

MIL-C-82156A(MC)
 28 December 1973
SUPERSEDING
 MIL-C-82156(MC)
 1 August 1967

MILITARY SPECIFICATION
 COAT, MAN'S: SCARLET, DRUM
 AND BUGLE CORPS, MUSICIANS

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

1. SCOPE.

*1.1. Scope. This specification covers requirements for musician's scarlet wool drum and bugle corps coats.

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

Schedule of sizes
(Short, Regular, Long, Extra Long)

34
 35
 36
 37
 38
 39
 40
 41
 42
 44
 46

*1.3 Individual orders. When the coat is custom tailored to an individual order, this specification shall govern except that the detail requirements of Section 3, Table I, may be modified to the extent necessary for good custom tailoring practices.

2. APPLICABLE DOCUMENTS

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

SPECIFICATIONS

FEDERAL

R-N-91	- Napthalene, Technical.
V-T-276	- Thread, Cotton
V-T-280	- Thread, Cotton Gimp, Buttonhole.
V-T-301	- Thread, Silk.

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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-326

- Cloth, Silesia, Cotton.

MIL-C-368

- Cloth, Satin, Rayon and Cloth, Twill, Rayon.

MIL-B-3461

- Buttons, Insignia, Metal, Uniform And Cap.

MIL-P-15064

- Pad, Shoulder and Sleeve-Head.

MIL-C-16375

- Cloth, Wigan, Cotton.

MIL-C-21115

- Cloth, Tropical, Wool, Polyester/Wool.

MIL-C-43718

- Cloth, Twill, Polyester And Cotton.

MIL-C-82114

- Coat Front For Coats, Musicians.

STANDARDS

FEDERAL

FED-STD-151

- Metal, Test Methods.

FED-STD-191

- Textile Test Methods.

FED-STD-751

- Stitch, Seam And Stitching.

MILITARY

MIL-STD-105

- Sampling Procedures And Tables For Inspection By Attributes.

MIL-STD-129

- Marking For Shipment And Storage.

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

*2.2 Other publications. The following document forms a part of this specification to the extent specified herein. Unless otherwise indicated, the issue in effect on date of invitation for bids or request for proposal shall apply.

UNIFORM CLASSIFICATION COMMITTEE, AGENT
Uniform Freight Classification Rules

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

3. REQUIREMENTS

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

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*3.2 First article approval. Unless otherwise specified (see 6.2), before production is commenced, a first article consisting of the number of finished coats specified by the procuring activity (see 6.2) shall be submitted or made available to the contracting officer or his authorized representative for approval. The approval of the first article authorizes the commencement of production, but does not relieve the supplier of responsibility for compliance with all provisions of this specification. The first article shall be manufactured by the supplier in the same facilities to be used for the manufacture of the production items.

3.3 Materials.

*3.3.1 Basic material. The basic material shall be cloth, wool, tropical, scarlet shade 2502 (see 6.3), 10.5 ounce conforming to type I, class 1 of MIL-C-21115.

*3.3.2 Lining. The material for lining the coat and collar and for making the underarm shields, collar eyelet covers, coat hanger, straps to secure the lining to the bottom edge of the coat and the front eyelet cover shall be cloth, satin rayon twill, scarlet shade 2506 (see 6.3), conforming to class 1 of MIL-C-368.

*3.3.3 Silesia or polyester and cotton. The stays for armhole and shoulder seams; the reinforcement pieces for the collar eyelets; and the binding for the neck edge of the coat front interlining and the lower edge of the collar interlining shall be cut from cloth, cotton silesia, 4.5-ounce conforming to type I of MIL-C-326 or polyester and cotton conforming to MIL-C-43718 except the requirement for nonfibrous material and seam efficiency shall not apply. The color of the silesia or polyester and cotton shall be khaki shade 3707 for the armhole and shoulder seam stays, the collar eyelet reinforcement pieces, and the binding for the neck edge of the coat front interlining, and black for the binding for the lower edge of the collar interlining.

*3.3.4 Collar interlining. The material for interlining the collar shall be cloth, cotton buckram, double texture, laminated, starch finish, natural color, conforming to the following when tested as specified in Section 4, Table III.

*3.3.4.1 Collar buckram. The buckram shall be made of cotton of suitable staple length and grade to meet the requirements of this specification. The cotton buckram shall be thoroughly cleaned, well carded, drawn and evenly spun.

3.3.4.2 Weave. The weave of the single plies of the cloth shall be four harness, 2 up and 2 down herringbone twill, 20 ends right and 20 ends left.

*3.3.4.3 Yarn count. Each ply of cloth shall have a minimum yarn count per inch of 50 in the warp and 20 in the filling.

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*3.3.4.4 Laminated cloth. The two plies of the cloth shall be thoroughly adhered together with synthetic resin type laminating material which shall not cause any objectionable odor in the finished cloth. The laminated cloth shall show no evidence of delamination after being subjected to wet (dry) cleaning, accelerated aging, and perspiration tests specified in Section 4, Table III.

*3.3.4.4.1 Finish. The cloth shall have a starch finish. The original stiffness of the finished cloth, and the stiffness of the cloth after being subjected to the wet (dry) cleaning, accelerated aging, and perspiration tests shall conform to the following when tested as specified in Section 4, Table III:

<u>Stiffness, inch-pound:</u>	<u>Minimum</u>	<u>Maximum</u>
- original	0.60	0.95
- after accelerated aging	0.70	0.95
- after wet (dry) cleaning	0.50	0.85
- after perspiration	0.50	0.85

*3.3.4.4.2 Weight. The weight of the finished laminated cloth shall be 21 to 23 ounces per square yard when tested as specified in Section 4, Table III.

*3.3.4.4.3 Breaking strength. The breaking strength of the finished laminated cloth shall be 100 pounds minimum in the warp direction and 80 pounds minimum in the filling direction, when tested as specified in Section 4, Table IV. After being subjected to the accelerated aging test, the breaking strength of the cloth shall be not less than the original breaking strength when tested as specified in Section 4, Table III.

3.3.5 Reinforcement discs. The reinforcement discs for buttons secured to the back side seam, with ring toggle, shall be punched from cloth, cotton, buckram specified in 3.3.4.1. The reinforcement discs shall be 7/8 inch in diameter with a 1/8-inch-diameter hole at the center.

*3.3.6 Padding for collar. The material for padding the collar shall be a suitable cotton felt, white, weighing 4.25 to 4.75 ounces per square yard, when tested as specified in Section 4, Table III.

*3.3.7 Coat fronts. The coat fronts shall conform to class 1 of MIL-C-82114.

*3.3.8 Shoulder pads. The shoulder pads shall conform to the requirements of type I, class 2 of MIL-P-15064.

3.3.9 Sleeve head pads. The sleeve head pads shall conform to type IV of MIL-P-15064.

*3.3.10 Stay tape. The stay tape for armholes shall be cotton, unbleached, 1/4 inch wide conforming to type III, class 1 of DDD-T-86, except the requirement for nonfibrous material shall not apply.

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***3.3.11 Piping.** The material for piping shall be cloth, polyester-wool blend, black shade 2607 (see 6.3), conforming to type III of MIL-C-21115, cut 5/8 to 3/4 inch wide for piping the shoulder straps, collar and ornamental sleeve patches and 1 inch wide for piping front and bottom edges of the coat.

***3.3.12 Binding.** The binding for the collar interlining shall be cut 1 inch wide from the following materials:

For upper edge of collar interlining - cloth, polyester wool blend black (see 3.3.11).

For lower edge of collar interlining - cloth, cotton, silesia or polyester and cotton black (see 3.3.3).

3.3.13 Wigan. The material for reinforcing the bottom edge of the sleeves shall be cloth, cotton, wigan, 2.5 ounces conforming to type I of MIL-C-16375.

3.3.14 Thread.

***3.3.14.1 Silk thread.** The silk thread shall conform to V-T-301 as follows, except the requirements for extractable matter shall not apply:

Use	Type	Class	Ticket No.	Ply
Bartacks and all outside seaming and stitching.	I		A	
Machine felling.			O	
Making buttonholes in coat.	I		B and F	3
Hand felling; and hand sewing.	III,	3	C	2

***3.3.14.2 Cotton, thread.** The cotton thread shall conform to V-T-276 as follows:

Use	Type	Ticket No.	Ply
All inside seaming and stitching.	1C2	A	3
Serging and overedge stitching.	1A1	70	2
Machine tacking armholes.	1B3	24	4

The thread for basting shall be good commercial grade cotton.

***3.3.14.3 Color and colorfastness.** All thread shall be dyed scarlet shade W, cable No. 66040, except the cotton thread for basting and machine tacking armholes may be white, and the cotton thread for overedge stitching the piping at bottom edge of coats shall be black. The colored threads shall show the following colorfastness when tested as specified in the applicable thread specification:

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<u>Thread</u>	<u>Color</u>	<u>Wet (dry) Cleaning</u>	<u>Light</u>
Cotton	Scarlet	Good	--
Silk	Scarlet	Fair	Fair
Silk	Black	Good	Good

3.3.15 Gimp. The buttonhole gimp shall be cotton, No. 8, soft or glazed finish, conforming to type I or II of V-T-280. The color of the gimp shall be scarlet W, cable No. 66040, and shall show good fastness to wet (dry) cleaning.

***3.3.16 Buttons.**

***3.3.16.1 Insignia buttons.** The insignia buttons shall be metal, gold plated, enlisted design, 27-line for shoulders, belt loops and ornamental sleeve patches and 40-line for fronts, conforming to type I, style 3, class A, subclass 2 of MIL-B-3461.

***3.3.16.2 Ring toggles.** Ring toggles for securing the 27-line insignia buttons to the coat, belt loops and ornamental sleeve patches shall conform to MIL-B-3461.

***3.3.17 Collar closure hooks and eyes.** The hooks and eyes for closing the collar shall be brass, black enameled finish, size No. 16 commercial type. All surfaces and edges of the hooks and eyes shall be clean, smooth, free from burrs, tool marks, sharp edges, and roughness. The hooks and eyes shall be thoroughly and completely lacquered with the best available quality of black japanned lacquer. The dry lacquer film shall be continuous, level, adherent, free from lint, dust or other foreign inclusions that may affect appearance or serviceability, and shall withstand the test for tackiness specified in Section 4, Table III.

***3.3.18 Labels.** Each coat shall have a combination personal-clothing identification label and a size label as follows. The coat is intended to be dry cleaned and the label shall show fastness to dry cleaning.

***3.3.18.1 Combination personal-clothing identification label.** The combination personal-clothing identification label shall conform to type I, classes 1 and 10 (combined) of DDD-L-20 except all printing and the space between lines of printing shall be minimum 10 point (approximately 1/8 inch). The content and format shall be as follows:

NAME _____

SERVICE NO. _____

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COLLAR SIZE _____
 NOMENCLATURE (Item description) _____
 CONTRACT NO. _____ DATE _____
 NAME OF CONTRACTOR _____
 WOOL PRODUCTS ACT INFORMATION _____

***3.3.18.2 Size label.** The size label shall conform to type I, class 2, of DDD-L-20. The label shall consist of the numerical size designation specified in 1.2 followed by the letter S, R, L, or XL for Short, Regular, Long and Extra Long, as shown by the following example:

40R
 Stock number

The stock number may be incorporated in the identification label instead of in the size label.

***3.4 Design.** The coat shall be the U.S. Marine Corps design shown on Figures 1 through 3. The coat shall be seven button, single breasted, form-fitting, fully lined having a one-piece front; waist and chest darts; a four-piece back without a center vent; belt loops to button; ornamented at sleeve ends; shoulder straps to button; and a standup collar with hooks and eyes for front closure and a worked eyelet at each end for removable branch of service insignia. The top and bottom edges of collar, front and bottom edges of coat, the top, bottom and scalloped back edges of ornamental sleeve patches, and the edges of shoulder straps shall be piped with the material specified in 3.3.11.

***3.5 Patterns.** Standard patterns will be furnished to the supplier by the Government. The standard patterns shall not be altered in any way and shall be used only as a guide for cutting the supplier's working patterns. The supplier's working pattern shall be identical to the standard pattern. The standard pattern shall provide 5/8-inch allowance for center back, 3/4-inch allowance for side seams, and 3/8-inch allowance for all other seams except as otherwise specified in Table I. Standard patterns show size and are marked and notched for proper cutting, placement and assembly of component parts.

***3.5.1 List of pattern parts.** Coats shall be cut from the materials specified herein in accordance with the pattern parts indicated below:

<u>Item</u>	<u>Pattern nomenclature</u>	<u>No. of</u>
	<u>Material basic: Cloth, wool, tropical</u>	<u>cut parts</u>
1.	Front	2
2.	Front facing, right	1
3.	Front facing, left	1
4.	Side back	2
5.	Center back	2
6.	Top sleeve	2
7.	Under sleeve	2
8.	Collar, outer ply	2
9.	Shoulder straps, top ply	2
10.	Shoulder straps, under ply	2

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<u>Item</u>	<u>Pattern nomenclature</u>	<u>No. of</u> <u>cut parts</u>
	<u>Material basic: Cloth, wool, tropical</u>	
11.	Ornamental sleeve patch, top ply	2
12.	Ornamental sleeve patch, under ply	2
13.	Belt loops	2
	<u>Material: Cloth, rayon lining</u>	
14.	Front	2
15.	Side back	2
16.	Center back	2
17.	Top sleeve	2
18.	Under sleeve	2
19.	Collar lining	1
20.	Collar eyelet cover	2
21.	Underarm shield	4
22.	Front eyelet cover	1
	<u>Material: Cloth, cotton, buckram</u>	
23.	Collar interlining	1
	<u>Markers</u>	
24.	Sleeve turnup and sleeve ornamentation marker	

3.6 Construction.

3.6.1 Manufacturing requirements. The coat shall be manufactured in accordance with the operations and the stitch, seam, and stitching types specified in Table I.

3.6.1.1 Operations. The supplier is not required to follow the exact sequence of the operations as listed in Table I, but all operations specified shall be used to manufacture the coats.

3.6.1.2 Stitches, seams and stitching. The stitch, seam and stitching types specified in Table I shall conform to FED-STD-751. The number of stitches per inch as specified in Table I indicates the minimum and maximum number permitted. All overedge stitching shall be done on serging machine with a knife attachment properly set to trim the raveled edge without cutting the material.

***3.6.1.2.1 Tacking and backstitching.** End of all seams and stitching (stitch type 301), except ends of a continuous line of stitching, when not caught in other seams or stitchings shall be backtacked not less than 1/4 inch. The ends of a continuous line of stitching shall be overlapped not less than 1/2 inch. Thread breaks shall be secured back of the break not less than 1/2 inch.

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*** 3.6.1.3 Shade marking.** The component parts of the coat cut from one piece of wool and lining materials, including pairs of sleeve linings and underarm shields when cut from ends, shall be shade marked to insure a uniform shade and size throughout the garment. Any method of shade marking may be used except:

- (a) Corrosive metal fastening devices.
- (b) Sew-on shade tickets.
- (c) Adhesive type tickets which show discoloration and the adhesive mass which adheres to the material upon removal of the tickets.

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
1.	<p><u>Cutting.</u></p> <p>a. Cut coats in strict accordance with patterns furnished by the Government.</p> <p>b. Cut all materials in the direction of the warp as indicated by directional lines on the patterns.</p> <p>c. Cut all scarlet wool parts of the coat from one piece of basic material, except the following parts may be cut from ends: underply of shoulder straps and underply of ornamental sleeve patch. Parts cut from ends shall harmonize with the shade of the coat.</p> <p>d. Cut the body and collar linings, the front eyelet covers and the top ply of the underarm shields, from one piece of rayon lining material. All other rayon lining parts may be cut from ends. When pairs of sleeve linings are cut from ends, the shade of the sleeve linings shall match. Cut the strips for coat hanger and lining securing straps 1-1/8 inches wide.</p> <p>e. Cut silesia or polyester and cotton stays for armhole and shoulder seams on the bias 3/4 inch wide and 4 +1/4 inches long. Cut silesia or polyester and cotton for binding the neck edge of the coat front interlining on the bias, 3/4 inch wide and approximately 5 inches long. Cut the silesia or polyester and cotton reinforcement pieces for collar eyelets not less than 2 inches long by 1-3/4 inches wide.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
	<p>f. Cut the cotton buckram, for interlining the collar on the straight in accordance with the pattern furnished.</p> <p>g. Cut the cotton felt, for padding the collar, 1-1/4 inches wide and of sufficient length to fold over the ends of the interlining for each size collar.</p> <p>h. Cut the piping material (see 3.3.11) for piping the front and bottom edges of coats, edges of shoulder straps, collar, and ornamental sleeve patch, on the straight. The piping shall be cut 5/8 to 3/4 inch wide for shoulder straps, collar, and ornamental sleeve patches, and 1 inch wide for front and bottom edges of coat. Cut the binding material specified in 3.3.12 for the top and bottom edges of the collar interlining 1-1/8 inches wide on the straight.</p> <p>i. Cut the wigan for reinforcing the bottom of sleeves on the bias in accordance with the pattern.</p> <p>j. Punch the reinforcement discs for buttons secured to the side seam from cloth, cotton, buckram. The reinforcement discs shall be 7/8 inch diameter with a 1/8-inch diameter hole at the center.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
2.	<p><u>Replacement of damaged parts.</u></p> <p>a. At time of cutting replace any part of coat containing holes, seriously weakening defects, such as smashes, multiple floats, loose or weakening slubs, etc. expected to develop into holes, shade bars and dye streaks or unsightly slubs etc. affecting appearance.</p> <p>b. Replace any part damaged during the manufacturing process by needle chews which may be expected to develop into holes, scissor or knife cuts, tears, holes, mends or burns, in the material, affecting appearance.</p>					
3.	<p><u>Shade marking.</u></p> <p>a. Mark or ticket (see 3.6.1. 3) all component parts cut from one piece of basic and lining materials, and pairs of sleeve linings when cut from ends, to insure uniform shade and size throughout the coat.</p> <p>b. The use of tickets with any metal fastening devices is prohibited on the rayon lining.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
4.	<u>Make coat hanger and lining securing straps.</u> Finished appearance. The coat hanger and lining securing straps shall finish 1/4 to 3/8 inch wide. a. Fold the 1-1/8-inch-wide strip of lining material in half lengthwise, turn the edges to the inside and seam 1/16 inch from the turned edges. b. Cut the coat hanger 3-3/4 ±1/4 inches long. c. Cut the lining securing straps 4-1/2 ±1/4 inches long.	301	EFp-1	12-16	A	A
5.	<u>Make collar eyelet covers.</u> Finished appearance. The collar eyelet covers shall finish 1-3/4 ±1/8 inches wide. a. Turn under the side edges of the collar eyelet cover and stitch 1/16 to 1/8 inch from folded edges, catching the turned under portions in the stitching. b. Fold each cover in half across the width and seam 1/16 to 1/8 inch from the folded side edges.	301	EFa-1 (each side edge)	12-16	A	A
6.	<u>Make underarm shields.</u> Finished appearance. The shields shall finish smooth and flat without puckers, pleats, gathers or other distortions.	301		12-16	A	A

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
6.	<p><u>Make underarm shields.</u> (cont'd)</p> <p>a. Position the two plies of material for the underarm shields with edges even. Seam the two plies together along the curved side and bottom edges 3/8 inch from the edges.</p> <p>b. Turn the shield right side out working out completely the seamed edges.</p> <p>c. Press the shields smooth and flat with a heated pressing iron or pressing machine.</p>	301	SSa-1	12-16	A	A
7.	<p><u>Make front eyelet cover.</u></p> <p>a. Fold front eyelet cover in half lengthwise, turn in the raw top and bottom edges and seam 1/16 to 1/8 inch from the raw edge and folded top and bottom edges.</p>	301	SSa-1 (raw edge) SSc-1 (top and bottom edges)	12-16	A	A
8.	<p><u>Make belt loops.</u></p> <p>Finished appearance. The belt loops shall be uniform in appearance and shall finish smooth and flat without puckers, pleats, gathers or other distortions. The buttonholes shall be clean cut, well made and well worked over gimp to fit a 27-line insignia button. The gimp and thread shall be pulled through to the underside of the loops. The purling of the buttonholes shall be on the outside.</p> <p>a. Fold the belt loops in half lengthwise face to face forming two plies.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
8.	<u>Make belt loops.</u> (cont'd)					
	b. Seam the two plies together along the side and pointed edges 3/16 inch from the raw edges.	301	SSe-2 (a)	12-16	A (silk)	A
	c. Trim corners and point, for proper turning. Turn loops, working out completely the point and seamed edges.					
	d. Edge stitch the loops uniformly 1/16 to 1/8 inch from folded and seamed edges.	301	SSe-2 (b) seamed edges OSf-1 (folded edges)	12-16	A (silk)	A
	e. Make a horizontal eyelet end, square-bar type buttonhole, cut 3/4 inch long, in each loop midway between the back and front edges with the inside edge of the eyelet end of buttonhole finishing 5/8 inch from pointed end of loop.	Button-hole		60 per buttonhole (not including bartack)	B (silk)	F
	f. Securely bartack the end of the buttonholes, catching the ends of the gimp and thread in the bartack. Trim the ends of the gimp and thread.	Bartack		21 per bartack	A (silk)	A
9.	<u>Make shoulder straps.</u> Finished appearance. The shoulder straps shall be uniform in appearance and shall finish smooth and flat, without twists, gathers, puckers, pleats, or other distortions. The piping shall be evenly worked out and shall extend uniformly 1/8 inch beyond the seamed edges of the shoulder straps. The buttonholes shall					

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
9.	<u>Make shoulder straps.</u> (cont'd)					
	be clean-cut, well made and well worked over gimp to fit a 27-line insignia button. The gimp and thread shall be pulled through to the underside of the straps. The purling of the buttonholes shall be on the outside.					
	a. The shoulder straps shall be made of two plies of basic material, piped with a 5/8- to 3/4 inch-wide strip of piping material specified in 3.3.11.					
	b. Turn under one edge of the piping 5/16 inch and seam the turned under portion to the body of the piping 1/8 inch from the turned raw edge.	301	EFa-1	10-14	A	A
	c. Position the right side of the top ply of the shoulder strap on the hemmed piping with the raw edges of shoulder strap in line with the piping stitching line.					
	d. Join shoulder strap to piping along the back, front and collar end, 1/8 inch from the inner edge of piping.	301		10-14	A (silk)	A
	e. Trim and notch piping in accordance with good manufacturing practices in order to prevent pulling and to eliminate gathers and bulges around the collar end.					
	f. Position the top ply on the underply face to face, with the outer edge of piping and raw edge of the underply even and back notches matching.	301	SSk-1 (a) (without cord)	10-14	A (silk)	A

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
9.	<u>Make shoulder straps. (cont'd)</u>					
	g. Stitch along the back, front, and collar end through all plies 3/16 inch from the inner raw edge of piping. Trim any excess material if necessary.	301	SSk-1 (a) (Without cord)	10-14	A (silk)	A
	h. Turn the straps, completely working out the piped edges.					
	i. Topstitch the straps uniformly 3/16 inch from the folded edge of the piping.	301	SSk-1 (b) (without cord and top stitched)	10-14	A	A
	j. Press the shoulder straps smooth and flat with a heated pressing iron or pressing machine.					
	k. Make a horizontal, eyelet-end, square-bar type buttonhole cut 3/4 inch long, in each strap, midway between the back and front edges and with the inside edge of the eyelet end of the buttonhole finishing 5/8 inch from outer edge of piping at the collar end of strap.	Button-hole		60 per buttonhole	B (silk)	F
	l. Securely bartack the end of the buttonhole, catching the ends of the gimp and thread in the bartack. Trim the ends of the gimp and thread.	Bar-tack		21 per bartack	A (silk)	A
10.	<u>Make ornamental sleeve patches.</u>					
	Finished appearance. The ornamental sleeve patch shall be uniform in appearance and shall finish smooth and flat, without twists, gathers, puckers,					

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
10.	<u>Make ornamental sleeve patches.</u> (cont'd)					
	or other distortions. The piping shall be evenly worked out and shall extend uniformly 1/8 inch beyond the seamed edges of the sleeve patch. The eyelet shall be well worked with the purling on the outside of the sleeve patch and shall finish with a 1/8-to 3/16-inch-diameter opening.					
	a. The ornamental sleeve patch shall be made of two plies of basic material, piped with a 5/8-to 3/4-inch-wide strip of piping material specified in 3.3.11.					
	b. Turn under one edge of the piping 5/16 inch and seam the turned under portion to the body of the piping 1/8 inch from the folded edge.	301	EFa-1	12-16	A	A
	c. Position the right side of the top ply of sleeve patch on the hemmed piping, with the raw edges of the sleeve patch in line with the piping stitching line.					
	d. Join sleeve patch to piping along the top, bottom and scalloped edge 1/8 inch from the inner edge of piping.	301		12-16	A	A (silk)
	e. Trim and notch the outer edge of piping along the scalloped edge in order to prevent pulling and bulges on the edges.					
	f. Position the top ply of sleeve patch on the underply, face to face, with the outer edge of piping and raw edge of the underply even.					

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
10.	<u>Make ornamental sleeve patches.</u> (cont'd)					
	g. Stitch along the top, bottom and scalloped edge through all plies 3/16 inch from the inner raw edge of piping. Trim any excess material if necessary.	301	SSk-1 (a) (without cord)	12-16	A (silk)	A
	h. Turn the sleeve patches, working the piping out completely and forming smooth corners and point at the scalloped side edge.					
	i. Topstitch the sleeve patches uniformly 3/16 inch from the folded edge of the piping.	301	SSk-1 (b) (without cord and top stitched)	12-16	A (silk)	A
	j. Press the sleeve patches smooth and flat with a heated pressing iron or pressing machine.					
11.	k. Mark each sleeve patch as indicated by marks on pattern, for the location of three eyelets.					
	l. Make one eyelet at each mark through all plies of the sleeve patches for attaching insignia button.	Eye- let		22 per eyelet	A (silk)	A
	<u>Stitch and press dart in under sleeves.</u>					
	a. Fold the under sleeve, matching the cut edges of the sleeve dart. Stitch the entire length of the dart 1/4 inch from the cut edges of the armhole, tapering the line of stitching to zero at the lower folded edge.	301	SSa-1 (cut edge) OSf-1 (folded edge)	12-16	A	A

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
11.	<u>Stitch and press dart in under sleeves.</u> (cont'd) b. Turn the cut edges of the dart toward the forearm edge and press the entire dart smooth and flat with a heated pressing iron.					
12.	<u>Seam sleeves at forearm.</u> Finished appearance. The forearm seam shall finish smooth and flat without twists, gathers, puckers or pleats and shall start and finish evenly. a. Position the top sleeve with upper forearm edge in line with the notch in the armhole edge of undersleeve and with the notches in the lower forearm edge of top and under sleeves matching. Seam the top and under sleeves together 3/8 inch from forearm edge of top sleeve, forming a tapered outlet on the under sleeve. b. Spread open the seam and press flat with a heated pressing iron. c. Mark sleeve end for turnup and mark the top sleeve for positioning the ornamental sleeve patch with pattern marker.	301	SSbd-1 and SSa-1	12-16	A	A
13.	<u>Baste wigan reinforcement to sleeve.</u> a. Position the sleeve on the wigan reinforcement piece with marks and notches matching. b. Baste sleeve and wigan piece together at the mark for the bottom turnup.	Hand or 101				

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
14.	<p><u>Join ornamental sleeve patches to top sleeves.</u></p> <p>Finished appearance. The ornamental sleeve patch shall be uniformly stitched to the top sleeve without twists, gathers, puckers, pleats or raw edges. The folded front edge of the patch shall not be topstitched. The dimensions and position of the ornamental sleeve patch shall be as shown in Figure 4. The scalloped edge of sleeve patch shall be stitched to the sleeve at the corners and point only, in order to facilitate removal of insignia buttons when pressing coat.</p> <p>a. Mark the ornamental sleeve patch on the under ply 1/4 inch from the raw edge. Position the sleeve patch on the sleeve with marks matching and with bottom edge of sleeve patch even with mark for bottom turnup of sleeve.</p>					
	b. Seam the sleeve patch to the sleeve at the mark.	301	LSa-1	12-16	A (silk)	A
	c. Turn back the sleeve patch at the seamline and stitch through the sleeve and wigan along the upper and bottom piped edges. The line of stitching shall be adjacent to the stitching line of the sleeve patch piped edge and shall extend from the turned edge to approximately one half over the pointed ends. At the center point, the stitching shall extend approximately one half on each side of the point.	301		12-16	A (silk)	A

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
15.	<u>Seam sleeves at backarm.</u> Finished appearance. The backarm seam shall finish smooth and flat without twists, gathers, puckers or pleats and shall start and finish evenly. a. Join the top and under-sleeves together at the backarm with a 3/8-inch seam, catching the ends of the wigan reinforcement piece in the stitching. b. Spread open the seam and press smooth and flat with a heated pressing iron.	301	SSa-1	12-16	A	A
16.	<u>Baste and tack sleeve turnup to reinforcement.</u> a. Turn up the bottom edge of sleeve to the inside at the mark and baste along the turned edge. b. Tack the raw edge of the turned-up portion to the reinforcement wigan piece with blindstitching.	Hand or 101 or 301 or Hand	EFc-1	4-6 4-6	A C (silk)	A
17.	<u>Stitch and press dart in under sleeve linings.</u> a. Fold the under sleeve lining, matching the cut edge of the under sleeve dart. Stitch the entire length of the dart 1/4 inch from the cut edges of the armhole, tapering the line of stitching to zero at the lower folded edge.	301	SSa-1 (cut edge) OSf-1 (folded edge)	12-16	A	A

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
17.	<u>Stitch and press dart in under sleeve linings. (cont'd)</u> b. Turn the cut edges of the dart toward the forearm edge and press the entire dart smooth and flat with a heated pressing iron.					
18.	<u>Seam sleeve linings at forearm.</u> Finished appearance. The forearm seam shall finish smooth and flat without twists, gathers, puckers or pleats and shall start and finish evenly. a. Position the top sleeve lining with upper forearm edge in line with the notch in the armhole edge of undersleeve lining and, with the notches at lower forearm edge of top and undersleeve lining matching, seam the top and undersleeve lining together 3/8 inch from the forearm edge of top-sleeve lining, forming a tapered outlet on the under sleeve lining.	301	SSbd-1 and SSa-1	12-16	A	A
19.	<u>Seam sleeve lining at backarm.</u> Finished appearance. The backarm seam shall finish smooth and flat without twists, gathers, puckers or pleats and shall start and finish evenly. a. Join the top and under sleeve linings at the backarm with a 3/8-inch seam.	301	SSa-1	12-16	A	A

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
20.	<p><u>Assemble sleeve and sleeve lining.</u></p> <p>Finished appearance. The linings shall be seamed to the sleeve without twists, gathers, puckers or pleats.</p> <p>a. Position the sleeve lining on the sleeve with the upper edge of the lining extending approximately 1 inch beyond the armhole edge of the sleeve.</p> <p>b. Tack the sleeve lining to the forearm and backarm seam allowance, respectively, of the top sleeve, commencing at the top edge of the wigan reinforcement piece and extending to approximately 6 inches from armhole edge at backarm and approximately 4-1/2 inches from armhole edge at forearm.</p> <p>c. Pull sleeve through lining.</p>	301 or Hand		6-8 4-6	A C (silk)	A
21.	<p><u>Fell turnup of sleeve lining; press sleeves.</u></p> <p>Finished appearance. The sleeve lining shall not be short, tight, or twisted at bottom of sleeves.</p> <p>a. Turn under the bottom edge of sleeve lining to finish 1 to 1-1/4 inches above the finished end of sleeve and baste to turnup of sleeve, or, the sleeve lining may be felled to bottom sleeve without basting.</p> <p>b. Fell the folded edge of sleeve lining to the turnup of the sleeve with blind-stitching.</p>	Hand or 101		8-10 6-8	C (silk) O (silk)	O

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
22.	<p><u>Press sleeves.</u></p> <p>Turn the sleeves right side out and assemble in pairs. Press the lower half of sleeves smooth and flat, creasing at the forearm and backarm. The backarm crease shall be on the backarm seam. Remove basting at lower end of the sleeve.</p>					
23.	<p><u>Assemble collar interlining.</u></p> <p>Finished appearance. The binding at top and bottom edges of the collar interlining shall be uniformly stitched 1/4 inch from the folded edges. The binding shall not be tight or full causing puckers, gathers or pleats. The interlining eyelet reinforcement pieces and edges of the binding shall be securely caught in the stitching. The interlining shall finish with the eyelet reinforcement pieces positioned on the inside and the felt padding on the outside. The collar eyelet covers shall be positioned so that in the finished collar the covers shall be centered over the eyelets.</p> <p>a. Position the eyelet reinforcement at each end of the collar interlining. Bind the upper and lower edge of the interlining with 1/8-inch-wide strip of binding material specified in 3.3.12, catching the eyelet reinforcement in the seams.</p> <p>b. Position the strip of felt padding at the center of interlining, with the ends of the felt extending approximately 1 inch beyond each end of interlining.</p>	301	BSa-1 (each edge)	12-16	A	A

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
23.	<u>Assemble collar interlining.</u> (cont'd)					
	c. Stitch the padding through interlining and eyelet reinforcement from end to end 1/8 inch from the upper and lower edge of padding.	301	SSa-1	12-16	A	A
	d. Lap the raw edge of the collar eyelet cover 1/2 to 5/8 inch on the top inside edge of the collar interlining. Seam the covers to the interlining 1/4 inch from the raw edge of the cover.	301	LSa-1	12-16	A	A
24.	<u>Pipe outer ply of collar.</u>					
	Finished appearance. The piping shall extend at upper, lower and side edges of the outer ply and shall be uniformly stitched without twists, gathers, puckers or pleats.					
	a. The outer ply of the collar shall consist of two plies of basic material, piped at upper and lower edges with 5/8- to 3/4-inch-wide strip of the piping material specified in 3.3.11.					
	b. Position the two plies of collar (face up and edges even) and stitch together from end to end, 1/8 inch from upper and lower edges.					
	c. Seam the 5/8-to 3/4-inch-wide strip of piping to the two plies of collar from end to end, 1/8 inch from upper and lower edges.	301		12-16	A (silk)	A
	d. Turn back the piping and outer ply at upper and lower edges respectively, uniformly working the folded edge of the piping beyond the edges. Top-	301		12-16	A (silk)	A

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
24.	<u>Pipe outer ply of collar (cont'd)</u> stitch the outer ply uniformly 3/16 inch from the folded edge of piping.					
25.	<u>Assemble collar.</u> Finished appearance. The collar shall be assembled without twists, gathers, puckers or pleats. In the finished collar, the end of the lining shall extend approximately one half beyond the right end of collar and approximately 2-1/2 inches beyond the left end of the collar for the extension tab. Eyelet cover shall not be caught in the eyelet. a. Position the upper piped edge of collar 1/8 inch below the upper bound edge of collar interlining with lower edges of collar and collar interlining even. The collar shall extend approximately 1 inch beyond each end of collar interlining. b. Stitch collar to interlining along the upper and lower piped edge from end to end. Line of stitching shall be adjacent to stitching of piped collar edge, catching the eyelet cover in the stitching. c. Lap the upper piped edge of collar assembly over the upper raw edge of lining, approximately in half, with the lining facing up. Stitch collar to lining and eyelet cover along piped edge adjacent					
		301	SSa-1	12-16	A (silk)	A
		301	LSa-1	12-16	A	A

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
25.	<p><u>Assemble collar.</u> (cont'd)</p> <p>to stitching line of the collar piped edge. The stitching shall extend from center to center of eyelet covers.</p> <p>d. Smoothly fold the ends of the collar padding and outer ply to the inside over the ends of the interlining assembly and press smooth and flat with a heated pressing iron or pressing machine.</p> <p>e. Turn collar lining at the seam to the inside of the collar and press smooth and flat with a heated pressing iron or pressing machine.</p>					
26.	<p><u>Make collar extension tab.</u></p> <p>Finished appearance. The collar extension tab shall extend 3/4 to 7/8 inch beyond the folded edge of the left end of collar.</p> <p>a. Turn the top and bottom edges and the end of the collar lining at the left end of the collar to the inside of the lining and baste the turned portion along the top, front and bottom edges to the body of the lining, forming the collar extension tab.</p> <p>b. Stitch the collar extension tab 1/16 inch from the top, front and bottom edges and continue the stitching at the back of tab to top row, forming a 1-3/8-to 1-1/2-inch-wide box stitch.</p>	Hand				
		301	SSc-1 (top and bottom edges) OSf-1 (front) SSa-1 (back edge)	12-16	A (silk)	A

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
27.	<p><u>Fell ends of collar.</u></p> <p>Finished appearance. The upper and lower piped edges of the collar at each end shall not be visible on the outside of the finished collar.</p> <p>a. Fold the ends of collar to the inside, against the ends of interlining. Tack collar to reinforcement pieces and eyelet covers with overcast stitching.</p> <p>b. Make one eyelet, through all plies of the collar, midway between the upper and bottom edge and 1-1/2 +1/8 inches from folded edge.</p>	Hand		2-3	C (silk)	
28.	<p><u>Fold and stitch dart in front lining.</u></p> <p>Finished appearance. The darts shall finish without gathers, puckers, or pleats. The stitching shall be 3/8 inch from the folded edge at the center.</p> <p>a. Fold the front lining and stitch waist darts in accordance with marks indicated on the pattern, tapering the upper and lower ends to a flat point, and securely tacking the points.</p>	301	OSf-1	12-16	A	A
29.	<p><u>Sew on identification label.</u></p> <p>Finished appearance. The identification label shall be positioned so that in the finished coat the label shall be midway between front and back edges of the right facing and with the bottom edge of the label approximately 4 inches from the bottom finished edge of coat.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
29.	<u>Sew on identification label.</u> a. Sew the identification label to the outside of the right facing with a single row of stitches 1/16 from each edge.	301	SSa-1 (each edge)	12-16	A	A
30.	<u>Join front lining to wool facing.</u> Finished appearance. The lining shall be carefully joined to the facing so that in the finished coat the lining shall lie smooth and flat along the facing without creases, bulges, overlapping of excess material or other distortion. a. Position the lining on the wool facing with the top edges even. b. Seam front edges of the lining to the back edge of the facing 3/8 inch from the edge. The stitching shall extend from top edge of facing to approximately 1-1/4 inches from bottom edge.	301	SSa-1	12-16	A	A
31.	<u>Assemble back lining.</u> Finished appearance. The side back lining shall be carefully joined without gathers, puckers or pleats. The seams shall start and finish evenly. a. Position and join the left and right side back linings to the respective centerback lining with a 3/8-inch seam. b. Position the backs and join together at the center with a 3/8-inch seam.	301 301	SSa-1 SSa-1	12-16 12-16	A A	A A

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OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
32.	<u>Join side back and front linings.</u> Finished appearance. The back and front lining shall be carefully joined without gathers, puckers or pleats. The seams shall start and finish evenly.					
	a. Position and join the front and back lining, at the sides, with a 3/4-inch seam.	301	SSa-1	12-16	A	A
33.	<u>Overedge stitch lining and facing seams.</u> a. Overedge stitch together the raw edge of the facing lining, side, side back and center back seam allowances.	503 or 504		6-8 6-8	70/2 70/2	70/2 70/2
34.	<u>Press lining seams and waist darts.</u> a. Turn the edge of facing-lining seam, the side seams and side back seams toward the back and press smooth and flat. b. Turn the waist darts towards the side seam and press smooth and flat.					
35.	<u>Assemble fronts.</u> Finished appearance. The chest and waist darts shall finish without gathers, puckers, or pleats. The stitching for the waist darts shall be 3/8 inch from the folded edge at the center.					

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OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
35.	<u>Assemble fronts.</u> (cont'd)					
	a. Fold the fronts, matching the notches of the chest darts. Stitch the entire length of the darts 3/8 inch from the notches at the upper end, tapering the line of stitching to zero at the lower end.	301	SSa-1 (cut edge) OSf-1 (folded edge)	12-16	A	A
	b. Fold fronts and stitch waist dart in accordance with marks indicated on the pattern, tapering the upper and lower ends to a flat point and securely tacking the points.	301	OSf-1	12-16	A	A
36.	<u>Press darts on fronts.</u>					
	a. Turn the folded edges of the chest darts towards the armhole and press smooth and flat.					
	b. Turn the folded edge of the waist darts towards side seams and press smooth and flat.					
37.	<u>Assemble back.</u>					
	Finished appearance. The side and center backs shall be joined without gathers, puckers or pleats. The seams shall start and finish evenly.					
	a. Position the center back with notches matching and join with a 5/8-inch seam.	301	SSa-1	12-16	A	A
	b. Position and join the left and right side backs to the respective center backs with a 3/8-inch seam.	301	SSa-1	12-16	A	A

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OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
38.	<u>Join fronts and back.</u> Finished appearance. The fronts and back shall be joined without gathers, puckers or pleats. The seams shall start and finish evenly.					
	a. Position and join fronts to the back at the sides with a 3/4-inch seam.	301	SSa-1	12-16	A	A
39.	<u>Overedge stitch front and back seams.</u> a. Overedge stitch all raw edges of the joining seams for fronts and back.	503 or 504	EFd-1 EFd-1	6-8 6-8	70/2 70/2	70/2 70/2
	b. Spread open side and back seams and press smooth and flat with a heated pressing iron.					
40.	<u>Seam reinforcement stays to shoulder and armhole.</u> Finished appearance. The silesia or polyester and cotton reinforcement stays shall be sewn to the armhole and shoulder edges of the fronts without gathers, puckers or pleats. The top end of the armhole stay and lower edge of the shoulder stay shall form a right angle at the armhole without the stays overlapping each other.					
	a. Seam the 3/4-inch-wide stay to the underside of front along the shoulder edges and upper front edge of the armhole, respectively, 1/8 inch from the outer edges. The stay at the armhole shall extend from 1/2 inch below the shoulder seam down front edge of armhole approximately	301	SSaa-1	12-16	A	A

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
40.	<p><u>Seam reinforcement stays to shoulder and armhole.</u> (cont'd)</p> <p>4-1/2 inches and the stay on the shoulder shall extend from approximately 1/2 inch from armhole and neck.</p>					
41.	<p><u>Tape armholes.</u></p> <p>a. Sew the cotton tape to the armholes, starting with one end from approximately 1 inch above the notch in the fronts and continuing along the lower and back edge of the armhole to approximately 1/2 inch from the shoulder edge.</p> <p>b. The tape shall be stitched with slight tension along the lower front edges of the armholes and shall be held taut while stitching along the back edge.</p>	301	SSaa-1	12-16	A	A
42.	<p><u>Press shoulder blades and armhole tapes.</u></p> <p>a. Press the shoulder blade and the armhole tapes smooth and flat with a heated pressing iron or a suitable type pressing machine.</p>					
43.	<p><u>Mark and dress left front.</u></p> <p>a. Mark and shape the left front from the top notch to the bottom front notches.</p> <p>b. The mark line shall be 1 inch from the upper front edge to 1-1/8 inches at the waist line. Continue on a straight line from waist line to the notch at the bottom edge.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
43.	<p><u>Mark and dress left front.</u> (cont'd)</p> <p>Note: The dressing and shaping shall be performed in the sewing room.</p> <p>c. Where necessary, trim any frayed edges along the right front and bottom edges.</p>					
44.	<p><u>Stitch piping to coat.</u></p> <p>Finished appearance. The piping shall be uniformly stitched to the coat without twists, gathers, puckers or pleats. The piping shall extend from the collar notch at top edge of the right front along the bottom and up to the collar notch at top edge of the left front.</p> <p>a. Position the 1-inch-wide strip of piping material on the outside of left and right front, with one edge even with top, front and bottom edge of coat. Stitch piping to coat 1/8 inch from edge. The piping shall extend from the bottom right front edge to the collar notch at the top edge of left front.</p> <p>b. Turn the piping to the inside, folding the corners smooth and flat and working the folded edge uniformly 1/8 inch beyond the edges of the coat. Topstitch the piped edges of the coat uniformly 3/16 inch from the folded edge of the piping, catching the turned under portion of the piping in the stitching.</p>	301	SSa-1	12-16	A (silk)	A
		301		12-16	A (silk)	A

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OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
44.	<u>Stitch piping to coat.</u> (cont'd)					
	c. Cut out any excess piping material at the top and bottom front corners to eliminate bulkness. Trim the inner edge of piping on the left front only, from the upper front down to approximately 1-1/2 to 2 inches below waistline, so that the piping will not interfere with front buttonholes.					
	d. Serge stitch the raw edge of the piping at the bottom edge of coat.	503 or 504	EFd-1 EFd-1	6-8 6-8	70/2 70/2	70/2 70/2
	e. Press the piped edge of coat smooth and flat with a heated pressing iron or pressing machine.					
45.	<u>Interline fronts.</u>					
	a. Position the left and right fronts on the respective coat front interlining and baste the interlining and fronts together from approximately 3-1/2 inches down from the shoulder edge to approximately 2 inches from the bottom edge of the front.	Hand or 301	Hopper			
	b. Baste along the shoulder, allowing room for setting the shoulder pad and working the fullness in the front towards the armhole. Baste along the front of the armholes approximately 1 inch from the edge and continue to baste down the back edge of interlining, across the waist dart, to approximately 2 inches from the bottom edge of fronts. Baste along the top edge from the basting stitches for the shoulder to approximately 1-1/2 inches from the front edge. Continue to baste approximately 1-1/2 inches from the front edge of the bottom edge of fronts.	Hand or 301	Hopper			

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OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
46.	<p><u>Trim coat front interlining.</u></p> <p>a. Trim the top edge of coat interlining even with the top edge of fronts, from the point of shoulder to the collar notch.</p> <p>b. Notch the top edge of the interlining in line with the collar notch.</p> <p>c. Remove stitches joining the front edge of silesia or polyester and cotton to coat front interlining, approximately 1/2 inch back from front and top edge of fronts.</p> <p>d. Trim the interlining only, even with the front and bottom edges of fronts.</p> <p>e. Turn the fronts inside out and trim the interlining only, approximately 1/4 inch back from the front and top edge of fronts.</p> <p>f. Trim the shoulder edge of the coat front interlining to approximately 3/4 inch from shoulder at armhole edge of fronts; taper the trimming to 3/8 inch at the neck.</p>					
47.	<p><u>Bind front and top edge of interlining.</u></p> <p>a. Smoothly fold the silesia, or polyester and cotton, at the top and front edge of the interlining, over the respective raw edges to the underside. Secure the front turned under portion of the silesia, or polyester and cotton, to the body of the interlining with three rows of stitches 1/4 inch apart, placing the first row 1/8 inch from folded front edge and catching the upper turned under portion in the stitching.</p>	301	EFa-1	12-16	A	A

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OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
48.	<u>Bind top neck edge of interlining.</u>					
	Finished appearance. The silesia or polyester and cotton binding shall be uniformly stitched to the top edge of the coat front interlining from the collar notch to the shoulder point.					
	a. Lap the 3/4-inch-wide binding on the outside of the coat front interlining, from the collar notch to the shoulder point, approximately 1/4 inch. Stitch the binding to the interlining 1/8 inch from the raw edge of the binding.	301	LSa-1	12-16	A	A
	b. Smoothly fold the free edge of the binding over the top edge and to the underside of the interlining. Secure the free edge of binding to the interlining with a row of stitches 1/8 inch from the raw edge of the binding.	301		12-16	A	A
49.	<u>Fell piping to coat front interlining.</u>					
	a. Place the inner edge of piping on the outside of the interlining at the top front and bottom edges. Baste piping to interlining through the fronts.	101				
	b. Fell the upper, front and lower inner edges of the piping to the coat front interlining.	301 or Hand	EFc-1	4-6 4-6	A C (silk)	A
	c. Pull and remove basting stitches from piping.					
	d. Press the left and right fronts on a suitable type pressing machine. The chest shall conform to the shape of the body.					

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
50.	<u>Set belt loops.</u>					
	Finished appearance. The belt loops shall finish vertically straight.					
	a. Center the belt loops vertically on the side seam with the pointed end towards the bottom of the coat with the raw edge of the loop in horizontal alignment with the mark for the bottom buttonhole as indicated by the pattern.					
	b. Seam loops to the coat 1/4 inch from the raw edge.	301	LSq-2 (a)	12-16	A (silk)	A
	c. Turn the loop at the seam with the pointed end towards the top edge of coat, and secure loop to coat with a row of stitches 1/4 inch from the raised edge.	301	LSq-2 (b)	12-16	A (silk)	A
51.	<u>Join facing to fronts.</u>					
	a. Position the left and right fronts to the respective front facings (face to face) with the waistline notch of the front in line with the notch on the facing and the front piping edge approximately 3/8 inch from the front edge of facing. Mark the facing along the top, front and bottom edge of coat.					
	b. Lap the front edge of the right and left fronts respectively on the outside of the facing at the marks and join the front to the facing as close as possible to, but not on top of, the stitching joining the piping to the front. The stitching shall extend from the top to bottom edge of coat front edge only.	301	LSa-1	12-16	A (silk)	A
	c. Trim excess facing material where necessary.					

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
52.	<u>Join front eyelet cover to right facing.</u> a. Mark the outside of the right facing 1/2 inch from the seam joining facing to the front. Mark the upper edge of facing in such a manner that the front corner of the eyelet cover shall finish approximately 1/4 inch down from the folded edge of piping. b. Lap the front raw edge of the eyelet cover on the outside of the right facing at the marks. Seam the eyelet cover to the facing only, 1/4 inch from raw edge of eyelet cover. c. Turn back the eyelet cover at the seam and topstitch the cover, through the facing only 1/8 to 3/16 inch from the raised edge.	301	LSq-1 (a)	12-16	A (silk)	A
		301	LSq-2 (b)	12-16	A (silk)	A
53.	<u>Baste front edges.</u> a. Turn the facing-lining assemblies to the inside of fronts. Baste along front edge of left and right fronts, working the facing back from the folded edge of the piping.	101				
54.	<u>Baste facing (second time).</u> a. Baste the facing to the fronts approximately 1-1/4 inches from the top, front and bottom edges of the coat, holding the lower corner of the coat in such a manner as to cause the lower front edge of the fronts to roll inward towards the back edge of the facing.	Hand or 301	Hopper			

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
54.	<u>Baste facing (second time (cont'd))</u> b. Turn under and baste the top edge of the facing even with the fronts from the collar notch to the front edge, catching the turned under portion of the facing in the basting. c. Baste the facing to the fronts as close as possible to the facing-lining seam, placing the fullness over the chest and distributing the fullness in the facing in accordance with good commercial practice. The basting shall extend approximately 3 inches from shoulder edge of facings to approximately 1-1/4 inches from the lower edge of facing. d. Turn under the bottom edge of the facing at the mark and baste along the folded edge.	Hand or 301 Hand or 301 Hand or 301	Hopper Hopper Hopper			
55.	<u>Tack facings to interlining.</u> a. Tack the right and left facing-lining seam allowance to the respective coat front interlining from approximately 2-1/2 inches from bottom edge of coat to approximately 3 inches from the shoulder edge.	Hand or 103	SSm-1	2-4 4-6	C (silk) A (silk)	
56.	<u>Baste lining to coat.</u> a. Fold the front lining in accordance with the notches, forming the chest pleat, and baste along the entire center of the pleat. The folded edge of the pleat on the outside of the lining shall be towards the armhole.	Hand or 301	Hopper			

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
56.	<u>Baste lining to coat. (cont'd)</u> b. Baste the front lining to the coat, starting at the lower end of the chest pleat, continuing along lower edge of armhole approximately 2 inches from the edge and ending at the side seam. Match side seams of coat and lining and continue basting as close as possible to the side seam and then across the bottom toward the front approximately 4 inches from piped bottom edge of coat. c. Fold the back lining, forming approximately a 1-inch-wide pleat at the center back. Baste the back lining to the coat along the center pleat from the top end to approximately 4 inches from bottom finished edge of coat. d. Baste back lining to coat starting at side seam and continuing approximately 3 inches from the armhole and shoulder edges.	Hand or 301 Hand or 301 Hand or 301	Hopper Hopper Hopper			
57.	<u>Hem bottom edge of lining .</u> Finished appearance. The hem shall be uniformly stitched and shall finish smooth and flat without twists, gathers, puckers or pleats. The hem shall be $3/4 \pm 1/8$ inch wide. The lining securing straps shall be positioned on the side seam outlets of the lining with one edge even with the serged edge. a. Hem the bottom edge of body lining, with the raw edge turned under and with one end of the securing straps positioned and caught in the stitching $1/16$ inch from the upper folded edge of hem.	301	EFb-1	12-16	A	A

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
58.	<u>Tack the lining securing straps to bottom of coat.</u>					
	<p>Finished appearance. The lining securing straps when tacked to the bottom edge of coat shall not cause twists, or other distortions, to either the coat or the lining. The end of the securing strap shall finish between the piping at bottom edge of coat and the side seam allowance. In the finished coat, the lining shall not be visible below the bottom edge of coat.</p> <p>a. Position and securely tack the free end of the securing straps to the piping at the bottom edge of coat through the side seam allowance.</p> <p>b. Position the bottom edge of the lining so that in the finished coat the lining shall not be visible below the bottom edge of coat. Fold the lining securing strap across the width and stitch approximately 1/4 inch from the folded end in order to hold the lining in position.</p>	301			A	A
		301	OSf-1		A	A
59.	<u>Fell facings.</u>					
	<p>a. Fell the facing to the piping at the bottom edge of the coat, starting at the bottom edge of the lining and continuing along the back and bottom edges of facing to the front edge of coat.</p> <p>b. Fell the folded edge of the facings to the piping along the top edge from collar notch to front edge of coat.</p>	Hand		8-10	C (silk)	
		Hand		8-10	C (silk)	

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
60.	<u>Trim lining and interlining.</u> a. Trim the excess coat front interlining and front lining at the armhole. b. Trim back lining even at the neck. c. Trim the shoulder edge of the front and back lining to approximately 3/4 inch from shoulder at the armhole edge and taper the trimming to 3/8 inch at the neck.					
61.	<u>Baste shoulder pad to coat.</u> a. Insert shoulder pads between interlining and chest padding of coat fronts. Securely tack the pad to the interlining and chest padding only.	Hand or 301	Hopper			
62.	<u>Seam shoulders.</u> Finished appearance. The shoulder seam shall finish without a distorted appearance. a. Join the back to the fronts at the shoulders with a 3/8-inch seam, working in the fullness on the backs in accordance with good manufacturing practice. b. Spread open the shoulder seam and press flat holding the shoulders short and exercising much care in pressing in order not to effect a distorted appearance in the finished seam. The pressing shall be accomplished with a heated pressing iron or pressing machine over a suitable block.	301	SSa-1	12-16	A	A

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
62.	<u>Seam shoulders. (cont'd)</u> c. Position the front lining and coat front interlining at the neck, shoulder and armhole edges of the fronts. Baste all plies together along the front edge of armhole and continue along the shoulder seam and gorge, catching the shoulder pad in the basting.	Hand or 301	Hopper			
63.	<u>Set shoulder straps.</u> Finished appearance. The shoulder straps shall be uniformly stitched to the coat without twists, puckers, pleats or other distortion. On the finished coat, the straps, including the piping, shall be $2\frac{3}{8} + \frac{1}{8}$ inches wide at the armhole seam and shall taper to $1\frac{3}{4} + \frac{1}{8}$ inches wide at the buttonhole eyelet end. a. Position the shoulder straps with the back edge $\frac{1}{4}$ to $\frac{1}{2}$ inch to the back of the shoulder seam at the armhole and with the rounded end of the straps, on the finished coat, to be $\frac{1}{4}$ to $\frac{3}{8}$ inch from lower edge of collar. b. Seam the shoulder straps to the coat $\frac{3}{8}$ inch from the armhole edge. Trim the shoulder straps even with the armhole where necessary. Turn the coat on the inside.	301	SSa-1	12-16	A	A
64.	<u>Baste back lining and facing-lining assembly at shoulders.</u> a. Turn under and lap the shoulder edge of the back lining on the facing lining assembly. Baste lining along the folded edge of the back lining with the top end of the chest pleat caught in the basting.	Hand				

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
65.	<u>Seam neckline with size label and coat hanger.</u>					
	Finished appearance. The neckline shall finish smooth and flat, without twists, pleats or puckers. The size label shall be positioned between the ends of the coat hanger, and the ends of the coat hanger shall be positioned so that in the finished coat the hanger opening shall be 2 \pm 1/8 inches long when measured along the lower edge of collar lining.					
	a. Join facings and back lining to coat at the neckline from collar notch to collar notch, with a 1/4-inch seam and with the upper edge of the size label and the ends of the hanger positioned and caught in the stitching at the inside center back.	301	SSa-1	12-16	A	A
66.	b. Press the neckline of the coat smooth and flat with a heated pressing iron or pressing machine.					
	<u>Set collar with lining.</u>					
	Finished appearance. The collar shall be carefully joined to the coat without distortion of the collar.					
	a. Mark the neckline on the inside, 3/8 to 1/2 inch from top edge, for proper positioning of collar.					
	b. Position the collar with the lower edge lapped on the outside top edge of the coat at the mark.					
	c. Seam the collar, from end to end, to the coat as close as possible to, but not on top of, the stitching for the piping	301	LSa-1	12-16	A	A

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
66.	<u>Set collar with lining.</u> (cont'd) at the lower edge of the collar. The stitching shall not be through the collar lining.					
67.	<u>Make buttonholes</u> Finished appearance. The buttonholes shall be clean cut, well made and well worked over gimp to fit a 40-line insignia button. The stitching of the buttonholes shall be securely caught in the basic material. The gimp and thread shall be pulled through to the underside of the front. The purling of the buttonholes shall be on the outside of the fronts. The inside edge of the eyelet end of the buttonholes shall be 5/8 inch from the front edge of coat. The buttonholes shall be cut-first type. a. Mark the left front for the location of seven buttonholes. The marks for the top and bottom buttonholes shall be in accordance with the patterns. The marks for the remaining five buttonholes shall be evenly spaced. b. Make one horizontal eyelet end, square bar type buttonhole, cut 1-1/8 inches long, at each of the marks. c. Securely bartack the end of each buttonhole, catching the ends of the gimp and thread in the bartack. Trim the ends of the gimp and thread.	Button-hole Bartack		60 per button-hole (not including bartack) 21 per bartack	B (silk) A (silk)	F A

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
68.	<p><u>Set sleeves.</u></p> <p>Finished appearance. The armhole-sleeve seam shall finish without twists, gathers, puckers or pleats.</p> <p>a. Position sleeves on outside of coat at the armholes, with backarm seam of sleeve matching the side back seam, and with notch in top sleeve and front matching.</p> <p>b. Join the sleeve to the coat with a 3/8-inch seam, catching the end of the shoulder straps in the stitching.</p> <p>c. Press the entire armhole smooth and flat with a heated pressing iron exercising care not to stretch the armhole. Spread open upper part of the armhole-sleeve seam from the backarm seam of the sleeve to approximately midway between shoulder seam and notch at front edge of armhole. Press smooth and flat with a heated pressing iron.</p> <p>d. Fold the excess material at armhole pit up to the line of stitching of the armhole sleeve seam, forming a hinge effect. The fold shall extend from the armhole notch to approximately 4 inches from the backarm seam.</p> <p>e. Press the fold smooth and flat with a heated pressing iron.</p>	301	SSa-1	12-16	A	A

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
69.	<u>Baste armhole.</u> a. Baste around the entire armhole on the inside, holding the back lining, shoulder pad and front lining in place and distributing fullness evenly. Turn coat on the outside. b. Baste around the outside armhole adjacent to the armhole seam, forcing out the armhole in the basting. The basting shall extend from the backarm seam of sleeve to the front notch of coat.	Hand Hand				
70.	<u>Set underarm shields.</u> a. Baste or tack underarm shields at the base of armhole.					
71.	<u>Stitch sleeve head pads and linings at armhole.</u> Finished appearance. The armhole shall not be distorted or puckered due to stitching the sleeve head pads and linings at the armhole. a. Position the sleeve head pad on the sleeves with the folded edge of the pad approximately 1/8 inch back from the raw edge of armhole-sleeve seam, and with the one end of the pad matching the notch in the fronts. b. Stitch the sleeve head pad to the sleeve from end to end, through the armhole-sleeve seam allowance, 1/8 inch from the folded edge of pad, catching the front and	Hand or 301 301				
			SSa-1	4-6	24/4	24/4

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
71.	<p><u>Stitch sleeve head pads and linings at armhole. (cont'd)</u></p> <p>back linings and the shoulder pad in the stitching. Continue stitching the linings around the remainder of the armhole, catching the underarm shields in the stitching and trimming away the excess material.</p> <p>c. The underarm shield may be basted to the armhole prior to stitching.</p>					
72.	<p><u>Tack underarm shield to lining.</u></p> <p>Finished appearance. The tacking for the underarm shield shall finish approximately 1/2 inch from the seamed edges.</p> <p>a. Tack the underside of the underarm shields to body lining along the side and bottom edges.</p>	Hand		4-6	C (silk)	
73.	<p><u>Fell back lining and facing-lining assembly at shoulders.</u></p> <p>a. Fell the back lining and facing-lining assembly together at the shoulders, placing the stitching over the folded edge of back lining and securing the top end of the chest pleat in the felling.</p> <p>b. Fell the folded edge of facing to the piping along the top edge from collar notch to front edge of coat.</p>	Hand		8-10	C (silk)	
74.	<p><u>Fell sleeve lining at armhole.</u></p> <p>a. Position the sleeve lining at the armhole with the back and forearm seams of the sleeve and sleeve lining matching.</p>	Hand		8-10	C (silk)	

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
74.	<u>Fell sleeve lining at armhole.</u> (cont'd)					
	b. Turn under the armhole edge of the sleeve lining and lap the lining on the outside of the front and back lining and the top edge of the underarm shield. Fell the sleeve lining to the coat around the entire armhole, placing the stitching over the folded edge of the sleeve lining, catching the underarm shield in the felling, and distributing the fullness in accordance with good commercial practice. Back-stitch the lower armhole edge from back-arm seam of sleeve to the front edge of the shield.	Hand		8-10	C (silk)	
	OR					
	c. Machine stitch the lower edge of the sleeve lining, at the armhole, on the inside from forearm seam to backarm seam and hand fell the remaining portion as specified in operations 74.b above.	301	SSa-1	12-16	A	A
	OR					
	d. Machine stitch the lower edge of the sleeve lining, at the armhole on the inside from forearm seam to backarm seam and stitch the remaining portion of the sleeve lining at the armhole with machine simulated hand felling.	Machine		8-10	C (silk)	
	NOTE: It is required that the simulated hand felling produced by machine shall be equal to or better than the hand felling.					

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
75.	<p><u>Mark for eyelets in right front and shoulders.</u></p> <p>a. Mark the right front for the location of seven eyelets for removable insignia buttons to align with the buttonholes in left front. The mark for top eyelet shall be in line with right end of collar and the remaining eyelets shall be in vertical alignment with top mark.</p> <p>b. Mark each shoulder for the location of one eyelet for removable insignia buttons to align with the eyelet of buttonhole in shoulder straps. On the finished coat, the shoulder straps shall lie smooth and flat without twisting or bulging.</p>					
76.	<p><u>Make eyelets.</u></p> <p>Finished appearance. The eyelet shall be well worked with the purling of the eyelet to be on the outside of the shoulder and front. The eyelets shall finish with a 1/8-to 3/16-inch diameter opening.</p> <p>a. Make one eyelet at each mark on the right front through the facing, but not through front eyelet cover.</p> <p>b. Make one eyelet at the mark on each shoulder through all plies.</p>	Eyelet		22 per eyelet	A (silk)	A
		Eyelet		22 per eyelet	A (silk)	A
77.	<p><u>Sew hooks and eyes to collar.</u></p> <p>Finished appearance. The hooks shall be positioned on the collar so that in the finished coat the top and bottom hooks shall be approximately 1/4 inch</p>					

TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
77.	<p><u>Sew hqoks and eyes to collar.</u> (cont'd)</p> <p>from top and bottom edges respectively of collar and the remaining hook shall be midway between top and bottom hooks. The eyes shall be positioned to engage the hooks, affecting a flat, smooth closure at front of collar without misalignment or gapping.</p> <p>a. Position and securely sew three hooks to the right end and three eyes to the left end of the collar.</p>	Hand		12 per hook and eye	C (silk) (double thread)	
78.	<p><u>Finish collar.</u></p> <p>a. Securely tack the lower corners of the collar to the coat.</p> <p>b. Turn under the end and top edge of the lining at the right end of the collar and position the folded edge of the lining under the hook. Fell the folded end of the collar lining to the end of the collar and continue felling along the top folded edge to the end of the stitching joining the lining to the collar.</p> <p>c. Turn under and fell the lower edge of the collar lining to the coat from end to end, catching the turned under portion of the lining at the right end in the felling.</p> <p>NOTE: The lower edge of collar lining may be basted to coat prior to felling.</p>	Hand Hand Hand		8-10 8-10 8-10	C C (silk) C (silk)	

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
78.	<u>Finish collar.</u> (cont'd) d. Fell the collar extension tab to the left end of the collar and continue along the folded top edge to the end of the stitching joining the lining to the collar. e. Turn the collar eyelet covers to the inside of the collar and fell the front edge, from top to bottom edge. Continue the felling along the bottom edge for a distance of 1/2 inch from front edge.	Hand		8-10	C (silk)	
79.	<u>Fell front eyelet cover.</u> a. Turn front eyelet cover to inside and securely fell the upper and lower seamed edges of the cover to the facing, placing stitching over the folded edges of the cover.	Hand		8-10	C (silk)	
80.	<u>Clean coat.</u> a. Pull any basting thread and trim and remove any loose ends of thread. Remove any spots, stains and tickets without injury to the material.	Hand		6-8	C (silk)	
81.	<u>Press coat.</u> a. The coat shall be well pressed throughout with a heated pressing iron or pressing machine of a type suitable to obtain the desired shape and appearance in accordance with good manufacturing practices. b. Press the fronts smooth and flat, straightening and shaping the front edges and working fullness towards the chest. Care shall be exercised in pressing the fronts so that the bottom edges are even.					

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
81.	<p><u>Press coat.</u> (cont'd)</p> <p>c. Press the entire collar smooth and flat.</p> <p>d. Press the fronts on a body machine, shrinking in and properly shaping the chest.</p> <p>e. Press the sides, working the fullness towards the back.</p> <p>f. Press the back smooth and flat, removing all fullness.</p> <p>g. Press the sleeves smooth and flat, creasing at the backarm and forearm seam. The backarm crease shall be on the backarm seam. The forearm and backarm crease shall extend uniformly to a point approximately 3 to 3-1/2 inches below the base of the armhole.</p> <p>h. Block the shoulders to remove the fullness and press shoulders smooth on a shoulder shaping machine. Press the shoulder strap flat.</p> <p>i. Press the armhole solid from the inside, creasing the armhole at the front and creasing the excess material at the armpit. The armpit and back of the armhole shall be held short while pressing.</p> <p>j. Block the armholes on a pressing buck, shrinking in the top sleeves.</p> <p>k. Press lower edge of coat smooth, flat and even.</p> <p>l. Remove all wrinkles and impressions from under shoulder straps.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch's Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
81.	<u>Press coat.</u> (cont'd) m. Press body lining through- out, removing all back wrinkles and creases. Press the front and back lining pleats smooth and flat. n. Remove all gloss marks. o. Remove any wrinkles and creases missed by previous pressing operations.					
82.	<u>Mark for belt loop buttons.</u> a. Mark each side seam for the location of one removable 27-line insignia button to properly align with the eyelet button- hole in the belt loop.					
83.	<u>Cut opening for belt loop buttons.</u> a. Cut a vertical opening, approximately 1/4 inch long, at the mark on each side seam. The opening shall be made through side seam of the wool parts of the coat only. b. Securely tack or bartack each end of the opening.	Hand or 301		2-4 4-6	C (silk) A (silk)	A
84.	<u>Attach buttons.</u> a. Insert the shank of one 40-line insignia button through each eyelet on the right front. Secure buttons to front on the inside with metal ring toggle. b. Insert the shank of one 27-line insignia button through each eyelet on shoulders, ornamental sleeve patch, and through the openings cut at side seams.					

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TABLE I MANUFACTURING REQUIREMENTS

OPN NO.	OPERATION	Stitch Type	Seam or Stitch'g Type	Stitches Per Inch	THREAD	
					Needle	Bobbin or Looper
84.	<u>Attach buttons.</u> (cont'd) c. Attach reinforcement disc (see 3.3.5) through the shank of button on each side seam. Secure buttons to shoulders, side seam and ornamental sleeve patch with metal ring toggles. d. Button belt loops.					

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3.7 Finished measurements. The finished coat shall conform to the measurements shown in Table II.

Table II. - Coat measurements 1/

Size	Breast 2/	Back length 3/	Sleeve length 4/
Short			
	<u>inches</u>	<u>inches</u>	<u>inches</u>
34	35	28-3/4	17-1/2
35	36	28-7/8	17-1/2
36	37	29	17-1/2
37	38	29-1/8	17-1/2
38	39	29-1/4	17-1/2
39	40	29-3/8	17-1/2
40	41	29-1/2	17-1/2
41	42	29-5/8	17-1/2
42	43	29-3/4	17-1/2
44	45	30	17-1/2
46	47	30-1/4	17-1/2
Regular			
	<u>inches</u>	<u>inches</u>	<u>inches</u>
34	35	29-3/4	18-1/2
35	36	29-7/8	18-1/2
36	37	30	18-1/2
37	38	30-1/8	18-1/2
38	39	30-1/4	18-1/2
39	40	30-3/8	18-1/2
40	41	30-1/2	18-1/2
41	42	30-5/8	18-1/2
42	43	30-3/4	18-1/2
44	45	31	18-1/2
46	47	31-1/4	18-1/2
Long			
	<u>inches</u>	<u>inches</u>	<u>inches</u>
34	35	30-3/4	19-1/2
35	36	30-7/8	19-1/2
36	37	31	19-1/2
37	38	31-1/8	19-1/2
38	39	31-1/4	19-1/2
39	40	31-3/8	19-1/2
40	41	31-1/2	19-1/2
41	42	31-5/8	19-1/2
42	43	31-3/4	19-1/2
44	45	32	19-1/2
46	47	32-1/4	19-1/2

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Table II. - Coat measurements 1/ (cont'd)

Size	Breast 2/	Back length 3/	Sleeve length 4/
Extra Long			
	<u>inches</u>	<u>inches</u>	<u>inches</u>
34	35	32-1/4	20-1/2
35	36	32-3/8	20-1/2
36	37	32-1/2	20-1/2
37	38	32-5/8	20-1/2
38	39	32-3/4	20-1/2
39	40	32-7/8	20-1/2
40	41	33	20-1/2
41	42	33-1/8	20-1/2
42	43	33-1/4	20-1/2
44	45	33-1/2	20-1/2
46	47	33-3/4	20-1/2

1/ Tolerance for all measurements $\pm 3/8$ inch.

2/ Breast measurement taken with coat buttoned, from folded edge to folded edge in line with pit of armhole; multiply by 2.

3/ Back length measurement shall be taken along center back seam from lower edge of collar to piped bottom edge of coat.

4/ Sleeve length measurement shall be taken along forearm seam from pit of armhole to bottom edge of sleeve.

*3.8 Workmanship. The finished coats shall conform to the quality and grade of product established by this specification. The occurrence of defects shall not exceed the levels set by the applicable acceptable levels (AQL).

4. QUALITY ASSURANCE PROVISIONS

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

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

*4.2 Inspection. Inspection shall be in accordance with the provisions set forth in MIL-STD-105, except where otherwise indicated herein.

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***4.2.1 First article inspection.** When first article is required, inspection shall be performed on a completely fabricated coat for conformance to provisions of this specification.

***4.2.2 Component and material inspection.** In accordance with 4.1 above, components and materials shall be tested in accordance with all the requirements of reference specifications, figures and standards unless otherwise excluded, amended, modified or qualified in this specification or applicable purchase document. In addition to testing provisions contained in subsidiary specifications, figures and standards, testing shall be performed on components listed in Table III for characteristics noted. Wherever applicable, tests shall be conducted in accordance with FED-STD-191. When the "Results reported as" columns are not indicated, they shall be reported as required by the referenced test method. All test reports shall contain individual values utilized in expressing the final results.

***4.2.2.1 Sampling for testing.** Unless otherwise specified in subsidiary specifications, sampling shall be in accordance with the following. The lot shall be unacceptable if one or more sample units fail to meet any test requirement specified herein.

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

The unit for expressing lot sizes and sample unit for testing each component shall be in accordance with applicable subsidiary specifications and as follows:

<u>Component</u>	<u>Lot sizes expressed as</u>	<u>Sample unit for testing</u>
Cloth, cotton, buckram (collar interlining)	yards	2 yards full width
Padding for collar	yards	1/4 yard full width
Hook and eye	100 each	2 each, hook and eye

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

***4.2.3 Examination of end item.** The end item shall be examined for defects listed in 4.2.3.2 through 4.2.3.5. The sample unit shall be one coat.

***4.2.3.1 Classification of defects.** All defects shall be classified as indicated below, except those with an asterisk (*) in classification column, which shall be classified as follows:

- Major defect - When seriously affecting appearance or serviceability.
- Minor A defect - When affecting appearance or serviceability but not seriously.

Table III. Test Methods

Components	Characteristics	Rqmt. Para.	Test Method	No. Det. Per S/Units	Results reported as:
Cloth, Cotton, buckram (collar inter- lining)	Material Ident. 1/	3.3.4.1	1200	1	Pass or Fail
	Weave (single ply)	3.3.4.2	Visual	1	Pass or Fail
	Yarn count per inch (single ply)	3.3.4.3			
	- warp			3	
	- filling			3	Avg. of the 3 det. in each direction to the whole number
	Resistance to:				
	- wet (dry) cleaning (laminated cloth)	3.3.4.4	5622 <u>2/</u>	1	No evidence of delamination
	- accelerated aging (laminated cloth)	3.3.4.4	5850 <u>3/</u>	1	No evidence of delamination
	- perspiration	3.3.4.4	5680 <u>4/</u>	1	No evidence of delamination
	Stiffness, inch-lb.:				
	- original	3.3.4.4.1	5202 <u>5/</u>	10	Nearest 0.001 lb.
	- after wet (dry) cleaning	3.3.4.4.1	5622 <u>2/</u> & 5205 <u>5/</u>	10	Nearest 0.001 lb.
	- after accelerated aging	3.3.4.4.1	5850 <u>3/</u> & 5202 <u>5/</u>	10	Nearest 0.001 lb.
	- after perspiration	3.3.4.4.1	5680 <u>4/</u> & 5202 <u>5/</u>	10	Nearest 0.001 lb.
	Weight oz. per sq. yd.	3.3.4.4.2	5041	5	Avg. of the 5 det. to nearest 0.1 oz.
	Breaking strength (lbs) (laminated cloth)				Avg. of the 5 det. in each direction
	Original:				
	- warp direction	3.3.4.4.3	5100	5	Avg. of the 5 det. in each direction
	- filling direction	3.3.4.4.3	5100	5	
	After accelerated aging				
	- warp direction	3.3.4.4.3	5850 <u>3/</u> & 5100	5	Avg. of the 5 det. in each direction

Table III. Methods

Components	Characteristics	Rqmt. Para.	Test Method	No. Det. Per S/Units	Results reported as:
Cloth, Ctn., buckram (collar inter- lining)	- filling direction	3.3.4.4.3	5850 3/ & 5100	5	Avg. of the 5 det. in each direction
Padding, Felt (for Collar)	Material Ident. 1/	3.3.6	1200	1	Pass or Fail
	Weight oz. per sq. yd.	3.3.6	5041	5	Avg. of the 5 det. to nearest 0.1 oz.
	Color	3.3.6	Visual	1	Pass or Fail
Hook and eye	Tackiness	3.3.17.	4.3.1.2 1/	1	Pass or Fail

- 1/ A certificate of compliance will be acceptable for this requirement.
- 2/ Except the material shall be subjected to three complete wet cleaning cycles.
- 3/ Except the aging exposure shall be limited to 5 hours at a temperature of 100°
- 4/ Except the material shall be immersed in the specified solution and then air dried.
- 5/ Except that a moment weight of 1 pound shall be used.

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***4.2.3.2 General defects.** General defects shall be classified as follows:

Examine	Defect	Classification	
		Major(*)	Minor A B
Buttonholes (construction)	a. One or more omitted or added.	X	
	b. Wrong type or uncut.		X
	c. Not corresponding to size of button:		
	- too small, not permitting button to enter buttonhole.	X	
	- too large, 3/8 inch or more longer than the diameter of button (measured at inside of purling).		
	d. Buttonhole not securely caught on fabric causing stitching to pull away from fabric.	X	
	e. Bartack missing or loose on:		
	- one buttonhole.		X
	- two or more buttonholes.	X	
	f. Bartack misplaced not serving intended purpose on:		
	- one buttonhole.		X
	- two or more buttonholes.		X
	g. One or more broken stitches in:		
	- one buttonhole.		X
	- two or more buttonholes.	X	
	h. More than 2 skipped stitches in:		
	- one buttonhole.		X
	- two or more buttonholes.		X
	i. Ragged edges, affecting appearance.		X
	j. Gimp omitted in one or more buttonholes.		X
	k. Stitches per buttonhole (not including bartack) less than the minimum specified:		
	- one or two stitches.		X
	- three or more stitches.		X
	l. One or more buttonholes finished with purling on the underside.	X	

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
Button or ring toggles	m. Ends of gimp not pulled through to the underside on one or more buttonholes.		X
	a. Missing, loose, broken, or defective: - 1 button or ring toggle. - 2 or more buttons or 2 or more ring toggles.	X	X
	b. Not specified type, size, color or finish.		X
	c. One or more buttons on right front sewn with the head of the eagle in other than up-right position.		X
NOTE: Buttons shall be considered defective if they have sharp, rough or cracked edges; scratches, blemished or imbedded foreign matter on face side of button, loose shanks; or badly shaded.			
Cleanness	a. One or more removable spots or stains clearly noticeable outside of coat.		X
	b. One or more removable spots or stains clearly noticeable, inside of coat.		X
	c. One or more spots or stains of an obvious permanent nature.	*	
	d. Thread ends not trimmed, loose thread ends, 2 or more shade markings, or bastings not removed throughout garment (to be scored when the condition exists on major portion of coat).		X
Components and assembly	a. Any defective component or defect of assembly (not herein classified).	*	
	b. Any component part or required operation omitted (not herein classified).	*	

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
Cutting	a. Any component part of basic wool material not cut in accordance with directional lines on patterns, or in accordance with specification requirements.	X	
	b. Piping or binding material cut on the bias.		X
	c. Any lining part not cut in accordance with directional lines on patterns.		X
Eyelets (construction)	a. One or more omitted or added.	X	
	b. Wrong type.		X
	c. Eyelet not securely caught on fabric, causing stitching to pull away from fabric.	X	
	d. Diameter of inside opening less than 1/8 inch or more than 1/4 inch.		X
	e. One or more eyelets uncut.		X
	f. One or more broken stitches in: - one eyelet. - two or more eyelets.		X
	g. More than two skipped stitches in one or more eyelets.		X
	h. One or more eyelets finished with the purling on the underside.	X	
Hooks and eyes	a. One hook or eye omitted.		X
	b. Two or more hooks or eyes omitted.	X	
	c. Not specified type or size.		X
	d. Not aligned, causing collar ends to be uneven by 1/4 inch or more when front is buttoned and hooks and eyes are fastened.		X

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Examine	Defect	Classification	
		Major (*)	Minor A B
Material defects and damages	e. Hook or eye not securely tacked to ends of collar.		X
	f. Hooks or eyes misplaced, i.e., hooks positioned on left end eyes positioned on right end of collar.		X
	a. Any weakening defect such as smash, multiple float, loose slub, etc., that may develop into a hole.	*	
	b. Any hole (including drill holes).	*	
	c. Shade bar, unsightly slubs, etc: - on outside. - on inside.	*	X
	d. Needle chews which may develop into a hole.	*	
	e. Scissors or knife cut, tear, mend or burn.	*	

NOTE: Material defects and workmanship damages are to be classified as indicated above only when the condition is one which definitely weakens the fabric or when it is so conspicuously located as to be clearly noticeable. Weakening or nonweakening conditions which are inconspicuous and have negligible effect on serviceability are to be classified as follows:

	Material defect Workmanship damages	No defect Minor B defect
Pressing	a. Burned or scorched.	*
	b. Pressing omitted (entire garment).	X
	c. Poorly pressed (unless otherwise classified).	X
	d. Armhole stretched, affecting appearance.	X
	e. Basting or pressing impressions not removed on major portion of coat.	X

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
	f. Gloss not removed throughout coat, affecting appearance.		X
	g. Armholes not blocked or blocked poorly.	X	
	h. Inside of armholes not pressed solid.	X	
	i. Edges bulky, i.e., not pressed solid, affecting appearance.		X
	j. Sleeves not creased as required on forearm and backarm seam.		X
	k. Armhole sleeve seam not pressed open from backarm seam of sleeve and across top as specified.	X	
	l. Linings not pressed smooth.		X
Seams and stitching	a. Accuracy of seaming:		
	1. Any seam twisted, puckered, or pleated, affecting appearance.	X	
	2. Part of garment caught in any unrelated operation or stitching	*	
	3. Unsightly hand felling or blind-stitching exposed on outside of coat, affecting appearance.	X	
	4. Ends of all stitching (when not caught in other seams or stitching) not backtacked or backstitched as required.		X
	5. Wrong color of thread used on outside of coat, affecting appearance.	*	
	b. Gage of stitching (edge or raised stitching).		
	1. Irregular, i.e., unevenly gaged, or various stitchings not uniform, affecting appearance.		X

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
	2. Beyond range of width specified or varies more than 1/16 inch when no range is specified.		X
	c. Open seams		
	1. On outside:		
	- up to 1/4 inch inclusive.		X
	- more than 1/4 inch but not more than 1/2 inch.		X
	- more than 1/2 inch.	X	
	2. On inside:		
	- more than 1/2 inch (except machine felling).		X
	- up to 1/2 inch inclusive (except machine felling)		X
	- up to 1 inch inclusive (machine felling).		X
	- more than 1 inch (machine felling).		X

NOTE: One or more broken stitches or two or more continuous skipped or run-off stitches constitute an open seam.

d. Raw edges

1. On outside:		
- up to 1/8 inclusive.		X
- more than 1/8 inch but not more than 1/4 inch.		X
- more than 1/4 inch.	X	
2. On inside:		
- more than 1/8 inch but not more than 1/4 inch.		X
- more than 1/4 inch.	X	

NOTE: Raw edges shall be classified as such when they occur at places where an edge is required to be turned under. Raw edges not caught in stitching shall be classified as an open seam.

e. Run-offs (see classification of open seams).

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
	f. Stitch tension:		
	1. Loose tension resulting in loose seam.	X	
	2. Loose tension on raised or edge stitching, resulting in loosely exposed bobbin or top thread.		X
	3. Tight tension (stitches break when normal strain is applied).	X	
NOTE: Puckering is evidence of tight tension. When puckering is evident, the inspector shall test by exerting pull in lengthwise direction of seam.			
	g. Stitches per inch (excluding labels)		
	Less than minimum specified:		
	- one or more stitches.		X
	- three stitches.		X
	- four stitches or more.	X	
NOTE: To be scored only if condition exists on major portion of seam.			
	h. Wrong stitch or seam type.		X
	i. Stitching skipped or broken (on edge or raised stitching when seam is seamed, turned and stitched):		
	- 1/4 inch or more but not more than 1/2 inch.		X
	- more than 1/2 inch.		X
Shaded parts	a. On outside.		*
	b. On inside		
	1. Any lining part badly shaded (except sleeve lining).		X
	2. Any lining part badly shaded or pairs not matching each other.		X

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***4.2.3.3 Detailed defects (outside of coat).** Detailed defects on outside of coat with coat buttoned on form shall be classified as follows:

Examine	Defect	Classification	
		Major (*)	Minor
		A	B
Collar (construction and setting)	a. Interlining omitted.	X	
	b. Interlining tight or twisted, causing puckers on collar, affecting appearance.		X
	c. Tight at joining to front or back, causing puckers or pleats at neck of coat, affecting appearance.	*	
	d. Piping irregular, affecting appearance.		X
	e. Collar ends overlapping when fastened.		X
	f. Collar ends spread open more than 3/8 inch when fastened.		X
	g. One ply of outer basic material.	X	
	h. Binding strip at top or bottom edge of interlining omitted.		X
	i. Binding strip at top or bottom edge of interlining other than material specified.		X
	j. Center of eyelets from finished ends of collar:		
	- less than 1-3/8 inches but not less than 1-1/4 inches.		X
	- more than 1-5/8 inches but not more than 1-3/4 inches.		X
	- less than 1-1/4 inches or more than 1-3/4 inches.		X
	k. One or both eyelets off-center with top and bottom edges of collar by more than 1/4 inch.		X
	l. Collar off-center by more than 3/8 inch.		X

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
	m. Binding strip at top edge of interlining positioned more than 1/8 inch beyond top edge of piping on outer ply of collar.		X
	n. Binding strip at top edge of interlining irregular in width affecting appearance or not exposed beyond top edge on outer ply of collar.		X
	o. Collar irregular in width by 1/4 inch or more.	X	
	p. Front finished ends of collar uneven in width by 3/16 inch or more.	X	
Alignment of front buttons and button-hole	Not aligned, causing a noticeable bulge or twist on fronts when buttoned, affecting appearance.		X
Length of buttoned fronts	a. Left front at corner shorter than right front at bottom by: - more than 1/8 inch but not more than 1/4 inch. - more than 1/4 inch.	X	X
	b. Left front at corner longer than right front by: - more than 1/4 inch but not more than 3/8 inch. - more than 3/8 inch.		X
	c. Right front at corner exposed beyond bottom edge of left front by more than 1/8 inch.		X

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
Shoulder (construction)	Improperly joined or set, causing shoulders or back to twist.	*	
Shoulder pads	a. Not completely caught in armhole tacking.		X
	b. Misplaced, not serving in- tended purpose, i.e., too far back or too far forward.		X
	c. One or both pads omitted.		X
Shoulder straps (construction and setting)	a. Misplaced, i.e., one strap further forward or back from position of other loop, affect- ing appearance.		X
	b. Misplaced, so that it will not lie flat when buttoned, causing bulge or twist on strap.	*	
	c. Poorly shaped.		X
	d. Shoulder seam exposed beyond back edge of shoulder strap (except rounded end).		X
	e. Width of shoulder strap at armhole seam (including piping):		
	- less than 2-1/4 inches but not less than 2-1/8 inches		X
	- more than 2-1/2 inches but not more than 2-5/8 inches.		X
	- less than 2-1/8 inches or more than 2-5/8 inches.		X
	f. Width of shoulder strap across the buttonhole eyelet end (including piping):		
	- less than 1-5/8 inches but not less than 1-1/2 inches.		X
	- more than 1-3/8 inches but not more than 2 inches.		X
	- less than 1-1/2 inches or more than 2 inches.		X

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
Shoulder strap buttonhole and button	g. Rounded end of shoulder strap positioned less than 1/4 inch or more than 3/8 inch from collar edge.		X
	h. Piping irregular in width, affecting appearance.	X	
	i. Upperside of strap full or twisted, affecting appearance.		X
	j. Back edge of strap less than 1/4 inch or more than 1/2 inch from shoulder seam at armhole.		X
	a. Button not aligned with buttonhole, causing a bulge or twist on strap or puckers on shoulder, affecting appearance.	X	
	b. Buttons not uniformly set by more than 1/4 inch.	X	
	c. Buttonhole 1/4 inch or more off center.	X	
	d. Buttonhole from outer edge of piping at the collar end of strap: - less than 5/8 inch but not less than 1/2 inch or more than 3/4 inch. - less than 1/2 inch.	X	X
	a. Badly stretched, affecting appearance.	*	
	b. Taped too tight, causing puckering around armhole seam, affecting appearance.	*	
Armholes (construction)	c. Crooked seam, affecting appearance.	X	
	d. Tape stitching exposed and visible to outside surface.		X

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
Sleeves	e. Sleeve head pads not completely tacked to armholes, or misplaced, not serving intended purpose.		X
	f. One or both sleeve head pads omitted.		X
	a. Setting and hang:		
	1. Sleeve fullness misplaced, affecting appearance.		X
	2. Backarm seam of sleeve not matching side back seam by: - more than 1/4 inch but not more than 1/2 inch. - more than 1/2 inch.	X	X
	3. Hang of sleeves on the same coat in opposite direction by more than 2 inches.		X
	4. Sleeve tight in armhole, i.e., roll effect not present.		X
	b. Sleeve lining:		
	1. Twisted, tight, or short, causing bulge, twist or puckering on outside of sleeves.		*
	2. Sleeve lining too long, causing lining to sag at bottom more than 1/2 inch.		X
	3. Sleeve lining seams out of alignment more than 3/4 inch with sleeve seams at armhole or at bottom of sleeves.		X
	4. Cut dart on lining under-sleeve omitted.		X
	5. One or both lining darts not pressed flat.		X

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
	c. Construction of sleeves:		
	1. Wigan twisted, tight or pleated, causing ridges or puckering on outside of bottom of sleeves, affecting appearance.		X
	2. Tacking on bottom turnup to wigan omitted or insecure.		X
	3. Sleeve bottom edge uneven by more than 1/4 inch.		X
	4. Tacking on 1 or both sleeve lining seams to sleeve seams omitted, or insecure.		X
	5. Bottom edge of sleeve lining turnup less than 1 inch or more than 1-1/2 inches up from bottom edge of sleeve.		X
	6. Cut dart on wool under-sleeve omitted.	X	
	7. One or both wool sleeve darts not pressed open, smooth and flat.		X
	d. Ornamental sleeve pieces:		
	1. Piping irregular, affecting appearance.		X
	2. Ornamental piece stitched to sleeve too full or twisted, affecting appearance.		X
	3. Length of ornamental piece (including piping):		
	- less than 5-7/8 inches but not less than 5-5/8 inches.		X
	- more than 6-1/8 inches but not more than 6-3/8 inches.		X

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
	- less than 5-5/8 inches or more than 6-3/8 inches.	X	
	4. Width at top and bottom points (including piping):		
	- less than 2-3/8 inches but not less than 2-1/8 inches.		X
	- more than 2-5/8 inches but not more than 2-7/8 inches.		X
	- less than 2-1/8 inches or more than 2-7/8 inches.	X	
	5. Width at center point (including piping):		
	- less than 2-5/8 inches but not less than 2-3/8 inches.		X
	- more than 2-7/8 inches but not more than 3-1/8 inches.		X
	- less than 2-3/8 inches or more than 3-1/8 inches.	X	
	6. Poorly shaped, affecting appearance.	X	
	7. Set on crookedly, affecting appearance.	X	
	8. Misplaced, i.e., one piece further forward or back from position of other piece, affecting appearance.	X	
	9. Bottom edge not horizontal with bottom edge of sleeve by more than 1/8 inch.	X	
	10. Ornamental piece stitched to sleeve with pointed ends toward forearm seam of sleeve.	X	
e.	Position of buttons on ornamental pieces (measurements made from center button):		

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
	1. Front top and bottom edges: (including piped edges):		
	- less than 3/4 inch but not less than 1/2 inch.		X
	- more than 1 inch but not more than 1-1/4 inches.		X
	- less than 1/2 inch or more than 1-1/4 inches.	X	
	2. Top or bottom button from scalloped edge including piped edge:		
	- less than 5/8 inch but not less than 3/8 inch.		X
	- more than 7/8 inch but not more than 1-1/8 inches.		X
	- less than 3/8 inch or more than 1-1/8 inches.	X	
	3. Center button from pointed edge (including piped edge):		
	- less than 7/8 inch but not less than 5/8 inch.		X
	- more than 1-1/8 inches but not more than 1-3/8 inches.		X
	- less than 5/8 inch or more than 1-3/8 inches.	X	
	4. Center button not in line with pointed edge by more than 1/4 inch.	X	
Body (outside)	a. Fitting of body linings tight, short, or twisted, causing fullness or twist on outside of coat, affecting appearance.	*	
	b. Fitting of front interlining:		
	1. Tight, short or twisted, causing fullness or twist on outside of coat, affecting appearance.	*	
	2. Too full, causing coat front to have a wavy appearance.	*	

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
Chest darts	a. One or both omitted.	X	
	b. End on one or both darts not properly tapered, causing bulge or fullness, affecting appearance.		X
	c. Equal length of darts not uniform by 1/4 inch or more.		X
	d. Cut edges of dart not turned towards the armhole.		X
	e. Not pressed smooth and flat.		X
Waist darts	a. One or both omitted.	X	
	b. Top or lower end on one or both darts not properly tapered, causing bulge or fullness, affecting appearance.		X
	c. Equal length of darts not uniform by 1/4 inch or more.		X
	d. Alignment of both waist darts: - top or bottom end out of horizontal alignment by 1/4 inch or more.		X
	e. Folded edge not pressed towards side seam.		X
	f. Not pressed smooth and flat.		X
	g. Top or lower end on one or both darts not securely backstitched.		X
Front and bottom edges	a. Front edges stretched, affecting appearance.		X
	b. Piping set on tight, causing puckering on front, affecting appearance.		X
	c. Front or bottom piping irregular, affecting appearance.		X

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
	d. Bottom edge stretched, puckered or uneven, affecting appearance.		X
	e. Bottom corner of left front poorly shaped, affecting appearance.		X
	f. Left front rolling outward below bottom button.	*	
	g. Front edge irregular, affecting appearance.		X
	h. Piping tight on bottom edge, causing puckering outside of coat, affecting appearance.		X
	i. Left front not dressed as specified.		X
Front facing	Short, tight or twisted, causing fullness or twists on fronts affecting appearance.	*	
Back side panel seams	Curved panel seam on back of coat stretched or distorted, affecting appearance.		X
Belt loops (construction and position)	a. Poorly shaped or not of uniform shape, affecting appearance.		X
	b. Bottom end of one or both loops out of horizontal alignment with bottom front buttonhole by: - more than 3/4 inch below or more than 3/8 inch above.		X
	c. Pointed end on one or both loops not towards the top end of coat.		X
	d. One or both not stitched on the side seam.		X
	e. One or both not vertically straight, i.e., on an angle, affecting appearance.		X

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
Belt loop buttonhole and button(position and button attachment)	f. Alignment of both loops: - Top or bottom end cut out of horizontal alignment by more than 1/4 inch.	X	
	g. One or more edges not properly forced out, i.e., having a fold or lip of 1/8 inch or more.		X
	h. Bottom of loop not centered on side seam by more than 1/4 inch.	X	
	a. Button not aligned with button-hole, causing a bulge or twist on strap or puckers on coat, affecting appearance.	X	
	b. Buttons not uniformly set by more than 1/4 inch.		X
Openings cut for belt loop buttons	c. Buttonhole 1/4 inch or more off center.	X	
	d. Buttonhole less than 1/2 inch or more than 3/4 inch from pointed end of loop;		X
	e. Reinforcement disc beneath one or both buttons omitted.		X
	a. One or both omitted.	X	
	b. Opening not constructed vertically.		X
	c. One or more ends on one or both openings not securely tacked.		X
	d. Opening constructed through body lining.	X	
	e. Misplaced, i.e., more than 1/4 inch from marks indicated by patterns or not positioned on side seam.		X

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Examine	Defect	Classification	
		Major (*)	Minor A B
Front buttonholes (position)	a. Position from front edge, including piped edge: - less than 1/2 inch but not less than 3/8 inch or more than 3/4 inch but not more than 7/8 inch. - less than 3/8 inch or more than 7/8 inch.		X
		X	
	b. More than 1/4 inch from equal spacing.	X	
	c. Top or bottom buttonhole positioned more than 1/2 inch from pattern marks.	X	
Front eyelets (position)	d. Unevenly spaced from front edge by more than 3/16 inch.	X	
	a. Center of top eyelet not in vertical alignment with right end of collar by 1/4 inch or more.	X	
	b. Lower eyelets not in vertical alignment with top eyelet by 1/4 inch or more.	X	
Front buttons (position)	c. More than 1/4 inch from equal spacing.	X	
	Out of vertical alignment by 1/4 inch or more.	X	

*4.2.3.4 Detailed defects (inside of coat). Detailed defects on inside of coat shall be classified as follows:

Examine	Defect	Classification	
		Major (*)	Minor A B
Right front eyelet cover	a. Front raw edges not stitched together prior to seaming to right facing.		X
	b. Upper or lower seamed edge not hand felled to facing.		X

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
	c. Upper or lower seam edge not securely hand stitched to facing.		X
	d. Omitted.	X	
	e. Front corner of eyelet cover exposed beyond upper edge of right front.		X
	f. Front edge of cover positioned less than 1/4 inch or more than 3/4 inch in from front edge of right front.		X
Labels	a. Any required label missing, incorrect, illegible, or size label not securely caught in stitching.	X	
	b. Identification label not stitched on 4 sides.		X
	c. Bottom edge of identification label less than 3 inches or more than 5 inches from bottom finished edge of coat.		X
	d. Identification label not stitched to outside of right facing.		X
Hanger	a. Hanger omitted or ends not securely stitched.	X	
	b. Less than 1-7/8 inches or more than 2-1/8 inches long measured along the lower edge of collar lining.		X
	c. Hanger not stitched to neck of coat prior to seaming collar to neck of coat.		X

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
Front facings	d. Finished width less than 1/4 inch or more than 3/8 inch wide.		X
	a. Fullness or pleats on facings between eyelets, buttonholes, or between front edge and eyelets or buttonholes.		X
	b. Tacking on back edge to 1 or both interlinings: - omitted.		X
	- insecure or incomplete for a distance of more than 4-1/2 inches below shoulder seams, or more than 4 inches above bottom edge of coat.		X
	c. Felling at bottom edge of front facing or back edge of facing omitted or insecure on one or both facings.		X
Body linings	d. Felling along folded edge of one or both facings at collar notch omitted or insecure.		X
	a. Excessive puckering or pleating.		X
	b. Twisted, not affecting smoothness on outside of coat.		X
	c. One or both chest pleats on shoulders omitted.	X	
	d. Folded edge of 1 or both chest pleats facing front edge of coat.		X
	e. Pleat omitted at center of back lining.	X	
	f. Pleat less than 1/2 inch in depth at center of back lining.		X

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
	g. Bottom hem less than 5/8 inch or more than 7/8 inch wide.		X
	h. Lining too long, i.e., exposed beyond bottom edge of coat.	X	
	i. Facing-lining seam, side seams and side back seams not towards back or not pressed smooth and flat.	X	
	j. Waist darts not towards the side seam or not pressed smooth and flat.	X	
Lining-securing straps	a. One or both omitted or insecure.	X	
	b. Less than 1/4 inch or more than 3/8 inch wide.		X
	c. One or both positioned more than 1 inch from side seam.		X
	d. End on one or both straps not finished between the piping at bottom edge of coat and side seam allowance.		X
	e. One or both not folded and stitched across width.		X
	f. One or both not properly attached to lining hem or coat, causing twist or distortion to either the lining or coat.	X	
	g. One or both exposed beyond bottom edge of coat.	X	
Serge or overedge stitching (basic material)	Omitted where specified on one or more raw edges for seams joining fronts and back.		X

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
Serge or overedge stitching (lining joined seams)	Omitted where specified on one or more seams.	X	
Underarm shields	a. One or both omitted.	X	
	b. Not two-piece lining construction.	X	
	c. Tacking on one or both shields along side or bottom edge to body omitted or insecure.		X
	d. Top edge not caught in armhole tacking or stitching when tacked by hand.		X
	e. Puckered, pleated, or twisted.		X
	f. One or both shields misplaced, not serving intended purpose.		X
Inside of armhole	Backstitching at armpit of armhole from back arm seam of sleeve to front edge of shield omitted.		X
Collar lining extension piece	a. Omitted.	X	
	b. Extending less than 1/2 inch or more than 1 inch beyond left end of collar.		X
	c. Felling omitted or insecure at end or top edges.		X
	d. Stitching at top, front and bottom edges or across width of collar tab (forming box stitch) omitted.		X
Collar lining and eyelet covers	a. Ends of collar lining not securely tacked.		X

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Examine	Defect	Classification	
		Major (*)	Minor
		A	B
	b. One or both eyelet covers omitted.	X	
	c. One or both eyelet covers not covering eyelet.	X	
	d. Width of collar eyelet less than 1-5/8 inches or more than 1-7/8 inches.		X
	e. Felling on front edge and along lower corner of one or both eyelet covers omitted.	X	
	f. Felling along lower corner of one or both eyelet covers extending for a distance of more than 3/4 inch.		X
	g. Top or bottom hook positioned less than 1/4 inch from top or bottom edges respectively of collar.		X
	h. Middle hook not positioned midway between top and bottom hook.		X

***4.2.3.5 Finished measurements.** Any measurement deviating from the nominal dimension and tolerance specified in Table II shall be classified as a size measurement defect. Sleeve lengths uneven by more than 1/2 inch shall be classified as a size measurement defect.

***4.2.3.6 Inspection levels and AQL's.** Inspection levels and AQL's expressed in defects per 100 units (DHU) shall be as follows:

4.2.3.2 through 4.2.3.4

Inspection Level II of MIL-STD-105

AQL's	Major	1.5 DHU
	Major & Minor A (combined)	10.0 DHU
	Total Major, Minor A and Minor B (combined)	40.0 DHU

4.2.3.5

Inspection Level S-3 of MIL-STD-105

One class	4.0 DHU
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*4.2.4 Examination of preparation for delivery requirements. An examination shall be made to determine compliance with packaging, packing and marking requirements of Section 5 of this specification. Defects shall be scored in accordance with the list below. The sample unit shall be on shipping container fully prepared for delivery with the exception that it need not be sealed. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot size shall be the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 and the AQL shall be 4.0 DHU.

Examine

Marking (exterior and interior)

Defect

Omitted, incorrect, illegible, of improper size, location, sequence, or method of application.

Materials

Any component missing or damaged

Workmanship

Inadequate application of components, such as incomplete closure of case liners, container flaps, loose strapping, inadequate stapling. Bulging or distortion of containers.

Content

Number of coats per container is more or less than required.

*4.3 Tests.

*4.3.1 Metal composition. Chemical composition shall be determined in accordance with test method III of FED-STD-151.

*4.3.2 Test for tackiness. At room temperature (60° to 80°F) press a piece of tissue paper against the lacquered surface for 30 seconds, using any pressure capable of being exerted by the thumb and two fingers. The tissue shall not adhere to the lacquered surface, but shall fall free when pressure is released.

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5. PREPARATION FOR DELIVERY

* **5.1 Packaging and packing.** Unless otherwise specified (see 6.2), the coats shall be packaged in accordance with good commercial practice and packed in a manner to insure carrier acceptance and safe delivery at destination. Not less than 8 ounces of naphthalene, conforming to class B of R-N-91, or equal, shall be uniformly distributed throughout the entire contents of shipping container. Containers shall be in accordance with Uniform Freight Classification Rules or regulations of other carriers applicable to the mode of transportation.

5.2 Marking. In addition to any special marking required by the contract or order, the shipping containers shall be marked in accordance with the requirements of MIL-STD-129.

6. NOTES

* **6.1 Intended use.** The coat described herein is intended for wear by enlisted male personnel of the U.S. Marine Corps Drum and Bugle Corps.

* **6.2 Ordering data.** Purchasers should exercise any desired options offered herein, and procurement documents should specify the following:

* **6.2.1 Procurement requirements.**

- (a) Title, number and date of this specification.
- (b) Sizes required (see 1.2).
- (c) Whether first article is required (see 3.2).
- (d) Number of coats in first article (see 3.2).
- (e) When coats shall not be packaged and packed in accordance with commercial practice (see 5.1).

* **6.2.2 Contract data requirements.** Data conforming to Data Item Descriptions DI-R-4803, DI-R-4805, DI-T-4901, DI-T-4902, DI-T-4903 and DI-T-4904 will usually be required for delivery in connection with this specification. When so required, such data will be specified for delivery on a DD Form 1423 included in the contract.

6.3 Samples and shade samples. For information regarding availability of sample coats and standard shades specified, address inquiry to the procuring activity issuing the invitation for bids.

* **6.4 First article.** First article examination, test and approval shall be as specified by the contracting officer (see 3.2).

* **6.5 Moth repellent.** The moth repellent requirement (see 5.1) is not applicable when coats are made of moth repellent treated cloth.

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

Preparing activity:
Navy - MC
Project No. 8405-N549

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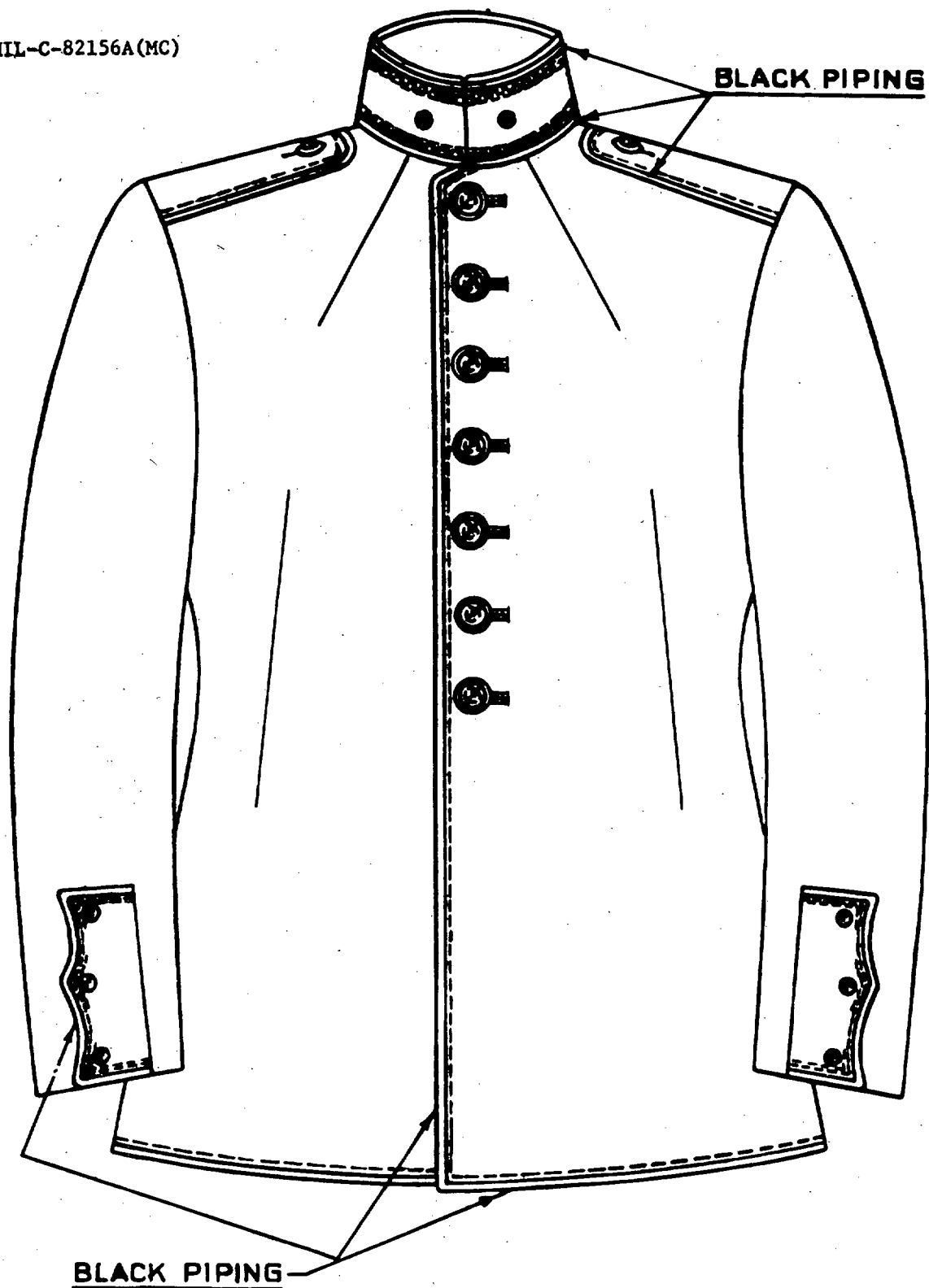


FIG.1. COAT, MAN'S: SCARLET,
DRUM AND BUGLE CORPS, MUSICIANS

90

M.C.S.A.
826:R.G.F.
28 Dec '73

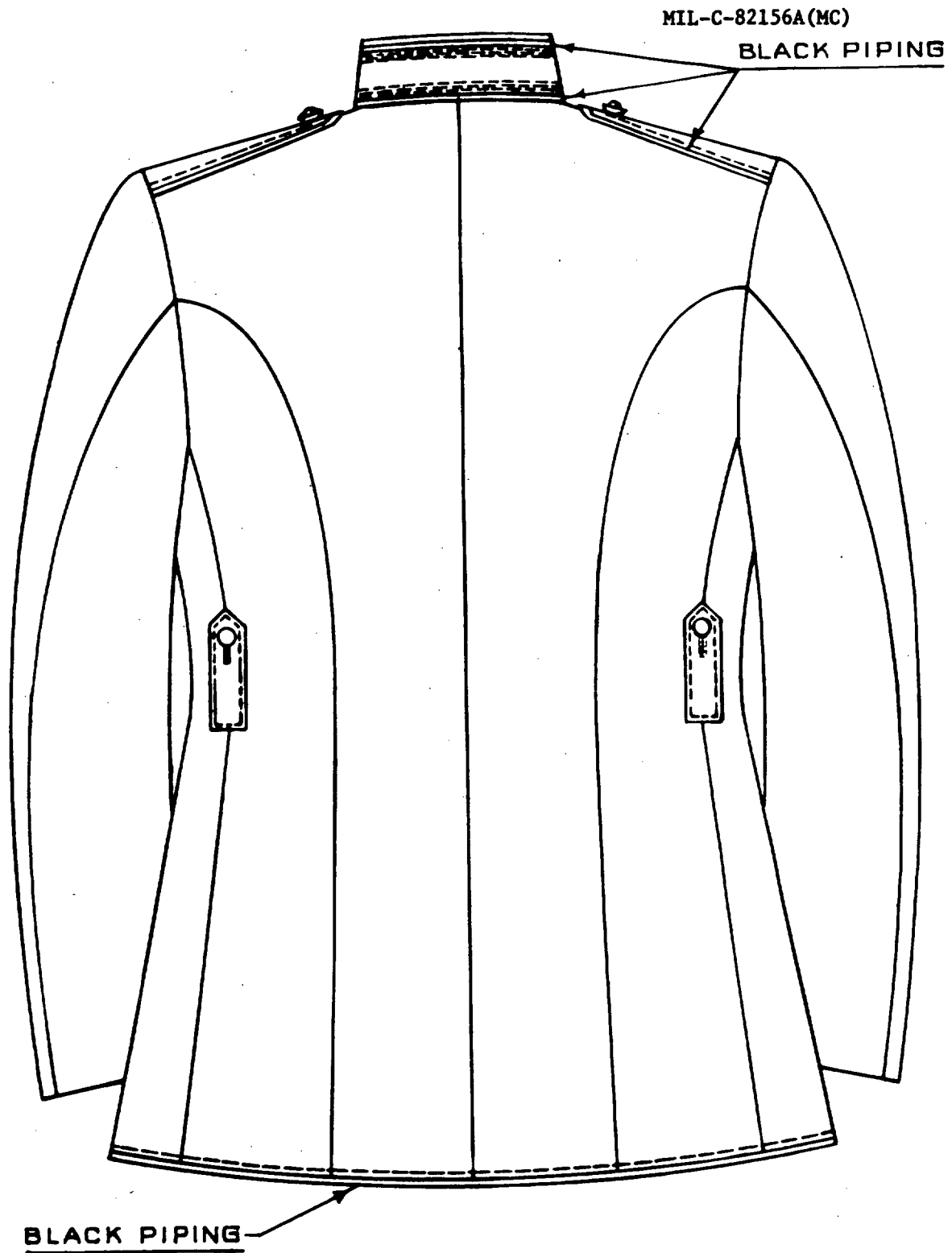
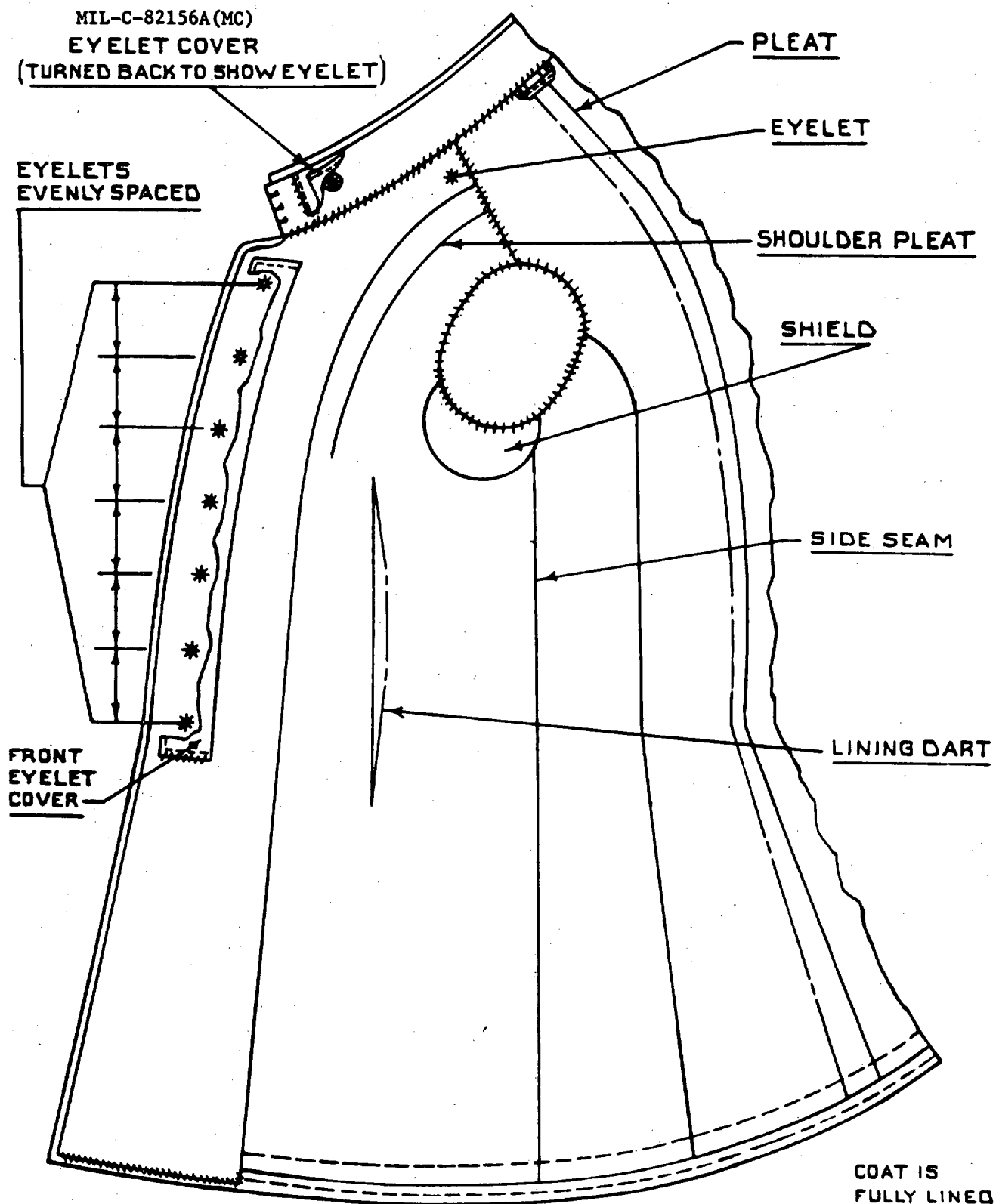
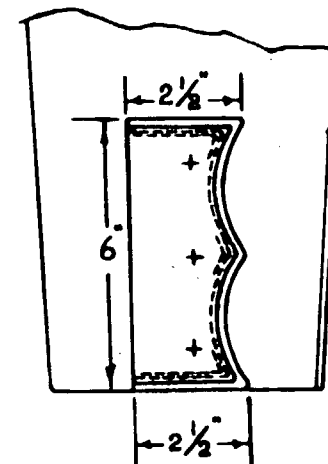
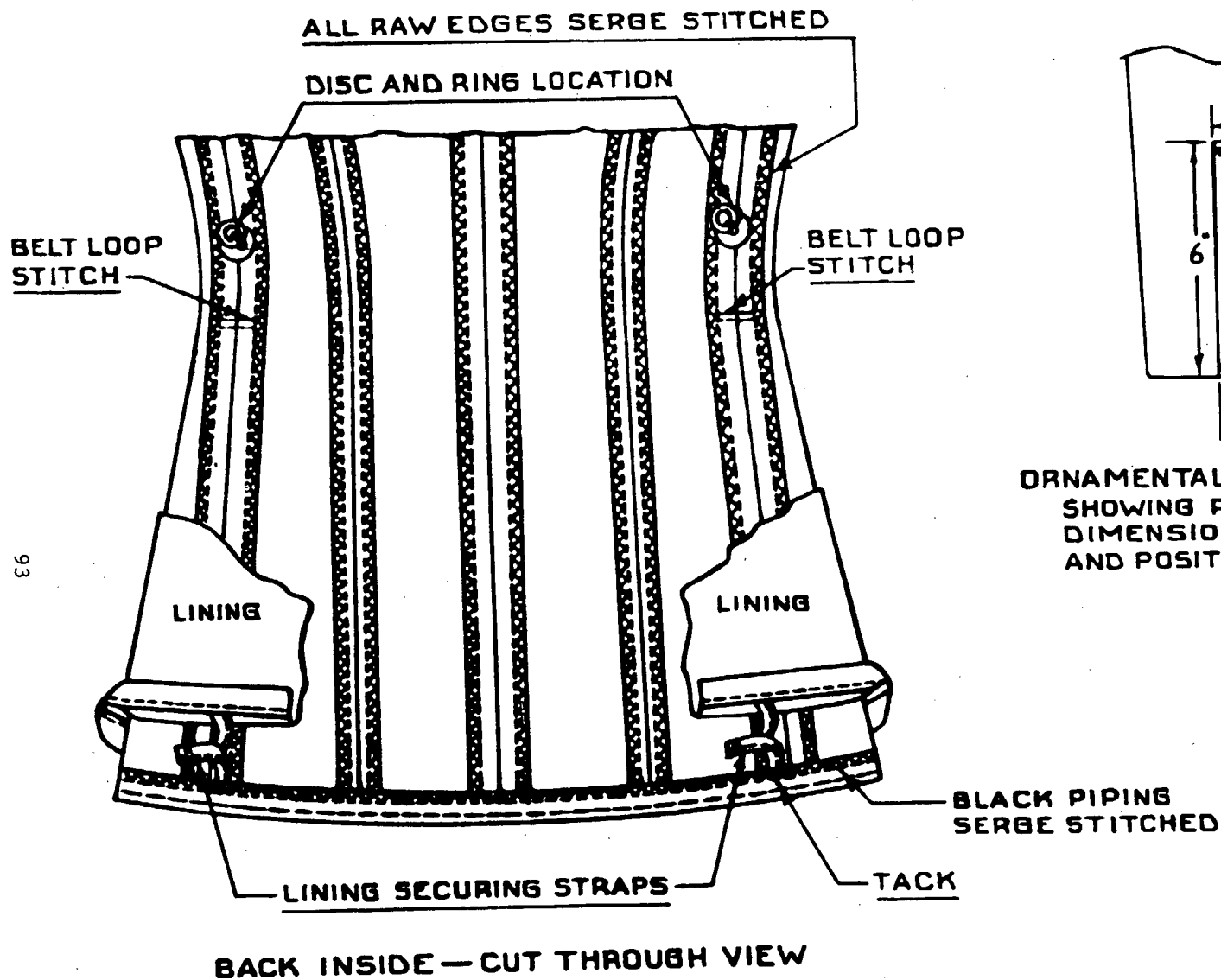


FIG.2. COAT; MAN'S: SCARLET,
DRUM AND BUGLE CORPS; MUSICIANS



RIGHT-INSIDE VIEW

FIG.3. COAT, MAN'S: SCARLET,
DRUM AND BUGLE CORPS; MUSICIANS



ORNAMENTAL SLEEVE PATCH
SHOWING POSITION AND
DIMENSIONS OF PATCH
AND POSITION OF EYELETS

FIG.4.COAT, MAN'S: SCARLET,
DRUM AND BUGLE CORPS; MUSICIANS

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28 Dec '73

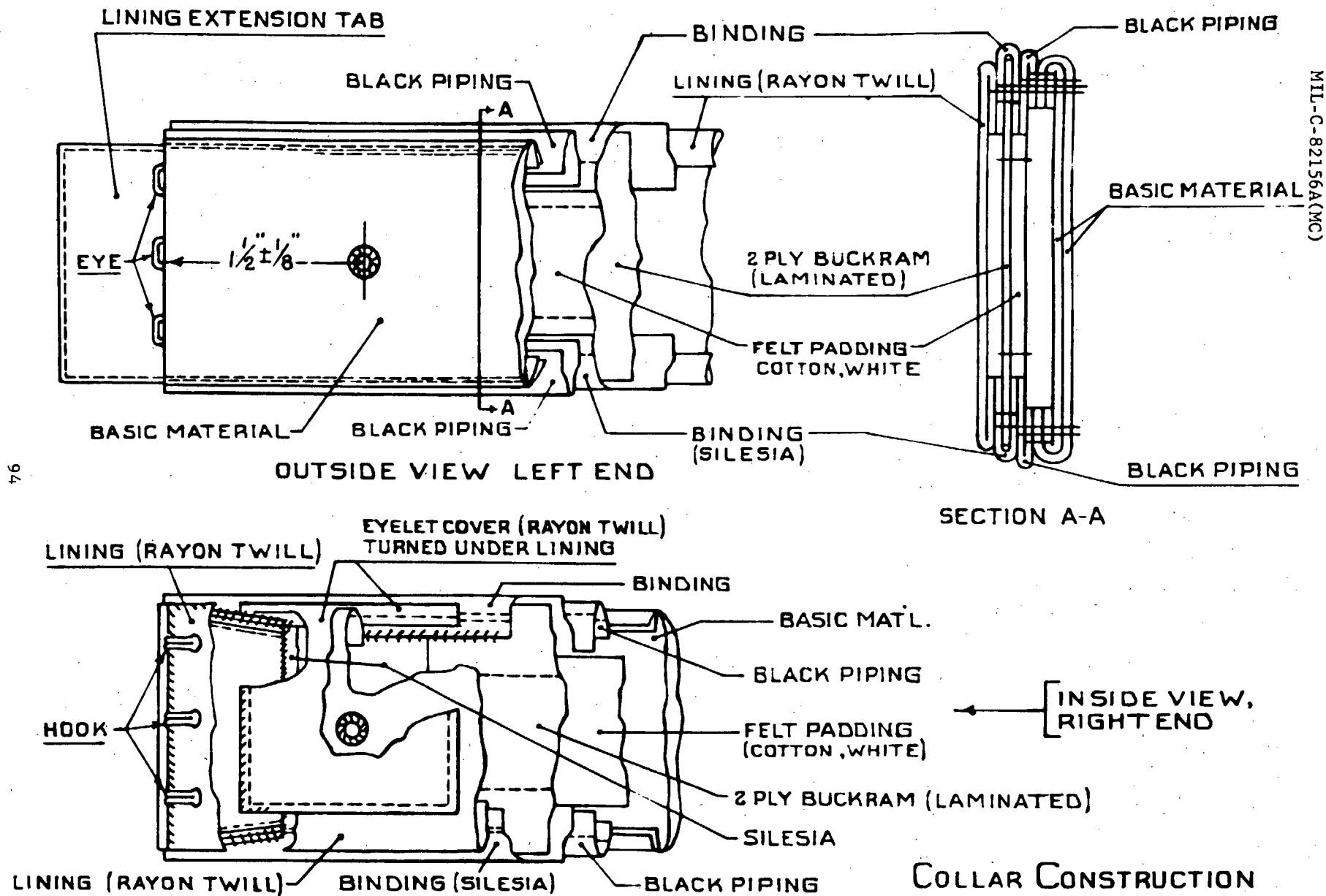


FIG.5.COAT,MAN'S: SCARLET,
DRUM AND BUGLE CORPS; MUSICIANS

POSTAGE AND FEES PAID

DoD-317



FFICIAL BUSINESS
TY FOR PRIVATE USE \$300

Commanding General (826)
Marine Corps Supply Activity
1100 South Broad Street
Philadelphia, Pennsylvania 19146
