

INCH-POUND

MIL-DTL-32021(MC)

13 February 1998

DETAIL SPECIFICATION

SKIRTS, WOMEN'S - WHITE

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 the requirements for white polyester/rayon skirts.

1.2. Classification. The skirts will be of one type in the following sizes and lengths (see 6.2):

Schedule of sizes and lengths

Sizes: XO, 2, 4, 6, 8, 10, 12, 14, 16, 18

Lengths: Short, Regular and Long

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

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 8410

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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).

SPECIFICATIONS

FEDERAL

- A-A-50198 - Thread, Gimp, Cotton, Buttonhole
- A-A-50199 - Thread, Polyester Core, Cotton or Polyester Covered
- A-A-52094 - Thread, Cotton
- A-A-52106 - Cloth, Twill or Plain Weave, Polyester and Polyester Blend
- V-B-871 - Button, Sewing Hole, and Button, Staple, (Plastic)
- V-F-106 - Fastener, Slide, Interlocking
- DDD-L-20 - Label: For Clothing, Equipage, and Tentage, (General Use)

DEPARTMENT OF DEFENSE

- MIL-C-368 - Cloth, Satin, Rayon and Cloth, Twill, Rayon
- MIL-B-371 - Braid, Textile, Tubular
- MIL-T-5237 - Tape, Textile; Webbing, Textile; Rayon
- MIL-C-41820 - Cloth, Gabardine, Polyester and Rayon
- MIL-C-44296 - Cloth, Fusible

STANDARDS

FEDERAL

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

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DEPARTMENT OF DEFENSE

MIL-STD-984 - Provisions for Size Labeling of Women's
Uniform Clothing

MIL-STD-1609 - Provisions for Evaluating Quality of Women's
Skirts

(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 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).

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, when furnished, are solely for guidance and information to the contractor (see 6.3). Variation from this specification may appear in the sample, in which case this 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.

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3.3. Materials.

3.3.1 Basic materials. The basic material for the skirt shall be cloth, gabardine, polyester/rayon, white, shade 2400, 8 ounce, conforming to type III, class 1 of MIL-C-41820.

3.3.2 Lining. The material for lining the skirts shall be cloth, twill, rayon, white, shade 2400, 3.7 ounces, conforming to class 1 of MIL-C-368.

3.3.3 Waistband interlining. The waistband interlining and top ply of watch pocket material shall be white twill polyester and cotton conforming to class 1 of A-A-52106. As an alternate, a fusible waistband interlining conforming to type V, class 1, style B of MIL-C-44296 may be used.

3.3.4 Finishing tape. The tape for finishing the bottom of the skirt and edges of back pleat shall be tape, textile, rayon conforming to type 1 of MIL-T-5237. The color shall be the same as specified for thread in 3.3.6.2.

3.3.5 Hanger braid. The braid for the skirt hangers shall be braid, textile, tubular, conforming to type IX, class 1 of MIL-B-371. The color shall be the same as specified for thread in 3.3.6.2.

3.3.6 Thread. Cotton thread shall be used conforming to A-A-52094 as follows:

| Operation | Type | Ticket No. | Ply |
|------------------|------|------------|--------|
| Buttonholes | III | 0 | 3 |
| Seams, stitching | I | 70, 50 | 2 or 3 |
| Buttons | II | 16, 20 | 4 |

As an alternate to the cotton thread, a polyester, cotton-covered thread conforming to A-A-50199 ticket No. 50, 2 or 3 ply may be used for seaming and ticket No. 70, 2 ply may be used for over edging.

3.3.6.1. Automatic button sewing. If an automatic machine which sews and shanks (wraps) the buttons in one operation is used, the thread shall be waxed.

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3.3.6.2. Color. The color of the thread shall be white (see DoD Standard Color Card of Official Standardized Shades for Sewing Threads 1968).

3.3.7 Gimp. The gimp for reinforcing the buttonhole shall be cotton, ticket No. 8, conforming to type I or II of A-A-50198. The color of the gimp shall be the same as indicated for thread in 3.3.6.2.

3.3.8 Buttons. The buttons for the waistband shall be 27-line conforming to type II, class D, style 4 of V-B-871. The color of the buttons shall be white, shade BA, cable No. 62031 (see DoD Standard Shades for Buttons 1966) and shall have a glossy finish.

3.3.9 Slide fasteners. The slide fastener for the skirt shall be brass, white metal finish, 7 inches in length, interlocking non separating automatic lock, open top stop, closed bottom stop, single slider with short tab pull conforming to type I, style 3, size 1 of V-F-106. The tape shall be cotton and the color shall be white.

3.3.10 Labels.

3.3.10.1. Label. Each skirt shall have an identification and instruction label conforming to type VI, class 1 and 3 of DDD-L-20. The fastness to laundering requirements of DDD-L-20 shall apply. The contents shall be 55 percent polyester and 45 percent wool. The content and format shall be as follows:

Skirt, Woman's
Stock No.: 8410-00-000-0000 (Example)
Contents: 55% polyester/45% wool
Contract No.: DLA100-93- (Example)
Name of Contractor
DRY CLEAN ONLY

3.3.10.2. Size label. The size label shall conform to type VI, class 2 of DDD-L-20 except the stock number is not required. The inscription on the size label shall conform to MIL-STD-984; Table II Height Ranges, Table III Body Measurements for Marine Corps and Figure 2.

3.4. Design. The skirt shall be the U.S. Marine Corps design shown in Figures 1, 2, and 3, having a gore style skirt with three front panels and two back panels, full lining, an opening

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at the top of the center back seam with a slide fastener closure, and a one-piece set-on waistband with both ends to button at the center opening. The skirt shall have a center back pleat and the bottom shall be pinked.

3.5. Patterns. Standard patterns will be furnished to the contractor by the Government (see 6.3). 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. Standard patterns show size, seam allowances, directional lines for cutting, and are marked or notched for proper placement and assembly of the component parts. The patterns provide an allowance of 3 inches for hemming the bottom of the skirt.

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

| ITEM | PATTERN NOMENCLATURE | NO. OF CUT PARTS |
|------|--|------------------|
| | Material: Basic | |
| 1 | Center front | 1 |
| 2 | Side front | 2 |
| 3 | Back | 2 |
| 4 | Waistband | 1 |
| 5 | Placket | 1 |
| 6 | Watch pocket (bottom ply) | 1 |
| | Material: Lining | |
| 7 | Front | 1 |
| 8 | Left back | 1 |
| 9 | Right back | 1 |
| | Material: Twill, polyester and cotton or fusible | |
| 10 | Watch pocket (top ply) (twill) | 1 |
| 11 | Waistband-interlining (twill or fusible) | 1 |

3.6. Construction. The skirts shall be manufactured in accordance with operation requirements as specified in Table I. The contractor is not required to follow the exact sequence of operation as listed in Table I, but all operations specified shall be used to manufacture the skirts.

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3.6.1 Stitches, seams, and stitchings. Stitch, seam, and stitching types specified in Table I shall conform to FED-STD-751. The minimum and maximum number of stitches per inch shall be specified in Table I.

3.6.1.1. Thread breaks and ends of seams. The ends of all seams and stitching produced with 301 stitch type, when not caught in other seams or stitching, shall be backstitched not less than 1/4 inch. Thread breaks (all stitch types) shall be secured by stitching back of the break not less than 1/2 inch. Skipped stitches may be repaired by using 301 stitch type. The ends of a continuous line of stitching shall be overlapped not less than 1/2 inch. Thread ends of darts shall be trimmed to a length of 1/2 inch. When an automatic dart machine is used, the ends shall be backstitched not less than three stitches.

3.6.2 Buttonhole. The buttonhole shall be eyelet end, taper bar type. The finished cut length of buttonhole shall be 3/4 inch.

3.6.3 Pressing. Pressing as required in Table I shall be accomplished with a heated pressing iron or machine.

3.6.4 Shade marking. The component parts shall be marked to ensure a uniform shade and size throughout the skirt. 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 or leave traces of paper or adhesive mass to the material upon removal of the tickets.

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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 skirt in strict accordance with patterns furnished by the Government.</p> <p>b. Cut all materials in the direction indicated by directional lines on pattern. The directional line shall be placed in the warp direction of the cloth unless otherwise indicated on the pattern.</p> <p>c. Cut component parts of skirt from one piece of basic material, except placket, which may be cut from ends.</p> <p>d. Cut front and back lining parts of the skirt from one piece of lining material.</p> <p>NOTE: The back lining may be cut on the selvage.</p> <p>e. Cut braid for skirt hangers in lengths of $4 \pm 1/8$ inches. Each skirt shall be provided with two hangers.</p> <p>f. Cut hem tapes not less than 65 inches long (see operation 26) and 18 inches long for edges of the kick pleat.</p> | | | | | |
| 2 | <p><u>Replacement of damaged parts.</u></p> <p>a. Replace at time of cutting any part of the skirt containing holes or seriously weakening defects such as smashes, multiple floats, loose weakening slubs, etc., expected to develop into holes, shade bars and dye streaks or unsightly slubs, etc.</p> <p>b. Replace any part damaged during manufacturing process by needle chews which may develop into a hole, scissor or knife cuts, tears, holes, mends or burns in the material.</p> | | | | | |

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TABLE I. Manufacturing requirements - Continued.

| NO | OPERATION | STCH TYPE | SEAM/ STCH TYPE | STCH/IN | NDL | BOB/ LPR |
|----|--|-----------------------------|-----------------------|--------------------|--------------|--------------|
| 3 | <u>Shade marking.</u> a. Mark, ticket or bundle all component parts (see 3.6.4) cut from one piece of basic material, except those parts cut from ends, to ensure uniform shade and size throughout the skirt. | | | | | |
| 4 | <u>Join front and back skirt panels.</u> a. Join the side front panels to the center front panel with a 3/4 inch seam allowance and with notches matching. The ends of the seam shall start and finish evenly at the seam line. b. From the bottom of the upper notch to the mark at the top of the kick pleat, join the back panels with a 1 inch seam allowance. The ends of the seams shall start and finish evenly at the seam line. | 301 301 | SSa-1 SSa-1 | 12-14 12-14 | 50 50 | 50 50 |
| 5 | <u>Tape edges of kick pleat.</u> a. The edges of the kick pleat shall be taped from the top of curve to bottom of unfinished hem. Place the left edge of tape to the top raw edge of pleat opening and stitch 1/8 inch from the edge. Turn tape to underside of basic fabric and blindstitch other edge of tape to the underside of skirt. | 301 | BSa-1 | 12-14 | 50 | 50 |
| 6 | <u>Over edge seams.</u> a. The raw edges of the seam allowance on the front and back parts shall be neatly over edge stitched. b. The center back seam shall be over edged together from the bottom of zipper (at the right side notch) to the curve at the top of the kick pleat. NOTE: Care shall be exercised during the over edging operation to ensure that no seam allowance is reduced by more than 1/16 inch. | 501 or 503 501 | Efd-1 EFd-1 | 8-10 8-10 | 70 70 | 70 70 |

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TABLE I. Manufacturing requirements - Continued.

| NO | OPERATION | STCH TYPE | SEAM/ STCH TYPE | STCH/IN | NDL | BOB/ LPR |
|----|--|--------------|-----------------------|---------|-----|-------------|
| 7 | <u>Tack the kick pleat.</u> a. The pleat shall finish left over right and shall be tacked through all plies from the center seam to the edge of the width of the pleat (approximately 2-3/4 inches, slanted downward 1/2 inch over total length). | 301 | SSa-1 | 12-14 | 50 | 50 |
| 8 | <u>Join front and back parts.</u> a. Join the front and back parts of skirt at the side seams with a 1-inch seam allowance and with notches matching. | 301 | SSa-1 | 12-14 | 50 | 50 |
| 9 | <u>Press seams.</u> a. Spread open all seams and press smooth and flat with a heated iron or pressing machine. The edges of the back opening shall be folded back in a straight line with the back seam line and well creased. | | | | | |
| 10 | <u>Pink bottom edge of skirt.</u> a. The raw edge of the bottom of the front and back skirt shall be neatly and evenly pinked with the points of the pinking 1/8 inch in depth. NOTE: Care shall be exercised during the pinking operation to assure that the length of the skirt is not reduced by more than 1/16 inch. | | | | | |
| 11 | <u>Make watch pocket.</u> a. The watch pocket shall be made of one ply of basic material and one ply of polyester/cotton twill and shall finish not less than 4 inches wide and 4 inches deep. b. Position both plies of watch pocket face up and with sides and bottom edges even. Join both plies together 3/8 inch from raw edges, 1/2 inch down from top raw edges at each side. -or- | 301 | SSa-1 | 10-14 | 50 | 50 |

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TABLE I. Manufacturing requirements - Continued.

| NO | OPERATION | STCH TYPE | SEAM/ STCH TYPE | STCH/IN | NDL | BOB/ LPR |
|----|---|------------------|-----------------------|---------|------|-------------|
| 11 | <u>Make watch pocket.</u> (cont'd) | | | | | |
| | c. The watch pocket may be joined by seaming and over edge stitching the raw edges together in one operation. | 516 or 517 | SSa-2 | 12-14 | 70 | 70 |
| 12 | <u>Attach watch pocket.</u> | | | | | |
| | Position the top inside edge of the polyester/cotton twill side of the pocket to the top raw edge of the right front of the skirt waist. The notch of the pocket shall be 1 inch in from the side seam. Join the pocket to the skirt waist with a 3/8 inch seam from notch to notch forming a 4 inch wide opening at the top of the waist seam. Turn the pocket up and raise stitch 1/16 inch through twill cloth and front of skirt, catching all plies. | 301 | SSa-1 | 12-14 | 50/3 | 50/3 |
| | b. Notch and turn pocket to the inside and bar tack each edge of opening. | Bar tack | | 21-28 | 0 | 0 |
| | NOTE: Watch pocket shall be between basic fabric and lining. | | | | | |
| 13 | <u>Join lining back parts.</u> | | | | | |
| | Finished appearance. The lining back parts shall be joined without gathers, puckers or pleats. | | | | | |
| | a. Position the lining back parts face to face with edges even and join at the center with a 1 inch seam, from the bottom of zipper mark to the bottom of lining. | 301 | SSa-1 | 12-14 | 50 | 50 |
| 14 | <u>Stitch darts in front and back lining.</u> | | | | | |
| | Finished appearance. The darts shall be tapered to a point at the lower end and shall finish without gathers, puckers or pleats. | | | | | |

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TABLE I. Manufacturing requirements - Continued.

| NO | OPERATION | STCH TYPE | SEAM/ STCH TYPE | STCH/IN | NDL | BOB/ LPR |
|----|---|--------------|-----------------------|---------|-----|-------------|
| 14 | <u>Stitch darts in front and back lining.</u> (cont'd) | | | | | |
| | a. Fold and stitch front and back lining waist darts in accordance with marks and notches as indicated on the pattern. The lower ends of waist darts shall be well tapered to a flat point. | 301 | OSf-1 | 12-14 | 50 | 50 |
| | b. Press the darts smooth and flat with a heated pressing iron, with the inside folded edge of waist darts towards the center of the lining. | | | | | |
| 15 | <u>Join front and back parts of lining.</u> | | | | | |
| | a. Join the front and back parts of lining at the side seam with a 1 inch seam and with notches matching. The back seam shall be joined from the bottom edge of lining to 7-1/2 inches from the top raw edge to provide for the center back opening | 301 | SSa-1 | 12-14 | 50 | 50 |
| | b. The back opening shall be edge stitched 1/8 - 1/4 inch on each side. | 301 | EFa-1 | 12-14 | 50 | 50 |
| 16 | <u>Press lining seams.</u> | | | | | |
| | a. Spread open the center back seam and side seams and press smooth and flat with a heated iron or pressing machine. | | | | | |
| 17 | <u>Pink seams and bottom edge of lining.</u> | | | | | |
| | a. The raw edge of the seam allowance at the side seams, center back lining, and raw edges at the bottom of the front and back lining shall be neatly and evenly pinked with the points of the pinking 1/8 inch in depth. | | | | | |
| | NOTE: Care shall be exercised during the pinking operation to assure that no seam allowance is reduced more than 1/16 inch. | | | | | |
| 18 | <u>Make waistband.</u> | | | | | |
| | Finished appearance. On the finished skirt, the outside end of the waistband shall be pointed and the inside end shall be squared. | | | | | |

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TABLE I. Manufacturing requirements - Continued.

| NO | OPERATION | STCH TYPE | SEAM/ STCH TYPE | STCH/IN | NDL | BOB/ LPR |
|----|---|------------------|-----------------------|---------|-----|-------------|
| | a. The waistband shall be made of a single ply of basic material and a single ply of interlining (twill or fusible). | | | | | |
| | b. Position the interlining on the inside of waistband with bottom edges even. Stitch the interlining to the underside of waistband along the top and bottom edges of interlining with a 1/8 inch seam. The line of stitching shall extend the entire length of waistband but the stitching shall not show on the front of the waistband. -or- When fusing the interlining to the waistband, position the interlining on the inside of waistband with bottom edges even. Stay stitch is not required. | 301 | SSa-1 | 12-14 | A | A |
| | c. Over edge stitch the inside raw edge of waistband. | 503 or 504 | EFd-1 | 8-10 | 70 | 70 |
| | d. Fold the waistband in half lengthwise face to face with notches matching. Join the two plies together, at the pointed end, with 3/8 inch seam, starting at the folded edge. | 301 | SSe-2 | 12-14 | 50 | 50 |
| | e. Close the squared end by seaming the two plies together 3/8 inch from the bottom raw edges, starting approximately midway between the notches and the end of the waistband, then seam straight across the width of the waistband to close the end. | 301 | SSe-2 (a) | 12-14 | 50 | 50 |
| 18 | <u>Make waistband.</u> (cont'd) | | | | | |
| | f. Trim the excess material at both ends to 1/8 inch from the seams. Turn the waistband, forcing out the corners and point completely, and edge stitch 1/16 inch from the seamed edges at the pointed and squared ends. | 301 | SSe-2 (b) | 12-14 | 50 | 50 |

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TABLE I. Manufacturing requirements - Continued.

| NO | OPERATION | STCH TYPE | SEAM/ STCH TYPE | STCH/IN | NDL | BOB/ LPR |
|----|--|------------------|-----------------------|---------|-----|-------------|
| | g. Continue to edge stitch along the length of the waistband 1/16 inch from the folded edge. | 301 | OSf-1 | 12-14 | 50 | 50 |
| | h. The edge stitching may be performed continuously with the top stitching on the outside of the waistband in operation 23.a. | | | | | |
| 19 | <u>Assemble placket and slide fastener (see Figure 3).</u> Finished appearance. The placket shall be smooth and flat. The folds of the skirt shall completely cover the slide fastener when slide fastener is closed. The stitching shall not interfere with the operation of the slider. | | | | | |
| | a. Fold the placket in half lengthwise, with the right side out. Baste the two plies together along the folded edge. -or- | 101 | OSf-1 | 6-8 | 50 | 50 |
| | b. The folded edge may be pressed. | | | | | |
| | c. Over edge stitch the side and bottom raw edges of placket together. | 503 or 504 | EFd-1 | 8-10 | 70 | 70 |
| | d. Place the closed slide fastener on the face (over edge seam to the right) side of the placket with the top end of the chain 1/2 inch below the top raw edge of the placket, and with the center of the chain 5/8 to 3/4 inches from the folded edge of placket. | | | | | |
| 19 | <u>Assemble placket and slide fastener (see Figure 3).</u> (cont'd) | | | | | |
| | e. Join the right half of the fastener to the placket with a single row of stitches 3/16 to 1/4 inch from the chain edge through the tape and both plies of the placket. | 301 | SSak-1 | 12-14 | 50 | 50 |

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TABLE I. Manufacturing requirements - Continued.

| NO | OPERATION | STCH TYPE | SEAM/ STCH TYPE | STCH/IN | NDL | BOB/ LPR |
|----|---|--------------|-----------------------|---------|-----|-------------|
| 20 | <p><u>Join placket assembly to skirt (see Figure 3).</u></p> <p>a. Open the slide fastener and place the front half of it on the inside of the right part of the skirt at the back opening, with the top end of the chain positioned 1/2 inch below the top raw edge and the chain positioned even with the creased front edge of the back opening.</p> <p>b. Join the left half of the slide fastener to the skirt with a single row of stitches through the tape and left back panel of the skirt. The row of stitches shall extend from the top edge of the left back panel to 1/4 to 3/8 inch below the bottom end of the chain, and shall be uniformly 5/16 inch from the center edge of the back opening.</p> <p>c. Close the slide fastener and turn the skirt right side out. Position the right back part of the skirt on the placket, holding the right edge of the opening as close as possible to the chain of the slide fastener so that in the finished skirt, the edge of the opening conceals the zipper when the skirt is worn. Join the right back to the placket assembly with a 5/16 inch seam from the folded edge of the right back opening through the slide fastener tape and the placket.</p> <p>d. Topstitch across the bottom end of the opening through the slide fastener tape and the placket with a single row of stitches. The stitching shall not extend past the finished stitching of each side opening.</p> | 301 | SSak-1 | 12-14 | 50 | 50 |
| | | 301 | LSah-1 | 12-14 | 50 | 50 |
| | | 301 | SSv-1 | 12-14 | 50 | 50 |
| 21 | <p><u>Joining lining to skirt.</u></p> <p>Finished appearance. The right side of lining shall be $3/4 \pm 1/8$ inch from the folded edge of placket and the left side lining shall be $1/4 \pm 1/8$ inch from the folded edge of back opening.</p> | | | | | |

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TABLE I. Manufacturing requirements - Continued.

| NO | OPERATION | STCH TYPE | SEAM/ STCH TYPE | STCH/IN | NDL | BOB/ LPR |
|----|--|--------------|-----------------------|---------|-----|-------------|
| | a. Join lining to the skirt at the waist with a 1/4 inch seam from the respective seams with the right side seams matching equally distributing the fullness. The back opening of the lining shall not overlap the slide fastener. | 301 | SSa-1 | 12-14 | 50 | 50 |
| 22 | <u>Join waistband to skirt, with hangers.</u> | | | | | |
| | a. Position the waistband on the outside of the skirt, with notches at the pointed end of waistband even with the left back edge of the skirt, with the raw edge of the waistband even with the top raw waist edge of skirt and with the notches at the square end of the waistband matching the right back folded edge of skirt. | | | | | |
| | b. Join the outside part of the waistband to the skirt with a 3/8 inch seam, with the braid for the hanger folded in half to form a loop and with the ends of the loops placed on the inside of the skirt and the watch pocket caught in the stitching. | 301 | BSr-1 (a) | 12-14 | 50 | 50 |
| | c. The hangers shall be positioned one at the right side seam line and one at the left side seam line. | | | | | |
| | d. In the finished skirt, the length of the hanger loop shall be 1-5/8 ± 1/8 inches, measured from the bottom edge of the waistband to the end of the loop. | | | | | |
| 23 | <u>Topstitch waistband.</u> | | | | | |
| | Finished appearance. The waistband shall be sewn on smoothly and evenly and shall have a flat appearance without gathers, puckers, pleats or other distortions either in the waistband, front part or back part, and shall be even width along the entire length. The waistband shall be 1-1/4 ± 1/8 inch wide. The pointed end shall extend 1-1/2 ± 1/8 inches beyond the center back edge of the back opening, and the squared end shall extend 2 ± 1/8 inches beyond the back edge of the back opening. | | | | | |

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TABLE I. Manufacturing requirements - Continued.

| NO | OPERATION | STCH TYPE | SEAM/ STCH TYPE | STCH/IN | NDL | BOB/ LPR |
|----|--|--------------|-----------------------|--|-----|-------------|
| | a. Turn back the waistband and topstitch the waistband to the skirt 1/16 inch from the raised edge, catching the over edge stitched portion in the stitching, and with the stitching extending the entire length of the waistband. | 301 | BSr-2 (b) | 12-14 | 50 | 50 |
| 24 | <u>Make buttonholes.</u> Finished appearance. The buttonholes shall be clean cut, well made and correctly positioned. The stitching shall be securely caught in the basic material. The buttonholes shall be well worked over gimp to fit 27-line buttons. The purling of the buttonholes shall be on the outside of the waistband. | | | | | |
| | a. Make a 3/4 inch long horizontal, eyelet-end, taper-bar type buttonhole through the center of the pointed and squared ends of the waistband with the inside purling edge of the eyelet 1/2 to 5/8 inch from the finished ends to waistband. | Button-hole | | 52-54 per button-hole including tack | 0/3 | 0/3 |
| 25 | <u>Clean skirt.</u> a. All ends of stitching shall be trimmed and the loose threads removed from skirt. Pull and remove any basting threads. | | | | | |
| 25 | <u>Clean skirt.</u> (cont'd) b. Any spots, stains and shade tickets or markings shall be removed without injury to the material. | | | | | |
| 26 | <u>Press skirt.</u> a. The entire skirt shall be pressed smooth with a heated steam pressing iron or steam pressing machine. Press marks and gloss shall be removed. | | | | | |

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TABLE I. Manufacturing requirements - Continued.

| NO | OPERATION | STCH TYPE | SEAM/ STCH TYPE | STCH/IN | NDL | BOB/ LPR |
|----|---|--------------------------------|-----------------------|--|------|-------------|
| 27 | <p><u>Sew on buttons.</u></p> <p>a. Close the slide fastener and mark the inside and outside ends of waistband with the location for sewing on the buttons to correspond with the eyelet of buttonholes.</p> <p>b. The buttons shall be positioned to engage with the eyelet-end of buttonholes, so that on the finished skirt, the ends of the waistband lie smooth and flat without twisting, bulging or other distortion.</p> <p>c. Securely sew a 27-line button at each mark. The thread ends of hand sewn buttons shall be securely tacked. The button on the outside of waistband shall be sewn through all plies of waistband. The stitches for the button sewn to the inside of the waistband shall not be visible on the outside.</p> | Hand or 101 or 301 | | 4-6 per button- hole (double thread) 14-16 | 16/4 | |
| 28 | <p><u>Prepare for packing.</u></p> <p>a. Examine skirt.</p> <p>b. An envelope containing the tape for the skirt hem shall be attached by string to the left hanger loop.</p> | | | | | |

3.7. Finished measurements. The finished skirt shall conform to the measurements shown in Table II. The skirt shall be buttoned and slide fastener closed and be placed flat upon a table for measuring, except as otherwise specified herein.

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Table II. Finished measurements.

| Short | | | |
|-------------|-----------------|----------------|------------------|
| Size | Waist <u>1/</u> | Seat <u>2/</u> | Length <u>3/</u> |
| XO | 22-1/2 | 34-1/2 | 25-7/16 |
| 2 | 23-1/2 | 35-1/2 | 25-5/8 |
| 4 | 24-1/2 | 36-1/2 | 25-13/16 |
| 6 | 25-1/2 | 37-1/2 | 26 |
| 8 | 27 | 39 | 26-3/16 |
| 10 | 28-1/2 | 40-1/2 | 26-3/8 |
| 12 | 30 | 42 | 26-9/16 |
| 14 | 32 | 44 | 26-3/4 |
| 16 | 34 | 46 | 26-15/16 |
| Regular | | | |
| XO | 22-1/2 | 34-1/2 | 26-15/16 |
| 2 | 23-1/2 | 35-1/2 | 27-1/8 |
| 4 | 24-1/2 | 36-1/2 | 27-5/16 |
| 6 | 25-1/2 | 37-1/2 | 27-1/2 |
| 8 | 27 | 39 | 27-11/16 |
| 10 | 28-1/2 | 40-1/2 | 27-7/8 |
| 12 | 30 | 42 | 28-1/16 |
| 14 | 32 | 44 | 28-1/8 |
| 16 | 34 | 46 | 28-7/16 |
| 18 | 36 | 48 | 28-5/8 |
| Long | | | |
| 2 | 23-1/2 | 35-1/2 | 28-5/8 |
| 4 | 24-1/2 | 36-1/2 | 28-13/16 |
| 6 | 25-1/2 | 37-1/2 | 29 |
| 8 | 27 | 39 | 29-3/16 |
| 10 | 28-1/2 | 40-1/2 | 29-3/8 |
| 12 | 30 | 42 | 29-9/16 |
| 14 | 32 | 44 | 29-3/4 |
| 16 | 34 | 46 | 29-15/16 |
| 18 | 36 | 48 | 30-7/16 |
| Tolerances: | <u>+1/2</u> | <u>+1/2</u> | <u>+1/2</u> |

1/ Twice the measurement taken from folded edge to folded edge at center of waistband with slide fastener closed and waistband buttoned.

2/ Twice the measurement taken from folded edge to folded edge of skirt, 7 inches down from lower edge of waistband.

3/ Measurement taken at center front from lower edge of waistband to bottom edge of unhemmed skirt (see Figure 1).

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3.8. Workmanship. The finished skirts 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-1609.

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

4.4. Conformance inspection.

4.4.1 Components and material inspection. 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.

4.4.2 Examination of the end item. Samplings and examination of the end item shall be performed for dress (D) skirts in accordance with the provisions of MIL-STD-1609.

4.4.3 Dimensional examination. The dimensional examination provisions for the finished skirts shall be as listed in 3.7 and as specified in MIL-STD-1609.

4.4.4 In-process inspection. Inspection shall be performed during the manufacturing of the end item to ascertain that the operations are performed as specified herein. The Government

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reserves the right to determine the acceptability of construction methods not performed in accordance with specified requirements for operations or subassemblies.

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 skirts described herein are intended for wear by female 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.
- 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. Classes and sizes required (see 1.2).
- e. Whether first article is required (see 3.2).
- f. Number of skirts in first article (see 3.2).

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

6.4. Figures. Figures 1 through 3 are furnished for information purposes only. To the extent of conflict between these figures

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and the text of this specification, the text of this specification will govern.

6.5. Subject term (keyword) listing.

Hanger braid
Slide fastener
Waistband
Watch pocket

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. 8410-N900

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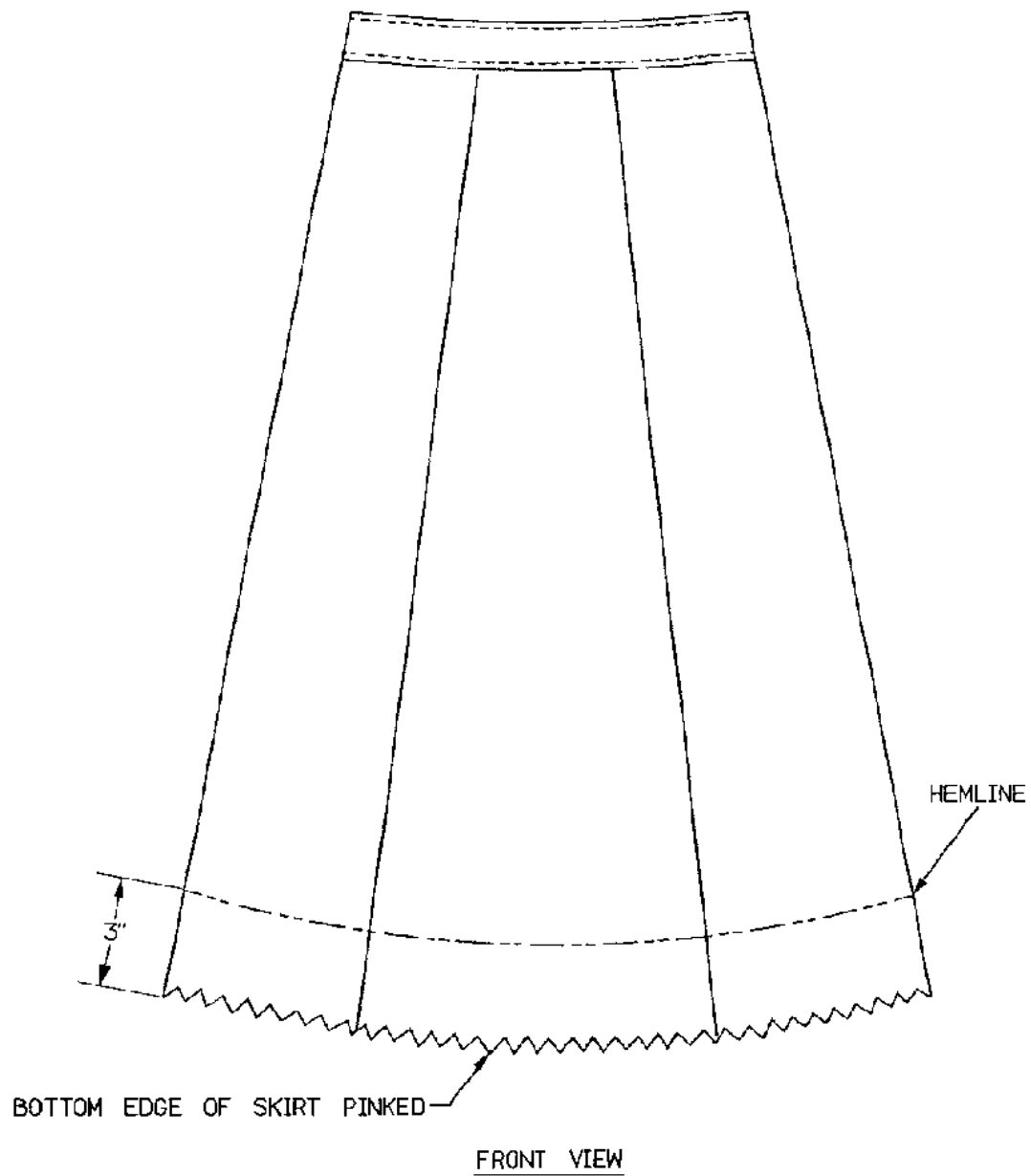


Figure 1. Skirts, Women's - White

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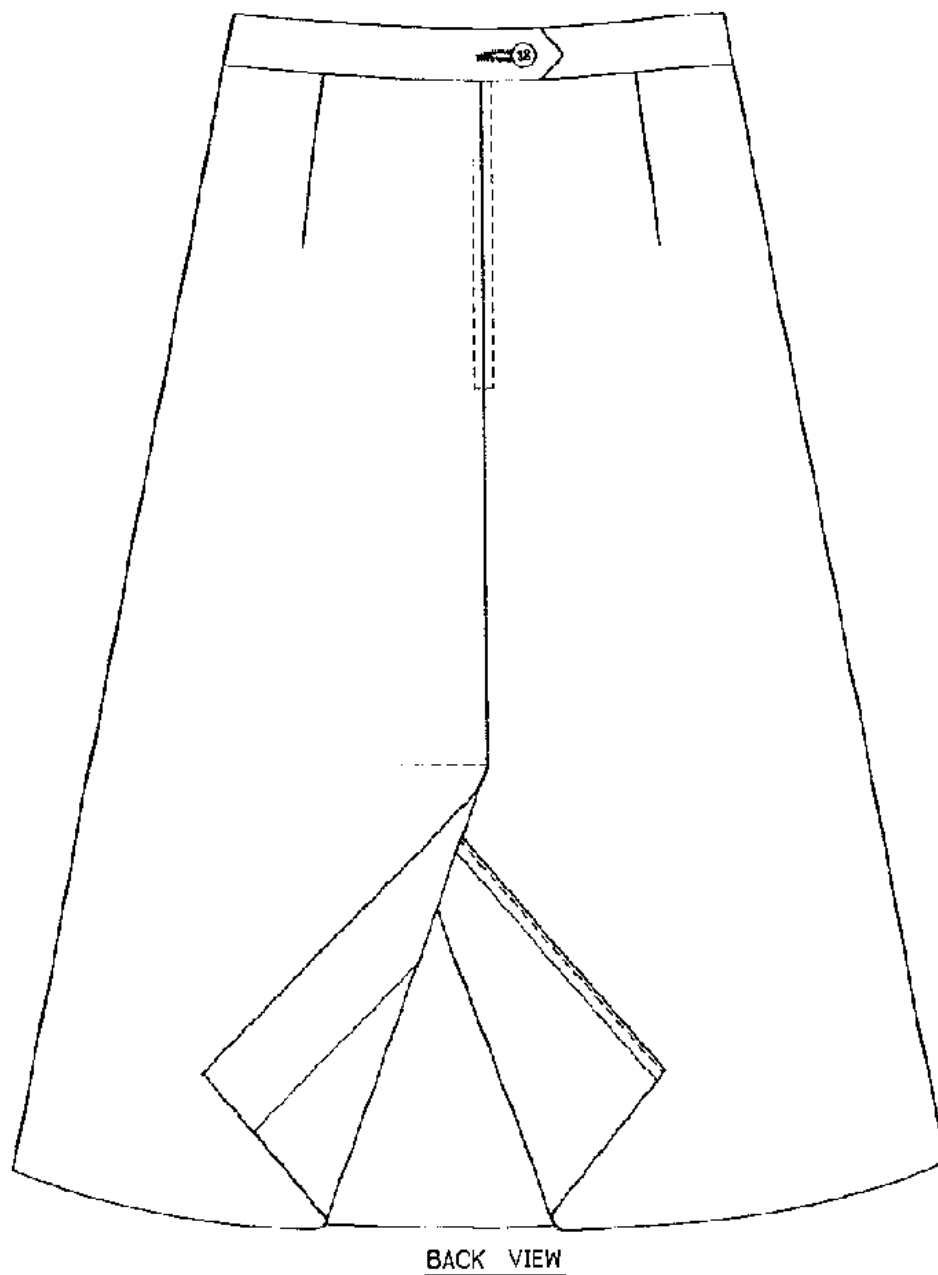


Figure 2. Skirts, Women's - White

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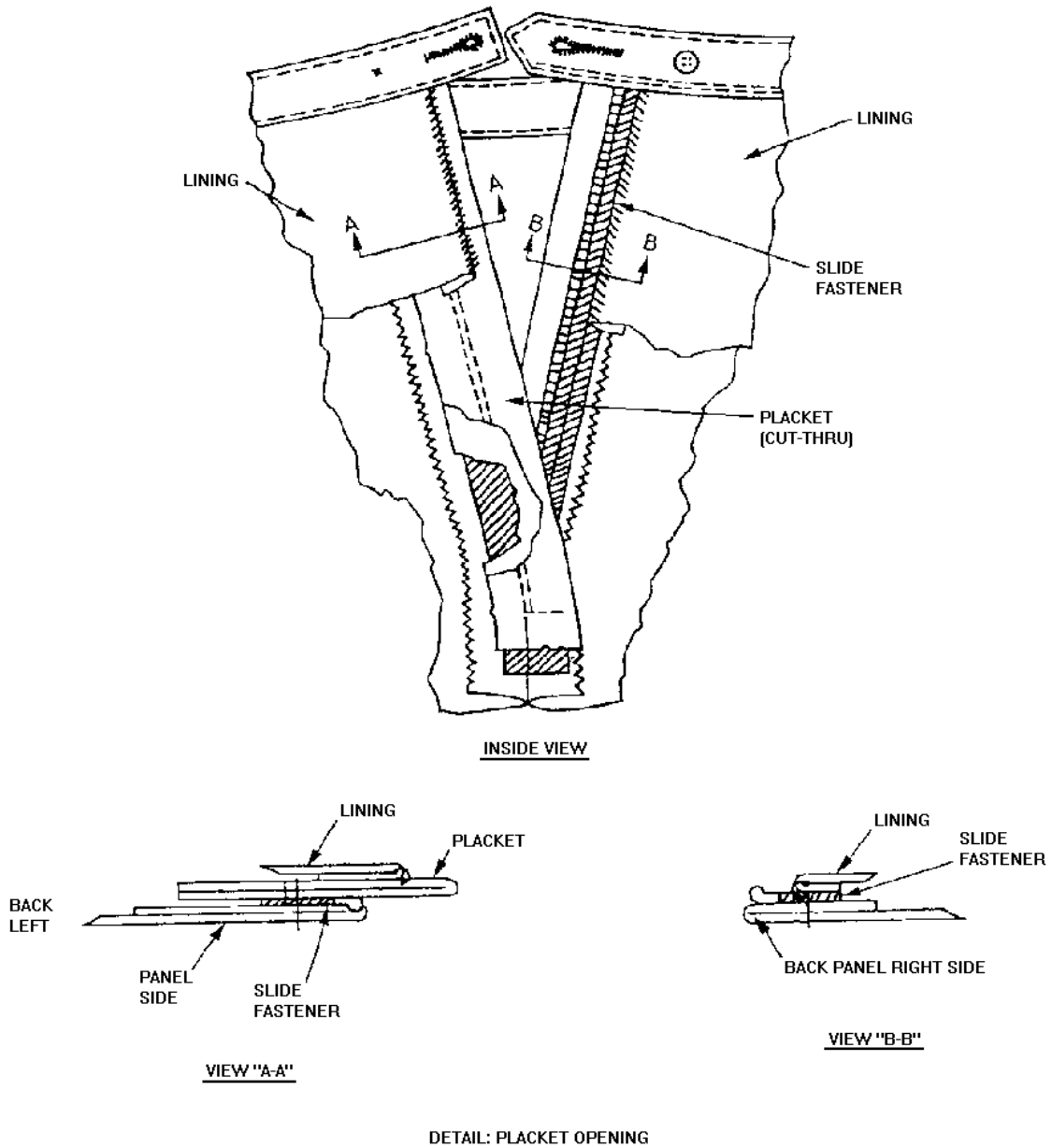


Figure 3. Skirts, Women's - White

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| STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL | | |
|---|--|---|
| INSTRUCTIONS | | |
| <p>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.</p> <p>2. The submitter of this form must complete blocks 4, 5, 6, and 7.</p> <p>3. The preparing activity must provide a reply within 30 days from receipt of the form.</p> <p>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.</p> | | |
| I RECOMMEND A CHANGE: | 1. DOCUMENT NUMBER MIL-DTL-32021 | 2. DOCUMENT DATE (YYMMDD) 13 February 1998 |
| 3. DOCUMENT TITLE | SKIRTS, WOMEN'S - WHITE | |
| 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) (1) Commercial (2) DSN (if applicable) | 7. DATE SUBMITTED (YYMMDD) |
| 8. PREPARING ACTIVITY | | |
| a. NAME COMMANDER, MARCORSYSCOM, PSE-D | b. TELEPHONE (include Area Code) (1) Commercial (2) DSN (703) 784-4584 278-4584 | |
| c. ADDRESS (Include Zip Code) 2033 BARNETT AVE, SUITE 315, QUANTICO, VA 22134-5010 | IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT: Defense Quality and Standardization Office 5203 Leesburg Pike, Suite 1403, Falls Church, VA 22041-3466 Telephone (703) 756-2340, DSN 289-2340 | |

DDFORM 1426, OCT 89 (EF)

Previous editions are obsolete.