

INCH-POUND
MIL-C-29107C(NU)
7 June 1989

SUPERSEDING
MIL-C-29107B(NU)
16 March 1982

MILITARY SPECIFICATION

COAT, MAN'S, POLYESTER/WOOL

This specification is approved for use by the 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 blue double breasted dress coat fabricated from polyester/wool tropical blend cloth.

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

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

1.2.2 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.

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

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2. APPLICABLE DOCUMENTS

2.1 Government documents.

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

SPECIFICATIONS

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 |
| * NN-P-71 | - Pallet, Material Handling, Wood, Stringer Construction, 2 Way and 4 Way (Partial) |
| 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-B-3461 | - Buttons, Insignia, Metal, Uniform and Cap |
| * MIL-P-15011 | - Pallet, Material Handling, Wood, Post Construction, 4 Way Entry |
| MIL-C-15062 | - Cloth, Flannel, Wool, Undercollar Cloth |
| MIL-P-15064 | - Pads, Shoulder and Sleeve-Head |
| MIL-C-15065 | - Coat Fronts |
| MIL-C-16375 | - Cloth, Wigan, Cotton |
| MIL-B-17757 | - Boxes, Shipping, Fiberboard, (Modular Sizes) |
| MIL-C-21115 | - Cloth, Tropical; Wool; Polyester/Wool |
| MIL-C-29137 | - Cloth, Felt Fabric Composite, Undercollar |
| * MIL-T-43548 | - Thread, Polyester Core: Cotton-, Rayon-, or Polyester-Covered |
| * MIL-C-43718 | - Cloth, Polyester; Polyester and Cotton; Polyester and Rayon, for Pockets |
| * MIL-C-44121 | - Cloth, Twill, Polyester |

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STANDARDS

FEDERAL

- * FED-STD-191 - Textile Test Methods
- FED-STD-751 - Stitches, Seams, and Stitchings

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- MIL-STD-129 - Marking for Shipment and Storage
- * MIL-STD-147 - Palletized Unit Loads
- MIL-STD-1490 - Provisions for Evaluating Quality of Coats, Men's, Dress
- * MIL-STD-2073-1 - DOD Materials Procedures 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 Naval Publications and Forms Center, (ATTN: NPODS), 5801 Tabor Avenue, Philadelphia, PA 19120-5099.)

* 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 SERVICE MANUAL

(Copies 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, Illinois 60606-5808).

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THE COLOR ASSOCIATION OF THE UNITED STATES

Department of Defense Standard Shades for Sewing Threads

Department of Defense Standard Shades for Buttons

(Application for copies should be addressed to the Color Association of the United States, 343 Lexington Avenue, New York, NY 10016).

* (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.

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.

* 3.3.1 Basic material. The basic material for the coat shall be polyester/wool tropical cloth, 10 ounce, shade Blue 3346, conforming to type III, class 3 of MIL-C-21115. The piece number for the standard sample is 4001369.

* 3.3.2 Lining. The material for lining the fronts, sleeves, left front fly, sword vest flap, yoke, and for the right inside breast pocket welt and facing shall be rayon lining, 3.7 ounce, shade Black 3202, conforming to class 1 of MIL-C-368, piece number 79221. As an alternate, the lining material may be a polyester twill cloth, shade Black 3202, conforming to MIL-C-44121, piece number 87034.

3.3.3 Binding. The material used for the binding the underarm shield shall be as specified in 3.3.2, 3/4 to 7/8 inch wide, cut on a 45 (+ 5) degree angle with the edges treated with a synthetic resin to prevent raveling. Testing shall be in accordance with 4.4.1.

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3.3.4 Collar interlining. The material for the collar interlining shall be cotton, buckram, natural or bleached, 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 and the stiffness requirement shall not be less than 0.015 inch-pounds in the filling.

3.3.5 Undercollar cloth. The undercollar material shall be wool flannel conforming to MIL-C-15062 or a felt fabric composite conforming to requirements specified in 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 the sleeve bottoms shall be cotton, wigan, natural shade, conforming to type I of MIL-C-16375.

* 3.3.7 Pocketing. The material for the welted front pockets, cash pocket, inside breast pocket, and pocket stays shall be twill cloth conforming to class 1 of MIL-C-43718. The shade shall be black and requirements for perspiration and crocking shall not apply.

* 3.3.8 Hanger loop. The hanger loop for the coat shall be cotton tubular braid conforming to type III, class 1 of MIL-B-371 or shall be of the material specified in 3.3.2. The braid shall be black and shall show good fastness to wet-dry cleaning and shall show a crocking rating not lower than 3.0 when tested as specified in 4.4.1.

3.3.9 Coat front interlining. The coat front interlining shall conform to type VI of MIL-C-15065, except that a twill cloth conforming to class 1 of MIL-C-43718 may be used as an alternate for the shoulder piece. The interlinings shall be dyed black.

3.3.10 Shoulder and sleeve-head pads. The shoulder and pads shall conform to type I, class 1 and the sleeve-head pads shall conform to type IV of MIL-P-15064.

3.3.11 Tapes.

3.3.11.1 Woven tape. The tapes for staying the coat shall be cotton, preshrunk, conforming to types I and II and class 1 or 2 of DDD-T-86. The types and widths of the tapes shall be as follows:

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

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

3.3.11.2 Cross-cut and bias-cut tapes. The stay tapes shall be cut from twill cloth, dyed or undyed, conforming to class 1 of MIL-C-43718. The raw edges of the cross-cut tape shall be treated with a synthetic resin to prevent ravelling and shall be tested in accordance with 4.4.1. The types and widths of the tapes shall be as follows:

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Cross-cut - 1/2 inch wide for back neck

Bias-cut - 3/4 inch wide for shoulder, upper part of front armhole, and front neck gorge

* 3.3.11.3 Tape, fusible. As an alternate for joining the front facing the tape shall be woven or non-woven, natural color, with a thermoplastic polyamide resin applied to the tape, and 5/8 inch in width. Testing shall be in accordance with 4.4.1.

3.3.12 Thread.

* 3.3.12.1 Thread polyester covered. The thread shall be cotton-covered or rayon-covered polyester core conforming to MIL-T-43548. The color of the thread shall be dyed shade Black AA, CA 66043 in accordance with the Department of Defense Standard Shades for Sewing Threads. The use of polyester-covered, polyester core thread is not allowed. The thread shall be as follows:

Use	Ticket No.	Ply
Seaming, stitching, buttonholes and bartacks	30, 50, 70	2 or 3
Button sewing	50	2 or 3

3.3.12.2 Thread, cotton. As an alternate to the polyester-core 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 in accordance with the Department of Defense Standard Shades for Sewing Threads, conforming to V-T-276 as follows:

Use	Type	Ticket No.	Ply
Seaming, stitching, and blindstitching	IA3	70	2
	IA3	30, 50	3
	IC2	A	3
Tacking armholes and attaching sleeve-head pads	IA1 or IA2	30	3
Button sewing	IA3 or IB3	12, 16, 20	4

3.3.12.3 Silk thread. The silk thread shall be dyed shade Black AA, Cable No. 66043 in accordance with the Department of Defense Standard Shades for Sewing Threads, conforming to V-T-301 in the following types and sizes:

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Use	Type	Class	Ticket No.	Ply
Machine felling and blindstitching	I	-	0	3
Buttonholes and bartacks	I	-	B, C	3
Hand felling	III	3	A, C	2

3.3.12.4 Silk thread alternate. The following threads may be utilized as alternate to the silk thread 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 monofilament 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.

3.3.12.5 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 in accordance with test methods outlined in V-T-295.

* 3.3.12.6 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 MIL-T-43548, V-T-276, V-T-285, V-T-295, or V-T-301. As a limit of acceptability, or when no standard sample is available, the dyed threads shall show a minimum of good colorfastness to wet-dry cleaning and light when tested as specified in MIL-T-43548, 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. As a limit of acceptability, or when no standard sample is available, the dyed gimp shall show a minimum of good fastness to wet-dry cleaning when tested as specified in V-T-280.

3.3.14 Buttons.

* 3.3.14.1 Metal buttons. The plated metal buttons for the fronts shall be type I, style 4, class A (Gold, Officer) or class C (Silver, NJROTC), 35-line, hopper back, conforming to MIL-B-3461 (see 6.2). The buttons for the left front shall be furnished with a bodkin type toggle.

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* 3.3.14.2 Plastic buttons. The plastic buttons shall be type II, class D, styles 20 and 21, 30-line for inside anchor button and 24-line for sword vent flap conforming to V-B-871. The buttons shall be Black BT, Cable No. 62001 in accordance with the Department of Defense Standards Shades for Buttons.

3.3.15 Labels.

* 3.3.15.1 Identification and size label. Each coat shall have a combination identification and size label conforming to type VI, classes 1 and 2 of DDD-L-20. The label marking shall show colorfastness to dry cleaning. The inscription shall be as follows:

COAT, MAN'S, 55% POLYESTER/45% WOOL
 LINING, 100% RAYON (Example)
 CONTRACT NO: DLA 100-00-0-0000 (Example)
 STOCK NO: 8405-00-000-0000 (Example)
 SIZE: 38R (Example)
 NAME OF CONTRACTOR:
 NAME OF MANUFACTURER: (If other than contractor)

NOTE: The length (Extra Short, Short, Regular, Long, and Extra Long) may be abbreviated as XS, S, R, L, or XL.

3.3.15.2 Personal instruction label. Each coat shall have a combination personal and instruction label conforming to type VI, 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:

DRY CLEAN ONLY
 ROLL PRESS SLEEVES AND LAPELS

* 3.3.16 Removable size ticket. A commercial type 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 stitches per tack by machine or 2 to 4 stitches per tack by hand.) The corners may be double perforated for ease in tacking. The tickets shall be made of suitable commercial cardboard and shall be legibly printed with the following information:

Size - 38 Regular (Example)

The length (Extra Short, Short, Regular, Long or Extra Long) may be abbreviated as XS, S, R, L, or XL.

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* 3.4 Design. The sack coat shall be semi-fitted, double breasted, half lined with three Navy eagle metal buttons on each front. The coat shall have semi-peaked lapels, front and side body, two-piece back, one welted outside breast pocket, two welted lower front hip pockets, cash pocket inside right hip pocket, one inside right breast pocket, and a sword vent with flap in side seam of left forepart (see Figures 1 and 2).

3.4.1 Figure. The figures are furnished for information purposes only. When inconsistencies exist 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). 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. The patterns allow 3/8 inch for all seams, except as otherwise indicated in Table I.

* 3.5.1 Pattern parts. The component parts shall be cut from the materials specified and in accordance with the following pattern parts:

<u>Material</u>	<u>Pattern parts</u>	<u>Cut parts</u>
Cloth, Tropical, Polyester/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
	Sword vent facing	1
Cloth, Lining	Front lining	2
	Back-Yoke lining	1 <u>1/</u>
	Top sleeve lining	2
	Under sleeve lining	2
	Front fly (left side)	2
	Pocket welt and facing (right inside breast pocket)	1
	Sword vent flap lining	1

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<u>Material</u>	<u>Pattern parts</u>	<u>Cut parts</u>
Twill cloth	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
	Inside breast pocket stay	2
	Cash pocket	- 2/
Cloth, felt fabric composite	Undercollar, composite (bias)	1 3/
Cloth, wool, flannel	Undercollar, flannel (bias)	2 4/
Cloth, cotton, buckram	Undercollar, interlining (bias)	2 4/
Cloth, cotton wigan	Sleeve interlining (bias)	2 -
Templates	Undercollar shaper	-
	Lapel shaper	-
	Finished lapel and collar shaper	-
	Undercollar stand marker	-

1/ Pattern may be cut as two pieces

2/ Pattern to be supplied by the contractor

3/ Pattern shall be cut as one piece only

4/ 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 the requirements of FED-STD-751. Whenever two or more methods for seam or stitch types are given for the same part of the operation, anyone of them may be used. Seam allowances shall be maintained with seam sewn so that no raw edges, runoffs, twists, pleats, puckers or open seams result. All seams shall start and finish evenly. Thread tension shall be maintained so that there is no tight or loose stitching. Where stitch type 401 is used, the looper (underthread) shall be on the inside of the coat. Ends of all seams produced by stitch type 401 shall be caught in other seams or stitching. Buttonholes shall be cut clean and the stitching shall be securely caught in the fabric. Unless otherwise specified, topstitching and edgestitching shall be 1/16 inch from the 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 (except label) shall be overlapped not less than 1/2 inch. The ends of the label stitching (except removable size label) shall be overlapped not less than 3 stitches. Thread breaks (all stitch types) shall be secured by stitching back of the break not less than 1/2 inch. Skipped stitches or thread breaks of 401 stitching shall be repaired by using 301 stitch type.

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

* 3.7 Manufacturing operations requirements. The coat 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 coat is identical to those produced by following the sequence of operations as listed in Table I. Minor modifications are permitted where necessary when using automatic equipment. These modifications shall not alter the appearance, serviceability, or dimensional requirements cited in this specification.

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

3.7.2 Shade and size marking. The component parts of the coat shall be marked or ticketed to insure a uniform shade and size throughout the garment. Any method may be used except:

(1) Corrosive metal fastening devices. No metal device or sew-on type marking shall be used on lining.

(2) Adhesive type tickets which discolor or adhere to the material upon removal of tickets.

NOTE: The use of ink pad numbering machine, rubber stamp or pencil is allowed, provided the numbering does not show on the outside of the garment and wherever possible, is covered by the seam allowance.

* 3.7.3 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
smr	-	similar
Btnhl	-	Buttonhole
incl	-	including
dbl	-	double
chnstch	-	chainstitch

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TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
1.	<p><u>Cutting.</u></p> <p>a. Cut the coat in strict accordance with patterns, which show size, shape of component parts, placement of pockets, directional lines, and notches for the proper assembly of all parts. Perforated paper markers and plain paper markers shall not be used on the basic fabric. Felt back paper markers are permitted.</p> <p>b. All component basic material parts shall be cut from one piece of material except the pocket facings, sword vent facing, and underarm shields which may be cut from ends. When armhole shields are cut from ends, they shall match each other.</p> <p>c. All component lining parts shall be cut from one piece of material except bias binding for underarm shields, front fly (left side), sleeve linings, and sword vent flap lining 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> <p>* e. Cut all outside pocket stays 2-1/2 inches wide in the warp direction (see 3.3.7). The length of the individual pocket stays shall be 1-1/2 inches longer than the nominal finished welt lengths specified in operations 11.r and 11.s.</p> <p>f. 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 (see 3.7.2).</p>				

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TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR	
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-1490 shall be removed from production and replaced with non-defective and properly matched components.					
3.	<u>Make sword vent flap.</u>					
* a.	Switch sword vent flap lining to sword vent flap 1/4 inch from raw edges leaving straight edge open.	301 or 401	SSe-2(a)	10-14	50 50 50 70	
* b.	Turn, work out edges and point; trim where necessary, press, and stitch 1/16 inch from finished edge.	301	SSe-2(b)	10-14	50 50	
c.	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 33a, b, and d). Eyelet shall be 5/8 to 3/4 inch from point of flap.	Btn- hole	Stchs per size: 5/8 inch 3/4 inch	Btn- hole stchs 32-38 40-46 (incl tack)	C B (silk)	
d.	The finished sword vent flap shall measure 3-1/2 (+ 1/4) inches long and 2 (+ 1/8) inches deep in the center.					
4.	<u>Make coat front interlinings.</u> The coat front interlinings shall conform to the requirement of 3.3.9.					
5.	<u>Make collar.</u>					
a.	Wool flannel undercollar construction.					
1.	The undercollar 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 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.

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TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	4. Seam buckram interlining at center back overlapping the edges approximately 3/8 inch.	301 or 401	LSa-1	10-14	50	50
	NOTE: This operation shall be omitted when buckram interlining is cut as one piece.				50	70
	5. Pad interlining to wool flannel undercollar with seven to eight rows of blindstitching, the length of 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 or SSm-8	4-8	70	
	6. Press undercollar flat.					
	7. Mark and shape undercollar to conform to undercollar pattern template. 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 template.					
	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 and along straight top edge of topcollar matching and distributing fullness of topcollar between the notches on outer edge of undercollar and topcollar.	Hand or Machine				Comrcl
	NOTE: This operation shall be omitted when top edge of collar is machine felled.					

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TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
	11. Baste along breakline and ends of collar.	Hand or Machine			Comrc1
	12. Trim, turn, and baste edges of topcollar over interlining between wool flannel undercollar and interlining.	Hand or Machine			Comrc1
	13. Fell corners, top and side edges of topcollar to finished undercollar by hand. Top edge may be machine felled with simulated hand stitching. Fullness of topcollar shall be matched and distributed between notches on outer edge of undercollar and topcollar.	Hand or Machine		8-10 6-10	C (silk) 0 0 (silk)
	OR				
	As an alternate - Machine stitched collar ends will be permitted. Stitch, face to face, the top collar to undercollar along ends, trim and turn collar to finished position. Adjusting topcollar and undercollar patterns for machine stitching will be the responsibility of the manufacturer.	301	SSa-1	8-10	50 50
	Stitch undercollar to top collar using a 3/16 inch knife attachment, matching notches and distributing fullness. The interlining edge shall be used as a guide for the finished stitch line and the shape of the collar.	301	SSe-1	10-14	70 70
	Turn collar, force out points and edges and baste collar edge with at least 2 rows of stitching, distributing the collar fullness evenly and rolling the joining seam to underside. The first row of basting shall be 1/4 inch and the second 1 inch from outside edge of collar.				

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NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
	14. Trim neck edge of topcollar to allow for seaming.				
	15. 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 and holding the crease line short. Center area of crease line 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 undercollar material.				
	2. Mark and shape undercollar to conform to undercollar shaper template. Marking and shaping of undercollar 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 edge and along straight top edge of topcollar matching and distributing fullness of topcollar between the notches on outer edge of undercollar and topcollar.	Hand or Machine			Comrc1
NOTE:	This operation shall be omitted when top edge of collar is machine felled (see operation 5.b.6).				
	4. Baste the topcollar to undercollar along creaseline and outer edge putting in proper fullness. The finished collarstand at center shall measure 1-1/4 (+ 1/8) inches.	Hand or Machine			Comrc1
	5. Trim, turn, and baste edges of topcollar.	Hand or Machine			Comrc1

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NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
6.	Fell top and side edges of topcollar to finished undercollar by hand or top edge may be machine felled with simulated hand stitching. Fullness of topcollar shall be matched and distributed between notches on outer edge of undercollar and topcollar.	Hand or Machine		8-10	C	
					(silk)	
					0	0
					(silk)	
	OR					
	As an alternate - Machine stitched collar ends will be permitted. Stitch, face to face, the top collar to undercollar along ends, trim and turn collar to finished position. Adjusting topcollar and undercollar patterns for machine stitching will be the responsibility of the manufacturer.	301	SSa-1	8-10	50	50
	Stitch undercollar to topcollar using a 3/16 knife attachment, matching notches and distributing fullness. The undercollar edge shall be used as a guide for the finished stitch line and the shape of the collar.	301	SSa-1	10-14	70	70
	Turn collar, force out points and edges and baste collar edge with at least 2 rows of stitching, distributing the collar fullness evenly and rolling the joining seam to the underside. The first row of basting shall be 1/4 inch and the second shall be 1 inch from outside edge of collar.					
7.	Trim neck edge of topcollar to allow for seaming.					
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 and holding the creaseline short. Center area of creaseline shall be straight for a distance of 3 to 4 inches.					

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NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
6.	<u>Make sleeves and sleeve linings.</u>					
	a. Join forearm seam of sleeve (basic material) face to face 3/8 inch from edge distributing fullness between notches.	301	SSa-1	10-14	30	30
	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 turnup notches. Trim ends of sleeve interlining even with edges of sleeve.	301 or 401	SSa-1	10-14	50	50 70
	d. Press turnup of sleeve as indicated by notches in pattern.					
	e. Join backarm seam of sleeve face to face 3/8 inch from edge.	301	SSa-1	10-14	30	30
	f. Press backarm seam open and flat.					
	g. Blindstitch top edge of sleeve turnup 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 edge distributing fullness between notches.	301	SSa-1	10-14	50	50
	i. Join the backarm seam of sleeve linings face to face 3/8 inch from edge.	301	SSa-1	10-14	50	50
7.	<u>Attach sleeve lining to sleeve.</u>					
	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 4-8 1/2 to 1-1/2 inches in length	50	50 70 50 or Comrcl

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NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
	c. Pull sleeve through lining and baste turnup of sleeve lining. Sleeve lining shall have not less than 1-1/4 inch turnup.	Hand or Machine			Comrc1
NOTE: The bottom of the sleeve lining may be felled without basting.					
	d. Fell bottom of sleeve lining to sleeve turnup.	Hand or 301 or 306		6-8 6-10 6-10	A or C (silk) 0 (silk) 0 0 (silk)
	e. Turn sleeves to finished position and assemble in pairs.				
8.	<u>Make cash pocket.</u>				
	a. There shall be a cash pocket on the inside of the right hip pocket. Cash pocket shall be made from material specified in 3.3.7 and shall measure 3-3/4 (+ 1/4) inches wide and 3 (+ 1/4) inches deep.				
	* b. The method of construction of the cash pocket shall be at the option of the manufacturer.				
9.	<u>Make back yoke lining.</u>				
	a. A one or two piece yoke is permitted.				
	b. When a two piece yoke is used, stitch center back seam face to face, 1/2 inch from raw edge. When stitching the hem of a two piece yoke, the seam allowance shall be folded towards the right back.	301 or 401	SSa-1	10-14	50 50 50 70
	c. Turn under bottom raw edge 3/16 to 1/4 inch and stitch 1/16 inch from folded edge forming a 1/4 to 3/8 inch finished hem.	301	EFb-1	10-14	50 50
	d. Press a 3/8 to 1 inch pleat at center and press bottom hem flat.				
10.	<u>Join fronts and side body pieces and make sword vent.</u>				
	a. Each front shall consist of two pieces, a front and a side body.				

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NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR	
	b. Stitch the cut out dart front section as indicated by pattern, tapering from a point at the top end to approximately 3/8 inch in the middle and 1/4 inch at the bottom end.	301	SSa-1	10-14	30	30
	c. Press darts open and flat.					
	d. Abut edges of hip pocket openings and zigzag stitch.	304 or Hand	FSa-1	4-8 2-4	50	50 50
*	e. Stitch sword vent flap to side (underarm) seam of left front, face to face, 3/8 inch from edge as indicated by notches on pattern.	301	LSq-2(a)	10-14	50	50
*	f. Stitch sword vent facing to front (underarm) seam of left side body piece, face to face, 3/8 inch from edge as indicated by notches on pattern.	301	LSq-2(a)	10-14	50	50
*	g. Join front (underarm) seam of side body pieces to the side (underarm) seam of left and right fronts, face to face, 3/8 inch from edge (leave the prestitched sword vent flap and facing open as indicated by notches on pattern).	301	SSa-1	10-14	30	30
	h. Press each joining seam open and flat.					
*	i. Turn and topstitch sword vent flap through front and seam allowance.	301	LSq-2(b)	10-14	50	50
*	j. Turn the seam allowance against the sword vent facing and topstitch.	301	LSq-2(b)	10-14	50	50
*	k. Turn vent facing to finished position and press.					
*	l. 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.	Brtck or Hand		21 per brtck 10-12 per tack	B (silk) B (silk)	B
11.	<u>Make welt pockets.</u>					
*	a. There shall be three single welt pockets; one on the left breast and one on each hip.					

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NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	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	SSa-1	10-14	50	50
	c. Stitch 1/4 inch from 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 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 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.	301	SSa-1	10-14	50	50
	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 measurements.					
	h. Stitch welt to front thru 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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NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	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 thru under ply of welt simultaneously catching the prestitched stay. In the finished coat the welt setting seam shall be spread open.	301		10-14	50	50
	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				Comrc1
	q. Press pocket facing-front joining seam open when alternate method in operation 11.h is used.					
	r. The finished outside breast pocket shall measure:					

Inches	<u>33-36</u>	<u>37-39</u>	<u>40-42</u>	<u>43-48</u>	<u>Toler- ance</u>
Length of welt	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

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NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
s. The finished outside hip pockets shall measure:					
<u>Inches</u>	<u>33-36</u>	<u>37-39</u>			
Length of welt	$\frac{6-1}{8}$	$\frac{6-3}{8}$			
Width of welt	1-3/16	1-3/16			
Depth of pocket	6-1/2(XS,S) 7 (R,L,XL)	6-1/2(XS,S) 7 (R,L,XL)			
<u>Inches</u>	<u>40-42</u>	<u>43-48</u>			
Length of welt	$\frac{6-3}{4}$	$\frac{7}{4}$			
Width of welt	1-3/16	1-3/16			
Depth of pocket	6-1/2(XS,S) 7 (R,L,XL)	6-1/2(XS,S) 7 (R,L,XL)			
<u>Inches</u>	<u>Tolerance</u>				
Length of welt	$\pm \frac{1}{8}$				
Width of welt	$\pm \frac{1}{16}$				
Depth of pocket	$\pm \frac{1}{2}$ $\pm \frac{1}{2}$				
2. <u>Make backs.</u>					
a. The back shall consist of two pieces.					
* b.	Turn under edges of center back and side seam allowances of each back piece 1/4 ($\pm 1/16$) inch and blindstitch.	103 or 306	SSba-3(a)	3-6	50 50 50
c.	Join center back seam, face to face, 5/8 inch from folded edge.	301	SSa-1	10-14	30 30
d. Press seam open and flat.					
* e.	Stitch 1/2 inch wide cross-cut tape 1/8 inch from the back neck edge.	301	SSaa-1	10-14	50 50
f.	Fit and baste yoke lining inside of back maintaining the center pleat in the yoke.	Hand or Machine			comrcl

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NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
13.	<u>Stitch tapes to front</u>					
	a. Stitch a 3/4 inch wide woven tape on neck gorge of front 1/8 inch from edge.	301	SSaa-1	10-14	50	50
	b. Stitch a 3/4 inch wide bias-cut tape on each front along shoulder 3/4 to 1 inch from gorge to within 1/2 to 3/4 inch from armhole.	301	SSaa-1	10-14	50	50
	c. Stitch a 3/4 inch wide bias-cut tape 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	SSaa-1	10-14	50	50
	d. Stitch a 3/16 inch wide woven tape on armholes of foreparts from approximately 3/4 inch of underarm seam to approximately 3/8 inch beyond bias-cut tape on armhole; holding tape taut (see operation 18.c for alternate operation).	301 or 401	SSaa-1	10-14	50 50	50 70
	e. Press tapes.					
14.	<u>Prepare front linings.</u>	301	OSf-1	10-14	50	5
	a. Fold and stitch dart in each lining front, as indicated on pattern, 3/8 inch wide at center and tapering to a point on both ends.					
	b. Stitch underarm darts of lining pieces 3/8 inch from edge, leaving an opening on left seam to accommodate sword slit opening.	301	SSa-1	10-14	50	50
	c. Seam right front lining to right front facing, face to face, 3/8 inch from edge; terminating seam 1 to 1-1/2 inches above the bottom of facing-lining assembly to facilitate hem felling operation.	301	SSa-1	10-14	50	50
15.	<u>Make inside breast pocket and attach labels</u>					
	a. There shall be an inside double piped pocket located on right breast of coat as indicated by marks on patterns.					

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NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	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 the identification and size 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 to pocketing. Label shall be located on the pocket ply next to the coat front.	301	LSd-1	10-14	50	50
	OR					
	c. As an alternate, stitch the four sides of label to pocket piece with the top edge of label overlapping lining facing.	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	smlr 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 two rows 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
	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.	301	SSa-1	10-14	50	50

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NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	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.i for alternate operation).	103 or 306	SSm-1	2-4	50	50
	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.					
* 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. Ends of pocket opening shall be securely tacked. In addition, when this machine is used, the contractor may utilize the machine manufacturer's recommended pocket stay material in addition to the specification material. Close top of pocket on the inside by stitching across the joining seam of top piped piece through all plies. Stitch an inside pocket stay from the back end of the pocket to the armhole.	101 and 301		10-14	A-cotton 50	50
	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	LSbj-1	10-14	50	50
16.	<u>Make front fly in left front lining</u>					
	a. Position and stitch, face to face, 3/8 inch from 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 topstitch through fly lining and seam allowance.	301	LSq-2	10-14	50	50
	b. Position and stitch, face to face, 3/8 inch from edge, front edge of fly lining piece to front edge of left front lining piece. Turn to finished position and topstitch though fly lining and seam allowance.	301	LSq-2	10-14	50	50

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NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	c. Join left front facing to left front lining 3/8 inch from edge leaving an opening (fly) between notches as indicated on pattern. Terminate seam as indicated in operation 14c.	301	SSa-1	10-14	50	50
	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
	e. Press seam joining front body lining to the facings and darts flat to one side toward side seam; press pocket smooth and flat, and press open bottom of joining facing seam.					
17.	<u>Baste interlining to coat front</u>					
	a. Baste interlining to coat front from top of outside 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.	Hand or Machine				comrcl
	b. Tack vertical front dart to the interlining. Tack front, back, and across top of outside breast pocket stay to interlining.	301 or Hand		2-4	50 or comrcl	50
	c. Tack hip pocket stay to interlining at front top corner. Tack front edge of hip pocket seam allowance to interlining.	301 or Hand		2-4	50 or comrcl	50
	d. In addition, baste the interlining to coat front as follows:	Hand or Machine				comrcl
	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.					

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NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	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 stamp marked to assure amount of fullness.	Hand or Machine			comrc1	
	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.	103 or 306	SSm-6 to 8	4-8	70	70
	g. Blindstitch bridle stay along both edges.	103 or 306	SSm-2	408	70	70
	h. After the lapels are padded, the left and right fronts shall be pressed individually on a left and right coat chest machine respectively to conform to the shape of the body.					
18.	<u>Join side bodies and back</u>					
	a. Join back to side bodies, face to face, 5/8 inch from edge (side seam).	301 or 401	SSa-1	10-14	30	30
	b. Press seams open and flat.				30	50
	c. Stitch a 3/16 inch wide woven tape on back of armhole 1/2 to 3/4 inch from top of shoulder to approximately one 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
NOTE: As an alternate armholes may be taped in one operation.						
	d. Stitch a 1/2 inch wide cross-cut tape to back neckline.	301 or 401	SSaa-1	10-14	50	50
	e. Press tapes.				50	70

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NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
19.	<u>Shape lapels and fronts</u>					
	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 the tape stitching.					
	e. Marking and trimming of lapels, fronts, and bottom may be performed with a clicker machine using dies conforming to pattern shapers.					
20.	<u>Baste and join facings to fronts and make hem</u>					
	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				comrc1
	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 5/8 inch wide stay tape, 1/8 to 3/16 inch from edge, 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 and LSbj-1	10-14	50	50
	d. Blindstitch back edge of tape to interlining on fronts and lapels.	103 or 306	SSm-1	3-6	50	50

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NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
NOTE: As an alternate to operations 20b and c, a 5/8 inch fusible tape may be used in lieu of the 5/8 inch stay tape. When this method is used, the tape must first be stitched according to operation 20c 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.				
	g. Baste edge (first basting) across and down lapel and front, and the bottom width of facing.	Hand or Machine			comrcl
	h. Turn up bottom of coat to finish 1-1/8 (+ 1/8) inches. Press edge of hem across bottom of coat.				
	OR				
*	As an alternate the bottom edge of the coat may be finished with the 3/4 inch binding in paragraph 3.3.3.	Mchine	BSb-1	10-14	50 50
	i. Turn under bottom edge on back sections of coat 1/4 (+1/16) inch to a point extending just beyond side seams and baste complete turnup across bottom of coat.	Hand or Machine			comrcl
	j. Blindstitch complete bottom turnup of coat.	301 or 306 or Hand	EF1-1 and EFm-1	6-8	0 0 (silk) 0 0 (silk) A (silk)
	k. 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			comrcl

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NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
	l. 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			comrcl
	m. Baste along breakline of lapel, allowing fullness in facing, to permit lapel to roll.	Hand or Machine			comrcl
	n. Baste back edge of facing putting fullness over chest.	Hand or Machine			comrcl
21.	<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.	103 or 306 or Hand	SSm-1 SSm-1	2-4 2-4 2-4	50 or comrcl 50 50 or comrcl 50 or comrcl
	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 SSm-1	2-4 2-4 2-4	50 or comrcl 50 50 or comrcl 50 or comrcl
22.	<u>Sew shoulder pads</u> Insert shoulder pads between interlining and felt padding and tack to shoulder in proper position.	301 or Hand		2-4 2-4	30 30 or comrcl 30 or comrcl
23.	<u>Baste lining</u>				
	a. Tack upper back edge of inside breast pocket to interlining with ends of stitching backtacked.	301 or Hand		4-6 3-5	50 50 or comrcl 50 or comrcl
	b. Fit and baste lining to coat front taking in excess material and forming a vertical pleat at each shoulder. Baste across shoulders, around armholes, down the side seams to the bottom and across bottom.	Hand or Machine			comrcl

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TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	c. Fold under bottom and sides of lining approximately 1 inch and baste to the coat. Basting to allow for felling operation.	Hand or Machine				comrcl
	d. 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.					
24.	<u>Fell lining</u> Fell the bottom and sides of front lining with a blindstitch.	306 or Hand		6-10	0 0 (silk) A (silk)	
25.	<u>Join shoulder seam</u> a. Join respective backs and fronts at shoulder 3/8 inch from edge working in proper fullness on backs.	301 or 401	SSa-1	10-14	30 30 30 50	
	b. Press shoulder seam open and flat over a suitable block; holding shoulder seam short and shaping armhole end of seam towards the front.					
26.	<u>Baste shoulder</u> Position shoulder interlining and lining and baste upper part of each shoulder on outside and turn coat to inside. Turn under edges of yoke lining at shoulder and baste upper part of each shoulder, with proper fullness on the back shoulder lining, continuing basting across neck at back.	Hand or Machine				comrcl
	OR					
	In lieu of basting the lining at the shoulder as required in operation 26, 30a, and hand felling as required in operation 31b, 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.	301	SSa-1	10-14	50 50	
27.	<u>Set collar</u> a. Seam topcollar to front facing at gorge to a point not less than 1 inch back of lapel breakline.	301	SSa-1	10-14	50 50	

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TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
	b. Tack gorge seam open catching bridle stay in the tacking.	301 or Hand		10-14 2-4	50 50 or comrc1 50 or comrc1
	* c. Mark seam outlet 5/8 inch from raw edge of neckline on coat. Baste undercollar to coat putting in proper fullness over the shoulder.	Hand or Machine			comrc1
	d. Raise the lower edge of top collar 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 comrc1 50 or comrc1
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 hanger from lining material by folding the material in half lengthwise with the raw edges turned in face to face and stitched 1/16 inch from edge. The finished hanger loop shall measure 3/16 to 1/4 inch wide.	301	EPp-2	10-14	50 50
	f. Stitch the ends of a hanger loop (braid or lining) to neck edge with the loop centered over the center back seam.	301		10-14	50 50
	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			comrc1
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 Mchne (hand type felling) or 306	LSa-1	8-10 8-10 8-10	C (silk) C C (silk) 0 0 (silk)

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TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR	
NOTE: This operation shall be performed after the neck edge (gorge seam to gorge seam) of the topcollar is machine sewn. When 306 stitch type is used, the raw edge of the undercollar shall be enclosed within the felling stitches.						
j.	Fell lower edge of topcollar from gorge seam to gorge seam tacking ends of hanger loop.	Hand		8-10	C (silk)	
k.	Finished collar shall measure as follows: - Topcollar (measure from creaseline to outer edge) 1-5/8 (+ 1/8) inches wide at center back. - Collarstand section of undercollar (measure from creaseline to bottom edge) 1-1/4 (+ 1/8) inches wide at center back.					
l.	In lieu of operations 27d, 27h, and 27j, stitch lower edge of topcollar across neck from gorge seam to gorge seam.	301	Smlr to SSbd-1	10-14	50	50
28.	<u>Set in sleeves</u> Set sleeves, matching front sleeve with front armhole notch and back arm seam with back armhole notch, 3/8 inch from raw edge, distributing the fullness.	301 or 401	SSa-1	10-14	30	30 50
29.	<u>Press armhole seam</u> Press fullness of sleeve flat around the armhole. Press seam open across top from 3/4 to 1 inch above back arm seam to 3 or 4 inches forward of shoulder seam. In pressing armhole seam, care shall be taken not to stretch or distort armhole.					

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TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
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 yoke lining shall be folded under and laped over the front lining, distributing the fullness properly along the back shoulder lining.	Hand or Machine			comrcl
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.	301	SSa-1	10-14	50 50
	b. Bind bottom raw edge of underarm shields. Underarm shields shall be made of one ply of basic material.	301	BSc-1	10-14	50 50
	c. Tack all around armhole through all plies of material catching underarm shields at base of armhole.	Hand or 301		2-4 4-6	30 or comrcl 30 30 or comrcl
NOTE:	When armholes are tacked by machine, a loose but properly formed and elastic stitch may be used. 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 side (underarm) seam.	301	SSa-1	4-6	30 30 or comrcl
NOTE:	This operation shall be omitted when armhole is tacked by machine.				
	e. Trim away excess lining, interlining and shoulder pads.				

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TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
	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 comrc1 30 30 or comrc1
31.	<u>Complete felling</u>				
	a. Fell sleeve lining to armholes. Backstitch pit of armhole from forearm seam of sleeve to side seam areas when armholes are hand felled. Sleeve lining shall be seam on seam with sleeve.	Hand or Machine (hand type)		7-10 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 30a for alternate machine stitched method).	Hand		8-10	A or C (silk)
	c. Hand fell sides of front lining the depth of the back yoke.	Hand		8-10	A or C (silk)
	d. Hand fell corners of yoke across side seam outlet.	Hand		8-10	A or C (silk)
	e. Hand fell corners of lining and facing at bottom.	Hand		8-10	A or C (silk)
	f. Hand fell corners of lining and bottom hem at side seam.	Hand		8-10	A or C (silk)
	g. Hand tack bottom bound edge of underarm shields on the underside to lining.	Hand		68 per tack	A or C (silk)
	h. Hand fell lining along entire opening of sword vent.	Hand		8-10	A or C (silk)
	OR				

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TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
	* As an alternate, operations 31c, d, e, f, g, and h may be stitched by machine. The stitching shall not be visible on the outside.	301	SSa-1	10-12	0 nylon or Mercerized cotton
	i. Front edge of inside pocket may be tacked by hand in lieu of operations 15i and 23a. 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)
32.	<u>Press fronts</u> a. Press left front prior to buttonhole operations. b. Press right front and right and left lapels before removal of basting thread.				
33.	<u>Mark and stitch buttonholes</u> a. All buttonholes, except where otherwise specified, shall be eyelet end, square bar, cut first type, reinforced with well worked over gimp with the stitching securely caught in the fabric. When ends of gimp finish on top of the buttonhole they shall be pulled through to the underside. Buttonholes shall be clean, correctly positioned and the purling finished on the outside. b. The ends of all buttonholes shall be bartacked by hand or machine in a separate operation from buttonhole making; securely catching ends of gimp and covering the width of the bar. The bartack shall be not more than 1/4 inch long. 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.	Brck or Hand		21 per brck 10-12 per tack	B B (silk) B (silk)
		Btnhl	Stchs per size: 1 inch 1-1/8 inches	Btnhl 53-60 60-70 (not in- cluding brck)	C B (silk)

NOTE: Bottom buttonhole shall be located between the top of the welt and the bottom seam of the welt.

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TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD		
					NDL	BOB/ LPR	
	d. Buttonholes shall be measured from inside purled edge of the eyelet.						
34.	<u>Mark and stitch eyelets</u>						
	a. Mark and stitch three 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. The inside diameter of the finished stitched eyelet shall be 3/16 inch.	Eyelet		22 per eyelet	0	0	(silk)
	b. Purling shall be on outside.						
35.	<u>Cleaning</u>						
	a. Remove all basting threads.						
	b. All ends of stitching shall be trimmed and loose threads removed from the coat.						
* NOTE: Care shall be taken when trimming thread ends that damage to the fabric does not result.							
	c. All spots and stains shall be removed. Shade tickets shall be removed without injury to the material.						
36.	<u>Pressing</u>						
	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

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB LPR
	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 the 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.				
	f. Press armholes and shoulders on a armhole machine.				
	g. Press the armhole solid from the inside, creasing the armhole on the front, back and then the armpit. The armholes 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.				
	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.				
37. <u>Finish pressing</u>					
	a. Press coat lining smooth with a hand iron maintaining creased pleats at front shoulder and center of yoke.				
	* b. Block armhole and shrink top sleeve on an armhole blocking machine.				
	c. Press any wrinkle missed by previous pressing operations.				
	d. Touch up any areas missed by machine pressing.				
	e. Remove gloss, creases, and all pressing impressions.				
	f. Place coat on hanger until thoroughly dried.				

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TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
38.	<u>Mark and sew buttons</u>					
	a. Hand or machine sewn buttons shall have the thread ends securely tacked off with not less than two stitches and thread ends hidden.					
	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:	Hand		4 per button	50	
		or		double thread		
		101		14-16	50	
	- 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.	or		per button		
		301		14-16	50	50
		or		per button		
		205		12(min)	No. 4	
				per button	nylon	
	- Bottom button thru front and interlining or thru all plies of material.					
	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.	Hand		4 per button	50	
		or		double thread		
		101		14-16	50	
		or		per button		
		301		14-16	50	50
		or		per button		
		205		12(min)	No. 4	
				per button	nylon	
	e. Hand tack the edge of the nylon fly to the left front facing in line with the middle hopper back button eyelet.	Hand		68 per tack	A or C (silk)	

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TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL BOB/ LPR	
	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		4 per	50	
		or		button		
				double		
		101		thread		
		or		14-16	50	
39.	<u>Attach removable size ticket</u> See 3.3.16.			per		
		301		button		
		or		14-16	50	50
				per		
40.	<u>Fold each coat</u> Refer to Section 5 for instructions.	205		button		
				12(min)	No. 4	
				per	nylon	
				button		

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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

Sizes	Chest (A)	Coat Length (B)				
		X-S	Short	Regular	Long	X-Long
33	36	26-1/8	27-5/8	29-1/8	30-5/8	32-1/8
34	37	26-1/4	27-3/4	29-1/4	30-3/4	32-1/4
35	38	26-3/8	27-7/8	29-3/8	30-7/8	32-3/8
36	39	26-1/2	28	29-1/2	31	32-1/2
37	40	26-5/8	28-1/8	29-5/8	31-1/8	32-5/8
38	41	26-3/4	28-1/4	29-3/4	31-1/4	32-3/4
39	42		28-3/8	29-7/8	31-3/8	32-7/8
40	43		28-1/2	30	31-1/2	33
41	44		28-5/8	30-1/8	31-5/8	33-1/8
42	45		28-3/4	30-1/4	31-3/4	33-1/4
43	46		28-7/8	30-3/8	31-7/8	33-3/8
44	47		29	30-1/2	32	33-1/2
45	48		29-1/8	30-5/8	32-1/8	33-5/8
46	49		29-1/4	30-3/4	32-1/4	33-3/4
47	50		29-3/8	30-7/8	32-3/8	33-7/8
48	51		29-1/2	31	32-1/2	34
Tolerance	$\pm 3/4$	$\pm 1/2$	$\pm 1/2$	$\pm 1/2$	$\pm 1/2$	$\pm 1/2$

Sizes	Sleeve Length (C)				
	X-S	Short	Regular	Long	X-Long
33	15	16	17	18	19
34	15	16	17	18	19
35	15	16	17	18	19
36	15	16	17	18	19
37	15	16	17	18	19
38	15	16	17	18	19
39		16	17	18	19
40		16	17	18	19
41		16	17	18	19
42		16	17	18	19
43		16	17	18	19
44		16	17	18	19
45		16	17	18	19
46		16	17	18	19
47		16	17	18	19
48		16	17	18	19
Tolerance	$\pm 1/2$	$\pm 1/2$	$\pm 1/2$	$\pm 1/2$	$\pm 1/2$

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NOTE: Chest and length 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 down center back seam to bottom of coat.

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

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 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).

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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-1490.

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. The contractor shall furnish a certificate of compliance for the resin treatment requirements of 3.3.3 and 3.3.11.2, tape requirements of 3.3.11.3 and the colorfastness requirements fo 3.3.8.

4.4.2 Examination of the end item. Examination of the end item shall be in accordance with the provisions of MIL-STD-1490 and the following:

<u>Defect</u>	<u>Point Value</u>
BUTTONHOLE	

Thread ends on inside of buttonholes not trimmed to less than 1/4 inch:

- | | |
|----------------------------------|---|
| 1. One or more but less than six | 2 |
| 2. Six or more | 3 |

Basic fabric not caught in buttonhole stitching:

- | | |
|----------------------------------|---|
| 1. One or more but less than six | 2 |
| 2. Six or more | 3 |

End of gimp not pulled through to underside:

- | | |
|----------------------------------|---|
| 1. One or more but less than six | 2 |
| 2. Six or more | 3 |

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

* 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.

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<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-Packaging. Packaging shall be level A or C as specified (see 6.2).

* 5.1.1 Level A. Each coat shall be laid back down and a bending or non-bending paperboard shoulder form conforming to Figure 3 shall be 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 the pockets. The coat shall then be folded in half by bringing the bottom portion up even with the collar creased edge so that the folded coat measures approximately 23 by 15 inches. Each coat shall be inserted in a snug-fitting clear polyethylene film bag of not less than 0.003 inch thickness (+ 20% tolerance). All seams and closures shall be formed by heat sealing. A 1/4 inch hole shall be made at one corner of the bag to allow excess air to escape. As an alternate, the polyethylene bag may be of the tuck-in or reverse flap type where a heat seal closure and corner hole are not required.

5.1.2 Level C. Coats shall be packaged to afford adequate protection against deterioration and 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 (5) coats of one size and length only, packaged as specified in 5.1 shall be packed in a fiberboard shipping container assembled, closed and reinforced conforming to type CF, class weather-resistant, variety DW, grade V15c, size 2A of MIL-B-17757. The fiberboard used for fabricating the box liner shall conform to type CF, class domestic 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.

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* 5.2.2 Level B. Five (5) coats of one size and length only, packaged as specified in 5.1 shall be packed in a fiberboard shipping container assembled, closed, and reinforced conforming to type CF, class domestic, variety DW, grade 200, size 2A of MIL-B-17757. The fiberboard used for fabricating the box liner shall conform the type CF, class domestic 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.

5.2.3 Level C. 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 US 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, 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 means C, K, and L or O or P. 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.)

6.1 Intended use. The coat specified herein is part of the service dress uniform worn by Navy male officers and chiefs.

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

- a. Title, number, and date of this specification
- b. Sizes and lengths required (see 1.2)
- c. When coat and trousers are procured as a uniform (see 1.3).
- d. 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).
- e. 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.
- f. Class of metal button required (see 3.3.14.1)
- g. Levels of packaging and packing required (see 5.1 and 5.2)
- h. When palletization is required (see 5.4)
- i. When all packaging data is to be found in MIL-STD-2073-1 and MIL-STD-2073-2 (see 5.5).

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 Recycled materials. It is encouraged that recycled materials be used when practical as long as it meets the requirements of this specification.

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.

* 6.6 Subject term (key word) listing.

Coat, Naval male officers and chiefs uniform
Coat, part of service dress uniform
Coat, polyester/wool tropical

Custodian:
Navy - NU

Preparing Activity:
Navy - NU

Review Activity:
DLA - CT

Project No. 8405-N081

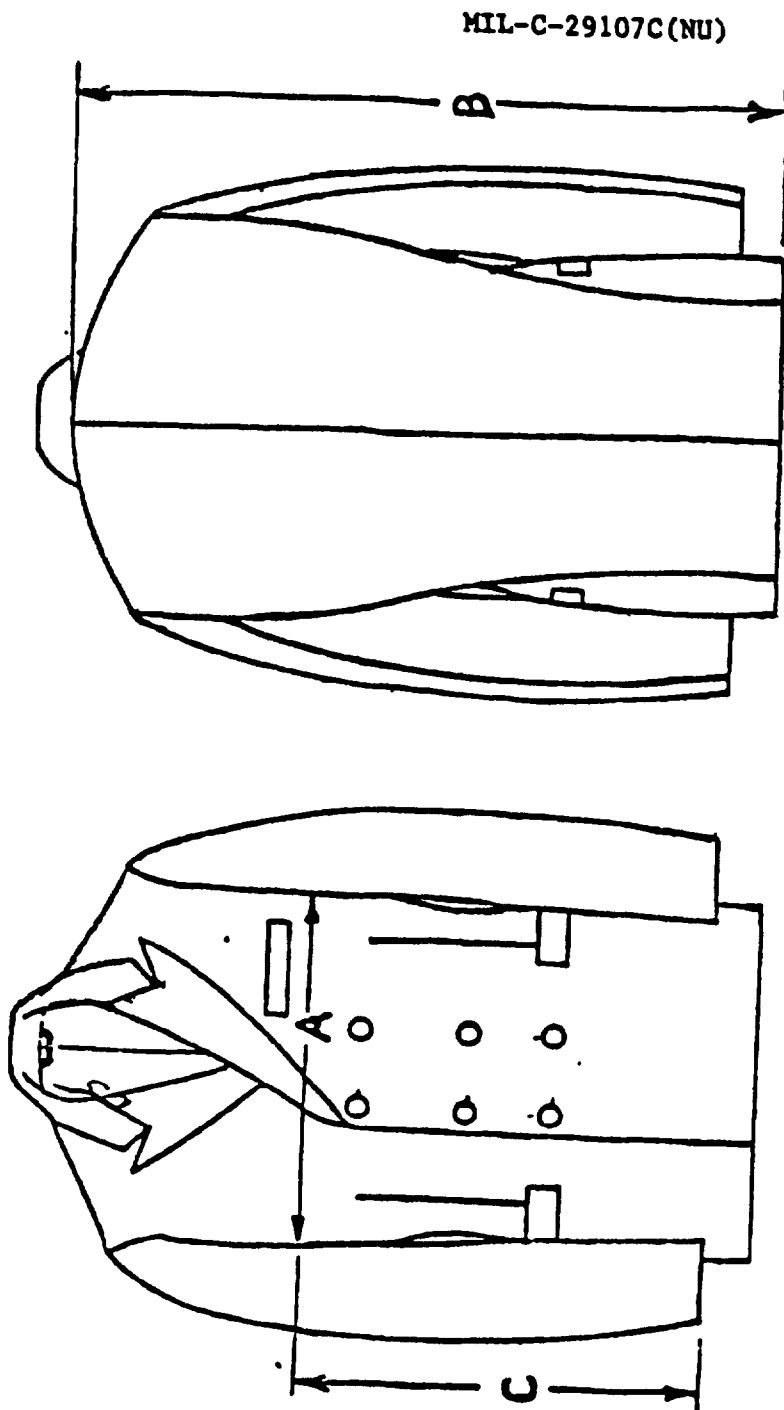


FIGURE 1- COAT, MAN'S, POLYESTER/WOOL

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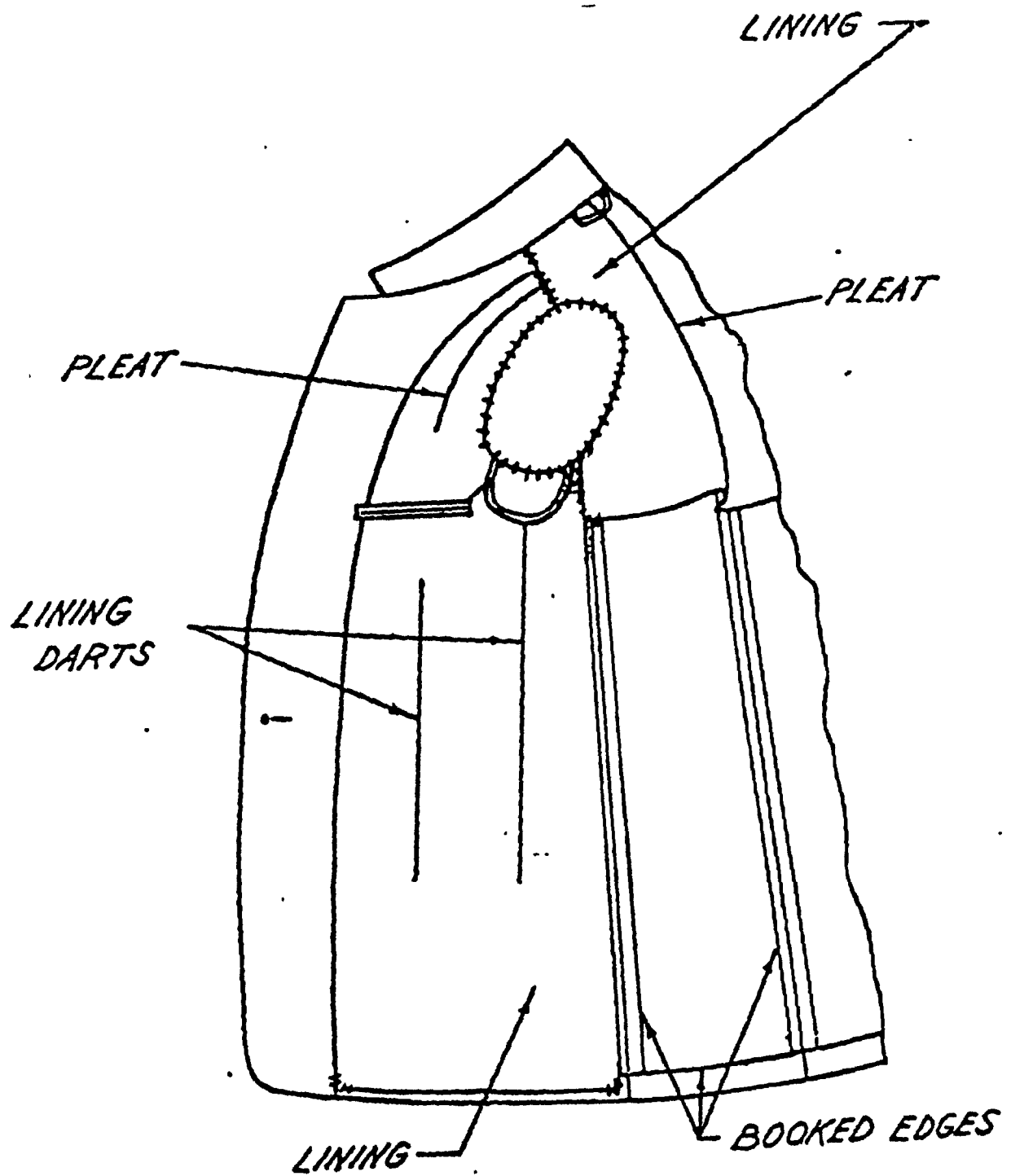
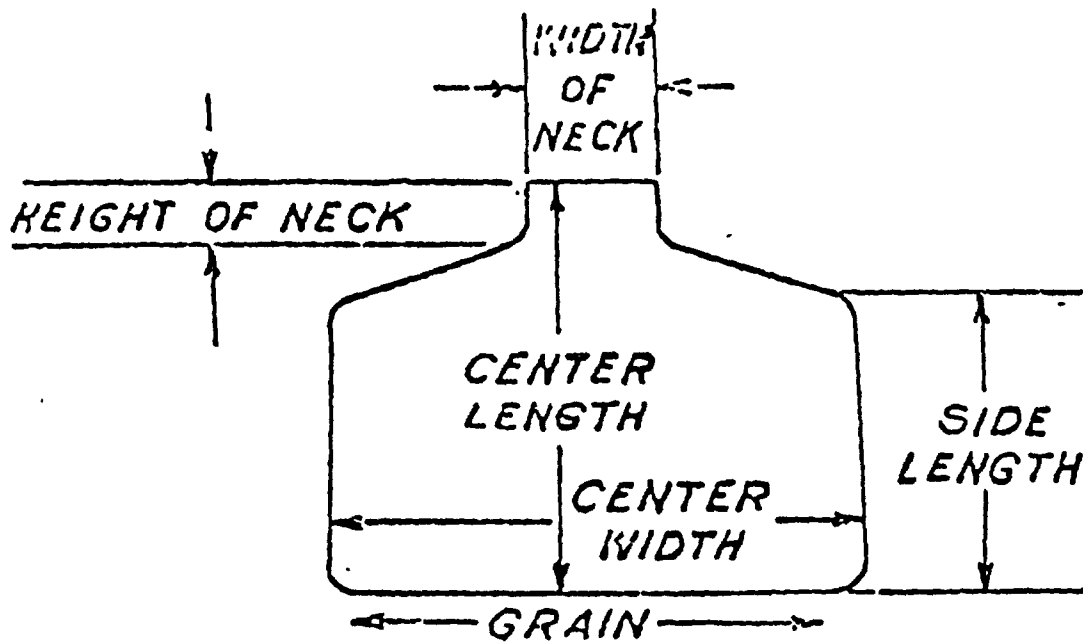


FIG. 2 - COAT, MAN'S, POLYESTER/WOOL

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LEGEND

CENTER LENGTH	14- $\frac{1}{2}$ INCHES
CENTER WIDTH FOR SIZES :	
33-37	15 INCHES
38-42	18 INCHES
43-48	21 INCHES
SIDE LENGTH	10- $\frac{1}{2}$ INCHES
HEIGHT OF NECK	1- $\frac{1}{2}$ INCHES
WIDTH OF NECK	3- $\frac{1}{2}$ INCHES
PAPERBOARD	0.040 INCH THICK

NOTE: ALL MEASUREMENTS ARE APPROXIMATE

FIG. 3-SHOULDER FORM

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