

MIL-C-29106B(NU)

1 March 1982

SUPERSEDING

MIL-C-29106A(SA)

5 December 1974

MILITARY SPECIFICATION

COAT, MAN'S, WOOL, WINTER

This specification is approved for use by Navy Clothing and Textile Research Facility, 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 a double breasted dress coat constructed of 15 ounce blue wool serge cloth.

1.2 Classification. The coat shall be of one type, in the following classes, sizes and lengths as specified (see 6.2).

1.2.1 Classes. Class 1 - Officers
Class 2 - Enlisted Men

1.2.2 Sizes. 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, and 48.

* 1.2.3 Lengths. Extra short, short, regular, long, and extra long.

1.3 Uniform. When coat and trousers are procured as a uniform (see 6.2), the coat and trousers shall be cut from the same piece of material and the shades shall match.

2. APPLICABLE DOCUMENTS

* 2.1 Issue of documents. The following documents of the issue in effect on date of invitation for bids or request for proposal form a part of this specification to the extent specified herein:

Beneficial comments (recommendations, additions, and 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 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

FSC 8405

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SPECIFICATION

FEDERAL

- V-B-871 - Button, Sewing Hole, and Button, Staple (Plastic)
- V-T-276 - Thread, Cotton
- V-T-280 - Thread, Cotton Gimp, Buttonhole
- V-T-285 - Thread, Polyester
- V-T-295 - Thread, Nylon
- V-T-301 - Thread, Silk
- CCC-C-438 - Cloth, Buckram, 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-C-368 - Cloth, Satin, Rayon and Cloth, Twill, Rayon
- MIL-B-371 - Braid, Textile (Cotton, Tubular)
- MIL-C-823 - Cloth, Serge, Wool; Wool and Nylon; Polyester and Wool
- MIL-B-3461 - Buttons, Insignia, Metal, Uniform and Cap
- MIL-C-15062 - Cloth, Flannel, Wool, Undercollar Cloth
- MIL-P-15064 - Pad, Shoulder and Sleeve-Head
- MIL-C-15065 - Coat Fronts
- MIL-C-16375 - Cloth, Wigan, Cotton
- MIL-B-17757 - Boxes, Fiber, Corrugated (Modular Sizes)
- MIL-C-29137 - Cloth, Felt Fabric, Composite, Undercollar
- MIL-T-43548 - Thread Polyester Cotton-covered
- MIL-C-43718 - Cloth, Twill, Polyester, Polyester and Cotton Polyester and Rayon

STANDARDS

FEDERAL

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

MILITARY

- MIL-STD-129 - Marking for Shipment and Storage
- MIL-STD-1490 - Provisions for Evaluating Quality of Coats, Men's, Dress

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

RULES AND REGULATIONS

U.S. POSTAL SERVICE MANUAL

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

2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless a specific issue is identified, the issues in effect on date of invitation for bids or request for proposal shall apply:

NATIONAL MOTOR FREIGHT TRAFFIC ASSOCIATION, INC., AGENT
National Motor Freight Classification

(Application for copies should be addressed to American Trucking Association, Attn: Traffic Department, 1616 P Street, N.W., Washington, D.C. 20036.)

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.)

3. REQUIREMENTS

3.1 Guide samples. 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.

3.2 First article. When specified (see 6.2), the contractor shall furnish sample unit(s) for first article inspection and approval (see 4.2).

3.3 Materials

3.3.1 Basic material. The basic material for the coats shall be wool, serge, shade Blue 3346, conforming to type I, class 5 of MIL-C-823.

3.3.2 Lining. The material for lining the coat body, sleeves, left front fly and for the right inside breast pocket welt and facing shall be rayon, 3.7 ounce, conforming to class 1 of MIL-C-368. The material shall match shade Black 3202.

3.3.3 Rayon binding. The binding for the underarm shields shall be the same material as specified in 3.3.2. The binding shall be cut on a 45 (+ 5) degree angle in strips 3/4 to 7/8 inch wide. The ends of the strips shall be joined together by stitch type 301 and seam type SSa-1 with 10 to 12 stitches per inch. The seams shall be 1/8 inch wide and shall be pressed open and flat. The edges of the binding shall be treated with a synthetic resin to prevent raveling when tested as specified in 4.4.1

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3.3.4 Collar interlining. The material for the collar interlining shall be cotton, buckram, natural or white conforming to type I, class 2 of CCC-C-438, except that the test for shrinkage shall be in accordance with test method 5580 of FED-STD-191.

3.3.5 Undercollar cloth. The undercollar material shall be wool flannel conforming to MIL-C-15062 or a felt/fabric composite conforming to MIL-C-29137. The shade shall be black and requirements for perspiration and crocking shall not apply. When the felt/fabric composite is used, the cotton buckram collar interlining is not required.

3.3.6 Wigan. The material for interlining bottom of sleeves shall be cotton, wigan, natural color, conforming to type I of MIL-C-16375.

* 3.3.7 Pocketing. The material for the pockets and stays shall be twill shall be twill cloth conforming to class 1 of MIL-C-43718. The shade for the pockets shall be black. The shade for pocket stays may be black or bleached.

3.3.8 Hanger loop. The hanger loop for the coat shall be of the material specified in 3.3.2 or shall be braid, cotton, tubular, conforming to type III, class 1 of MIL-B-371. The braid shall be black and shall show good fastness to crocking and wet-dry cleaning when tested as specified in 4.4.1.

3.3.9 Coat front. The coat fronts shall conform to type VI and the construction thereto of MIL-C-15065. As an alternate to the silesia used for stays, a twill cloth, conforming to class 1 of MIL-C-43718 may be used.

3.3.10 Shoulder and sleeve pads. The shoulder and sleeve pads shall conform to type I, class 1 and type IV and the construction thereto of MIL-P-15064. The type I shall be used for the shoulders and the type IV shall be used for the sleeve heads.

3.3.11 Tapes.

3.3.11.1 Woven tape. The tape shall be cotton, preshrunk, conforming to class 1 or class 2 and shall be of the following types and widths of DDD-T-86:

Type I - 5/8 inch wide stay tape for bridle at breakline of lapel

Type II - 3/16 inch wide stay tape for welt of pockets, front neck gorge, back armhole and lower part of front armhole

Type III - 3/8 inch wide stay tape for lapel, back neck, front and bottom edges

3.3.11.2 Bias-cut. The stay tape for the shoulders and upper part of front armhole shall be bias cut, 3/4 inch in width, twill cloth dyed or undyed, conforming to class 1 of MIL-C-43718.

* 3.3.11.3 Tape, fusible. The tape for joining the fronts and facings shall be woven or non-woven, natural color, with a thermoplastic polyamide resin applied to the tape. The tape shall be 5/8 inch in width (see 4.4.1).

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* 3.3.12 Threads

3.3.12.1 Thread-polyester, cotton-covered. The thread shall be dyed shade Black AA, CA 66043 and shall conform to MIL-T-43548 as follows:

Use	Ticket No.	Ply
Seaming, stitching and bartacks	50, 70	2 or 3
Button sewing		
Hand	16	2 or 3
Machine	20	2 or 3

3.3.12.1.2 Thread, cotton. As an alternate to the polyester cotton-covered thread listed in 3.3.12.1 a cotton thread may be used. When this option is exercised, the thread shall match shade Black AA, CA 66043, conforming to V-T-276 as follows:

Use	Type	Ticket No.	Ply
Seaming and stitching	1A3	70	2
	1A3	30, 50	3
	1C2	A	3
Tacking armholes and attaching sleeve head pads	1A1 or 1A2	30	3
Button sewing:			
Hand	1B3 or	12 or 16	4
Machine	1A3	20	4

3.3.12.1.3 Basting thread. The thread for basting and tacking shall be a good commercial grade cotton, bleached or unbleached. A monofilament synthetic thread may be used for only those basting operations where the thread is required to be removed provided the garment is subsequently given a treatment by a cleaning agent in which the synthetic thread is soluble. When this thread is used, any residue remaining on the garment after the dry cleaning process shall be brushed off or removed.

* 3.3.12.2 Silk thread. The silk thread for hand and machine sewing shall be dyed Black AA, Cable No. 66043, conforming to V-T-301 as follows:

Use	Type	Class	Ticket N.	Ply
Machine stitching and felling	I		0	3
Buttonholes and bartacks	I		B, C	3
Hand felling	III	3	A, C	2

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3.3.12.2.1 The following threads may be utilized as alternates to the silk threads specified above for the operations indicated:

- a. For machine felling and blind felling - polyester thread conforming to type I, size A/3 or AA/2 of V-T-285 or a mono-filament nylon thread of comparable type and size.
- b. For hand felling - nylon thread conforming to type IV, size A/2 or C/2 of V-T-295.

3.3.12.2.2 Nylon thread. If an automatic machine which sews shank buttons imitating hand sewing is used, the thread shall be nylon waxed monocord, special No. 4, having a breaking strength of 11 pounds and a minimum length per pound of 3,250 yards and shall be tested for these requirements.

3.3.12.3 Colorfastness of threads. The dyed threads shall show colorfastness to wet-dry cleaning and light equal to or better than the standard sample when tested as specified in V-T-276, V-T-285, V-T-295 or V-T-301. When no standard sample is available, the dyed threads shall show good colorfastness to wet-dry cleaning and light when tested as specified in V-T-276, V-T-285, V-T-295, or V-T-301.

3.3.13 Gimp. The gimp for reinforcing the buttonholes shall be thread, cotton gimp, buttonhole conforming to type I or II, size No. 8 of V-T-280. The gimp shall be dyed black.

3.3.13.1 Colorfastness. The dyed gimp shall show fastness to wet-dry cleaning equal to or better than the standard sample when tested as specified in V-T-280. When no standard sample is available, the dyed gimp shall show good fastness to wet-dry cleaning when tested as specified in V-T-280.

3.3.14 Labels

3.3.14.1 Combination label. Each coat shall have a combination label listing identification and size and shall conform to type IV, classes 1 and 2 of DDD-L-20. The label marking shall show colorfastness to wet-dry cleaning. The inscription shall be as follows:

COAT, MAN'S, WOOL, WINTER
 FIBER CONTENT: WOOL (100%)
 CONTRACT NO.: DLA-100-00-0-0000 (Example)
 STOCK NO.: 8405-00-000-0000 (Example)
 SIZE: 38R (Example)
 NAME OF CONTRACTOR

NOTE: The length (extra short, short, regular, long and extra long) may be abbreviated as XS, S, R, L or XL.

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3.3.14.2 Size ticket. Unless otherwise specified, a size ticket shall be attached on the outside of the right top sleeve 2 or 3 inches from the bottom edge. The ticket shall be tacked on four corners by machine or hand (6 to 8 per tack by machine, or 2 to 3 per tack by hand). The corners may be double perforated for ease in tacking. The size ticket shall be made of suitable commercial cardboard measuring not less than 2-1/8 by 1-1/4 inches and shall be legibly printed with the following information:

COAT, MAN'S, WOOL, WINTER
SIZE: 38R

The nomenclature shall be printed in letters not less than 1/8 inch in height and size numerals not less than 1/4 inch in height. The model may be designated XS, S, R, L or XL.

3.3.14.3 Personal and instruction label. Each coat shall have a combination personal and instruction label conforming to type IV classes 3 and 10 of DDD-L-20, except that the Name and Service No. shall be in letters not less than 1/4 inch in height; all other lettering shall be 1/8 inch in height. The overall size of the label shall be 3-1/2 (+ 1/8) inches by 1-1/2 (+ 1/8) inches. The label shall show colorfastness to dry cleaning and the inscription shall be as follows:

NAME
SERVICE NO.:

CAUTION
Roll press sleeves and lapels.
Dry clean only.

3.3.15 Buttons

3.3.15.1 Metal buttons. The gold plated buttons for the class 1 coat shall conform to 35-line, regular shank for left front and 35-line, short shank for right front conforming to type I, style 4, class A of MIL-B-3461. The silver buttons for the class 2 coat shall conform to type I, style 4, class C, hopper-back of MIL-B-3461. The buttons for the left front, for class 1 and class 2 coats, shall be furnished with bodkin toggles.

3.3.15.2 Composition buttons. The buttons for the inside left front fly of coat shall be plastic, type II, class D, styles 20 and 21, 30-line; and type II, class D, styles 20 and 21, 24-line for sword vent flap conforming to V-B-871. The buttons shall be black and have a glossy finish.

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3.4 Design. The coat shall be a semi-fitted, double-breasted fully lined sack coat. It shall have three, 35-line Navy eagle gilt buttons (class 1) or three, 35-line Navy eagle silver buttons (class 2) on each forepart, semi-peaked lapels, front and side body, two-piece back, one welted outside breast pocket, two welted lower front pockets and inside welt or double piped pocket at the right breast, and a sword slit with flap in side (underarm) seam of left forepart (class 1) (see Figure 1).

3.4.1 Figures. Figures are furnished for information purposes only. To the extent of any inconsistencies between the written specification and the figures, 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). Except as allowed by footnotes to the List of Pattern Parts, the working patterns shall be identical to the Government patterns which shall not be altered in any way. The patterns allow 3/8 inch for all seams, except as otherwise indicated in Table I.

3.5.1 List of pattern parts. The component parts of the Coat, Man's, Wool, Winter shall be cut from materials as specified and in accordance with the number of parts required for the manufacturing process as follows:

<u>Material</u>	<u>Pattern Parts</u>	<u>Cut Parts</u>
Cloth, serge, wool	Front	2
	Side body	2
	Back	2
	Facing	2
	Top sleeve	2
	Under sleeve	2
	Top collar	1
	Pocket welt (hip)	2
	Pocket welt (outside breast)	1
	Pocket facing (hip)	2
	Pocket facing (outside breast)	1
	Underarm shield	2
	Sword vent flap	1 $\frac{1}{2}$
	Sword vent facing	1 $\frac{1}{2}$
Cloth, rayon, lining	Front	2
	Back	2
	Top sleeve	2
	Under sleeve	2
	Front fly (left side)	2
	Pocket welt and facing (right inside breast pocket)	1
	Sword vent flap	1 $\frac{1}{2}$

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<u>Material</u> (cont'd)	<u>Pattern Parts</u>	<u>Cut Parts</u>
Cloth, twill, class 1	Hip pocket (inner ply)	2
	Hip pocket (outer ply)	2
	Outside breast pocket (inner ply)	1
	Outside breast pocket (outer ply)	1
	Inside breast pocket	1
Cloth, felt, wool and rayon	Undercollar (bias)	1 <u>2/</u>
Cloth, wool, flannel	Undercollar (bias)	2 <u>3/</u>
Cloth, cotton, interlining	Undercollar, canvas (bias)	2 <u>3/</u>
Cloth, cotton, wigan	Sleeve interlining (bias)	2
Templates	Undercollar shaper	-
	Lapel shaper	-
	Finished lapel and collar shaper	-
	Undercollar stand marker	-

1/ Class 1 coat only.

2/ Pattern shall be cut as one pice only.

3/ Pattern may be cut as one piece.

3.6 Construction

3.6.1 Stitches, seams, and stitching types. Stitch, seam, and stitching types as 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 of them may be used. Where stitch type 401 or 101 is used, the looper (underthread) shall be on the inside of the coat. Unless otherwise specified, topstitching and edgestitching shall be 1/16 inch from edge.

3.6.2 Thread breaks and ends of seams. Ends of all seams and stitchings when not caught in other seams or stitchings shall be backtacked not less than 3/8 inch unless otherwise specified. The ends of a continuous line of stitching shall be overlapped not less than 1/2 inch. Thread breaks (all stitch types) shall be secured by stitching back of the break not less than 1/2 inch. Skipped stitches or 401 stitch type thread breaks may be repaired by using 301 stitching type. Where stitch type 401 or 101 is permitted, as an option, it shall not be used unless the ends are caught in other seams or stitching, except basting and button sewing operations.

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

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3.7 Manufacturing operations requirements. The coats 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 listed provided that the finished coats are identical to those produced by following the sequence of operations as listed in Table I.

3.7.1 All pressing operations referenced in Table I shall be performed by using a heated pressing iron or steam pressing machine.

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Table I - Construction of coat

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
1.	<p><u>Cutting</u></p> <p>a. Cut the coat in strict accordance with patterns, which show size, shape, placement of component parts, directional lines, and notches for the proper assembly of all parts. Wax crayon for the marking of outer edges of patterns or paper markers with a felt backing is permissible for cutting the wool. Perforated paper markers are prohibited on the wool but may be used for cotton components.</p> <p>b. All component wool parts of the coat shall be cut from one piece of material except the pocket facings, sword vent facing, and underarm shields which may be cut from ends and when so cut shall approximately match the main assembly.</p> <p>c. All component lining parts of the coat shall be cut from one piece of material except bias binding for underarm shields, front fly (left side), sword vent flap lining, and sleeve linings which may be cut from ends and when so cut shall approximately match the main assembly. When pairs of sleeve linings are cut from ends, they shall be shade marked and shall match each other.</p> <p>d. Cut all other component parts listed in 3.5.1 as indicated by patterns from the material specified. When the wool flannel undercollar is cut in two pieces, the two pieces shall match each other.</p>					

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
1.	<p><u>Cutting (cont'd)</u></p> <p>e. Cut pocket stays 2-1/2 inches wide in the warp direction. The length of the individual pocket stays shall be 1-1/2 inches longer than nominal finished welt length specified in operation 11.q and 11.r, and width of pocket opening specified in operation 15.j (see 3.3.7).</p>					
2.	<p><u>Replacement of defective components</u></p> <p>Care shall be exercised during the spreading, cutting and manufacturing operations to assure that material defects and damages as specified in MIL-STD-1490 are excluded and replaced with non-defective and properly matched material.</p>					
3.	<p><u>Shade marking</u></p> <p>a. All component parts of the basic material and linings including sleeve linings whether cut from ends or in the main lay shall be marked or ticketed to assure a uniform shade throughout the coat. Other parts cut from ends need not be shade marked.</p> <p>b. The use of metal fastening devices for shade and identification marking is permitted on the wool but is prohibited on the rayon lining. When metal stapled tickets are used on the base fabric, the wire shall be aluminum</p> <p>c. Adhesive tickets which discolor or adhere to the material upon removal of the tickets are prohibited.</p>					
*						

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
3.	Shade marking (cont'd) d. The use of ink pad numbering machine, rubber stamp or pencil is acceptable provided the numbers are legible and do not show through on the outside of the coat; wherever possible, numbers shall be on the seam allowance.					
4.	Make coat fronts The coat fronts shall conform to the requirements of 3.3.9.					
5.	Make sword vent flap a. Stitch sword vent flap lining to wool sword vent flap. Turn, work out edges and point, trim where necessary and edgestitch. b. Mark and stitch in sword vent flap, a 5/8 to 3/4 inch horizontal buttonhole, eyelet end, taper bar type, worked over gimp with ends securely tacked or an eyelet end, square-bar type may be used (see operations 33.a, b and d). Eyelet shall be 5/8 to 3/4 inch from point of flap. c. The finished sword vent flap shall measure 3-1/2 (+ 1/4) inches long and 2 (+ 1/8) inches deep in the center.	301 or 401 Button-hole	SSe-2 Stitches per size/ inch 5/8 3/4	10-14 Button-hole stitches 32-38 40-46 (including tack)	50 50 C (silk)	50 70 B (silk)

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
6.	Make collar					
	a. Wool flannel undercollar construction:					
	(1) The collar shall consist of a one or two piece wool flannel undercollar and a one or two piece buckram interlining.					
	(2) Seam wool flannel undercollar, face to face, at center back 1/4 inch from the edge.	301 or 401	SSa-1	10-14	50 50	50 70
	(3) Press seam open and flat.					
	NOTE: These operations shall be omitted when wool flannel undercollar is cut as one piece.					
	(4) Seam buckram interlining undercollar at center back overlapping the edges approximately 3/8 inch.	301 or 401	LSa-1	10-14	50 50	50 70
	NOTE: This operation shall be omitted when buckram interlining is cut as one piece.					
	(5) Pad interlining undercollar to wool flannel undercollar with seven to eight rows of blindstitching the length of the undercollar and with fullness on the buckram interlining between rows of blindstitching to cover the width of the undercollar up to the allowance for insertion of the topcollar.	103	SSm-7 to 8	4-8	70	
	(6) Press undercollar flat.					
	(7) Mark and shape undercollar to conform to undercollar pattern shaper. Trim interlining 1/8 to 3/16 inch from neck edge of undercollar.					
	NOTE: Marking and shaping of undercollar may be performed with a clicker machine using dies conforming to undercollar shaper.					

Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
6.	Make collar (cont'd)					
	a. Wool flannel undercollar construction: (cont'd)					
	(8) Mark the breakline of the finished undercollar in accordance with marks on pattern.					
	(9) Seam wool flannel undercollar to interlining at breakline (the finished collar stand at center shall measure $1-1/4 (+ 1/8)$ inches).	301 or 401	SSv-1	10-14	50 50	50 70
	(10) Baste top edge of finished undercollar $1/2 (+ 1/4)$ inch away from end and along straight top edge of top-collar matching and distributing fullness of topcollar between the notches on outer edge of undercollar and topcollar.	Hand or Machine			Commercial	Commercial
	NOTE: This operation shall be omitted when top edge of collar is machine felled (see operation 6.a.13).					
	(11) Baste along breakline and ends of collar.	Hand or Machine			Commercial	
	(12) Trim, turn, and baste edges of topcollar over interlining between wool flannel undercollar and interlining.	Hand or Machine			Commercial	
	(13) Fell corners, top and side edges of topcollar to finished undercollar matching and distributing fullness of topcollar between the notches on outer edge of undercollar and topcollar.	Hand or Machine		8-10 6-10	C (silk) O (silk)	O (silk)

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
b.	Make collar (cont'd) (13) Cont'd)					
*	or As an alternate, machine stitched collar ends will be permitted. Place topcollar on undercollar, face to face, and machine stitch ends of collar. Trim and turn collar to finished position. Adjusting top-collar and under collar patterns will be the responsibility of the manufacturer.					
	(14) Trim neck edge of topcollar to allow for seaming.	301	SSa-1	8-10	50	50
	(15) Press and crease the stand of the topcollar and the undercollar together in one operation to shape, holding creaseline short. Center area of creaseline shall be straight for a distance of 3 to 4 inches.					
	OR b. Composite undercollar construction:					
	(1) The composite undercollar shall be one piece. A separate collar interlining is not required with this type of undercollar material.					
	(2) Mark and shape undercollar to conform to under-collar shaper template. Marking and shaping of under-collar may be performed with a clicker machine using dies conforming to undercollar shaper template.					
	(3) Baste top edge of finished undercollar 1/2 (+ 1/4) inch away from end and along straight top edge of topcollar matching and distributing fullness of topcollar between notches on outer edge of undercollar and topcollar.	Hand or Machine				Commercial

NOTE: This operation shall be omitted when top edge of collar is machine felled

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
6.	Make collar (cont'd) b. Composite undercollar construction: (cont'd) (4) Baste the topcollar to undercollar along crease-line and outer edge putting in proper fullness. The finished collarstand at center shall measure 1-1/4 (+ 1/8) inches. (5) Trim, turn and baste edges of topcollar.	Hand or Machine			Commercial	
*	(6) Fell top and side edges of topcollar to finished undercollar. Fullness of topcollar shall be distributed between notches on outer edge of undercollar and topcollar. OR As an alternate, machine stitched collar ends will be permitted. Place topcollar on undercollar, face to face, and machine stitch ends of collar. Trim and turn collar to finished position. Adjusting topcollar and undercollar patterns will be the responsibility of the manufacturer.	Hand or Machine		8-10 6-10	C (silk) D (silk)	O (silk)
	(7) Trim neck edge of topcollar to allow for seaming.	301	SSa-1	8-10	50	50
	(8) Press and crease the stand of the topcollar and the undercollar together in one operation to shape, stretching the outer edge of the collar across the shoulders, holding the creaseline short. Center area of creaseline shall be straight for a distance of 3 to 4 inches.					

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
7.	Make sleeve and sleeve linings					
	a. Join forearm seam of sleeve (basic material), face to face, 3/8 inch from the edge, distributing fullness between notches.	301 or 401	SSa-1	10-14	30 30	30 50
	b. Press forearm seam open and flat holding seam short.					
	c. Stitch sleeve interlining (wigan) to forearm seam and sides of backarm seam allowances. Bottom edge of sleeve interlining shall be 1/2 to 3/4 inch below turnout notches. Trim ends of sleeve interlining even with edges of sleeve.	301 or 401		10-14	50 50	50 70
	d. Press turnout of sleeve as indicated by notches in pattern.					
	e. Join backarm seam of sleeve, face to face, 3/8 inch from the edge.	301 or 401	SSa-1	10-14	30 30	30 50
	f. Press backarm seam open and flat.					
	g. Blindstitch top edge of sleeve turnout to interlining.	103 or Hand	EFc-1(b)	4-8	50 50	
	h. Join the forearm seam of the sleeve linings, face to face, 3/8 inch from the edge distributing fullness between notches.	301 or 401	SSa-1	10-14	50 50	50 70
	i. Join the back arm seam of sleeve linings, face to face, 3/8 inch from the edge.	301 or 401	SSa-1	10-14	50 50	50 70

Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
8.	Attach sleeve lining to sleeve					
	a. The sleeve lining shall extend not less than 3/4 inch nor more than 1 inch above top of the basic material sleeve.					
	b. Tack forearm and backarm seam of sleeve lining to forearm and backarm seam of sleeves respectively distributing proper fullness in lining. Tacking shall extend from not more than 6 inches below top to not more than 6 inches above creased bottom edge. When tacking is done by hand, both ends of the stitching shall be securely backstitched with not less than three stitches.	301 or 401 or Hand		4-8 1/2 to 1-1/2 inches in length	50 50 50 or Commercial	50 70 Commercial
	c. Pull sleeve through lining and baste turnout of sleeve lining. Sleeve lining shall have not less than 1-1/4 inches turnout.	Hand or Machine				Commercial
	NOTE: The bottom of the sleeve lining may be felled without basting.					
	d. Fell bottom of sleeve lining to sleeve turnout.	Hand or 101 or 306		6-8	A or C (silk)	
	e. Turn sleeves to finished position and assemble in pairs.			6-10	0 (silk)	0 (silk)

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
9.	<p>Make cash pocket</p> <p>a. There shall be a cash pocket on the inside of the right hip pocket. Cash pocket shall be made from the material specified in 3.3.7 and shall measure 3-3/4 (+ 1/4) inches wide and 3 (+ 1/4) inches deep.</p> <p>b. Construction of the cash pocket shall be at the option of the manufacturer.</p>					
10.	<p>Join fronts and side body pieces and attach sword vent flap and facing</p> <p>a. Each front shall consist of two pieces, a front and a side body.</p> <p>b. Stitch the cut out dart front section as indicated by pattern, tapering to a point at the top and to approximately 3/8 inch in the middle and 1/4 inch at the bottom end.</p> <p>c. Press darts open and flat.</p> <p>d. Abut edges of the hip pocket opening and zigzag stitch.</p> <p>e. Stitch sword vent flap to the side (underarm) seam of left front, face to face, 3/8 inch from raw edge as indicated by notches on patterns.</p>	<p>301 or 401</p> <p>304 or Hand</p> <p>301</p>	<p>SSa-1</p> <p>FSa-1</p> <p>LSq-2(a)</p>	<p>10-14</p> <p>4-8 2-4</p> <p>10-14</p>	<p>30 30</p> <p>50 50</p> <p>30</p>	

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
10.	Join fronts and side body pieces and attach sword vent flap and facing (cont'd)					
	f. Stitch sword vent facing to front (underarm) seam of left side body piece, face to face, 3/8 inch from raw edge as indicated by notches on pattern.	301	LSq-2(a)	10-14	30	30
	g. Join front (underarm) seam of side body piece to the side (underarm) seam of left and right fronts, face to face, 3/8 inch from edge. (On the class 1 coat, leave the prestitched sword vent flap and facing open as indicated by notches on pattern.)	301 or 401	SSa-1	10-14	30 30	30 50
	h. Press each joining seam open and flat.					
11.	i. Turn and raisestitch sword vent flap through front and seam allowance.	301	LSq-2(b)	10-14	30	30
	j. Turn vent facing to finished position and press.					
	k. Stitch a 3/16 to 1/4 inch bartack across each end of the sword vent opening. The bartacks shall be centered across the joining seam.	Bartack or Hand		21-28 per bartack 10-12 per tack	B (silk) B (silk)	B (silk)
	Make welt pockets a. There shall be three welt pockets; one on the left breast and one on each hip. b. Position a 3/16 inch wide woven tape adjacent to center foldline on underside of underply of welt piece and stitch 1/16 to 1/8 inch from edge of tape. The tape stitching shall not show on outer ply of welt.	301		10-14	50	50

Table I - Construction of coat (cont'd)

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No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
11.	Make welt pockets (cont'd)					
	c. Stitch 1/4 inch from the edge, face to face, the outer ply of pocket piece to the under ply of welt.	301	SSa-1	10-14	50	50
	d. Stitch 1/4 inch from the edge, face to face, the inner ply of pocket piece to the facing.	301	SSa-1	10-14	50	50
	e. Fold welt in half lengthwise and stitch the ends 3/16 inch from the edge, terminating the stitching at the ends of seam joining the outer ply of pocket to the under ply of welt. Trim corners, turn to finished position, working out seamed edges and points of welt.					
	f. The ends and top of welt may be basted or the welt may be pressed flat with a heated pressing iron.					
	g. Mark width of welt from foldline in accordance with finished measurement.					
	h. Stitch welt to front through all plies as indicated by marks on pattern, catching pocket stay on the underside. As an alternate, the top ply of the welt may be stitched to the front.	301	LSbj-1	10-14	50	50
	i. The ends of welt seam allowance may be clipped.					
	j. Stitch pocket facing to front with the stitching approximately 1/2 inch from the seam joining top ply of welt to front.	301	LSbj-1	10-14	50	50
	k. Cut opening of pocket between the two rows of stitching and tongue notch ends.					

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Loop
11.	Make welt pockets (cont'd)					
	l. When alternate method in operation 11.h is used, the seam allowance of top ply of welt shall be turned up and stitched on the underside adjacent to the welt setting seam. Stitch through under ply of welt simultaneously catching the prestitched stay. In the finished coat, the welt setting seam shall be spread open.					
	m. Turn pocket through cut opening to finished position.					
	n. Topstitch ends of welt through front, pocket facing and stay. Reinforce corners with a diagonal stitch approximately 1/4 inch in length and backstitch.	301		10-14	50	50
	o. Stitch sides and bottom of pockets. (see finished measurements for welts and pockets.)	301 or 401	SSa-1	10-14	50 50	50 70
	p. Baste welt joining seam open	Hand or Machine			Commercial	
	q. Press pocket facing-front seam open when alternate method in operation 11.h is used.					
	r. The finished outside breast pocket shall measure:					
	Inches					
	Length of welt	33-36	37-39	40-42	43-48	Tot.
		4-1/8	4-1/2	4-3/4	5	+ 1/8
	Width of welt	15/16	15/16	15/16	15/16	+ 1/16
	Depth of pocket	6	6	6	6	+ 1/2

MIL-C-29106B(NU)

Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
11.	Make welt pockets (cont'd) s. The finished hip pockets shall measure: Inches 33-36 37-39 40-42 43-48 Length of welt 6-1/8 6-3/8 6-3/4 7 Width of welt 1-3/16 1-3/16 1-3/16 1-3/16 Depth of pocket 6-1/2(S,XS) 6-1/2(S,XS) 6-1/2(S,XS) 6-1/2(S,XS) 7 (R,L,XL) 7(R,L,XL) 7(R,L,XL) 7(R,L,XL)	ToL. + 1/8 + 1/16 + 1/2 + 1/2				
12.	Make backs a. The back shall consist of two pieces. b. Stitch back pieces, face to face, 3/4 inch from the edge. c. Press seam open and flat.	301 or 401	SSa-1	10-14	30 30	30 50
13.	Stitch tapes to front a. Stitch a 3/16 inch wide herringbone tape on neck gorge of front 1/8 inch from the edge. b. Stitch a 3/4 inch wide bias-cut tape strip on each front along shoulder 3/4 to 1 inch from gorge to within 1/2 to 3/4 inch from armhole. c. Stitch a 3/4 inch wide bias-cut tape strip on front of armhole from 2 to 2-1/2 inches above armhole notch to within 1/2 to 3/4 inch from shoulder.	301 301 301	SSaa-1 SSaa-1 SSaa-1	10-14 10-14 10-14	50 50 50	50 50 50

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
13.	<p>Stitch tapes to front (cont'd)</p> <p>d. Stitch a 3/16 inch wide herringbone tape on armholes of foreparts from approximately 3/4 inch of underarm seam to approximately 3/8 inch beyond bias-cut tape strip on armhole; holding tape taut.</p> <p>e. Press tapes.</p>	301 or 401	SSaa-1	10-14	50 50	50 70
14.	<p>Prepare front lining</p> <p>a. Fold and stitch dart in each lining front as indicated on pattern 3/8 inch at center and tapering to a point on both ends.</p> <p>b. Stitch underarm darts of lining pieces 3/8 inch from edges.</p> <p>c. Seam right front lining to right front facing, face to face, 3/8 inch from the edge; terminate seam 1 to 1-1/2 inches above the bottom of facing-lining assembly to facilitate hem felling operation.</p>	301 or 401	OSf-1	10-14	50 50	50 70
		301	SSa-1	10-14	50	50
		301 or 401	SSa-1	10-14	50 50	50 70
15.	<p>Make inside breast pocket and attach label</p> <p>a. There shall be an inside breast double piped pocket located on right inside breast of coat as indicated by marks on patterns.</p> <p>b. Center the inside breast pocket lining facing on and between the ends of the inside breast pocket piece and turn under both edges 1/4 to 3/8 inch and stitch. Selvage need not be turned under. The top edge of a label shall be centered, inserted and caught under the edge of the lining facing; printing on label shall not be obscured. Stitch the remaining three sides of label.</p>	301	LSd-1 and LSbj-1	10-14	50	50

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
15.	Make inside breast pocket and attach label (cont'd) Label shall be located on the pocket ply next to the coat front.					
	c. As an alternate, stitch the four sides of label to the pocket piece with the top edge of label overlapping lining facing. Label shall be located on the pocket ply next to the coat front.	301	LSbj-1	10-14	50	50
	d. Fold pocket piece approximately in the center of the lining facing and stitch to right facing-lining assembly at the mark for the pocket opening and a pocket stay on the underside forming a 1/4 inch to 3/8 inch piped piece.	301	Similar to LSbt-2(a)	10-14	50	50
	e. Stitch under layer of pocket piece to facing-lining assembly and pocket stay 1/4 to 3/8 inch above the first row of stitching.	301	LSbj-1	10-14	50	50
	f. Cut opening of pocket through pocket facing-lining assembly and stay piece midway between the row of stitching; tongue notch the ends of opening and turn pocket piece through opening.					
	g. Topstitch facing-lining assembly at ends and top of pocket opening with tongue tab at each end turned under and seam allowance at top of pocket turned upward.	301	LSq-2(b) (shows finished seam at top of pocket opening)	10-14	50	50

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
15	Make inside breast pocket and attach label (cont'd) h. Stitch pocket piece at sides securely tacking corners through tongue notch and bottom, rounding corners. The back part of pocket shall be held taut to prevent gapping of pocket opening. i. Notch top of pocket at front edge for the full width of seam allowance and blindstitch inner ply of pocket to facing (see 31.g for alternate operation). j. The finished inside breast pocket shall measure 5-1/4 (+ 1/4) inches wide, 6-3/4 (+ 1/2) inches deep and shall extend into the facing 1/2 (+ 1/4) inch. k. Position top edge of personal and instruction label on outside of inside breast pocket 1/8 to 1/4 inch below joining seam of lower piped piece at center of pocket opening and stitch label on all four sides to the front lining through one ply of the pocketing.	301 103 or 306 301	SSa-1 SSm-1 LSbj-1	10-14 2-4 10-14	50 50 50 50	50 50 50
*	NOTE: As an alternate, the above pocket opening operations may be accomplished with a double piped pocket machine which stitches, cuts, and turns piped edges in one operation. When this machine is used, the piped piece may be trimmed to permit insertion into the machine and the manufacturer's recommended pocket-stay material may be used. Ends of pocket opening shall be securely tacked. Close top of pocket on the inside by stitching across the joining seam of top piped piece through all plies.	101 and 301 or 401		10-14	A/3 (Cotton) 50 A/3 (Cotton)	50 or A/3 (Cotton)

MIL-C-29106B(NU)

Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
16.	<u>Make front fly in left front lining</u>					
	a. Position and stitch, face to face, 3/8 inch from the edge, front edge of front fly lining piece to inner edge of left front facing as indicated by notches on pattern. Turn to finished position and raisestitch through fly lining and seam allowance.	301	LSq-2	10-14	50	50
	b. Position and stitch, face to face, 3/8 inch from the edge, front edge of fly lining piece to front edge of left front lining piece. Turn to finished position and raisestitch through fly lining and seam allowance.	301	LSq-2	10-14	50	50
	c. Join left front facing to left front lining 3/8 inch from the edge, leaving an opening (fly) between notches as indicated on pattern. Terminate seam as indicated in operation 14.c.	301 or 401	SSa-1	10-14	50 50	50 70
	d. To complete fly opening, stitch 2-1/2 (+ 1/4) inches in from open folded edge and along top and bottom through front lining and plies of fly lining.	301	SSa-1	10-14	50	50
*17.	e. Press seam joining front body lining to the facing and darts flat to one side toward side seam; press pocket smooth and flat; press open bottom of joining facing seam.					
	<u>Join back and front linings</u>					
	a. Join sides of front and back linings, face to face 1/2 inch from the edge.	301 or 401	SSa-1	10-14	50 50	50 70
	b. Join lining at center back, face to face, 3/8 inch from the edge.	301 or 401	SSa-1	10-14	50 50	50 70

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
17.	Join back and front linings (cont'd) c. Press side seams flat to one side with a heated pressing iron; placing the side joining seams toward the center back. d. Press, with a heated pressing iron, seam joining front body lining to the facings flat to one side toward side seam and pocket smooth and flat, open bottom of joining seam.					
18.	Baste interlining to coat front a. Baste interlining to coat front from top of out-side breast pocket along front dart seam to top edge of hip pocket welt, across welt to front end of opening and down to bottom of coat. Interlining shall extend well beyond the armholes and shoulders. b. Tack vertical front dart to the interlining. Tack front, back and across top of outside breast pocket stay to interlining. c. Tack hip pocket stay to interlining at front top corner. Tack front edge of hip pocket seam allowance to interlining. d. In addition, baste the interlining to coat front as follows: (1) Across shoulder allowing for placement of shoulder pads. (2) Around armhole and down back edge of interlining. (3) Along breakline of lapel. (4) Down the front edge of interlining to bottom of coat.	Hand or Machine 301 or Hand 301 or Hand Hand or Machine		2-4 2-4	Commercial 50 or Commercial 50 or Commercial Commercial	

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
18.	Baste interlining to coat front (cont'd) e. Position a 5/8 inch wide bridle stay tape adjacent to and behind breakline of each lapel from gorge to 1 to 1-1/2 inches from bottom of lapel. Baste tape even and smooth for a distance of 1-1/2 to 2 inches from gorge, then hold tape taut for a distance of 4 to 5 inches to work in not less than 1/2 inch or more than 5/8 inch breast fullness. The balance of the tape shall be stitched without tautness or fullness. Tape and interlining shall be stamped to assure amount of fullness. f. Pad (blindstitch) each lapel of coat with 6 to 8 equally spaced rows of stitching with fullness of interlining between the rows of stitching to roll lapel. g. Blindstitch bridle stay along both edges. h. After the lapels are padded, the left and right fronts shall be pressed individually on the left and right coat chest machine respectively to conform to the shape of the body.	Hand or Machine 103 or 306 103 or 306	SSm-6 to 8 SSm-2	4-8 4-8	70 70 70 70	Commercial 70 70
19.	Join side bodies and back a. Join back to side bodies, face to face, 1/2 inch from the edge. b. Press seams open and flat.	301 or 401	SSa-1	10-14	30 30	30 50

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
19.	Join side bodies and back (cont'd)					
	c. Stitch a 3/16 inch wide herringbone tape on back of armhole 1/2 to 3/4 inch from top of shoulder to approximately 1 inch in back of underarm seam, holding tape taut to draw up material and working in proper fullness.	301 or 401	SSaa-1	10-14	50 50	50 70
	d. Stitch a 3/8 inch wide tape strip to back neckline	301 or 401	SSa-1	10-14	50 50	50 70
	e. Press tapes.					
20.	Shape lapels and fronts					
	a. Position lapel shaper on breakline of lapel and mark as indicated by the shaper.					
	b. Trim lapel, front and bottom edges of coat front. The front edge of left front shall be straight with the bottom edge right angled.					
	c. Trim bottom of right front 1/4 inch at front tapering to nothing 5 inches from front edge, so that the right front will not extend below the left front in the finished coat.					
	d. Trim interlining 1/4 to 5/16 inch back from lapel and front edges. Interlining at bottom may be cut diagonally so that bottom edge is not caught in tape stitching.					
	e. Marking and trimming of lapels, fronts and bottom edges may be performed with a clicker machine.					

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
21.	Baste and join facings to coat front					
	a. Match, fit and baste facing to each front putting in proper lapel and breast fullness. The facings shall be held slightly taut at bottom edges of foreparts.	Hand or Machine				Commercial
	b. Tape on lapel edge shall be sewn natural and smooth without material take-up and held taut from bottom of lapel breakline to bottom edge.					
	c. Stitch a 3/8 inch wide tape strip to edge of coat front and facing from lapel notch, across top of lapel down front and across bottom to a point 2 to 3 inches beyond back edge of facing.	301	SSab-1	10-14	50	50
	d. Blindstitch back edge of tape to interlining on fronts and lapels.	103 or 306	SSm-1	3-4	50 50	50
*	NOTE: As an alternate to operations b and c a 5/8 inch fusible tape may be used in lieu of the 3/8 inch tape. When this method is used, the tape must first be stitched according to operation c and then pressed and fused to the interlining. The back edge of the tape does not need to be blindstitched to the interlining.					
	e. Press edges flat and smooth, pull basting threads, and press edge seam open and flat.					
	f. Notch corners of lapels, trim around rounded corner of lapels, bottom corners and front edges. Turn facing to finished position, work out lapels and bottom corner of fronts.					

Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
21	Baste and join facings to coat front (cont'd)					
	g. Baste edge (first basting) across and down lapel and front, and the bottom width of facing.	Hand or Machine			Commercial	Commercial
	h. Turn up bottom of coat to finish 1-1/8 (+ 1/8) inches and baste creased edge of hem across bottom of coat.	Hand or Machine			Commercial	Commercial
	i. Blindstitch complete bottom turn-up of coat.	103 or 301 or 306 or Hand	EF1-1	6-8	0 (silk)	0 (silk)
	j. Baste facings along lapel fronts (second basting) approximately 1 inch from edge holding lower corner of coat rolled in such a manner as to cause lower front edge of forepart to roll inward.	Hand or Machine			0 (silk) A (silk)	0 (silk)
	k. Baste a row of stitching diagonally from lapel break to the point of lapel placing fullness in lapel to allow lapel to roll.	Hand or Machine			Commercial	Commercial
	l. Baste along breakline of lapel, allowing fullness in facing, to permit lapel to roll.	Hand or Machine			Commercial	Commercial
	m. Baste back edge of facing putting fullness over chest.	Hand or Machine			Commercial	Commercial

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
22.	<u>Tack facing to interlining</u> a. Tack the back edge of right facing to the interlining with a row of blindstitching from not more than 2-1/2 inches from the shoulder seam to not more than 2 inches above inside breast pocket opening. Continue the tacking along outer ply of inside breast pocket seam allowance and seam allowance of facing to approximately 2 inches from bottom of coat. b. Tack the back edge of left facing to interlining with a row of blindstitching from not more than 2-1/2 inches from shoulder seam to approximately 2 inches from bottom of coat.	103 or 306 or Hand	SSm-1	2-4	50 or Commercial 50 or Commercial 50 or Commercial	50 or Commercial
23.	<u>Sew shoulder pads</u> Insert shoulder pads between interlining and felt padding and tack to shoulder in proper position.	103 or 306 or Hand	SSm-1	2-4	50 or Commercial 50 or Commercial 50 or Commercial	30 or Commercial 30 or Commercial
24.	<u>Baste lining</u> a. Tack upper back edge of inside breast pocket to interlining with ends of stitching tacked. b. Fit and baste back lining to inside of coat taking in excess material and forming a center back pleat with the fold against the left back or right back. Continue basting across shoulder area and around armhole.	301 or Hand		4-6 3-5	50 or Commercial 50 or Commercial	50 or Commercial Commercial

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
24.	<p>Baste lining (cont'd)</p> <p>c. Flit and baste lining to coat front, tacking in excess material and forming a vertical pleat at each shoulder. Baste around armhole, and down along side seams.</p> <p>d. Fold bottom of lining approximately 1 inch and baste to hem of coat. Basting to allow for felling operation.</p> <p>e. Trim lining along shoulders, armhole and neck edges of front and back with lining extending beyond shoulders, neck and armhole to allow for thickness of shoulder pads and hand or machine felling of armholes.</p>	<p>Hand or Machine</p> <p>Hand or Machine</p>			Commercial	Commercial
25.	<p><u>Join shoulder seam</u></p> <p>a. Join respective backs and fronts at shoulder 3/8 inch from the edge working in proper fullness on backs.</p> <p>b. Press shoulder seam open and flat over a suitable block; holding shoulder seam short and shaping armhole end of seam towards the front.</p>	301 or 401	SSa-1	10-14	30 30	30 50
26.	<p><u>Baste shoulder</u></p> <p><u>Position shoulder interlining and lining and baste upper part of each shoulder on outside and turn coat to inside. Turn under edges of back lining at shoulder and baste upper part of each shoulder with proper fullness on the back shoulder lining, continuing basting across neck at back.</u></p> <p>OR</p> <p>In lieu of basting the lining at the shoulder as required in operations 26, 30.a and hand felling as required in operation 31.b, the front and yoke lining at shoulder may be trimmed to allow for thickness of the shoulder pad and stitched on the inside with fullness properly distributed along the back shoulder lining.</p>	301	SSa-1	10-14	50	50

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
27.	Set collar					
	a. Seam topcollar to front facing at gorge to a point not less than 1 inch back of lapel breakline.	301		10-14	50	50
	b. Tack gorge seam open catching bridle stay in the tacking.	301 or Hand		10-14 2-4	50 or Commercial 50 or Commercial	50
	c. Baste undercollar to coat putting in proper fullness over the shoulder.	Hand or Machine			Commercial	
	d. Raise the lower edge of topcollar and tack the upper edge of the coat and back lining to the collar interlining with overcast stitching from shoulder seam to shoulder seam.	103 or Hand		4-6 2-4	50 or Commercial 50 or Commercial	
	NOTE: This operation shall not be performed when the neck edge (gorge seam to gorge seam) of the topcollar is machine stitched.					
	e. As an alternate (when used in lieu of a braid), form a rayon (lining) hanger by folding the material in half lengthwise with the raw edges turned in, face to face, and stitched 1/16 inch gauge. The finished hanger loop shall measure 3/16 to 1/4 inch wide.	301	EFp-2	10-14	50	50
	f. Stitch the ends of a hanger loop (braid or rayon lining) to neck edge with the loop centered over the center back seam.	301		10-14	50	50

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
27.	Set collar (cont'd)					
	g. The finished hanger loop shall measure 1-3/4 (+ 1/4) inches between inner edges.					
	h. Turn under lower edge of topcollar and baste across neck.	Hand or Machine			Commercial	
	NOTE: This operation shall not be performed when the neck edge (gorge seam to gorge seam) of the topcollar is machine stitched.					
	i. Fell undercollar to neckline of coat by hand or machine and tack corners by hand.	Hand or Machine (hand type felling) or 306	LSa-1	8-10	C (silk) C (silk)	C (silk)
	NOTE: This operation shall be performed after the neck edge (gorge seam to gorge seam) of the topcollar is machine sewn.				0 (silk)	0 (silk)
	j. Tack corners.	Hand		8-10	C (silk)	
	k. Fell or stitch lower edge of topcollar from gorge seam to gorge seam tacking ends of hanger loop.	Hand or 301	SSa-1	8-10 10-14	C (silk) 50	50
	l. Finished collar shall measure as follows: Collar stand (underside) at center back 1-1/4 (+ 1/8) inches. Collar leaf (between top of stand and outer edge on outside) at center back 1-5/8 (+ 1/8) inches.					

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
27.	Set collar (cont'd) m. In lieu of operations 27.d, 27.h, and 27.k, stitch lower edge of topcollar across neck from gorge seam to gorge seam.	301	Similar to SSbd-1	10-14	50	50
29.	Set in sleeves Set sleeves matching front sleeve with front armhole notch and back arm seam with back armhole notch, distributing the fullness.	301 or 401	SSa-1	10-14	30 30	30 50
29.	Press armhole seam Press fullness of sleeve flat around the armhole. Press seam open across top from 3/4 to 1 inch above back arm seam 3 to 4 inches forward of shoulder seam. In pressing armhole seam care shall be taken not to stretch or distort armhole.					
30.	Baste and tack armholes a. Baste around outside armholes positioning front and back lining and shoulder pad and back of shoulder in place or back part of armholes may be basted from the lining side. Baste balance of shoulder lining. The shoulder edge of back lining shall be folded under and lapped over the front lining distributing the fullness properly along the back shoulder lining. NOTE: In lieu of basting and hand felling operations, the shoulder seam may be stitched by machine distributing the fullness properly along the back shoulder lining. b. Bind bottom raw edge of underarm shields.	Hand or Machine			Commercial	
		301	SSa-1	10-14	50	50
		301	BSc-1	10-14	50	50

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Loop
30.	Baste and tack armholes (cont'd)					
	c. Tack all around armhole through all plies of material catching underarm shields at base of armhole.	Hand or 301	BSc-1	2-4 4-6	30 or Commercial 30 or Commercial	30
	NOTE: When armholes are tacked by machine, a loose but properly formed and elastic stitch may be used, and when so tacked, operation 30.d may be omitted. When armholes are tacked by hand, tacking shall be backstitched every other stitch from front notch to side (underarm) seam across top of armhole.					
	d. Tack across base of armhole from sleeve notch on front to side (underarm) seam.	301	SSa-1	4-6	30 or Commercial	30
	e. Trim away excess lining, interlining and shoulder pads.					
	f. Tack sleeve head wadding to armhole from front sleeve notch to back seam of sleeve. The sleeve head wadding shall be positioned with the folded edge adjacent to the edge of armhole, backing cloth side against sleeve and in such a manner as to cause it to fold on itself. The tacking shall be adjacent to the armhole seam and fullness shall be properly distributed. When armhole is tacked by machine, the sleeve head wadding shall be attached in the armhole tacking operation. When sleeve head waddings are tacked by hand, every other stitch shall be backstitched.	Hand or 301		2-4 4-6	30 or Commercial 30 or Commercial	30

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
31.	<u>Complete felling</u>					
	a. Hand or machine fell lining all around armholes. Backstitch pit of armhole from forearm seam of sleeve to side seam areas. The sleeve lining shall be seam on seam with sleeve.	Hand or Machine (hand type)		7 (min.) 6-8	C (silk) A (silk)	
	OR					
	As an alternate, the sleeve lining may be stitched to the armhole on the inside by machine.	301	SSa-1	10-14	50	50
	b. Hand fell lining at shoulder. (See operation 30.a for alternate machine stitched method.)	Hand		8-10	A or C (silk)	
	c. Hand fell corners of lining and facing at bottom.	Hand		8-10	A or C (silk)	
	d. Hand or machine fell lining to bottom of coat with a blindstitch.	Hand or Machine		8-10 6-10	A or C (silk) O (silk)	O (silk)
	e. Hand tack bottom bound edge of underarm shields on the underside to lining.	Hand		6-8 per tack	A or C (silk)	
	f. Hand fell lining along entire opening of sword slit.	Hand		8-10	A or C (silk)	
	g. Front edge of inside pocket may be tacked by hand in lieu of operations 15.i and 22.a. Tack through facing, pocket seam allowance and interlining from corner of pocket opening and down for a distance of not less than 3 inches.	Hand		2-4	A or C (silk)	

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
32.	Press left front					
	a. Press left front prior to buttonhole operations.					
	b. Press right front and right and left lapels before removal of basting thread.					
33.	Mark and stitch buttonholes					
	a. All buttonholes shall be eyelet and, square bar, cut first type, reinforced with well worked over gimp with the stitching securely caught in the fabric and the ends of the gimp pulled through the underside. Buttonholes shall be clean, correctly positioned and the purling finishing on the outside.					
	b. The ends of all buttonholes shall be tacked by hand or machine with 1/4 inch bartack in a separate operation from buttonhole making; securely catching ends of gimp and covering the width of the bar.	Bartack or Hand		21 per bartack 10-12 per tack	B (silk) B (silk) B (silk)	B (silk)
	c. Mark and stitch three 1 to 1-1/8 inch horizontal buttonholes on left front and one on right front to correspond with center buttonhole on left front. The inside edge of eyelets shall be 5/8 to 3/4 inch from the finished edge and positioned as indicated by marks on pattern.	Button-hole	Stitches per size/in 1 1-1/8	Button-hole 53-60 60-70 (not including bartack)	C (silk)	B (silk)
	NOTE: Bottom buttonhole shall be located in a line midway between the depth of hip welt pockets.					

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
33.	Mark and stitch buttonholes (cont'd) d. Buttonholes shall be measured from inside purled edge of eyelet.	Eyelet		22 per eyelet	0 (silk)	0 (silk)
34.	Mark and stitch eyelets a. Mark and stitch three 3/16 inch (inside diameter) eyelets 5-1/2 (+ 1/8) inches from front edge of left front where buttons are to be placed; spacing of eyelets shall correspond with respective buttonholes. b. Purling shall be on outside.					
35.	Cleaning a. Remove all basting threads. b. All ends of stitching shall be trimmed and loose threads removed from the coat. c. All spots and stains shall be removed. Shade tickets shall be removed without injury to the material.					
36.	Pressing a. Press edges of lapels, fronts, collar and bottom of coat on edge pressing machine keeping edges straight along the front edge from the top button/buttonhole to the bottom of the coat. b. Press right and left fronts on right and left breast machine respectively. c. Sleeves shall be roll pressed. d. Press balance of fronts, side seams, and back on body machine.					

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
36.	<p><u>Pressing (cont'd)</u></p> <p>e. On a collar pressing machine, press the bridle area holding the bridle short. Press collar stretching outer edge of collar over the shoulder area. Crease on the breakline first the left side of collar and lapel and then the right side of collar and lapel and shape collar according to the finished shaper to obtain the proper contour without stretching along the edge of the creased breakline. Collar shall not be short nor too long.</p> <p>f. Press armholes and shoulders on an armhole machine.</p> <p>g. Press the armhole solid from the inside creasing the armhole on the front, back and then armpits. The armhole shall be held short while pressing. The crease shall extend from 1/2 inch above the backarm seam downward and around to front of armhole to within 4 inches of the shoulder seam.</p> <p>h. Press lapels. The creasing of the lapels shall extend a uniform distance from the gorge seam. The lapels shall be roll pressed from midway between the gorge seam to bottom of lapel.</p>					
37.	<p><u>Finish pressing</u></p> <p>a. Press coat lining smooth with a hand iron maintaining creased pleats at front shoulder and center back.</p> <p>b. Block armholes and shrink top sleeve on an armhole blocking machine.</p> <p>c. Press any wrinkle missed by previous pressing operations.</p> <p>d. Touch up any areas missed by machine pressing.</p>					

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
37.	Finish pressing (cont'd) e. Remove gloss, creases, and all pressing impressions. f. Place coat on hanger until thoroughly dried.					
*38.	Mark and Sew Buttons a. Hand or machine sewn buttons shall have the thread ends securely tacked off with not less than two stitches and thread ends hidden.	Hand or 101 or 301 or 801 (see Figure 3)		4 per button double thread 14-16 per button 14-16 per button 12 (min) per button nylon	12/4 or 16/4 20/4 20/4 No. 4	20/4
	b. Right front - Mark place for three buttons 5-1/2 (+ 1/8) inches from front edge of right front to correspond with buttonholes on left front. Sew a 35-line hopper back button with the eagle upright on each mark as follows: - top and center buttons thru front and interlining or thru front, interlining and outer ply of inside pocket. Center button may be sewn thru all plies when it does not restrict use of inside pocket. - bottom button thru front and interlining or thru all plies of material.					

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
38.	Mark and Sew Buttons (cont'd) c. Left front - Insert back of 35-line hopper back button with permanently attached bodkin type toggle through each eyelet of left front and secure by setting bodkin. d. Sew a 30-line plastic button on the inside of the left front to correspond with buttonhole eyelet on right front and button eyelet of left front. Stitching shall be sewn through both plies of the rayon fly. Button thread shall be tightly wrapped not less than four times around to form a 1/8 (+ 1/16) inch shank. e. Hand tack the edge of the rayon fly to the left front facing in line with the middle hopper back button eyelet. f. Sew a 24-line button on the left coat front lining to correspond with buttonhole eyelet in sword vent flap. Stitching shall be caught through sword vent facing.	Hand		6-8 per tack	A or C (silk)	
39.	Attach size ticket (See 3.3.14.2.)					

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* 3.8 Sizes and measurements. Sizes and measurements of finished coat shall be as shown in Table II (see Figure 1). All measurements are expressed in inches.

Table II Sizes and Finished Measurements

Size	Chest	(A)				Coat Length(B)				Sleeve Length(C)			
		X-Short	Short	Regular	Long	X-Long	X-Short	Short	Regular	Long	X-Long	X-Short	Short
33	36	26 1/8	27 5/8	29 1/8	30 5/8	32 1/8	15	16	17	18	19		
34	37	26 1/4	27 3/4	29 1/4	30 3/4	32 1/4	15	16	17	18	19		
35	38	26 3/8	27 7/8	29 3/8	30 7/8	32 3/8	15	16	17	18	19		
36	39	26 1/2	28	29 1/2	31	32 1/2	15	16	17	18	19		
37	40	26 5/8	28 1/8	29 5/8	31 1/8	32 5/8	15	16	17	18	19		
38	41	26 3/4	28 1/4	29 3/4	31 1/4	32 3/4	15	16	17	18	19		
39	42		28 3/8	29 7/8	31 3/8	32 7/8		16	17	18	19		
40	43		28 1/2	30	31 1/2	33		16	17	18	19		
41	44		28 5/8	30 1/8	31 5/8	33 1/8		16	17	18	19		
42	45		28 3/4	30 1/4	31 3/4	33 1/4		16	17	18	19		
43	46		28 7/8	30 3/8	31 7/8	33 3/8		16	17	18	19		
44	47		29	30 1/2	32	33 1/2		16	17	18	19		
45	48		29 1/8	30 5/8	32 1/8	33 5/8		16	17	18	19		
46	49		29 1/4	30 3/4	32 1/4	33 3/4		16	17	18	19		
47	50		29 3/8	30 7/8	32 3/8	33 7/8		16	17	18	19		
48	51		29 1/2	31	32 1/2	34		16	17	18	19		
Tolerance		+ 1	+ 1/2	+ 1/2	+ 1/2	+ 1/2	+ 1/2	+ 1/2	+ 1/2	+ 1/2	+ 1/2	+ 1/2	+ 1/2

NOTE: Chest, waist, and length of coat measurements shall be taken with coat fully buttoned, placed smooth and flat.

A. Chest - Twice the measurement taken across front at the base of armholes from folded edge to folded edge.

B. Coat Length - Measurement taken from the base of undercollar (seam), down center back to bottom of coat.

C. Sleeve length - Measurement taken from the base of armhole, along inseam to bottom of sleeve.

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3.9 Workmanship. The finished coats shall conform to the quality of product established by this specification. As a final step in the contractor's production control plan before formation of a lot, each dress coat shall be examined after pressing and prior to folding for packaging, and a coat containing a selected defect shall not be included in the end item lot. Selected defects are those defects listed in MIL-STD-1490 indicated by an asterisk (*). The occurrence of defects shall not exceed the applicable acceptable point value or defect limit.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract, 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 submitted, the Government reserves the right to check test such items to determine the validity of the certification.

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

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

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

4.4 Quality conformance inspection. Sampling for inspection shall be performed in accordance with MIL-STD-1490.

* 4.4.1 Component and material inspection. In accordance with 4.1, components and materials shall be inspected and 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 purchase document. The contractor shall furnish a certificate of compliance for the resin treatment requirements of 3.3.3, the type requirements of 3.3.11.3 and the colorfastness requirements of 3.3.8.

* 4.4.2 End item examination. Sampling and examination of the end item shall be performed in accordance with the provisions of MIL-STD-1490.

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* 4.4.5 Packaging inspection. Packaging inspection shall be in accordance with MIL-STD-1490.

5. PREPARATION FOR DELIVERY

5.1 Packaging. Packaging shall be level A or C (see 6.2).

5.1.1 Level A. Each coat shall be laid back down and the shoulder form, conforming to Figure 2, inserted into the coat so as to fit snugly into the collar and shoulders. The buttonhole front shall overlap the button front. The sleeves shall be positioned full length so that sleeve ends rest over pockets. The coat shall then be folded in half by bringing the bottom up even with the collar creased edge so that the folded coat measures approximately 23 by 15 inches.

5.1.2 Level C (Commercial Packaging). Coats 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).

5.2.1 Level A. Five coats of one size only, packaged as specified in 5.1.1, shall be packed in a fiberboard shipping container assembled, closed and reinforced conforming to Type SF, class weather-resistant, grade V2s, size 2A of MIL-B-17757. The fiberboard used for fabricating the box liner shall conform to type CF, class weather-resistant, variety DW, grade V15c of MIL-B-17757. Level A folded coats shall be stacked flat, collars alternated, five in depth within a shipping container. Each container shall have the contents completely covered on the top and bottom with a sheet of commercial grade kraft paper. Toward the end of the contract, or when there are less than the required amount per container of the same size, mixed sizes may be packed within the same shipping container.

* 5.2.2 Level B. Five coats of one size only, packaged as specified in 5.1.1, shall be packed in a fiberboard shipping container assembled and closed conforming to class domestic, grade 275, size 2A of MIL-B-17757. The fiberboard used for fabricating the box liner shall conform to type CF, class domestic, variety DW, grade 200 of MIL-B-17757. Level A folded coats shall be stacked flat, collars alternated, five in depth within a shipping container. Each container shall have the contents completely covered on the top and bottom with a sheet of commercial grade kraft paper. Toward the end of the contract, or when there are less than the required amount per container of the same size, mixed sizes may be packed within the same shipping container.

5.2.2.1 When specified (see 6.2), the shipping container shall be a grade V3c, V3s or V4s fiberboard box fabricated in accordance with MIL-B-17757 and closed in accordance with the appendix of the box specification.

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5.2.3 Level C (Commercial Packing). Coats, packaged as specified in 5.1, shall be packed 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 U.S. Postal Service 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, interior packages and shipping containers shall be marked in accordance with MIL-STD-129.

5.3.1 Labels, mixed sizes. Each shipping container, packed with mixed sizes, shall have securely attached to the end and side, directly under the printing or stencilling, a white paper label 5 by 4 inches with the words "MIXED SIZES" plainly stamped or printed thereon and under these words shall be legibly stamped or printed the correct quantity and sizes contained therein.

6. NOTES

* 6.1 Intended use. The coat specified herein is part of the service dress winter uniform worn by Naval male Chiefs and Officers.

6.2 Ordering data. Procurement documents should specify the following:

- a. Title, number and date of this specification.
- b. Sizes, classes and lengths required (see 1.2).
- c. When coat and trousers are procured as a uniform (see 1.3).
- d. When first article sample is required (see 3.2).
- e. Levels of packaging and packing required (see 5.1 and 5.2).
- f. When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).

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

* 6.4 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.

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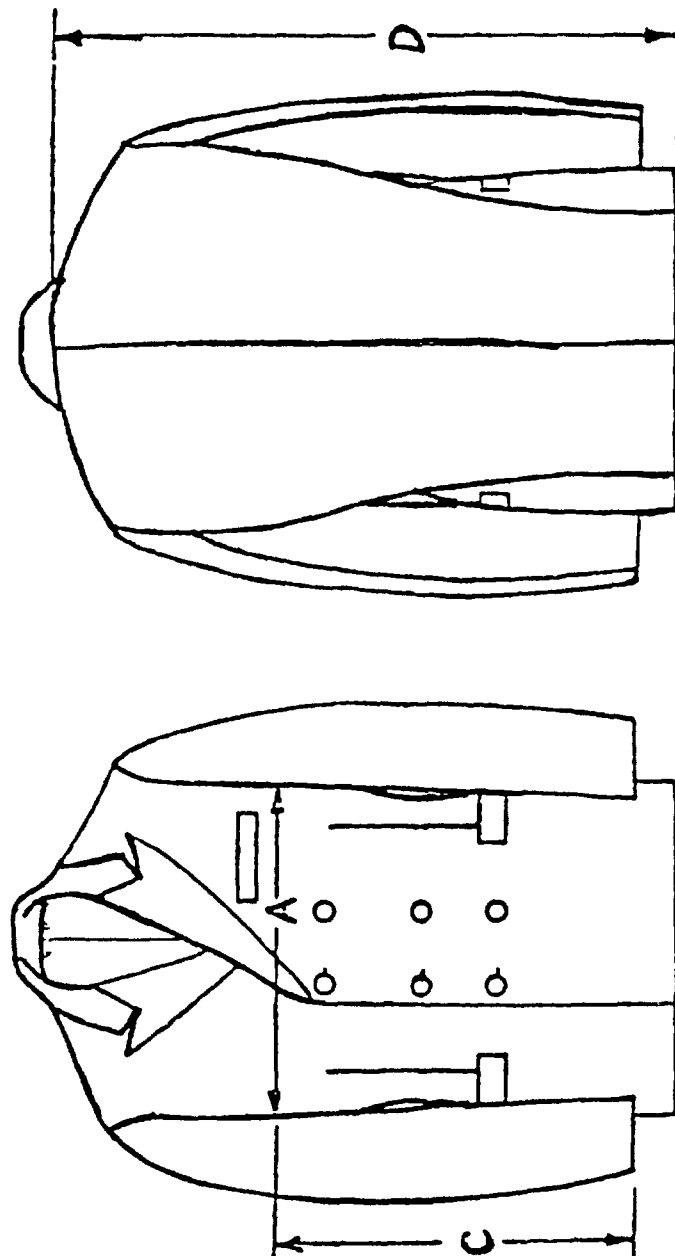
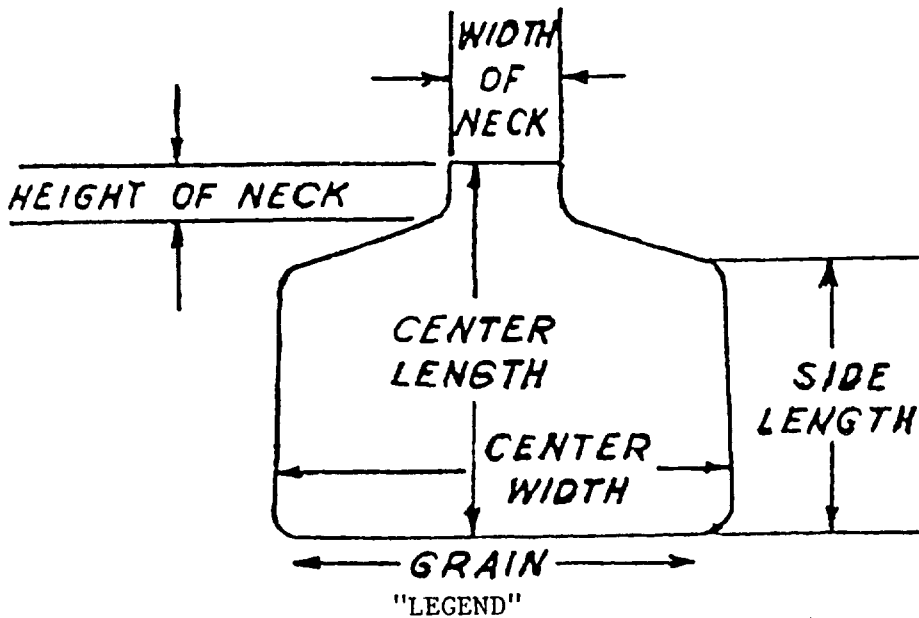


FIGURE 1- COAT, MAN'S, WOOL, WINTER



Center Length	14 1/2 inches
Center Width for Sizes:	
33-37	15 inches
38-42	18 inches
43-48	21 inches
Side Length	10 1/2 inches
Height of Neck	1 1/2 inches
Width of Neck	3 1/2 inches
Paperboard	0.040 inch thick

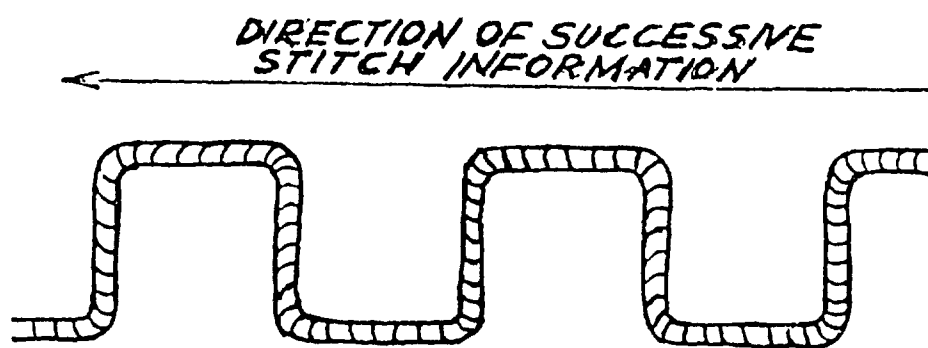
NOTES:

SLOPE SO THAT NO CORNERS WILL TEAR CLOTHING.
 ALSO ROUND CORNERS OFF AT BOTTOM OF FORM
 TO PREVENT TEARING OF CLOTHING.
 ALL ABOVE MEASUREMENTS ARE APPROXIMATE.

FIG. 2 - SHOULDER FORM

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Stitch Class 800 - This class of stitch shall be formed with one or more needle threads and has for a general characteristic that the thread does not interloop with itself or any other thread or threads. The thread is passed completely through the material by means of a double pointed center eye needle and returned by another path. This class of stitch simulates hand stitching.



This type of stitch shall be formed with one needle thread which is passed completely through the material and returned by another path after the material has been moved forward one stitch length.

FIGURE - 3 - STITCH TYPE 801

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MIL-C-29106B(NU) Coat, Man's, Wool, Winter

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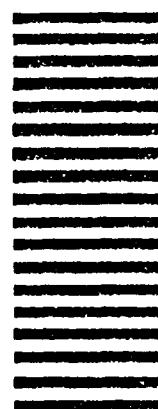
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