

INCH-POUND

MIL-C-29381C

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SUPERSEDING

MIL-C-29381B(MC)

29 December 1988

MILITARY SPECIFICATION

COAT, ALL-WEATHER, WOMEN'S

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

1. SCOPE

1.1 Scope. This specification covers the requirement for a woman's all-weather coat.

1.2 Classification. The all-weather coats shall be one type in the following classes and sizes, as specified (see 6.2).

Class.

Class 1 - Marine Corps Pewter 2246

Class 2 - Marine Corps Blue 2324

Class 3 - Army Black 385

Sizes.

<u>Short (S)</u>	<u>Regular (R)</u>	<u>Long (L)</u>
4	4	4
6	6	6
8	8	8
10	10	10
12	12	12
14	14	14
16	16	16
18	18	18
20	20	20
	22	22

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to the Commanding General (PSE-C), Marine Corps Research, Development and Acquisition Command, Washington, D. C. 20380-0001, 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 8410

Distribution Statement A. Approved for public release; distribution is unlimited.

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2. APPLICABLE DOCUMENTS

2.1 Government documents

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

SPECIFICATION

FEDERAL

A-A-203	- Paper, Kraft, Untreated
A-A-50083	- Bag, Plastic Folded Garment
A-A-50198	- Thread, Gimp, Cotton, Buttonhole
A-A-50199	- Thread, Polyester Core, Cotton or Polyester Covered
V-B-871	- Button, Sewing Hole, and Button, Staple, (Plastic)
V-F-106	- Fasteners, Slide, Interlocking
V-T-276	- Thread, Cotton
DDD-L-20	- Label: for Clothing, Equipage, and Tentage (General Use)
PPP-F-320	- Fiberboard: Corrugated and Solid, Sheet Stock (Container Grade), and Cut Shapes

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MIL-B-371	- Braid, Textile, Tubular
MIL-B-1860	- Buckle, Slide, Plastic
MIL-T-3530	- Thread and Twine Mildew Resistant or Water Repellant Treated
MIL-P-15011	- Pallet Material Handling, Wood Post Construction 4 Way Entry
MIL-B-17757	- Box, Shipping, Fiberboard (Modular Sizes)
MIL-C-21852	- Cloth, Taffeta, Nylon
MIL-C-29363	- Cloth, Poplin, Polyester and Cotton (Water Repellent)
MIL-L-35078	- Loads, Unit, Preparation of Semiperishable Substance Items; Clothing, Personal Equipment and Equipage; General Specification for
MIL-C-43525	- Cloth, Satin, Acetate or Rayon Face and Rayon or Cotton Back
MIL-C-43718	- Cloth, Twill, Polyester and Cotton, Polyester and Rayon
MIL-C-44192	- Container, Shipping and Storage, Coat (Hanger Pack)
MIL-C-44296	- Cloth, Fusibles

STANDARDS

FEDERAL

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

MILITARY

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

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MIL-STD-147	- Palletized Unit Loads
MIL-STD-731	- Quality of Wood Members for Containers and Pallets
MIL-STD-1494	- Provisions for Evaluating Quality of Raincoat

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

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

Department of Defense Standard Color Card for Sewing Threads
Department of Defense (DOD) Standard Shades for Buttons 1966

Quartermaster Standard Shade of Slide Fastener Tape

(Copies may be obtained from the Color Association of the United States, Inc., 323 Lexington Avenue, New York, New York 10016.)

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 are 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).

American Society for Testing and Materials (ASTM)
D-3951 Standard Practices for Commercial Packaging

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103-1187.)

(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 specification and the references cited herein. The text of this specification shall take precedence. Nothing in this specification, however, shall supersede applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

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

3.2 First article. When specified in the contract or purchase order, a sample shall be subjected to first article inspection and approval (see 4.4 and 6.3).

3.3 Materials.

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3.3.1 Basic fabric. The fabric shall be 65 percent polyester/35 percent cotton poplin cloth, with a durable water repellent finish conforming to MIL-C-29363.

3.3.2 Shell Lining. The material for the body lining, sleeve lining and for binding the back edge of the facing and the liner shall be nylon taffeta cloth, 1.9 ounce, conforming to type IV of MIL-C-21852. The color for class 1 shall be Marine Corps pewter shade to approximate the basic fabric shade. The color for classes 2 and 3 coats shall be black.

3.3.3 Coat Liner. The material for the liner shall be rayon face and rayon or cotton back satin cloth conforming to type II of MIL-C-43525. The color for class 1 shall be Marine Corps pewter shade to approximate the basic fabric shade. The color for the classes 2 and 3 shall be black.

3.3.4 Material for hanger loop. The hanger loop shall be made of the basic fabric specified in 3.3.1 or shall be cotton or rayon braid that conforms to type IX, class 1, of MIL-B-371. Color shall match shade of basic fabric.

3.3.5 Interlining. The interlining for the front, side front, front facing, front flap, topcollar, collar stand, pocket welts, shoulder straps, sleeve straps, sleeve turnup, and belt and for class 3 only, the front flap (upper) shall be non-woven fusible cloth 85% polyester, 15% polyamide or 100% polyester, 1.75 to 2.0 ounces per square yard, polyamide dot. The color shall be charcoal for class 1 and charcoal or black for classes 2 and 3. The fusible cloth shall be Pellon Style 8335 or 8416 or Handler Textiles 71915 or equal to or better.

3.3.6 Slide fastener. The slide fastener for the liner shall conform to type IV, style 1, size L, short tab pull, aluminum chain of V-F-106. The length of the slide fastener shall conform to the below listing. The tape shall be cotton warp and nylon filling, 7/16 to 3/4 inches wide. All the components of the slide fastener shall be aluminum and from the same supplier. As an alternate, 100 percent texturized polyester tape in the slide fastener conforming to V-F-106 may be used.

LENGTH OF SLIDE FASTENERS

Size of Coat	Length in Inches		
	Short	Regular	Long
4	70	74	77
6	70	74	77
8	70	74	77
10	70	74	77
12	70	74	77
14	70	74	77
16	74	77	80
18	74	77	80
20	74	77	80
22		77	80

3.3.7 Color and colorfastness. The slide fastener tape shall be shade AH, cable No. 66533 sage green for class 1 and black shade G, Cable No. 66507 for classes 2 and 3 coats. The tape shall show colorfastness to wet dry cleaning equal to or better than the standard sample (see 6.3). If a standard sample is not furnished, the slide fastener tape shall have good colorfastness to wet-dry cleaning. (See Quartermaster Standard Shades of Slide Fastener Tapes.)

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3.3.8 Buckles. The plastic buckle for the belt shall be a 2-1/4-inch general purpose buckle conforming to class 2 of MIL-B-1860. The color shall be green AF Cable No. 62017 for class 1, blue BV Cable No. 62002 for class 2 and shade black CT62001 for class 3. (See DOD Standard Shades for Buttons 1966).

3.3.9 Buttons. The buttons shall conform to type II, class D of V-B-871 in the following styles and sizes:

	Style	Size
Front, inside anchor and extra	20 or 21	34
Sleeve, shoulder strap, sleeve liner belt and extra	20 or 21	24
Stay	15	18

The buttons shall have a glossy finish and shall be green shade AF Cable No. 62017 for class 1, blue BV Cable No. 62002 for class 2 and black shade CT62001 for class 3. (See DOD Standard Shades for Buttons 1966).

3.3.10 Thread.

3.3.10.1 Polyester/cotton covered. The thread shall be dyed shade taupe A, Cable No. 66030 for class 1, shade blue AB, Cable No. 66044 for class 2, and shade black AA Cable No. 66043 for class 3 and shall conform to A-A-50199 as follows:

USE	Ticket No.	Ply
Seaming, stitching, buttonholes, buttons and bartacks	50 or 70	2 or 3
Buttons sewing	30	2 or 3

The thread shall be water repellent treated in accordance with type II, class 3 of MIL-T-3530.

3.3.10.2 Cotton. The cotton thread shall conform to V-T-276, type IC2, mercerized finish, Ticket No. A, 3 ply for all seaming, stitching and overedge stitching on the removable liner and for stitching the binding on the front and neck facing of the coat. The color of the thread shall be taupe A, Cable No. 66030 for class 1, blue shade AB, Cable No. 66044 for class 2 and shade black AA, Cable No. 66043 for class 3. The polyester/cotton thread may be used as an alternate.

3.3.10.3 Colorfastness. The dyed thread shall show fastness to wet-dry cleaning and light equal to or better than the standard sample when tested as specified in V-T-276 or A-A-50199. When no standard sample is available, the dyed thread shall show "good" fastness to wet-dry cleaning and light when tested as specified in V-T-276 or A-A-50199.

3.3.11 Gimp. The cotton gimp for reinforcing the buttonholes shall be dyed shade taupe A, Cable No. 66030 for Class 1, shade blue AB, Cable No. 66044 for Class 2 and shade black AA, Cable No. 66043 for class and shall conform to type I or II, size 8 of A-A-50198.

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3.3.11.1 Colorfastness. The dyed gimp shall show fastness to wet-dry cleaning equal to or better than the standard sample when tested as specified in A-A-50198. When no standard sample is available, the dyed gimp shall show "good" fastness to wet-dry cleaning when tested as specified in A-A-50198.

3.3.12 Labels.

3.3.12.1 Combination label. Each coat shall have a combination identification and instruction label conforming to type VI, Class 14 of DDD-L-20. The printing shall show fastness to dry cleaning and shall bear the following inscription:

NOMENCLATURE: COAT, WOMAN'S ALL WEATHER
 FIBER CONTENT: Polyester (65%), Cotton (35%)
 CONTRACT NO: DLA-100-00-0-0000 (Example)
 STOCK NO: 8405-00-000-0000 (Example)
 NAME OF CONTRACTOR:

CLEANING INSTRUCTIONS

DRY CLEAN ONLY

3.3.12.2 Size label. Each coat and liner shall have a separate size label conforming to type VI, Class 2 of DDD-L-20 and shall bear the following inscription:

Size: 36R (Example)

The length (Short, Regular and Long) may be abbreviated as follows: S, R and L.

3.4 Design. The class 1 and 2 coats shall be the U.S. Marine Corps design shown on Figures 1 through 6 and the class 3 coat shall be the U.S. Army design shown on figures 7 and 8. The coats have a double breasted front model with belt and buckle, convertible collar, shoulder straps, sleeve straps, hanging pockets, a closed pleated back vent, and zip out liner and shall be water repellant finished. The coats shall also have a two-piece front, two-piece back and two-piece split sleeves. The class 3 coats only shall have a upper front flap (gunpatch), half cape back and extra buttons sewn on the inside facing.

3.5 Patterns. Standard patterns will be furnished to the contractor by the Government. The standard patterns shall not be altered in any way and shall be used only as a guide for cutting the contractor's working patterns. The contractor's working patterns shall be identical to the standard patterns except the standard patterns shall provide 1/4-inch allowance for seams at the edge of shoulder strap, collar, sleeve straps, belt, and facing to front; 3/8-inch allowance for sleeves, sleeve linings, setting sleeves, shoulder seams, collar stand to neck and center front to side front; 5/8-inch allowance for side; 3/8-inch allowance for all seams in the liner, except as otherwise specified in Table I. Additional notches for use during construction are permitted on the working patterns. Also, minor modifications are permitted where necessary when using automatic equipment. These modifications shall not alter the dimensional serviceability or appearance requirements cited in this specification. Standard patterns show size, seam allowances, directional lines for cutting, and are marked or notched for proper placement and assembly of the component parts.

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3.5.1 Pattern parts. Coats shall be cut from the material specified herein in accordance with the pattern parts indicated below.

Item	Pattern Nomenclature	No. of cut parts
Material: Basic fabric		
1.	Center front	2
2.	Side front	2
3.	Back	2
4.	Front sleeve	2
5.	Back sleeve	2
6.	Front facing	2
7.	Collar	2
8.	Collar stand	2
9.	Belt	1
10.	Back vent facing	1
11.	Pocket welt	2
12.	Sleeve strap	2
13.	Shoulder strap	4
14.	Neck facing	1
15.	Pocket facing	2
16.	Front flap (upper left gun patch) - Class 3	2
17.	Outside back yoke - Class 3	1
18.	Hanging Pocket (top ply)	2
19.	Hanging Pocket (under ply)	2
Material: Lining		
20.	Front	2
21.	Back	2
22.	Front Sleeve	2
23.	Back Sleeve	2
Material: Nonwoven Fusible Interlining		
24.	Center front	2
25.	Side front	2
26.	Front facing	2
27.	Belt	1
28.	Shoulder strap	2
29.	Pocket welt	2
30.	Collar	1
31.	Collar stand	1
32.	Sleeve strap	2
33.	Neck facing	1
34.	Front sleeve bottom reinforcement	2
35.	Back sleeve bottom reinforcement	2
36.	Front flap (upper left - gun patch) Class 3	1
Material: Liner		
37.	Front	2
38.	Back	2
39.	Sleeve	2
Marker		
40.	Lapel	
41.	Button and Buttonhole	
42.	Button and Belt Fastener	

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3.6 Construction. The coat shall be manufactured in accordance with the operations and the stitch, seam, and stitching types specified in Table I. The manufacturer will not be required to follow the exact sequence of operations as listed. The thread and the fabric shall not be lubricated by any means prior to or during the seaming. The stitch, seam, and stitching type specified in Table I shall conform to FED-STD-751. The number of stitches per inch as specified in Table I indicates the minimum and maximum number permitted. If two or more methods or seam or stitch types are given for the same part of an operation, any one of them may be used. Where stitch type 401 is used, the looper (under thread) shall be on the inside of the outer shell of the coat and on the side of the liner that will face the outer shell in the finished coat. Seams shall be sewn so that no raw edges, run offs, twists, pleats, puckers, or open seams will result. All seams shall start and finish evenly. Thread tension shall be maintained so that the stitching will not be tight or loose. Unless otherwise specified herein, raise stitching or edge stitching shall be 1/16 inch from the edge and 1/4 inch gage. The stitching for safety stitch construction shall be 3/8-inch gage. The guides and knives on the safety switch machine shall be set to trim only the ravelled ends of the fabric. Seams required to be worked out having a depth between the fold of 1/16 inch or more shall not be acceptable. The ends of all seams and stitchings not caught by other seams and stitching shall be backtacked not less than 1/2 inch. Thread breaks of stitch Type 301 shall be secured by stitching back of the break not less than 1/2 inch. Thread breaks or skipped stitches in stitch Type 401 shall be backstitched not less than 1 inch with the stitching superimposed and anchoring the ends of the break when automatic equipment is authorized for use. When automatic equipment is authorized for use, minor modifications are permitted where necessary. These modifications shall not alter the dimensional, serviceability or appearance requirements cited in this specification.

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

- a. Corrosive metal fastening devices.
- b. Adhesive type tickets which show discoloration or the use of an adhesive mass which adheres to the material upon removal of the tickets.

3.6.2 Fusing operations. The fusing operation for fusing the fusible interlining specified in 3.3.5 to the basic fabric of the outer shell specified in 3.3.1 should be performed on a fusing press. Specific settings (see 6.7) for the particular fusible style and press to be used should be obtained from the supplier of the fusible material so that the optimum results can be obtained.

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
1.	<p><u>Cutting.</u></p> <p>a. Cut the coat in strict accordance with patterns furnished by the Government.</p> <p>b. Cut all materials in the direction indicated by the pattern. The pattern has markings for placement of pockets, buttonhole sizes, seam allowance and notches for proper assembly of all parts. Unless otherwise specified, place the directional lines of the patterns in the warp direction of the material.</p> <p>c. Unless otherwise specified herein, cut all parts that are made of the basic fabric specified in 3.3.1 from the same material. The undercollar, the underside of the shoulder straps, and the undercollar stand, may be cut from ends. The part cut from ends shall approximate the shade of the outer shell.</p> <p>d. Cut the stripping 2 inches wide for the hanger, belt loops, belt keeper and belt fastener in the direction of the warp. The finished width of the stripping shall be $\frac{1}{2} + \frac{1}{16}$ inch wide.</p> <p>e. Cut the parts of the liner that are made of fabric specified in 3.3.3 from the same piece of material in accordance with the directional lines of the pattern.</p> <p>f. Cut all interlining parts in accordance with the pattern.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
1.	<p><u>Cutting.</u> (cont'd)</p> <p>g. Cut the binding for both the outer shell and the liner on the bias $1 \frac{1}{8}$ inches wide.</p> <p>h. Cut sleeve and body lining in accordance with pattern. When cut from ends, the shade of each pair shall match.</p> <p>i. The use of drill holes for marking pockets and darts shall be permitted provided extreme care is taken in placement of drill holes and that no drill holes are visible on the outside finished item. Visible drill holes will be a major defect.</p>					
2.	<p><u>Replacement of damaged parts.</u></p> <p>a. Remove any parts containing material defects or workmanship damages that are classified as defects in MIL-STD-1494 from production during the spreading, cutting, and manufacturing process and replace with nondefective and properly matched parts.</p> <p>b. Replace at time of cutting any parts of coat containing holes or serious weakening defects such as smashes, multiple floats, loose or weakening slubs, etc., expected to develop into holes, shade bars and dye streaks or unsightly slubs, etc., affecting appearance.</p> <p>c. Replace any parts damaged during the manufacturing process by needle chews which may develop into a hole, scissor knife cuts, tears, holes, mends or burns in the material affecting appearance.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
3.	<p><u>Shade marking.</u></p> <p>a. Mark or ticket (see 3.6.1) all component parts to insure a uniform shade throughout the coat and the proper assembling of all parts.</p> <p>b. If shade marking is used, the marking shall not show through and be visible on the outside of the coat.</p> <p>c. The use of tickets with any metal fastening devices or sew-on shade tickets is prohibited.</p>					
4.	<p><u>Make shoulder straps.</u></p> <p>a. Position the shoulder strap interlining on the top ply of each shoulder strap and fuse (see 3.6.2).</p> <p>b. Join the top ply of each shoulder strap (with interlining) to the underply of the shoulder strap along the sides and across the point. Trim the corners, and turn seam to the edges. Stitch each shoulder strap with double stitch seam 1/16 inch from the edge and 1/4 inch from gage.</p> <p>c. Make a 5/8-inch square-bar, eyelet-end type buttonhole in each shoulder strap, positioned midway, with the inside edge of the eyelet 5/8 to 3/4 inch from the pointed end. The buttonhole shall not be off centered by more than 1/8 inch.</p>	<p>301 or 401 and 301</p>	<p>SSe-3 (a) SSe-3 (a) SSe-3 (b)</p>	<p>10-12 10-12 10-12</p>	<p>50 50 50</p>	<p>50 70 50</p>
5.	<p><u>Make sleeve strap.</u></p> <p>a. Position the sleeve strap interlining on each ply of sleeve strap and fuse (see 3.6.2).</p>	<p>But- ton- hole</p>		<p>50-54 per button- hole includ- ing bar- tack</p>	<p>70</p>	<p>70</p>

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
5.	<u>Make sleeve strap.</u> (cont'd)					
	b. Fold strap in half lengthwise and stitch along side raw edge and point. Trim, turn and work out edges. Double stitch sides and point 1/16 inch from the seamed and folded edges and 1/4 inch gage.	301 or 401 and 301	SSe-3 (a) SSe-3 (a) SSe-3 (b)	10-12 10-12 10-12	50 50 50	50 70 50
	c. Overedge stitch raw edge of strap.	503 or 504	EFd-1 EFd-1	6-12 6-12	70 70	70 70
	d. Make a 5/8-inch square-bar, eyelet-end type buttonhole in each strap positioned midway; the inside edge of the eyelet shall be 5/8 to 3/4 inch from the pointed end. The buttonhole shall not be off centered by more than 1/8 inch.	But- ton- hole		50-54 per button- hole includ- ing tack at end	30	50
6.	<u>Make collar.</u>					
	a. Fuse the collar interlining to the respective collar parts (see 3.6.2).					
	b. Stitch the undercollar to the topcollar around the side and the top edges with 1/4-inch seam.	301 or 401	SSe-3 (a) SSe-3 (a)	10-12 10-12	50 50	50 70
	c. Trim, turn, and force out the edges of the collar. Double stitch the collar 1/16 inch from the turned edges and 1/4 inch gage.	301	SSe-3	10-12	50	50
7.	<u>Make collarstand and attach collar.</u>					
	a. Position collarstand interlining on both plies of collarstand and fuse (see 3.6.2).					

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
7.	<u>Make collarstand and attach collar.</u> (cont'd)					
	b. Position the collar between the top collarstand and the under collarstand, with the raw edges even and notches matching, and stitch along the top edge of the collarstand with 1/4-inch seam.	301 or 401	SSq-2 (a) SSq-2 (b)	10-12 10-12	50 50	50 70
	c. Turn down collarstand and stitch 1/16 inch from raised edge.	301	LSq-2 (b)	10-12	50	50
	d. Stitch the bottom of the top collarstand and the under collarstand together. The finished collar shall be 2 5/8 + 1/8 inches wide at the center back	301	SSa-1	10-12	50	50
8.	<u>Make pocket welt.</u>					
	Finished appearance. The welts shall be uniformly made and stitched.					
	a. Position welt interlining to the inside of each welt and fuse (see 3.6.2).					
	b. Fold welt in half lengthwise face to face and close each end of the welt with a 1/4-inch seam.	301	SSE-3 (a)	10-12	50	50
	c. Turn welt, completely working out seamed edges and corners.					
	d. Double edgestitch the welt uniformly 1/16 inch from the turned and folded edges and 1/4-inch gage.	301	SSE-3 (b) and OSf-1	10-12	50	50
	e. On the finished coat, the length of the welt shall be 7 + 3/16 inch for all sizes of coats.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
9.	<u>Make front upper flat (Gun-patch) Class 3</u>					
	a. Position the fusible interlining on the underside of the top ply of the front flap and fuse (see 6.7.1).					
	b. Position the top ply and the underply of front flap face to face with edges even. Seam the two plies together along the front and bottom edges with a 1/4 inch seam. The line of stitching shall be from the step at the gorge (neck edge) to the armhole edge.	301	SSe-3 (a)	10-12	50	50
	c. Turn the flap right side out, forcing the seam to the edge. Topstitch the flap with a double row of stitching 1/16 inch from the edge and 1/4 inch gage.	301	SSe-3 (b)	10-12	50	50
10.	<u>Make sleeve lining.</u>					
	a. Position the back and front sleeve lining face to face with edges even and join together the top arm seam, and under arm seam 3/8 inch from the raw edges.	301	SSa-1	10-12	A	A
	b. Overedge stitch the raw edges together.	503 or 504 or 602	SSa-1 SSa-1 SSa-1	6-12 6-12 6-12	A A A	A A A
	-or-					
	c. As an alternate, operation 10a and 10b may be performed in one operation by simultaneously stitching and overedging.	515 or 516 or 519	SSa-2 Chain- stitch ing SSa-2 Over- edge stitch ing	6-12 6-12 6-12	A A A	A A A

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
10.	<u>Make sleeve lining.</u> (cont'd)					
	d. Press seams smooth and flat with a heated pressing iron or pressing machine.					
11.	<u>Assemble back lining.</u>					
	a. Position the back parts of lining with edges even, notches matched, and join at the center back with 3/8-inch seam from top edge (neck edge) of back to bottom edge.	301 or 401	SSa-1 SSa-1	10-12 10-12	A A	A A
	b. Overedge stitch the raw edges together.	503 or 504 or 602	SSa-1 SSa-1 SSa-1	6-12 6-12 6-12	A A A	A A A
	-or-					
	c. As an alternate, operation 10a and 10b may be performed in one operation by simultaneously stitching and overedging.	515 or 516 or 519	SSa-2 (Chain stitch ing) SSa-2 (Over- edge- stitch ing) SSa-2	6-12 6-12 6-12	A A A	A A A
	d. Fold the upper edge of the back in accordance with the notches. Stitch across the fold to form center back lining pleat. The pleat shall be toward the left wide as worn.	301	SSa-1	10-12	A	A
	e. Fold and stitch shoulder darts as indicated by marks on the patterns. The darts shall be neatly formed and tapered to a flat point and securely tacked or backstitched.	301	OSf-1	10-12	50	50

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
11.	<u>Assemble back lining.</u> (cont'd) f. Press the back seams and shoulder dart smooth and flat with a heated pressing iron or pressing machine. The shoulder darts shall be pressed toward the center back.					
12.	<u>Assemble front lining.</u> a. Fold and stitch bust darts in front lining as indicated by marks on the patterns. The darts shall be neatly formed and tapered to a flat point. The point shall be securely tacked or backstitched. b. Press the bust darts smooth and flat with a heated pressing iron or pressing machine. The bust darts shall be pressed toward the front.	301	OSf-1	10-12	A	A
13.	<u>Join back and front lining.</u> a. Position the back and fronts with edges even and join together at the sides with 3/8-inch seam. b. Position the back and fronts with edges even and join together at the shoulder with 3/8-inch seam, catching the back and bust darts in the stitching. c. Overedge stitch the raw edges together at the side and shoulder seams. -or-	301 301 or 401 503 or 504 or 602	SSa-1 SSa-1 SSa-1 SSa-1 SSa-1 SSa-1	10-12 10-12 10-12 6-12 6-12 6-12	A A A A A A	A A A A A A

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
13.	<u>Join back and front lining.</u> (cont'd)					
	d. As an alternate, operation 12a and 12b may be performed in one operation by simultaneously stitching and over- edging.	515 or 516 or 519	SSa-1 (Chain stitch ing) SSa-1 (Over- edge- stitch ing) SSa-1	6-12 6-12 6-12	A A A	A A A
	e. Press side seams and shoulder seams smooth and flat with a heated pressing iron or pressing machine. The seams shall be pressed toward the back.					
14.	<u>Hem body lining.</u>					
	a. Turn up the bottom edge of body lining in accordance with notches. Turn raw edge under at the lower notch and form a 1 + 1/8-inch wide hem. Stitch 1/16 inch from the inner folded edge.	301	EFb-1	10-12	A	A
15.	<u>Join sleeve lining to body lining.</u>					
	a. Position sleeve lining on the outside of body lining at armhole, with notches matching. The top arm seam line of the sleeve shall match the should seam line. The shoulder, the sides and sleeve seam allowance shall be turned toward the back.					
	b. Join sleeve lining to the body lining with 3/8-inch seam. The fullness shall be distributed in accordance with good manufacturing practices.	301	SSa-1	10-12	A	A

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
15.	<u>Join sleeve lining to body lining.</u> (cont'd)					
	c. Overedge stitch the arm-hole seam allowance together.	503	SSa-1	6-12	A	A
	Overedge stitch each bottom raw edge of sleeve lining.	or 504	SSa-1	6-12	A	A
		or 602	SSa-1	6-12	A	A
	-or-					
	d. As an alternate, operation 15.b and 15.c may be performed in one operation by simultaneously stitching and overedging.	515	SSa-2	6-12	A	A
		or 516	(Chain stitch ing)	6-12	A	A
		or 519	SSa-2 (Over- edge- stitch ing) SSa-2	6-12	A	A
16.	<u>Finish raw edges of lining.</u>					
	a. Overedge stitch the raw edge of the body lining along the front and neck edge.	503	SSa-1	6-12	A	A
		or 504	SSa-1	6-12	A	A
		or 602	SSa-1	6-12	A	A
17.	<u>Assemble front facing.</u>					
	a. Position the upper front facing, interlining, and facing reinforcement interlining on the front facing, with back edge of facing and facing interlining even and notches matching, and fuse (see 3.6.2).					
	b. Position the neck facing interlining on the neck facing and fuse (see 3.6.2).					
	c. Join neck facing to front facing at shoulder with 3/8-inch seam.	301	SSa-2 (a)	10-12	50	50
	d. Press seam open smooth and flat with a heated pressing iron or pressing machine.					

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
17.	<u>Assemble front facing.</u> (cont'd)					
	e. Overedge stitch the seam allowance at the shoulder	503 or 504	EFd-1	6-12	70	70
	f. Bind the back raw edge of the front and neck facing. The finished binding shall be 3/16 to 1/4 inch wide.	301 or 401	BSa-1	10-12	A	A
	g. Mark a line 1 1/4 inches along back edge of front and neck facing for positioning of body lining.					
	h. Sew the combination identification instruction label to the left front facing with a single row of stitching 1/8 inch from each edge of label. The labels shall be positioned on the lower center of facing with the bottom of the label approximately 3 inches above the finished bottom edge of coat.	301	SSa-1	10-12	50	50
18.	<u>Seam facing assembly to body lining.</u>					
	a. Lap the body lining on the inside of facing with the front edge of the lining in line with the mark, the shoulder seams matching, and the finished bottom edge of lining aligned with the notch in the facing assembly 1/4 inch from the front edge of lining.	301	LSa-1	10-12	50	50
19.	<u>Make fronts.</u>					
	a. Position the center front interlining on each center front with front edge of interlining 1/4 to 5/16 inch from the front edge of the coat and fuse (see 3.6.2).					

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
19.	<p><u>Make fronts.</u> (cont'd)</p> <p>b. Position the side front interlining on each side front with front edge of interlining 1/4 to 5/16 inch from the front edge of side front and fuse (see 3.6.2).</p> <p>c. Position front and side front with notches matching and edges even and join together with 3/8-inch seam.</p> <p>d. Spread open the seams and press smooth and flat with a heated iron.</p> <p>e. Overedge stitch the raw edge of each seam allowance.</p>	<p>301 or 401</p> <p>503 or 504</p>	<p>SSa-1 SSa-1</p> <p>EFd-1 EFd-1</p>	<p>10-12 10-12</p> <p>6-12 6-12</p>	<p>50 50</p> <p>70 70</p> <p>70 70</p>	<p>70 70</p> <p>70 70</p>
20.	<p><u>Set pocket facing to hanging pocket.</u></p> <p>a. Position pocket facing to the top ply of hanging pocket with back edge of facing in line with upper notch on the hanging pocket.</p> <p>b. Turn under the bottom and front raw edge of pocket facing and stitch 1/16 to 1/8 inch from the turned under edge.</p>	<p>301</p>	<p>LSD-1</p>	<p>10-12</p>	<p>50</p>	<p>50</p>
21.	<p><u>Set welt, facing and hanging pocket to front.</u></p> <p>Finished appearance. The welt, facing, and hanging pocket shall be set to the fronts smooth and flat, without twists, puckers, raw edges, or distortion. The gage of stitching shall be uniform. The tongue notches of the pocket opening in fronts shall not be exposed.</p>					

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
21.	<p><u>Set welt, facing and hanging pocket to front.</u> (cont'd)</p> <p>a. The pocket opening may be cut prior to setting of pocket welt and hanging pocket to fronts (when not cut in cutting room).</p> <p>b. Mark fronts for position of pocket in accordance with marks in the pattern.</p> <p>c. Position pocket welt and the cut out edge of the under ply of hanging pocket together, with edges even and in line with the mark and with the folded edge of pocket welt toward the front. Stitch hanging pocket and pocket welt to the fronts uniformly 1/4 inch from raw edge of hanging pocket and pocket welt.</p> <p>d. Position the raw edge of pocket facing on the outside of front aligned with the mark and abutted raw edges of hanging pocket and pocket welt. Stitch facing to front 1/4 inch from raw edge.</p> <p>e. Cut the opening for the pocket midway between the two rows of stitches. The opening shall extend to 1/4 inch from each end of welt and tongue notch each end of opening. Care shall be taken not to slash beyond each end of pocket welt.</p> <p>f. Turn pocket and raw edge of welt through opening to inside. Smooth out the pocket and pocket welt and stitch the fronts 1/16 inch from raised edge through welt and front part of pocket.</p>	301	SSq-2C (b)	10-12	50	50
		301	SSq-2 (b)	10-12	50	50
		301	SSq-2 (b)	10-12	50	50

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
21.	<u>Set welt, facing and hanging pocket to front. (cont'd)</u>					
	g. Turn the facing joining seam, facing, and the top ply of the hanging pocket through the opening; raise-stitch the front through the facing and pocket, 1/16 inch from the joining seam line. The raised seam shall be covered by the welt.	301	LSq-2 (b)	10-12	50	50
	h. Join the top and under plies of hanging pocket together 3/8 to 1/2 inch from raw edges, except at the back edge below pocket opening where the line of stitching shall extend along the facing joining seam line.	301	SSa-1	10-12	50	50
	i. Overedge stitch the raw edge of pocket seam allowance, and continue along the raw edge of back pocket.	503 or 504 or 602	SSa-1 SSa-1 SSa-1	6-12 6-12 6-12	70 70 70	70 70 70
	j. Lay pocket smooth and flat and tack top and bottom edges of pocket to the front seam allowance of coat.	301	SSa-1	6-12	50	50
	k. Turn coat on the outside.					
	l. Stitch top and bottom ends of welt to the fronts through the hanging pocket from the raised seam at front edge of welt to the back edge of welt. Stitch diagonally to outer corner of top stitching of the welt and continue on the line of topstitching at each end of the welt to the stitching at the same seam. Continue on the line of stitching of the raised seam to the outer row and backtack approximately 1/2 inch along the outer row.	301	LSa-2	10-12	50	50

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
21.	<p><u>Set welt, facing and hanging pocket to front.</u> (cont'd)</p> <p>The outer row of stitching at top and bottom ends of welt shall be uniformly 1/16 inch from the ends.</p>					
22.	<p><u>Set front upper flap (Gun Patch) Class 3.</u></p> <p>Finished appearance. The front flap shall be joined to the left front without distortion, puckers or pleats.</p> <p>a. Position front flap to the upper left front with raw edges of flap even with gorge, shoulder and armhole edges. Stitch flap 1/8 to 1/4 inch from raw edges.</p>	301	SSa-1	10-12	50	50
23.	<p><u>Make back.</u></p> <p>Finished appearance. The center back seam of the coat shall be carefully joined without twist, puckers, pleats, or raw edges. The seam shall start and finish evenly.</p> <p>a. Position the back parts with edges even and notches matching and join at the center back with 5/8-inch seam from the neck edge of back to approximately 5/8 to 3/4 inch below top end of vent.</p> <p>b. Spread the center back seam open and press smooth and flat with a heated pressing iron.</p> <p>c. Overedge stitch each raw edge of center back seam allowance.</p>	301	SSa-1	10-12	50	50
		503	SSa-1	10-12	70	70
		or 504	SSa-1	10-12	70	70
		or 602	SSa-1	10-12	70	70

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
23.	<u>Make back.</u> (cont'd)					
	d. Fold and stitch shoulder darts as indicated by marks on the patterns. The darts shall be neatly formed and tapered to a flat point. The point shall be securely tacked or backstitched.	301	SSa-1	10-12	50	50
	e. Press each dart smooth and flat with a heated pressing iron. The darts shall be turned toward the center back.					
24.	<u>Join back pleat facing to back vent.</u>					
	Finished appearance. The back pleat facing shall be uniformly joined to the left and right back parts at the vent without twists, puckers, gathers, pleats, or raw edges.					
	a. Position the back pleat facing on the left and right back, respectively, with bottom and side edges even.					
	b. Join left and right side of facing, respectively, to right and left back, 1/8 inch from raw edge.	301	SSae-2 (a)	10-12	50	50
	c. Turn the facing back at the seam and edgestitch 1/4 inch from seam edges from bottom of back to top edge of vent.	301	SSae-2 (b)	10-12	50	50
	d. Form triangle. Turn under top edge of facing, forming a point, and seam to back along top edges, 1/16 to 3/32 inch, continuing down sides for a distance of 5/8 to 3/4 inch and continue directly across width of pleat with two rows of stitching 3/16 to 1/4 inch gage, closing pleat. Point of	301	OSg-3	10-12	50	50

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
24.	<u>Join back pleat facing to back vent.</u> (cont'd) pleat facing shall be centered on center back seam (+ 1/8 inch off center tolerance).					
25.	<u>Hem outside yoke and join to back.</u> Class 3. Finished appearance. The outside back yoke shall be hemmed with a double row of stitching. a. Hem the bottom edge of back yoke with raw edge turned under and caught in the stitching 1/16 inch from the folded edge using a 1/4 inch gage. The hem shall finish 3/8 inch in width. b. Press the back yoke smooth and flat with a heated pressing machine. c. Position the yoke on the outside of the back, with armhole, shoulder and neck edges even and notches matching and join the yoke to the back 1/8 to 3/16 inch along the armhole, shoulder and neck edge.	301	EFb-2	10-12	50	50
		301	SSa-1	10-12	50	50
26.	<u>Join front and back at sides.</u> Finished appearance. The side seams of the coat shall be carefully joined without twists, puckers, pleats, or raw edges. The seams shall start and finish evenly. a. Position the back and fronts with edges even and join together at sides with 5/8-inch seam.	301	SSa-1	10-12	50	50

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
26.	<u>Join front and back at sides.</u> (cont'd)					
	b. Spread open the seam and press smooth and flat with a heated pressing iron.					
	c. Overedge stitch each raw edge of side seam allowance.	503 or 504 or 602	SSa-1 SSa-1 SSa-1	6-12 6-12 6-12	70 70 70	70 70 70
27.	<u>Make belt loops, belt keeper, fastener and hanger loop.</u>					
	Finished appearance. The finished strips shall be uniform in width, $1/2 \pm 1/16$ inch wide.					
	a. Make belt loops, belt keeper, belt fastener and hanger loop from basic material.					
	b. Fold the raw edges to the center with raw edges abutted. Fold over on itself forming the $1/2$ inch finished dimension and topstitch $1/16$ inch from each outer edge.	301	EFp-2 (modified)	10-12	50	50
	c. The finished length of the hanger loop shall be $2 \frac{3}{4}$ inches.					
	d. Cut the loops for the right side and for the front 4 inches long.					
	e. Cut the loop for the left side $5 \frac{1}{4}$ inches long.					
	f. Cut the keeper $5 \frac{1}{2}$ inches long. Fold in half end to end and join the ends together $1/4$ to $3/8$ inch from end. The finished keeper shall finish $2 \frac{1}{2} \pm 1/8$ inches.	301	SSa-1	10-12	50	50

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
27.	<p><u>Make belt loops, belt keeper, fastener and hanger loop.</u> (cont'd)</p> <p>g. Cut the fastener 9 1/2 inches long. Fold one end of fastener 1 1/2 inches and stitch together 1/16 to 1/8 inch on both sides and folded edge.</p> <p>NOTE: A Sonic Machine may be used to cut the strips to the proper length.</p> <p>h. Make a horizontal straight type buttonhole on the fastener, cut 5/8 inch long, through the center of the turned under portion, securely tacking each end of buttonhole.</p> <p style="text-align: center;">-or-</p> <p>i. A 5/8 inch eyelet-end square-bartype buttonhole may be used with 50-54 stitches including the bartack.</p>	301	SSa-1	10-12	50	50
28.	<p><u>Make belt.</u></p> <p>Finished appearance. The belt shall finish smooth and flat, without pleats, puckers or raw edges. The gage of stitching shall be uniform in width. The belt shall finish 2 1/8 + 1/8 inches wide. The belt fastener shall finish on the underside of the belt.</p> <p>a. The belt shall be made of one ply of basic material interlined with fusible material.</p>	But- ton		42-48 per button hole (mini- mum) includ ing tack	50	50

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
28.	<u>Make belt.</u> (cont'd)					
	b. Position the belt interlining to the inside of belt and fuse (see 3.6.2).					
	c. Mark on the outside of the belt the location for sewing belt fastener and button in accordance with pattern marker.					
	d. Turn under the raw end of the fastener 3/8 to 1/2 inch and bartack the fastener to belt 1/8 to 3/16 inch from folded edge. The bartack shall be across the width of the fastener. The fastener, when buttoned, shall be smooth and flat without twist or bulging.	Bar-tack		28 stitches per bar-tack	50	50
	e. Sew a 24-line button on the mark to properly engage the buttonhole for the fastener.	101 or 301		14-16 per button	30	30
	f. Fold belt in half lengthwise with the belt fastener enclosed within the fold. Stitch the entire length of belt 1/4 inch from raw edge.	301	SSa-1	10-12	50	50
	g. Close the pointed end with 1/4 inch seam along the slanted edge.	301	SSa-1	10-12	50	50
	h. Trim the pointed end of belt for proper turning. Turn the belt on the right side through the open end, working out the point and seam to the edge.					

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
28.	<p><u>Make belt.</u> (cont'd)</p> <p>i. Edgestitch both sides and pointed end of belt with a double row of stitching 1/16 inch from seamed and folded edge and 1/4 gage.</p> <p>j. Press belt smooth and flat with a heated pressing iron or pressing machine.</p> <p>k. Position the belt keeper on the belt 6 1/2 inches from the unfinished end. Tack or bartack the keeper to the belt, on each side of seam allowance of keeper, on the under side of belt. Stitch through all plies.</p> <p>Alternate Method: The bartack may be horizontally across the seam allowance and through all plies.</p> <p>l. Fold unfinished end of belt over the buckle bar 2 3/4 inches.</p> <p>m. Turn under raw edge and double stitch to belt 1/16 inch from folded edge and 1/4-inch gage.</p>	301	SSe-3 (b)	10-12	50	50
		Bar- tack		28 per bar- tack	50	50
29.	<p><u>Set belt loops and hanger loop.</u></p> <p>Finished appearance. The belt loops shall be finished vertically straight and shall be positioned as follows:</p> <p>One loop on each front 1 inch above and in line with front pocket seam line.</p> <p>One loop on each side seam in horizontal line with the front loops.</p>	301	EFb-2	12-16	50	50

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
29.	<p><u>Set belt loops and hanger loop.</u> (cont'd)</p> <p>The belt loops shall measure 2 1/2 inches long from top to bottom folded edge. The under loop for the belt fastener shall have an opening of not less than 1 1/2 inches.</p> <p>NOTE: Raw edge on bottom of loops shall be stitched to the coat so that the stitching is not visible on the outside of loops. The top portion of loop shall be bartacked 1/16 inch from top folded edge. The raw ends of the loop shall not extend more than 1/4 inch.</p> <p>a. Position the 5 1/4 inch long belt loop on the left side seam line, with one end approximately 1 3/4 inches from the bottom mark, and bartack the loop to the coat 1/16 inch from the end of the loop for the belt fastener. Turn under the top end of the loop and bartack the loop through the side seam 1/16 inch from the folded edge.</p> <p>b. Position one end of each 4 inch belt loop on each front and left side seam at the marks and bartack loop 1/4 inch from end. Turn under the top end of the loop and bartack 1/16 inch from the folded edge.</p> <p>c. Position the hanger loop on the center of the top collar stand. Turn the ends of the hanger loop under 3/8 inch and bartack. The bartack shall be 1/2 + 1/16 inch long. Finished length of hanger loop shall be 2 3/4 inches.</p>					
		Bar-tack		28 per bar-tack	50	50
		Bar-tack		28 per bar-tack	50	50
		Bar-tack		28 per bar-tack	50	50

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
30.	<p><u>Mark lapels.</u></p> <p>a. Mark the lapels in accordance with lapel marker.</p>					
31.	<p><u>Mark hem turnup.</u></p> <p>a. Mark the fronts and back including the center pleat, 1 1/4 inches from the bottom edge for the turnup.</p>					
32.	<p><u>Seam shoulders.</u></p> <p>Finished appearance. The shoulder seams of the coat shall be carefully joined without twists, puckers, pleats, or raw edges. The seams shall start and finish evenly.</p>					
	<p>a. Join back and fronts together at the shoulders with 3/8-inch seams.</p>	301	SSa-2	10-12	50	50
	<p>b. Spread open the seams and press smooth and flat with a heated pressing iron.</p>					
	<p>c. Overedge stitch each raw edge of shoulder seam allowance.</p>	503 or 504 or 602	SSa-1 SSa-1 SSa-1	6-12 6-12 6-12	70 70 70	70 70 70
33.	<p><u>Set shoulder straps.</u></p> <p>Finished appearance. The shoulder straps shall be uniform in size and setting. The straps shall lie smooth and flat without twists or fullness.</p> <p>a. Position the shoulder straps, with the pointed end of the strap even with the edge of the gorge and with the notch centered on shoulder seam.</p>					

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
33.	<u>Set shoulder straps.</u> (cont'd)					
	b. Seam the shoulder straps to the coat 1/8 to 1/4 inch from the armhole edge. Trim the shoulder strap even with the armhole, where necessary.	301	SSa-2	10-12	50	50
34.	<u>Join collar to coat.</u>					
	Finished appearance. The collar shall be carefully joined to the coat without distortion of the collar.					
	a. Position underside of collar on outside of coat with neck edge of collar even with neck edge of coat and ends of the collar in line with lapel notch.					
	b. Join collar to coat with a 1/4-inch seam from end to end.	301	SSa-1	10-12	50	50
35.	<u>Join facing-lining assembly to coat and set size label.</u>					
	Finished appearance. The facing-lining assembly shall be uniformly stitched to the coat and shall finish smooth and flat without gathers, pleats or puckers.					
	a. Position the facing-lining assembly on the outside of the respective fronts and back with collar inserted between, with edges even and the notches at the front, neck facing, and collar matching.					
	b. Join facing-lining assembly to fronts with 1/4-inch seam. The stitching shall extend from the back bottom edge of facing, along fronts, up to the base of lapel mark and continuing to stitch on the mark along the front and top edges of lapel, the gorge	301	SSa-1	10-12	50	50

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
35.	<p><u>Join facing-lining assembly to coat and set size label.</u> (cont d)</p> <p>and the neck, catching the collar, size label and neck facing in the stitching. Size label shall be centered on outside of neck facing.</p> <p>c. Trim corners of lapel and bottom corners of coat for proper turning. Notch seam allowance along the gorge and neck to allow for proper turning.</p>					
36.	<p><u>Hem and edgestitch coat.</u></p> <p>Finished appearance. The edgestitching shall be uniform width without twists, pleats, or puckers. The bottom hem shall be uniform in width without distortion and shall finish 3/4 to 7/8 inch wide.</p> <p>a. Hem the bottom edge of coat with raw edge turned under 3/8 inch to 1/2 inch and stitch 1/16 inch from the upper folded edge. The stitching shall extend along the back edge of facing, from the upper folded edge of the bottom turnup to 1/16 inch above the bottom edge of coat, with facing lapped on the bottom turnup. Continue to edgestitch 1/16 inch along the bottom and front edge up to the end of collar. From that point, continue to stitch the facing-lining assembly to collar and 1/16 inch from raised edge. The underply of the collar shall not be caught in the stitching.</p>	301	<p>SSe-2 (b) (top and front edge of lapels) (front edges and bottom edge of coat) LSa-1 (back edge of facing) EFb-1 (upper folded edge of bottom turnup)</p>	10-12	50	50

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
36.	<u>Hem and edgestitch coat.</u> (cont'd)					
	b. Edge stitch the top and front edge of lapel and along the front edge of coat to the bottom edge of facing 1/4 inch from seamed edge.	301	SSe-2 (b)	10-12	50	50
	c. Fold the bottom hem back face to face, at each side of the back pleat seam line, and stitch through all plies. The line of the stitch shall be 1/4 to 5/16 inch from the folded edge at the bottom and gradually tapering to and joining the seam line.	301	SSe-3	10-12	50	50
37.	<u>Press coat fronts.</u>					
	a. Press the coat fronts smooth and flat with a heated pressing iron or pressing machine.					
38.	<u>Make sleeve (outer shell).</u>					
	a. Position the sleeve reinforcement interlining at the bottom turnup of the front and back sleeve, with notches matching, and fuse (see 3.6.2).					
	b. Position the front and back sleeve face to face, with edges even. Join together along the top seam with 3/8-inch seam from the raw edges.	301	SSa-1	10-12	50	50
	c. Overedge stitch each raw edge of the seam allowance.	503 or 504 or 602	SSa-1 SSa-1 SSa-1	6-12 6-12 6-12	70 70 70	70 70 70
	d. Spread seams open and press smooth and flat with a heated pressing iron or pressing machine.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
38.	<u>Make sleeve (outer shell).</u> (cont'd)					
	e. Position the sleeve strap to the outside of the back sleeve inseam, face to face, with the lower edge of the sleeve strap aligned with the notch on the sleeve and raw edges even. Stitch the strap to sleeve 1/4 inch from edge.	301	SSa-1	10-12	50	50
	f. Join front and back sleeve together along the inseam with 5/8-inch seam, catching the sleeve strap in the stitching.	301	SSa-1	10-12	50	50
	g. Overedge stitch each raw edge of the seam allowance. The end of the sleeve strap shall not be caught in the stitching of the back sleeve seam allowance.	503 or 504	LSbm-3 (a) LSbm-3 (a)	10-12 10-12	70 70	70 70
	h. Press seam open and flat with a heated pressing iron or pressing machine.					
39.	<u>Set sleeves.</u>					
	Finished appearance. The sleeves shall be uniformly stitched without twists, gathers, pleats, puckers or raw edges.					
	a. Position sleeve on outside of coat at the armhole, with notch in armhole edge of back matching backarm seam of sleeve, the notch in the top of sleeve aligned with shoulder seam line and the notch at armhole edge of fronts and top sleeve matching.					
	b. Join sleeve to armhole with 3/8-inch seam, catching the end of shoulder straps and side seams in the stitching.	301	LSq-2 (a)	10-12	50	50

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
39.	<u>Set sleeves.</u> (cont'd)					
	c. Overedge stitch the raw edge of the armhole and sleeve shell separately.	503 or 504 or 602	SSa-1 SSa-1 SSa-1	6-12 6-12 6-12	70 70 70	70 70 70
40.	<u>Stitch lining to sleeves.</u>					
	a. Stitch the sleeve lining to each sleeve at the wrist with two rows of stitching. The first row of stitching shall be 1/4 to 3/8 inch from the sleeve bottom. The second row of stitching shall be parallel to and 1 1/2 inches above the sleeve bottom.	301	SSa-2	10-12	50	50
	b. Stitch the sleeve lining seam allowance to the outer shell at the inseam allowance 2 1/2 to 3 inches from the bottom of each sleeve for a distance of 6 to 6 1/2 inches.	301	SSa-1	10-12	50	50
	c. Position shoulder seam of lining and coat even, and stitch along the upper armhole seam allowance of lining and coat together approximately 1 1/2 inches on each side of shoulder seam line.	301	SSa-1	10-12	50	50
	d. Stitch armhole seam allowance of lining and coat together at the base of armhole for a distance of 2 1/2 to 3 inches.	301	SSa-1	10-12	50	50
	e. Turn sleeves right side out.					
41.	<u>Set slide fastener on outer shell.</u>					
	a. Position the slide fastener on the outer shell facings so that the ends of the slide fastener will be equidistant from the bottom edge of the outer shell and the separating	301	SSa-1	10-12	50	50

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
41.	<p><u>Set slide fastener on outer shell.</u> (cont'd)</p> <p>pin of the slide fastener will on the right facing. Position the slide fastener on the underside of the outer shell facings with the front edge of the chain 1/8 to 3/16 inch from the bound edge. Turn in the end of the slide fastener tape 1/2 to 3/4 inch. Stitch the length of the slide fastener tape 3/16 to 5/16 inch from the back edge of the chain.</p>					
42.	<p><u>Make buttonholes.</u></p> <p>Finished appearance. The buttonholes shall be clean cut, well made and correctly positioned. The buttonholes shall be well worked over gimp to fit a 34 line button. The stitching shall be securely caught in the fabric with the purling on the outside of the right front and on the facing side of the lapels.</p> <p>a. Mark the location for 3 buttonholes on the right front, one buttonhole on the left front, and the location for one buttonhole on each lapel, in accordance with buttonhole marker. The buttonhole for left front shall be top location of front buttonhole marker.</p> <p>b. Make a horizontal eyelet-end square bar type buttonhole, cut 1 inch long, at each mark on the left and right front and on each lapel. The inside edge of the eyelet end of the buttonhole shall be 3/4 inch from front edge of coat and lapels, with the</p>	But- ton- hole		70 per button hole includ- ing bar	50	50

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
42.	<p><u>Make buttonholes</u> (cont'd)</p> <p>center of the top buttonhole to be 1 1/2 + 1/8 inches from top edge of lapels.</p> <p>c. Securely bartack the ends of each buttonhole, catching the ends of the gimp in the bartack. Trim the ends of the gimp.</p>	Bar-tack		21 per bar-tack	A	A
43.	<p><u>Press coat.</u></p> <p>Finished appearance. The coat shall be well pressed throughout with a heated pressing iron or pressing machine of a type suitable to obtain the desired appearance in accordance with good manufacturing practices.</p> <p>a. Press the fronts smooth and flat, straightening and shaping the front edges, the collar and the backs with a heated pressing iron or pressing machine.</p> <p>Note: Caution is suggested in the pressure and temperature settings used in pressing to avoid creases and impressions on the finished garment.</p>					
44.	<p><u>Sew buttons on outer shell.</u></p> <p>a. Mark the position of the buttons, as indicated by the pattern marks, and sew the buttons to the coat as follows:</p> <p>(1) Sew three 34-line buttons on the right and left fronts on the mark to correspond with the buttonholes, with the stitching of each button through the fronts, right interlining and facing. The stitching of both bottom buttons shall only catch the</p>	101 or 301		14-16 per button 14-16 per button	30 30	30

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
44.	<p><u>Sew buttons on outer shell.</u> (cont'd)</p> <p>front and top ply of front pockets. The buttons shall be set on a stand with a 18-line stay button behind and then shank wrapped.</p> <p>NOTE: The buttons on the right front of coat shall not be shanked but must have a stay button and shall be sewn with tighter stitch to prevent a sagging appearance.</p> <p>(2) Sew one 34-line anchor button to the inside right front to properly engage buttonhole on left front.</p> <p>(3) Position and sew one 34-line button on the upper left front on the lapel buttonhole to provide a smooth closure with the ends of the collar meeting at the neck. The collar ends at the neck shall not overlap or spread apart more than 1/2 inch.</p> <p>(4) Sew one 24-line button on each sleeve to correspond with the buttonholes in the sleeve strap.</p> <p>(5) Sew one 24-line button to each shoulder to align with the eyelet end of the buttonhole in the shoulder straps. On the finished coat, the straps, when buttoned, shall lie smooth and flat without twisting or bulging.</p> <p>b. Sew a 24-line button on each sleeve, 1 to 1 1/4 inch from the bottom edge of the sleeve, without stitching through the outer shell. The buttons shall be positioned to correspond with the button loop at the end of the sleeve for the liner.</p>	<p>101</p> <p>or</p> <p>301</p>		<p>14-16</p> <p>per</p> <p>but-</p> <p>ton</p> <p>14-16</p> <p>per</p> <p>but-</p> <p>ton</p>	<p>30</p> <p>30</p>	<p>30</p>

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
44.	<u>Sew buttons on outer shell.</u> (cont'd) <u>Class 3.</u> Sew one extra 34-line button and one 24-line button on the inside left facing $1 + \frac{1}{4}$ inch from the inside edge of the facing and positioned $8 + \frac{1}{4}$ inches (coat length - short) and $9 + \frac{1}{4}$ inches (coat lengths - regular and long) from the finished bottom edge of the coat. The stitching shall not be through the outershell.	101 or 301		14-16 per but- ton	30 30	30
45.	<u>Make removable liner.</u>					
	a. Fold the front part at the shoulder and stitch bust darts as indicated by the marks on the patterns. The darts shall be neatly formed and taper to a flat point. The point shall be securely tacked or back-stitched.	301	OSf-1	8-10	A	A
	b. Fold the back part at the shoulder and stitch darts in accordance with marks on the patterns. The darts shall be neatly formed and tapered to a flat point. The point shall be securely tacked or back-stitched.	301	OSf-1	8-10	A	A
	c. Fold front bust darts toward the front and back shoulder darts toward the center back and press smooth and flat with a heated pressing iron.					
	d. Join the fronts and backs together face to face at the shoulder $\frac{3}{8}$ inch from raw edge.	301 or 401	SSa-1 SSa-1	8-10 8-10	A A	A A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
45.	<u>Make removable liner.</u> (cont'd)					
	e. Overedge stitch the raw edge together.	503 or 504	SSa-1	8-10	A	A
	or	602	SSa-1	8-10	A	A
	f. As an alternate, operation 45.d and 45.e may be performed in one operation simultaneously stitching and overedging.	515 or 516 or 519	SSa-2	8-10	A	A
46.	<u>Set sleeve to liner.</u>					
	a. Position sleeves on the outside of liner at the armholes with notches matching and with edges even.					
	b. Join sleeves to the liner 3/8 inch from raw edge.	301 or 401	SSa-1	8-10	A	A
	c. Overedge stitch the raw edge together.	503 or 504 or 602	SSa-1	8-10	A	A
	-or-					
	d. As an alternate, operation 46b and 46c may be performed in one operation by simultaneously stitching and overedging.	515 or 516 or 519	SSa-2	8-10	A	A
47.	<u>Join side and underarm seam of liner.</u>					
	a. Join the side and the underarm with a 3/8-inch seam.	301	SSa-1	8-10	A	A
	b. Overedge stitch the raw edge together.	503 or 504 or 602	SSa-1	8-10	A	A
	-or-					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
47.	<u>Join side and underarm seam of liner. (cont'd)</u>					
	c. As an alternate, operation 47a and 47b, may be performed in one operation by simultaneously stitching and over-edging:	515 or 516 or 519	SSa-2 SSa-2 SSa-2	8-10 8-10 8-10	A A A	A A A
48.	<u>Bind edges of liner and attach label.</u>					
	a. Bind edges of liner as specified herein. The binding shall be uniformly stitched with no raw edges showing. The fabric shall be caught in the stitching. The finished binding shall be 3/16 to 1/4 inch wide.	301 or 401 and Bar- tack	BSc-1 BSc-1	10-12 10-12	A A	A A
	(1) Bind the edge of the vent, the bottom, the fronts, and the neck in one operation. Catch the top of the size label under the binding at center of back neck area. The binding shall not be started or finished at the top of the vent. The ends of the binding shall be turned in and binding shall overlap not less than 1/2 inch. The end of the binding shall be turned on itself and securely stitched or bartacked. The bartack shall be 1/2 + 1/16 inch long.			28 stitch- es per bartack		
	(2) Bind the bottom of each sleeve. The binding shall be started and finished at the underarm seam. The end of the binding of each sleeve shall be formed into a loop that will accommodate the 22-line button on the inside of sleeve. The end of the binding of each sleeve shall be bartacked or securely stitched. The bartack shall be 5/8 + 1/16 inch long.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
49.	<u>Sew size label to liner.</u>					
	a. Stitch the two sides and bottom of the size label to the back of the liner.	301	LSbj-1	10-12	A	A
50.	<u>Set slide fastener on liner.</u>					
	a. Position the slide fastener on the underside of the liner, as indicated by the pattern marks, with the back edge of the chain immediately adjacent to the bound edge of the liner. Turn in the raw end of the slide fastener tape 1/2 to 3/4 inch. Stitch the length of the slide fastener tape with the stitching superimposed on the binding stitching. The slider shall be on the left side of the finished liner. When the fastener tape has a fused end, turn in of the end is not required.	301	LSa-1	10-12	50	50
51.	<u>Clean coat and liner.</u>					
	a. Trim all ends.					
	b. Remove all loose threads.					
	c. Remove all spots and stains.					
	d. Remove all shade tickets.					
52.	<u>Attach liner to outer shell.</u>					
	a. Attach the liner to the outer shell with the slide fastener, checking the operation of the slide fastener to insure free and easy movement of the slider. When the slide fastener is closed, the outer shell and the liner shall not show any evidence of bulging or distortion. The liner shall match the outer shell in size.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
53.	<u>Attach belt to coat.</u> a. Match the belt to coat. Place the belt through the loops, thread the belt fastener through the underloop and button.					

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3.7 Dimensions. The finished measurements of the outer shell (coat) and the liner shall conform to the following:

Outer shell (coat)				
Measurements in Inches				
Size	Breast <u>1/</u>	Back Length <u>2/</u>	Sleeve Length <u>3/</u>	Belt Length <u>4/</u>
<u>SHORT</u>				
4	38	41	16	38
6	39	41-1/4	16	39-1/2
8	40	41-1/2	16	41
10	41	41-3/4	16	42-1/2
12	42-1/2	42	16	44
14	44	42-1/4	16	45-1/2
16	45-1/2	42-1/2	16	47
18	47-1/2	42-3/4	16	49
20	49-1/2	43	16	51
<u>REGULAR</u>				
4	38	43	17	38
6	39	43-1/4	17	39-1/2
8	40	43-1/2	17	41
10	41	43-3/4	17	42-1/2
12	42-1/2	44	17	44
14	44	44-1/4	17	45-1/2
16	45-1/2	44-1/2	17	47
18	47-1/2	44-3/4	17	49
20	49-1/2	45	17	51
22	51-1/2	45-1/4	17	53
<u>LONG</u>				
4	38	45	18	38
6	39	45-1/4	18	39-1/2
8	40	45-1/2	18	41
10	41	45-3/4	18	42-1/2
12	42-1/2	46	18	44
14	44	46-1/4	18	45-1/2
16	45-1/2	46-1/2	18	47
18	47-1/2	46-3/4	18	49
20	49-1/2	47	18	51
22	51-1/2	47-1/4	18	53
Tolerance <u>±</u>	3/4	1/2	1/2	3/4

1/ Breast measurement taken with coat buttoned from folded edge to folded edge in line with pit of armhole and multiplied by two.

2/ Back length measurement taken along center back seam from lower edge of under-collar to bottom edge of coat.

3/ Sleeve length measurement taken along inseam from pit of armhole to bottom end of sleeve.

4/ Belt length measurement shall be taken along the center from end to end.

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Liner			
Measurements in Inches			
Size	Breast <u>1/</u>	Back Length <u>2/</u>	Sleeve Length <u>3/</u>
<u>SHORT</u>			
4	31	31-1/4	15
6	31-1/2	31-1/2	15
8	33	31-3/4	15
10	34-1/2	32	15
12	36	32-1/4	15
14	37-1/2	32-1/2	15
16	49	32-3/4	15
18	41	33	15
20	43	33-1/4	15
<u>REGULAR</u>			
4	31	33-1/4	16
6	31-1/2	33-1/2	16
8	33	33-3/4	16
10	34-1/2	34	16
12	36	34-1/4	16
14	37-1/2	34-1/2	16
16	49	34-3/4	16
18	41	35	16
20	43	35-1/4	16
22	45	35-1/2	16
<u>LONG</u>			
4	31	35	17
6	32-1/2	35-1/4	17
8	33	35-1/2	17
10	34-1/2	35-3/4	17
12	36	36	17
14	37-1/2	36-1/4	17
16	49	36-1/2	17
18	41	36-3/4	17
20	43	37	17
22	45	37-1/4	17
Tolerance <u>+</u>	3/4	1/2	1/2

NOTE: The liner shall be placed flat on a table and measured as listed above:

1/ Breast measurement taken with liner folded in half (down center back) and measured from front bound edge to back folded edge in line with pit of armhole and multiplied by two.

2/ Back length taken along the center back neck edge to bottom of liner.

3/ Sleeve length measurement taken along the underarms from pit of armhole to bottom of sleeve.

3.8 Workmanship. The finished coat shall conform to the quality and grade of product established by this specification. The occurrence of defects shall not exceed the applicable point value or defect limit.

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4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements (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 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 Responsibility for compliance. All items must 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 assuring 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 Certification of compliance. Where certificates of compliance are permitted, the Government reserves the right to check test such items to determine the validity of the certification.

4.1.3 Responsibility for dimensional requirements. Unless otherwise specified in the contract or purchase order, the contractor is responsible for ensuring that all specified dimensions have been met. When dimensions cannot be examined on the end item, inspection shall be made at any point, or at all points in the manufacturing process necessary to ensure compliance with all dimensional requirements.

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

- a. First article inspection (see 4.4).
- b. Quality conformance inspection (see 4.5).

4.3 Inspection conditions. Unless otherwise specified all inspections shall be in accordance with the test conditions specified in MIL-STD-1494.

4.4 First article inspections. When a first article is required (see 3.2 and 6.2), it shall be examined for the defects specified in MIL-STD-1494.

4.5 Quality conformance inspection. Unless otherwise specified, sampling for inspection shall be performed in accordance with MIL-STD-105.

4.5.1 Component and material inspection. In accordance with 4.1, components and materials shall be inspected in accordance with all requirements of referenced specifications, drawings and standards unless otherwise excluded, amended, modified or qualified in this specification or applicable purchase document. The

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method of testing shall be as specified in FED-STD-191, wherever applicable. All test reports shall contain the individual values used in expressing the final result. The lot shall be unacceptable if one or more sample units fail to meet any of the test requirements specified. The lot size and sample size shall be in accordance with the following:

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

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

4.5.2.1 Bond strength of fusible interlining and tape. The strength of the bond of the fusible interlining and tape to the outer shell shall be tested once each 4 hours as follows at each fusing press to determine that adequate fusing is being obtained. Prepare a test sample by fusing the fusible interlining specified in 3.3.6 to the basic fabric of the outer shell specified in 3.3.1 under the same fusing conditions to be used in the manufacture of the coat. Determine the bond strength of the test sample with a commercial spring scale (see 6.8). If the bond strength of any test sample is less than 22 ounces per inch of width, the fusing conditions shall be corrected and the bond strength test shall be repeated. Those units represented by this test shall be fused again and retested. If they fail, they shall be rejected.

4.5.3 End item visual examination. The end items shall be examined for visual defects in accordance with the provisions of MIL-STD-1494.

4.5.4 End item dimensional examination. The end items shall be examined for dimensional defects in accordance with the provisions of MIL-STD-1494.

4.5.5 Sampling test. Samples of the end item shall be subjected to the sampling tests listed below. If one or more sample units fail to meet any test requirements listed below, the lot represented shall not be accepted.

<u>Sampling test</u>	
<u>Characteristics</u>	<u>Test Methods</u>
<u>End Item appearance</u>	
Bubbling or delamination of fused area after five dry cleanings	Dry cleaning and visual <u>1/</u>
Strike through of adhesive	Visual
<u>1/ The complete coat shall be dry cleaned five times in a single unit, coin-operated cycle capable of providing a complete automatic dry to dry cycle, using perchlorethylene and then shall be visually examined for bubbling and delamination of the fused areas.</u>	

After the coat has been subjected to five dry cleanings, the coat shall not show any evidence of bubbling or delamination of the fused areas. The coat shall not have any "strike through" of the adhesive after fusing.

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4.5.6 Packaging examination. The fully packaged end items shall be examined in accordance with the provisions of MIL-STD-1494.

5. PACKAGING

5.1 Packaging. Packaging shall be level A or commercial as specified (see 6.2).

5.1.1 Level A. Each coat shall be buttoned and then folded to approximately 14 inches by 22 1/2 inches. Each folded coat shall be inserted in a close fitting flat style clear polyethylene bag conforming to A-A-50083. The bag shall be at least 1 inch longer than the folded coat. The unsealed opening of the bag shall be at the smaller dimension of the bag.

5.1.2 Commercial preservation. The coats shall be preserved in accordance with ASTM D 3951.

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

5.2.1 Level A. Ten coats of one size and class only, packaged as specified, shall be packed in a fiberboard shipping container that is assembled, closed, and reinforced in accordance with grade v2s, size 3A of MIL-B-17757. The fiberboard for the liner shall conform to type CF, class weather-resistant, variety DW, grade V15c of MIL-B-17757. Level A packages shall be packed flat with every other coat reversed top to bottom within the shipping container. The top and the bottom of the contents of the shipping container shall be completely covered with a sheet of 30 pound (minimum) basis weight paper conforming to A-A-203. Shipping containers shall be arranged in unit loads in accordance with MIL-L-35078 for the type and class of load specified (see 6.2). Strapping shall be limited to nonmetallic strapping for type II, class F loads.

5.2.1.1 Level B. Ten coats of one size only, packaged as specified, shall be packed in a shipping container that is assembled and closed to conform to class domestic, variety DW, grade 275, size 3A of MIL-B-17757. The fiberboard for the liner shall conform to type CF, class domestic variety DW, grade 275 of PPP-F-320. Level A packages shall be packed flat, with every other coat reversed top to bottom within the shipping container. The top and the bottom of the contents of the shipping container shall be completely covered with a sheet of 30 pound (minimum) basis weight paper conforming to A-A-203. Shipping containers shall be arranged in unit loads in accordance with MIL-L-35078 for the type and class of load specified (see 6.2). Strapping shall be limited to nonmetallic strapping for type II, class F loads.

5.2.2 Optional shipping container. If specified by the procuring activity (see 6.2), a weather resistant shipping container shall be fabricated in accordance with grade V3c or V3s of MIL-B-17757 and classed in accordance with the appendix of the container specification. If specified by the procuring activity (see 6.2), the material for the shipping container shall conform to grade V4s of PPP-F-320.

5.2.3 Commercial packing. Coats, packaged as specified in 5.1, shall be packed in accordance with ASTM D 3951.

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5.2.4 Hanger pack. When specified (see 6.2), 10 coats of one class and size shall be placed on a 16 inch hanger and packed in a type I container (hanger pack) in accordance with MIL-C-44192, except the inside depth of the box shall be 48 inches (+0, -2 inches). The loaded containers shall be palletized and marked in accordance with MIL-C-44192.

5.3 Marking. In addition to any special marking required by the contract or purchase order, unit packs, shipping containers and palletized unit loads shall be marked in accordance with the requirements of MIL-STD-129 or ASTM D 3951, as applicable.

5.3.1 Polyethylene bags. Each polyethylene package (see 5.1.1) shall have the nomenclature, stock number and size of the item packaged therein legibly printed or stamped in black directly across the center face of the bag or on a white paper label inserted within the bag so that it is readable through the polyethylene.

5.4 Palletization. When specified (see 6.2), coats packed as specified in 5.2.1 and 5.2.2 shall be palletized on a 4-way entry pallet in accordance with load type 1A of MIL-STD-147. Pallet type shall be type I (4-way entry), type IV or type V in accordance with MIL-STD-147. Pallets shall be fabricated from wood groups I, II, III or IV of MIL-STD-731. Each prepared load shall be bonded primary and secondary straps in accordance with bonding means C and D or film bonding means F or G. Pallet pattern shall be in accordance with the appendix of MIL-STD-147. 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 used shall be approved by the contracting officer.

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 covered by this specification is intended to be worn by female personnel of the U.S. Marine Corps and the U.S. Army.

6.2 Acquisition requirements. Acquisition documents must specify the following:

- a. Title, number, and date of this specification.
- b. Size and class required (see 1.2).
- c. Issue of DoDISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.1.1 and 2.2).
- d. When a first article is required (see 3.2, 4.4 and 6.4).
- e. Levels of packaging and packing (see 5.1 and 5.2).
- f. Type and class of unit load required (see 5.2.1).
- g. When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2).
- h. When palletization is required (see 5.4).

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6.3 First article. When a first article is required, it shall be inspected and approved under the appropriate provisions of FAR 52.209. The first article should be a preproduction sample. The contracting officer should specify the appropriate type of first article and the number of units to be furnished. The contracting officer should include specific instructions in all acquisition instruments regarding arrangements for selection, inspection, and approval of the first article.

6.4 Standard sample. The standard sample and color sample may be obtained from the acquiring activity or as directed by the contracting officer.

6.5 Subject term (keyword) listing.

Cover
Female
Repellant
Weather

6.6 Figures. Figures 1 through 8 show general design of the coat and are furnished for information purposes only. In the event of conflict between these figures and the text of this specification, the text of this specification shall govern.

6.7 Fusing conditions. Specific machine setting should be obtained from the supplier of the particular fusible material for optimum results. The following fusing conditions include the recommendations of several suppliers of fusible material and are furnished for guidance only.

6.7.1 Fusible interlining. (See 3.3.5)

- (a) Temperature between pressing surfaces of 280°F minimum and 310°F maximum, at the fuseline (not the temperature at the clock).
- (b) Pressure between pressing surfaces of four pounds force per square inch ($1\text{b}_f/\text{in}^2$) minimum and five $1\text{b}_f/\text{in}^2$ maximum.
- (c) Pressing time of 10 seconds minimum and 12 seconds maximum.
- (d) Heat-dry.

6.8 Peel strength test. The procedure for the peel strength testing with a spring scale should be obtained from the supplier of the fusible material, and shall be accomplished 2 hours after fusing.

6.9 Changes from previous issue. Asterisks are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.

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Preparing activity
Navy-MC
Project No. 8410-0745

Custodian:
Army-GL

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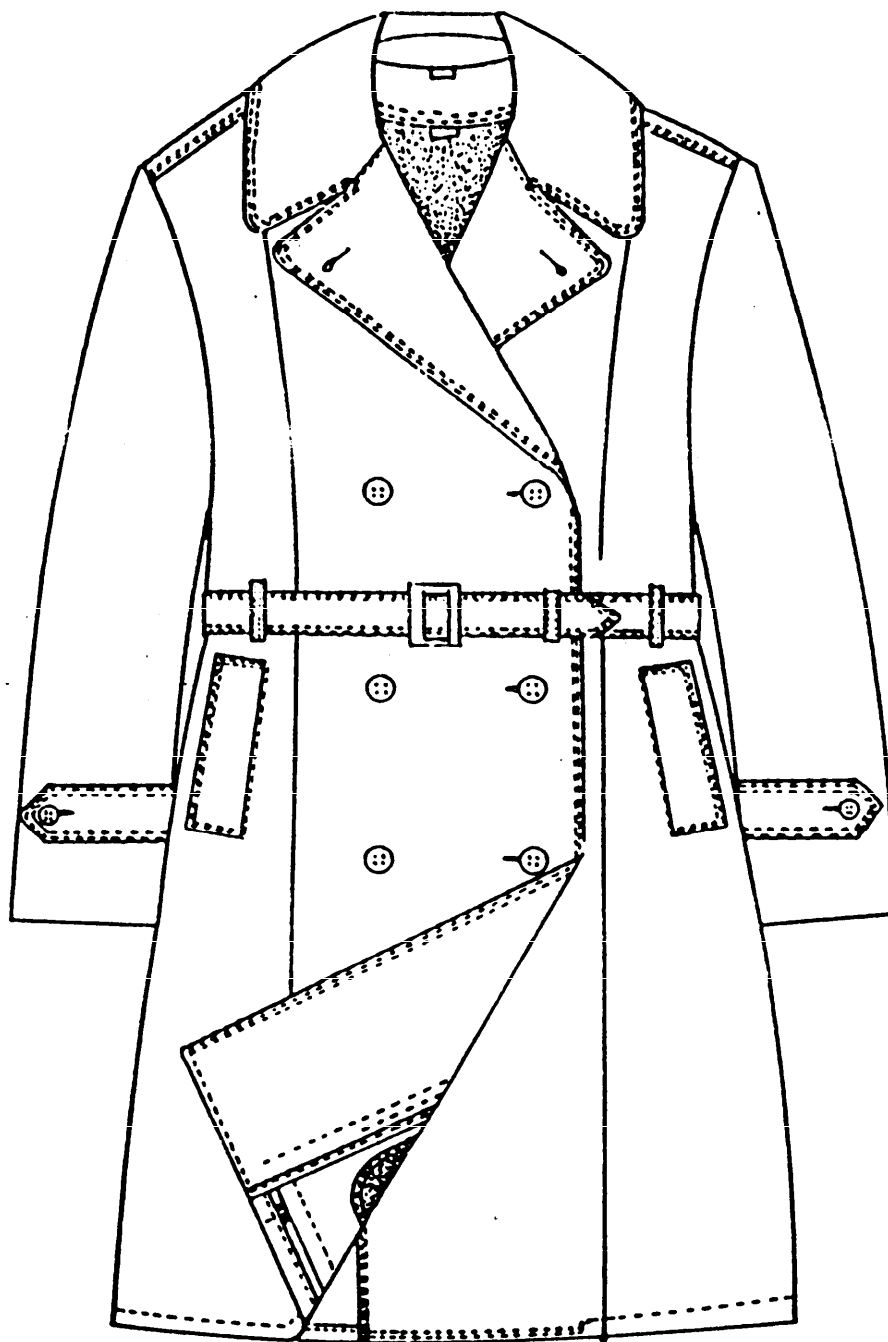


FIGURE 1: Coat, All-weather. Women's, Classes 1 & 2

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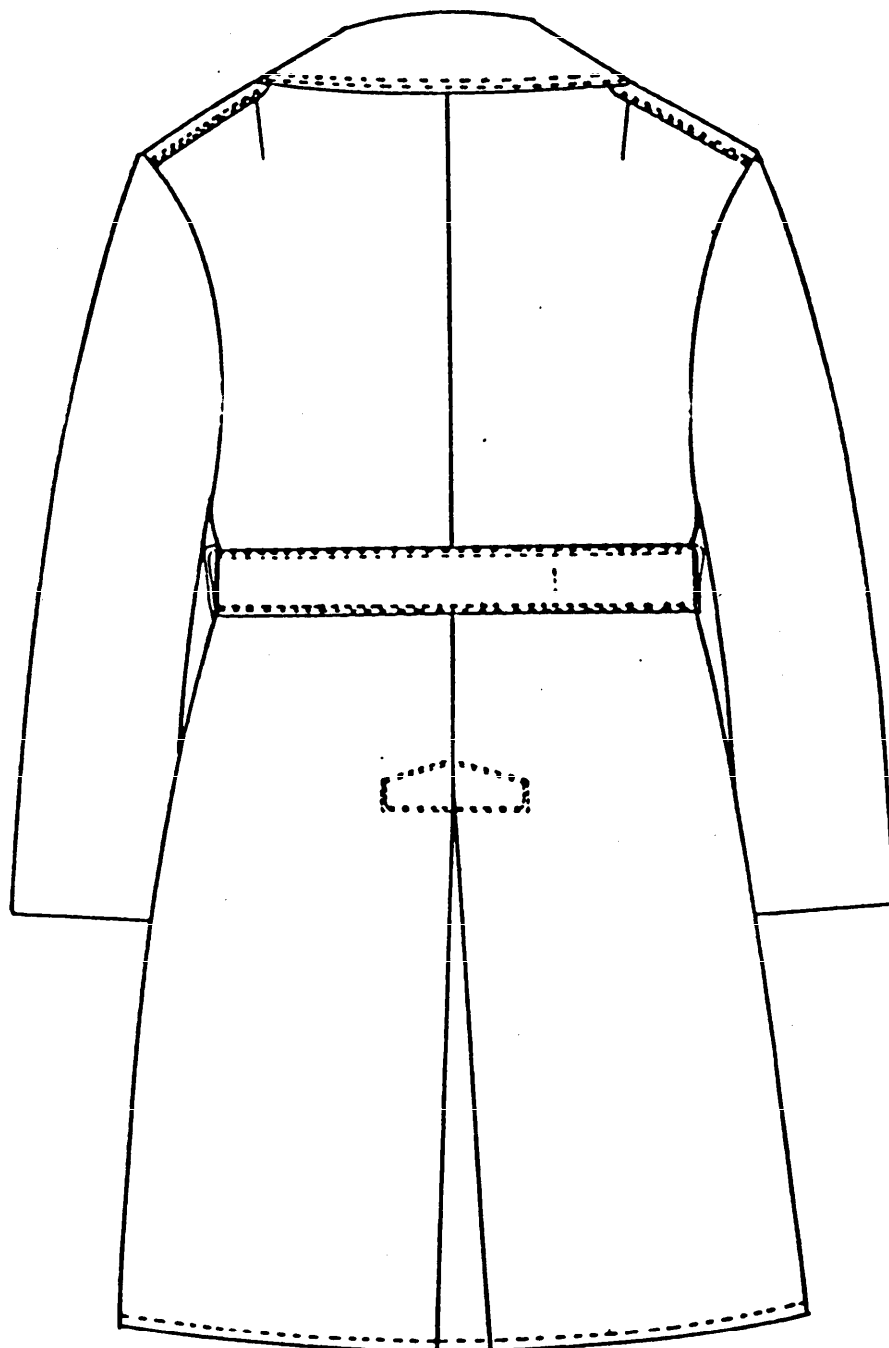


FIGURE 2: Coat, All-weather, Women's, Classes 1 & 2

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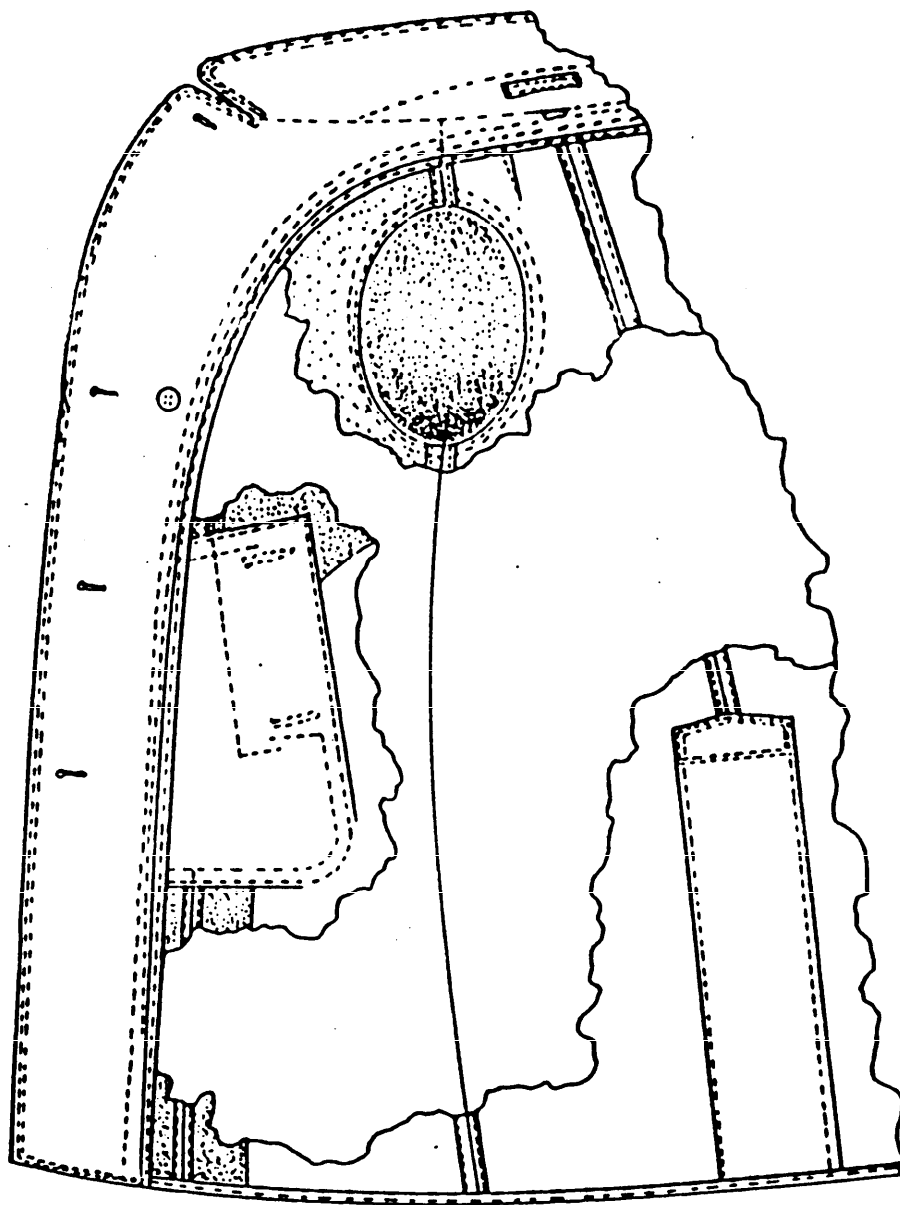


Figure 3: Coat, All-weather, Women's

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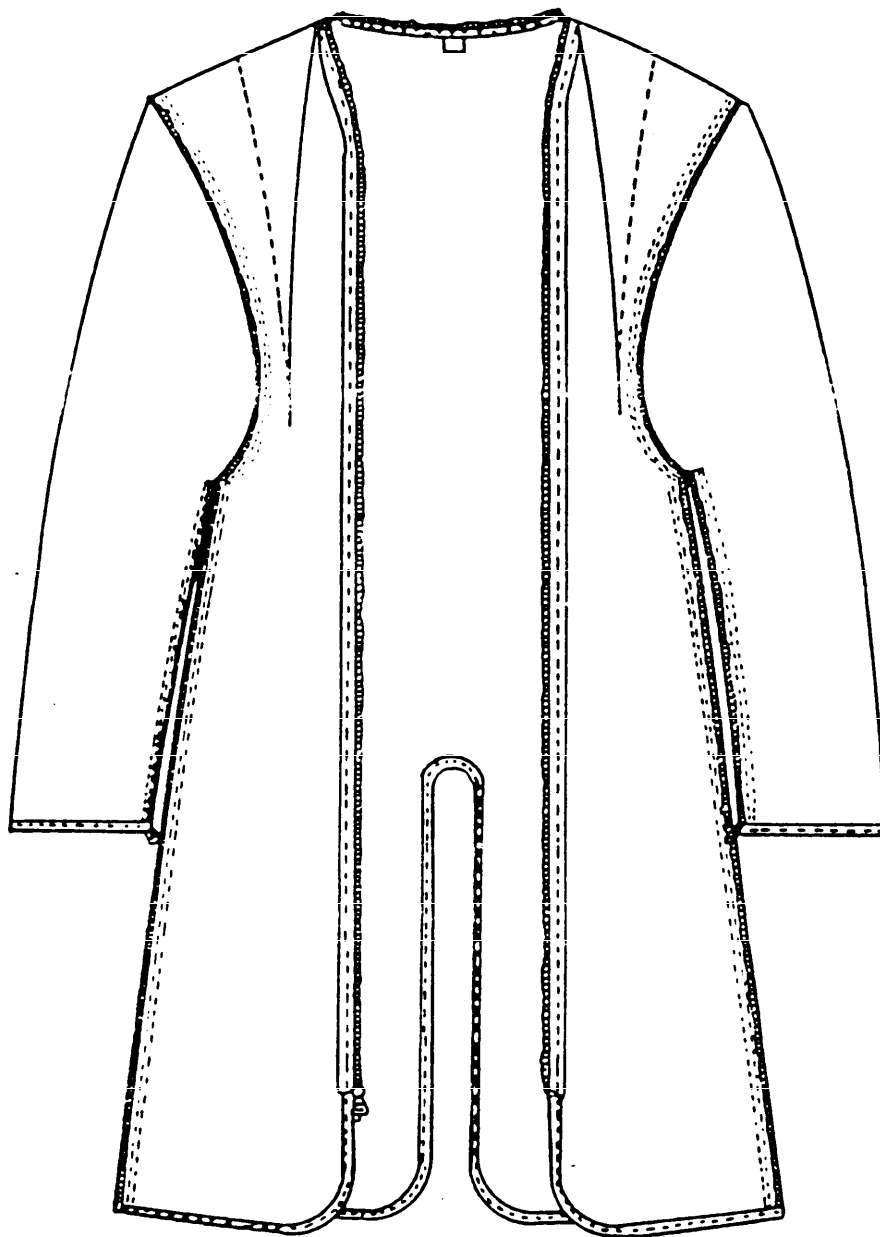
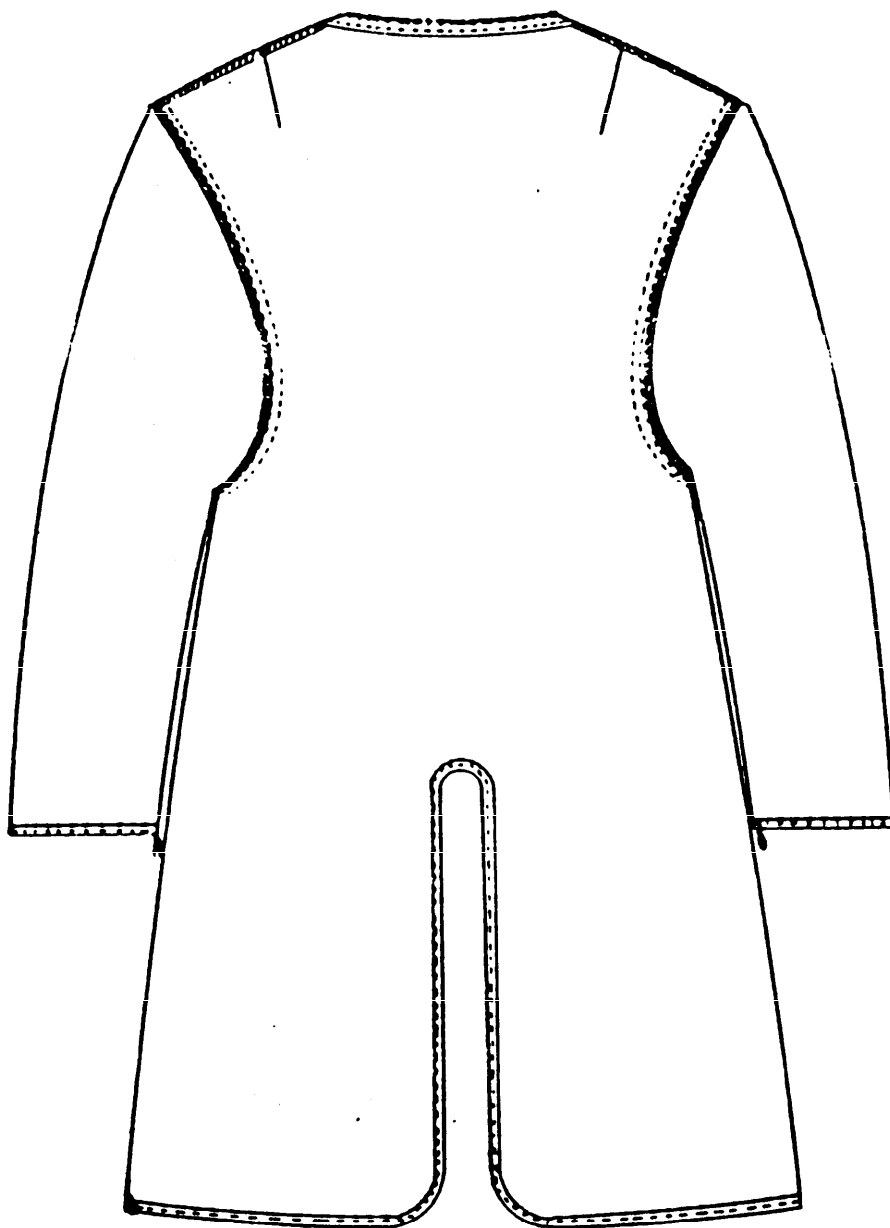


Figure 4: Coat All-weather, women's, liner

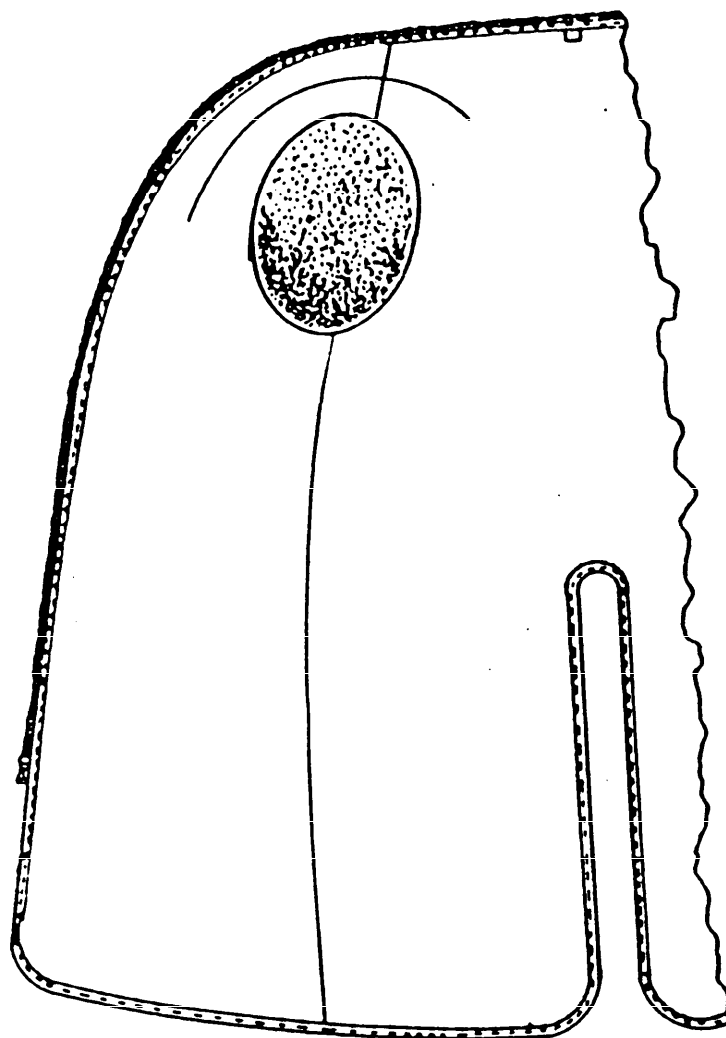
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OUTSIDE BACK

Figure 5: Coat, All-weather, women's, liner

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OUTSIDE SIDE

Figure 6: Coat, All-weather, women's, liner

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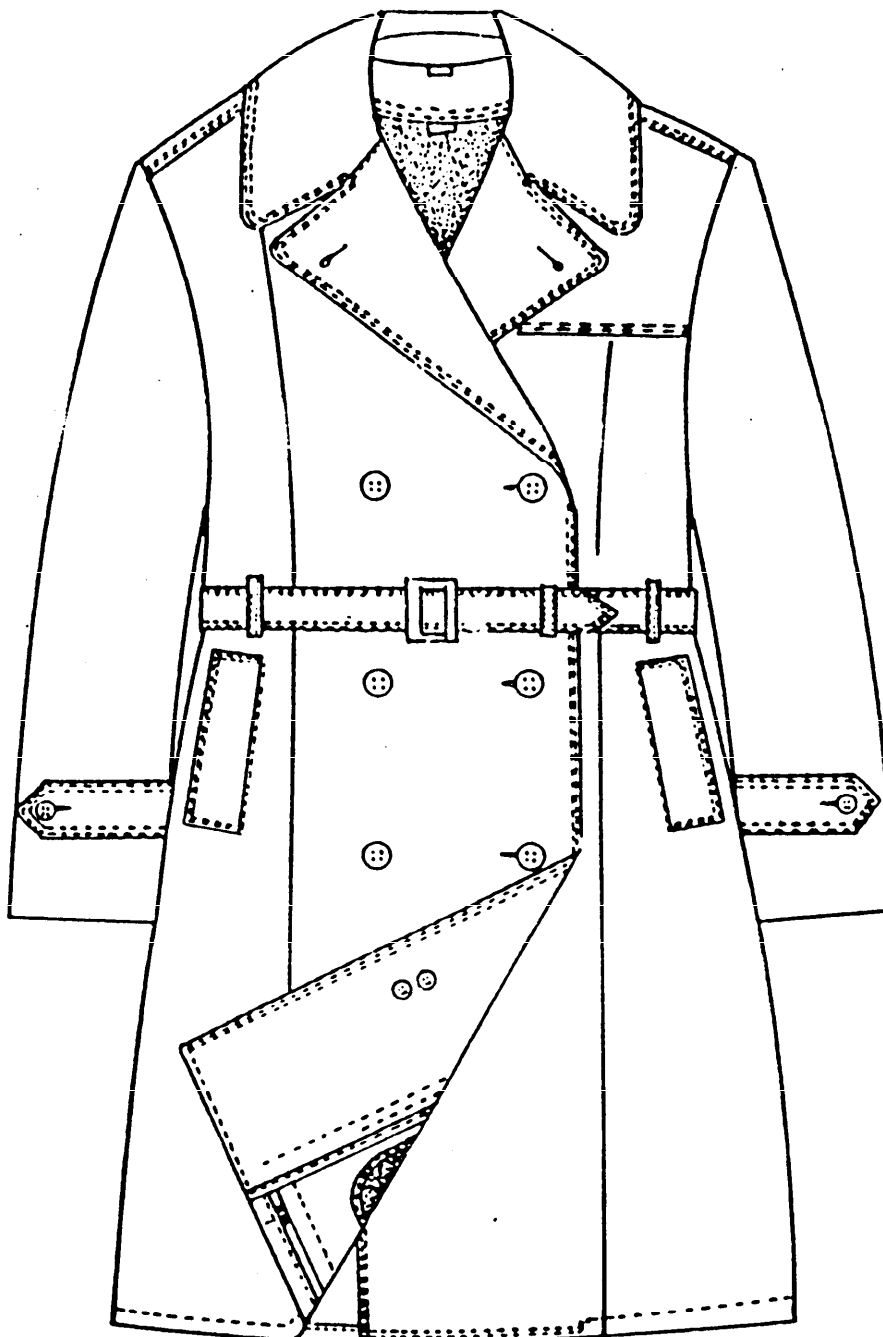


FIGURE 7: Coat, All-weather. Women's, Class 3

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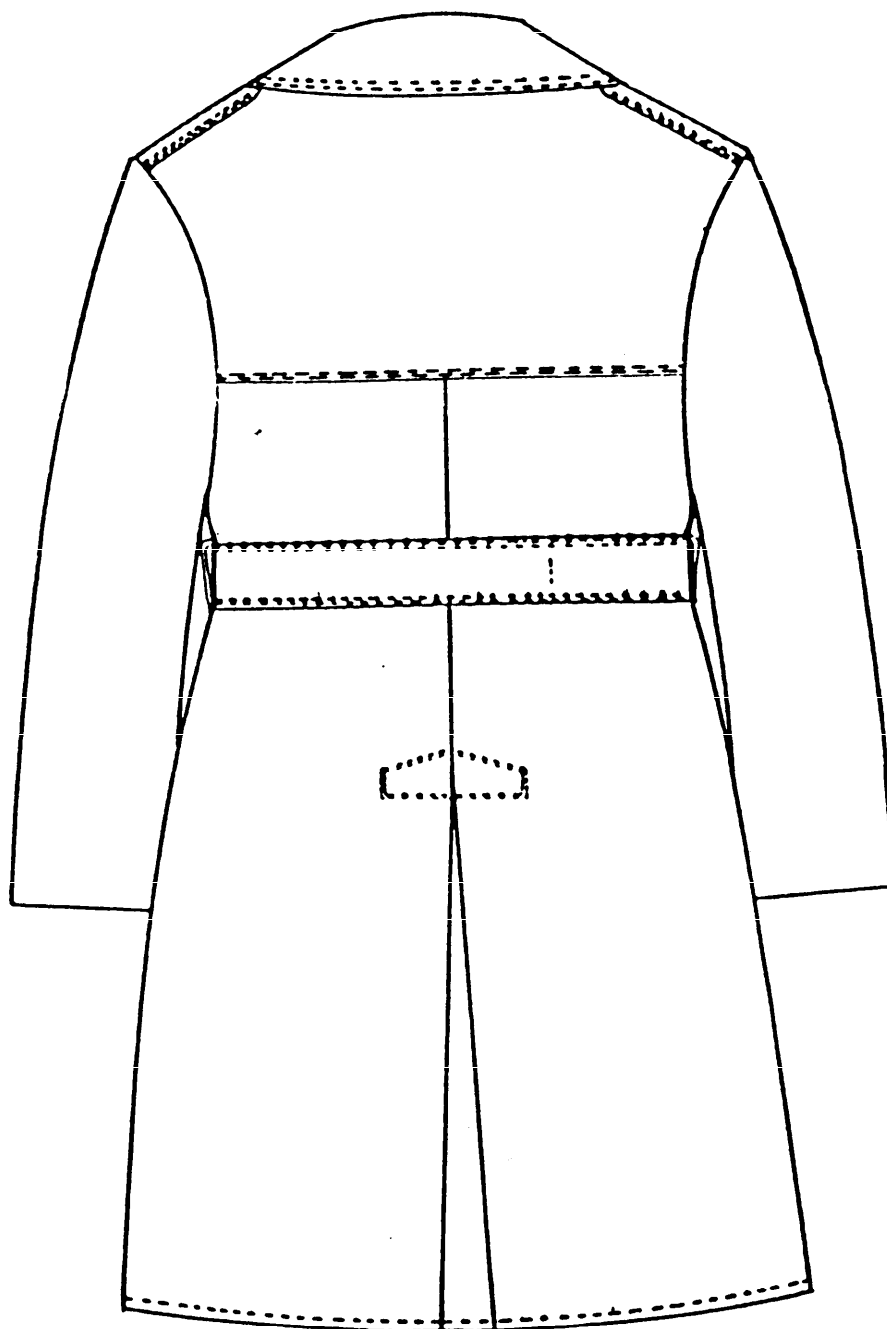


FIGURE 8: Coat, All-weather, Women's, Class 3

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

INSTRUCTIONS

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

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

I RECOMMEND A CHANGE:	1. DOCUMENT NUMBER MIL-C-29381C	2. DOCUMENT DATE (YYMMDD) 10 SEPTEMBER 1990
3. DOCUMENT TITLE COAT, ALL-WEATHER, WOMEN'S		
4. NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)		
5. REASON FOR RECOMMENDATION		
6. SUBMITTER		
a. NAME (Last, First, Middle Initial)	b. ORGANIZATION	
c. ADDRESS (Include Zip Code)	d. TELEPHONE (Include Area Code)	7. DATE SUBMITTED (YYMMDD)
	(1) Commercial (2) AUTOVON (if applicable)	
8. PREPARING ACTIVITY		
a. NAME Commanding General, Marine Corps Research, Development, and Acquisition Command (PSE-C)	b. TELEPHONE (Include Area Code)	(1) Commercial (2) AUTOVON
	(202) 696-1186/87/88	226-1186/87/88
c. ADDRESS (Include Zip Code) Washington, DC 20380-0001	IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT: Defense Quality and Standardization Office 5203 Leesburg Pike, Suite 1403, Falls Church, VA 22041-3466 Telephone (703) 756-2340 AUTOVON 289-2340	