

INCH-POUND

MIL-DTL-29387C (MC)
16 October 1997
SUPERSEDING
MIL-N-29387B (MC)
20 September 1994

DETAIL SPECIFICATION

NECKTIE, WOMEN'S - GENERAL OFFICER

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 the scarlet necktie made from tropical polyester/wool material of one size and type only.

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

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 8445

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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).

SPECIFICATIONS

FEDERAL

- A-A-50196 - Thread, Silk
- A-A-50199 - Thread, Polyester Core, Cotton, or Polyester Covered
- DDD-L-20 - Label: For Clothing, Equipage, and Tentage (General Use)

DEPARTMENT OF DEFENSE

- MIL-C-21115 - Cloth, Tropical: Wool, Polyester/Wool
- MIL-F-21840 - Fastener Tapes, Hook and Loop, Synthetic
- MIL-C-44296 - Cloth, Fusibles

STANDARDS

FEDERAL

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

(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

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documents not listed in the DoDISS are the issues of the documents cited in the solicitation (see 6.2).

ANSI/ASQC Z1.4 - Sampling Procedures and Tables for
Inspection by Attributes

(Application for copies should be addressed to The American National Standards Institute, 11 West 42nd Street, New York, NY 10036.)

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). Variation 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 the necktie shall be cloth, 10 ounce, tropical, polyester/wool, conforming to type III, class 3 of MIL-C-21115 in scarlet, shade 2502.

3.3.2 Fusible interlining. The fusible interlining for the necktie shall be cloth, non-woven, fusible, conforming to type V, class 1, style B of MIL-C-44296.

3.3.3 Fastener tape. The nylon fastener tape for securing the neckband shall be 3/4 inch wide hook and loop tape conforming to type I, class 1 of MIL-F-21840. The color of the hook and loop tape shall match the shade of the basic fabric with colorfastness requirements as specified in MIL-F-21840.

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3.3.4 Thread.

3.3.4.1. Silk thread. The silk thread for machine sewing shall conform to type I, ticket No. A of A-A-50196 for all bartacks and all outside seaming and stitching.

3.3.4.2. Cotton/polyester. The cotton-covered polyester or polyester thread shall be ticket No. 70, 2-ply conforming to A-A-50199 for all inside seaming, label, seam or overedge stitching.

3.3.4.3. Color. The color of the thread for the necktie shall conform to scarlet, shade W, Cable No. 66040 (see DoD Standard Color Card of Official Standardized Shades for Sewing Threads 1968).

3.3.4.4. Colorfastness. The dyed thread shall show fastness to wet (dry) cleaning and light equal to or better than the standard sample. When no standard sample is available, the dyed thread shall show good fastness to wet (dry) cleaning and light.

3.3.5 Label. Each necktie shall have an identification label conforming to type VI, class 1 of DDD-L-20. The fastness to laundering requirements of DDD-L-20 shall apply. The label shall not be more than 5/8 inch wide by 2-1/2 inches long. The content and format shall be as follows:

Nomenclature: (Necktie, Women's)
Contract number: DSA-100-77-7147 (Example)
Name of contractor:

3.4. Design. The necktie shall be a ready-made type, with neckband adjustable by hook and loop tape fastener closure, as shown in Figure 1.

3.5. Patterns. Standard patterns will be furnished to the contractor by the Government. The standard patterns shall not be altered in any way and shall be used only as a guide for cutting the contractor's working patterns. The contractor's working patterns shall be identical to the standard patterns. The standard patterns provide a 1/4 inch allowance for joining. A 1/8 inch seam is used to attached the label to the underside of the necktie.

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3.5.1 List of pattern parts. The necktie shall be cut from the specified materials in accordance with the pattern parts as follows:

ITEM	PATTERN NOMENCLATURE	NO. OF CUT PARTS
	Material: Cloth, polyester/wool	
1	Top ply	1
2	Under ply	1
	Material: Cloth, nonwoven fusible	
3	Top ply interlining	1

3.6. Construction. The neckties shall be manufactured in accordance with the operations and stitch, seam, and stitching types specified in Table I. The contractor is not required to follow the exact sequence of operations as listed in Table I, but all operations shall be used to manufacture the neckties.

3.6.1 Stitches, seams, and stitchings. The stitch, seam, and stitching types specified in Table I shall conform to FED-STD-751. Whenever two or more stitch or seam types are specified for the same operation, any one of them may be used. Where stitching type 401 is used, the looper (under thread) shall be on the inside of the necktie. The number of stitches per inch as specified in Table I indicates the minimum and maximum number permitted.

3.6.1.1. Thread breaks and ends of seams. Ends of seams and stitching produced with 301 type stitch 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. Skipped stitches and thread breaks may be repaired using stitch type 301.

3.6.2 Fusing. The fusing interlining shall be fused to the basic material in accordance with the following conditions:

a. Temperature between pressing surfaces of 300°F minimum and 320°F maximum at the fuseline (not the temperature at the clock).

b. Pressure between pressing surfaces of 6 pounds per square inch (lb_f/in_2) minimum and 7 lb_f/in_2 maximum.

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- c. Pressing time of 12 seconds minimum and 14 seconds maximum.
- d. Heat-dry.

TABLE I. Manufacturing requirements.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
1	<p><u>Cutting.</u></p> <p>a. Cut the necktie in strict accordance with the pattern furnished by the Government.</p> <p>b. Cut neckties from one piece of basic material in the direction of warp as indicated by directional lines on pattern.</p> <p>c. Cut fusible interlining for neckties in accordance with the pattern.</p>					
2	<p><u>Replacement of damaged parts.</u></p> <p>a. Replace at time of cutting, all parts containing damages such as holes or serious weakening defects such as smashes, multiple floats and slubs likely to develop into holes.</p> <p>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 or burns.</p>					
3	<p><u>Make necktie.</u></p> <p>Finished appearance. The necktie shall finish smooth and flat, without twists, gathers, puckers, pleats, or raw edges, and the corners and seamed edges shall be uniformly worked out.</p> <p>a. The neckties shall be made from two plies of basic material and one ply of fusible interlining.</p>					

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
3	<u>Make necktie.</u> (cont'd)					
	b. Position the fusible interlining material on the underside of the top ply of basic material. Fuse the fusible interlining to the basic material of the necktie as specified in 3.6.2.					
	c. The identification label shall be sewn to the face of the under ply of the basic material and shall be centered on the finished necktie (see Figure 1). Stitch on all four sides.	301	LSBj-1	10-14	70	70
	d. Fold the top ply of the basic material lengthwise with the interlining face to face and notches matching. Stitch the entire length of each tuck from top notch to bottom notch 1/32 to 1/16 inch from the folded edges.	301	OSf-1	10-14	A (silk)	A (silk)
	e. Mark and trim top ply of necktie in accordance with the shape of the pattern furnished.					
	f. Position the under ply on the top ply with edges even and notches matching. Seam the two plies together 1/4 inch from raw edges, leaving an opening at one end for turning.	301	SSa-1	10-14	A (silk) or (cotton)	A (silk) or (cotton)
	g. Turn the necktie right side out, working out the seamed edges and points.					
	h. Press the necktie smooth and flat with a heated pressing iron or pressing machine.					
	i. Position hook portion of the nylon fastener tape to the right neckband and the loop pile portion of the nylon fastener tape to the left neckband, with edge of tape even with finished edges of neckband, and stitch to the neckband 1/16 to 1/8 inch from all edges. The hook and loop pile portion shall each measure 3-1/2 inches long by 3/4 inch wide \pm 1/16 inch.	301 or 401	SSa-1	10-14	70	70

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
4	<u>Clean and press necktie.</u> a. Trim thread ends, loose threads, spots, stains and shade tickets. b. Finish press the necktie with heated pressing iron or pressing machine.					

3.7. Finished measurements. The finished measurements of the necktie shall be as shown in Figure 1.

3.8. Workmanship. The finished necktie 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 provisions set forth in ANSI/ASQC Z1.4.

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

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4.4. Conformance inspection.

4.4.1 Component and material testing. Components and materials shall be inspected and tested in accordance with all the requirements of referenced specifications and standards unless otherwise excluded, amended, modified, or qualified in this specification or applicable purchase documents. The method of testing specified in FED-STD-191, wherever applicable, shall be followed.

4.4.1.1. Sampling for testing. Government furnished materials shall not be sampled or tested unless specifically requested by the Government.

4.4.2 Examination of the end item. The end item shall be examined for defects in accordance with 4.4.2.1 and 4.4.2.2. The sample unit for these examinations shall be one necktie.

4.4.2.1. Classification of defects. All defects shall be classified as indicated below:

Examine	Defects	Classification	
		Major	Minor A B
Cleanness	a. Spot or stain clearly noticeable. - on front part of necktie. - on underside of necktie.	101	301
	b. Thread ends not trimmed or loose thread ends not removed (to be scored only when the condition exists on major portion of necktie).		302
Components and assembly	a. Any component parts or required operation omitted (unless otherwise classified herein).	102	
Cutting	a. Not cut in accordance with the warp directional lines on the patterns or not in accordance with specified requirements.	103	
Label	a. Missing, incorrect, or illegible.		201

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Examine	Defects	Classification	
		Major	Minor A B
Material defects and damages	b. Not stitched on one or more sides.		303
	c. Stitching through printing on label.		304
	d. Not positioned on center back.	104	
	a. Any holes.	105	
	b. Any weakening defect, such as a smash, multiple float, or loose slub.	106	
	c. Shade bar or unsightly slub.	107	
	d. Any tear, mend, burn, or needle chew.	108	
	Dimensions	a. Any measurement deviating from dimensions and tolerances specified in Figure 1 shall be scored as a size measurement defect.	
Pressing	a. Burned or scorched.	109	
	b. Not pressed or poorly pressed.		203
Seams and stitching	a. General.		
	1. Seams twisted, puckered, or pleated.		204
	2. Ends of any stitching (when not caught in the other seams or stitching) backtacked less than 1/4 inch.		305
Seams and stitching (cont'd)	3. Thread break secured by stitching back of the break less than 1/2 inch.		205

Note: Material defects and workmanship damages are to be classified as indicated above only when the condition is one which weakens the fabric or when it is so conspicuously located that it is clearly noticeable. Non-weakening conditions which are inconspicuous shall not be classified as defects.

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Examine	Defects	Classification	
		Major	Minor A B
	4. Any part of necktie caught in an unrelated operation or stitching.	110	
	5. Not specified color or varying shades of thread exposed on outside of necktie.		206
	b. Open seams: - 1/8 inch or less. - more than 1/8 inch, up to and including 1/4 inch. - more than 1/4 inch.	111	306
	c. Run-offs (use classification of open seam).		
	d. Raw edges: - 1/4 inch or less. - more than 1/4 inch, but not more than 1/2 inch. - more than 1/2 inch.	112	307
	e. Seam and stitch type: not specified seam or stitch type.		209
	f. Stitch tension: 1. Loose tension, resulting in a loose seam.	113	
	2. Tight tension (stitches break when normal strain applied to seam or stitching).	114	
Seams and stitching (cont'd)	g. Stitches per inch (to be scored only when the condition exists on a major portion of the seam) less than minimum or more than maximum specified: - one or two stitches. - three stitches. - four or more stitches.	115	308 210
Shaded parts	a. Any parts badly shaded.	116	

Note: Puckering is evidence of tight tension. When puckering is evident, the seam shall be tested by exerting a pull in the lengthwise direction of the seam or stitching.

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4.4.2.2. Defects applicable to specific parts. Defects applicable to specific parts shall be classified as follows:

Necktie	a. Pointed end poorly shaped.	117	
	b. Twisted, affecting appearance.	118	
	c. Tucks not sewn at notches, causing misalignment.	119	
Fusible interlining	a. Bulging or delamination.	120	
	b. Strike through of adhesive.		211
	c. Peeling.	121	

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 neckties covered by this specification are intended for wear by women general officer personnel of the U.S. Marine Corps.

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

- a. Title, number, and date of the specification.

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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. Whether first article is required and quantity required (see 3.2).

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

6.4. Figures. Figure 1 is furnished for information purposes only. To the extent of any inconsistencies between the written specification and the figure, the written specification will govern.

6.5. Subject term (keyword) listing.

Neckband
Nylon fastener tape
Tropical polyester 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. 8445-N141

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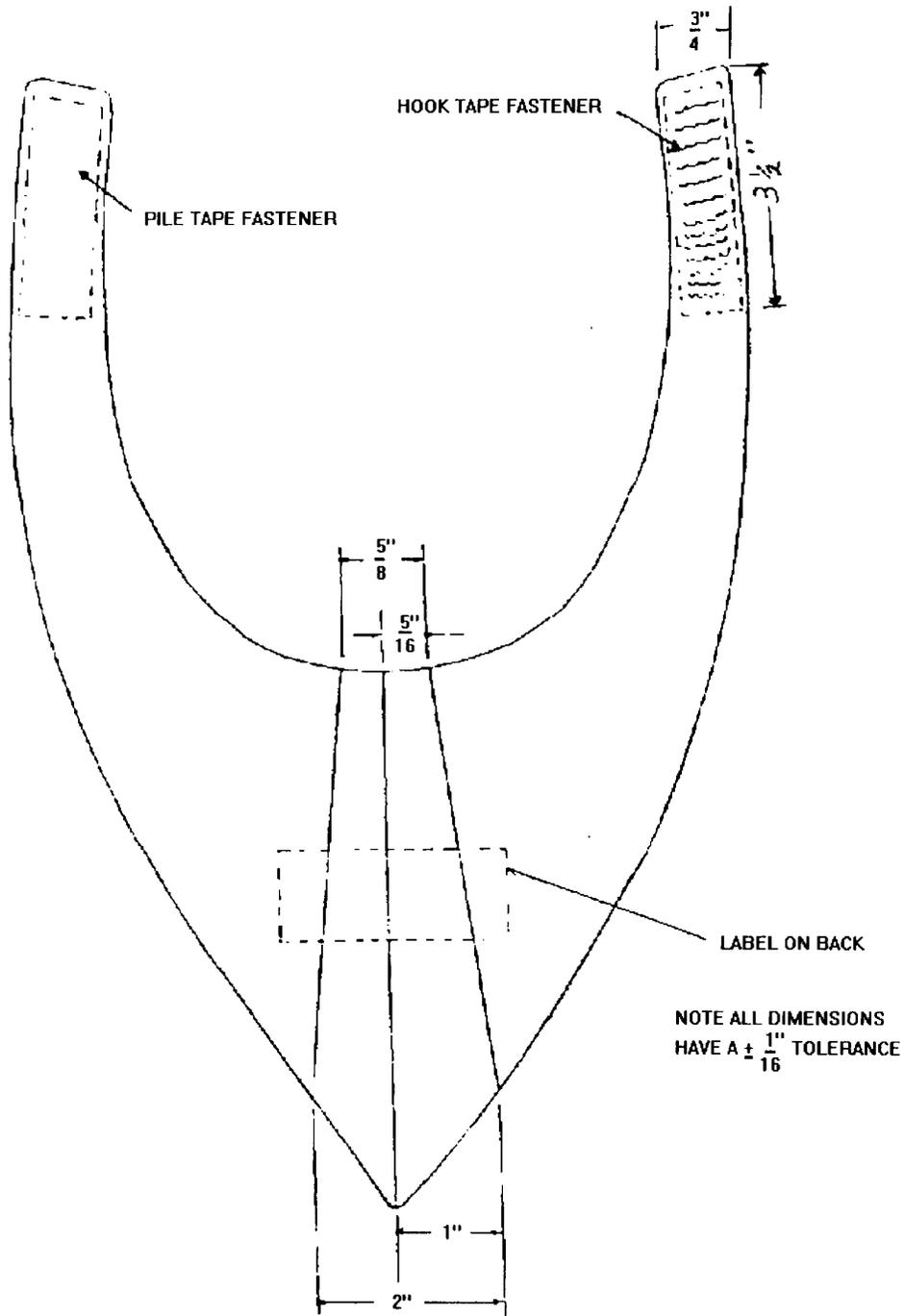


Figure 1. Necktie, Women's - General Officer

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.

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I RECOMMEND A CHANGE:
1. DOCUMENT NUMBER
MIL-DTL-29387C

2. DOCUMENT DATE (YYMMDD)
971016

3. DOCUMENT TITLE NECKTIE, WOMEN'S - GENERAL OFFICER

4. NATURE OF CHANGE *(Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)*
5. REASON FOR RECOMMENDATION
6. SUBMITTER
a. NAME *(Last, First, Middle Initial)*
b. ORGANIZATION
c. ADDRESS *(Include Zip Code)*
d. TELEPHONE *(Include Area Code)*
7. DATE SUBMITTED
(YYMMDD)

(1) Commercial

 (2) AUTOVON
(if applicable)
8. PREPARING ACTIVITY
a. NAME

COMMANDER, MARCORSYSCOM, PSE-D

b. TELEPHONE *(Include Area Code)*

 (1) Commercial
(703) 784-4584

 (2) AUTOVON
278-4584

c. ADDRESS *(Include Zip Code)*

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IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT:

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