12	30	30
	d. Place two vertical 3/8 (+ 1/16) inch bartacks, superimposed on the inner row of stitching at the top of the flap. Place a vertical bartack on each side of the pencil pocket opening.	Brck		28 per brck	30	30
	e. Pencil pocket opening shall measure 1-1/8 to 1-1/4 inches wide.					
	NOTE: The pencil pocket opening shall be positioned at the end of flap closest to protective flap.					

MIL-C-2202H

TABLE I - CONSTRUCTION OF COVERALLS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread Ndl	Bob/ Lpr
*11.	<u>Make pass-thru opening (Type I only).</u>					
	a. Fold pass-thru flap lengthwise and stitch ends 1/4 inch. Turn points and topstitch 1/4 inch from the three folded edges.	301	SSe-2(a) & (b)	10-14	30	30
	b. Stitch 1 inch long hook fastener tape to flap according to pattern marks. Stitch tape on all four sides through all plies.	301	LSbj-1	10-14	30	30
	c. Place pass-thru flap face to face with raw edge on marked welt line of trouser.					
	d. Overedge ends of welt.	502 503 or 504	EFd-1	10-14	50	50
	e. Place welt face to face on top of pass-thru flap according to pattern marks.					
	f. Stitch box for welt opening 1/8 inch from marked line through all plies.	301	LSbj-2	10-14	30	30
	g. Cut center line and tongue notch ends of stitch box. Turn to wrong side and top stitch flap joining seam 1/16 inch from folded edge.	301	SSe-2(b)	10-14	30	30
	h. Turn raw edge of welt furthest from side seam under 1/4 inch forming a hidden pleat and stitch 1/16 inch from edge.	301	LSb-1	10-14	30	30
	i. Position and stitch 1 inch long loop fastener tape through all plies according to pattern marks on trouser. Stitch tape on all four sides.	301	LSbj-1	10-14	30	30
	NOTE: Take caution not to close opening.					
*12.	<u>Sew on front trouser pockets (Type I only).</u>					
	NOTE: Stitch side furthest from side seam, and bottom of pocket first.					
	a. Turn in raw edge of front trouser pockets along front and bottom edges 3/8 inch and double stitch to fronts, 1/4 inch gage, as indicated by marks on patterns.	301	LSd-2	10-14	30	30

OR

MIL-C-2202H

TABLE I - CONSTRUCTION OF COVERALLS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
	b. Turn in the raw edges of pockets and single stitch 1/16 to 1/8 inch from edge.	301	LSd-1	10-14	30	30
	NOTE: Pocket edges closest to side seam should cover pass-thru opening and care shall be taken not to close pocket when stitching.					
	c. Complete side of pocket closest to side seam by stitching through all plies, up 1 inch at bottom and down 1-3/4 inch at top leaving a 7 inch pass thru opening.	301	LSd-2	8-12	30	30
	d. Fold under the remainder of the side nearest pass thru opening 3/8 inch and double stitch 1/4 inch gauge with outer edge 1/16 inch from folded edge, thru pocket and trouser front.	301	LSd-2	8-12	30	30
13.	<u>Rule pocket (Type I only).</u>					
	a. Turn in the raw edges of pocket 3/8 inch and double stitch the back and bottom edges to the right back. The front edge shall be seamed in with the right outseam of trousers and the top inserted under hip pocket.	301	LSd-2	10-14	30	30
	OR					
	b. Turn in the raw edges of the pocket and single stitch 1/16 to 1/8 inch from edge.	301	LSd-1	10-14	30	30
	c. The front edge (toward outseam) of the rule pocket may be stitched to side seam allowance prior to outseam joining.	301	SSa-1	10-14	30	30
14.	<u>Sew on hip pocket (Type I only).</u>					
	a. Turn in the raw edges 3/8 inch and double stitch hip pocket on right side, as indicated on patterns, 1/4 inch gage.	301	LSd-2	10-14	30	30
	OR					
	b. Turn in the raw edges of the pocket and single stitch 1/16 to 1/8 inch from edge.	301	LSd-1	10-14	30	30

MIL-C-2202H

TABLE I - CONSTRUCTION OF COVERALLS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
*15.	<u>Make leg and waist tabs (Type I only).</u>					
	a. Tabs shall finish 1-1/4 (+ 1/16) inches wide and 5 (+ 1/8) inches long.					
	b. Fold tabs made of basic material in half lengthwise face to face and stitch 1/4 inch from raw edges on one end and length of tab. Turn to finished position.	301	SSe-3(a)	10-14	30	30
	c. Double stitch, 1/4 inch gage around two sides and one end and leaving the raw end to be caught or covered in the attachment operation.	301	SSe-3(b)and OSf-2	10-14	30	30
	OR					
	d. Single stitch 1/16 to 1/8 inch from edge around two sides and one end leaving the raw end to be caught or covered in the attachment operation.	301	SSe-2(b)and OSf-1	10-14	30	30
	e. As an alternate, turn one edge of 1-1/4 inch tape 1/4 to 3/8 inch and single stitch 1/16 inch from folded edge, leaving one end with a raw edge to be caught or covered in the attachment operation.	301	EFb-1	10-14	30	30
	f. Place 2 inch long hook fastener tape 3/8 inch from folded end of tabs, centered lengthwise. Stitch tape on all four sides.	301	LSbj-1	10-14	30	30
16.	<u>Make sleeves (Type I and II).</u>					
	a. Join top and undersleeve with a double lapped and double stitched seam, 1/4 inch gage with the top over the undersleeve. (Applicable only when the sleeve is made from two pieces of material.)	301 or 401	LSc-2	10-14	30 30	30 50
	(Type I only).					
	*b. Stitch 1 inch long hook and 2 inch long loop tapes on all four sides according to marks on patterns.	301	LSbj-1	10-14	30	30
17.	<u>Make hanger (Type I and II).</u>					
	a. Make hanger from the basic material. The hanger shall measure 1/4 to 1/2 inch wide and 3-3/8 to 3-5/8 inches long when finished. The hanger shall be double stitched 1/8 to 1/4 inch using a covering stitch on the underside.	406	EFh-1	10-14	30	30

OR

MIL-C-2202H

TABLE I - CONSTRUCTION OF COVERALLS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
	b. Fold hanger stripping in half with the raw edges turned in and stitch 1/16 to 1/8 inch from each edge.	301	EFp-2	10-14	30	30
18.	<u>Make flap (Type I and II).</u>					
	a. Fold the protective flap in half lengthwise, face to face, and single stitch top and bottom edges 3/8 inch, turn, force out edges, and single stitch 1/16 to 1/8 inch from folded edges.	301 or 401 and 301	SSe-2(a) SSe-2(a) SSe-2(b)	10-14 10-14 10-14	30 30 30	30 50 30
	OR					
	b. Turn in raw edges at the top and bottom of flap and single stitch 1/16 to 1/8 inch from folded edge.	301	SSc-1	10-14	30	30
	*c. Place 2 inch long hook fastener tapes to flap according to marks on patterns. Stitch tapes on all four sides.	301	LSbj-1	10-14	30	30
*19.	<u>Make lapels (Type I and II).</u>					
	a. Seam on lapel facings face to face to fronts stitching front edges and lapel steps. Turn and topstitch 3/16 to 1/4 inch from folded edge.	301	SSe-2(a) and SSe-2(b)	10-14	30	30
20.	<u>Make backs.</u>					
	(Type I)					
	a. On outside of coverall fold 4 pleats at bottom of back, as indicated on patterns, and topstitch 1/16 to 1/8 inch from folded edge with vertical row of stitching extending 1-3/4 to 2-1/4 inches from bottom raw edge. Pleats shall be folded towards the side seams.	301	0Se-1	10-14	30	30
	OR					
	b. Form pleats at bottom of back, as indicated on patterns, with pleats folded toward respective side seams. Staystitch across bottom of pleat 1/4 inch from bottom raw edge.	301	SSa-1	10-14	30	30

MIL-C-2202H

TABLE I - CONSTRUCTION OF COVERALLS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
	(Type II) c. On inside of coverall fold 2 darts at bottom of back, as indicated on patterns, and stitch a vertical row of stitching extending approximately 6-1/2 to 7 inches from bottom raw edge. Darts shall be folded towards the side seams.	301	OSf-1	10-14	30	30
	(Type I and II) d. Two (2) piece back construction is permitted. When used, join right and left backs with a double lapped and double stitched seam, 1/4 inch. The right shall be lapped over the left back.	301 or 401	LSc-2	10-14	30	30 50
21.	<u>Join seat seam (Type I and II).</u> Join seat seam with a double lapped and double stitched seam 1/4 inch gage, with the right over left back.	301 or 401	LSc-2	10-14	30	30 50
22.	<u>Join shirt part to trousers (Type I and II).</u> Join shirt to trousers with a double lapped and double stitched seam, 1/4 inch gage, with waist seam lapping in either direction.	301 or 401	LSc-2	10-14	30	30 50
*23.	<u>Finish fronts of shirt.</u> (Type I) a. Turn in bottom edges of lapels 3/8 inch.					
	b. Turn right and left facing raw edges in 3/8 inch and single stitch 1/16 to 1/8 inch from turned edge, catching the protective flap piece under the stitching in-between the left front and left lapel facing. Position protective flap piece at waist as indicated by marks on patterns.	301	EFa-1	10-14	30	30
	c. Single stitch 1/16 inch from front folded edge of lapel facings and front facings continuing stitching to bottom of opening. Stitch 1-1/16 inch across folded edge at bottom of lapel facing.	301	EFa-1	10-14	30	30
	d. Turn in back edge of right facing 3/8 inch and single stitch 1/16 to 1/8 inch from edge. Stitch 1-1/16 inch across folded edge at bottom of lapel facing.	301	LSb-1	10-14	30	30

MIL-C-2202H

TABLE I - CONSTRUCTION OF COVERALLS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
	e. Protective flap shall finish approximately 8 inches wide at top and shall taper to approximately 2-1/2 inches wide at the bottom fly piece.					
	f. Place 2 inch long hook fastener tapes to right side opening according to marks on template. Stitch all four sides of tape.	301	LSbj-1	10-14	30	30
	g. Place 2 inch long loop fastener tapes to left side opening according to marks on template. Stitch tape on all four sides.	301	LSbj-1	10-14	30	30
	(Type II only)					
	h. Overedge stitch at back and bottom edges of facings. Fold right facing under with the bottom of the fold according to marks on patterns, increasing the width of the fold to match the width of the front facing at waistband seam. Fold the left facing according to marks on patterns.	502 or 503 or 504	SSa-1	10-14	50	50
	i. Stitch back edge of facings to fronts, 1/4 to 5/16 inch from the overedge stitched edge.	301	SSa-1	10-14	30	30
24.	<u>Join shoulder seams (Type I and II).</u> Join shoulder seams with a double lapped and double stitched seam, 1/4 inch gage, with the backs on top of front, catching the end of the lapel facing in the stitching.	301 or 401	LSc-2	10-14	30	30 50
25.	<u>Sew on collar and attach hanger.</u> (Type I and II)					
	a. Seam undercollar to shirt.	301	SSa-1	10-14	30	30
	b. Turn in the lower edge of top collar and double stitch collar to shirt 1/4 inch gage, simultaneously catching ends of hanger and top edge of label in the seaming at center of collar if label is not stitched on all four sides.	301	LSb-2	10-14	30	30

OR

MIL-C-2202H

TABLE I - CONSTRUCTION OF COVERALLS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
	c. Turn in edge of topcollar and single stitch collar to shirt 1/16 to 1/8 inch from edge, simultaneously catching ends of hanger and top edge of label in the seaming at center of collar if label is not stitched on all four sides.	301	LSb-1	10-14	30	30
26.	<u>Set sleeves (Type I and II).</u> Sew in sleeves with a double lapped and double stitched seam, 1/4 inch gage, with front and back over sleeve.	301 or 401	LSc-2	10-14	30	30 50
27.	<u>Join outseams (Type I and II).</u> Join the outseams of the sleeves, shirt, and trousers with a double lapped and double stitched seam, 1/4 inch gage, with the front over the back. For Type I, catch welt piece in the outseams and the rule pocket in the right outseam.	301 or 401	LSc-2	10-14	30	30 50
28.	<u>Hem sleeves (Type I only).</u> Turn up bottom of sleeve with the raw edge turned in 3/8 inch and single stitch 1/16 to 1/8 inch from fold of turned under edge. Finished hem shall measure 1/2 (+1/8) inch wide.	301	EFb-1	10-14	30	30
29.	<u>Join knitted wristlet to sleeve (Type II only).</u> a. Wristlet shall be a double thickness of ribbed knit aramid cloth.					
	b. Join sleeve bottom and knit wristlet together by seaming and overedging raw edges in one operation.	515 or 516 or 519	SSa-2	8-10	30	50 (chain- stitch) 50 50 (over- edge)
*30.	<u>Join crotch seam (Type I and II).</u> a. Turn crotch seam of the right front to the outside 3/8 inch to nothing at end of slash, and single stitch 1/16 to 1/8 inch from edge.	301	EFa-1	10-14	30	30

MIL-C-2202H

TABLE I - CONSTRUCTION OF COVERALLS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
	b. Turn edge of left front crotch seam to the inside 1/4 inch and double stitch, catching the right front crotch seam with both rows of stitching (not exposing right front seam raw edges), continue the double row of stitching across bottom of left facing catching the right facing and the bottom of flap piece in both rows of stitching. The bottom of the right facing on Type I coverall shall not be exposed beyond finished bottom edge of protective flap.	301	LSb-2	10-14	30	30
*31.	<u>Join inseams.</u> (Type I and II) Join inseams, fronts over the backs, with a double lapped and double stitched seam, 1/4 inch gage.	301 or 401	LSc-2	10-14	30	30 50
*32.	<u>Attach leg tabs (Type I only).</u> NOTE: Position marker bottom with raw edge of leg bottom.					
	a. Stitch all four sides of 2 inch long loop fastener tapes to legs according to marker.	301	LSbj-1	10-14	30	30
	b. Fold under tab 1/2 inch and boxstitch end of leg tabs according to marker. The finished leg tab shall measure 1-1/4 (+ 1/16) inch wide and 5 (+ 1/8) inch long.	Box criss- cross stch	LSd-1	10-14	30	30
*33.	<u>Hem bottoms of trousers (Type I only).</u> Turn up bottom of trousers with the raw edge turned in 3/8 inch and single stitch 1/16 to 1/8 inch from fold of turned under edge. Finished hem shall measure 1/2 (+1/8) inch wide.	301	EFb-1	10-14	30	30
*34.	<u>Set waist tabs (Type I only).</u> a. Turn under raw edge of waist adjustment tab 1/2 inch. Place turned edge 2 inches back from side seam over waist seam.					
	b. Box stitch folded end of waist adjustment tab, or raw edge end of alternate tape. Box pattern shall measure 3/8 to 1/2 inch wide with outside rows of stitching 1/16 to 1/8 inch from edge.	301	LSd-1	10-14	30	30

MIL-C-2202H

TABLE I - CONSTRUCTION OF COVERALLS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
	c. Place 4 inch long loop fastener tape 1 inch forward of side seam, centered over waist seam and stitch all four sides of tape 1/16 inch from edges.	301	LSbj-1	10-14	30	30
35.	<u>Join knitted anklet to trouser (Type II only).</u>					
	a. Anklet shall be a double thickness of ribbed knit aramid cloth.					
	b. Join leg bottom and ribbed knit anklet together by seaming and overedging raw edges in one operation.	515 or 516 or 519	SSa-2	8-10	30	50 (chain- stitch) 50 50 (overedge)
36.	<u>Make bartacks.</u>					
	a. Bartacks shall be 1/2 to 5/8 inch in length. Unless otherwise specified, vertical bartacks shall be in line with single stitching, or when double stitched in line with inner row of stitching.					
	(Type I)					
	b. Bartack (vertical) the top corners of front trouser pockets.	Bartack		24-28 per bartack	30	30
	*c. Bartack (vertical) the top corners of left breast pocket.	Bartack		24-28 per bartack	30	30
	d. Bartack (vertical) the top corners of hip pocket.	Bartack		24-28 per bartack	30	30
	e. Bartack both corners of rule pocket opening with top bartack (horizontal) through hip pocket, and lower bartack (vertical) at outseams in line with row of stitching on outseam next to the pocket.	Bartack		24-28 per bartack	30	30

MIL-C-2202H

TABLE I - CONSTRUCTION OF COVERALLS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
	(Type I and II) f. Bartack (horizontal) base of front closure 1/16 to 1/8 inch in from folded front edge on upper row of horizontal stitching.	Bartack		24-28 per bartack	30	30
	(Type I) *g. Place two vertical 3/8 inch bartacks, superimposed on the inner row of stitching at the top of the pocket flap. Place a vertical bartack on each side of the pencil pocket opening.	Bartack		24-28 per bartack	30	30
	(Type I) *h. Place two horizontal bartacks at end of the pass-thru opening making sure to catch flap underneath.	Bartack		24-28 per bartack	30	30
	(Type I) *i. Bartack diagonally across joint of lapel and collar.	Bartack		24-28 per bartack	30	30
*37.	<u>Attach fastener tapes to front (Type II only).</u>					
a.	Attach the loop portion of the fastener tape to the left front opening. Position the top of the strip of tape on left front facing according to mark on pattern, with the outer edge of tape 3/8 inch from facing seam. The bottom edge of tape shall finish 1 inch above the end of the fly opening. Stitch all four sides of the tape 1/8 inch from edge through all plies.	301	LSbj-1	10-14	30	30
b.	Attach the hook portion of the fastener tape to the right front to correspond with loop tape on left front. Stitch all four sides of the tape 1/8 inch from edge through all plies.	301	LSbj-1	10-14	30	30

MIL-C-2202H

TABLE I - CONSTRUCTION OF COVERALLS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
	c. Attach a 1 inch square piece of the loop portion of the fastener tape to the left lapel according to mark on pattern. Stitch 1/8 inch from edge through all plies.	301	LSbj-1	10-14	30	30
	d. Attach a 1 inch square piece of the hook portion of fastener tape on the right front to correspond with the loop portion applied in 37c. Stitch 1/8 inch from edge on all four sides.	301	LSbj-1	10-14	30	30
	NOTE: The front closure shall finish smooth and flat without any twists or puckers when fastened.					
38.	<u>Clean coveralls.</u>					
	a. Trim all thread ends and remove loose threads.					
	b. Remove all shade and size tickets.					
39.	<u>Fasten and fold coveralls.</u>					
	Fasten the front closures, waist, and leg tabs, and fold for packaging as specified in 5.1.1.					
	NOTE: Leave sleeve adjustment tabs unfastened for packaging.					

MIL-C-2202H

3.8 Sizes and measurements. Unless otherwise specified, finished measurements of coveralls shall be as listed in Table II. All measurements and tolerances are expressed in inches.

Table II - Sizes and measurements (inches)

Size	Chest 1/	Sleeve Length 2/	Leg inseam 3/
(Type I coverall)			
Small	22	21 1/2	29 1/2
Medium	24	22	30 3/4
Large	26	22 1/2	32
X-Large	28	23	33 1/4
XX-Large	30	23 1/2	33 1/4
(Type II coverall)			
XXX-Small	16	18 1/4	24 1/4
XX-Small	18	18 3/4	25
X-Small	20	19 1/4	25 3/4
Small	22	19 3/4	26 1/2
Medium	24	20 1/4	27 1/4
Large	26	20 3/4	28 1/2
X-Large	28	21 1/2	30
XX-Large	30	22	30
Tolerance:	± 1	$\pm 1/2$	$\pm 1/2$

NOTE: The above measurements shall be taken with coveralls fastened and laid out smooth and flat.

- 1/ Chest - Measurement taken across front at base of armholes from folded edge to folded edge.
- 2/ Sleeve length (Type I) - Measurement taken from base of armholes along inseam to bottom of sleeve.
(Type II)- Measurement taken from base of armholes along inseam to seamline at top of knitted cuff.
- 3/ Leg inseam (Type I) - Measurement taken from crotch seam along inseam to bottom of hemmed trouser leg.
(Type II)- Measurement taken from crotch seam along inseam to seamline at top of knitted cuff.

3.9 Workmanship. The finished coveralls shall conform to the quality established by this specification. The occurrence of defects shall not exceed the applicable acceptable point value or defect limit.

MIL-C-2202H

4. QUALITY ASSURANCE PROVISIONS

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

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

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

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

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

4.3 First article inspection. When required, the first article submitted in accordance with 3.2 shall be inspected for compliance with design, construction, workmanship, appearance, and dimensional requirements.

4.4 Quality conformance inspection. Sampling for inspection shall be performed in accordance with MIL-STD-1668, except where otherwise indicated.

4.4.1 Component and material inspection. In accordance with 4.1 above, components and materials shall be tested in accordance with all the requirements of referenced specifications, drawings, and standards unless otherwise excluded, amended, modified, or qualified in this specification or applicable procurement documents.

4.4.2 Examination of the end item. Examination of the end item shall be as specified in MIL-STD-1668.

MIL-C-2202H

4.4.3 Packaging inspection. Packaging inspection shall be in accordance with MIL-STD-1668.

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

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

5. PACKAGING

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

5.1.1 Level A. Each coverall shall be folded as follows: (1) Lay coverall flat, face down. (2) Fold coverall in half along the length. (3) The sleeves, placed together, shall be folded at the shoulder seam and placed on top and parallel to the folded edge of the garment. (4) Fold in thirds, by bringing the legs up and the top down, so that the folded garment measures approximately 14 1/2 inches in width by 23 inches in length.

5.1.2 Level C. Coveralls shall be packaged to afford adequate protection against physical damage during shipment from the contractor to the first receiving activity. The package and the quantity per package shall be the same as that normally used by the contractor for retail distribution.

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

MIL-C-2202H

5.2.1 Level A. Eighteen (18) coveralls, of one type and size only preserved as specified in 5.1, shall be packed in a fiberboard shipping container as follows: Stack eighteen coveralls flat, with every other one reversed and the length of the garments parallel with the side panels of the container. The contents of each container shall be completely covered on the top and bottom with a sheet of commercial grade kraft paper. Each fiberboard shipping container shall be assembled, closed, and reinforced conforming to type CF, class domestic, variety DW, grade V15c, size 3A of MIL-B-17757. The fiberboard for the box liner shall conform to type CF, class domestic of MIL-B-17757.

5.2.2 Level B. Eighteen (18) coveralls, of one type and size only, preserved as specified in 5.1, shall be packed in a fiberboard box as follows: Stack eighteen coveralls flat, with every other one reversed and the length of the garment parallel with the side panels of the container. The contents of each container shall be completely covered on the top and bottom with a sheet of commercial grade kraft paper. Each fiberboard shipping container shall be assembled and closed conforming to type CF, class domestic, variety SW, grade 275, size 3A of MIL-B-17757. The fiberboard for the box liner shall conform to type CF, class domestic of MIL-B-17757.

5.2.3 Level C. Item packaged, as specified in 5.1, shall be preserved in a manner to insure carrier acceptance and safe delivery at destination at the lowest transportation rate for such supplies. The quantity per shipping container shall be the same as that normally used by the contractor for retail distribution. Containers shall comply with the US Postal Manual, Uniform Freight Classification Rules or National Motor Freight Classification Rules, as applicable.

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

* 5.4 Palletization. When specified (see 6.2) item packed as specified shall be palletized on a 4-way entry pallet in accordance with load type 1A of MIL-STD-147. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding methods C and D or Film bonding F or G. Pallet pattern shall be in accordance with the appendix of MIL-STD-147. The pallet shall be 4-way, type IV; type V, class 1, size 2; or type VIII, fabricated from wood group I, II, III or IV, grade A of NN-P-71, or 4-way, style 1, size A, type I, class 1 fabricated from wood groups specified in MIL-P-15011. Interlocking of loads shall be effected by reversing the pattern of each course. If the container is of a size which does not conform to any of the patterns specified in MIL-STD-147, the pallet pattern used shall be approved by the contracting officer.

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

6. NOTES

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

MIL-C-2202H

6.1 Intended use. The items are intended for wear by the Department of Defense personnel and are designed to be worn over conventional clothing.

* 6.2 Acquisition requirements. Acquisition documents should specify the following:

- a. Title, number, and date of this specification
- b. Types, sizes and lengths required (see 1.2)
- c. 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).
- d. When first article sample is required (see 3.2). The item will be tested and should be a first article sample. The contracting officer should include specific instructions in acquisition documents regarding arrangements for examination, quantity, testing and approval of the first article.
- e. Levels of packaging and packing required (see 5.1 and 5.2)
- f. When palletization is required (see 5.4)
- g. When all packaging data is to be found in MIL-STD-2073-1 and MIL-STD-2073-2.

6.3 Samples and patterns. For access to samples and patterns, address the procuring activity issuing the invitation for bids (see 3.1 and 3.5).

* 6.4 Subject term (key word) listing.

Overgarment, cuffed sleeve
 Overgarment, mechanics
 Overgarment, one-piece
 Overgarment, pass-thru pocket
 Overgarment, protective
 Suit, mechanics
 Suit, protective one-piece

* 6.5 Changes from previous issue. The margins of this specification are marked with an asterisk to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous issue.

Custodian:

Navy - NU
 Air Force - 99
 Army - GL

Preparing Activity:

Navy - NU

Project 8405-0035

Review activity:

Navy - MC
 Air Force - 11, 82
 DLA - CT

User activity:

Air Force - 45

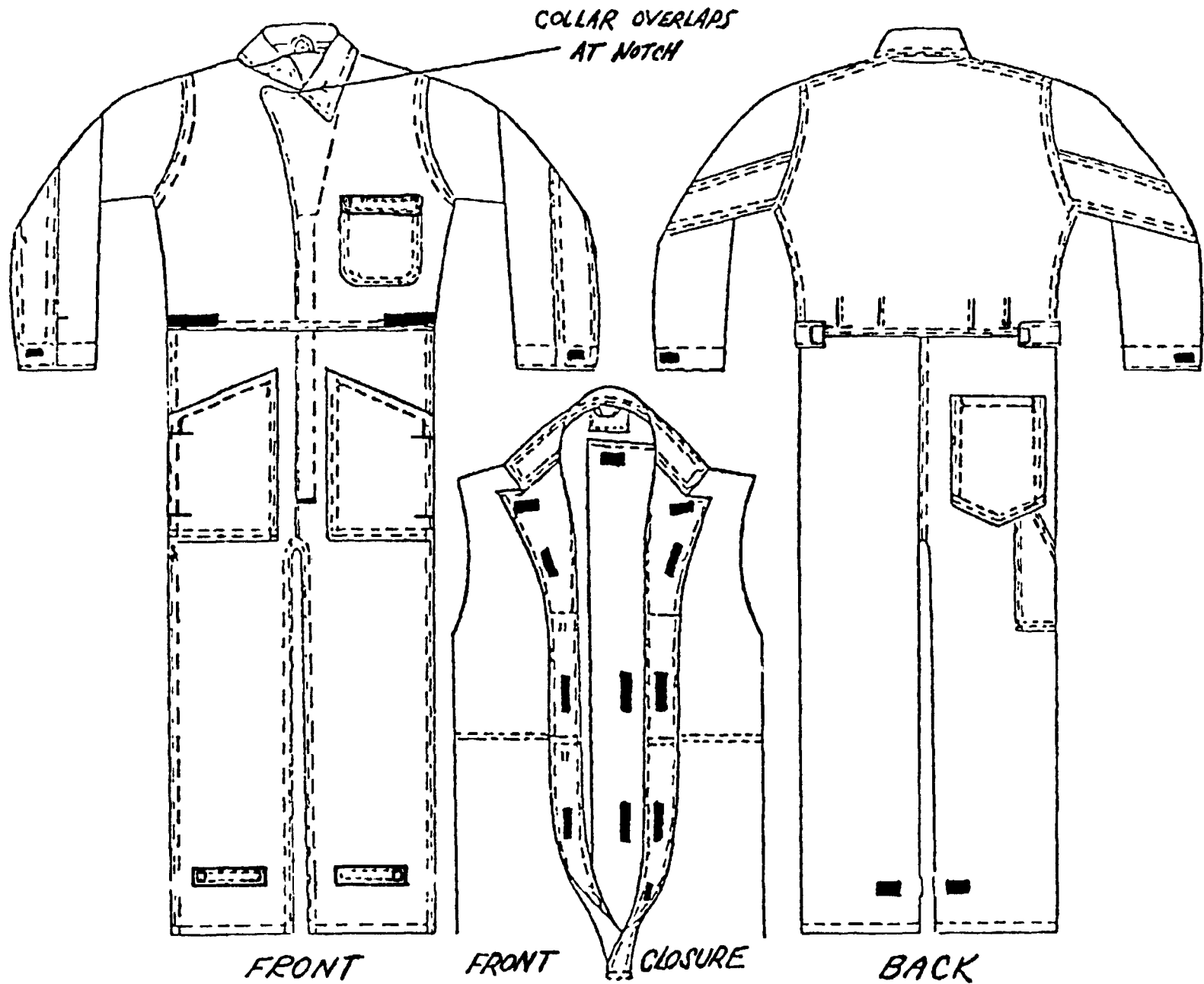
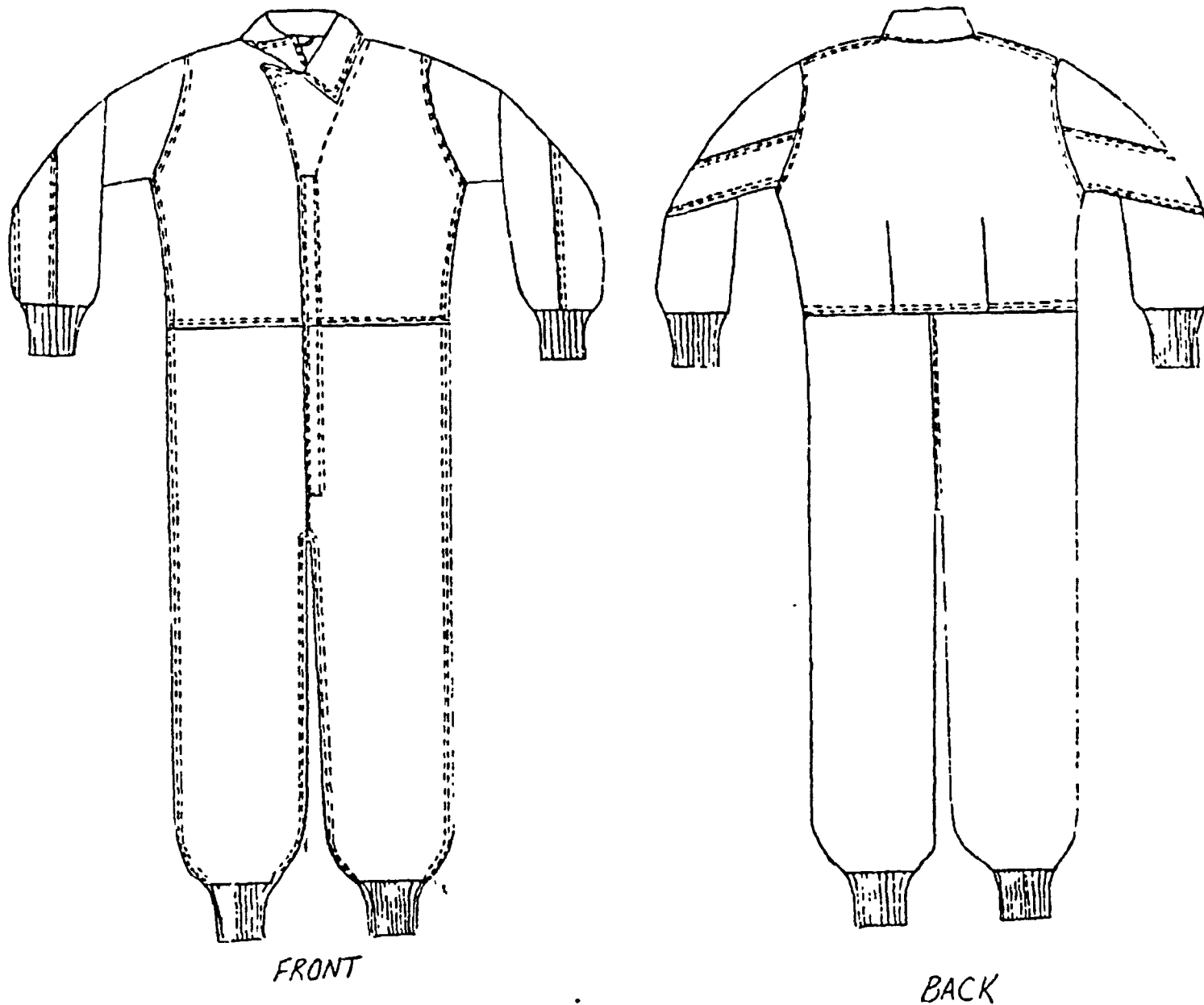


FIGURE 1 - COVERALLS, MEN'S, COTTON, SATEEN, TYPE I



HIL-C-2202H

FIGURE 2 - COVERALLS, MEN'S, COTTON, SATEEN - TYPE II