

INCH-POUND

MIL-DTL-28920C(MC)

23 July 1997

SUPERSEDING

MIL-T-28920B(MC)

28 March 1994

DETAIL SPECIFICATION

TROUSERS, MEN'S - DRESS (OFFICER'S)

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

1. SCOPE

1.1. Scope. This specification covers requirements for officer's dress trousers.

1.2. Classification. The trousers will be of the following types, classes, styles, and sizes as specified (see 6.2).

Types

- Type I - General Officers
- Type II - Marine Band Officers
 - Class 1 - Cloth, tropical, wool, polyester/wool
 - Class 2 - Cloth, broadcloth, wool
- Type III - Other Officers

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to the Commander (PSE-D), Marine Corps Systems Command, Quantico, VA 22134-5010 by using the Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8405

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

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Style

- Style A - With watch pocket
 Style B - Without watch pocket

Schedule of sizes

Waist (inches)	26	28	30	32	34	36	38	40	42	44
Inseam lengths (inches)	29	29	29	29	29	29	29			
	31	31	31	31	31	31	31	31	31	31
		33	33	33	33	33	33	33		
		35	35	35	35	35	35	35		

1.3. Individual orders. When trousers are custom tailored to an individual order, this specification will govern, except the detail requirements of Section 3, Table I may be modified to the extent necessary for good custom tailoring practice.

2. APPLICABLE DOCUMENTS

2.1. General. The documents listed in this section are specified in sections 3 and 4 of this specification. This section does not include documents cited in other sections of this specification or recommended for additional information or as examples. While every effort has been made to ensure the completeness of this list, document users are cautioned that they must meet all specified requirements documents cited in sections 3 and 4 of this specification, whether or not they are listed.

2.2. Government documents.

2.2.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues 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 (see 6.2).

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SPECIFICATIONS

FEDERAL

- A-A-50186 - Cloth, Buckram, Woven and Nonwoven
- A-A-50196 - Thread, Silk
- A-A-50198 - Thread, Gimp, Cotton, Buttonhole
- A-A-52071 - Tape, Textile, Cotton, General Purpose,
(Unbleached, Bleached or Dyed)
- A-A-52094 - Thread, Cotton
- A-A-52106 - Cloth, Twill or Plain Weave, Polyester and
Polyester Blend
- DDD-L-20 - Label: For Clothing, Equipage, and Tentage,
(General Use)
- V-B-871 - Button, Sewing Hole and Button, Staple
(Plastic)
- V-F-106 - Fastener, Slide, Interlocking

DEPARTMENT OF DEFENSE

- MIL-C-10176 - Cloth, Gabardine: Wool, Polyester and Wool
- MIL-DTL-20271 - Lace, Gold - Ornamental
- MIL-C-21115 - Cloth, Tropical: Wool, Polyester/Wool
- MIL-C-29405 - Cloth, Broadcloth: Wool and Wool/Nylon

STANDARDS

FEDERAL

- FED-STD-751 - Stitches, Seams and Stitchings

DEPARTMENT OF DEFENSE

- MIL-STD-1488 - Provisions for Evaluating Quality of
Trousers

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

2.3. Non-Government publications. The following document(s) form a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DoD adopted are those listed in the issue of the DoDISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DoDISS are the issues of the documents cited in the solicitation (see 6.2).

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Department of Defense (DoD) Standard Color Card of Official
Standardized Shades for Sewing Threads 1968

Department of Defense (DoD) Standard Shades for Buttons 1966

(Application for copies should be addressed to the Color
Association of the United States, Inc., 409 W. 44th Street, New
York, NY 10016-0927).

2.4. 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 sample. Standard samples are furnished solely for
guidance and information to the contractor (see 6.3). Variations
from this 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 in accordance with 4.3.

3.3. Materials.

3.3.1 Basic material. The basic material for each type and
class trousers shall be as follows (see 6.3).

3.3.1.1. Type I. Cloth for the type I trousers shall be cloth,
gabardine, polyester/wool, dark blue, shade 2312, 10.6 ounce,
conforming to type II, class 12 of MIL-C-10176, or approved 16
ounce wool elastique.

3.3.1.2. Type II.

3.3.1.2.1 Class 1. Cloth for the class 1 trousers shall be
cloth, tropical, wool, polyester/wool, 8.5 to 9.5 ounces, black,
shade 2607, conforming to type III of MIL-C-21115.

3.3.1.2.2 Class 2. Cloth for the class 2 trousers shall be
cloth, broadcloth, wool, dark blue, shade 2307, conforming to
type 1 of MIL-C-29405.

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3.3.1.3. Type III. Cloth for the type III trousers shall be cloth, gabardine, polyester/wool, sky blue, shade 2319, 10.6 ounce, conforming to type II, class 12 of MIL-C-10176, or approved 16 ounce wool elastique.

3.3.2 Ornamental stripes. The ornamental stripes for trousers shall be made of cloth, broadcloth, wool, scarlet, shade 2501, conforming to type I of MIL-C-29405.

3.3.3 Pocketing, lining, and interlining. The material for lining the pockets, waistband, right fly, pocket flaps, crotch, left fly interlining, and pocket stay shall be black polyester, polyester and cotton or polyester and rayon cloth conforming to class 1 of A-A-52106.

3.3.4 Buckram. The material for interlining waistbands shall be cloth, buckram, cotton, natural shade, conforming to type I of A-A-50186.

3.3.5 Stay tape. The tape for the front edge of the side pocket shall be cotton, 1/4 inch wide, conforming to type II, class 1 of A-A-52071.

3.3.6 Lace. The lace for the outseams of type II trousers shall be lace, gold, ornamental, conforming to class 3 of MIL-DTL-20271.

3.3.7 Slide fastener. The slide fastener for the fly shall conform to type I, style 1, brass, natural finish, size LS, with the short tab pull as specified in V-F-106. The tape shall show good fastness to wet (dry) cleaning. The color of the tape shall be black, shade G, cable No. 66507.

3.3.8 Thread and gimp.

3.3.8.1. Thread. All outside seaming and stitching shall be performed with silk thread conforming to type I of A-A-50196 and all other seaming and stitching with cotton thread conforming to A-A-52094.

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Operation	Type	Ticket No.	Ply	Material	Needle or Bobbin
Topstitching	--	A	3	Silk	Needle
	III	A	3	Cotton	Bobbin
Inseaming, outseaming, seat seaming	III	A	3	Cotton	Both
Bartacks, inside	II	40	3	Cotton	Bobbin
Bartacks, outside	--	A	3	Silk	Needle
Serging	II	70	2	Cotton	Both
Attaching belt loops	II	A	3	Cotton	Bobbin
Buttonholes	--	A	3	Silk	Bobbin
	III	A	3	Cotton	Needle
Buttons	II	24	4	Cotton	Both
All other seaming and stitching	I	40	3	Cotton	Both

3.3.8.2. Gimp. The buttonhole gimp shall be cotton, ticket No. 8, soft or glazed finish, conforming to type I or II of A-A-50198.

3.3.8.3. Color. The color of thread and gimp shall be black, shade AA, cable No. 66043 for types I and II and blue, shade AC, cable No. 66045 for type III and the color of the top thread of the bartacks at the ends of side pocket openings and the thread used for stitching the ornamentation to the trousers shall be yellow (goldenlite), shade AJ, cable No. 66051 for the gold lace and scarlet, shade W, cable No. 66040 for the scarlet stripe (see DoD Standard Color Card of Official Standardized Shades for Sewing Threads 1968).

3.3.8.4. Colorfastness. The thread and gimp shall show good fastness to wet (dry) cleaning and, in addition, the silk thread shall show good fastness to light when tested as specified in applicable thread specifications.

3.3.9 Buttons. Buttons shall conform to type II, class D, glossy finish, style 4, 22 line and 27 line of V-B-871. The color of the buttons shall be black, shade BT for types I and II and blue, shade BV, cable No. 62003 for type III (see DoD Standard Shades for Buttons 1966).

3.3.10 Labels. Each pair of trousers shall have a combination personal-identification-size-instruction label. The combination

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label shall conform to type VI, class 14 of DDD-L-20. The label shall conform to the colorfastness and writing test requirements of DDD-L-20. The content (inscription) and format of the combination label shall be as follows:

Nomenclature:

Fiber Content:

Size:

Contract number:

Name of contractor:

DRY CLEAN ONLY

3.4. Design. The trousers shall be the U.S. Marine Corps design as shown in Figures 1, 2, and 3, having a two-piece lined waistband with outlet at center back, button french-type fly with slide fastener closure, seven belt loops, side pockets with straight opening, two back pockets with flaps to button, hip darts, finished leg bottoms, with watch pocket, style A, or without watch pocket, style B. The type II trousers shall have ornamental gold lace; the types I and III trousers shall have ornamental scarlet stripes, two inches wide for type I and 1-1/2 inches wide for type III.

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 supplier's working patterns. The contractor's working patterns shall be identical to the standard patterns. The standard patterns provide a 1/2 inch allowance for crotch seam and 3/8 inch allowance for all other seams, except as otherwise specified herein, and seat seam outlet at waist in accordance with patterns. The patterns provide a three inch allowance for bottom turnup of legs. The standard patterns show size, directional lines for cutting, and are marked and notched for proper placement and assembly of the component parts.

3.5.1 List of pattern parts. The component parts for the trousers shall be cut from the specified materials in accordance with the pattern parts indicated below:

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ITEM	PATTERN NOMENCLATURE	NO. OF CUT PARTS
	Material: Basic	
1.	Front	2
2.	Back	2
3.	Right fly	1
4.	Left fly	1
5.	Facing, side pocket	2
6.	Bearer, side pocket	2
7.	Facing and cord piece, hip pocket	4
8.	Facing, watch pocket (style A trousers)	1
9.	Flap, hip pocket	2
10.	Waistband	2
11.	Belt loops, strip	1
12.	Buttonhole tab	2
	Material: Cloth, twill, polyester, polyester and cotton or polyester and rayon	
	<u>Type III</u>	
13.	Side pocket	2
14.	Hip pocket	2
15.	Watch pocket (style A trousers)	2
	<u>Type I</u>	
16.	Stay, side pocket	2
17.	Crotch lining	2
18.	Left fly interlining	2
19.	Right fly lining	1
20.	Hip pocket flap lining	2
21.	Waistband lining	2
	Material: Cloth, buckram, cotton	
22	Waistband interlining	2
	Marker	
23	Bottom turnup marker	

3.6. Construction

3.6.1 Manufacturing requirements. The trousers shall be manufactured in strict accordance with the operations and the stitch, seam, and stitching types specified in Table I. The supplier is not required to follow the exact sequence of the

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operations listed in Table I, but all operations specified shall be used to manufacture the trousers.

3.6.1.1. Stitches, seams and stitchings. The stitch, seam, and stitching types specified in Table I shall conform to FED-STD-751.

3.6.1.2. Overedge stitching. Overedge or serge stitching shall be done on serging machines with knife attachment properly set to trim the raw edge when overedged without cutting the material.

3.6.1.3. Tacking and backstitching. Ends of seams and stitching produced with stitch type 301, when not caught in other seams or stitching, shall be backtacked not less than 1/4 inch. Thread breaks (all stitch types) shall be secured by stitching back of break not less than 1/2 inch. When stitch type 401 is used, ends of seams and stitching shall be caught in other seams or stitching, and skipped stitches and thread breaks may be repaired using stitch type 301 backstitched not less than 1/2 inch on each side of the skip or break.

3.6.2 Shade marking. The component parts of the trousers 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 discolorations or leave traces of paper or adhesive mass on the material upon the removal of the tickets.

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TABLE I. Manufacturing requirements.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
1	<p><u>Cutting.</u></p> <p>a. Cut the trousers in strict accordance with the patterns furnished by the Government.</p> <p>b. Cut the material in the direction indicated by directional lines on the patterns. Lay fronts and backs so that the directional lines are in the warp direction. The directional lines may deviate from the warp direction by not more than 1 inch on both fronts and backs. Measurements shall be taken from the top and bottom of the directional line on patterns to the selvage edge of the fabric and the difference between the two measurements shall not exceed the tolerance specified.</p> <p>c. Cut the component parts for the trousers from one piece of the basic material, except the following parts may be cut from ends but when so cut, the parts shall harmonize with the shade of the trousers: belt loops, left and right flies, fly buttonhole tab, pocket bearers and facings.</p> <p>d. Cut the pockets on the straight of the material in accordance with patterns. Cutting of pockets in the direction of the filling is not permitted except when it is essential for economical use of the material.</p> <p>e. Cut the ornamental stripes in the warp direction. Cut the stripes 4 inches wide for type I trousers and 3 inches wide for type III trousers.</p>					
2	<p><u>Replacement of damaged parts.</u></p> <p>a. Replace any part containing damages at time of cutting, such as holes or serious weakening defects such as smashes, multiple floats and slubs likely to develop into holes.</p>					

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
2	<u>Replacement of damaged parts.</u> (cont'd) b. Replace any part damaged during the manufacturing process by needle chews which may be expected to develop into a hole, scissors or knife cuts, tears, holes, mends, burns, and large exposed drill holes.					
3	<u>Shade marking.</u> a. Mark or ticket the component parts to ensure a uniform shade and proper assembly throughout the trousers, except those parts specified in operation 1.c, which may be cut from ends and need not match each other. Ticket shall conform to 3.6.2.					
4	<u>Overedge stitch trousers.</u> Finished appearance. The overedge stitching shall be securely caught in the fabric. The raw edge of the over edged material shall be properly trimmed. a. Overedge stitch the inseam and outseam of front trouser, also the edge of right front. The overedge stitching of the inseam of left front shall extend from bottom of trouser to fly notch. The overedge stitching of the outseam of fronts shall extend from the bottom notch of side pocket to bottom of trouser leg. b. Overedge stitch inseam and outseam of back part of trousers. The side pocket stay piece, with the bottom edge turned up, may be attached to the outseam in the overedge operation. c. Overedge stitch crotch seam, seat seam and raw edge at the left end of waistband.	503 or 504	EFd-1	6-10	70/2	70/2
		503 or 504	EFd-1	6-10	70/2	70/2
		503 or 504	EFd-1	6-10	70/2	70/2

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
5	<p><u>Set back pocket bearer.</u></p> <p>Finished appearance. The pocket bearer shall be properly positioned and securely sewn with stitching of uniform gage and without pleats, puckers or other distortion.</p> <p>a. The back pocket bearers shall each be a single ply of basic material.</p> <p>b. Position the bearers on the pocket material in accordance with notches as indicated by marks on the pattern.</p> <p>c. Fold under the lower raw edge of bearers 1/4 to 3/8 inch and stitch to the pocket 1/16 to 1/8 inch from the folded edge. A selvage edge need not be turned.</p>	301	LSd-1 or LSbj-1	12-16	A	40/3
6	<p><u>Set side pocket bearers and facings.</u></p> <p>Finished appearance. The pocket bearer and facing shall be properly positioned and securely sewn with stitching of uniform gage and without pleats, puckers or other distortion.</p> <p>a. The side pocket bearers and facings shall each be a single piece of basic material.</p> <p>b. Position the bearers and facing on the pocket material in accordance with notches as indicated by marks on the pattern.</p> <p>c. Fold under the lower raw edge of bearers and facing 1/4 to 3/8 inch, stitch to the pocket 1/8 inch from the folded edge and continue stitching across the bottom raw edge. A selvage edge need not be turned.</p>	301	LSd-1 or LSbj-1	12-16	A	40/3

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
7	<p><u>Make back pocket flaps.</u></p> <p>Finished appearance. The flaps shall finish smooth and flat, without twists, pleats, or puckers and shall be uniform in shape and size in accordance with patterns. The lining shall not be exposed on the outside. The edges of the flaps shall be well forced out and the edge stitching shall be uniform in width. The buttonholes shall be correctly positioned, clean-cut and well made, and the stitching securely caught in the basic material.</p> <p>a. Flaps for the back pockets shall be made of one piece of basic material and one piece of lining material.</p> <p>b. Seam the two pieces together 3/16 to 1/4 inch from the side and bottom edges, trimming for proper turning when necessary.</p> <p>c. Turn flap, forcing out the corners, point, and seamed edges. Edgestitch the seamed edges uniformly 1/16 inch from edges working the lining back 1/16 inch from the finished edge of the flaps.</p> <p>d. Make a vertical, eyelet-end, taper-bar type buttonhole cut 5/8 inch long through the center of the flap with the edge of the eyelet 1/2 to 5/8 inch above the center point. Buttonholes shall be well worked over gimp to fit a 22 line button with the ends of the button-holes securely tacked.</p> <p>The purling of the buttonhole shall be on the outside of the flaps.</p>	<p>301</p> <p>301</p> <p>Button -hole</p>	<p>SSe-2 (a)</p> <p>SSe-2 (b)</p>	<p>12-16</p> <p>12-16</p> <p>48 min per button -hole (incl. tack)</p>	<p>A or A</p> <p>A (silk)</p> <p>A (silk)</p>	<p>A or A</p> <p>A (silk)</p> <p>A (silk)</p>

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
8	<u>Make left fly.</u> Finished appearance. The left fly shall finish smooth without twists, puckering or distortion. The overedge stitching shall be securely caught in the fabric.					
8	<u>Make left fly.</u> (cont'd)					
	a. Position slide fastener on fly and interlining material with bottom end of chain 1/4 to 1/2 inch above the fly notch. The front edge of chain shall be 5/8 to 3/4 inch from front edge of finished fly at top, tapering from 3/8 to 1/2 inch at the bottom. Seam fastener tape to fly through the interlining with a double row of stitches 3/16 to 1/4 inch gage.	301 or 401	LSbj-2	12-16	A	A
	b. Overedge the back edge of left fly and fly interlining together.	503 or 504	SSa-1	6-10	70/2	70/2
9	<u>Make buttonhole tab for right fly.</u> Finished appearance. The buttonhole tab shall finish without distortion, with the buttonhole stitching securely caught in the fabric and with the seams finishing at the edge of the tab.					
	a. The tab shall be made of two plies of basic material.					
	b. Seam the plies together at top, front and bottom edges with 3/16 to 1/4 inch seam and turn, forming out all edges.	301	SSE-2 (a)	12-16	A	A
	c. Topstitch the tab 1/16 to 1/8 inch from the seamed edges.	301	SSE-2 (b)	12-16	A	A
	d. Make a 5/8 inch long, horizontal, eyelet-end, taper-bar type stitches through the center of tab with edge of eyelet 1/2 ± 1/8 inch from finished end of tab. The buttonhole shall be well worked over gimp to fit a 22 line button and with the purling on inner side of tab.	Button - hole		48 min per button - hole (incl. tack)	A (silk)	A (silk)

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
10	<u>Make right fly.</u> Finished appearance. The right fly shall finish without bulkiness, twists, puckers, or pleats.					
10	<u>Make right fly.</u> (cont'd) a. The fly shall consist of one ply of basic material, a buttonhole tab and the lining. b. Position the buttonhole tab on the outside of the fly, with raw edges even and the upper finished edge of tab in line with the notch in the upper front edge of fly. c. Seam fly and lining together 3/16 inch from front edge. The seam shall extend from the bottom edge of fly up to the upper edge of buttonhole tab, catching the tab in the stitching. d. In the finished trousers, the upper end of the lining shall extend to top of waistband over the waistband lining, and the lining extension piece at the lower end shall extend not less than 1/2 inch beyond inseam.	301	SSe-2 (a)	12-16	40/3 or A	40/3 or A
11	<u>Assemble right and left flies.</u> Finished appearance. The flies shall be of even length where they join the crotch seam. The fastener parts shall be set so that there is no twisting or puckering when fly is closed. a. Position flies with notches at lower end matching, and seam fastener tape to back edge of right fly, stitching 1/4 inch from edge.	301	SSa-1	12-16	A	A
12	<u>Make belt loops.</u> Finished appearance. The belt loops shall be flat without distortions or raw edges, with stitching of uniform gage. The loops shall be of uniform length and width.					

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
12	<p>a. Belt loops shall be made from a 1 inch wide strip of the basic material and shall finish 1/2 inch wide and shall finish 3-1/4 inches long.</p> <p><u>Make belt loops.</u> (cont'd)</p> <p>b. Fold in the raw edges of the strip so that they abut each other at the center back of the finished loop. Join the raw edges together with a 1/4 inch gage covering stitch. The margin of stitching shall be uniformly 1/8 inch from the edges of the finished loop.</p> <p style="text-align: center;">- or -</p> <p>c. Fold the stripping lengthwise, turning under the raw edges and abutting the turned under edges at the center. Join the abutted edges with a covering stitch.</p> <p style="text-align: center;">- or -</p> <p>d. Turn under one side of the stripping; fold the stripping lengthwise, overlapping the turned under edge on the raw edge at the center. Join the lapped edges with a covering stitch.</p>	406	EFh-1	10-14	A (silk)	A (silk)
13	<p><u>Make watch pocket (style A trousers only).</u></p> <p>Finished appearance. The watch pocket bearer and watch pocket halves shall be properly positioned and securely sewn without pleats, puckers, or other distortions.</p> <p>a. The watch pocket shall be made of two pieces of pocketing material and a facing consisting of one ply of basic material</p> <p>b. Position the bearer over one ply of pocket material with the upper edges even. Turn under the lower edge of bearer and seam to the pocket 1/8 inch from the folded edge. A selvage edge need not be turned.</p>	105	EFae-1	10-14	0	0
		301	LSd-1	12-16	A	A

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
13	<u>Make watch pocket (style A trousers only).</u> (cont'd)					
	c. Properly position front and back pieces of the pocket with edges even and join together at the side and bottom edges with a 1/4 inch seam. The stitching shall extend from notch to notch at upper side edges.	301	SSe-2 (a)	12-16	40/3	40/3
	d. Turn the pocket, forcing out the seamed edges. Topstitch the pocket uniformly 1/4 inch from the seamed edges.	301	SSe-2 (b)	12-16	40/3	40/3
14	<u>Make ornamental stripes.</u>					
	Finished appearance. The scarlet stripes shall be basted without distortions and the finished stripe shall be uniformly 2 inches wide for type I trousers and 1-1/2 inches wide for type III trousers.					
	a. Fold the raw edges of the stripes so that they abut each other at the center back of the finished stripes and baste along the folded edges.	101		4-6		
15	<u>Make waistband lining.</u>					
	Finished appearance. The waistband lining shall be without distortion.					
	a. The waistband lining shall be made of one ply of lining material and one ply of buckram.					
	b. Overlap lining material on buckram 3/4 inch and stitch 1/8 to 3/16 inch from edge of lining material. Fold lining material over buckram and press.	301 or 401	LSa-1	6-10	40/3	40/3
	- or -					
	c. Use a commercial, buckram interlined, waistband lining, provided the furnished lining conforms to specification requirements.					

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
16	<p><u>Seam crotch lining to fronts.</u></p> <p>a. The crotch lining shall consist of lining material and shall extend not less than 1 inch above fly notch.</p> <p>b. Fold crotch lining lengthwise to form a double thickness and seam to fronts or attach to fronts in the overedge operation.</p>	<p>301 or 503 or 504</p>	<p>SSa-1 EFd-1</p>	<p>12-16 6-10</p>	<p>A 70/2</p>	<p>A 70/2</p>
17	<p><u>Seam darts in back.</u></p> <p>Finished appearance. The darts shall be properly positioned and finished without pleats, puckers, or gathers. In the finished trousers, the darts shall be well tapered to a flat point at lower end and shall extend to the pocket opening.</p> <p>a. Fold the backs, matching the cut edges of the waist darts. Seam lengthwise along the entire length of the dart, starting 3/8 inch from the cut edges at the top end and tapering to a point at the lower end as indicated by marks on patterns.</p> <p>b. Spread open and press darts smooth and flat with heated pressing iron or pressing machine.</p>	<p>301</p>	<p>SSa-1</p>	<p>12-16</p>	<p>A</p>	<p>A</p>
18	<p><u>Attach hip pocket, flaps, and label.</u></p> <p>Finished appearance. The pockets shall finish smooth and flat without bulkiness, bulges, or other distortions on the outside of the finished trousers. The stitching shall be uniform and secure. The pocket openings and flaps shall be in proper alignment.</p> <p>a. Position pocket flaps on the outside of the back, in line with the mark as indicated by pattern and with the pocketing on the under side. Stitch through all plies 3/16 to 1/4 inch from the mark.</p>	<p>301</p>	<p>LSg-2 (a)</p>	<p>10-14</p>	<p>40/3</p>	<p>40/3</p>

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
18	<u>Attach hip pocket, flaps, and label.</u> (cont'd)					
	b. Position the hip pocket cord on the outside of trousers in line with the mark and stitch through all plies 3/16 to 1/4 inch from the mark.	301	SSe-2 (a)	10-14	40/3	40/3
	c. Cut pocket opening through the back and pocketing, simultaneously. The opening shall not extend beyond the ends of the flap. Turn the cord piece through the opening and raise stitch back, forming a 1/8 to 3/16 inch cord edge at lower edge of pocket opening.	301	SSe-1 (show finished seam)	10-14	A or 40/3	A or 40/3
	d. Turn under the lower raw edge of cord facing and seam to pocketing 1/16 to 1/8 inch from folded edge. When cord facing is cut on selvage, the edge need not be turned under.	301	LSbj-1 (selvage)	10-14	40/3	40/3
	e. Turn the pocketing wrong side out, matching notches with pocket opening, and stitch sides 3/16 to 1/4 inch from raw edges. The stitching may extend across the bottom folded edge.	301 or 401	SSae-2 (a) SSae-2 (a)	10-14 10-14	40/3 40/3	40/3 40/3
	f. Turn pocketing, forcing out corners and seamed edges. Fold and stitch the pocket 1/4 to 3/8 inch from the side edges. Continue to stitch along the bottom edges. The ends of the bearer and cord facing shall be caught in the stitching.	301 or 301	SSae-2 (b) OSf-1	10-14 10-14	40/3 40/3	40/3 40/3
	g. Turn flap down and raise stitch through all plies 1/16 inch from joining seam, closing top of pocket.	301	LSq-2 (show finished seams)	10-14	A or 40/3	A or 40/3

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
18	<u>Attach hip pocket, flaps, and label.</u> (cont'd)					
	h. Position the combination personal-identification-size-instruction label on the top of the right pocketing so that on the finished trousers it will face the wearer. No part of the label printing will be covered by the waistband interlining curtain. Stitch the label on all four sides 1/16 to 3/32 inch from edges. Stitching shall not be through printing. Stitch top edge of the combination personal-identification-size-instruction label to the lower edge of the waistband lining above the right hip pocket. The ends of stitching need not be tacked provided the stitching extends to at least 1/2 inch beyond each side of label.	301	LSbj-1	10-14	40/3	40/3
	i. Securely bartack both ends of the pocket opening through all plies of material. - or -	301	SSa-1 (each end)	10-14	40/3	40/3
	j. Operations 5.c, 18.a, 18.b, and 18.c, may be accomplished on an automatic machine which sets the flap, stitches, cuts, and turns cord facing in one operation. When this machine is used, the bearer and cord facing may be trimmed to permit insertion into the machine and the recommended pocket stay material may be used.	101		10-14	40/3 or A/3	
	k. Raise stitch the joining seam of the lower edge of pocket opening through back of trousers and cord facing only. Raise stitch the back at upper edge of pocket opening through all plies, closing the top of the pocket. Securely tack both ends of pocket openings.	301	-	10-14	A or 40/3	A or 40/3

MIL-DTL-28920C(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
18	<p><u>Attach hip pocket, flaps, and label.</u> (cont'd)</p> <p>l. The depth of the pockets shall be 5-3/4 to 6-1/4 inches when measured on the inside of pocket from top edge of cord facing to bottom.</p> <p>m. The finished pocket opening (after bartacking) shall not exceed the hip pocket flap.</p> <p>n. On the finished trousers, the pocket flaps shall be 2-1/4 ± 1/4 inches at center, measured from seam to center point.</p>					
19	<p><u>Attach watch pocket.</u></p> <p>Finished appearance. The completed watch pocket opening shall not be stretched and the material shall not be exposed on the outside.</p> <p>a. Position the pocket on the outside of the right front at the pocket notches for the pocket opening. Seam the front part of the pocket only to the front of trousers 3/8 inch from the top edge, from notch to notch.</p> <p>b. Extend depth of notches to the seam. Turn the pocket to the inside of the front of trousers and edgestitch the pocket opening 1/8 inch below the top edge.</p> <p>c. Securely tack the ends of the pocket opening through front of trousers and front and back of pocket.</p> <p>d. In the finished trousers, the notches for the pocket opening shall not be exposed and the edge of the opening shall meet the lower edge of the waistband. The pocket opening (after backtacking) shall be 2-7/8 ± 1/8 inches and the depth of the pocket shall be 3-3/4 ± 1/4 inches.</p>	301	SSe-2 (a)	12-16	40/3	
		301	SSe-2 (b)	12-16	40/3	A
		301	SSa-1	12-16	A	A

MIL-DTL-28920C(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
20	<p><u>Join fly assembly to fronts.</u></p> <p>Finished appearance. The seam joining the fly assembly to the fronts shall be without pleats, puckers, twists, or other distortions.</p> <p>a. Sew on left fly with 3/8 inch seam with notches matching.</p> <p>b. Turn left fly to the inside with joining seam 1/8 inch back of folded edge and press front edge without damage to the fastener.</p> <p>c. Sew on right fly with 3/8 inch seam with notches matching.</p> <p>d. Press right fly seam open and flat with heated pressing iron with the fastener tape facing towards side seam.</p>	301	SSa-1	12-16	A	A
		301	LSq-2 (a)	12-16	A	A
21	<p><u>Attach side pockets.</u></p> <p>Finished appearance. The edge of the pocket openings shall finish smooth and flat without distortion. Pocket openings shall be of uniform appearance. The bottom front corners of the pockets shall be backstitched, and care shall be taken to avoid notching the pocket on the underside beyond the width of the side seam outlet.</p> <p>a. Position the outside of the fronts on the facing of the side pocket in accordance with the notches for the pocket opening as indicated by marks on the pattern.</p> <p>b. Seam the front, facing, and pocket material together from notch to notch 3/8 inch from the edge of the front, with cotton stay tape for edge of pocket opening caught in the stitching.</p>	301	SSe-2	12-16	A	A

MIL-DTL-28920C(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
21	<p><u>Attach side pockets.</u> (cont'd)</p> <p>c. Cut the depth of the notches for the pocket opening to the seam and turn the pocket to the inside of the front so that the seam will finish on the inside of the pocket 1/8 inch back from the finished edge of the pocket opening.</p> <p>d. Topstitch the front from notch to notch, through all plies of material, 1/4 inch from the finished edge of the pocket opening.</p> <p>e. Fold pocket inside out and seam raw edges from step of pocket, 3/16 to 1/4 inch from edge, to bottom and continue along the bottom of pocket. Notch pockets and bearers at top of step and turn.</p> <p>f. Tack the ends of pocket opening through facing with 1/4 to 3/8 inch tack.</p> <p>g. In the finished trousers, the top of pocket shall extend into the waistband and be caught in the bottom stitching of waistband.</p> <p>h. The finished pocket opening (after bartacking) shall measure 6-1/4 ± 1/4 inches.</p>	<p>301</p> <p>301</p> <p>401</p> <p>301</p>	<p>SSe-2 (b) (show finished seam)</p> <p>SSae-2 (a) or SSae-2 (b)</p> <p>SSa-1 (each end)</p>	<p>12-16</p> <p>12-16</p> <p>12-16</p> <p>12-16</p>	<p>A (silk)</p> <p>50/3</p> <p>50/3 or 70/2</p> <p>50/3</p>	<p>A (silk)</p> <p>50/3</p> <p>50/3</p> <p>50/3</p>
22	<p><u>Join outseams.</u></p> <p>Finished appearance. Outseams shall be carefully joined, with notches matching, and without twists, puckers, or pleats. The seams shall start and finish evenly and lie smooth and flat.</p> <p>a. Join the outseam with a 3/8 inch seam, matching the notches as indicated by marks on the patterns, joining the back to the pocket bearer and to the front at the side seam and catching the side pocket stay with its bottom edge turned in.</p>	<p>301 or 401</p>	<p>SSav-2 (b)</p>	<p>12-16</p>	<p>A</p>	<p>A</p>

MIL-DTL-28920C(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
22	<u>Join outseams.</u> (cont'd) b. Spread open the outseams from top edge of trousers to bottom and press smooth and flat with a heated pressing iron or pressing machine, with the pocket stay folded and pressed flat over the open seam.					
23	<u>Finish side pocket.</u> a. Turn under the back edge of side pocket, fold the stay piece over the open seam and stitch pocket to stay piece 1/4 inch from edge along the side seam allowance, with the stitching extended to the front bottom edge of pocket.	301	SSc-1 and SSe-2 (b)	12-16	A	A
24	<u>Attach ornamentation.</u> Finished appearance. Ornamentation shall be set on the trousers from top edge of fronts to bottom edge of legs, with the top end to finish in the waistband seam. The ornamentation shall be securely and uniformly stitched, properly positioned and shall finish without distortion. a. Position the ornamentation on fronts, with back edge of ornamentation aligned with outseam and edge of pocket opening. Seam to trousers from top of fronts to lower end of pocket opening 1/8 inch from each edge of ornamentation. Continue stitching from lower end of pocket opening, gradually working ornamentation towards the back to center over the outseams.	301	SSas-4 (b)	12-16	A (silk)	A (silk)

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
25	<p><u>Sew waistband and belt loops to trousers.</u></p> <p>Finished appearance. The waistband shall be seamed to the trousers smoothly and neatly without fullness, gathers, or pleats. The belt loops shall be properly inserted and correctly positioned with the ends securely caught in the waistband stitching.</p>					
25	<p><u>Sew waistband to belt loops and trousers.</u> (cont'd)</p> <p>a. The waistband shall be made of one ply of basic material.</p> <p>b. Seam waistband to trousers 3/8 inch from edge, with end of belt loops inserted in seam at correct positions and securely caught in the stitching (except center back loop).</p> <p>c. Position belt loops as follows:</p> <p>(1) One loop in center of right and left fronts and backs according to notches on patterns.</p> <p>(2) Side loops on the backs with front finished edge even with outseams.</p> <p>(3) Stitch the loop for the center back of the trousers after the back is joined at the seat seam.</p> <p>d. The raw right front ends of the waistband shall extend 1/4 to 3/8 inch beyond the front edge of the right fly. The left front ends of the waistband shall finish even with the back edge of the left fly. The raw right and left back ends of the waistband shall finish even with the edges of the back.</p>	301	SSa-1	12-16	A	A
26	<p><u>Press waistband seam.</u></p> <p>a. Press waistband seam open and flat with a heated pressing iron or pressing machine.</p>					

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
27	<u>Seam front ends of waistband.</u>					
	a. Turn back right fly lining and stitch top end to front and top edges of waistband, down to the buttonhole tab, rounding off the corner slightly. Trim the corner.	301	SSe-2 (a) (each edge)	12-16	A	A
	b. Turn back the end of the left waistband in line with the joining seam of the left fly to front and stitch across top edge of waistband the width of the fly.	301	SSa-1	12-16	A	A
28	<u>Join lining to waistband.</u>					
	a. Insert top edge of waistband between lining and buckram of waistband lining, with edge of lining turned in, and join all plies with a row of imitation handfelled stitches, or trouser waistband lining may be felled by hand.	304 or 404 or Hand		12-16 12-16 7-10	40/3 40/3 40/3	40/3 40/3
	b. Left end of waistband lining shall finish at front edge of trousers, with the end of the waistband lining trimmed slightly back from front edge on an angle. Right end of waistband lining shall extend approximately 1 inch under the fly lining in the finished trouser.					
29	<u>Press waistband.</u>					
	a. Turn out front end of left and right waistband, forcing out the corners. Turn waistband lining to inside and press along the top edge of waistband. Trouser waistband lining shall not be exposed beyond top edge of waistband.					
	b. Finished width of waistband shall be $1\text{-}3/4 \pm 1/8$ inches.					
30	<u>Stitch pockets to lower edge of waistband.</u>					
	Stitch top end of all pockets to waistband seam allowance with pockets properly positioned and smoothed out.	301	SSa-1	6-10	A	40/3

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
31	<p><u>Finish left fly.</u></p> <p>Finished appearance. The base of the fly shall be finished so as to avoid twisting, pleating or puckering. The joining seam of left fly to front shall not be exposed on outside of trouser.</p> <p>a. Seam back edge of left fly to front from notch to top of waistband uniformly $1-1/2 \pm 1/8$ inches from front edge to fly.</p>	301	SSa-1	12-16	A (silk)	A (silk)
32	<p><u>Finish right fly.</u></p> <p>a. Turn to the inside and edgestitch right fly lining front and top edges of right fly and through the buttonhole tab 1/8 inch from edge. The lining shall not be exposed on the outside of the trousers.</p> <p>b. Turn under the raw edge of fly lining and raise stitch the fly joining seam, catching the turned under portion of lining and slide fastener tape in the stitching.</p>	301	SSe-2 (b) (show finished seams)	12-16	40/3	A
33	<p><u>Join inseam.</u></p> <p>Finished appearance. Inseams shall be carefully joined with notches matching and without twists or puckers. The seams shall start and finish evenly and be smooth and flat.</p> <p>a. Join the inseam from the bottom edge of the legs to the crotch with the notches matching as indicated by marks on the patterns, forming an outlet tapering the seam allowance of the back from 1-1/8 inches at the crotch to 3/8 inch at the knee notch.</p> <p>b. Press the inseam open.</p>	401	LSg-2 (b)	12-16	A (silk)	40/3

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
34	<p><u>Join crotch and seat seam.</u></p> <p>Finished appearance. The crotch and seat seams shall be joined with proper tension, resulting in sufficient elasticity of seam to counteract strain encountered in sitting or stooping. In the joining of the seat seam, the inseams shall meet.</p> <p>a. Measure waist to proper size before joining crotch, seat, and waist seam.</p>					
34	<p><u>Join crotch and seat seam.</u> (cont'd)</p> <p>b. Place the left and right assemblies together with the edges of the crotch seam aligned with the waistband on the left assembly, aligned with the waistband on the right assembly at the fly opening, and with the notches at the lower end of the flies matching.</p> <p>c. Join the left and right assemblies at the crotch and seat seam from the fly notch to a point 1/2 to 3/4 inch from the top of the finished waistband with two rows of stitches not more than 1/32 inch apart, forming a 1/2 inch V-shaped opening at back. The left and right assemblies shall be joined at the crotch with a 1/2 inch seam.</p> <p>d. Fold back waistband lining over the joining seat seam and single stitch each end of the outlet 1/4 inch from seat seam, with the lower corner diagonally folded and caught in the stitching. Turn and force out upper corners.</p>	401	SSa-2	10-14	A	A
35	<p><u>Assemble slide fastener.</u></p> <p>a. Attach slider and securely staple bottom of fastener together with the ends of the chain even and the head of the staple towards the outside.</p>	301	SSa-1 (each end)	12-16	A	A

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
36	<u>Press seams (with heated pressing iron or pressing machine).</u> Finished appearance. The seams shall finish smooth and flat without pleats, puckers or twists. a. Spread open the seat and crotch seams from top of waistband to fly notch and press smooth and flat.					
37	<u>Stitch right fly lining extension to crotch seams.</u> a. Turn under raw edge of the right fly lining extension and stitch by machine or hand fell to each side of the crotch seam. b. The right fly lining shall extend not less than 1/2 inch beyond the inseam in the finished trousers.	301 or Hand	SSa-1 (each edge)	12-16 6-8	40/3 0 (silk)	A (silk)
38	<u>Finished waistband.</u> Finished appearance. The waistband shall finish smooth, even and flat without gathers, puckers, pleats, or other distortions either in the waistband or the trousers at waistband joining. On the finished trousers, the waistband shall be uniformly 1-3/4 ± 1/8 inches wide, the edge of the waistband shall be 4-1/2 ± 1/4 inches from the top of the back pocket flaps and the waistband lining shall finish 2-1/2 ± 1/8 inches wide. a. Topstitch the waistband seam 1/16 inch from joining seam on trousers side (not through waistband) catching waistband lining. The stitching shall extend to the stitching on the left (not across) fly and to back edge of right fly.	301	LSd-2 (show finished seam)	12-16	A (silk)	40/3 (silk)

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
39	<u>Finish belt loops.</u> Finished appearance. All belt loops shall measure $1-7/8 \pm 1/8$ inches from the bartacking at the top of the loop to the bottom folded edge. The tacking shall extend the width of the loops but not beyond.					
	a. Drop loops and securely stitch to trousers $1/4 \pm 1/8$ inch below waistband seam. The tacking shall be hidden by loops when trousers are finished. The bottom edge of the waistband lining shall not be caught in the tacking of the loop.	301	SSa-1	12-16	A	A
39	<u>Finish belt loops.</u> (cont'd)					
	b. Turn under the top end of all belt loops and securely stitch or bartack at top of waistband with the turned under portion caught in the stitching.	301 or Bartack	SSb-1	12-16 28 per bartack	A A (silk)	A 40/3 (silk)
	c. Position back loop over seat seam with the finished side up, and with the top raw end of loop placed at bottom of V-shaped opening. Stitch or bartack across top end of loop through waistband $1/4$ to $5/16$ inch below V-shaped opening.	301 or Bartack	LSq-2 (a)	12-16 28 per bartack	A (silk) A (silk)	0 (silk) 40/3 (silk)
	d. Turn up the loop, covering the top raw edge, and stitch or bartack the loop over first tacking	301 or Bartack	LSq-2 (b)	12-16 28 per bartack	A (silk) A (silk)	0 (silk) 40/3 (silk)
	e. Fold loop back even with top edge of waistband. Turn under bottom raw end and stitch or bartack to trousers $1/4 \pm 1/8$ inch below waistband seam.	301 or Bartack	LSd-1	12-16 28 per bartack	A (silk) A (silk)	0 (silk) 40/3 (silk)

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
40	<p><u>Make buttonhole in waistband.</u></p> <p>Finished appearance. Buttonhole shall be clean cut, well made, and correctly positioned. The stitching shall be securely caught in the fabric.</p> <p>a. Make a horizontal eyelet-end, taperbar type button hole cut 5/8 inch long through the left front end of the waistband with the edge of the eyelet 1/2 inch from the front edge of the fly opening. The buttonhole shall be made in the center of the waistband and shall be worked over gimp to fit a 22-line button. The purling of the buttonhole shall be on the outside.</p>	Button - hole		48 min per button -hole (incl. tack)	A (silk)	A (silk)
41	<p><u>Bartack trousers.</u></p> <p>Finished appearance. The trousers shall not be distorted by the bartacks. The pockets shall lie smooth and flat. The bartacks shall be properly positioned and correctly placed to reinforce the points of strain as specified.</p> <p>a. Bartack both ends of all pocket openings. Bartacks for the back pockets and watch pocket shall be vertical. Bartacks for the side pockets shall be horizontal.</p> <p>b. Bartack the bottom end of the fly horizontally through all plies at the juncture of the crotch seam and fly.</p> <p>c. Bartack front edge of right fly to back of left fly with a vertical bartack, with lower end of bartack approximately 3/4 inch above the horizontal bartacks at base of fly.</p> <p>d. Bartacks shall be made 3/8 to 1/2 inch long, and shall be stitched through all plies of material at the point of bartacking.</p>	Bartac k		28 per bartac k	A (silk)	40/3 (silk)
		Bartac k		28 per bartac k	A (silk)	40/3 (silk)
		Bartac k		28 per bartac k	0	40/3
42	<p><u>Sew buttons to trousers.</u></p>					

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
	Finished appearance. The buttons shall be securely sewn with the ends of the stitching securely tacked. The buttons shall be properly aligned with the buttonholes to secure a smooth and complete closure without bulging or misalignment.					
	a. Sew a 22-line button through the waistband lining only in line with the buttonhole in the right tab.	101 or 301 or Hand		20-22 per button 14-16 per button 4 per button (double thread)	24/4 24/4 24/4	24/4
42	<u>Sew buttons to trousers.</u> (cont'd)					
	b. Sew a 22-line button on each back through pocket to correspond with buttonhole in flaps.	101 or 301		20-22 per button 14-16 per button	24/4 24/4	24/4
	c. Sew six 27-line buttons on the inside of the waistband lining only. One button shall be positioned over each of the side seams on one button on each front 4-1/2 to 4-3/4 inches from the side seam and one on each of the backs 2-1/4 to 2-3/8 inches from the back seam. The center the buttons shall be positioned 1/2 to 5/8 inch below top of waistband.	101 or 301 or Hand		20-22 per button 14-16 per button 4 per button (double thread)	24/4 24/4 24/4	24/4

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
	d. Sew a 22-line button on right end of waistband through all plies to correspond with buttonhole on left end of waistband.	301 or 101 or Hand		14-16 per button 20-22 per button 4 per button (double thread)	24/4 24/4 24/4	
	e. Shank wrap all buttons.	Hand		4 wraps per button (double thread) 16 stitch -es per button	24/4 24/4	24/4
43	<u>Press trousers.</u> Finished appearance. All pressing shall be done with a heated pressing iron or pressing machine of a type suitable to obtain the desired appearance in accordance with good manufacturing practice. a. Press the top, fly, and pockets smooth and flat.					

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM / STCH TYPE	STCH/I N	NDL	BOB/ LPR
43	<u>Press trousers.</u> (cont'd) b. Press smooth and crease the legs in the center, with the seams matching at the bottom and in the crotch, or the inseam in the crotch may be slightly back of the outseam. c. Close fly and waistband, and pockets.					
44	<u>Finish leg bottoms.</u> Finished appearance. The turnup shall finish 2-3/4 to 3 inches deep. a. Mark the trouser leg for bottom turnup in accordance with the pattern marker. b. Turn all trousers wrong side out. Turn up bottom end of leg and blindstitch to body of leg. c. Turn trousers right side out to complete pressing.	301	EFc-1	6-8	A	A
45	<u>Clean trousers.</u> a. Trim all ends of stitching and remove all loose threads; and remove all spots, stains, and shade tickets or markings without injury to the material. b. Trim away excess turn under of belt loops where necessary.					

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

TABLE II. Finished measurements. 1/

Size (inches)	26	28	30	32	34	36	38	40	42	44	Toleranc e
1/2 Waist <u>2/</u>	13	14	15	16	17	18	19	20	21	22	$\pm 1/4$
Inseam <u>3/</u>	----- As marked on label. -----										$\pm 1/2$

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- 1/ The trousers shall be fastened and placed flat upon a table except as otherwise indicated herein.
- 2/ Waist measurement taken from folded edge to folded edge on waistband with waistband buttoned.
- 3/ Inseam measurement taken along inseam from crotch seam to bottom edge of legs.

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

3.9. Recycled, recovered, or environmentally preferable materials. Recycled, recovered, or environmentally preferable materials should be used to the maximum extent possible provided that the material meets or exceeds the operational and maintenance requirements, and promotes economically advantageous life cycle costs.

4. VERIFICATION

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

- a. First article inspection (see 4.3).
- b. Conformance inspection (see 4.4).

4.2. Inspection conditions. Unless otherwise specified, all inspections shall be performed in accordance with the test conditions specified in MIL-STD-1488.

4.3. First article inspection. When first article is required, inspection shall be made of completely fabricated trousers for all provisions of this specification.

4.4. Conformance inspection. Inspection shall be performed in accordance with MIL-STD-1488.

4.4.1 Examination and testing. Examination for testing and conformance shall be as stated in the contract.

4.4.2 Examination of the end item. Samplings and examination of the end item shall be performed for dress (D) trousers in accordance with the provisions of MIL-STD-1488.

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4.4.3 Finished measurement examination. The provisions for the finished measurement examination of the finished trousers shall be as specified in MIL-STD-1488 and as outlined in Table II.

5. PACKAGING

5.1. Packaging. For acquisition purposes, the packaging requirements shall be as specified in the contract or order (see 6.2). When actual packaging of material is to be performed by Department of Defense (DoD) personnel, these personnel need to contact the responsible packaging activity to ascertain requisite packaging requirements. Packaging requirements are maintained by the Inventory Control Point's packaging activity within the Military Department of Defense Agency, or within the Military Department's Systems Command. Packaging data retrieval is available from the managing Military Department's or Defense Agency's automated packaging files, CD-ROM products, or by contacting the responsible packaging activity.

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 trousers are intended for wear by officers of the U.S. Marine Corps as follows:

Type I - Dress wear for general officers.

Type II - Full dress wear for U.S. Marine Band leader and assistant leader.

Type III - Dress wear for officers other than general officers.

6.2. Acquisition requirements. Acquisition documents must specify the following:

- a. Title, number, and date of the specification.
- b. Issue of DoDISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.2).
- c. Packaging requirements (see 5.1).
- d. Type, style, class, sizes and lengths required (see 1

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- e. Whether first article if required (see 3.2).
- f. Number of trousers in first article (see 3.2).

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

6.4 Figures. Figures 1, 2, and 3 show the general design of the trousers and are furnished for information only. In the event of conflict between the figures and the text of this specification, the text of this specification shall govern.

6.5 Subject term (keyword) listing.

Broadcloth
Marine band
Wool

6.6 Changes from previous issue. Marginal notations are not used in this revision to identify changes with respect to the previous issue due to the extent of the changes.

Preparing Activity
Navy - MC
Project No. 8405-N311

MIL-DTL-28920C(MC)

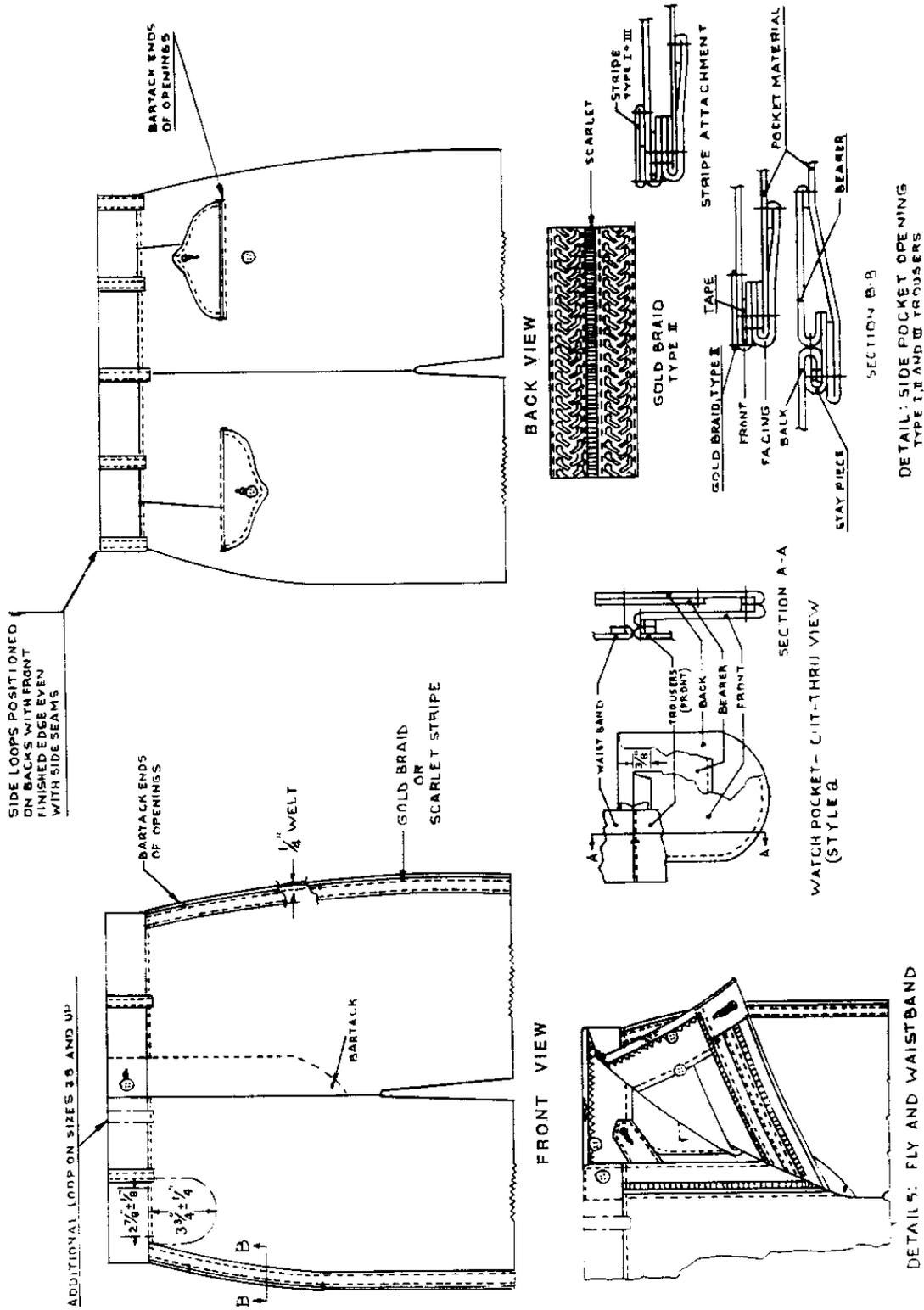


Figure 1. Trousers, Men's - Dress (Officer's)

MIL-DTL-28920C(MC)

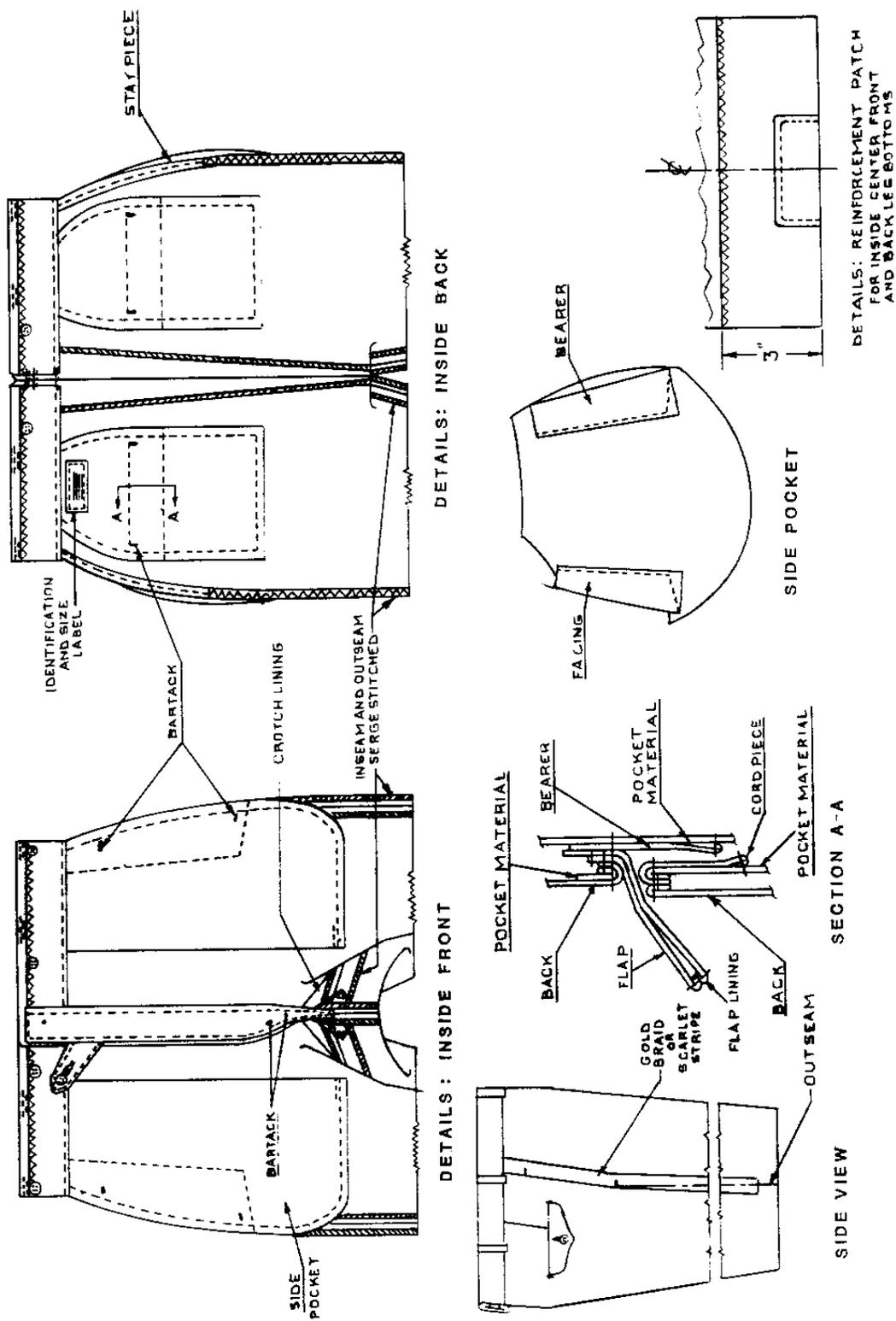
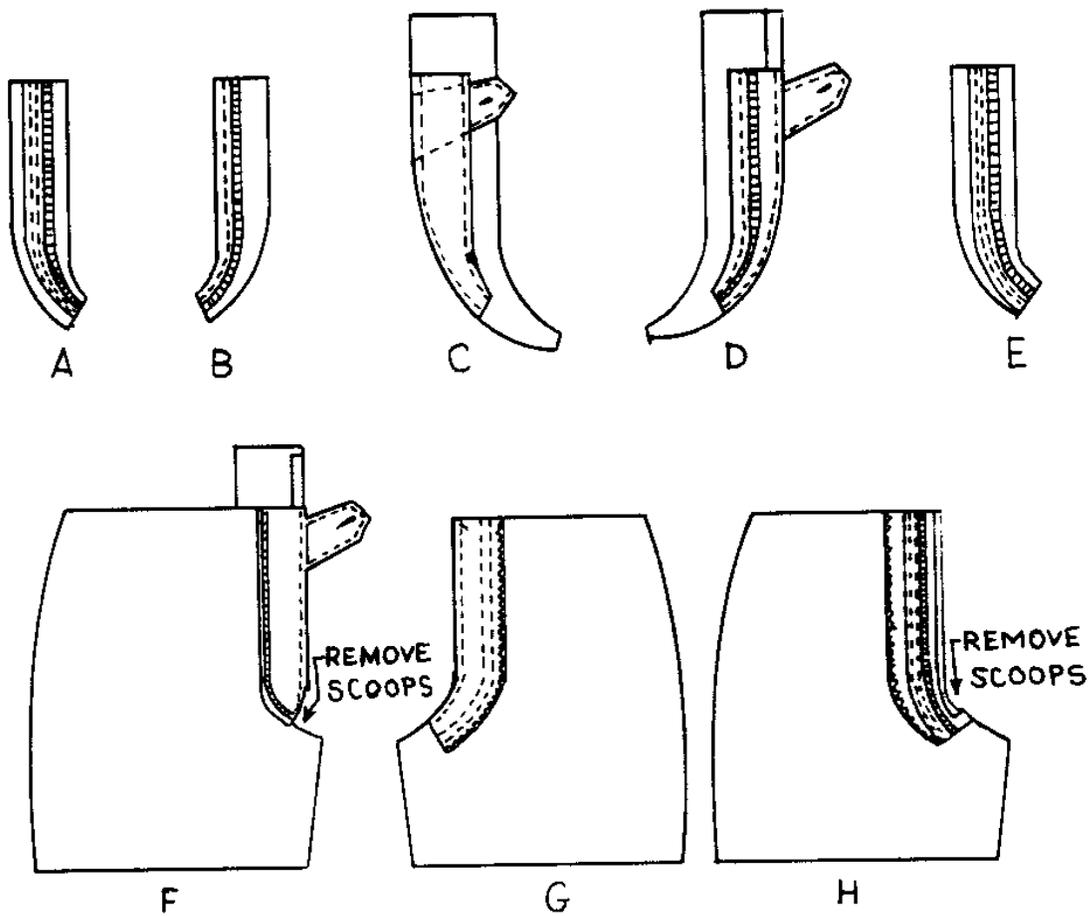


Figure 2. Trousers, Men's - Dress (Officer's)

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- A. DOUBLE STITCH FASTENER TAPE TO LEFT LINING.
- B. SEAM FASTENER TAPE TO RIGHT FLY.
- C/D. SEAM LINING TO RIGHT FLY, TURN & RAISE STITCH.
- E. OVEREDGE LEFT FLY.
- F. JOIN RIGHT FLY TO TROUSERS.
- G/H. JOIN LEFT FLY TO TROUSERS & PRESS.

Figure 3. Trousers, Men's - Dress (Officer's)

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL**INSTRUCTIONS**

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

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

I RECOMMEND A CHANGE:		1. DOCUMENT NUMBER MIL-DTL-28920C(MC)	2. DOCUMENT DATE (YYMMDD) 97 08 11
3. DOCUMENT TITLE		TROUSERS, MEN'S-DRESS (OFFICER'S)	
4. NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)			
5. REASON FOR RECOMMENDATION			
6. IDENTIFIER			
a. NAME (Last, First, Middle Initial)		b. ORGANIZATION	
c. ADDRESS (Include Zip Code)		d. TELEPHONE (Include Area Code) (1) Commercial (2) AUTOVON (If applicable)	7. DATE SUBMITTED (YYMMDD)
8. PREPARING ACTIVITY			
a. NAME COMMANDER, MARCORSYSCOM, PSE-D		b. TELEPHONE (include Area Code) (1) Commercial (703) 784 4584 (2) AUTOVON	
c. ADDRESS (Include Zip Code) 2033 BARNETT AVE, SUITE 315 QUANTICO, VA 221234-5010		IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT: Defense Quality and Standardization Office 5203 Leesburg Pike, Suite 1403, Falls Church, VA 22041-3488 Telephone (703) 756-2340 Autovon 289-2340	