

INCH-POUND

MIL-C-29632(CG)

20 March 1990

MILITARY SPECIFICATION**COAT, MAN'S, POLYESTER/WOOL, SERGE, FUSIBLE (COAST GUARD)**

This specification is approved for use by the United States Coast Guard, Department of Transportation, 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 man's blue single breasted dress coat fabricated of polyester/wool serge cloth with fusible fronts, collars, lapels, and sleeve hems.

1.2 Classification. The coat shall be of one type, in the following sizes and lengths, as specified in (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: Short, Regular, Long, and Extra Long

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).

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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MIL-C-29632(CG)

SPECIFICATIONS

FEDERAL

- C-F-206 - Felt Sheet, Cloth, Felt, Wool, Pressed
- V-T-276 - Thread, Cotton
- V-T-280 - Thread, Cotton Gimp, Buttonhole
- V-T-285 - Thread, Polyester
- V-T-295 - Thread, Nylon
- V-T-301 - Thread, Silk
- CCC-C-438 - Cloth, Buckram, Woven and Non-Woven
- 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-297 - Cloth, Interlining, Cotton or Synthetic Warp, and Spun Hair-wool or Rayon Filling
- MIL-C-368 - Cloth, Satin, Rayon and Cloth, Twill, Rayon
- MIL-B-371 - Braid, Textile Tubular
- MIL-C-823 - Cloth, Serge; Wool, Wool and Nylon, Polyester and Wool
- MIL-B-3461 - Buttons, Insignia, Metal, Uniform and Cap
- MIL-C-15062 - Cloth, Flannel, Wool, Undercollar Cloth
- MIL-P-15064 - Pads, Shoulder and Sleeve Head
- MIL-C-29137 - Cloth, Felt-Fabric, Composite, Undercollar
- MIL-T-43548 - Thread, Polyester Core: Cotton-, Rayon-, or Polyester-Covered
- MIL-C-43718 - Cloth, Twill, Polyester, Polyester and Cotton; Polyester and Rayon
- MIL-C-44121 - Cloth, Twill, Polyester
- 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 Stitchings

MILITARY

- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
- MIL-STD-129 - Marking for Shipment and Storage
- MIL-STD-2073-1 - DOD Materials Procedures for Development and Application of Packaging Requirements
- MIL-STD-2073-2 - Packaging Requirement Codes

MIL-C-29632(CG)

(Unless otherwise indicated, copies of federal and military specification, 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, 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.

CODE OF FEDERAL REGULATIONS

Title 9 - Animal and Animal Products

Part 95 - Sanitary Control of Animal By-Products

(Copies of The Code of Federal Regulations (CFR) and the Federal Register (FR) are for sale on a subscription basis by 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 specification to the extent specified herein. Unless otherwise specified, the issue of documents which are DoD adopted shall be those listed in the issue of the DODISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of the documents cited in the solicitation (see 6.2).

AATCC Photographic Comparative Rating of Single and Double Needle Seams

Method 88B - Two photos

(Applications for copies should be addressed to the American Association of Textile Chemists and Colorists, P.O. Box 12215, Research Triangle Park, NC 27709-9989.)

THE COLOR ASSOCIATION OF THE UNITED STATES

Department of Defense Standard Shades for Sewing Threads

(Application for copies of color cards should be addressed to the Color Association of the U.S., Inc., 343 Lexington Avenue, New York, NY 10016-0927.)

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

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

3. REQUIREMENTS

MIL-C-29632(CG)

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 a 11.5 ounce polyester/wool serge conforming to type III, class 3 of MIL-C-823. The color shall be shade Blue 3362 and the piece number shall be 80353.

3.3.2 Lining. The material for lining the fronts, sleeves, yoke, right vent, and for the weltings and facings of the inside breast pockets shall be rayon lining, 3.7 ounce, shade Blue 3351, conforming to class 1 of MIL-C-368. The piece number for the standard sample is 1533. As an alternate, the lining material may be a polyester twill cloth, Blue 334, conforming to MIL-C-44121.

3.3.3 Undercollar interlining. The material for the undercollar 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 minimum stiffness requirement (inch pounds) shall be 0.015 in the filling.

3.3.4 Fusible interlinings.

3.3.4.1 Fronts fusible interlining. The fusible interlining for the coat fronts shall be black and conforming to MIL-C-44296, type II, class 1, style B, except the minimum dots per inch shall be 200; or type VIII, class 1, except that the weight shall be 2.1 ounces per yard² ($\pm 0.5\text{oz.}$), with a minimum dots per inch of 200; or type V, class 1, style B, except that the minimum dots per inch shall be 200.

3.3.4.2 Small parts fusible interlining. The lapels, collars, and sleeve hems known as "small parts", shall use a black fusible interlining and shall conform to type V, class 1, style A or B of MIL-C-44296.

3.3.4.3 Fused state bonding strength. The small parts and fronts fusible material for preproduction and in-process testing shall meet an initial minimum bonding strength requirement in the warp (machine) direction of 32 ounces per inch or splits prior to drycleaning when tested as specified in Table V, and minimum 24 ounces per inch or splits in the warp (machine) direction after three drycleanings and pressings when tested as specified in 4.4.3.1. Additionally the small parts fusible interlining will be accepted if it either begins to debond from the outer shell material, equivalent to the minimum bond strength or higher, and then splits from itself or if the small parts fusible readily splits from itself at a minimum tear strength of 6.0 ounces per inch.

3.3.4.4 Colorfastness. All dyed finished fusible interlining materials shall show a fastness to drycleaning as specified in MIL-C-44296, except when no standard sample is available, the finished fusible materials shall show "fair" fastness to drycleaning.

MIL-C-29632(CG)

3.3.4.5 Shrinkage. The interlining, after fusing to the basic cloth as specified in 3.3.4.6, shall not exceed 1.5 percent differential shrinkage when tested as specified in 4.4.3.1. Additionally, the interlining after fusing to the basic cloth as specified in 3.3.4.6 shall not exceed 2.0 percent shrinkage after drycleaning when testing as required in 4.4.3.1. All drycleaned materials shall not exhibit any sign of bubbling, puckering or delamination.

3.3.4.6 Fusing press operating procedure and conditions. A single layer of fusible interlining shall be fused to a single layer of basic material on a dry electrically heated conveyor type fusing press which has the capacity of controlling and retaining pressure, dwell time, and temperature for a minimum of 8 hours. Pair or sandwich fusing which can create differential shrinkage, stitching and uneven bonding shall not be permitted. A steam sourced fusing press shall not be allowed for any initial fusing operations. For optimum results, the fusible material manufacturers recommendations for fusing dwell time, pressure, and temperature, based upon the fusing equipment used and basic material being fused, shall be utilized. Common fusing press settings shall be established in order to fuse both the small parts and fronts fusibles together. Basic preproduction and production maintenance procedures, including a fusing press information chart, shall be required to assure proper fusing press performance relative to temperature control, evenness in pressure head or roller contact, dwell time and cleanliness. Results of the production maintenance procedures shall be recorded on Figure 3.

3.3.5 Undercollar cloth. The undercollar material shall be wool tanned conforming to MIL-C-15062 with an interlining of cotton buckram conforming to CCC-C-438. The shade shall be black or a blue shade approximating the basic material and requirements for perspiration and crocking shall not apply.

3.3.6 One piece undercollar. As an alternate a one piece undercollar may be used and shall be a felt/fabric composite material conforming to MIL-C-29137. The shade shall be black or a blue shade approximating the basic material and requirements for perspiration and crocking shall not apply. When felt/fabric composite is used the cotton buckram interlining is not required.

3.3.7 Pocketing. The material for lining the lower pockets, inside breast pockets, top of vent, and for use as 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 or shall match the lining or basic material and shall show good fastness to wet-dry cleaning and a Munsell value for crocking not lower than 8.5 when tested as specified in 4.4.1.

3.3.9 Floating chest piece.

3.3.9.1 Cloth chest piece. The chest piece and wedge piece shall be cotton warp and spun hair-wool filling interlining conforming to type I, class 2 of MIL-C-297.

MIL-C-29632(CG)

3.3.9.2 Haircloth. The shoulder piece shall be 2-ply cotton warp and natural horsehair filling cloth, undyed, having not less than 60 ends and 40 picks per inch, weighing not less than 4.5 ounces per square yard, and containing no sizing when tested as specified in 4.4.1. The horsehair shall meet current Quarantine Laws and pertinent regulations of the U.S. Department of Agriculture as set forth in the Code of Federal Regulations.

3.3.9.3 Felt cloth. The felt piece for padding the floating chest piece shall be felt made of pressed wool conforming to type III (roll-felt), class 11A2 of C-F-206.

3.3.9.4 Thread. The thread for seaming and stitching the chest piece shall be cotton, soft finish, type IA1 or type IA2, shade White AH, C.A. 66050, ticket No. 50 or 70, 2-ply, conforming to V-T-276.

3.3.10 Shoulder and sleeve-head pads. The shoulder 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 and binding.

3.3.11.1 Woven tape. The tapes for staying the coat shall be cotton, preshrunk, conforming to classes 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 for bridle at breakline of lapel
- Type II - 3/16 inch wide stay for left vent, neck gorge, back armhole, and lower part of front armhole
- Type III - 3/8 inch wide stay for lapel, front, and bottom edges

3.3.11.2 Cross-cut tape. The tapes for staying the shoulder, back neckline, and upper part of front armhole shall be cross-cut, 1/2 inch in width, 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.

3.3.12 Thread.

3.3.12.1 Polyester, covered. The thread for the coat shall be a polyester core thread, dyed shade Blue AT, Cable No. 66060 conforming to MIL-T-43548 in the following types and sizes shall be used. The polyester covered, polyester core thread is not allowed.

Use	Ply	Ticket No.
Assembling and tacking	2 or 3	50, 70
Button sewing		
Hand	2 or 3	16
Machine	2 or 3	20

MIL-C-29632(CG)

3.3.12.2 Cotton thread. As an alternate to the polyester core thread, a cotton thread may be use, and shall be dyed shade Blue AT, Cable No. 66060 and shall conform to V-T-276 in the following types and sizes:

Use	Type	Ticket No.	Ply
Seaming and stitching	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
Padding lapels	IA3	70	2

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

3.3.12.4 Silk thread. The silk thread shall be dyed to approximate Cotton Shade Blue AT, Cable No. 66060 and shall conform to V-T-301 in the following types and sizes:

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

3.3.12.5 Alternate threads. The following threads may be utilized as alternates to the silk and cotton threads specified above for the operations indicated:

(a) For machine 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.

3.3.12.6 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.

MIL-C-29632(CG)

3.3.12.6.1 Colorfastness of thread. The dyed threads shall show colorfastness to wet-dry cleaning and light equal to or better than the standard sample when tested as specified in V-T-276, V-T-285, V-T-295, V-T-301, or MIL-T-43548. When no standard sample is available, the dyed threads shall show good colorfastness to wet-dry cleaning and light when tested as specified in V-T-276, V-T-285, V-T-295, V-T-301 or MIL-T-43548.

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 shade Blue AT, Cable No. 66060.

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

3.3.14 Buttons. The metal buttons for the coat shall be gold plated, 22-1/2 line, hopper back (flat) with bodkin type toggles for the front pocket flaps, and 35 line hopper back (depressed) for the right front conforming to type I, style 5, class A of MIL-B-3461, except length of bodkin for 22-1/2 line button shall be 15/16 (+ 1/32) inches.

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, POLYESTER/WOOL, SERGE
 CONTRACT NO: DLA 100-00-0-0000 (EXAMPLE)
 STOCK NO: 8405-00-000-0000 (EXAMPLE)
 SIZE: 38 REGULAR (EXAMPLE)
 NAME OF CONTRACTOR:
 NAME OF MANUFACTURER (If other than the contractor)

3.3.15.2 Personal and 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

MIL-C-29632(CG)

3.3.15.3 Size ticket. A commercial type size ticket shall be attached on the outside of the right front 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 ticket shall be made of suitable commercial cardboard and shall be legibly printed with the following information:

Size - 38 Regular (Example)

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

3.4 Design. The coat shall be single breasted with four buttons and square fronts, notched lapels with two inner breast welt pockets. The coat shall have a patch pocket and pocket flap on each breast and a hanging pocket on each lower front with a pocket flap. Each flap shall have a dummy buttonhole and bodkin style button. The coat shall have a 1/2 lined yoke back, side-body panels, two piece fully lined sleeves, and single back vent. The coat shall contain a floating chest piece, shoulder pad and sleeve head, fused fronts, collars, lapels and sleeve hem. There shall be a hanger loop at the center back neck (see Figures 1 and 2).

3.4.1 Figures. 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. Also, minor modifications are permitted where necessary when using automatic equipment. These modifications shall not alter the dimensional, serviceability, or appearance requirements cited in the specification. The seam allowance shall be 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:

MIL-C-29632(CG)

Material	Pattern Parts	Cut Parts
Cloth, Serge, Polyester/Wool	Front	2
	Side body	2
	Back	2
	Right front facing	1
	Left front facing	1
	Topsleeve	2
	Undersleeve	2
	Topcollar	1
	Breast patch pocket	2
	Breast patch pocket flap	4
	Lower pocket flap	4
	Lower pocket top and bottom piping	2
	Lower pocket facing	2
Cloth, Lining	Front lining	2
	Back yoke lining	1 <u>1/</u>
	Topsleeve lining	2
	Undersleeve lining	2
	Right vent lining	1
	Inside breast pocket welt and facing	2 <u>2/</u>
Twill Cloth	Lower pocket	2
	Lower pocket stay	2
	Inside breast pocket stay	2
	Inside breast pocket	2
Cloth, Wool, Flannel	Undercollar	1 <u>1/</u>
Cloth, Buckram, Cotton	Undercollar interlining	1 <u>1/</u>
Cloth, Felt/Fabric Composite	Undercollar (alternate)	1
Cloth, Chest Piece - Hymo	Chest piece	2
	Wedge piece	2
Haircloth	Shoulder piece	2
Cloth, Felt	Chest piece	2
Cloth, Fusible (fronts)	Front interlining	2
Cloth, Fusible (small parts)	Top collar interlining	1
	Top sleeve hem interlining	2
	Undersleeve hem interlining	2
	Lapel facing interlining	2
	Undercollar interlining	1
	Breast pocket interlining	2
	Breast pocket hem interlining	2

MIL-C-29632(CG)

Templates	Lapel shaper	-
	Undercollar shaper	-
	Left and right front marker	-
	Undercollar stand marker	-
	Breast patch pocket marker	-
	Finished lapel and collar shaper	-
	Finished lower pocket flap	-
	Finished breast pocket flap	-
	Finished breast pocket	-

1/ Pattern may be cut as two (2) pieces with seam allowance added.

2/ When automatic pocket machine is used, the pattern part shall be cut in half.

3.6 Construction.

3.6.1 Stitches, seams and stitchings. Stitch, seam and stitching types specified in Table I shall conform to FED-STD-751. Whenever two or more methods for seam or stitch types are given for the same part of the operation any one may be used. Seam allowance shall be maintained with seams 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 trousers. Ends of all seams produced by stitch type 401 shall be caught in other seams or stitching. Top stitching and edge stitching shall be 1/16 to 1/8 inch from the edge. The bight of the overedge stitching shall be 3/16 inch. The guide and knife shall be set to trim only the ravelled ends of the fabric. Double needle stitching shall be 1/4 (+ 1/16) inch gauge, with the outer row of stitching 1/16 to 1/8 inch from the finished edge. Buttonholes shall be clean cut and the stitching shall be securely caught in the fabric. Bartacks shall be 3/8 inches long and the width shall be 1/8 (+ 1/32) inch wide.

3.6.2 Thread breaks and ends of seams. End of all seams and stitching when not caught in other seams or stitching shall be backtacked not less than 3/8 inch. The ends of a continuous line of stitching (except label) shall be overlapped not less than 1/2 inch. The ends of label stitching shall be overlapped not less than 3 stitches. Thread breaks (all stitch type) shall be repaired by stitching back of the break not less than 1/2 inch. Skipped stitches or thread breaks on 401 stitch type may be repaired by using 301 stitch type. When ends of overedge stitching are not caught in other seams or stitching, the ends shall be tacked.

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

MIL-C-29632(CG)

3.7 Manufacturing operations requirements. The coats shall be manufactured in accordance with all 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 equipments. These modifications shall not alter the dimensional, serviceability, or appearance requirements cited in the specification.

3.7.1 Pressing. All pressing operations referenced in Table I shall be performed by using a heated pressing iron or 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) The use of corrosive metal fastening devices or sew-on type tickets.
- (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
Comrcl	-	Commercial
smlr	-	similar
Btnhl	-	Buttonhole
incl	-	including
dbl	-	double
chnstch	-	chainstitch

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
1.	<u>Cutting.</u>				
	a. Cut the coat in strict accordance with patterns, which show size, shape, 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.				
	b. All component basic material parts shall be cut from one piece of material except the lower pocket facings and underply of flaps, which may be cut from ends and when so cut shall approximately match the main assembly.				
	c. All component lining parts shall be cut from one piece of material except sleeve linings, which may be cut from ends and when so cut shall approximately match the main assembly. Sleeve linings cut from ends shall be shade marked and match each other.				
	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.				
2.	<u>Replacement of defective components.</u>				
	Care shall be exercised during the spreading, cutting, and manufacturing operations to assure that material defects and damages, as specified in section 4, are excluded and replaced with non-defective and properly matched material.				
3.	<u>Shade marking.</u>				
	a. All component parts of the basic material and linings, including sleeve linings, whether cut from ends or in the main lay, shall be marked or ticketed to assure a uniform shade throughout the coat.				
	b. Identify test swatches (basic material and fusible interlining) that represent the every 1000 coat units of production (see 4.4.3.1).				

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD		
					NDL	BOB/ LPR	
4.	<u>Fusing.</u>						
	a. Fuse top sleeve hem interlining and undersleeve interlining piece to top sleeve and undersleeve with notches matching and centered.						
	b. Fuse top collar interlining to top collar. Position top collar interlining centered on the top collar with the interlining center top edge positioned 1/8 inch from the top collar edge.						
	c. Fuse undercollar to undercollar interlining, positioned 1/8 inch from edge.						
	NOTE: Do not fuse top collar or undercollar when flannel undercollar and separate interlining are used.						
	d. Fuse lapel facing interlining to the front facings with the top of the fusible interlining even with the top of the shell. Fuse front interlining to front with the front edges even.						
	e. Fuse small parts and fronts fusible test swatches.						
	NOTE: Fused lots and test swatches shall be allowed to cool to the touch prior to bundle tying or testing.						
5.	<u>Make floating chest piece.</u>						
	a. Spread shoulder dart on chest piece and stitch wedge with edges overlapped. Notches on wedge piece pattern part show spread of dart.	304		4-8		Comrc1	
	b. Overlap 1/4 inch and stitch the edges of the armhole dart on the chest piece.	304		4-8		Comrc1	

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
	c. Position shoulder piece under chest piece 1/2 inch below top edge and 1/2 inch back from front edge. Position felt chest piece under shoulder piece with top even with chest piece and front corner 1/4 inch back from front edge of chest piece. The back edge of felt shall extend 1/8 inch beyond edge of armhole and side seam. Starting at front edge, quilt the assembly together with rows of stitching 3/8 inch apart and parallel to front of padding. The shoulder portion shall be left open to accomodate the shoulder pad.	304		4-8	Comrc1
6.	<u>Make collar.</u>				
	a. Wool flannel undercollar construction.				
	1. The undercollar shall consist of a wool flannel undercollar and a cotton buckram interlining.				
	2. If the undercollar is two pieces, seam together, face to face, along center back 1/4 inch from edge.	301 or 401	SSa-1	10-14	50 50 50 70
	3. Press seam open and flat.				
	4. If interlining is cut as two pieces, overlap edge at center back approximately 3/8 inch.	301 or 401	LSa-1	10-14	50 50 50 70
	5. Pad interlining to wool flannel undercollar with seven to eight rows of blindstitching.	103 or 306	SSm-7 or 8	4-8	70
	6. Press undercollar flat.				
	7. Mark and shape undercollar to conform to undercollar shaper. Trim interlining 1/8 to 3/16 inch from neck edge of undercollar.				
	NOTE: Marking and shaping of undercollar may be performed with a clicker machine using dies conforming to undercollar template.				

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD		
					NDL	BOB/ LPR	
	8. Mark the breakline of the finished undercollar in accordance with the undercollar stand marker.						
	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 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.						
	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)		
	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 creaseline short. Center area of creaseline shall be straight for a distance of 3 to 4 inches.						

OR

b. Composite undercollar construction.

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD		
					NDL	BOB/ LPR	
	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. Marking and shaping of undercollar may be performed with a clicker machine using dies conforming to undercollar shaper.						
	3. Baste top edge of finished undercollar 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 6b6).						
	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
	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 6-10	C (silk) 0 0 (silk)		
	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.						

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
7.	<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	50	50
	b. Press forearm seam open and flat holding seam short.					
	c. Press turnup of sleeve as indicated by notches in pattern.					
	d. Join backarm seam of sleeve, face to face, 3/8 inch from edge.	301	SSa-1	10-14	50	50
	e. Press backarm seam open and flat.					
	f. Blindstitch top edge of sleeve turnup to interlining.	103 or 306 or Hand	EFc-1(b)	4-8 4-8	50 50 50	50
	g. 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
	h. Join the backarm seam of sleeve linings, face to face, 3/8 inch from edge.	301	SSa-1	10-14	50	50
8.	<u>Attach sleeve lining to sleeve.</u>					
	a. The sleeve lining shall extend not less than 3/4 inch or 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 machine or Hand		4-8 1/2 to 1-1/2 inches in length	50 or Comcrl or 0/3 or Comcrl	50
	c. Pull sleeve through lining and baste turnup of sleeve lining. Sleeve lining shall have not less than 1-1/4 inches turnup.	Hand or Machine			Comcrl	

NOTE: The bottom of the sleeve lining may be felled without basting.

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR	
	d. Fell bottom of sleeve lining to sleeve turnup.	Hand or Machine		6-8	A or C (silk)	
	e. Turn sleeves to finished position and assemble in pairs.			6-10	0 0 (silk)	
9.	<u>Make 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	SSa-1	10-14	50	50
	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>Make four pocket flaps.</u>					
	a. The pocket flaps shall be made of and self lined with the basic material.					
	b. Stitch lining to flaps, around side and bottom edges, face to face, 3/16 to 1/4 inch from raw edge. Trim corners, turn to finished position, work out points.	301	SSa-1	10-14	50	50
	c. Baste pocket flaps around side and bottom edges 1/8 inch from edges.	Hand or Machine			Comcr1	
	d. Press pocket flaps smooth and flat.					
	e. Make a vertical square bar, cut-first type buttonhole or cut-after cross bar buttonhole in each flap with the exception that only the eyelet portion of the buttonhole will be cut open to allow insertion of the bodkin type toggle and the use of gimp is not necessary. The buttonhole shall be centered between the side edges, with the inside edge of the eyelet 1/2 to 5/8 inch from the point of flap. The length of the partially cut finished buttonhole after tacking shall measure 5/8 to 3/4 inch.	Button- Size: hole		Stchs	C	B
		5/8 inch		Per	(silk)	
		3/4 inch		Size:		
				42-48		
				50-56		
				not in- cluding bartacks		

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	f. Tack the end of each buttonhole by hand or machine with a 1/8 to 3/16 inch bartack.	Hand or Machine		10-12 per tack 21 per bar- tack	B (silk) B (silk)	B
	g. Overedge stitch together the top raw edges of each flap with a 1/8 to 3/16 inch bight.	502 or 503 or 504	SSa-1	6-8	50	50
	NOTE: Care shall be exercised so that the basic material does not stretch when being overedged. Overedge stitching has a tendency to stretch the raw edges to a point where the ends may protrude beyond the sides of the flap when stitched to the coat.					
11.	<u>Make two breast patch pockets.</u>					
	a. Place breast pocket hem interlining, matching notches, to wrong side of pocket hem even with the folding notches. Stay stitch 1/4 inch from fold.	301	SSa-1	10-14	50	50
	b. Place breast pocket interlining face to face with breast pocket, matching the notches and stitch 1/4 inch from straight edge.	301	SSa-1	10-14	50	50
	c. Fold pocket to finished position and fuse. Fusing shall not extend past shell fabric.					
12.	<u>Prepare front linings.</u>					
	a. Seam underarm darts.	301	SSa-1	10-14	50	50
	b. Stitch forepart of front linings to facings 3/8 inch from raw edge.	301	SSa-1	10-14	50	50
13.	<u>Make inside breast pockets and attach labels.</u>					
	a. There shall be two inside double welt pockets, one on the right and one on the left breasts of the coat as indicated by marks on pattern.					

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL BOB/ LPR	
	b. Center each inside breast pocket welt and facing on inside of breast pocket and turn under both edges 1/4 to 3/8 inch and stitch. Selvage edges need not be turned under.	301	LSd-1	10-14	50	50
	c. The top edge of the identification and size label shall be centered, inserted, and caught under the edge of facing of right inside breast pocket; 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	LSbj-1	10-14	50	50
	OR					
	d. As an alternate, stitch the four sides of the identification and size label to the right front pocket piece with the top edge of label overlapping facing.	301	LSbj-1	10-14	50	50
	e. Position fold line of pocket assembly to front facing/lining assembly according to marks on pattern. Stitch two rows of stitching 1/4 to 3/8 inch gauge, centered over fold line.	301	Smlr to LSbt-2(a)	10-14	50	50
	f. 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
	g. Cut opening of pocket through each pocket facing/lining assembly and stay piece midway between the row of stitching; tongue notch the ends of opening and turn pocket piece through opening.					
	h. Stitch under layer of pocket piece to each facing/lining assembly and pocket stay through all plies.	301	LSbj-1	10-14	50	50
	i. Topstitch each 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

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAI NDL BC LF	
	j. Stitch sides and bottom of each pocket, securely tacking corners of pocket opening thru tongue notch. The back part of each pocket shall be held taut to prevent gapping of pocket opening.	301	SSa-1	10-14	50	50
	k. Notch top of each pocket at front edge for the full width of seam allowance and blindstitch inner ply of pocket to facing.	103 or 306	SSm-1	2-4	50	50
	l. The finished inside breast pockets 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 welt pocket machine which stitches, cuts, and turns welt edges in one operation. When this machine is used, the welt piece may be trimmed to permit insertion into the machine. The bottom welt piece shall be raise stitched 1/16 inch through all plies of material. The top welt piece shall be raise stitched through all plies closing top of the pocket opening. 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.					
	m. Position top edge of personal and instruction label on outside of right inside breast pocket, 1/8 to 1/4 inch below joining seam of lower welt 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
14.	<u>Make backs.</u>					
	a. Turn under edges of center back and side seam allowances of back parts 1/4 to 5/16 inch and blindstitch.	103 or 301	EF1-1	6-8	50 50	50
	b. Join 5/8 inch from folded edge the center back seam face to face catching a stay-piece at top of vent. The bottom end of seam shall terminate 3/8 to 1/2 inch below the top end of vent step.	301	SSa-1	10-14	50	50

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL BOB/ LPR	
	c. Slash seam allowance of right back diagonally at top of vent and press back seam open and flat.					
	d. Fold back left vent in line with center seam line and bottom notch.					
	e. Press left vent.					
15.	<u>Make left vent.</u>					
	a. Stitch a 3/16 inch wide woven stay tape along back of fold line of left vent. Tape shall extend from top of vent to bottom turnup.	301	SSaa-1	10-14	50	50
	b. Fold raw edge of left vent under 3/4 to 1 inch and edgestitch 1/16 inch from folded edge.	301	EFa-1	10-14	50	50
	c. The finished left vent shall measure 1-1/8 to 1-5/8 inches wide.					
16.	<u>Make right vent.</u>					
	a. Fold right vent lining in half lengthwise, face to face, and seam top edge 1/16 to 1/8 inch from raw edge. Turn and force out seam.	301	SSa-1	10-14	50	50
	b. Stitch raw edge side of vent lining to raw edge of right vent 1/16 to 1/8 from edge. Vent lining shall extend above the top of vent.	301	SSe-2(a)	10-14	50	50
	c. Double stitch diagonally across top of vent thru all plies, the width of the left seam allowance.	301		10-14	50	50
	d. Turn right vent lining to finished position and edgestitch 1/16 inch from folded edge of vent.	301	SSe-2(b)	10-14	50	50
	e. Hand fell vent lining to basic fabric across top folded edge of lining and down 1 to 1-1/4 inches on raw edge side of lining.	Hand		8-10	A or C (silk)	

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
17.	<u>Make fronts.</u>					
	a. Join front edge of side body pieces to the back edge of left and right fronts, face to face, 3/8 inch from edge (underarm seam) as indicated by notches on pattern.	301	SSa-1	10-14	50	50
	b. Press each underarm joining seam open and flat.					
	c. Mark fronts for position of breast pockets, breast pocket flaps, lower pocket openings, and lower pocket flaps according to template.					
	d. Stitch breast patch pockets on fronts at marks, 1/8 to 3/16 inch from raw edges. The stitching shall be invisible when pockets are finished.	301	LSbj-1	10-14	50	50
	e. Stitch breast pocket flaps on fronts at marks, 1/8 to 3/16 inch from overedged edge.	301	LSbj-1	10-14	50	50
	f. Fold flap down to finished position and stitch a 1/4 to 5/16 inch long vertical tack at the top corners of each flap.	301		4-6 per tack	50	50
	NOTE: The pocket and pocket flaps shall be in accordance with finished pocket flap and pocket templates.					
18.	<u>Make two lower pockets.</u>					
	a. Double piping construction:					
	(1) Position top edge of facing piece on pocketing and turn in the bottom edge of facing piece and seam to pocketing. Selvage edge need not be turned in.	301	LSd-1	10-14	50	50
	(2) Position the piping piece of pocketing with edge even with opposite end of pocketing and single stitch 1/4 to 3/8 inch from edge.	301	SSa-1	10-14	50	50
	(3) Position piping piece on outside of coat fronts at mark and seam with two rows of stitching through coat and pocketing stay piece on the underside of coat. The narrow piping piece shall be used to form the upper piping.					

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR	
	(4) Cut opening through coat and pocketing stay piece on underside of coat and tongue notch the ends of the pocket opening. Turn pocket through opening.					
	(5) Open seam and fold each piping piece to form a firm 1/8 to 1/4 inch piping and seam between the folds through seam. The stitching shall be imbedded in the seam.	301	SSaf-2(b)	10-14	50	50
	(6) Turn pocketing up and stitch across top of pocket adjacent to top piping piece; stitch, catching facing and pocketing in the stitching, closing top of pocket.	301	SSa-1	10-14	50	50
	(7) Adjust piping, tongues, and pocketing stay piece and tack ends of pocket opening, continue stitching around the pocketing.	301		10-14	50	50
	OR					
	b. As an alternate, the above pocket opening 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 welt piece may be trimmed to permit insertion into the machine. The joining seam of the bottom piping piece shall be raise stitched through front and piping piece and the joining seam of the top piping piece shall be raise stitched through all plies in the closing of the top pocket. Ends of pocket 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 pocketing stay material.	101 and 301		10-14	50 or A/3 50 or A/3	50 or A/3
	c. Stitch lower pocket flaps on fronts at marks, 1/8 to 3/16 inch from overedged edge. Stitching shall be through a pocketing material stay piece on the underside of front.	301	SSa-1	10-14	50	50
	d. Fold flap down to finished position and stitch a 1/4 to 5/16 inch long vertical tack at the top corners of each flap.	301		4-6 per tack	50	50

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD		
					NDL	BOB/ LPR	
	e. Press flaps smooth and flat. The finished flap shall conform to the finished lower pocket flap template.						
	f. The finished lower pocket openings shall measure for sizes 33 through 37, 5-1/2 (+ 1/8) inches; and for sizes 38 through 48, 6 (+ 1/8) inches.						
19.	<u>Attach floating chest piece to front.</u>						
	a. Position floating chest piece assembly on underside of front 1/2 inch back from breakline and baste in position from top of breast pocket flap through patch pocket along front to bottom of chest piece. Baste across shoulder allowing room for setting shoulder pads. Baste around armhole and down back side of chest piece.	301 or Hand		4-6			Cmrc1
	b. Position a 5/8 inch wide bridle stay tape adjacent to and behind breakline at 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 inches 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 or 50 50
	c. Blindstitch bridle stay along both edges.	103 or 306	SSm-2	4-8			70 70 70
	d. The left and right fronts shall be pressed individually on the left and right coat chest machine respectively to conform to the shape of the body.						
20.	<u>Join side bodies and back.</u>						
	a. Join back to side bodies, face to face, 5/8 inch from edge (side seam).	301	SSa-1	10-14	50		50
	b. Press seams open and flat.						

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
21.	<u>Stitch tapes to fronts and backs.</u>					
	a. Stitch a 3/16 inch wide woven tape on neck gorge of front 1/8 inch from edge.	301	SSaa-1	10-14	50	50
	b. Stitch a 1/2 inch wide cross-cut tape on each front along shoulder seam 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 1/2 inch wide cross-cut tape on upper part of front 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 1/2 inch beyond cross-cut tape on front; holding tape taut to draw up material and working in proper fullness.	301	SSaa-1	10-14	50	50
	e. 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	SSaa-1	10-14	50	50
	NOTE: As an alternate, armholes may be taped in one operation.					
	f. Stitch a 1/2 inch wide cross-cut tape to back neckline.	301	SSaa-1	10-14	50	50
22.	<u>Shape lapels and fronts.</u>					
	a. Position lapel shaper on breakline of lapel and mark as indicated by the shaper.					
	b. Position left and right front markers on respective fronts and dress (trim).					
	c. Trim lapels, fronts, and bottom edge of coat front.					
	NOTE: Marking and trimming of lapels, fronts, and bottom may be performed with a clicker machine.					

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL BOB/ LPR	
23.	<u>Match and baste facings.</u> Match, fit, and baste facings to each front putting in proper lapel and breast fullness. The facings shall be held slightly taut at bottom edges of foreparts.					
24.	<u>Tape lapel, front, and bottom edges.</u> a. Stitch a 3/8 inch wide woven tape, 1/8 to 3/16 inch from edge of coat, from lapel notch, across top of lapel, down front and across bottom to a point 2 to 3 inches beyond back edge of facing. Tape on lapel edge shall be sewn natural and smooth without material take-up.	301	SSab-1 and LSbj-1	10-14	50 50	
	b. Blindstitch or fuse back edge of tape to interlining on fronts and lapels.	103 or 306	SSm-1	3-6	50 50 50	
	c. Press edges flat and smooth, pull basting threads and press edge seam open and flat.					
25.	<u>Baste coat edges and join facings to fronts.</u> a. Notch corners of lapels, trim around rounded corners of lapels, bottom corners and front edges. Turn facing to finished position, work out lapels and bottom corner of fronts.					
	b. Turn under complete bottom edge of coat 1/4 (+ 1/16) inch and blindstitch.	103 or 306 or Hand	EF1-1	6-8	0(silk) 0 0 (silk) A(silk)	
	c. Baste edge (first basting) across and down lapel and front, and the bottom width of facing.	Hand or Machine			Comrc1	
	d. Turn up bottom of coat as indicated by patterns matching lengths of vent opening and baste.	Hand or Machine			Comrc1	
	e. Blindstitch complete bottom turn-up of coat.	103 or 306 or Hand	Efl-1	6-8	0(silk) 0 0 (silk) A(silk)	

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
	f. Baste facings along lapel fronts (second basting) approximately 1 inch from edge to a point in line with top edge of breast flaps, holding lower corner of coat rolled in such a manner as to cause lower front edge of forepart to roll inward.	Hand or Machine			Comrc1
	g. 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			Comrc1
	h. Baste along breakline of lapel, allowing fullness in facing, to permit lapel to roll.	Hand or Machine			Comrc1
	i. Baste back edge of facing, putting fullness over chest.	Hand or Machine			Comrc1
NOTE: Whenever possible reduce the basting tensions to reduce the pull on the fabric during basting. The smallest size needles and thread should be used (see 6.7)					
26.	<u>Tack facings to interlining.</u> Tack the back edge of facings 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 openings. 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 Comrc1 50 50 or Comrc1 50 or Comrc1
27.	<u>Sew shoulder pads.</u> Insert shoulder pads between interlining and padding and tack to shoulder in proper position.	301 or Hand		1-2 1-2	50 50 or Comrc1 50 or Comrc1
28.	<u>Baste lining.</u> a. 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			Comrc1

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
	b. Turn under the bottom and sides of lining and baste to body of coat; basting to allow room for felling.	Hand or Machine			Comrc1
	c. Trim gorge and the lining of armholes and shoulders.				
29.	<u>Fell lining.</u> Blindstitch the bottom and sides of front lining to body of coat.	301 or Hand		6-10	0 0 (silk) A or C (silk)
30.	<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	SSa-1	10-14	50 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.				
31.	<u>Baste shoulder.</u> a. Position assembled floating chest piece 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, continuing basting across neck at back.	Hand or Machine			Comrc1
	OR				
	b. In lieu of basting the lining at the shoulder as required in operations 31a, 35a, and hand felling as required in operation 36b, the front and yoke lining at shoulder may be trimmed to allow for thickness of the shoulder pad and stitched on the inside.	301	SSa-1	10-14	50 50

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
32.	<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
	b. Tack gorge seam open catching bridle stay in the tacking.	301 or Hand		10-14 2-4	50 or 50	50 Comrcl or Comrcl
	c. Baste undercollar to coat putting in proper fullness over the shoulder.	Hand or Machine				Comrcl
	d. Tack outlet at neck to undercollar interlining.	301 or Hand		4-6 2-3	50 or 50	50 Comrcl or Comrcl
	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 loop by folding the lining 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	EFp-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				Comrcl

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
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 Ma- chine (hand type felling) or 306	LSa-1 LSa-1 LSa-1	8-10 8-10 8-10	C(silk) C C (silk) 0 0 (silk)
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 (\pm 1/8) inches wide at center back.				
	- Collar stand section of undercollar (measure from creaseline to bottom edge) 1-1/4 (\pm 1/8) inches wide at center back.				
l.	In lieu of operations 32d, 32h, and 32j, stitch lower edge of topcollar across neck from gorge seam to gorge seam.	301	Smlr to SSbd-1	10-14	50 50
33.	<u>Set in sleeves.</u> Set sleeves, matching top sleeve notch with front armhole notch and backarm seam with back armhole notch, 3/8 inch from raw edge, distributing the fullness.	301	SSa-1	10-14	50 50

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
34.	<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 backarm seam to a point 3 to 4 inches forward of shoulder seam. In pressing armhole seam, care shall be taken not to stretch or distort armhole.				
35.	<u>Baste and tack armholes.</u> a. Baste around outside armholes positioning back yoke 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 lapped over the front lining.	Hand or Machine			Comrc1
	NOTE: In lieu of basting and hand felling operations the shoulder seam may be stitched by machine.	301	SSa-1	10-14	50 50
	b. Tack all around armhole through all plies of material.	Hand or 301		2-4 4-6	50 or Comrc1 50 50 or Comrc1
	NOTE: When armholes are tacked by machine, a loose but properly formed and elastic stitch shall 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.				
	c. Tack across base of armhole from sleeve notch on front to side (underarm) seam.	301	SSa-1	4-6	50 50 or Comrc1
	d. Trim away excess lining, interlining and shoulder pads.				

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	e. 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	50 or Comrcl 50 50 or Comrcl	
36.	<u>Complete felling.</u>					
	a. Fell lining all around armholes. Backstitch pit of armhole from forearm seam of sleeve to side seam areas when armholes are hand felled. The sleeve lining shall be seam on seam with sleeve.	Hand or Machine (hand type)		7 (min)C (silk) 6-8 A (silk)		
	OR					
	The sleeve lining may be stitched to the armhole on the inside from forearm seam of sleeve to the backarm seam across undersleeve.	301	SSa-1	10-14	50 50	
NOTE: When a hand stitch simulating machine is used, the operation shall be performed as a finishing operation versus an internal construction operation.						
	b. Hand fell lining at shoulder.	Hand		8-10	A or C (silk)	
	c. Hand fell side 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)	

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
	g. Front edge of inside pockets may be tacked by hand in lieu of operations 13i and 26. 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)
37.	<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.				
38.	<u>Mark and stitch buttonholes on left front.</u> a. All buttonholes shall be eyelet end, square bar, cut first type reinforced with well worked over gimp with the stitching securely caught in the fabric and the ends of the gimp pulled through the underside. Buttonholes shall be clean, correctly positioned and the purling finishing on the outside. b. The ends of all left front 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 3/16 inch long. c. Stitch four horizontal buttonholes in left front as indicated by marks on pattern. The inside edge of eyelets shall be 5/8 to 3/4 inch from the finished edge of coat. The fully cut finished buttonhole after tacking shall measure not less than 1 inch nor more than 1-1/8 inches. The top buttonhole shall be on a line with the eyelet of buttonhole in breast pocket flaps.	Bartack or Hand		21 per C B bar- (silk) tack 10-12 C per (silk) tack	
		But- ton- hole	Size: 1 inch 1-1/8 inches	53-60 C B 60-70 (silk) (not including tack)	
39.	<u>Cleaning.</u> a. Remove all basting threads. b. All ends of stitching shall be trimmed and loose threads removed from the coat.				

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH	SEAM/	STCH	THREAD
		TYPE	STCH TYPE	IN	NDL BOB/ LPR

c. All spots and stains shall be removed. Shade tickets shall be removed without injury to the material.

NOTE: Care should be taken when trimming to ensure that damage to fabric does not result.

40. Pressing.

a. Press edges of lapels, fronts, collar and bottom of coat on edge pressing machine.

b. Press right and left fronts on right and left breast machine respectively, including pockets and flaps.

c. Sleeves shall be roll pressed.

d. Press balance of fronts, side seams, and back on body machine.

e. Press collar on collar machine stretching outer edge of collar over shoulder area. Collar shall not be short nor too long.

f. Press armholes and shoulders on an armhole machine.

g. Press armhole solid on the inside. Crease the armhole from not less than 1/2 inch above backarm seam to not less than 4 inches of shoulder seam. The armpit and back of the armhole shall be held short and pressed flat.

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.

41. Finish pressing.

a. Press coat lining smooth with a hand iron maintaining creased pleats at front shoulder and center of yoke.

b. Block armholes and shrink top sleeve.

c. Press any wrinkle missed by previous pressing operations.

MIL-C-29632(CG)

TABLE I - CONSTRUCTION OF COAT

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD		
					NDL	BOB/ LPR	
	d. Touch up any areas missed by machine pressing.						
	e. Remove gloss and all pressing impressions.						
	f. Place coat on hanger until thoroughly dried.						
42.	<u>Mark and sew buttons on right front.</u>						
	a. Mark the location of the four right front buttons to correspond with buttonholes on left front. Hand or machine sewn buttons shall have the thread ends securely tacked off with not less than two stitches and thread ends hidden. Buttons shall be sewn vertically aligned and 1-3/4 (+ 1/8) inches from front edge of right front with anchor in the upright position.						
	b. Sew a 35-line hopper back button on each mark thru all plies of material.	Hand		4 per	12		
		or		button or			
		101		double 16			
		or		thread			
				14-16	20		
		301		per			
				button			
				14-16	20	20	
		or		per			
		205		button			
				12	No. 4		
				(min)	nylon		
				per	button		
43.	<u>Attach flap buttons.</u>						
	Insert shank of 22-1/2 line button thru buttonhole eyelet of each flap and secure with bodkin type toggle.						
44.	<u>Attach size ticket.</u>						
	Attach removeable size ticket to outside of lower left sleeve.	Hand or machine		2-4 6-8			

MIL-C-29632(CG)

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

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

- (A) Chest - Twice the measurement taken across front at the base of armholes from folded edge to folded edge.
- (B) Coat length - Measurement taken from the base of undercollar (seam), down center back to bottom of coat.
- (C) Sleeve length - Measurement taken from the base of the armhole, along inseam to bottom of sleeve.

3.9 End item. The end item fusible shall have "no strike through" of the adhesive after fusing. The production end item testing shall be as specified in 4.4.5. Results of the end item drycleaning test shall be recorded on Figure 4. Copies of Figures 3 and 4, shall be attached to and become part of the contractor's end item examination record.

3.10 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 (after pressing but prior to packaging) shall be buttoned on a model form and examined for selected defects. A coat containing a selected defect shall not be included in the end item lot. Selected defects are those defects listed in section 4 and are indicated by an asterisk (*). The occurrence of major and minor defects shall not exceed the applicable acceptable quality levels.

4. QUALITY ASSURANCE PROVISIONS

MIL-C-29632(CG)

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 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 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 acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the government to acceptance of defective material.

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

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

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

4.3 First article inspection. The first article, submitted in accordance with 3.2, shall be inspected as specified in 4.4.4 for compliance with design, construction, workmanship, and dimensional requirements.

4.4 Quality conformance inspection. Sampling for inspection shall be performed in accordance with MIL-STD-105, except where otherwise indicated.

4.4.1 Component and material inspection. In accordance with 4.1 above, components and materials shall be inspected in accordance with all the requirements of referenced documents unless excluded, amended, modified, or qualified shall be performed on components listed in Table III or characteristics noted including small parts and fronts fusibles fused to the outershell fabric as prepared by the contractor during the pre-production testing period. The methods of testing specified in FED-STD-191, wherever applicable, and as listed in Table III shall be followed. In addition a certificate of compliance will be acceptable as evidence that the tape for staying the front edges of the coat shall conform to the cross cut, width, and edge treatment requirements in 3.3.11.2 and the colorfastness requirements of 3.3.8. All requirements are applicable to the sample unit. Unless otherwise specified lot average will apply when more than one determination is made per sample unit. All test reports including Figures 3 and 4 shall contain the individual values used in expressing the final result. The component lot shall be unacceptable if one or more sample units fail to meet any of the test requirements specified.

MIL-C-29632(CG)

The lot size shall be expressed in linear yards and the sample unit shall be 18 linear inches in full width. The sample size shall be in accordance with the following:

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

TABLE III - Component and material tests

<u>Component</u>	<u>Characteristic</u>	<u>Requirement</u>	<u>Test method</u>
Cloth, fusible, all parts	Color	3.3.4.1 thru 3.3.4.2	Visual 1/
	Adhesive type	3.3.4.1 thru 3.3.4.2	1/
	Evenness of adhesive	3.3.4.1 thru 3.3.4.2	1/ 2/
	Colorfastness to drycleaning	3.3.4.4	5621
Haircloth	Material identif.	3.3.9.2	--
	Yarns per inch	3.3.9.2	5050
	Weight	3.3.9.2	5041
	Sizing content	3.3.9.2	2611

1/ A certificate of compliance will be accepted for this requirement.

2/ A 12 inch head end per 100 yards of fusible material shall be viewed under a black light for unevenness of adhesive, missing dot, or extreme heavy coating. Any of these conditions observed shall cause rejection of the 100 yard sample.

4.4.2 Daily preproduction testing. The tests listed in Table IV shall be performed each day prior to the start of production.

TABLE IV - Daily preproduction tests

<u>Characteristic</u>	<u>Requirement</u>	<u>Test procedure</u>
Bonding strength		
Small parts	3.3.4.3	4.4.2.3
Fronts	3.3.4.3	4.4.2.3
Fusing press settings	3.3.4.6	4.4.2.1
Actual fusing temperature	3.3.4.6	4.4.2.2

4.4.2.1 Fusing press settings. Before production begins each day, visually check all fusing machine settings for temperature, pressure and conveyor speed dwell time for conformance with manufacturer's recommendations. Nonconforming settings shall be adjusted accordingly. Actual settings will be recorded in the first column of Figure 3.

MIL-C-29632(CG)

4.4.2.2 Actual fusing temperature. Two swatches of outershell, 12 inches in the warp direction and 11 inches in the filling direction, shall be cut from the outershell material to be used in the first 2 hours of the day's production. At the same time, one swatch each of small parts and fronts fusible material, 12 inches in the warp (machine) direction and 11 inches in the filling (cross-machine) direction, shall be cut from the material to be used in the first 2 hours of the day's production. All test swatches shall be cut into three equal parts of approximately 3.6 inches by 12 inches. The fusible test swatches may be cut slightly smaller in size to avoid conveyor belt contamination. Sandwich a temperature strip face down between one specimen of outershell material placed face down and a specimen of fronts fusible material placed on top with the adhesive side down. The temperature strip shall be placed slightly within the fusible starter strip. All small parts and fronts fusing tests shall have an approximate 1 inch by full width starter strip or non-fused area incorporated into the top portion of any given bond strength samples. This can be accomplished by placing a thin non-adhesive material between the fusible interlining and outershell before fusing, or by folding the fusible to itself. This sample shall be placed in the center of the fusing press conveyor with the outershell material down. Prepare two additional samples as described above using the fronts fusible material and place them on the left and right sides of the conveyor belt with the outershell material face down. Repeat the process for the small parts fusible material but without using the temperature strips. Lanes may be designated on the samples if necessary. After the fusing press is fully warmed up, run all samples through the press. When all the samples are cool to the touch after running through the fusing press, take the temperature strip specimens, determine the average of the three readings, and record the results in column 2 of Figure 3. Retain each individual temperature reading in an organized self-developed worksheet format. If the average falls outside of the fusible manufacturers recommended range, or if there is a variance in excess of 10°F or 6°C between lanes, determine the cause, correct the problem and repeat the testing process. Actual temperature and time shall be recorded in Figure 3. See 6.5 for suggested temperature strip sources.

4.4.2.3 Bonding strength. To determine bonding strength, trim all small parts and fronts fusible swatches from the actual fusing temperature test to 1 inch by 12 inch strips. Pinking shears shall not be used to cut strips. The outershell fabric of each shall be clamped at the top, and the fusible material pulled from the starter strips downwards in a verticle direction in a steady continuous motion. A constant-rate-extension (CRE), or a constant-rate-traverse (CRT), or calibrated spring scale type tester may be used. If a spring scale type tester is used it shall be calibrated once weekly. Any calibration procedure used shall assure an accuracy of 1/4 ounce or better, and the date of calibration shall be entered on Figure 3. Average the three bonding strength readings for each fusible type. Retain each individual bonding strength reading in an organized self-developed worksheet format and record the average on Figure 3. If any individual reading fails to meet minimum bonding strength requirement specified in 3.3.4.3 then the cause must be determined, corrections made and the material retested until the problem is resolved before commencing production. In case of bonding strength dispute see 6.6.

MIL-C-29632(CG)

4.4.3 In-process inspection. Examination shall be made of the following operations to establish conformance to specified requirements. The contractor shall inspect a minimum of 30% of each bundle in the sewing lot. Whenever nonconformance is noted, the contractor shall inspect 100% of those bundles in question, and corrections shall be made to the items affected, the lot in process and to the operation. Parts which can not be corrected shall be removed from production. The contractor shall establish inspection stations for the following defects.

a. Visual and dimensional examination of the working patterns to determine that they conform to the government patterns in all respects.

b. Visual and dimensional examination of the cut parts to determine that they are properly cut with respect to size, material directional requirements (warp and filling); that location marks and notches on the parts are located correctly; and that parts containing material defects and damages have been removed and replaced. (Table I, operation 1 and 2)

c. Visual examination of cut small part operations to insure that they are produced in accordance with specification requirements.

d. Visual examination of the fused cut parts to assure conformance to the specified positioning requirements of operations 4 and 11 in Table I and that there is no bubbling, strike back, or strike through. Additionally, all cut parts shall be examined for any resin transference.

e. Visual examination of pressed fronts to determine that pressing is performed correctly and proper pressing machine is used (Table I, operation 19d).

f. Visual examination of collar gorge seam to determine seam is tacked open and the bridle tape is caught in the tacking. (Table I, operation 32b).

g. Visual examination of sleeves (prior to basting lining to armhole, side seams, and bottom of coat) to determine that sleeves are set uniformly with fullness at armhole distributed without pleats or puckers (Table I, operation 33).

h. Visual examination of taped front and back armholes to determine that armhole tape is stitched correctly without any indication of a stretched back and front armhole (Table I, operation 21d and 21e).

4.4.3.1 In-process fusing press maintenance and representative production testing. In-process tests listed in Table V shall be performed. Actual fusing temperature and bonding strength testing shall be performed after every 2 hours of fusing production time, and prior to re-starting fusing production after any skipping of fusing for 29 minutes or more. Pressure evenness and dwell time maintenance testing shall be performed once weekly. All representative production testing shall be performed on outershell, and both small parts and fronts fusible materials, samples from component lots to be consumed in the next 1000 units of coat production. Sample size, and acceptance/rejection criteria shall be as specified in the applicable test procedure.

MIL-C-29632(CG)

TABLE V - In-process fusing press maintenance and representative production tests

Characteristic	Requirement	Test procedure
Fusing press maintenance:		
Bonding strength		
Small parts	3.3.4.3	4.4.2.3
Fronts	3.3.4.3	4.4.2.3
Actual fusing temperature	3.3.4.6	4.4.2.2
Pressure evenness	3.3.4.6	4.4.3.2
Dwell time	3.3.4.6	4.4.3.2
Representative production:		
Differential shrinkage	3.3.4.5	4.4.3.3
Appearance (before & after drycleaning)	3.3.4.5	4.4.3.4
Drycleaned shrinkage	3.3.4.5	4.4.3.4
Drycleaned bonding strength		
Small parts	3.3.4.3	4.4.3.4
Fronts	3.3.4.3	4.4.3.4

4.4.3.2 Pressure evenness and dwell time. Cut five, 12 inches in the warp direction by 2 inches in the filling, strips of outershell material and slightly smaller sized fronts fusible material. Place each of the fusible strips with the adhesive side down on the top of the outershell material with the face side down and with a fusible starter strip (see 4.4.2.2). Arrange the five specimens on the fusing press conveyor belt alongside each other in five different lanes consisting of extreme left, middle left, center, middle right and extreme right. Lanes may be marked on each strip if necessary. Run the specimens through the fusing press and using a stop watch, wrist watch or any mechanism that assures proper timing, mark the time elapsed between the time the leading edge of one of the specimens comes under pressure contact and the time it is released from the pressure contact. As an alternate procedure, the dwell time test may be conducted with the outershell differential swatch required in 4.4.3.3. Enter the dwell time on Figure 3. Remove the strips from the fusing machine when adequately cooled, cut fused outershell/fusible laminate to 1 inch filling direction, and perform the bonding test in 4.4.2.3 on all five specimens, recording the results for each specimen in Figure 3. The dwell time should be consistent with the machine speed ratings, and the fusible manufacturers recommended range and all five specimens should meet the minimum initial requirement for bond strength specified in 3.3.4.3. Any variations shall be investigated for cause, correction made, and the testing process repeated.

MIL-C-29632(CG)

4.4.3.3 Differential shrinkage. From the outershell material cut three, 12 inches in the warp direction by 11 inches in the filling direction swatches and one each slightly smaller sized (not less than 10.5 inches) swatch from small parts and fronts fusible materials. Mark all swatches with 10 inch square gage marks using drycleaning resistant ink. Run one swatch of the outershell material through the heated fusing press by itself, and record the dimensional change in both directions to the nearest one-half percent. As an alternate, the dwell time test (see 4.4.3.2) may be conducted using this swatch. Prepare the two composite samples with the remaining two outershell swatches placed face down, then place the small parts and fronts fusible material swatches, matching the outershell warp direction, on top with the adhesive side down and with the fusible starter strips (see 4.4.2.2). After running through the fusing press, record the dimensional changes in both directions to the nearest one-half percent. Differential shrinkage shall be calculated as the difference, if any, between the dimensional percent changes in the outershell only material and each of the fusible materials. This information shall be recorded on chart A of Figure 4. If the differential shrinkage exceeds the requirements specified in 3.3.4.5, investigate to determine the cause, correct the problem, and repeat testing.

4.4.3.4 Drycleaning appearance, shrinkage and bonding strength. For all tests use the two small parts and fronts premarked 12 inch by 11 inch fused swatches fabricated in 4.4.3.3. Prior to drycleaning, the two swatches shall be pressed twice each on a top and bottom steam press with closed head for 20 seconds and vacuum for 10 seconds. Both swatches shall be drycleaned three times using a commercial dry cleaning procedure and perchloroethylene solvent. Each swatch shall be steam pressed with 20 second bottom steaming in the non-locked position and vacuum after each of the three drycleanings. After cleaning and pressing, examine the swatches for bubbling, delamination or strike through and record the observations on chart A of Figure 4. Measure the bench marks on the outershell material in both directions for each swatch, determine shrinkage to one-half percent, and record on chart A of Figure 4. Trim each swatch into three 1 inch by 12 inch strips and perform bonding strength tests using the bonding strength procedure in the preproduction testing in 4.4.2.3. Retain each individual bonding strength reading in an organized self-developed worksheet format and record the averages on chart A of Figure 4. Any evidence of bubbling, delamination, or strike through, or either shrinkage or bonding strength not meeting the requirements of 3.3.4.3 shall be investigated for cause, corrections made and retesting performed before continuing production of the 100 coats represented by the sample.

4.4.3.5 In-process examination of coat fronts. The right and left coat fronts after stitching darts, making lower pockets, and attaching breast pockets, pocket flaps, coat front interlinings and bridle tape shall be examined for the defects listed below. The lot shall be all pairs (matched right and left) of coat fronts submitted for inspection at one time. The sample unit shall be one pair of coat fronts (right and left). The inspection level shall be II and acceptable quality level (AQL's), expressed in terms of defects per hundred units, shall be 2.5.

MIL-C-29632(CG)

<u>Examine</u>	<u>Defect</u>
Darts, underarm	<ul style="list-style-type: none"> a. One or more omitted b. One or more not as specified c. One or more not pressed as specified
Front fusible interlining, facing fusible interlining and all other fused component cut parts	<ul style="list-style-type: none"> a. Not attached or positioned as specified b. Not fused c. Omitted d. Any evidence bubbling or delamination of the bond, change of color or strike through
Front floating chest piece	<ul style="list-style-type: none"> a. Not attached or positioned as specified. b. Omitted. c. Not assembled according to specified requirements.
Breast pockets, flaps	<ul style="list-style-type: none"> a. One or more misaligned or not parallel with front edge.
Bridle tape	<ul style="list-style-type: none"> a. Omitted, not held taut causing breakline to be stretched b. Misplaced at gorge: <ul style="list-style-type: none"> - More than 3/8 inch behind lapel breakline - Onto or extending beyond breakline on lapel side. c. Misplaced at bottom lapel breakline: <ul style="list-style-type: none"> - More than 5/8 inch behind breakline. - Onto or extending beyond breakline on lapel side. - Not within 1 to 1-1/2 inches from bottom of lapel. d. Tape and interlining not stamp marked for fullness of bridle.

4.4.3.6 In-process examination of fronts and backs after joining. The fronts and backs after joining shall be examined for the defects listed below. The lot shall be all joining fronts and backs submitted for inspection at one time. The sample unit shall be one joined front and back. The inspection level shall be II and the AQL's expressed in terms of defects per hundred units shall be 1.5.

<u>Examine</u>	<u>Defects</u>
Fronts and lapels	One or more not shaped in accordance with shaper pattern
Left front	Not dressed from bottom notch to base of lapel.

MIL-C-29632(CG)

4.4.4 Examination of the end item. Examination of the end item shall be in accordance with 4.4.4.1 through 4.4.4.3. The applicable acceptable quality levels (AQL's) shall be as indicated in 4.4.4.3. The sample unit shall be one finished coat. The lot size shall be expressed in units of coats. As part of the end item examination, the appropriate number of coats determined from the table below shall be measured for selective dimensions. The purpose of measuring is to determine conformance with the dimensions requirements cited in this specification. The sample will be inspected for all end item characteristics as well as measured for this dimensional inspection. Additional dimensional measurements may be taken at any time in the remainder of the end item examination. The defects scored during this inspection will be included in the defects scored for the entire specified sample size of the end item examination.

The contractor will clearly identify the units subjected to this measurement inspection by stamping the identification/instruction label with a 1/2 inch stamp depicting a -D-, using indelible ink.

Sample size will be determined as indicated below:

<u>Lot Size</u>	<u>Sample Size</u>
Up thru 500	8
501 thru 3200	13
3201 thru 35,000	20

4.4.4.1 Visual examination. The coats shall be examined for defects of shade, design, material, construction and workmanship, and the defects classified in accordance with Table VI. The model forms for examination of defects X through XXIV in Table VI shall be men's forms conforming to measurements specified below. The coat sizes tested shall be examined on the appropriate model form size as specified below.

Model Form Measurements for Coast Guard Coats

		Model form measurements (+ 1/2 inch)		
Coat size	Model form size	Chest	Waist	Seat-Hip
33	32	34	28	34
34-35	34	36	30	36
36-37	36	38	32	38
38-39	38	40	34	40
40-41	40	42	36	42
42-43	42	44	38	44
44-45	44	46	40	46
46-47	46	48	42	48
48	48	50	44	50

MIL-C-29632(CG)

Table VI - Classification of defects 1/

Defect	Major	Minor A	Minor B
I. MATERIAL DEFECTS AND WORKMANSHIP DAMAGE			
a. Any hole, cut, tear, smash, mend, burn, scored area, or open place:			
1. On outside	X		
2. On inside (longest dimension in any direction):			
(a) - up to 1/4 inch, inclusive			X
(b) - more than 1/4 inch		X	
b. Loose yarn, misweave, area of no dye penetration, dye streak, missing yarn, broken yarn, thin place, shade bar, or woven in waste; more than 1/4 inch (largest dimension in any direction) on outside.		X	
c. Permanent fold, pleat, or crease in cloth (when caught in seaming or stitching) on outside	X		
d. Needle chew:			
1. On outside:			
(a) - up to 1/4 inch inclusive		X	
(b) - more than 1/4 inch	X		
2. On inside:			
(a) - up to 1/2 inch inclusive			X
(b) - more than 1/2 inch		X	
e. Knot or slub on outside (exceeding the limits specified in the basic cloth specification)		X	
f. Delamination			
1. Partial or complete delamination on any fused component	X		
2. Bubbling on any fused component	X		
g. Any strike through or bleed through	X		
1. Any resin transfer to coat			
1. On any fused component	X		
2. On any non-fused component			X

1/ Defects I through X are general defects.

MIL-C-29632(CG)

Defect	Major	Minor	
		A	B
II. SHADED PART			
a. On outside:			
1. Variation in shade within a part or between parts (except parts which may be cut from ends).	X		
2. Part cut from ends badly shaded			X
b. On inside:			
1. Any lining part badly shaded (except sleeve linings)			X
2. Sleeve lining part badly shaded, pairs not matching each other			X
III. PRESSING			
a. Pressing omitted (any specified operation)	X		
b. Excess gloss or poorly pressed		X	
c. Edge bulky, i.e., not pressed solid			X
d. Lapel not roll pressed as specified			X
e. Sleeve not pressed as required		X	
f. Armhole stretched		X	
g. Armhole not blocked		X	
h. Inside of armhole not creased as required		X	
i. Lining (except sleeve linings) not finish pressed		X	
j. Any required seam not pressed open or not pressed smooth and flat for more than 1/2 inch			X
k. Finished pressed width of lapel not uniform (i.e., one side finishing 1/4 inch or more than other when measured across upper portion of horizontal from forced out edge to lapel crease line)		X	
l. Improper pressing, i.e., pleat, pressed fold or crease (on outside)		X	

MIL-C-29632(CG)

Defect	Major	Minor	
		A	B
IV. CLEANNESS			
a. Spot or stain on outside:			
1. Up to 1/4 inch inclusive in longest direction			X
2. More than 1/4 inch in longest direction	X		
b. Any marking exposed or visible on outside	X		
c. Five or more thread ends on inside not trimmed to 1/2 inch or less or three or more threads on outside not trimmed to 1/4 inch or less			X
d. Two or more shade or size tickets on coat not removed			X
e. Basting thread (including monofilament thread or fragments of monofilament thread) not completely removed from outside			X
f. Fusible fibers pulled through basting stitches causing a quilling effect	X		
V. COMPONENT AND ASSEMBLY			
a. Any component part or operation omitted (unless otherwise classified herein)	X		
b. Any component not as specified (type, size, color, etc)	X		
c. Any component part tight, twisted, distorted, pleated, or full (unless otherwise classified herein)			X
d. Any operation not performed as specified (unless otherwise classified herein)			X
e. The edge of any component part required to be forced out having folds of more than 1/8 inch (unless otherwise classified herein)			X
VI. CUTTING			
a. Any component part not cut in accordance with specified pattern, directional lines on patterns or in accordance with specification requirements	X		
b. Twillline of any outside part not running in specified direction	X		

MIL-C-29632(CG)

Defect	Major	Minor	
		A	B

VII. SEAMS AND STITCHING

a. Accuracy of seaming:

1. Seam puckered (on outside) (When examined at a distance of 3 feet and compared with the AATCC photographic comparative rating Method 88B for seams, puckering is equal to or worse than a rating of 3)
 - (a) - From 1/4 to 1/2 the length of seam X
 - (b) - More than 1/2 the length of seam X
2. Seam irregular, pleated, or wavy (unless otherwise classified herein) X
3. Any part of coat caught in an unrelated operation or stitching X
4. Blindstitching, tacking, or hand felling of armhole exposed on outside X
5. Machine felling or hand felling (other than around armhole) exposed for a distance of 3/8 inch or more X
6. End of stitching when not caught in another seam or stitching not finished as specified. X
7. Stitching overlapping end of thread break less than 1/2 inch X
8. End of a continuous line of stitching overlapped less than 1/2 inch X
9. Not specified color thread used on outside X
10. Needle perforation visible on outside of coat X

b. Gage of stitching and seam allowance:

1. Edge, top, or raised stitching sewn too close to edge resulting in damage to cloth X
2. Seam allowance not as specified by 1/16 inch or more (score only when condition exists on more than half the length of the seam). X
3. Irregular or not within range specified or varies more than 1/16 inch when no range or tolerance is specified (score only when condition exists on more than half the length of the seam). X

MIL-C-29632(CG)

Defect	Major	Minor	
		A	B
c. Open seam: <u>2/</u>			
1. On outside (excluding lower edge of undercollar):			
(a) - more than 3/4 inch	X		
(b) - more than 1/2 inch up to 3/4 inch inclusive		X	
(c) - up to 1/2 inch inclusive			X
2. On inside: Machine felling and hand felling (other than hand felling around armhole):			
(a) - more than 3/8 inch up to 2 inches inclusive			X
(b) - more than 2 inches		X	
3. On inside: Stitch type 301 and hand felling around armhole			
(a) - up to 2 inches inclusive			X
(b) - more than 2 inches		X	
d. Raw edge: <u>3/</u>			
1. On outside:			
(a) - up to 1/2 inch inclusive			X
(b) - more than 1/2 inch up to 3/4 inch inclusive		X	
(c) - more than 3/4 inch	X		
2. On inside:			
(a) - 3/8 inch up to 2 inches inclusive			X
(b) - more than 2 inches		X	
e. Seam and stitch type:			
1. Not specified seam or stitch type		X	
2. Any line of stitching omitted or insecure	X		
3. Any line of stitching not beginning or ending where specified (unless otherwise classified herein)			X
4. Looper thread of 401 stitch type on outside	X		

2/ Classify a seam as open when one or more stitches joining a seam are broken or run off, or when two or more continuous skipped stitches occur.

3/ Classify any edge not finished as specified including any protruding edge on the outside of the coat as a raw edge.

MIL-C-29632(CG)

Defect	Major	Minor	
		A	B
f. Stitch tension:			
1. Loose tension resulting in a loose seam:			
(a) - up to 1/2 inch inclusive			X
(b) - more than 1/2 inch up to 3/4 inch inclusive		X	
(c) - more than 3/4 inch	X		
2. Loosely exposed loops of lower or top thread on edge, top, or raised stitching		X	
3. Tight tension (stitches break when strain is applied in the direction of the seam or stitching)	X		
g. Stitches per inch (score only when condition exists on more than half the length of seam):			
1. More than the maximum specified			X
2. Less than the minimum specified			
(a) - by one or two stitches			X
(b) - by three or more stitches		X	
h. Runoff, skipped or broken stitch			
1. Joining seam - use (open seam) classification (see VII.C)			
2. Edge, top, or raised stitching (more than 1/4 inch)			X
i. Bartack, backtack, tack, or tacking (except buttonhole bartack):			
1. Missing, insecure, misplaced, not serving intended purpose, or not specified size or type			X
2. Loose stitch tension			X
VIII. BUTTONHOLE OR EYELET			
a. Omitted, added, not specified type, or not finished as specified	X		
b. Gimp omitted, uncut, finished length or diameter not as specified, or end of gimp not pulled through to underside on square bar type buttonholes (except on flaps)			X

MIL-C-29632(CG)

Defect	Major	Minor	
		A	B
c. Ragged edge, incomplete stitching, stitching not securely caught in fabric, bulky appearance, or stitches not uniform		X	
d. Broken stitch, or two or more skipped stitches		X	
e. Buttonhole stitching extending beyond bartack		X	
f. Bartack missing, loose, or misplaced (not serving intended purpose)		X	
g. Stitches per buttonhole, eyelet, or bartack less than specified by:			
1. One to three stitches			X
2. Four or more stitches		X	
h. Flap buttonholes not specified type or size or cut as specified			X
IX. BUTTON OR TOGGLE			
a. Omitted, broken, or defective		X	
b. Out of horizontal or vertical alignment by:			
1. 3/16 to 3/8 inch			X
2. More than 3/8 inch		X	
c. Misplaced, loose, not attached as specified, or insecurely sewn			X
d. Tacking stitches omitted or insecure (hand sewn)			X
e. Button sewn with anchor and wings of eagle in other than upright position (front and flap buttons)			X
f. Stitching on button not locked at end of cycle (tug at loose end of the thread when accessible to determine whether it will ravel)			X

Note: Coat should be buttoned on model form for defects X through XXIV.

X. ALIGNMENT OF FRONT, BUTTON, OR BUTTONHOLE

- | | |
|---|---|
| a. Top front button or buttonhole out of horizontal alignment with breast pocket flap buttons by: | |
| 1. More than 3/8 inch up to 1/2 inch inclusive | X |
| 2. More than 1/2 inch | * |

MIL-C-29632(CG)

Defect	Major	Minor	
		A	B
b. Lower front button or buttonhole misplaced by more than 3/8 inch from top of pocket	X		
c. Left front rolling outward below bottom front button	*		
d. Button and buttonhole not aligned, causing a bulge or twist on front	X		
e. Front buttonhole position (from inside edge of eyelet):			
1. Less than 5/8 inch but not less than 3/8 inch, or more than 3/4 inch, but not more than 7/8 inch from edge			X
2. Less than 3/8 inch or more than 7/8 inch from edge		X	
3. Unevenly spaced from edge by 1/8 inch or more			X
f. Spacing between front buttonholes varying more than 1/4 inch			X

XI. LENGTH OF BUTTONED FRONT

- a. Left front shorter or longer than right front at bottom by:
1. More than 1/8 inch up to 1/4 inch inclusive X
 2. More than 1/4 inch up to 1/2 inch inclusive X
 3. More than 1/2 inch *

XII. POCKET OR FLAP

- a. Misshapen or distorted - any point varying from finished shaper by:
1. 1/4 inch or more but less than 1/2 inch X
 2. 1/2 inch or more *
- b. Not uniform in size or shape, varying from matching part by:
1. 1/4 inch or more but less than 1/2 inch X
 2. 1/2 inch or more X
- c. Flap (any)
1. Twisted or bulged when tacked and buttoned X
 2. Full X
 3. Bottom corner of flap curled upwards; flap not completely covering pocket opening. X

MIL-C-29632(CG)

Defect	Major	Minor	
		A	B
d. Out of alignment or misplaced by: <u>4</u> /			
1. 1/8 inch to 1/4 inch inclusive			X
2. More than 1/4 inch up to 1/2 inch inclusive	X		
3. More than 1/2 inch	*		
<u>4</u> / Following focal points shall be measured in the examination for this condition:			
1. Flap: Top corner of flap nearest front edge of coat and front edge of flap just before the curved corner.			
2. Patch pocket: Bottom of straight edge nearest front edge of coat.			
3. Welt pocket: Top corner or pocket nearest front edge of coat.			
4. Misplaced, not positioned as specified			X
5. Raw edge beneath top edge of flap; corner of flap; corner of flap not securely backstitched			X
6. Buttonhole out of alignment with point at center of flap by more than 1/8 inch or not positioned as specified			X
7. Overedge stitching omitted			X
e. Breast pocket flap			
1. Point at center of flap from center of pocket pleat:			
(a) - more than 1/8 inch up to 1/4 inch inclusive			X
(b) - more than 1/4 inch		X	
2. Lower side edge of flap not covering side of pocket by:			
(a) - more than 3/16		X	
(b) - 1/8 up to 3/16 inch (inclusive)			X

MIL-C-29632(CG)

Defect	Major	Minor	
		A	B
3. Pocket flaps are tacked at each corner:			
(a) - tacking visible on outside of flap			X
(b) - less than 2 stitches on hand tacking			X
f. Breast pocket:			
1. Side of pocket not parallel with front edge of coat by: <u>5/</u>			
(a) - more than 3/8 inch	X		
(b) - 1/4 inch up to 3/8 inch		X	
2. End of stitching at end of pocket not backtacked as specified			X
g. Lower pocket opening:			
1. Opening gapped by 1/4 inch or more or length of opening not as specified			X
2. Width of corded or piped edge not as specified by more than 1/6 inch			X
3. Front edge of flap not parallel with front edge of coat by more than 1/4 inch when coat is buttoned			X
4. End of facing not caught in twill cloth pocket seaming			X
5. Tacking at ends of pocket opening omitted or insecure			X

5/ Measure from straight front edge of coat to front edge of pocket at top (immediately below flap), and also at bottom of pocket, just before the rounded corner. Any difference between measurements is the amount pocket is not parallel with front edge.

XIII. LAPEL OR COLLAR

- a. Misshapen or distorted - any point varying 1/4 inch or more with corresponding point on finished shaper
 - X
- b. Not uniform insize or shape - any point varying
 - 1. More than 1/4 inch with corresponding point on matching part
 - X

MIL-C-29632(CG)

Defect	Major	Minor	
		A	B
2. More than 1/8 inch but not more than 1/4 inch with corresponding point of matching part		X	
c. Twisted, short, or tight, causing collar or lapel to turn out	*		
d. Collar:			
1. Collar rolling up above collar breakline by more than 1/8 inch	X		
2. Long, i.e., setting away from neck, or lapel rolling higher than 2 inches above top front button or buttonhole	X		
3. Tight at joining to gorge seam or across back, causing fullness or pleats on lapel or across outside back	X		
4. Collar edge:			
(a) - crooked, irregular, or wavy		X	
(b) - undercollar exposed along collar edge for a length of 1/4 inch or more			X
5. Gorge seam not spread open (any portion): not straight; tacking insecure or tacking omitted			X
6. Gorge seam not uniform in length by 1/4 inch or more (measure from collar breakline to end of gorge seam notch)			X
7. Tacking in corner of undercollar to lapel omitted or insecure			X
8. Top collar full, having pucker or folds 1/8 inch or more from edge of undercollar		X	
e. Undercollar:			
1. Interlining pleated, affecting smoothness of top collar		X	
2. Center seam more than 1/4 inch from center back seam; width of undercollar stand at center back seam not as specified			X

MIL-C-29632(CG)

Defect	Major	Minor	
		A	B
3. Interlining or undercollar tight causing pleat or puckers on undercollar of neck of coat			X
4. Lower raw edge of undercollar not enclosed within felling stitches for more than 3/4 inch			X
5. Blind tacking at corner of collar and lapel exposed on outside of coat			X
6. Bottom edge of undercollar exposed beyond collar edge		X	
f. Lapel:			
1. Gap between top edge of lapel and end of collar on one side of coat not uniform with other side of coat by:			
(a) - more than 1/8 inch up to 1/4 inch			X
(b) - 1/4 inch up to 3/8 inch	X		
(c) - 3/8 inch or more	*		
2. Puckers of pleat	X		
3. Lapel edge irregular or wavy			X
4. Lapel edge not fully forced out (i.e., having folds of more than 1/8 inch), or front part exposed on lapel edge			X
5. Bridle tape not held taut causing breakline to finish flat.	X		
6. Fullness (not smooth and flat)			X
7. Bridle tape misplaced:			
(a) At gorge			
(1) - more than 3/8 inch up to 5/8 inch beyond lapel breakline	X		
(2) - more than 5/8 inch	*		
(3) - bridle tape basted onto or extending beyond breakline on lapel side	*		

MIL-C-29632(CG)

Defect	Major	Minor	
		A	B
(b) At 1-1/2 inches from lapel bottom:			
(1) - more than 5/8 inch up to 7/8 inch behind lapel breakline	X		
(2) - more than 7/8 inch	*		
(3) - bridle tape basted onto or extending beyond breakline on lapel side	*		
(c) Bridle tape end not within 1 to 1-1/2 inches from bottom of lapel			X
XIV. SHOULDER CONSTRUCTION			
a. Improperly joined or set, causing shoulder or back to twist	X		
b. Shoulder seam curved towards back from normal position at armhole end by:			
1. More than 3/8 inch		X	
2. 1/4 inch up to 3/8 inch, inclusive			X
XV. SHOULDER PAD			
Not completely caught in armhole tacking; or misplaced, not serving intended purpose, i.e., too far back or too far forward			X
XVI. ARMHOLE OR SHOULDER			
a. Fullness or puckering in any of the following locations:	X		
1. Over shoulder in back area			
2. In collar or shoulder area			
3. Between lapel and sleeve seam			
b. Puckering on front or back of coat around armhole from back seam to forearm seam	X		
c. Stretched affecting appearance	X		
d. Crooked seam; armhole not completely tacked; sleevehead pad not completely tacked; or sleevehead pad misplaced, not serving intended purpose			X

MIL-C-29632(CG)

Defect	Major	Minor	
		A	B
XVII. SLEEVE			
a. Setting and hang:			
1. Break or twist on sleeve, or top sleevehead too short	*		
2. Sleeve fullness misplaced or concentrated in one area	X		
3. Sleeve tight, i.e., front or back part of sleeve not having roll effect at armhole	X		
4. Sleeve too far front or back, i.e., front edge of sleeve away from center of lower flap button or center of pocket:			
(a) - more than 2 inches	X		
(b) - more than 1 inch up to 2 inches,inclusive			X
5. Sleeve lining too long, causing lining to sag below bottom edge of sleeve by more than 1/4 inch			X
b. Construction of sleeve:			
1. Sleeve lining seam out of alignment more than 3/4 inch with sleeve seam at armhole or at bottom of sleeve			X
2. Sleeve bottom edge uneven by more than 1/4 inch			X
3. Tacking on sleeve lining seam to sleeve seam omitted, insecure, or incomplete for a distance of more than 6 inches from top or bottom edges			X
4. Sleeve lining twisted, tight, or short causing fullness or twist on outside of sleeve	X		

MIL-C-29632(CG)

Defect	Major	Minor	
		A	B
XVIII. FITTING			
a. Fitting of body and yoke lining: tight, short, or twisted causing fullness or twist on outside of coat	X		
b. Fitting of front interlining:			
1. Tight or short causing fullness on outside of coat	X		
2. Too full causing coat front to have a wavy appearance or not lie smoothly	X		
XIX. FRONT AND BOTTOM EDGE			
a. Front rolling outward below bottom button	*		
b. Front edge stretched, puckering, or fold more than 1/8 inch on front or bottom edge, front edge irregular, or bottom corner of left front misshapen or distorted		X	
c. Left front below bottom button, swings to right or left of the perpendicular by more than 1/2 inch			X
XX. VENT OPENING			
a. Left vent edge stretched causing vent to spread open	X		
b. Left vent edge crooked or irregular; or right vent lining tight, short, or twisted, causing fullness on outside of right vent.		X	
c. Left vent 1/4 inch or more longer or shorter than right vent, or bottom turnup exposed or visible on left front edge			X
d. Diagonal row of stitching across top of vent opening omitted			X
XXI. SIDE SEAM OR CENTER BACK SEAM			
a. Side seam or center back seam puckered		X	
b. Side seam or center back seam full	X		
c. Side seam or center back seam twisted (i.e., having a diagonal twist on front or back of coat)	X		

MIL-C-29632(CG)

Defect	Major	Minor	
		A	B
XXII. HANGER			
End not secure or length not as specified			X
XXIII. FRONT FACING			
a. Short, tight or twisted, causing fullness or twist on fronts	X		
b. Exposed beyond edge of left front by more than 1/16 inch			X
c. Tacking catching through pocket or forepart			X
d. Tacking of back edge to interlining insecure or incomplete for a distance of more than 2-1/2 inches below shoulder seam, more than 2 inches above bottom of coat; or felling at bottom corner of facings omitted or insecure			X
e. Fullness on facing between button, buttonhole, or between front edge and button or buttonhole			X
NOTE: Coat should be layed out flat and smooth on table for the remainder of the defects listed.			
XXIV. INSIDE POCKET			
a. Opening not extending into facing - 1/4 to 3/4 inch, or extending into armhole			X
b. Pocket opening badly gapped, width of opening or depth of pocket not as specified			X
XXV. LABEL			
a. Missing, incorrect, or illegible			
1. Size label, instruction label or combination label		X	
2. Identification label			X
b. Not attached as specified, misplaced, or stitching through the printing			X

MIL-C-29632(CG)

Defect	Major	Minor	
		A	B
XXVI. SIZE TICKET			
a. Missing, incorrect, or illegible			X
b. Not securely tacked to right front sleeve			X
XXVII. BACK YOKE			
a. Width of center pleat less than specified, center pleat omitted or width of bottom hem not as specified			X
b. Felling at lower edge of yoke lining to side seam outlet omitted or insecurely felled on one or both sides			X
XXVIII. FRONT BODY LINING			
a. Pleat omitted at shoulder, underarm dart omitted		X	
b. Lining exposed below bottom edge of coat		X	
c. Felling on bottom corners of lining and vent omitted or insecure			X
d. Pleat on center back lining omitted		X	
XXIX. RIGHT VENT LINING			
a. Top edge not completely covering edge of center back seam outlet			X
b. Diagonal stitching across top of vent not full width of left back seam allowance			X
XXX. LINING SIDE OF ARMHOLE			
Backstitching at armpit of armhole, from forearm seam of sleeve to side seam omitted (hand type sewing only)			X
XXXI. BOTTON HEM AND TURNUP			
a. Hem and back parts twisted or irregular in width by 1/4 inch or more			X
b. Tacking on turn-up of front to front omitted or insecure			X

MIL-C-29632(CG)

4.4.4.2 Dimensional examination. The coats shall be examined for measurement defects in accordance with Table II. Any measurement deviating from nominal dimensions and tolerances shall be scored as a measurement defect.

4.4.4.3 Inspection levels and acceptable quality levels. The inspection levels and acceptable quality levels (AQL's) expressed in defects per hundred units for visual and dimensional examination shall be as below.

NOTE: Selected defects are unacceptable. Lots containing one or more selected defects will be rejected.

	<u>AQL</u>	<u>Inspection level</u>
For visual examination in 4.4.4.1		
Major	1.0	III
Major, Minor A (combined)	6.5	III
Total (Major, Minor A and B combined)	15.0	III
For dimensional examination in 4.4.4.2		
	4.0	S-3

4.4.5 End item testing. One coat shall be randomly selected for end item testing for each 3000 coats or any portion of 3000 coats in the end item lot. Each coat selected shall be initially examined visually for any defects in the fusible category of Table VI. After initial examination each sample unit shall be drycleaned and pressed three times as described in 4.4.3.4. Each sample coat shall then again be visually examined for fusible defects as listed in Table VI. If any sample coat contains any fusing defects after three drycleanings and pressings, then retesting shall be performed by randomly selecting one coat for each 1000 coats or portion of 1000 coats in the end item lot and repeating the testing procedure. If any sample coat contains any fusing defects after three drycleanings and pressings upon retesting, the end item lot shall be rejected. An end item testing chart shall be maintained in accordance with Figure 4.

4.4.6 Examination of packaging requirements. An examination shall be made to determine that packaging, packing, and marking comply with Section 5 requirements of this specification. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully prepared for delivery. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot size shall be on the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 and the acceptable quality level (AQL) shall be 2.5, expressed in terms of defects per hundred units.

MIL-C-29632(CG)

<u>Examine</u>	<u>Defect</u>
<u>Marking</u> (exterior and interior)	Omitted, incorrect, illegible, of improper size, location, sequence, or method of application.
Materials	Any component missing, damaged, or not as specified.
Workmanship	Inadequate application of components, such as: incomplete closure of container flaps, loose strapping, improper taping, inadequate stapling, bulged or distorted container.
Content	Number of items per shipping container is more or less than required. Size shown on one or more items not as specified on shipping container. <u>1/</u>

1/ For this defect, one item from each shipping container in sample shall be examined.

4.4.7 Packaging inspection. Packaging inspection of hanger packs shall be in accordance with MIL-C-44192. The occurrence of defects shall not exceed the applicable point value or defect limit specified.

4.4.8 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 AQL, expressed in terms of defects per hundred units, shall be 6.5 in accordance with MIL-STD-105.

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

5. PACKAGING

5.1 Preservation. Preservation shall be as specified in 5 1.1 (see 6.2).

MIL-C-29632(CG)

5.1.1 Hanger packs. Coats shall be hung with fronts lapped and unbuttoned on a 17 inch hanger and preserved as specified in the appendix of MIL-C-44192.

5.2 Packing. Packing shall be as specified in 5.2.1 (see 6.2).

5.2.1 Hanger packs. Ten (10) coats of one size and length only, preserved as specified in 5.1.1 shall be packed in a type I container, using either style A or style B hanger bar in accordance with MIL-C-44192. No mixed sizes are permitted within the same container.

5.2.2 Palletization. When specified (see 6.2), coats, packed as specified in 5.2 shall be palletized in accordance with the appendix of MIL-C-44192 using pallet load pattern number 95.

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 marked in accordance with MIL-STD-129. When hanger packs are used, the container shall have marked on each side in bold, clear, red or blue lettering "THIS SIDE UP" with arrows pointing to the top of the container.

5.4 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 item is intended for wear as part of the dress uniform worn by Coast Guard enlisted male personnel.

6.2 Acquisition requirements. Acquisition documents should specify the following:

- a. Title, number, and date of this specification
- b. Sizes and length 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 and 2.2)
- d. When first article sample is required (see 3.2). The item will be tested and should be a first article sample. The contracting officer should include specific instructions in acquisition documents regarding arrangements for examination, quality, testing and approval of the first article.
- e. Levels of preservation and packing required (see 5.1 and 5.2)
- f. When palletization is required (see 5.4)
- g. When all packaging data is to be found in MIL-STD-2073-1 and MIL-STD-2073-2 (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).

MIL-C-29632(CG)

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

6.5 Temperature indicators. Suggested sources for temperature indicators are as follows:

Paper Thermometer Company - (603) 547-2034
MRC Inc., Reatec Division - (215) 687-4300

6.6 Bonding strength dispute procedure. In case of dispute, the average of the first 3 inches of the five highest bonding strength peaks from a chart recording on a CRE Tensile Tester, running at 12 inches per minute shall determine the bonding strength. If splitting is observed, then just the highest peak shall be regarded as the bonding strength.

6.7 Basting recommendations. In order to assure good basting without quilling effect (protrusion of extraneous fibers through basting needle holes) the following practices are recommended:

a. Utilize either 70/2 smooth finish cotton/polyester wrap or size A nylon thread. Avoid using threads with coarse, hairy exterior structure.

b. Utilize finest size sewing needle possible (sizes 12 or 14) with ballpoint. Larger sized needles will provide larger holes and better chance for fibrous material to enter.

c. Increase quality control checks on needle changes during production. Dull or burred needle tips will push fibrous material to outershell exterior.

d. Reduce basting sewing tensions and amount of pull on the material being sewn wherever possible.

6.8 Subject term (key word) listing.

Dress clothing
Fused interlining
Single breasted
Uniform, dress

Custodian:
Navy - NU

Preparing activity:
Navy - NU

Review activities:
Navy - CG
DLA - CT

Project 8405-N126

MIL-C-29632(CG)

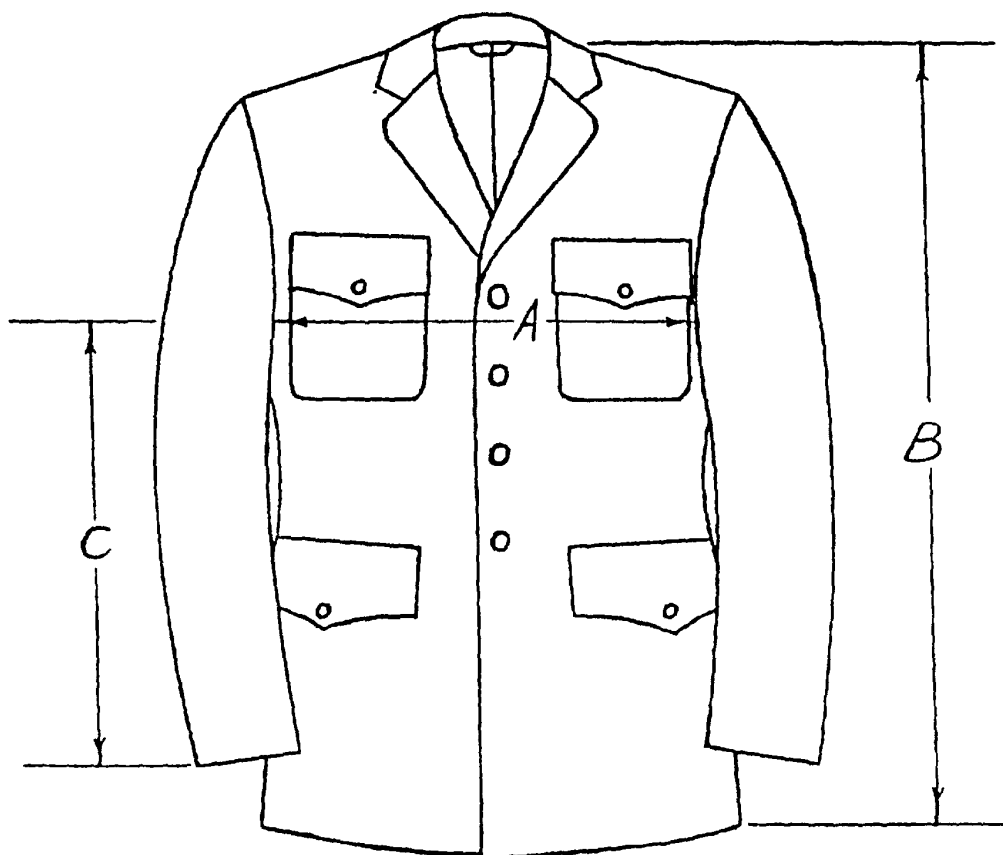


FIGURE 1

COAT, MAN'S, POLYESTER/WOOL, SERGE, FUSIBLE, (COAST GUARD)

MIL-C-29632(CG)

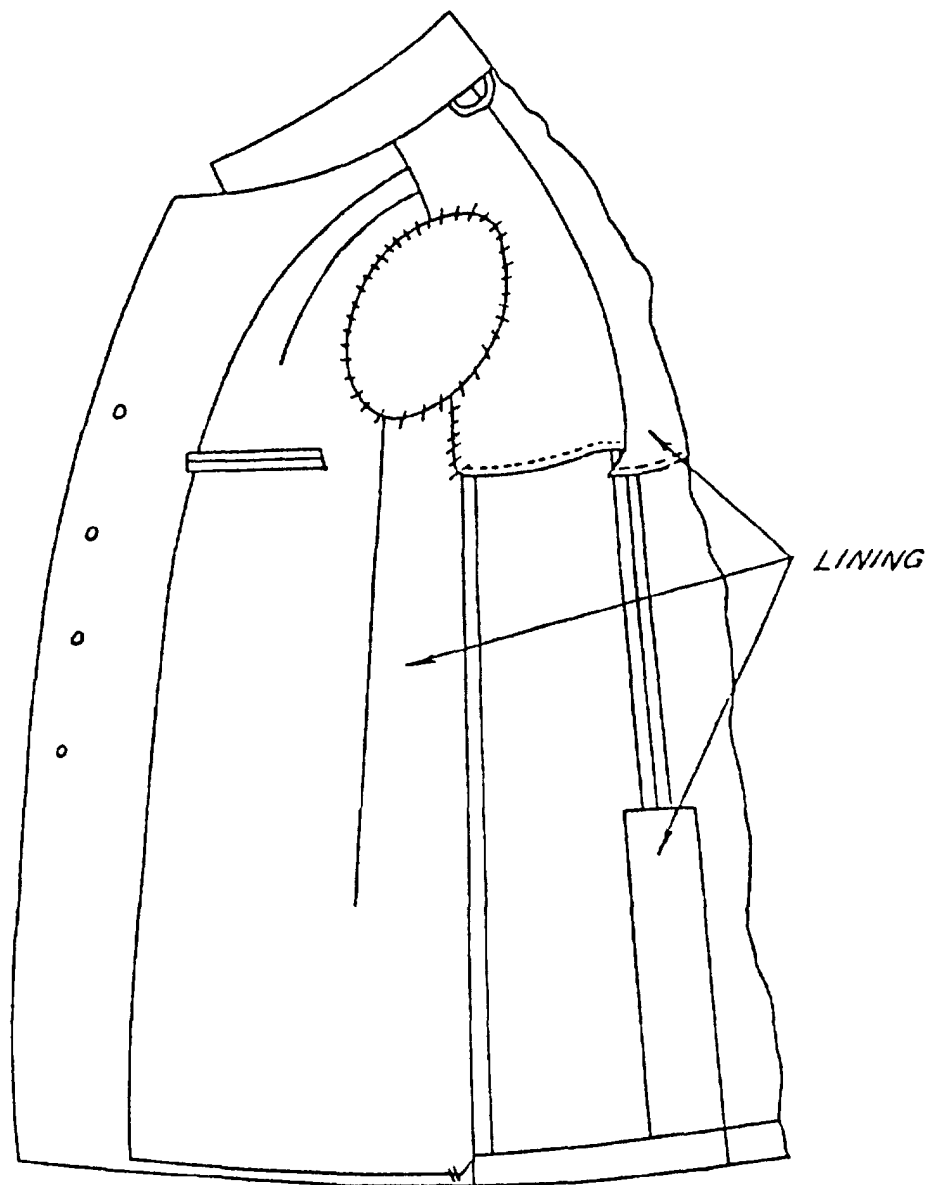


FIGURE 2

COAT, MAN'S, POLYESTER/WOOL, SERGE, FUSIBLE (COAST GUARD)

MIL-C-29632 (C7)

FUSING PRESS MAINTENANCE/BONDING STRENGTH CHECK CHART
ONE WEEK PRE-PRODUCTION & PRODUCTION

		TIME		Fusing Press Settings Recommended by Fusible Mfg.	
Contract # _____	TEMPERATURE	BONDING	Temperature, F(C) _____		
	STRENGTH				
Contractor _____	Record (See: 4.4 2.2 & 4.4.2.3)			Pressure, Bar _____	
QAR Name _____				Dwell Time, Sec. _____	
Initial Daily Test (after machine warm up)			and test every TWO hours after and subsequent to any 29 minute (min) production stoppage.		FUSING PRESS CLEANLINESS once daily (See: 3.3 4 4)
Date DD/MM/YY					

MS	T						
MT - P - DT	TE BS *						AI

/ /							
MS	T						
MT - P - DT	TE BS *						AI

/ /							
MS	T						
MT - P - DT	TE BS *						AI

/ /							
MS	T						
MT - P - DT	TE BS *						AI

/ /							
MS	T						
MT - P - DT	TE BS *						AI

/ /							
MS	T						
MT - P - DT	TE BS *						AI

/ /							

* Min req 2 lbs (32 oz) (907 gms.) / inch or Split for Small Parts

PRESSURE EVENNESS, BONDING STRENGTH (See: 4.4 3.2)

TEST ONCE WEEKLY

Date _____ AI -----

DWELL TIME, SEC. (See: 4 4 3 2)

TEST ONCE WEEKLY

Date.	MACHINE	STOP WATCH	
/ /	SETTING	READING	AI

SPRING SCALE CALIBRATION (See 4.4 2 3)

TEST ONCE WEEKLY

Date _____ AI -----

KEY

AI Authorized initials to verify contractor tests.

BS Bonding Strength / In., Ave

DT Dwell time

MS Machine setting

MT Machine temperature

P Pressure

T Time

TE Temperature strip reading, Ave

I Small Parts, fusible

II Fronts, fusible

Figure 3

COAT, MAN'S, POLYESTER/WOOL, SERGE, FUSIBLE (COAST GUARD)

MIL-C-29632(CG)

Representative Production Bond Strength Check Chart. Chart A (See 4.4.3.4 & 4.4.3.3)

Contract # _____ Small Parts, Fusible * Fronts, Woven Fusible *

Contractor _____ *(All samples shall be pressed twice in accordance
with 4.4.3.4 before being dry cleaned)

QAR Name _____

Representative Production Units / 1,000	Date DD/MM/YY	Prod. Lot #	Shrink,% Diff. DC.	B.S. After 3 DC.	Appear. After 3 DC.	Shrink,% Diff. DC.	B.S. After 3 DC.	Appear. After 3 DC.	AI
1 - 1,000	___/___/___	___	___	___	___	___	___	___	-----
1,001 - 2,000	___/___/___	___	___	___	___	___	___	___	-----
2,001 - 3,000	___/___/___	___	___	___	___	___	___	___	-----
3,001 - 4,000	___/___/___	___	___	___	___	___	___	___	-----
4,001 - 5,000	___/___/___	___	___	___	___	___	___	___	-----
5,001 - 6,000	___/___/___	___	___	___	___	___	___	___	-----
6,001 - 7,000	___/___/___	___	___	___	___	___	___	___	-----
7,001 - 8,000	___/___/___	___	___	___	___	___	___	___	-----
8,001 - 9,000	___/___/___	___	___	___	___	___	___	___	-----
9,001 - 10,000	___/___/___	___	___	___	___	___	___	___	-----
10,001 - 11,000	___/___/___	___	___	___	___	___	___	___	-----
11,001 - 12,000	___/___/___	___	___	___	___	___	___	___	-----
Requirement.			1 5%(max) ----- 2%(max)	** or split	Good	1 5%(max) ----- 2%(max)	**	Good	

End Item Testing Check Chart Chart B (See 4.4.5)

Coats Production Units / 3,000	Date DD/MM/YY	Coat Prod lot #	Appearance				Coat Lot Accept Reject	AI	KEY	
			Initial	After	3 DC. *				Shrink Diff	Shrinkage Differential
1 - 3,000	___/___/___	___	-	-	-	-	___	___		(W x F)
Retest	1000 -	___	-	-	-	-	___	___	DC.	Drycleans
	2000 -	___	-	-	-	-	___	___		(W x F)
	3000 -	___	-	-	-	-	___	___		(W x F) Warp x
3,001 - 6,000	___/___/___	___	-	-	-	-	___	___		Filling
Retest	1000 -	___	-	-	-	-	___	___	Appear	Appearance
	2000 -	___	-	-	-	-	___	___	B.S.	Bonding
	3000 -	___	-	-	-	-	___	___		Strength /In
6,001 - 9,000	___/___/___	___	-	-	-	-	___	___		Ave
Retest	1000 -	___	-	-	-	-	___	___	AI	Authorized
	2000 -	___	-	-	-	-	___	___		Initials
	3000 -	___	-	-	-	-	___	___	**	1 5 lbs
9,001 - 12,000	___/___/___	___	-	-	-	-	___	___		(24 oz.)
Retest	1000 -	___	-	-	-	-	___	___		(680 gms)
	2000 -	___	-	-	-	-	___	___		
	3000 -	___	-	-	-	-	___	___		
Requirement			Good	Good						

Figure 4

COAT, MAN'S, POLYESTER/WOOL, SERGE, FUSIBLE (COAST GUARD)

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.

RECOMMEND A CHANGE		1. DOCUMENT NUMBER	2. DOCUMENT DATE (YYMMDD)
3. DOCUMENT TITLE			
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		b. TELEPHONE (Include Area Code)	
		(1) Commercial (2) AUTOVON	
c. ADDRESS (Include Zip Code)		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	