

INCH-POUND

MIL-C-82172B(MC)
 19 JULY 1990

 SUPERSEDING
 MIL-C-82172A(MC)
 2 May 1974

MILITARY SPECIFICATION

COAT, MAN'S: SUMMER AND WINTER, SCARLET,
 DRUM AND BUGLE CORPS, DRUM MAJOR

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

1. SCOPE

1.1 Scope. This specification covers requirements for 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	40
35	41
36	42
37	44
38	46
39	

<p>Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to the Commanding General (PSE-C), Marine Corps Research, Development, and Acquisition Command, Washington, DC 20380, by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.</p>

AMSC N/A

FSC 8405

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1.3 Individual orders. When the coat is custom tailored to an individual order, this specification shall govern, except that the detailed requirements of section 3, table I, may be modified to the extent necessary for good custom tailoring practice.

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specification, standards, and handbooks. The following specifications, standard, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issue of these documents are those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto cited in the solicitation.

SPECIFICATIONS

FEDERAL

V-T-276	- Thread, Cotton
V-T-280	- Thread, Gimp, Cotton, Buttonhole.
V-T-301	- Thread, Silk.
DDD-L-20	- Label; For Clothing, Equipage, and Tentage, (General Use).
DDD-T-86	- Tape, Textile; Cotton, General Purpose (Unbleached, Bleached, Or Dyed).

MILITARY

MIL-C-368	- Cloth, Satin, Rayon and Cloth, Twill, Rayon.
MIL-B-3461	- Button, Insignia, Metal, Uniform and Cap.
MIL-P-15064	- Pads, Shoulder and Sleeve-Head.
MIL-C-16375	- Cloth, Wigan, Cotton.
MIL-C-21115	- Cloth, Tropical: Wool, Polyester/Wool.
MIL-C-43718	- Cloth, Polyester; Polyester and Cotton; Polyester and Rayon, For Pockets.
MIL-C-82114	- Coat Front: For Coats, Musicians.

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STANDARDS

FEDERAL

- FED-STD-151 - Metals: Test Method.
- FED-STD-191 - Textile Test Methods.
- FED-STD-751 - Stitches, Seams, and Stitchings.

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- MIL-STD-105 - Sampling Procedures and Tables For Inspection By Attributes.
- MIL-STD-129 - Marking For Shipment and Storage.

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

2.1.2 Other Government documents, drawings, and publications. The following other Government publication forms a part of this document to the extent specified herein. Unless otherwise specified, the issue is that cited in the solicitation.

LAWS AND REGULATIONS

U.S. POSTAL SERVICE MANUAL

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

2.2 Non-Government publications. The following document form a part of this document to the extent specified herein. Unless otherwise specified, the issue of the document which is DoD adopted is that listed in the issue of the DODISS cited in the solicitation. Unless otherwise specified, the issue of the document not listed in the DODISS is the issue of the document cited in the solicitation.

UNIFORM CLASSIFICATION COMMITTEE

Uniform Freight Classification Rules

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

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Department of Defense (DOD) Standard Color Card of Official
Standardized Shades of Sewing Thread 1968

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

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

3. REQUIREMENTS

3.1 Standard samples. Standard samples are furnished solely for guidance and information to the contractor (see 6.4). Variation from the specification may appear in the sample, in which case the specification shall govern.

3.2 First article. When specified (see 6.2), a sample shall be subjected to first article inspection (see 6.4) in accordance with 4.4.

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

3.3.3 Polyester and cotton. The stays for the armhole and shoulder seams, reinforcement pieces for the collar eyelets, bindings for the lower edge of the collar, and neck edge of the coat front interlining shall be cut from cloth, polyester and cotton twill, conforming to MIL-C-43718, except the requirement for nonfibrous material and seam efficiency shall not apply. The 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 front interlining; and black for the binding for the lower edge of the collar interlining.

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

3.3.4.1 Cotton buckram. The buckram shall be made of cotton of suitable staple length and grade to meet the requirements of this specification, 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 Texture. The two plies of the cloth shall each have a minimum thread count per inch of 50 in the warp and 20 in the filling.

3.3.4.4 Laminated cloth. The two plies of the cloth shall be thoroughly adhered together with a 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 the wet (dry) cleaning, accelerated aging, and perspiration tests as specified in section 4, table III.

3.3.4.4.1 Finish. The laminated 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 (see 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 III. After being

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subjected to the accelerated aging test, the breaking strength of the cloth shall not be less than the original breaking strength when tested as specified in section 4, table III.

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

3.3.6 Padding for collar. The material for padding the collar shall be 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 the requirements of 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 the requirements of type IV of MIL-P-15064.

3.3.10 Stay tape. The stay tape for the armhole 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.

3.3.11 Piping. The piping material shall be cloth, polyester/wool blend, black, shade 2607 (see 6.4), conforming to type III of MIL-C-21115, cut 5/8 to 3/4 inch wide for piping the shoulder straps, collar, or ornamental sleeve patches; and 1 inch wide for piping the 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:

a. Upper edge of collar interlining - cloth, polyester/wool blend as specified in 3.3.11.

b. Lower edge of collar interlining - cloth, polyester and cotton as specified in 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.

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3.3.14 Threads.

3.3.14.1 Silk thread. The silk thread shall conform to V-T-301 as follows, except the requirements for extractable material 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 and sewing on buttons.	1B3	24	4

The thread for basting shall be good commercial grade cotton.

3.3.14.3 Color and colorfastness. All thread shall be scarlet, shade W, cable No. 66040, except the cotton thread for basting and machine tacking armholes may be white. The cotton thread for overedge stitching the piping at the bottom edge of the coat shall be black. The colored thread shall show the following colorfastness when tested as specified in the applicable thread specification: (see DOD Standard Color Card of Standardized Shades For Sewing Threads 1968)

<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.

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The color of the gimp shall be scarlet, shade W, cable No. 66040, and shall show good fastness to wet (dry) cleaning.

3.3.16 Ornamental braid. The ornamental braid for the coat fronts shall conform to the following requirements when tested as specified in section 4, table III:

Cover

- material (covering)	metal thread
- color of wire	light gold
- metal wire (undercoating)	silver and copper
- plating material	gold
- winding thread	2 ply white or yellow cotton thread

Core (stuffer)

- material	cotton thread (soft)
- number of threads (minimum)	7
- ply of thread (minimum)	2
- color	gold

Weave

number of carrier (minimum)	12
ends/carriers	6-8 (total 79)
shape	tubular
width (inch) (minimum)	3/8 + 1/16
weight/linear yd. (grains)	154.5

Metal content (%)

- gold	0.3
- silver	0.6
- copper	remainder (traces of nickel and zinc)

Fastness to

- water	good
- wet (dry) cleaning	good

3.3.17 Buttons.

3.3.17.1 Insignia button. 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.

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

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3.3.18 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; and free from burrs, tool marks, sharp edges, and roughness. 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; and free from lint, dust, or other foreign inclusions that may affect appearance or serviceability, and shall withstand the test for tackiness specified in 4.7.2.

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

3.3.19.1 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 the lines of printing shall be minimum 10 point (approximately 1/8 inch). The content and format shall be as follows:

NAME _____
 SERVICE NO. _____
 COLLAR SIZE _____
 NOMENCLATURE (item description) _____

 CONTRACT NO. _____ DATE _____
 NAME OF CONTRACTOR _____
 WOOL PRODUCTS ACT INFORMATION _____

3.3.19.2 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 letters S (short), R (regular), L (long), or XL (extra long), as shown by the following example:

40 R

 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: a seven-button, single breasted,

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form-fitting, fully lined coat, having a one-piece front with gold braid; waist and chest darts; a four-piece back without a center vent; belt loop to button; ornamented sleeve ends; shoulder straps to button; and a standup collar with hooks and eyes for front closure and with a worked eyelet at each end for a removable branch of service insignia. The top and bottom edges of the collar; front and bottom edges of the coat; the top, bottom and scalloped back edges of the ornamental sleeve patches; and the edges of the shoulder straps shall be piped with the material specified in 3.3.11.

3.5 Patterns. Standard patterns will be furnished to the contractor by the Government. The standard patterns shall not be altered in any way and shall be used only as a guide for cutting the contractor's working patterns. The contractor's working patterns shall be identical to the standard pattern. The standard patterns 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 cut parts</u>
	<u>Material basic: Cloth, wool, tropical</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
11.	Ornamental sleeve patch, top ply	2
12.	Ornamental sleeve patch, under ply	2
13.	Belt loops	2

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<u>Item</u>	<u>Pattern nomenclature</u>	<u>No. of cut parts</u>
	<u>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
	<u>Cloth, cotton, buckram</u>	
22.	Collar interlining	1
	<u>Cloth, polyester and cotton</u>	
23.	Collar - Interlining	1
	<u>Cloth, cotton, wigan</u>	
24.	Reinforcement (bottom edges of sleeves)	2
	<u>Markers</u>	
25.	Sleeve turnup and sleeve ornament	-

3.6 Construction

3.6.1 Manufacturing requirements. The coats 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 contractor is not required to follow the exact sequence of 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 machines with a knife attachment properly set to trim the raveled edge without cutting the material.

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3.6.1.2.1 Thread breaks and ends of seams. Ends of 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.

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 ensure 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 use of an adhesive mass which adheres to the material upon removal of the tickets.

TABLE I. Manufacturing requirements.

Opn No.	Operation	Seam/		Stch Per Inch	Thread	
		Stch Type	Stch Type		Ndl	Bob Lpr
1.	<u>Cutting.</u> a. Cut coats in strict accordance with patterns furnished by the Government. b. Cut all materials in direction of warp as indicated by directional lines on patterns.					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
1.	<p><u>Cutting.</u> (cont'd)</p> <p>c. Cut all scarlet wool parts from one piece of basic material, except the following parts may be cut from ends: under ply of the shoulder straps, and under ply 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 collar 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>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
1.	<p><u>Cutting.</u> (cont'd)</p> <p>e. Cut polyester and cotton stays for armhole and shoulder seams on the bias, 3/4 inch wide and $4 \pm 1/4$ inches long. Cut the 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 polyester and cotton for the collar interlining on the straight in accordance with the pattern furnished.</p> <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>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
1.	<p><u>Cutting.</u> (cont'd)</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 patches 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 the coat. Cut the applicable binding material (see 3.3.12) for the top and bottom edges of the collar interlining on the straight, 1-1/8 inches wide.</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</p>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
1.	<p><u>Cutting.</u> (cont'd)</p> <p>to the side seam from cloth, cotton buckram. The reinforcement disc shall be 7/8 inch diameter with a 1/8 inch diameter hole at the center.</p>					
2.	<p><u>Replacement of damaged parts.</u></p> <p>a. At time of cutting, replace all parts 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; scissors or knife cuts; tears; holes;</p>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
2.	<p><u>Replacement of damaged parts.</u> (cont'd)</p> <p>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>					
4.	<p><u>Make coat hanger and lining securing straps.</u></p> <p>Finished appearance. The coat hanger and lining securing straps shall finish 1/4 to 3/8 inch wide.</p>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
4.	<u>Make coat hanger and lining securing straps.</u> (cont'd)					
	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.	301	EFp-1	12-16	A	A
	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.					
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 covers. Stitch 1/16 to 1/8 inch from the folded edges, catching the turned under portions in the stitching.	301	EFa-1 (each side edge)	12-16	A	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
5.	<u>Make collar eyelet covers.</u> (cont'd)					
	b. Fold each cover in half across the width. Seam 1/16 to 1/8 inch from the folded side edges.	301	SSa-1	12-16	A	A
6.	<u>Make underarm shields.</u>					
	Finished appearance. The shields shall be finished smooth and flat without puckers, pleats, gathers, or other distortions.					
	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.	301	SSa-1	12-16	A	A
	b. Turn the shield right side out, working out the seamed edges completely.					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/	Stch	Thread	
			Stch Type	Per Inch	Ndl	Bob Lpr
6.	<p><u>Make underarm shields.</u> (cont'd)</p> <p>c. Press the shields smooth and flat with a heated pressing iron or pressing machine.</p>					
7.	<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, well worked over the 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	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
7.	<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 the point and seamed edges completely.					
	d. Edgestitch the loops uniformly 1/16 to 1/8 inch from folded and seamed edges.	301	SSe-1 (b) (seamed edge) OSf-1 (folded edge)	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. The inside edge of the eyelet end of the buttonhole shall finish 5/8 inch from pointed the end of the loop.	But- ton- hole		60 per button- hole not includ- ing bartack	B (silk)	F

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
7.	<u>Make belt loops.</u> (cont'd)					
	f. 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
8.	<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 strap. The buttonholes shall be cleancut, well made, well worked over gimp to fit a 27 line insignia button. The gimp and thread shall be pulled through to the underside of					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
8.	<p><u>Make shoulder straps.</u> (cont'd)</p> <p>the straps. The purling of the buttonhole shall be on the outside.</p> <p>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.</p> <p>b. Turn under one edge of the piping 5/16 inch and stitch through all plies, 1/16 inch from the turned raw edge.</p> <p>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.</p> <p>d. Stitch shoulder strap to piping along the back, front, and collar</p>	301	EFa-1	12-16	A	A
		301	SSe-2 (a)	10-16	A (silk)	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
8.	<p><u>Make shoulder straps.</u> (cont'd)</p> <p>end, 1/8 inch from the inner edge of the piping.</p> <p>e. Trim and notch the piping in accordance with good manufacturing practice in order to prevent pulling and to eliminate gathers and bulges around the collar end.</p> <p>f. Position the top ply on the underply face to face, with the outer edge of piping and the raw edge of the underply even with the back notches matching.</p> <p>g. Stitch along the back, front, and collar end, through all plies, 3/16 inch from the inner raw edge of the piping. Trim any excess material if necessary.</p> <p>h. Turn straps, working out piped edges completely.</p>	301	SSk-1 (a) (with- out cord)	10-16	A (silk)	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
8.	<u>Make shoulder straps.</u> (cont'd)					
	i. Topstitch the straps 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 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. The inside edge of the eyelet end of the shall buttonhole finish 5/8 inch from the outer edge of the piping at the collar end of the strap.	But- ton hole		60 per Button- hole not includ- ing bartack	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

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
9.	<p><u>Make ornamental sleeve patches.</u></p> <p>Finished appearance. The ornamental sleeve patch shall be uniform in appearance and shall finish smooth and flat without twists, gathers, pleats, puckers, 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 eyelets 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.</p> <p>a. The ornamental sleeve patch shall be made of two plies of basic material piped with a 3/4 inch wide strip of the piping material specified in 3.3.11.</p>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
9.	<u>Make ornamental sleeve patches.</u> (cont'd)					
	b. Turn under one edge of the piping 5/16 inch. Stitch through all plies, 1/16 inch from the turned raw edge.	301	EFa-1	12-16	A	A
	c. Position the right side of the top ply of the sleeve patch on the hemmed piping, with the raw edges of the sleeve patch in line with the piping stitching line.					
	d. Join the sleeve patch to the piping along the top, bottom and scalloped edge 1/8 inch from the inner edge of the piping.	301	SSe-2 (a)	12-16	A (silk)	A
	e. Trim and notch the outer edge of piping along the scalloped edge in order to prevent pulling and bulges on the edges.					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
9.	<u>Make ornamental sleeve patches.</u> (cont'd)					
	f. Position the top ply of the sleeve patch on the underply, face to face, with the outer edge of the piping and the raw edge of the underply even.					
	g. Stitch along the top, bottom, and scalloped edge, through all plies 3/16 inch from the inner raw edge of the piping. Trim any excess material if necessary.	301	SSk-1 (a) (without cord)	12-16	A (silk)	A
	h. Turn the sleeve patches, working out the piping 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 topstitched)	12-16	A (silk)	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
9.	<p><u>Make ornamental sleeve patches.</u> (cont'd)</p> <p>j. Press the sleeve patches smooth and flat with a heated pressing iron or pressing machine.</p> <p>k. Mark each sleeve patch, as indicated by marks on pattern, for the location of three eyelets.</p> <p>l. Make one eyelet at each mark, through all plies of the sleeve patches, for attaching insignia button.</p>	Eye- let		22 per eyelet	A (silk)	A
10.	<p><u>Stitch and press dart in under sleeve.</u></p> <p>a. Fold the under sleeve, matching the cut edges of the sleeve darts. Stitch the entire length of the dart, 1/4 inch from the cut edges of the armhole, and taper</p>	301	SSa-1 (cut edges) OSf-1 (folded edge)	12-16	A	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
10.	<p><u>Stitch and press dart in under sleeves.</u> (cont'd)</p> <p>the line of stitching to zero at the lower folded edges.</p> <p>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.</p>					
11.	<p><u>Seam sleeves at forearm.</u></p> <p>Finished appearance. The forearm seam shall finish smooth and flat without twists, gathers, puckers, or pleats and shall start and finish evenly.</p> <p>a. Position the top sleeve with upper forearm edge in line with the notch in the armhole edge of under sleeve. The notches in the lower forearm edge of top and under sleeve shall match. Seam top and</p>	301	SSbd-1 and SSa-1	12-16	A	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
11.	<u>Seam sleeves at forearm.</u> (cont'd) under sleeves together, 3/8 inch from the forearm edge of top the 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 the pattern marker.					
12.	<u>Baste wigan reinforcement to sleeve.</u> a. Position the sleeve on the wigan reinforcement piece with the marks and notches matching. b. Baste the 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	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
12.	<u>Baste wigan reinforcement to sleeve.</u> (cont'd)					
	c. Tack the sleeve to the reinforcement piece along the forearm seam allowance, and along the backarm edges of the top and under sleeve.	101 or 301	SSa-1	8-12	A	A
				8-12	A	A
13.	<u>Join ornamental sleeve patches to sleeves.</u>					
	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 position of the ornamental sleeve patch shall be as shown in figure 4. The scalloped edge of the sleeve patch shall be stitched to the sleeve only at the corners and point in order to facilitate					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
13.	<p><u>Join ornamental sleeve patches to sleeves.</u> (cont'd)</p> <p>removal of insignia buttons when pressing the 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 the marks matching and the bottom edge of sleeve patch even with mark for the bottom turnup of the sleeve.</p> <p>b. Seam the sleeve patch to the sleeve at the mark.</p> <p>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</p>					
		301	LSa-1	12-16	A (silk)	A
		301	LSbj-1	12-16	A (silk)	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
13.	<u>Join ornamental sleeve patches to sleeves.</u> (cont'd) edge to approximately 1/2 inch over the pointed ends. At the center point, the stitching shall extend approximately 1/2 inch on each side of the point.					
14.	<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 sleeve together at the backarm with a 3/8 inch seam, catching the ends of the wigan reinforcement piece in the stitching.	301	SSa-1	12-16	A (silk)	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
14.	<u>Seam sleeves at backarm.</u> (cont'd) b. Spread open the seam and press smooth and flat with a heated pressing iron.					
15.	<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 turn up portion to the reinforcement wigan piece with blindstitching.	Hand or 101		4-6 4-6	A C (silk)	A
16.	<u>Stitch and press dart in under sleeve linings.</u> a. Fold the under sleeve lining, matching the cut edges of the under sleeve dart. Stitch the entire length of the dart, 1/4 inch from the cut edges at the armhole, and taper	301	SSa-1 (cut edges) OSf-1 (folded edge)	12-16	A	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
16.	<p><u>Stitch and press dart in under sleeve linings.</u> (cont'd)</p> <p>the line of stitching to zero at the lower folded edge.</p> <p>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.</p>					
17.	<p><u>Seam sleeve lining at forearm.</u></p> <p>Finished appearance. The forearm seam shall finish smooth and flat without twists, gathers, puckers or pleats and shall start and finish evenly.</p> <p>a. Position the top sleeve lining with upper forearm edge in line with the notch in the armhole edge of under sleeve lining. The notches at the lower forearm edge of the top</p>	301	SSbd-1 and SSa-1	12-16	A	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
17.	<p><u>Seam sleeve lining at forearm.</u> (cont'd)</p> <p>and under sleeve lining shall match. Seam the top and under sleeve lining together, 3/8 inch from the forearm edge of topsleeve lining, forming a tapered outlet on the under sleeve lining.</p>					
18.	<p><u>Seam sleeve lining at backarm.</u></p> <p>Finished appearance. The backarm seam shall finish smooth and flat without twists, gathers, puckers, or pleats and shall start and finish evenly.</p> <p>a. Join the top and under sleeve linings at the backarm with a 3/8-inch seam.</p>	301	SSa-1	12-16	A	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
19.	<p><u>Assemble sleeve and sleeve lining.</u></p> <p>Finished appearance. The lining 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 the 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	SSa-1	6-8 4-6	A	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
20.	<p><u>Fell turnup of sleeve lining.</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 the sleeve lining to finish 1 to 1-1/4 inches above the finished end of the sleeve. 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 the sleeve lining to the turnup of the sleeve with blindstitching.</p>	<p>Hand or 101</p> <p>Hand or 301</p>	<p>EFC-1 (b)</p>	<p>8-10</p> <p>6-8</p>	<p>C (silk)</p> <p>0 (silk)</p>	<p>0</p>
21.	<p><u>Press sleeves.</u></p> <p>Turn the sleeve right side out and assemble in pairs. Press the lower half of sleeve smooth and flat, creasing at the</p>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
21.	<u>Press sleeves.</u> (cont'd) forearm and back- arm. The backarm crease shall be on the backarm seam. Remove the basting at lower end of the sleeve.					
22.	<u>Assemble collar interlining.</u> Finished appear- ance. The binding at the top and bot- tom edge of the collar interlining shall be uniformly stitched 1/4 inch from the folded edges. The bind- ing shall not be tight or full causing puckers, gathers, or pleats. The interlining, eyelet reinforce- ment pieces, and edges of the binding shall be securely caught in the stitching. The interlining shall finish with the eyelet rein- forcement pieces positioned on the inside and the felt padding on the					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
22.	<p><u>Assemble collar interlining.</u> (cont'd)</p> <p>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 a 1-1/8 inch wide strip of the 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 the interlining, with the ends of the felt extending approximately 1 inch beyond end of the interlining.</p>	301	BSa-1 (each edge)	12-16	A	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
22.	<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
23.	<u>Pipe outer ply of collar.</u> Finished appearance. The piping shall extend at lower, upper, and side edges of the outer ply. Shall be uniformly stitched without twists, gathers, puckers, or pleats.					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
23.	<u>Pipe outer ply of collar.</u> (cont'd)					
	a. The outer ply shall consist of two plies of basic material piped at upper and lower edges with 3/4 inch wide strip of the piping material specified in 3.3.11.					
	b. Position the two plies of the outer collar together (face up and edges even) and stitch together from end to end, 1/8 inch from upper and lower edges.	301	SSa-1	12-16	A (silk)	A
	c. Seam the 3/4 inch wide strip of piping to the two plies of the collar from end to end, 1/8 inch from upper and lower edges.	301	SSe-2	12-16	A (silk)	A
	d. Turn back the piping and outer ply at the upper and lower edges, respectively, uniformly working the folded edge of the piping beyond	301	BSm-3 (b)	12-16	A (silk)	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
23.	<u>Pipe outer ply of collar.</u> (cont'd) the edges. Top-stitch the outer ply uniformly, 3/16 inch from the folded edge of the piping.					
24.	<u>Assemble collar</u> (see figure 5). Finished appearance. The collar shall be assembled as shown in figure 5 without twists, gathers, puckers, or pleats. In the finished collar, the end of the lining shall extend approximately 1/2 inch beyond the right end of the collar and approximately 2-1/2 inches beyond the left end of the collar for the extension tab. The eyelet cover shall not be caught in the eyelet. a. Position the upper piped edge of the collar 1/8 inch below the upper bound edge of the collar interlining					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
24.	<p><u>Assemble collar (see figure 5).</u> (cont'd)</p> <p>with lower edges of the collar and collar interlining even. The collar shall extend approximately 1 inch beyond each end of collar interlining.</p> <p>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.</p> <p>c. Lap the upper piped edge of collar assembly over the upper raw edge of lining approximately 1/2 inch with the lining facing up. Stitch collar to lining and eyelet cover along piped edge adjacent to stitching line of the collar piped edge. The stitching shall extend</p>					
		301	SSa-1	12-16	A (silk)	A
		301	LSa-1	12-16	A (silk)	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
24.	<p><u>Assemble collar</u> (see figure 5). (cont'd)</p> <p>from center to center of the 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. Press smooth and flat with a heated pressing iron or pressing machine.</p> <p>e. Turn the collar lining at the seam to the inside of the collar. Press smooth and flat with a heated pressing iron or pressing machine.</p>					
25.	<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 at the left end of the collar.</p>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
25.	<u>Make collar extension tab.</u> (cont'd)					
	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. Baste the turned portion along the top, front, and bottom edges to the body of the lining forming the collar extension tab.	Hand				
	b. Stitch the collar extension tab 1/16 inch from the top, front and bottom edges. Continue the stitching at the back of tab to top row, forming a 1-3/8 to 1/2 inch wide box stitch.	301	SSc-1 (top and bottom edges) OSf-1 (front edge) SSa-1 (back edge)	12-16	A (silk)	A
26.	<u>Fell ends of collar.</u>					
	Finished appearance. The upper and lower piped edges of the collar at each end shall not be visible on					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
26.	<p><u>Fell ends of collar.</u> (cont'd)</p> <p>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 on each end of the collar through all plies of collar midway between the upper and bottom edges and $1-1/2 \pm 1/8$ inches from folded edge. The eyelet shall not go through the eyelet cover.</p>	Hand		2-3	C (silk)	
	<p>b. Make one eyelet on each end of the collar through all plies of collar midway between the upper and bottom edges and $1-1/2 \pm 1/8$ inches from folded edge. The eyelet shall not go through the eyelet cover.</p>	Eye-let		22 per eyelet	A (silk)	A
27.	<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</p>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
27.	<p><u>Fold and stitch dart in front lining.</u> (cont'd)</p> <p>the folded edge at the center.</p> <p>a. Fold the front lining and stitch the waist darts in accordance with marks indicated on the pattern. Taper the upper and lower ends to a flat point and securely tack the points.</p>	301	OSf-1	12-16	A	A
28.	<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 with the bottom edge of the label shall be approximately 4 inches from the bottom finished edge of the coat.</p>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
28.	<u>Sew on identification label.</u> (cont'd)					
	a. Sew the identification label to the outside of the right facing with a single row of stitches 1/16 to 1/8 inch from each edge.	301	SSa-1 (each edge)	12-16	A	A
29.	<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 be 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.	301	SSa-1	12-16	A	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
29.	<u>Join front lining to wool facing.</u> (cont'd) The stitching shall extend from the top edge of facing to approximately 1-1/4 inches from the bottom edge.					
30.	<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 center back lining with a 3/8 inch seam.	301	SSa-1	12-16	A	A
	b. Position the backs and join together at the center with a 3/8 inch seam.	301	SSa-1	12-16	A	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
31.	<u>Join side back and front linings.</u> Finished appearance. The side, back, and front linings shall be carefully joined without gathers, puckers, or pleats. The seams shall start and finish evenly.					
	a. Position and join the front and side back linings at the sides with a 3/4 inch seam.	301	SSa-1	12-16	A	A
32.	<u>Overedge stitch lining and facing seams.</u>					
	a. Overedge stitch together the raw edges of the facing lining seam, side seam, side back seam, and center back seam allowance.	503 or 504		6-8 6-8	70/2 70/2	70/2 70/2
33.	<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					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
33.	<u>Press lining seams and waist darts.</u> (cont'd) press smooth and flat. b. Turn the waist darts toward the side seam and press smooth and flat.					
34.	<u>Assemble fronts.</u> Finished appear- ance. 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. 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. Taper the line of stitch- ing to zero at the lower end.	301	SSa-1 (cut edge) OSf-1 (folded edge)	12-16	A	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
34.	<u>Assemble fronts.</u> (cont'd)					
	b. Fold fronts and stitch the waist dart in accordance with the marks indicated on the pattern. Taper the upper and lower ends to a flat point and securely tack the points.	301	OSf-1	12-16	A	A
35.	<u>Press darts on fronts.</u>					
	a. Turn the folded edge of the chest dart toward the armhole and press smooth and flat.					
	b. Turn the folded edge of the waist dart toward the side seam and press smooth and flat.					
36.	<u>Assemble side backs and center back.</u>					
	Finished appearance. The side and center backs shall be joined without gathers, puckers, or pleats. The seams shall start and finish evenly.					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
36.	<u>Assemble side backs and center back.</u> (cont'd)					
	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, with notches matching, to the respective center back with a 3/8 inch seam.	301	SSa-1	12-16	A	A
37.	<u>Join fronts and back.</u>					
	Finished appearance. The fronts and back shall be joined without gathers, puckers, or pleats. The seam 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

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
37.	<u>Join fronts and back.</u> (cont'd)					
	b. 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
	c. Spread open the side and back seams and press smooth and flat with a heated pressing iron.					
38.	<u>Seam reinforcement stay to armhole and shoulder.</u>					
	Finished appearance. The polyester and cotton reinforcement stay 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.					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
38.	<u>Seam reinforcement stay to armhole and shoulder.</u> (cont'd)					
	a. Seam the 3/4 inch wide polyester and cotton stays to the underside of the front at the shoulder edge and upper front edge of the armhole, 1/8 inch from the outer edge. The stay at the armhole shall extend from 1/2 inch below the shoulder seam down the front edge of armhole approximately 4-1/2 inches. The stay on the shoulder shall extend from approximately 1/2 inch from armhole and neck.	301	SSaa-1	12-16	A	A
39.	<u>Tape armholes.</u>					
	a. Sew the cotton tape to the armhole starting with one end approximately 1 inch above the notch in the fronts and continuing along the lower and back edges of the	301	SSaa-1	12-16	A	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
39.	<p><u>Tape armholes.</u> (cont'd)</p> <p>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 edge of the armhole and shall be held taut while stitching along the back edge.</p>					
40.	<p><u>Press shoulder blades and armholes tapes.</u></p> <p>a. Press the shoulder blades and the armhole tape smooth and flat with a heated pressing iron or suitable type pressing machine.</p>					
41.	<p><u>Mark and dress left front.</u></p> <p>a. Mark and shape the left front edge from the top notch to the bottom front notch.</p>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
41.	<p><u>Mark and dress left front.</u> (cont'd)</p> <p>b. The mark line shall be 1 inch from the upper edge to 1-1/8 inches at the waistline. Continue on a straight line from the waistline to the notch at the bottom edge.</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.</p>					
42.	<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</p>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
42.	<p><u>Stitch piping to coat.</u> (cont'd)</p> <p>the collar notch at the 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 fronts, with edge even with top, front, and bottom edges of coat. Stitch the 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 out the folded edge of piping uniformly, 1/8 inch beyond the edges of the coat.</p> <p>c. Topstitch the coat to the piped edges uniformly, 3/16 inch from the folded edge of the piping, catching</p>	301	SSa-1	12-16	A (silk)	A
		301	SSE-2	12-16	A (silk)	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
42.	<p><u>Stitch piping to coat.</u> (cont'd)</p> <p>the turned under portion of the piping in the stitching.</p> <p>d. Notch out any excess piping material at the top and bottom front corners to eliminate bulkiness. Trim the inner edge of piping only on the left front from the upper front down to approximately 1 to 1-1/2 inches below waistline, so that the piping will not interfere with the front buttonholes.</p> <p>e. Serge stitch the raw edge of the piping at the bottom edge of the coat only.</p> <p>f. Press the piped edges of coat smooth and flat with a heated pressing iron or pressing machine.</p>					
		503	EFd-1	6-8	70/2	70/2
		or 504	EFd-1	6-8	70/2	70/2

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
43.	<u>Interline fronts.</u>					
	a. Position the left and right fronts on the respective coat front interlinings. 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, working the fullness in the fronts towards the armhole. Baste along the front of the armhole approximately 1-1/2 inches from the edge. 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	Hand or 301	Hopper			

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
43.	<p><u>Interline fronts.</u> (cont'd)</p> <p>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 to the bottom edge of the fronts.</p>					
44.	<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 the shoulder to the collar notch.</p> <p>b. Notch the top edge of the interlining in line with collar notch.</p> <p>c. Remove stitches joining the front edge of polyester and cotton to coat front interlining, approximately 1/2 inch back from the front and top edges of fronts.</p>					

MIL-C-82172B(MC)

TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
44.	<p><u>Trim coat front interlining.</u> (cont'd)</p> <p>d. Turn the fronts inside out and trim the interlining only, approximately 1/4 inch back from the front and top edges of fronts.</p> <p>e. 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>					
45.	<p><u>Bind front and top edge of interlining.</u></p> <p>a. Fold the polyester and cotton twill back and over the top and front raw edge of the interlining. Stitch the front turned under portion of the polyester and cotton twill to the body of the interlining with three rows of stitches, 1/4 inch</p>	301	EFa-3	12-16	A	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
45.	<u>Bind front and top edge of interlining.</u> (cont'd) apart, placing the first row 1/8 inch from folded front edge and catching the upper turned under portion in the stitching.					
46.	<u>Bind top neck edge of interlining.</u> Finished appearance. The 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

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
46.	<u>Bind top neck edge of interlining.</u> (cont'd) 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	EFa-1	12-16	A	A
47.	<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 the piping to the interlining through the fronts. b. Fell the upper front and lower inner edge of the piping to the coat front interlining. c. Pull and remove basting stitches from the piping.	101				
		301 or Hand	EFC-1	4-6 4-6	A C (silk)	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
47.	<p><u>Fell piping to coat front interlining.</u> (cont'd)</p> <p>d. Press the left and right fronts on a suitable type of heated pressing machine, with the chest to conform to the shape of the body.</p>					
48.	<p><u>Mark fronts for positioning the braid and buttonholes (see figure 6).</u></p> <p>a. Mark the location of seven buttonholes on the outside of the left front. The top and bottom buttonholes shall be in accordance with the mark on the pattern. The remaining five buttonholes shall be evenly spaced.</p> <p>b. Extend each buttonhole line towards the armhole edge. The second buttonhole line A-C shall extend to within 1-1/4 inches from armhole edge and 5/8 inch from</p>					

MIL-C-82172B(MC)

TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
48.	<p><u>Mark fronts for positioning the braid and buttonholes (see figure 6).</u> (cont'd)</p> <p>the front piped edge. The lower buttonhole line B-D shall be 1 inch shorter than line A-C as shown in figure 6.</p> <p>c. Bisect lines A-C and B-D and connect the bisecting points E-F with a straight line (see figure 6).</p> <p>d. Position the left front on the right front face to face, with collar notches and armhole edges even. Trace the same line on the right front to coincide with the lines on the left front; the lines on the right front shall extend $\frac{3}{4}$ to 1 inch from the front piped edge. The bisecting line on the right front shall be identical to line E-F on the left front.</p>					

MIL-C-82172B(MC)

TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
48.	<p><u>Mark fronts for positioning the braid and button-holes (see figure 6).</u> (cont'd)</p> <p>e. Draw a circle $7/8 + 1/32$ inch in diameter on each horizontal line, centered to the bisect line E-F. The edge of each circle shall touch the horizontal line forming a figure 8 design as shown on figure 6.</p>					
49.	<p><u>Baste gold braid to fronts.</u> (see figures 6 and 7).</p> <p>a. The braid shall be basted as shown in figure 7 to the fronts on the marks shown in figure 6. On the left side of the coat, the edge of the braid shall follow the edge of the buttonhole marks.</p>	Hand				

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
50.	<p><u>Stitch gold braid to fronts (see figure 7).</u></p> <p>a. The braid shall be stitched to the fronts as shown in figure 7, 1/16 inch from each edge of the braid, except the stitching shall not cross over the center of the figure 8 design. The braid on the left front only shall be unstitched for approximately 3 inches from front end of the button-hole loop braid.</p>	301	SSa-1 (each side)	12-16	A (silk)	A
51.	<p><u>Set belt loops.</u></p> <p>Finished appearance. The belt loops shall finish vertically straight.</p> <p>a. Center the belt loops vertically on the side seam with the pointed end towards the bottom of the coat and the raw edge of the loop in horizontal alignment with the mark for the bottom</p>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
51.	<u>Set belt loops.</u> (cont'd) 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
52.	<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 with the front piped edge approximately 3/8 inch from the front edge of the facing. Mark the facing along the					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
52.	<p><u>Join facing to fronts.</u> (cont'd)</p> <p>top, front, and bottom edges.</p> <p>b. Lap the front edge of the right and left fronts, respectively at the marks on the outside of the facing. Join the front and facing together as close as possible to, but not on top of, the stitching joining the piping to the front. The stitching shall extend from top to bottom edge of coat front edge only.</p> <p>c. Trim excess facing material where necessary.</p>	301	LSa-1	12-16	A (silk)	A
53.	<p><u>Baste front edges.</u></p> <p>a. Turn the facing-lining assemblies to the inside of fronts. Baste along the front edge of left and right fronts, working the facing back from the folded edge of the piping.</p>	101 or Hand				

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
54.	<u>Baste facing</u> <u>(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			
	b. Turn under and baste the top edge of the facing to the fronts from the collar notch to the front edge, catching the turned under portion of the facing in the basting.	Hand or 301	Hopper			
	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	Hand or 301	Hopper			

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
54.	<u>Baste facing (second time).</u> (cont'd) 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	Hopper			
55.	<u>Tack facings to interlining.</u> a. Tack the right and left facing-lining seam allowances to the respective coat front interlinings from approximately 2-1/2 inches from the bottom edge of the coat to approximately 3 inches from the shoulder edge.	Hand or 103	SSm-1	4-6 4-6	C (silk) A (silk)	

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
56.	<u>Baste front linings to coat.</u>					
	a. Fold the front lining in accordance with the notches, forming the chest pleat. 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			
	b. Baste the front lining to the coat. Start at the lower end of chest pleat, continue along lower edge of armhole approximately 2 inches from the edge, and end at the side seam. Match side seams of coat and lining. Continue basting as close as possible to the side seam and then across the bottom towards the front, approximately 4 inches from the piped bottom edge of the coat.	Hand or 301	Hopper			

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
57.	<u>Baste back lining to coat.</u> a. 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 the coat. b. Baste back lining to coat. Starting at side seam and continue approximately 3 inches from the armhole and shoulder edges.	Hand or 301	Hopper			
58.	<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 $3/4 + 1/8$ inch wide. The lining securing					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
58.	<p><u>Hem bottom edge of lining.</u> (cont'd)</p> <p>straps shall be positioned on the side seam outlets of the lining with one edge even with the serged edge.</p> <p>a. Hem the bottom edge of body lining with the raw edge turned under and one end of the securing straps positioned and caught in the stitching, 1/16 inch from the upper folded edge of hem.</p>	301	EFb-1	12-16	A	A
59.	<p><u>Tack the lining securing straps to bottom of coat.</u></p> <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 straps shall finish between the piping at bottom edge of coat and side seam</p>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
59.	<p><u>Tack the lining securing straps to bottom of coat.</u> (cont'd)</p> <p>allowance. In the finished coat, the lining shall not be visible below the bottom edge of the 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 the coat. Fold the lining securing straps across the width and stitch approximately 1/4 inch from the folded end in order to hold the lining in position.</p>	301	SSbh-3	12-16	A	A
		301	OSf-1	6-10	A	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
60.	<u>Fell facings.</u>					
	a. Fell the facing to the piping at the bottom edge of the coat. Start at the bottom edge of the lining and continue along the back and bottom edges of the facing to the front edge of the coat.	Hand		8-10	C (silk)	
	b. Fell the folded edge of the facings to the piping along the top edge from collar notch to front edge of coat.	Hand		8-10	C (silk)	
61.	<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 linings to approximately 3/4 inch from shoulder at the armhole edge.					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
61.	<u>Trim lining and interlining.</u> (cont'd) Taper the trimming to 3/8 inch at the neck.					
62.	<u>Baste shoulder pad to coat.</u> a. Insert shoulder pads between interlining and chest padding of coat fronts. Securely tack the pads to the interlining and chest padding only.	Hand or 301	Hopper			
63.	<u>Make buttonholes.</u> Finished appearance. The buttonholes shall be clean cut, well made, well worked over gimp to fit 40 line insignia buttons. 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					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
63.	<p><u>Make buttonholes.</u> (cont'd)</p> <p>be on the outside of the fronts. The inside edge of the eyelet end of the buttonhole shall be 5/8 inch from the front edge the of coat. The buttonholes shall be cut first type.</p> <p>a. Remove the basting on the unstitched portion of the braid.</p> <p>b. 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.</p> <p>c. Make one horizontal eyelet end, square bar type buttonhole, cut 1-1/8 inches long, at each of the marks.</p>					
		But- ton- hole		60 per button- hole (not includ- ing bar- tack)	B (silk)	F

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
63.	<u>Make buttonholes.</u> (cont'd) d. 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. e. Rebaste the unstitched portion of the braid around the buttonholes and completely stitch that portion of the braid through the facing as shown on figure 3.	Bar- tack		21 per bartack	A (silk)	A
64.	<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 back in accordance with good manufacturing practice.	301	SSa-1	12-16	A	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/	Stch Per Inch	Thread	
			Stch Type		Ndl	Bob Lpr
64.	<p><u>Seam shoulders.</u> (cont'd)</p> <p>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.</p> <p>c. Position the front lining and coat front interlining at the neck, shoulder and armhole edges of the fronts. Baste all plies together on the outside along the front edge of armhole and continue along the shoulder seam and gorge, catching the shoulder pad in the basting. Turn the coat on the inside.</p>	Hand or 301	Hopper			

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
65.	<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 to the coat along the folded edge of the back lining with the top end of the chest pleat caught in the basting.	Hand				
66.	<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. The ends of the coat hanger shall be positioned so that, in the finished coat, the hanger opening shall be 2 $\frac{1}{8}$ inches long when measured along					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
66.	<p><u>Seam neckline with size label and coat hanger.</u> (cont'd)</p> <p>the lower edge of collar lining.</p> <p>a. Join facings and back lining to coat at the neckline, from collar notch to collar notch, with a 1/4 inch seam. The upper edge of the size label and the ends of the hanger shall be positioned and caught in the stitching at the inside center back.</p> <p>b. Press the neckline of the coat smooth and flat with a heated pressing iron or pressing machine.</p>	301	SSa-1	12-16	A	A
67.	<p><u>Set collar with lining.</u></p> <p>Finished appearance. The collar shall be carefully joined to the coat without distortion of the collar.</p>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
67.	<p><u>Set collar with lining.</u> (cont'd)</p> <p>a. Mark the neck-line on the inside 3/8 to 1/2 inch from top edge for proper positioning of collar.</p> <p>b. Position the collar with the lower edge lapped on the outside top edge of the coat at the mark.</p> <p>c. Seam the collar to the coat from end to end as close as possible to, but not on top of, the stitching for the piping at the lower edge of the collar. The stitching shall not be through the collar lining.</p>	301	LSa-1	12-16	A (silk)	A
68.	<p><u>Set shoulder straps.</u></p> <p>Finished appearance. The shoulder straps shall be uniformly stitched to the coat without twists, puckers, pleats, or other distortions. On the finished coat, the</p>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
68.	<p><u>Set shoulder straps.</u> (cont'd)</p> <p>straps, including the piping, shall be $2\text{-}3/8 \pm 1/8$ inches wide at the armhole seam and shall taper to $1\text{-}3/4 \pm 1/8$ inches wide at the button-hole eyelet end.</p> <p>a. Position the shoulder straps with the back edge $1/4$ to $1/2$ inch to the back of the shoulder seam at the armhole and with the rounded end of the straps, on the finished coat, $1/4$ to $3/8$ inch from the lower edge of the collar.</p> <p>b. Seam the shoulder straps to the coat $1/4$ inch from the armhole edge. Trim the shoulder straps even with the armhole where necessary. Turn the coat on the inside.</p>	301	SSa-1	12-16	A (silk)	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
69.	<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 sleeve on outside of coat at the armhole, with backarm seam of sleeve matching the side back seam, and the notch in top sleeve and front matching.</p> <p>b. Join the sleeve to the coat with a $\frac{3}{8}$ 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</p>					
		301	SSa-1	12-16	A	A

MIL-C-82172B(MC)

TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
69.	<p><u>Set sleeves.</u> (cont'd)</p> <p>the front edge of armhole. Press smooth and flat with a heated pressing iron.</p> <p>d. Fold the excess material at the 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>					
70.	<p><u>Baste armhole.</u></p> <p>a. Baste around the entire armhole on the inside, holding the back lining, shoulder pad, and front lining in place. Distribute fullness evenly. Turn the coat on the outside.</p>	Hand or 301	Hopper			

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/	Stch Per Inch	Thread	
			Stch Type		Ndl	Bob Lpr
70.	<u>Baste armhole.</u> (cont'd) 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 or 301	Hopper			
71.	<u>Set underarm shields.</u> a. Baste or tack underarm shields at the base of the armhole.	Hand or 301				
72.	<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.					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
72.	<p><u>Stitch sleeve-head pads and linings at armhole.</u> (cont'd)</p> <p>a. Position the sleeve-head pad on the sleeve with the folded edge of the pad approximately 1/8 inch back from the raw edge of the armhole-sleeve seam and with the one end of the pad matching the notch in the fronts.</p> <p>b. Stitch the sleeve-head pad to the sleeve front, end to end, through the armhole-sleeve seam allowance, 1/8 inch from the folded edge of the pad, catching the front and 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>	301	SSa-1	4-6	A	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
72.	<u>Stitch sleeve head pads and linings at armhole.</u> (cont'd) c. The underarm shield may be basted to the armhole prior to stitching.					
73.	<u>Tack underarm shield to lining.</u> Finished appearance. The tacking for the underarm shield shall finish approximately 1/2 inch from the seamed edges. a. Tack the underside of the underarm shield to the body lining along the side and bottom edges.	Hand		4-6	C (silk)	
74.	<u>Fell back lining and facing-lining assembly at shoulders.</u> a. Fell the back lining and the facing-lining assembly together at the shoulders. Place the stitching over the folded edge of the back	Hand		8-10	C (silk)	

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
74.	<u>Fell back lining and facing-lining assembly at shoulders.</u> (cont'd) lining and secure the top end of the chest pleat in the felling. b. Fell the folded edge of facing to the piping along the top edge from collar notch to front edge of coat.	Hand		8-10	C (silk)	
75.	<u>Fell sleeve lining at armhole.</u> a. Position the sleeve lining at the armhole with the back and forearm seams of the sleeve and sleeve lining matching. b. Turn under the armhole edge of the sleeve lining. Lap the lining on the outside of the front and back linings and the top edge of the under-arm shield. Fell the sleeve lining to the coat around the entire	Hand		8-10	C (silk)	

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
75.	<p><u>Fell sleeve lining at armhole.</u> (cont'd)</p> <p>armhole. Place the stitching over the folded edge of the sleeve lining, catching the under-arm shield in the filling, and distribute the fullness in accordance with good commercial practice. Back-stitch the lower armhole edge from backarm seam of the sleeve to the front edge of the shield.</p> <p>OR</p> <p>c. Machine stitch the lower edge of the sleeve lining, at the armhole, on the inside, from forearm seam to backarm seam. Hand fell the remaining portion as specified in operations 74b above.</p> <p>OR</p>	301	SSa-1	12-16	A	A

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
75.	<u>Fell sleeve lining at armhole.</u> (cont'd) d. Machine stitch the lower edge of the sleeve lining at the armhole, on the inside, from forearm seam to backarm seam. Stitch the remaining portion of the sleeve lining at the armhole with machine simulated hand felling. NOTE: It is required that the simulated hand felling produced by machine shall be equal to or better than the hand felling.	Ma- chine		8-10	C (silk)	
76.	<u>Mark for eyelets on shoulders.</u> a. Mark each shoulder for the location of one eyelet, for removable insignia buttons, to align with the eyelet of buttonhole in the shoulder straps. On the finished coat, the shoulder					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
76.	<u>Mark for eyelets on shoulders.</u> (cont'd) strap shall lie smooth and flat without twisting or bulging.					
77.	<u>Make eyelets.</u> Finished appearance. The eyelet shall be well worked with purling of the eyelet on the outside of the shoulder. The eyelets shall finish with a 1/8 inch diameter opening. a. Make one eyelet at the mark on each shoulder through all plies.		Eye- let	22 per eyelet	A (silk)	A
78.	<u>Sew hooks and eyes to collar.</u> Finished appearance. The hooks shall be positioned on the collar so that, in the finished coat, the top and bottom hooks shall be respectively approximately 1/4 inch from top and bottom edges					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
78.	<p><u>Sew hooks and eyes to collar.</u> (cont'd)</p> <p>of collar. The remaining hook shall be midway between top and bottom hooks. The eyes shall be positioned to engage the hooks, effecting 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		16 per hook and eye	C (silk) (double thread)	
79.	<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. Position the folded edge of the lining under the hook. Fell the folded end of the collar lining to</p>					
		Hand		8-10	C (silk)	
		Hand		8-10	C (silk)	

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
79.	<u>Finish collar.</u> (cont'd)					
	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.	Hand		8-10	C (silk)	
	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.	Hand		8-10	C (silk)	
	NOTE: The lower edge of collar lining may be basted to coat prior to felling.					
	d. Fell the collar extension tab to the left end of the collar. Continue along the folded top edge to the end of the stitching joining the lining to the collar.	Hand		8-10	C (silk)	

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
79.	<u>Finish collar.</u> (cont'd) e. Turn the collar eyelet covers to the inside of the collar. Fell the front edge from the 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)	
80.	<u>Clean coat</u> a. Pull any basting thread, trim and remove any loose ends of thread; and remove any spots, stains and tickets without injury to the material.					
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.					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
81.	<p><u>Press coat.</u> (cont'd)</p> <p>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.</p> <p>c. Press the entire collar smooth and flat.</p> <p>d. Press the fronts on a body machine, shrinking 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. The</p>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
81.	<p><u>Press coat.</u> (cont'd)</p> <p>backarm crease shall be on the backarm seam. The forearm and backarm creases 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 straps flat.</p> <p>i. Press the armholes 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 the top sleeves.</p>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
81.	<u>Press coat.</u> (cont'd) k. Press lower edge of coat smooth, flat and even. l. Remove all wrinkles and impressions from under shoulder straps. m. Press body lining throughout, 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					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
82.	<u>Mark for belt loop buttons.</u> (cont'd) the eyelet button-hole in the belt loop.					
83.	<u>Cut opening for belt loop buttons.</u> a. Cut an approximately 1/4 inch vertical long opening at the mark on each side seam. The opening shall be made through the side seam of the wool parts of the coat only. b. Securely tack or bartack each end of the opening.	Hand or 301		2-5 4-6	C A (silk)	A
84.	<u>Mark for buttons on the right front.</u> a. Mark the location for sewing seven 40 line insignia buttons to the right front of the coat to properly engage with the button-holes on the left front. The mark for the top button shall be in line					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread	
					Ndl	Bob Lpr
84.	<p><u>Mark for buttons on the right front.</u> (cont'd)</p> <p>with right front end of collar. The remaining buttons shall be in vertical alignment with the top button.</p>					
85.	<p><u>Attach and sew on buttons.</u></p> <p>Finished appearance. The buttons shall be aligned with the buttonholes to secure a smooth and complete closure without bulging or misalignment.</p> <p>a. Insert the shank of one 27 line insignia button through each eyelet on shoulders, ornamental sleeve patch, and through cut openings at the side seams.</p> <p>b. Attach reinforcement disc (see 3.3.5) through the shank of buttons on each side seam. Secure buttons to shoulders, side</p>					

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TABLE I. Manufacturing requirements.

Opn No.	Operation	Stch Type	Seam/ Stch Type	Stch Per Inch	Thread Ndl	Bob Lpr
85.	<p><u>Attach and sew on buttons.</u> (cont'd)</p> <p>seam, and ornamental sleeve patch with a metal ring toggle.</p> <p>c. Button belt loop.</p> <p>d. Sew one 40 line insignia button at each of the marks on the right front through all plies.</p> <p>e. The insignia button on the front shall be sewn with the head of the eagle upright.</p>	Hand		8 wraps (double thread)	24/4	

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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 <u>2/</u>	Back length <u>3/</u>	Sleeve length <u>4/</u>
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	30-3/8	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

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TABLE II. Coat measurements 1/ - Continued.

Size	Breast 2/	Back length 3/	Sleeve length 4/
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
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 measurements shall be taken, with coat buttoned, from folded edge to folded edge in line with the pit of the armhole; multiply by two.

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

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

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3.8 Workmanship. The finished coats shall conform to the quality and grade of product established by this specification.

4. QUALITY ASSURANCE PROVISIONS

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

4.1.1 Responsibility for compliance. All items shall meet all requirements of section 3 and 5. The inspection set forth in this specification shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the contractor of the responsibility for ensuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations, is an acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to accept defective material.

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

- a. First article inspection (see 4.4).
- b. Component and material inspection (see 4.5.1).
- c. In-process inspection (see 4.5.1.2).

4.3 Inspection condition. Unless otherwise specified, all inspections shall be performed in accordance with the test conditions specified in table III.

4.4 First article inspections. When a first article is required (see 6.2), it shall be examined for the defects specified in 4.5.2.1 through 4.5.2.5. The presence of any defect or failure to pass any test shall be cause for rejection of the first article. The number of units to be inspected shall be specified by the contracting officer (see 6.2).

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4.5 Quality conformance inspection.

4.5.1 Component and material inspection. In accordance with 4.1 above, components and materials shall be tested in accordance with all the requirements of referenced specifications, 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 the components listed in table III for the 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.

4.5.1.1 Sampling for testing. Unless otherwise specified in subsidiary specifications, sampling shall be in accordance with MIL-STD-105. The unit for expressing lot sizes and sample unit for testing each component shall be in accordance 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 yard full width
Padding for collar	yards	1/4 yard full width
Hook and eye	100 each	2 each, hook and eye

4.5.1.2 In-process inspection. Inspection shall be performed during manufacture 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 the specified requirements for operations or subassemblies.

4.5.2 Examination of end item. The end item shall be examined for the defects listed in 4.5.2.1 through 4.5.2.5. The sample unit shall be one completely fabricated coat. The inspection level shall be II (see 6.5).

Table III. Test methods.

Components	Characteristics	Rqmt. para	Test methods	No. Det. Per S/unit	Results reported as:	
Cloth, cotton buckram, (collar interlining)	Material identification <u>1</u> /	3.3.4.1	1200	1	Pass or fail	
	Weave (single ply)	3.3.4.2	Visual	1	Pass or fail	
	Texture-threads per inch (single ply)	3.3.4.3	5050		Avg. of the 3 det. in each direction to the nearest whole number	
	- warp	3.3.4.3		3		
	- filling	3.3.4.3		3		
	Resistance to:					
	- wet (dry) cleaning (laminated cloth)	3.3.4.4	5622 <u>2</u> /	1	Good, fair or poor	
	- accelerated aging (laminated)	3.3.4.4	5850 <u>3</u> /	1	Pass or fail	
- perspiration (laminated cloth)	3.3.4.4	5680 <u>4</u> /	1	Good, fair or poor		
Stiffness, inch-lb						
- original	3.3.4.4.1	5202 <u>5</u> /	10	Nearest 0.001 lb.		

Table III. Test methods - Continued.

Components	Characteristics	Rqmt. para	Test methods	No. Det. Per S/unit	Results reported as:
	- after wet (dry) cleaning	3.3.4.4.1	5622 <u>2</u> / 5202	10	
	- after accelerated aging	3.3.4.4.1	5850 <u>3</u> / 5202	10	
	- after perspiration	3.3.4.4.1	5680 <u>4</u> / 5202	10	
	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) (min)	3.3.4.4.3	5100		Avg. of the 5 det.
	- warp direction			5	
	- filling direction			5	
Padding, felt (for collar)	Material identification <u>1</u> /	3.3.6	1200		
	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

III

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Table III. Test methods - Continued.

Components	Characteristics	Rqmt. para	Test methods	No. Det. Per S/unit	Results reported as:
Ornamental Braid (Front and Sleeve)	Cover thread	3.3.16			
	- material identification <u>1</u> /		1200	1	Pass or fail
	- color		Visual	1	Pass or fail
	- ply		Visual	1	Pass or fail
	Cover wire	3.3.16			
	- metal undercoat		Std. Coml	1	Pass or fail
	- metal plating		Std. Coml	1	Pass or fail
	Core (stuffer)	3.3.16			
	- material identification <u>1</u> /		1200	1	Pass or fail
	- number of threads		Visual	1	Pass or fail
- ply of threads		Visual	1	Pass or fail	
Color	3.3.16	Visual	1	Pass or fail	
Weave	3.3.16	Visual	1	Pass or fail	
No. of carriers	3.3.16	Visual	1	Pass or fail	
Ends/carriers	3.3.16	Visual	1	Pass or fail	
Shape	3.3.16	Visual	1	Pass or fail	
Width (in.)	3.1.16	5020	1	Pass or fail	

Table III. Test methods - Continued.

Components	Characteristics	Rqmt. para	Test methods	No. Det. Per S/unit	Results reported as:
	Metal content (%)	3.3.16	4.4.1.3		To nearest 0.1%
	- gold			2	
	- silver			2	
	- alloy			2	
	Fastness to:				
	- water	3.3.16	5630	1	Good, fair or poor
	- wet (dry) cleaning	3.3.16	5620	1	Good, fair or poor
Hook and eye	Material identification <u>1/</u>	3.3.18	Std. Coml	1	Pass or fail
	Finish	3.3.18	Std. Coml	1	Pass or fail
	Finish	3.3.18	4.4.1.2	1	Pass or fail

1/ Accept on certificate of compliance.

2/ Except that the colorfastness shall be evaluated after three wet (dry) cleaning cycles.

3/ Except that aging exposure shall be limited to 5 hours at a temperature of 100°C

4/ Except that the material shall be immersed in the specified solutions for 20 minutes and air-dried

5/ Except that a moment weight of 1 pound shall be used.

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4.5.2.1 Classification of defects. All defects shall be classified as indicated below, except those numbered 1 through 25 in classification column which shall be classified as follows:

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

4.5.1.2 General defects. General defects shall be classified as follows:

Examine	Defect	Classification		
		Major (*)	Minor	
			A	B
Buttonholes (construction)	a. One or more omitted, added, or wrong type.	101		
	b. Not corresponding to size of button: - too small, not permitting button to enter buttonhole. - too large, 3/8 inch or more longer than the diameter of button (measured at inside of purling).	102	201	
	c. Buttonhole not securely caught on fabric, causing stitching to pull away from fabric.	103		
	d. Bartack missing or loose on: - one buttonhole. - two or more buttonholes.	104	202	

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Examine	Defect	Classification			
		Major (*)	Minor		
			A	B	
Buttons or ring toggles	e. Bartack misplaced, not serving intended purpose on: - one buttonhole. - two or more buttonholes.		203		301
	f. One or more broken stitches in: - one buttonhole. - two or more buttonholes	105	204		
	g. More than 2 skipped stitches in: - one buttonhole. - two or more buttonholes.		205		302
	h. Ragged edges, effecting appearance; or exposed interlining not colored with reddish indelible ink.				303
	i. Any uncut buttonhole.		206		
	j. Gimp omitted in one or more buttonholes; or end of gimp not pulled through to underside.		207		
	k. Stitches per buttonhole (not including bartack) less than the minimum specified: - one or two stitches. - three or more stitches.		208		304
	l. One or more buttonholes finished with purling on the underside.	106			
	a. One missing, loose, broken, defective, or improper size or type.		209		
	b. Two or more missing, loose, defective, or improper size or type.	107			

MIL-C-82172B(MC)

Examine	Defect	Classification			
		Major (*)	Minor		
			A	B	
	c. One or more buttons sewn with the head of the eagle in other than upright position.				305
	NOTE: Buttons shall be considered defective if they have sharp, rough, cracked, or split edges; unsound soldering; scratches; dents; blemishes or imbedded foreign matter; loose shanks; or are poorly plated or badly shaded.				
Cleanness	a. One or more spots or stains, of a permanent nature, clearly noticeable: - on the outside. - on the inside.	108		210	
	b. One or more removable spots or stains clearly noticeable: - on the outside. - on the inside.			211	306
	c. Threads ends not trimmed throughout garment, or one or more bastings not removed, or two or more shade tickets not removed.				307
Components and assembly	a. Any component part or required operation omitted (unless otherwise classified herein).		1		
	b. Any defective component or defect of assembly (not herein classified).		2		
Cutting	a. Any component part of the basic wool material not cut in accordance with directional lines on patterns or in accordance with the specification requirements.	109			

MIL-C-82172B(MC)

Examine	Defect	Classification		
		Major (*)	Minor A B	
Eyelet (construction)	b. Piping material cut on the bias.		212	
	c. Any lining part not cut in accordance with directional lines on patterns, or in accordance with specification requirements.		213	
	a. One or more omitted or added.	110		
	b. Wrong type.		214	
	c. Eyelet not securely caught on fabric, causing stitching to pull away from fabric.	111		
	d. Diameter of inside opening less than 1/8 inch or more than 1/4 inch.			308
	e. One or more eyelets uncut.		215	
	f. One or more broken stitches in: - one eyelet. - two or more eyelets.		216	309
	g. More than two skipped stitches in one or more eyelets.			310
	h. One or more eyelets finished with purling on the underside.		217	
Hooks and eyes	a. One hook or eye omitted.		218	
	b. Two or more hooks or eyes omitted.	112		
	c. Not specified type or size.		219	

MIL-C-82172B(MC)

Examine	Defect	Classification	
		Major (*)	Minor <u>A</u> <u>B</u>
Material defects and damages.	d. Hook or eye not securely tacked to ends of collar.		220
	e. Not aligned, causing collar ends to be uneven by 1/4 inch or more when front is buttoned and hooks and eyes are fastened.		221
	a. Any weakening defects such as smash, multiple float, or loose slub.	3	
	b. Any hole.	4	
	c. Shade bar, unsightly slub, etc., affecting appearance: - on outside. - on inside.	5	222
	d. Scissors or knife cut, tear, mend, or burn.	6	
	e. Needle chews that may develop into a hole.	7	
<p>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:</p>			
	Material defects Workmanship damages	No defect Minor B defect	

MIL-C-82172B(MC)

Examine	Defect	Classification	
		Major (*)	Minor A B
Pressing	a. Burned or scorched.	8	
	b. Pressing omitted entire garment.		220
	c. Armhole stretched.	9	
	d. Poorly pressed (unless otherwise indicated).		311
	e. Basting or pressing impressions not removed on major portion of coat.		221
	f. Gloss not removed on major portion of coat.		312
	g. Armholes not blocked or poorly blocked, affecting appearance.		222
	h. Edges bulky; i.e., not pressed solid, affecting appearance.		223
	i. Inside of armhole not creased as required.		224
	j. Sleeve not creased at front or backarm seam.		225
	k. Wrinkles or pressing impressions not removed under side or center back seam allowance.		226
	l. Linings not pressed smooth.		227
	m. Armhole seam not pressed open across top as required.		228

MIL-C-82172B(MC)

Examine	Defect	Classification			
		Major (*)	Minor		
			A	B	
Seams and stitchings	a. Accuracy of seaming:	113			
	1. Any seam twisted, puckered, or pleated, affecting appearance.				
	2. Part of garment caught in any unrelated operation or stitching.		10		
	3. Unsightly hand felling or blindstitching exposed on outside of coat affecting appearance.			229	
	4. Ends of all stitching (when not caught in other seams or stitching) not backtacked or backstitched as required.			230	
	5. Wrong color of thread or two shades of thread used on outside of coat, affecting appearance.		11		
	b. Gage of stitching (edge or raised stitching):				
	1. Irregular; i.e., unevenly gaged, or various stitchings not uniform, affecting appearance.			231	
	2. Beyond range of width specified; or varies more than 1/16 inch when no range is specified.				313
	c. Open seams:				
	1. On outside:				
	- up to 1/4 inch inclusive.				314
	- more than 1/4 inch but not more than 1/2 inch.			232	
	- more than 1/2 inch.	114			
2. On inside:					
- more than 1/2 inch (except machine felling).			233		

MIL-C-82172B(MC)

Examine	Defect	Classification	
		Major (*)	Minor A B
	- up to 1/2 inch inclusive (except machine felling).		315
	- up to 1 inch inclusive (machine felling).		316
	- more than 1 inch (machine felling).	234	
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 inch inclusive.		317
	- more than 1/8 inch but not more than 1/4 inch.	235	
	- more than 1/4 inch.	115	
	2. On inside:		
	- more than 1/8 inch but not more than 1/4 inch.		318
	- more than 1/4 inch.	236	
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 open seams.			
	e. Run offs (see classification of open seams).		
	f. Stitch tension:		
	1. Loose tension resulting in loose seam.	116	
	2. Loose tension on raised or edge stitching, resulting in loosely exposed bobbin or top thread.		237

MIL-C-82172B(MC)

Examine	Defect	Classification			
		Major (*)	Minor		
			A	B	
	<p>3. Tight tension (stitches break when normal strain is applied).</p> <p>NOTE: Puckering is evidence of tight tension. When puckering is evident, the inspector shall test seam by exerting pull in lengthwise direction of seam.</p>	117			
	<p>g. Stitches per inch (excluding labels).</p> <p>1. Less than minimum specified:</p> <ul style="list-style-type: none"> - one or two stitches. - three stitches. - four or more stitches. <p>NOTE: To be scored only if condition exists on major portion of seam.</p>	118	238		319
	<p>h. Stitch and seam type:</p> <p>1. Wrong stitch or seam type.</p>		239		
	<p>i. Stitching skipped or broken (on edge or raised stitching when seam is seamed, turned, and stitched):</p> <ul style="list-style-type: none"> - 1/4 inch or more but not more than 1/2 inch. - more than 1/2 inch. 		240		320
Shaded parts	a. Any outside part shaded.		12		
	b. Any lining part badly shaded except sleeve lining.		241		
	c. Sleeve lining parts badly shaded, or parts not matching each other.				321
	<p>4.5.1.3 <u>Detailed defects (outside of coat).</u> Detailed defects on outside of coat with coat buttoned on form shall be classified as follows:</p>				

MIL-C-82172B(MC)

Examine	Defect	Classification	
		Major (*)	Minor A B
Collar (construction and setting)	a. Interlining omitted.	119	
	b. Interlining tight or twisted, causing puckers on collar, affecting appearance.		242
	c. Tight at joining to front or back, causing puckers or pleats at neck of coat, affecting appearance.		13
	d. Piping irregular, affecting appearance.		243
	e. Collar ends overlapping when fastened.		244
	f. Collar ends spread open more than 3/8 inch when fastened.		245
	g. Front finished ends of collar uneven in width by 3/16 inch or more.		246
	h. One ply of outer basic material.	120	
	i. Binding strip at top or bottom edge of interlining omitted.		247
	j. Binding strip at top or bottom edge of interlining other than material specified.		248
	k. Binding strip at top edge of interlining positioned more than 1/8 inch beyond the top edge of the piping on the outer ply of the collar.		249

MIL-C-82172B(MC)

Examine	Defect	Classification	
		Major (*)	Minor A B
Alignment of front buttons and buttonholes	l. Binding strip at the top edge of interlining irregular in width, affecting appearance; or not exposed beyond top edge of piping on outer ply of collar.		242
	m. Collar irregular in width by 1/4 inch or more.		243
	n. Center of eyelets from finished ends of collar:		
	- less than 1-3/8 inches but not less than 1-1/4 inches.		322
	- more than 1-5/8 inches but not more than 1-3/4 inches.		323
	- less than 1-1/4 inches or more than 1-3/4 inches.		244
	o. One or both eyelets off-center with top and bottom edges of collar by more than 1/4 inch.		324
	p. Collar off-center by more than 3/8 inch.		245
	a. Not aligned, causing a noticeable bulge or twist on the fronts when buttoned, affecting appearance.		246
	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.		121	247

MIL-C-82172B(MC)

Examine	Defect	Classification			
		Major (*)	Minor		
			A	B	
	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.				325
			248		
	c. Right front at corner exposed beyond edge of left front by more than 1/8 inch.		249		
Shoulder (construction)	a. Improperly joined or set, causing shoulder or back to twist.		14		
Shoulder pads	a. Not completely caught in armhole tacking.		250		
	b. Misplaced, not serving the intended purpose; i.e., too far back or too far forward.		251		
	c. One or both pad omitted.		252		
Shoulder straps	a. Misplaced; i.e., one strap further forward or back from position of other strap, affecting appearance.		253		
	b. Misplaced, so that it will not lie flat when buttoned, causing bulge or twist on strap.		15		
	c. Poorly shaped.				326
	d. Shoulder seam exposed beyond the back edge of the shoulder strap (except rounded end).		254		

MIL-C-82172B(MC)

Examine	Defect	Classification	
		Major (*)	Minor A B
	e. Width of shoulder strap at armhole seam (including piping):		
	- less than 2-1/4 inches but not less than 2-1/8 inches.		327
	- more than 2-1/2 inches but not more than 2-5/8 inches.		328
	- less than 2-1/8 inches or more than 2-5/8 inches.	255	
	f. Width of shoulder strap across center of buttonhole eyelet (including piping):		
	- less than 1-5/8 inches but not less than 1-1/2 inches.		329
	- more than 1-7/8 inches but not more than 2 inches.		330
	- less than 1-1/2 inches or more than 2 inches.	256	
	g. Rounded end of shoulder strap positioned less than 1/4 inch or more than 3/8 inch from collar edge.		331
	h. Piping irregular in width, affecting appearance.	257	
	i. Upper side of strap full or twisted, affecting appearance.		332
	j. Back edge of strap less than 1/4 inch or more than 1/2 inch from shoulder seam at armhole.		333

MIL-C-82172B(MC)

Examine	Defect	Classification		
		Major (*)	Minor <u>A</u> <u>B</u>	
Position of shoulder strap button and button- hole.	a. Button not aligned with buttonhole causing a bulge or twist on strap or puckers on shoulders, affecting appearance.		258	
	b. Buttons not uniformly set by more than 1/4 inch.		259	
	c. Buttonhole 1/4 inch or more off center.		260	
	d. Buttonhole from outer edge of piping: - less than 5/8 inch, but not less than 1/2 inch, or more than 3/4 inch. - less than 1/2 inch.		261	334
Armholes (construc- tion)	a. Badly stretched, affecting appearance.	16		
	b. Taped too tight, causing puckering around armhole seam, affecting appearance.	17		
	c. Crooked seam, affecting appearance.		262	
	d. Tape stitching exposed and visible on outside surface.			335
	e. Sleeve-head pads not completely tacked to armholes; or misplaced, not serving intended purpose.		263	
	f. One or both sleeve-head pads omitted.		264	

MIL-C-82172B(MC)

Examine	Defect	Classification	
		Major (*)	Minor A B
Sleeves	a. Setting and hang:		
	1. Sleeve fullness misplaced, affecting appearance.		265
	2. Backarm seam of sleeve not matching side back seam by:		
	- more than 1/4 inch but not more than 1/2 inch.		266
	- more than 1/2 inch.	122	
	3. Hang of sleeves on the same coat in opposite direction by more than 2 inches.		267
	4. Sleeve tight in armhole, i.e., roll effect not present.		268
	b. Sleeve lining:		
	1. Twisted, tight, or short, causing bulge, twist, or puckering on outside of sleeves.		18
	2. Sleeve lining too long, causing lining to sag at bottom more than 1/2 inch.		336
	3. Sleeve lining seams out of alignment more than 3/4 inch with sleeve seams at armholes or at bottom of the sleeves.		337
	4. Cut dart on undersleeve omitted.		338
	5. One or both darts not pressed flat.		339
	c. Construction of sleeves:		
1. Wigan twisted, tight or pleated, causing ridges or puckering on outside of bottom of sleeves, affecting appearance.		269	

MIL-C-82172B(MC)

Examine	Defect	Classification	
		Major (*)	Minor A B
	2. Tacking on bottom turnup to body of sleeve omitted or insecure.		270
	3. Sleeve bottom edge uneven by more than 1/4 inch.		340
	4. Tacking on one or both sleeve lining seams to sleeve seams omitted or insecure.		341
	5. Bottom edge of sleeve lining turnup less than 1 inch or more than 1-1/4 inches up from bottom edge of sleeve.		342
	d. Ornamental sleeve pieces:		
	1. Piping irregular, affecting appearance.		271
	2. Ornamental piece stitched to sleeve too full or twisted, affecting appearance.		272
	3. Length of ornamental piece (including piping):		
	- less than 5-7/8 inches but not less than 5-5/8 inches.		343
	- more than 6-1/8 inches but not more than 6-3/8 inches.		344
	- less than 5-5/8 inches or more than 6-3/8 inches.		273
	4. Width at top and bottom pts (including piping):		
	- less than 2-3/8 inches but not less than 2-1/8 inches.		345
	- more than 2-5/8 inches but not more than 2-7/8 inches.		346
	- less than 2-1/8 inches or more than 2-7/8 inches		274

MIL-C-82172B(MC)

Examine	Defect	Classification	
		Major (*)	Minor A B
	5. Width at center point (including piping):		
	- less than 2-5/8 inches but not less than 2-3/8 inches.		347
	- more than 2-7/8 inches but not more than 3-1/8 inches.		348
	- less than 2-3/8 inches or more than 3-1/8 inches.	275	
	6. Poorly shaped, affecting appearance.	276	
	7. Set on crookedly, affecting appearance.	277	
	8. Misplaced; i.e., one piece further forward or back from position of other piece, affecting appearance.	278	
	9. Bottom edge not horizontal with bottom edge of sleeve by more than 1/8 inch.	279	
	10. Ornamental piece stitched to sleeve with pointed ends toward forearm seam of sleeve.	123	
	e. Position of buttons on ornamental pieces (measurements made from center of button):		
	1. From top and bottom edges (including piped edge):		
	- less than 3/4 inch but not less than 1/2 inch.		349
	- more than 1 inch but not more than 1-1/4 inches.		350
	- less than 1/2 inch or more than 1-1/4 inches.	280	

MIL-C-82172B(MC)

Examine	Defect	Classification	
		Major (*)	Minor A B
Body (out- side)	2. Top or bottom button from scalloped edge including piped edge:		
	- less than 5/8 inch but not less than 3/8 inch.		351
	- more than 7/8 inch but not more than 1-1/8 inches.		352
	- less than 3/8 inch or more than 1-1/8 inches.	281	
	3. Center button from pointed edge (including piped edge):		
	- less than 7/8 inch but not less than 5/8 inch.		353
	- more than 1-1/8 inches but not more than 1-3/8 inches.		354
	- less than 5/8 inch or more than 1-3/8 inches.	282	
	4. Center button not in line with pointed edge by more than 1/4 inch.	283	
	a. Fitting of body lining:		
	1. Tight, short, or twisted, causing fullness or twist on outside of coat, affecting appearance.	19	
	b. Fitting of front interlinings:		
1. Tight, short, or twisted, causing fullness or twist on outside of coat, affecting appearance.	20		
2. Too full, causing coat front to have a wavy appearance.	21		

MIL-C-82172B(MC)

Examine	Defect	Classification			
		Major (*)	Minor A	Minor B	
Chest darts	a. One or both omitted.	124			
	b. Ends of one or both darts not properly tapered, causing bulge or fullness, affecting appearance.		284		
	c. Darts not of uniform length by 1/4 inch or more.				355
	d. Cut edges of dart not turned towards armhole.				356
	e. Not pressed smooth and flat, affecting appearance.		285		
Waist darts	a. One or both omitted.	125			
	b. Top or lower end of one or both darts not properly tapered, causing bulge or fullness, affecting appearance.		286		
	c. Length of darts not uniform in length by 1/4 inch or more.				357
	d. Folded edge not pressed toward side seam.				358
	e. Not pressed smooth and flat.		287		
	f. Alignment of both waist darts: - top or bottom end out of horizontal alignment by 1/4 inch or more.				359

MIL-C-82172B(MC)

Examine	Defect	Classification			
		Major (*)	Minor		
			A	B	
Ornamental front braid (position, construction and setting)	a. One or more rows of braid omitted or added.	126			
	b. One or more rows of braid on left front not horizontally aligned with corresponding row on right front by more than 1/2 inch.	127			
	c. One or more rows of braid not formed with a figure 8.	128			
	d. Diameter of figure 8 circle less than 27/32 inch or more than 7/8 inch.				360
	e. Stitching of one or more rows of braid not started or ended as indicated by figure 6.				361
	f. Stitching on one or more rows of braid not uniform in width, affecting appearance.				362
	g. Ends of stitching on one or more rows of braid not securely tacked.			288	
	h. One or more rows of braid not lying smooth; i.e., puckered, twisted, pleated or having excessive fullness, affecting appearance.		22		
	i. One or more rows of braid set on tight, causing puckers, twists or pleats on front.		23		
	j. Braid not pressed smooth or flat.				363

MIL-C-82172B(MC)

Examine	Defect	Classification	
		Major (*)	Minor A B
Front and bottom edges	k. Braid loop around one or more buttonholes not properly positioned, restricting use of the buttonhole.		289
	l. Front edge of one or more rows of braid on left front finished less than 1/4 inch from piping joining seam.		290
	m. Any row of braid on left front out of vertical alignment by more than 1/8 inch.		291
	a. Front edges stretched, affecting appearance.		292
	b. Tape or piping set on tight, causing puckering on front, affecting appearance.		293
	c. Front or bottom piping irregular, affecting appearance.		294
	d. Bottom edge stretched, puckered, or uneven, affecting appearance.		364
	e. Bottom corner of left front poorly shaped, affecting appearance.		295
	f. Left front rolling outward below bottom button.	24	
	g. Front edge irregular, affecting appearance.		296

MIL-C-82172B(MC)

Examine	Defect	Classification	
		Major (*)	Minor <u>A</u> <u>B</u>
	h. Piping tight on front or bottom edge, causing puckering outside of coat, affecting appearance.		297
	i. Left front not dressed as specified.		298
Front facings	a. Short, tight or twisted, causing fullness or twists on fronts, affecting appearance.	25	
Back side panel seams	a. Curved panel seam on back of coat stretched or distorted, affecting appearance.		299
Belt loops (construction and position)	a. Poorly shaped or not of uniform shape or size, affecting appearance.		201a
	b. Pointed end of one or both loops not toward top of coat.		202a
	c. 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.		203a
	d. One or both not stitched on the side seam.		204a
	e. One or both not vertically straight; i.e., set on an angle, affecting appearance.		205a
	f. Alignment of both loops: - top or bottom end out of horizontal alignment by more than 1/4 inch.		206a

MIL-C-82172B(MC)

Examine	Defect	Classification			
		Major (*)	Minor		
			A	B	
Belt loop buttonhole and button (position and button attachment)	g. One or more edges not properly forced out; i.e., having a fold or lip of 1/8 inch or more.				365
	h. Bottom of loop not centered on side seam by more than 1/4 inch.				366
	a. Button not aligned with buttonhole, causing a bulge or twist on loop or puckers on coat, affecting appearance.			207a	
	b. Buttons not uniformly set by more than 1/4 inch.				367
	c. Buttonhole 1/4 inch or more off center.			208a	
	d. Buttonhole from pointed end of loop: - less than 1/2 inch or more than 3/4 inch.				368
Cut opening for belt loop buttons	e. Reinforcement disc beneath one or both buttons omitted.				369
	a. One or both omitted.	129			
	b. Opening not constructed vertically.			209a	
	c. One or more ends on one or both openings not securely tacked.			210a	
	d. Opening constructed through body lining.	130			

MIL-C-82172B(MC)

Examine	Defect	Classification		
		Major (*)	Minor A B	
Front buttonholes (position)	e. Misplaced; i.e., more than 1/4 inch from marks indicated by patterns or not positioned on side seam.		211a	
	a. Position from front edge including piped edge:			
	- less than 1/2 inch but not less than 3/8 inch.		370	
	- more than 3/4 inch but not more than 7/8 inch.		371	
	- less than 3/8 inch or more than 7/8 inch.		212a	
	b. More than 1/4 from equal spacing.		213a	
Front buttons (position)	c. Top or bottom buttonhole positioned more than 1/2 inch from pattern marks.		214a	
	d. Unevenly spaced from front edge by more than 3/16 inch.		215a	
	a. Out of vertical alignment by 1/4 inch or more.		216a	
	b. Center of top button not in vertical alignment with right end of collar by 1/4 inch or more.		217a	
	4.5.2.4 Detailed defects (inside of coat). Detailed defects on inside of coat shall be classified as follows:			
	Right front eyelet cover (construction, presence and position)	a. Front raw edges not stitched together prior to seaming to right facing.		218a
b. Upper or lower seamed edge not hand felled to facing.			219a	

MIL-C-82172B(MC)

Examine	Defect	Classification	
		Major (*)	Minor A B
Labels	c. Upper or lower seam edge not securely handstitched to facing.		372
	d. Omitted.	131	
	e. Front corner of eyelet cover exposed beyond upper edge of right front.		373
	f. Front edge of cover positioned less than 1/4 inch or more than 3/4 inch in from front edge of right front.		220a
	a. Any required label missing, incorrect, illegible; or size label not securely caught in stitching.	132	
	b. Identification label not stitched on 4 sides.		221a
Hanger	c. Bottom edge of identification label less than 3 inches or more than 5 inches from bottom finished edge of coat.		374
	d. Identification label not stitched to outside of right facing.		375
	a. Hanger omitted or ends not securely stitched.	133	
	b. Less than 1-7/8 inches or more than 2-1/8 inches long measured along the lower edge of the collar lining.		222a

MIL-C-82172B(MC)

Examine	Defect	Classification		
		Major (*)	Minor <u>A</u> <u>B</u>	
Front facings	c. Hanger not stitched to neck of coat prior to seaming collar to neck of coat.		223a	
	d. Finished width less than 1/4 inch or more than 3/8 inch wide.			376
	a. Fullness or pleats on facings between eyelets; buttonholes; or between front edge and eyelet or buttonholes.		224a	
	b. Tacking on back edge to 1 or both interlinings: - omitted. - 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.		225a	377
Body linings	c. Felling at bottom edge of front facings or back omitted or insecure on one or both facings.		226a	
	d. Felling along folded edge of one or both facings at collar notch omitted or insecure.		227a	
	a. Excessive puckering or pleated.			378
	b. Twisted, not affecting smoothness on outside of coat.			379
	c. One or both chest pleats on shoulder omitted.		228a	

MIL-C-82172B(MC)

Examine	Defect	Classification	
		Major (*)	Minor A B
Lining (securing straps)	d. Folded edge of 1 or both chest pleats facing front edge of coat.		380
	e. Pleat omitted at center of back lining.	229a	
	f. Pleat less than 1/2 inch in depth at center of back lining.		381
	g. Bottom hem less than 5/8 inch or more than 7/8 inch wide.		382
	h. Lining too long; i.e., exposed beyond bottom edge of coat.	230a	
	i. Facing-lining seam, side seams, and side back seams not towards back or not pressed smooth and flat.	231a	
	j. Waist darts not towards the side seams or not pressed smooth and flat.	232a	
	a. One or both omitted or insecure.	233a	
	b. Less than 1/4 inch or more than 3/8 inch wide.		383
	c. One or both positioned more than 1 inch from side seam.		384
	d. End of one or both straps not finished between the piping at the bottom edge of the coat and the side seam allowance.		385

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Examine	Defect	Classification	
		Major (*)	Minor A B
Serge or overedge stitching	e. One or both not folded and stitched across width.		386
	f. One or both not properly attached to the lining hem or coat, causing twist or distortion to either the lining or the coat.	234a	
	g. One or both exposed beyond bottom edge of the coat.	235a	
	a. Basic material: - omitted on one or more raw edges for seams joining fronts and back where specified.	236a	
	b. Lining joined seams: - omitted on one or more seams where specified.	237a	
	Underarm shields	a. One or both omitted.	238a
b. Not two-piece lining construction.		239a	
c. Tacking on one or both shields along side or bottom edge to body lining omitted or insecure.			387
d. Top edge not caught in armhole tacking or stitching when tacked by hand.			388
e. Puckered, pleated, or twisted.			389
f. One or both shields misplaced, not serving intended purpose.			390

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Examine	Defect	Classification	
		Major (*)	Minor A B
Inside of armhole	a. Backstitching at armpit of armhole, from backarm seam of sleeve to front edge of shield, omitted.		391
Collar lining extension piece	a. Omitted.	134	
	b. Extended less than 1/2 inch or more than 1 inch beyond left end of collar.		392
	c. Felling omitted or insecure at end or top edges.		240a
	d. Stitching at top, front and bottom edges, or across width of collar tab (forming box stitch) omitted.		241a
Collar lining and eyelet covers	a. Ends of collar lining not securely tacked.		242a
	b. One or both eyelet covers omitted.		243a
	c. One or both eyelet covers not covering eyelet.		244a
	d. Width of collar eyelet less than 1-5/8 inches or more than 1-7/8 inches.		393
	e. Felling on front edge and along lower corner of one or both eyelet covers omitted.		245a
	f. Felling along lower corners of one or both eyelet covers extending for a distance or more than 3/4 inch.		394

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Examine	Defect	Classification	
		Major (*)	Minor A B
	g. Top or bottom hook positioned respectively less than 1/4 inch from the top or bottom edges of collar.		395
	h. Remaining hook not positioned midway between top and bottom hook.		396

4.5.2.5 Finished measurements. Any measurement deviating from nominal dimensions and tolerance included in table II shall be scored as a size measurement defect. Sleeve lengths uneven by more than 1/2 inch shall be scored as a size measurement defect. The inspection level shall be S-3 (see 6.5).

4.6 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 one 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-3 (see 6.5).

<u>Examine</u>	<u>Defect</u>
Marking (exterior and interior)	Omitted; incorrect; illegible; or 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, or inadequate stapling. Bulging or distortion of containers.
Contents	Number of coats per container is more or less than required.

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4.7 Tests. Tests shall be in accordance with the following:

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

4.7.2 Test for tackiness. At room temperature (60°F 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, and shall fall free when pressure is released.

4.7.3. Quantity of gold and silver. At least two pieces, 1 yard each, shall be assayed for the quality of gold and silver. The quantities of gold and silver may be determined by standard commercial methods of assay, but in case of dispute, shall be determined in accordance with 4.7.3.1 and 4.7.3.2, respectively.

4.7.3.1 Gold content. Boil sufficient braid to bear 1 gram of alloy (accurately weighed) with 60 milliliters (ml) 1:1 nitric acid (HNO₃) in a 400 ml beaker using a small flame or hot plate. Continue boiling until all metals except the gold are in solution. Dilute to 200 ml with hot water. Filter through a rapid ashless filter paper, and wash several times with hot water. Take the filter paper with the gold (cutting off any excess filter paper), wrap in a 2-inch by 2-inch piece of silver-free lead foil, and roll into a ball. Place the ball in the hollow of a bone ash cupel, and add lead shot around the ball. Place cupel in a muffle furnace for 1 hour at 1,000°C. Remove from the furnace, and examine hollow for flakes of gold, impurities and discolored gold bead. If any are noticed, add additional lead shot and return cupel to the muffle furnace for 1 hour. Otherwise, cool the gold bead and weigh. The gold content shall be calculated as follows:

$$\text{Gold Content} = \frac{W(\text{Au}) \times 100}{WS} = P(\text{Au})$$

Whereas: W(Au) - Weight of gold
 WS - Weight of sample
 P - Percent of gold

4.7.3.2 Silver content. Dilute the filtrate, from 4.7.3.1 to a 1,000 ml volumetric flask, and dilute to the mark. Pipette a 200 ml aliquot from the flask into a 400 ml beaker. Heat to boiling, and add hydrochloric acid (3:100) drop by drop from a pipette until precipitation is complete (1 ml of hydrochloric acid solution precipitates about 0.038 grams of silver). When solution has cooled and precipitate has settled, determine

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whether precipitation is complete by adding a few drops of the hydrochloric acid (3:100). If solution remains clear, filter on a weighed porcelain Gooch crucible. Wash the precipitate several times with HNO₃ (1:200) and finally with cold water. Protect the silver chloride from the light, dry in an oven for not less than 2 hours, cool and weigh. The silver content shall be calculated as follows:

$$\text{Silver Content} = \frac{W (\text{AgCl}) \times 752.63 \times 5}{WS}$$

Whereas: W(AgCl) - Weight of silver chloride
 WS - Weight of sample minus weight of gold

4.7.3.3 Alloy content. Alloy content is ascertained by the difference between the gold and silver content.

5. PACKAGING

5.1 Packaging. Packaging shall be commercial.

5.1.1 Commercial. Coats shall be packaged to afford adequate protection against physical damage during shipment from the contractor to the first receiving activity. The package and quantity per package shall be the same as that normally used by the contractor for retail distribution.

5.2 Packing. Packing shall be commercial.

5.2.1 Commercial. Packing containers shall be in accordance with Uniform Freight Classification Rules; U.S. Postal Service Manual; National Motor Freight Classification Rules or regulations of other carriers applicable to the mode of transportation.

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

6. NOTES

(This section contains information of a general or explanatory nature that may be helpful, but is not mandatory.)

6.1 Intended use. The coats described herein are intended for wear by enlisted male personnel of the U.S. Marine Corps Drum and Bugle Corps (Drum Major).

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6.2 Acquisition requirements. Acquisition documents shall specify the following:

- 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 4.4).
- e. Acceptance criteria (see 6.5).

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

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

6.5 Acceptance criteria. The acceptance criteria below are recommended for use. The acceptance criteria as specified in the contract or purchase order shall be binding. Unless otherwise specified, the following acceptance criteria are in accordance with MIL-STD-105.

6.5.1 For end item visual examination. An acceptance quality level (AQL), expressed in terms of defects per hundred units, of 1.5 for major defects, 10.0 for major and minor A combined and 40.0 for major, minor A and B combined is recommended.

6.5.2 For end item dimensional examination. An AQL, expressed in terms of defects per hundred units, of 10.0 is recommended.

6.5.3 For packaging examination. An AQL, expressed in terms of defects per hundred units, of 4.0 is recommended.

6.6 Figures. Figures are furnished for information purposes only. To the extent of any inconsistencies between the written specification and the figure, the written specification shall control.

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6.7 Subject (Key word) listing.

Dress
Enlisted
Music

6.8 Marginal notations. Asterisks are not used in this revision to identify changes with respect to the previous issue, due to extensive changes.

Preparing activity:
Navy - MC
Project No. 8405-N132

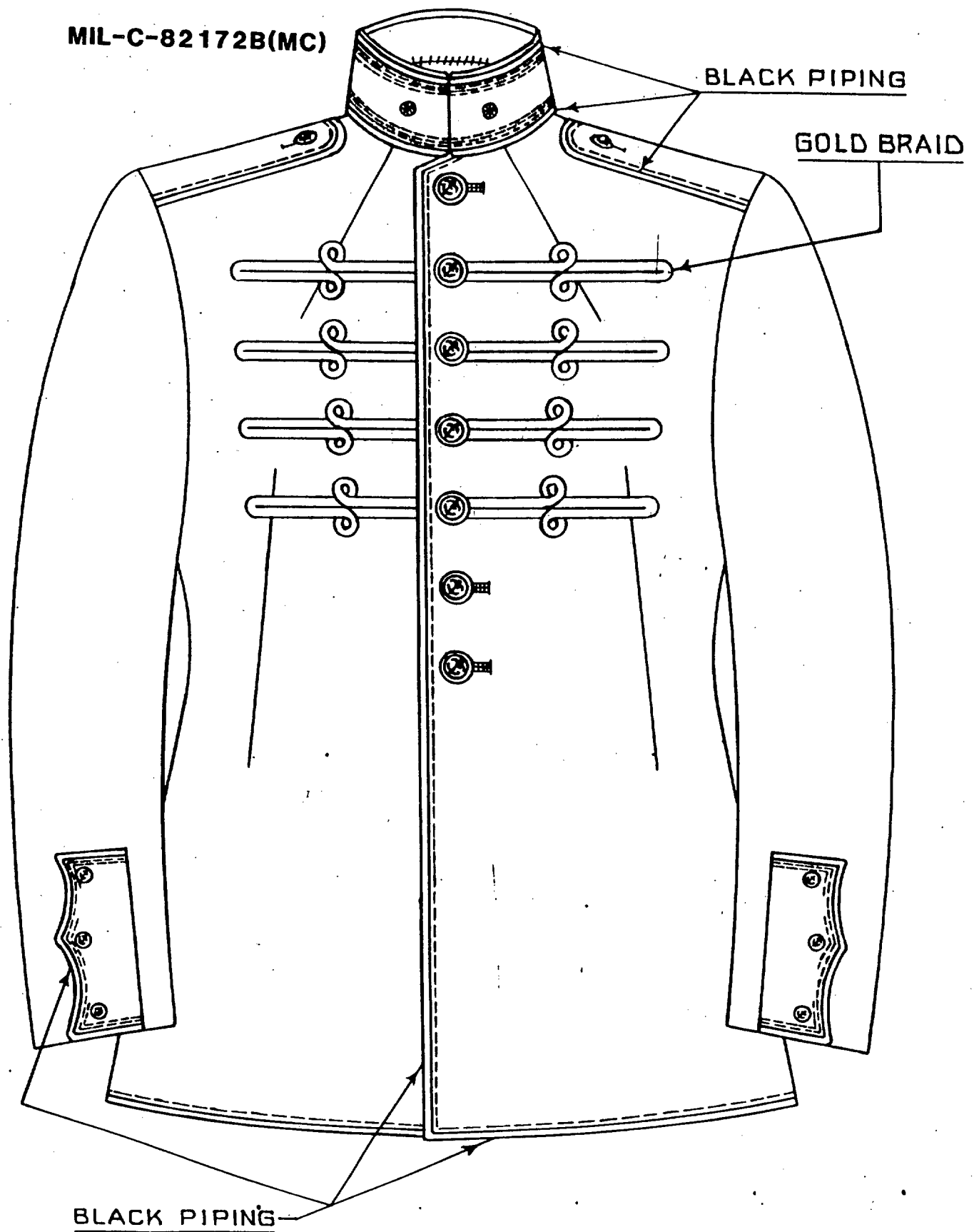


FIG. 1. COAT, MAN'S: SCARLET,
DRUM AND BUGLE CORPS; DRUM MAJOR

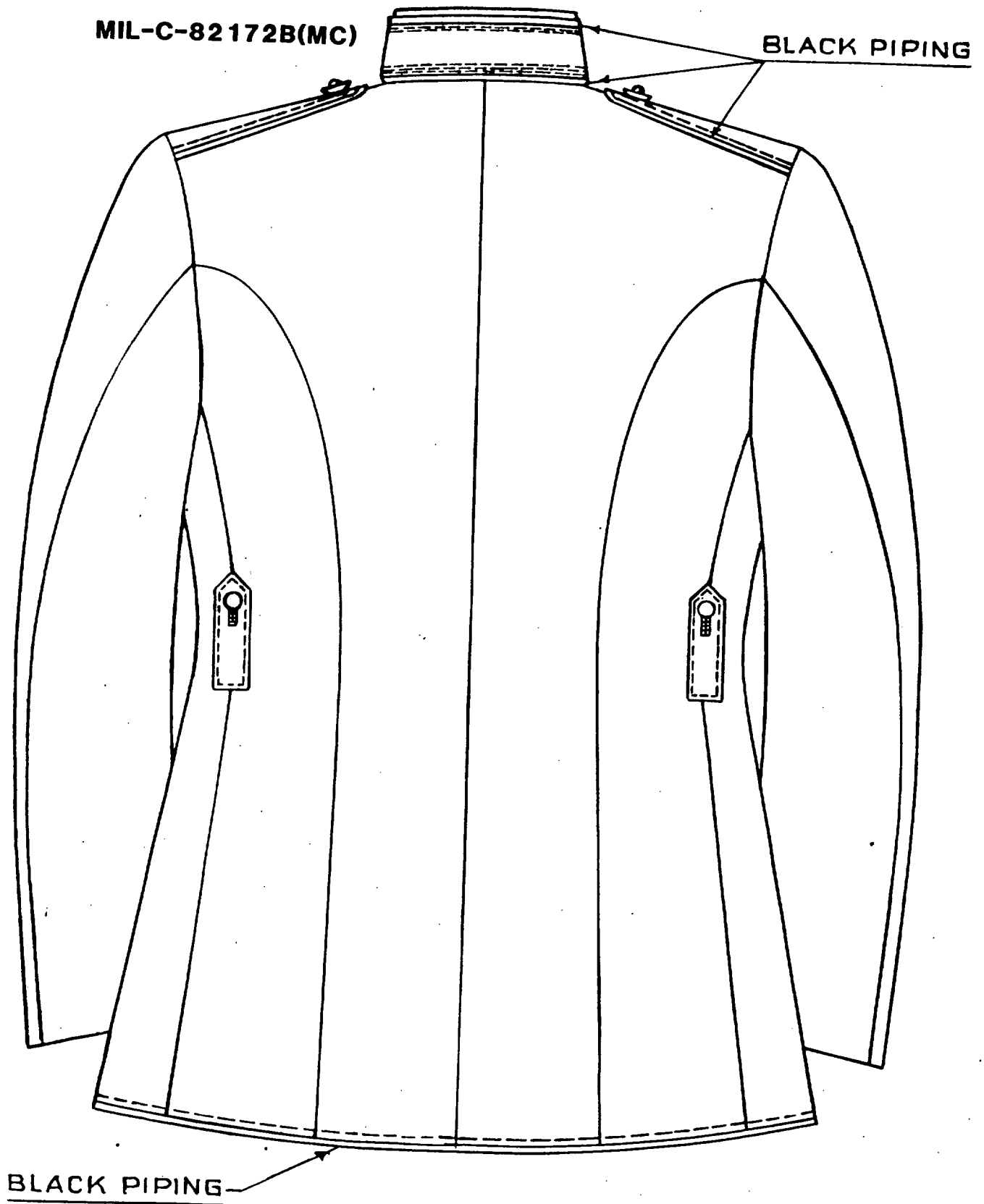
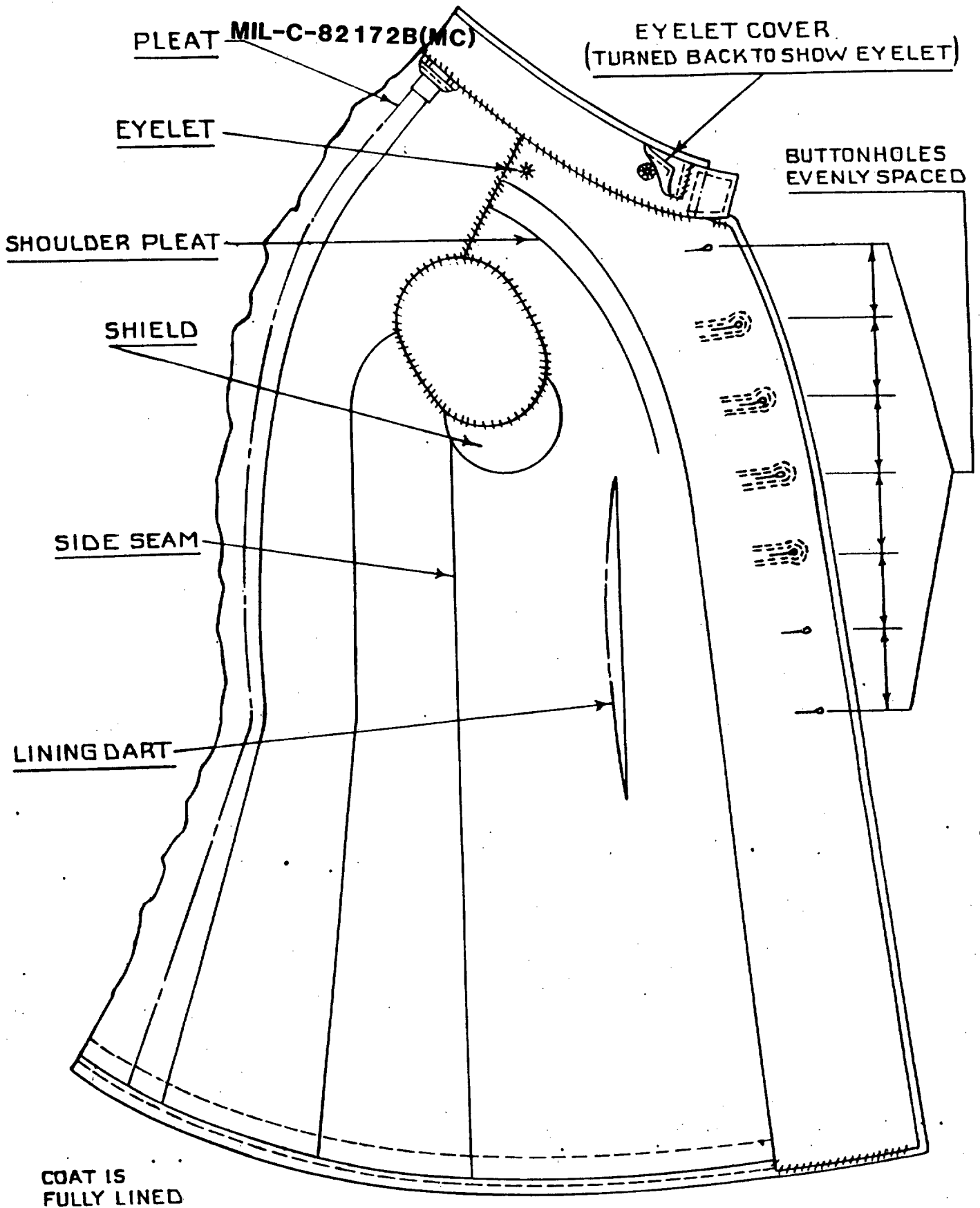
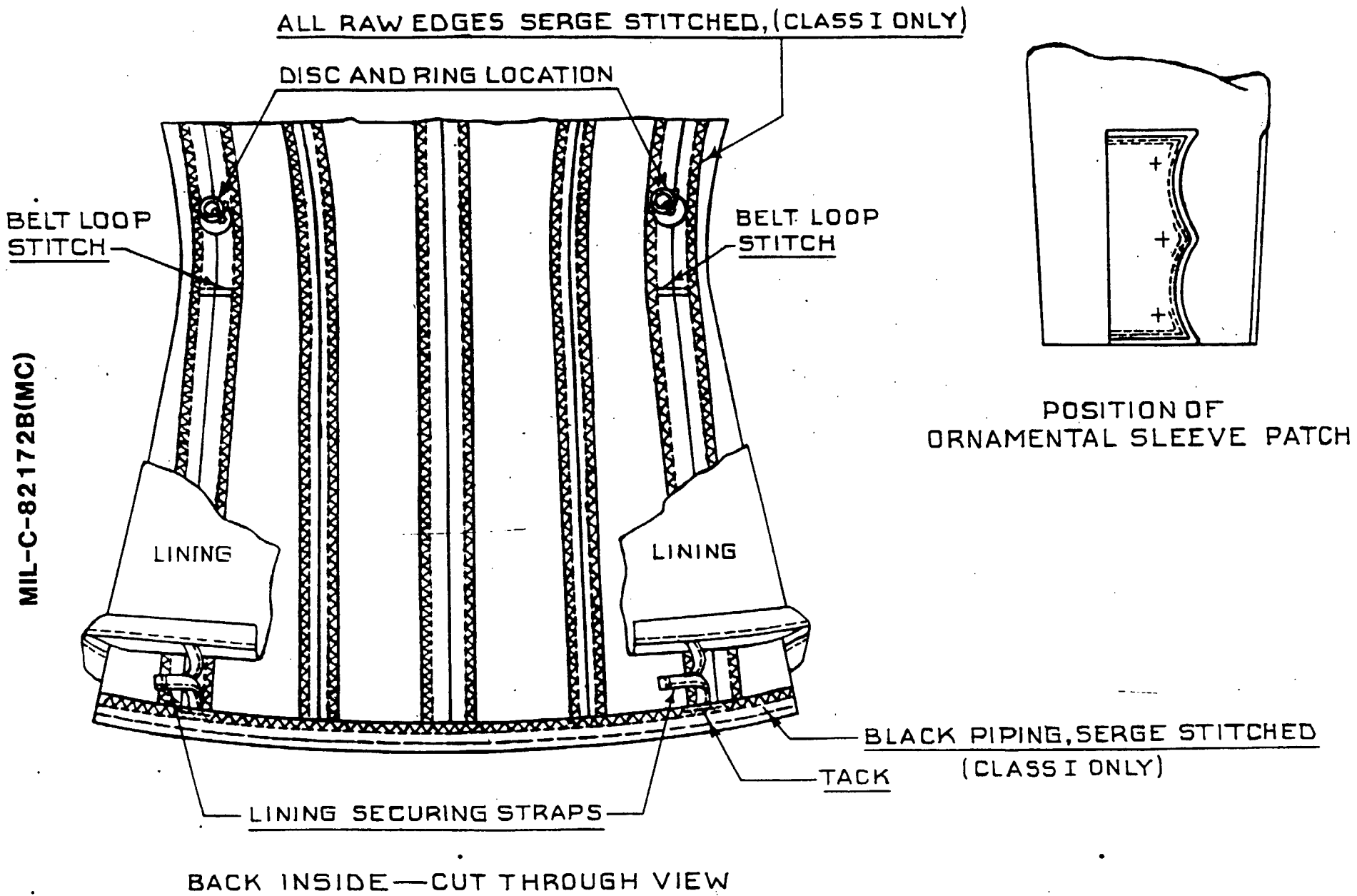


FIG. 2. COAT, MAN'S: SCARLET,
DRUM AND BUGLE CORPS; DRUM MAJOR



LEFT INSIDE VIEW

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



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ALL RAW EDGES SERGE STITCHED, (CLASS I ONLY)

DISC AND RING LOCATION

BELT LOOP STITCH

BELT LOOP STITCH

LINING

LINING

LINING SECURING STRAPS

TACK

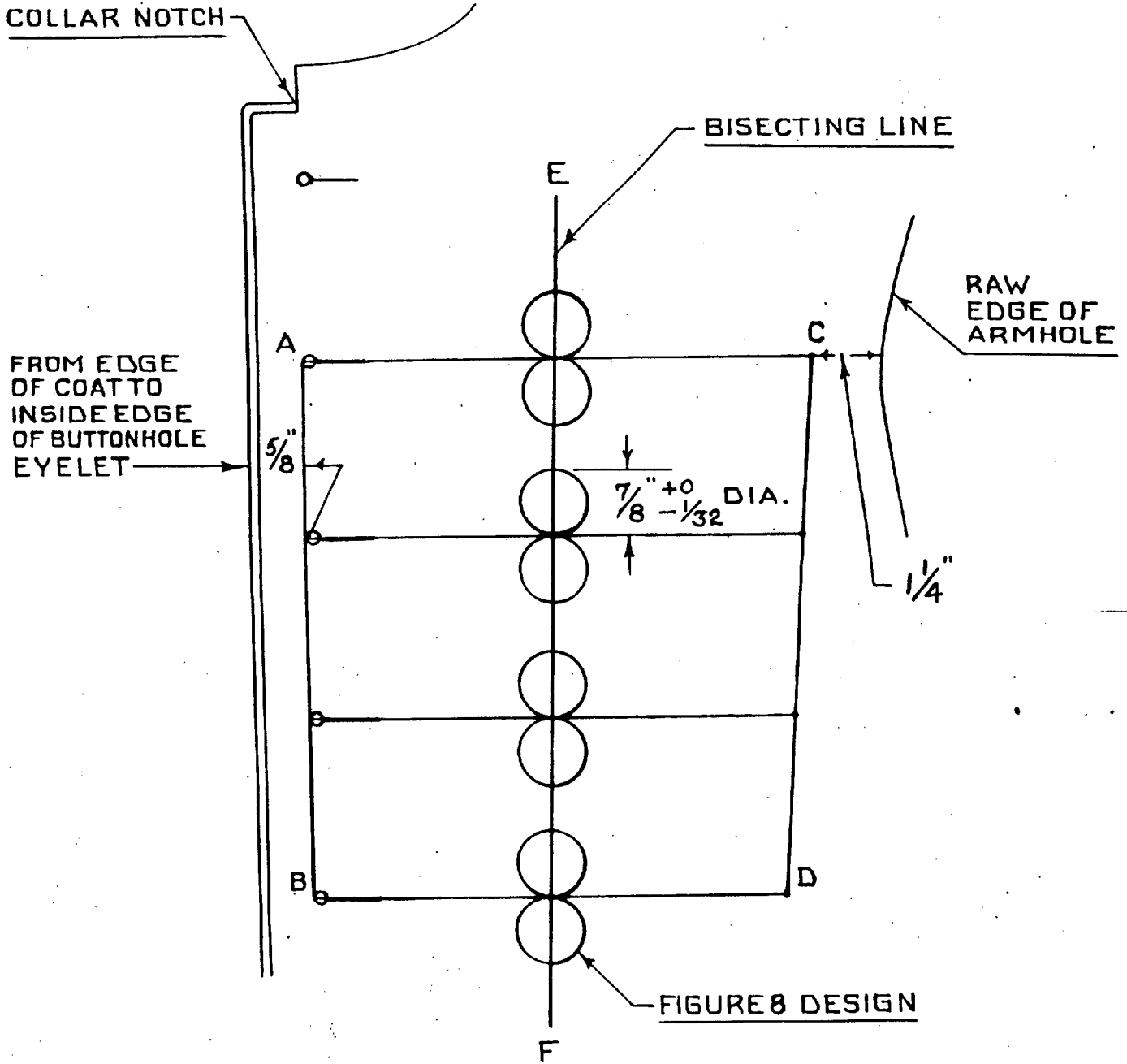
BLACK PIPING, SERGE STITCHED (CLASS I ONLY)

POSITION OF ORNAMENTAL SLEEVE PATCH

BACK INSIDE—CUT THROUGH VIEW

FIG. 4. COAT, MAN'S: SCARLET, DRUM & BUGLE CORPS; DRUM MAJOR

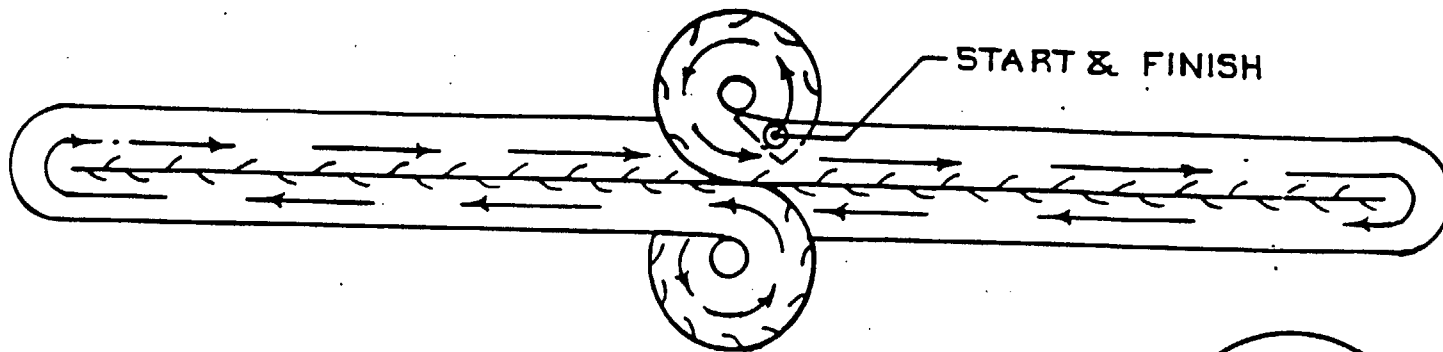
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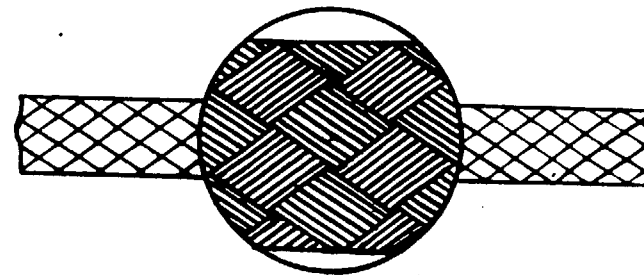
BRAID PLACEMENT DIAGRAM — LEFT FRONT

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

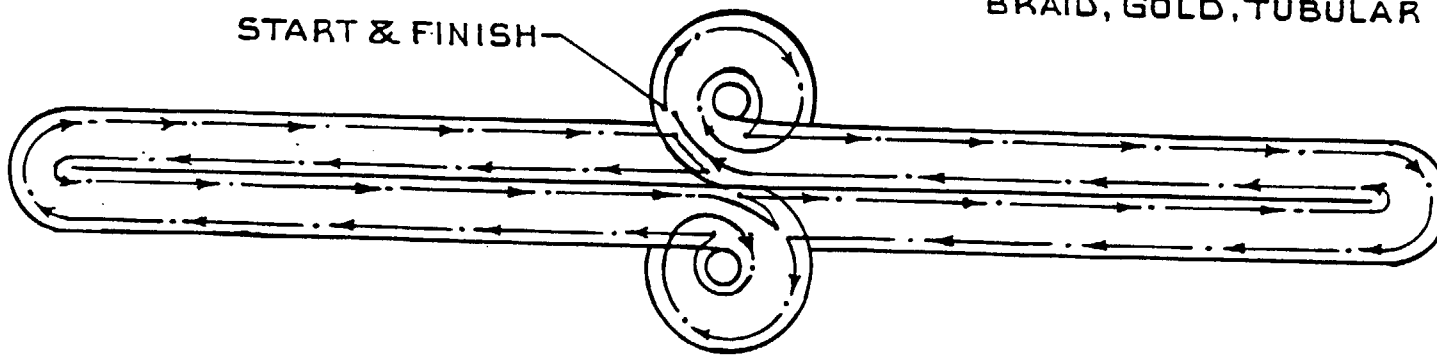
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BASTE BRAID



BRAID, GOLD, TUBULAR (DETAIL)



STITCHING DIAGRAM

RIGHT FRONT OF COAT:— (REVERSE FOR LEFT FRONT)

FIG. 6. COAT, MAN'S: SCARLET,
DRUM AND BUGLE CORPS; DRUM MAJOR

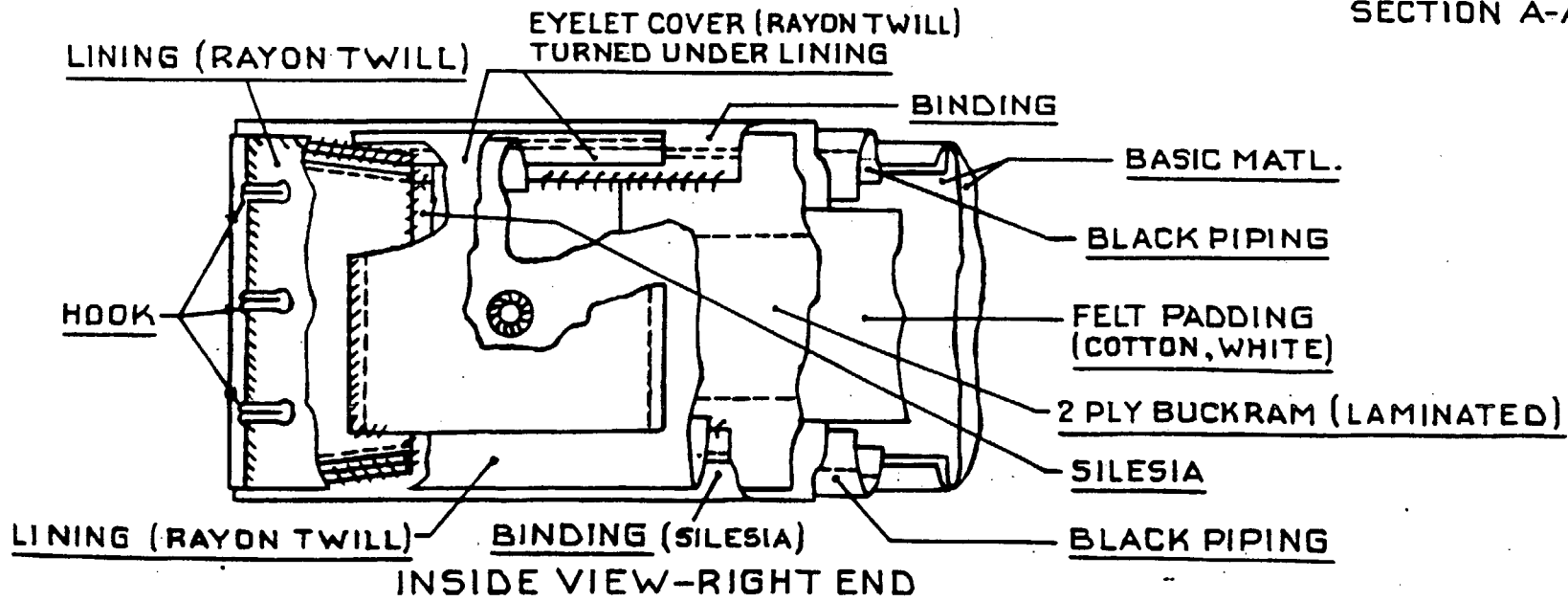
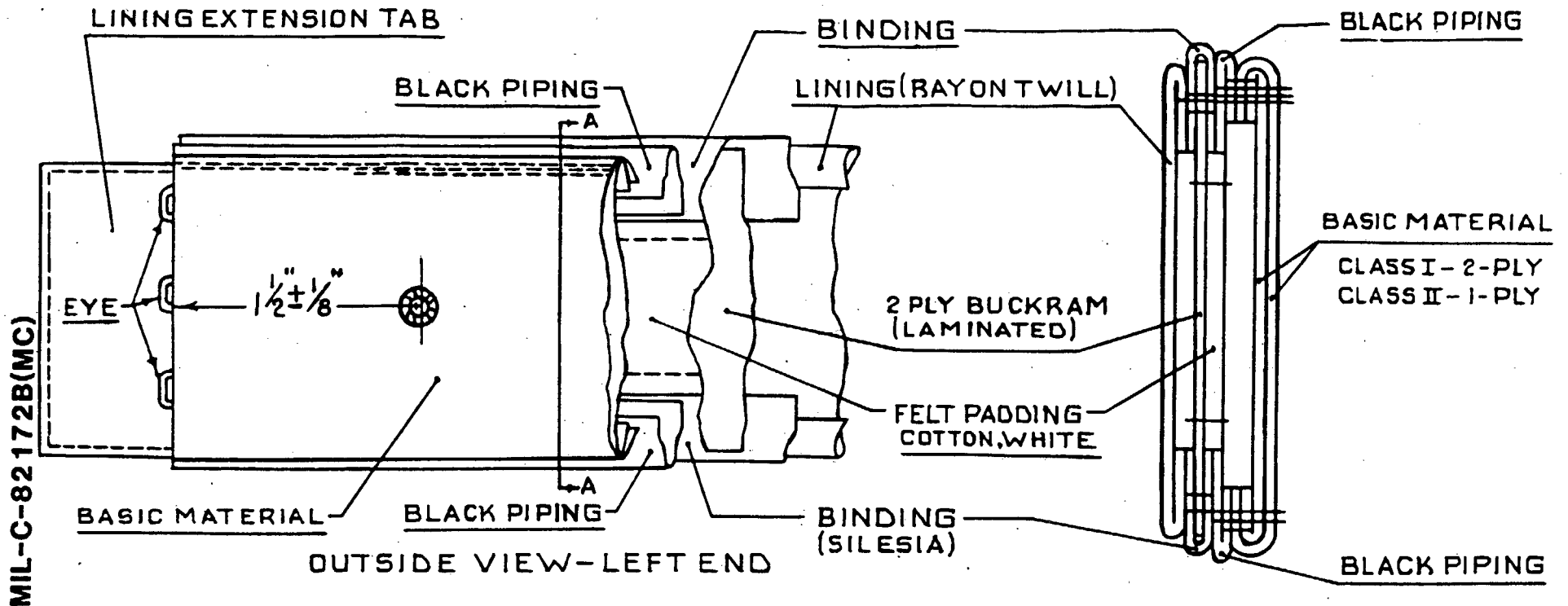


FIG. 7. COAT, MAN'S: SCARLET, DRUM & BUGLE CORPS; DRUM MAJOR

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I RECOMMEND A CHANGE:

1. DOCUMENT NUMBER

MIL-C-82172B(MC)

2. DOCUMENT DATE (YYMMDD)

19 JULY 1990

3. DOCUMENT TITLE

COAT, MAN'S: SUMMER AND WINTER, SCARLET, DRUM AND BUGLE CORPS, DRUM MAJOR

4. NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)

5. REASON FOR RECOMMENDATION

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b. ORGANIZATION

c. ADDRESS (Include Zip Code)

d. TELEPHONE (Include Area Code)

(1) Commercial

(2) AUTOVON
(If applicable)

e. DATE SUBMITTED
(YYMMDD)

PREPARING ACTIVITY

a. NAME

Commanding General, Marine Corps Research,
Development, and Acquisition Command (PSE-C)

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