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INCH-POUND
MIL-DTL-43455K
2 August 2007
SUPERSEDING
MIL-C-43455J
21 August 1991

DETAIL SPECIFICATION

COAT, COLD WEATHER, FIELD

This specification is approved for use by the Defense Supply Center, Philadelphia 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 one type of a straight front, cold weather, field coat made of water repellent fabrics.

1.2 Classification. The coat will be of the following classes and sizes, as specified (see 6.2):

Class 1	-	Olive Green 107
Class 2	-	Woodland Camouflage Printed
Class 3	-	Deleted (see 6.8)
Class 4	-	Desert Camouflage Printed (3 color)
Class 5	-	Universal Camouflage Printed

Schedule of Sizes

XX-Short	X-Short	Short	Regular	Long	X-Long	XX-Long
	X-Small	X-Small	X-Small	X-Small		
Small	Small	Small	Small	Small		
Medium	Medium	Medium	Medium	Medium	Medium	
		Large	Large	Large	Large	Large
		X-Large	X-Large	X-Large	X-Large	
					XX-Large	

Comments, suggestions, or questions on this document should be addressed to Defense Supply Center Philadelphia, Clothing and Textiles Directorate, Attn: DSCP-FQSE, 700 Robbins Avenue, Bldg 6D, Philadelphia, PA, 19111-5096 or emailed to Elizabeth.Roland@dla.mil. Since contact information can change, you may want to verify the currency of this address information using the ASSIST Online database at http://assist.daps.dla.mil

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2 APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 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 cited in the solicitation or contract.

FEDERAL SPECIFICATIONS

V-B-871 - Button, Sewing Hole and Button, Staple (Plastic)

FEDERAL STANDARDS

FED-STD-4 - Glossary of Fabric Imperfections
FED-STD-595 - Colors Used In Government Procurement (color chip 34094)

COMMERCIAL ITEM DESCRIIPTIONS

A-A-50186 - Cloth, Buckram, Woven and Nonwoven
A-A-50198 - Thread, Gimp, Cotton Buttonhole
A-A-50199 - Thread, Polyester Core, Cotton- or Polyester-Covered
A-A-55126 - Fastener Tape, Hook and Loop, Synthetic
A-A-55634 - Fasteners, Slide, Interlocking

DEPARTMENT OF DEFENSE SPECIFICATIONS

MIL-B-371 - Braid, Textile, Tubular
MIL-C-3924 - Cloth, Oxford, Cotton Warp and Nylon Filling, Quarpel Treated
MIL-C-43247 - Cloth, Knitted, Nylon, Tubular, Stretch Type
MIL-C-43303 - Cord, Elastic, Cotton
MIL-C-44296 - Cloth, Fusibles
MIL-DTL-10884 - Fasteners, Snap
MIL-DTL-32072 - Thread, Polyester
MIL-DTL-32075 - Label: For Clothing, Equipage and Tentage (General Use)
MIL-DTL-43191 - Cloth, Wind Resistant Sateen, Cotton and Nylon
MIL-T-3530 - Thread and Twine; Mildew Resistant or Water Repellent Treated
MIL-T-43566 - Tape, Textile, Cotton or Polyester, Genera Purpose, Natural or in Colors

(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available on-line at http://assist.daps.dla.mil/quicksearch/ or from the Standardization Documents Order Desk, 700 Robbins Avenue, Philadelphia, PA 19111-5094.)

2.2 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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AMERICAN SOCIETY FOR TESTING AND MATERIALS

ASTM-D-6193 - Standard Practice for Stitches and Seams

(Copies of these documents are available from the American Society for Testing and Materials, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959 or from www.astm.org.)

AMERICAN NATIONAL STANDARDS INSTITUTE (ANSI)/AMERICAN SOCIETY FOR QUALITY (ASQ)

ANSI/ASQ Z1.4 - Sampling Procedures and Tables for Inspection of Attributes

(Copies of these documents are available from the American National Standards Institute, 1430 Broadway, New York, NY 10018-3308 or from www.ansi.org.)

NATIONAL AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.

NASM 20652/1 - Eyelets, Metallic, Rolled Flange Type and Eyelet Washer

(Copies of these documents are available from the Aerospace Industries Association, 1000 Wilson Boulevard, Suite 1700, Arlington, VA 22209-3928 or from global.ihs.com/?RID=AIA)

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

3. REQUIREMENTS

3.1 First article. When specified (see 6.2), a sample shall be subjected to first article inspection (see 6.3) in accordance with 4.3.

3.2 Sample. Samples, when furnished, are solely for guidance and information to the contractor (see 6.4). Variation from this specification may appear in the sample, in which case this specification shall govern.

3.3 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.

3.3.1 Basic material.

3.3.1.1 Class 1. The basic material for the class 1 coat shall be Olive Green 107 conforming to class 2 of MIL-DTL-43191. The material for the hanging pockets shall be Olive Green 107 conforming to class 2 or dyed to ground shade conforming to class 3 of MIL-DTL-43191.

3.3.1.2 Class 2. The basic material for the class 2 coat shall be woodland camouflage printed, conforming to class 3 of MIL-DTL-43191. The material for the hanging pockets shall be woodland camouflage printed conforming to class 3, ground shade conforming to class 3 or Camouflage Green 483 conforming to class 2 of MIL-DTL-43191. As an alternate, printed seconds are allowed for the field coat on parts not visible as worn which include the lower hanging pocket, waist tunnel and lower pocket bearer.

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Printed seconds cloth shall be cloth which has been rejected only for defects pertaining to color, infrared reflectance or camouflage printed pattern.

3.3.1.3 Class 4. The basic material for the class 4 coat shall be desert camouflage printed (3 color), conforming to class 5 of MIL-DTL-43191. The material for the hanging pockets shall be desert camouflage printed (3 color) conforming to class 5 or ground shade conforming to class 5 of MIL-DTL-43191.

3.3.1.4 Class 5. The basic material for the class 5 coat shall be universal camouflage printed conforming to class 6 of MIL-DTL-43191. The material for the hanging pockets shall be universal camouflage printed conforming to class 6 or ground shade conforming to class 6 of MIL-DTL-43191.

3.3.2 Lining. The material for lining the coat and interlining the fronts shall conform to class 2 of MIL-C-3924. The color for class 1 shall be Olive Green 107, for class 2 shall be Camouflage Green 483, for class 4 shall be Tan 380 and for class 5 shall be Foliage Green 504. As an alternate for the interlining, a fusible interlining conforming to type V, class 3, style B of MIL-C-44296 may be used. As an alternate finished seconds and mill seconds finished firsts may be used for top sleeve and undersleeve lining only. Mill seconds may contain shade variations from the standard sample. Mill seconds finished firsts may contain slubs or pulls in accordance to MIL-C-3924, paragraph 4.4.2.1 sears fabric scale for slubs and FED-STD-4 for pulls.

3.3.2.1 Alternate interlining. As an alternate to the material specified in 3.3.2, the material for lining and interlining the class 2 coat shall conform to class 2 of MIL-C-3924. The color of the material shall be OG-107.

3.3.3 Cotton-nylon oxford. The material for the hood for the class 1 coat shall be Olive Green 107 conforming to class 2 of MIL-C-3924, for class 2 coat shall be woodland camouflage printed conforming to class 3 of MIL-C-3924, for class 4 coat shall be desert camouflage printed (3 color) conforming to class 5 of MIL-C-3924 and for the class 5 coat shall be universal camouflage printed conforming to class 6 of MIL-C-3924.

3.3.4 Buckram. The material for interlining the collar and reinforcing snap fasteners, buttonholes and eyelets (see Table II, operation 1.k.) shall be cotton buckram conforming to type I, natural or bleached of A-A-50186. As an alternate, a fusible material for interlining the collar conforming to type V, class 3, style B of MIL-C-44296 may be used.

3.3.5 Knitted cloth. The knitted cloth for the hood curtain shall conform to class 1 of MIL-C-43247, except that the class 1 shall be Olive Green 107, class 2 shall be Camouflage Green 483, class 4 shall be Tan 380 and class 5 shall be Foliage Green 504. Colorfastness requirements for MIL-C-43247 shall not apply.

3.3.6 Cotton tape. The tape for the collar tab shall be 1 inch wide cotton tape conforming to type I, class 8 of MIL-T-43566. The color of the tape for class 1 shall be Olive Drab 7, for class 2 shall be Camouflage Green 483, for class 4 shall be Tan 380 and for class 5 shall be Foliage Green 504.

3.3.7 Fasteners, nylon tape. All fastener tapes for the coat shall be nylon conforming to type II, class 1 of A-A-55126. The color for class 1 shall be Olive Green 106, for class 2 shall be Camouflage Green 483, for class 4 shall be Tan 380 and for class 5 shall be Foliage Green 504. The finished cut lengths for each piece shall be as specified in Table II, operation 1.g, 1.h. and 1.i.

3.3.8 Braids, drawcord. The ends of the drawcords referred to in 3.3.8.1, 3.3.8.2 and 3.3.8.3 shall be dipped or impregnated with cellulose acetate or cellulose butyrate to prevent raveling. Each dipped or impregnated end shall be a least 1/2 inch in length (see 4.4.1.1).

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3.3.8.1 Bottom-coat drawcord. The cord for the drawcord at bottom of coat shall be a cotton elastic cord, 3/16 inch in diameter conforming to class 2 of MIL-C-43303. The color of the cord for class 1 shall be Olive Drab 7, for class 2 shall be Camouflage Green 483, for class 4 shall be Tan 380 and for class 5 shall be Foliage Green 504.

3.3.8.2 Waist drawcord. The cotton braid for the waist drawcord shall be solid and tubular, 1/8 inch conforming to type IV, class 1 or 3/16 inch conforming to type V, class 1 of MIL-B-371. The color of the braid for class 1 shall be Olive Drab 7, for class 2 shall be Camouflage Green 483, for class 4 shall be Tan 380 and for class 5 shall be Foliage Green 504.

3.3.8.3 Hood drawcord. The cotton braid for the hood drawcord shall be flat, 3/16 inch conforming to type III, class 1 of MIL-B-371. The color of the braid for the class 1 shall be Olive Drab 7, for class 2 shall be Camouflage Green 483, for class 4 shall be Tan 380 and for class 5 shall be Foliage Green 504.

3.3.9 Labels. Each coat shall have a combination identification – size label and an instruction label or combination size, identification and instruction label conforming to type VI of MIL-DTL-32075. The labels shall show fastness to laundering. The item description for class 1 shall be "Coat, Cold Weather, Field, Olive Green 107", for class 2 shall be "Coat, Cold Weather, Field, Woodland Camouflage Pattern", for class 4 shall be "Coat, Cold Weather, Field, Desert Camouflage Pattern (3 Color)" and for class 5 shall be "Coat, Cold Weather, Field, Universal Camouflage Pattern". The following cable numbers of the Standard Color Card of America are furnished for information and guidance as to the intensity of the shade desired for the labels. The label color for classes 1 and 2 shall be Medium Green, Cable Numbers 70034, 70130 or 70131 and for the classes 4 and 5 shall be Khaki, Cable Number 70188.

3.3.9.1 Combination identification – size label. The combination identification – size label shall be a combination of class 1 and class 2. The size information shall be printed in letters and numerals not less than 10-point and shall be as follows:

X-Small - X-Short
Height: From 59 to 63 in.
Chest Mn: Up to 33 in.
Chest Wm: Up to 36 in.
Stock No.
NATO Size: 5060/7484

X-Small - Short
Height: From 63 to 67 in.
Chest Mn: Up to 33 in.
Chest Wm: Up to 36 in.
Stock No.
NATO Size: 6070/7484

X-Small - Regular
Height: From 67 to 71 in.
Chest Mn: Up to 33 in.
Chest Wm: Up to 36 in.
Stock No.
NATO Size: 7080/7484

X-Small - Long
Height: From 71 to 75 in.
Chest Mn: Up to 33 in.
Chest Wm: Up to 36 in.
Stock No.
NATO Size: 8090/7484

Small - XX-Short
Height: Under 59 in.
Chest Mn: From 33 to 37 in.
Chest Wm: From 36 to 40 in.
Stock No.
NATO Size: 4050/8494

Small - X-Short
Height: From 59 to 63 in.
Chest Mn: From 33 to 37 in.
Chest Wm: From 36 to 40 in.
Stock No.
NATO Size: 5060/8494

Small - Short
Height: From 63 to 67 in.
Chest Mn: From 33 to 37 in.
Chest Wm: From 36 to 40 in.
Stock No.
NATO Size: 6070/8494

Small - Regular
Height: From 67 to 71 in.
Chest Mn: From 33 to 37 in.
Chest Wm: From 36 to 40 in.
Stock No.
NATO Size: 7080/8494

Small - Long
Height: From 71 to 75 in.
Chest Mn: From 33 to 37 in.
Chest Wm: From 36 to 40 in.
Stock No.
NATO Size: 8090/8494

Medium - XX-Short
Height: Under 59 in.
Chest Mn: From 37 to 41 in.

Medium - X-Short
Height: From 59 to 63 in.
Chest Mn: From 37 to 41 in.

Medium - Short
Height: From 63 to 67 in.
Chest Mn: From 37 to 41 in.

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Chest Wm: From 40 to 44 in.
Stock No.
NATO Size: 4050/9404

Chest Wm: From 40 to 44 in.
Stock No.
NATO Size: 5060/9404

Chest Wm: From 40 to 44 in.
Stock No.
NATO Size: 6070/9404

Medium – Regular
Height: From 67 to 71 in.
Chest Mn: From 37 to 41 in.
Chest Wm: From 40 to 44 in.
Stock No.
NATO Size: 7080/9404

Medium - Long
Height: From 71 to 75 in.
Chest Mn: From 37 to 41 in.
Chest Wm: From 40 to 44 in.
Stock No.
NATO Size: 8090/9404

Medium – X-Long
Height: From 75 to 79 in.
Chest Mn: From 37 to 41 in.
Chest Wm: From 40 to 44 in.
Stock No.
NATO Size: 9000/9404

Large – Short
Height: Up to 67 in.
Chest: From 41 to 45 in.
Stock No.
NATO Size: 6070/0414

Large – Regular
Height: From 67 to 71 in.
Chest: From 41 to 45 in.
Stock No.
NATO Size: 7080/0414

Large - Long
Height: From 71 to 75 in.
Chest: From 41to 45 in.
Stock No.
NATO Size: 8090/0414

Large - X-Long
Height: From 75 to 79 in.
Chest: 41 to 45 in.
Stock No.
NATO Size: 9000/0414

Large – XX-Long
Height: Above 79 in.
Chest: 41 to 45 in.
Stock No.
NATO Size: 0010-0414

X-Large - Short
Height: Up to 67 in.
Chest: 45 in. and up
Stock No.
NATO Size: 6070/1424

X-Large – Regular
Height: From 67 to 71 in.
Chest: 45 in. and up
Stock No.
NATO Size: 7080/1424

X-Large – Long
Height: From 71 to 75 in.
Chest: 45 in. and up
Stock No.
NATO Size: 8090/1424

X-Large – X-Long
Height: From 75 to 79 in.
Chest: 45 in. and up
Stock No.
NATO Size: 9000/1424

XX-Large – X-Long
Height: 75 to 79 in.
Chest: Above 49 in.
Stock No.
NATO Size: 9000/2434

3.3.9.2 Instruction label. The instruction label shall conform to class 3 and contain the following information:

COAT, COLD WEATHER, FIELD

1. Wear as outer garment or as under-layer in cold dry climate.
2. Wear button-in liner for added insulation.
3. Adjust closures and drawcords to ventilate; avoid overheating of body.
4. When hood is used, lower extension shall be worn over neck opening, preventing water entering opening.
5. Brush snow or frost from garments before entering heated shelters.
6. For fast drying, remove liner from coat.
7. Do not expose to high temperature of a stove.
8. Lubricate slide fasteners with wax.
9. For cleaning and restoring or water repellency, return to laundry for machine washing in accordance with established procedures for quarpel treated garments.
10. Machine washing: Use permanent press cycle. Wash in warm water using mild detergent.

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11. Hand washing: Wash in warm water using mild detergent. DO NOT WRING OR TWIST. Rinse in clean warm water.
12. DO NOT USE CHLORINE BLEACH OR STARCH.
13. Drying: Dry at low heat (do not exceed 130°F). After drying, tumble at room temperature for 10 minutes. Remove immediately from dryer. To drip dry, remove from water and place on a rustproof hanger.
14. Pressing is acceptable provided the front flap of the coat overlaps the slide fastener and the temperature of the steam press does not exceed 300°F when using a hand iron. Do not iron over collar slide fastener.

DO NOT REMOVE THIS LABEL

3.3.9.3 Combination size, identification and instruction label. The identification label, size label and instruction label may be combined into one label, conforming to class 14. The three labels shall be printed as one continuous label with the size label first and the identification and instruction labels placed below the size label. The size and identification labels may be combined and the contents placed above the instruction label. A space of 1/2 inch minimum shall be maintained between the labels. In addition a solid line 1/16 inch minimum width shall extend across the entire label approximately in the middle of the 1/2 inch blank space.

3.3.9.4 Barcode label. Each coat shall be individually bar coded with a paper tag for personal clothing items. The paper tag shall be standard bleached sulfate having a basis weight of 100 pounds. The paper used for the tags shall have a smooth finish to accept thermal transfer and direct printing. The tags shall have a hole and shall be attached to each coat by a fastener. The tags shall be clearly legible and readable by scanner. The bar coding element shall be a 13 digit national stock number (NSN). There shall be a 12 digit UPC number assigned for all NSNs by the contracting activity. The initials "UPC" must appear beneath the code. The bar code for NSN and UPC type shall be a medium to high density and shall be located so that it is completely visible on the coat when it is folded and/or packaged as specified and so it causes no damage to the coat. The UPC code must also be placed on all shipping cartons on which the NSN appears.

3.3.10 Thread and gimp.

3.3.10.1 Thread. The thread shall be cotton-covered or polyester-covered polyester core thread conforming to A-A-50199, ticket numbers 30, 2 or 3 ply and 50, 2 ply for all seaming, stitching, buttonholes and button sewing and ticket number 70, 2 ply for overedging. As an alternate, either type IV or V, class 1, subclass B of MIL-DTL-32072 may be used. Tex size 40 shall be used in lieu of ticket numbers 50 and 70 and Tex size 60 shall be used in lieu of ticket number 30. The thread shall be water repellent treated in accordance with type II, class 3 of MIL-T-3530.

3.3.10.2 Gimp. The cotton gimp for reinforcing buttonholes shall conform to type I or type II, ticket number 8 of A-A-50198.

3.3.10.3 Color of thread and gimp. The thread and gimp for classes 1 and 2 shall be dyed Camouflage Green 483, approximating color chip 34094 of FED-STD-595, for class 4 shall be Khaki P-1, C.A. 66019 and for class 5 shall be Foliage Green 504.

3.3.11 Buttons. The buttons shall be 30-line, 4-hole, conforming to type II, class D, style 26 of V-B-871. The color of the buttons for classes 1 and 2 shall be Olive Green BP, for class 4 shall be Tan AJ Cable 62028 and for class 5 shall be Foliage Green 504. The finish shall be dull.

3.3.12 Fasteners, slide, interlocking. The slide fasteners shall be fabricated in conformance to A-A-55634.

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3.3.12.1 Coat fronts. The slide fasteners for the coat fronts shall be either brass or plastic. The length of the slide fastener shall be 18-1/2 ± 1/4, -3/8 inches. The tape extension at top of slide fastener shall be not less than 1 inch.

3.3.12.1.1 Brass slide fastener. The brass slide fastener shall conform to type IV, style 8, size MHS; slider with wire stirrup pull.

3.3.12.1.2 Plastic slide fastener. The plastic slide fastener shall be an individual molded plastic element size H, possessing a 160 pound minimum crosswise breaking strength with a slider having an opening large enough to accommodate the 3/8 inch thong. The color of the chain, slider, pull and thong shall approximately match the tape (see 3.3.12.3).

3.3.12.2 Collar. The slide fastener for the collar shall be brass, type I, style 6, size MS slider with short tab pull, except that the tape shall be 9/16 ± 1/32 inch wide and the slider pull tab shall have a thong approximately 1-1/2 inches in length. The length of the slide fastener shall be 16-1/2 ± 3/16, -1/4 inches. As an alternate, an equivalent polyester (plastic) coil or ladder type continuous element monofilament slide fastener with an automatic slider may be used. The color of the chain, slider, pull and thong shall approximately match the tape (see 3.3.12.3).

3.3.12.3 Slide fastener tape. The tape for classes 1 and 2 shall be dyed Olive Drab, S, Cable No. 66519, for class 4 shall be Khaki Shade P, Cable No. 66516 and for class 5 shall be Foliage Green 504. The dyed tape shall show fastness to light and laundering equal to or better than the standard sample. When no standard sample is available, the dyed tape shall show "good" fastness to light and laundering.

3.3.13 Fasteners, snap. The snap fasteners shall conform to style 2A, brass, finish 2, male and female complete, consisting of stud and eyelet size 1 or 2 with button size 1 or 2 and socket conforming to MIL-DTL-10884, except an uncapped button may be used to attach the socket. As an alternate, a Universal Series 200, prong type, snap fastener may be used (see 6.5), except the material for the spring in the socket component shall conform to the requirements in MIL-DTL-10884 for spring temper. The color of the snap fastener shall be Foliage Green 504.

3.3.14 Eyelets. The optional metal eyelets for the drawcord outlets shall conform to Part No. M20652/1 - BBE125 of NASM 20652/1, except that the size shall be 1/4 ± 1/32 inch inside diameter. The color of the eyelets shall be Foliage Green 504.

3.4 Design. The coat is a lined hip length design, having a bi-swing back; convertible stand-up collar with adjustable tab closure, four buttonholes and horizontal slide fastener closure on undercollar (exit for hood); attached hood (concealed between body layers) with drawcord adjustment; two piece set-in sleeves, adjustable tab cuff closure; slide fastener fly front closure with snap fasteners; two bellows type breast pockets and two lower inside hanging pockets with snap fastener flaps closures; waist and hem drawcords; and inside buttons for attaching the insulating liner. The coat shall have two pieces of loop fastener tape, one at top of each sleeve for placement of patches (see operation 1.i.). The coat shall also have a piece of loop fastener tape placed on the right and left sides of the chest directly above the chest pockets (see operations 1.g.) for nametape and U.S. Army tape and a piece of loop fastener tape for the rank centered between the second and third snap fastener on front flap (see operation 1.h.) There are also pieces of fastener tape on the collar tab, undercollar, sleeve tabs and outside of underarm (see operation l.g.).

3.5 Figures. Figures 1 and 2 are furnished for information purposes only. If there are any inconsistencies between the written specification and the figures, the written specification shall control.

3.5.1 Patterns. Standard patterns which provide an allowance of 3/8 inch for all seams,

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except double-lapped and double-stitched seams where 1/2 inch allowance is provided and for joining sleeve facing to bottom of sleeve where 1/4 inch allowance is provided, will be furnished by the Government to the contractor for cutting the working patterns. The working patterns shall be duplicates of the Government patterns which show size, placement of [pockets and notches for proper assembly of all parts. The Government patterns and working patterns shall not be altered in any way.

3.5.2 List of pattern parts. The components of the coat shall be cut from materials specified in accordance with the number of parts indicated in Table I.

TABLE I. List of pattern parts

Material	Nomenclature	Cut Parts
	Coat	
Basic material (see 3.3.1)	Front	2
	Back	1
	Left front facing	1
	Right front facing	1
	Top sleeve	2
	Undersleeve	2
	Bottom sleeve facing	2
	Topcollar	1
	Undercollar	1
	Breast pocket	2
	Breast pocket flap	2
	Breast pocket flap lining	2
	Lower pocket flap	2
	Lower pocket flap lining	2
	Lower hanging pocket 1/	2
	Lower pocket bearer 1/	2
	Lower pocket welt	2
	Waist tunnel strip 1/ 2/	1
	Sleeve tab	4
Cloth, cotton buckram (see 3.3.4)	Collar interlining 3/	1
Cloth, fusible (see 3.3.4)	Collar interlining (alternate)	1
	Lining	
Cloth, cotton/nylon oxford (see 3.3.2)	Front	2
	Back	1
	Top sleeve	2
	Under sleeve	2
	Neck reinforcement 4/	1
	Front interlining	2
Cloth, fusible (see 3.3.2)	Front interlining (alternate)	2
Cloth, cotton/nylon oxford (see 3.3.3)	Hood	2
Cloth, nylon, knitted (see 3.3.5)	Hood curtain	1

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1/ For class 1, the pattern pieces may be cut from Olive Green 107 cloth conforming to class 2, or dyed ground shade cloth conforming to class 3 of MIL-DTL-43191. For class 2, the pattern pieces may be cut from woodland camouflage printed cloth conforming to class 3, or dyed ground shade cloth conforming to class 3, or dyed Camouflage Green 483 cloth conforming to class 2 of MIL-DTL-43191. For class 4, the pattern pieces may be cut from 3 color desert camouflage printed cloth conforming to class 5 or ground shade conforming to class 5 of MIL-DTL-43191. For class 5, the pattern pieces may be cut from the universal camouflage printed cloth conforming to class 6 or ground shade conforming to class 6 of MIL-DTL-43191.

2/ May be cut from cotton oxford lining or cotton/nylon oxford cloth.

3/ May be cut from cotton/nylon oxford cloth.

4/ May be cut from basic material cloth.

3.6 Construction.

3.6.1 Stitches, seams and stitching. All stitching, seams and stitchings shall conform to FED-STD-751. The type of seam, stitching, and stitches per inch shall be as specified in Table II. Seam allowances shall be maintained with seams sewn so that no raw edges, runoffs, pleats, or open seams occur. Where two or more methods for seams or stitch types are given for the same part of the operation, any one of them may be used. When stitch type 401 is used, the looper (underthread), shall be on the inside of the coat. Unless otherwise indicated, the gage of stitching for the double-lapped, double-stitched seams shall be 3/16 to 5/16 inch. The width of overedging specified in Table II shall be 3/16 to 1/4 inch. The guide and knives for the overedge machines shall be set to trim only the raveled edges of the fabric. All seams shall start and finish evenly.

3.6.1.1 Type 301 stitching. Ends of all stitchings shall be backstitched or overstitched not less than 1/4 inch except where ends are turned under or caught in other seams or stitchings. Ends of a continuous line of stitching shall overlap not less than 1/2 inch. Thread tensions shall be maintained so that there will be no loose stitching resulting in loose bobbin or top thread or excessively tight stitching resulting in puckering of the materials sewn. The lock shall be imbedded in the materials sewn.

3.6.1.1.1 Repairs of type 301 stitching. Repairs of type 301 stitching shall be as follows:

a. When thread breaks, skipped stitches, run-offs, or bobbin runouts occur during sewing, the stitching shall be repaired by restarting the stitching a minimum of 1/2 inch back of the end of the stitching. 1/

b. Thread breaks or two or more consecutive skipped or run-off stitches noted during inspection of the item shall be repaired by overstitching. The stitching shall start a minimum of 1/2 inch in back of the defective areas, continue over the defective area and continue a minimum of 1/2 inch beyond the defective area onto the existing stitching. Loose or excessively tight stitching shall be repaired by removing the defective stitching without damaging the materials and restitching in the required manner. 1/

1/ When making the above repairs, the ends of the stitching are not required to be backstitched.

3.6.1.2 Types 401, 502, 503, 515, 516, and 519 stitching. Thread tension shall be maintained so that there will be no loose or excessively tight stitching resulting in puckering of the materials sewn. All repairs shall be in accordance with 3.6.1.1.1a and 3.6.1.1.1b. Type 301 stitching may be used in repairing type 401 stitching.

3.6.1.3 Thread ends. All thread ends shall be trimmed to 1/4 inch maximum length.

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3.6.2 Bartacking. Unless otherwise specified, bartacks shall be as follows:

		Tolerance		Stitches per
Length	Width	Length	Width	bartack
1/2 inch	1/8 inch	± 1/16 inch	± 1/32 inch	28
1 inch	1/8 inch	± 1/16 inch	± 1/32 inch	42

Bartacking shall be free from thread breaks and loose or tight stitching.

3.6.3 Buttonholes. The buttonholes shall be the eyelet-end taper bar type, worked over gimp (see 3.3.10.2) with not less than four stitches at bar end (not counting the crossover stitch). The buttonholes shall finish with the purling on the outside of the coat. The finished cut lengths shall be 3/4 to 7/8 inch. The buttonholes shall be clean cut with the stitching securely caught in the fabric. Additive treatments or materials used to secure the ends of the stitching or to stiffen the fabric prior to stitching the buttonholes are prohibited.

3.7 Manufacturing operations requirements. The coat shall be manufactured in accordance with operations specified in Table II. The contractor is not required to follow the exact sequence of operations. Any additional basting or holding stitching to facilitate manufacture is permissible, provided the thread is removed or does not show in the finished coat.

3.7.1 Use of automated apparel equipment. Automated apparel equipment may be used to perform any of the operations specified in Table II, providing that the seam and stitch type are as specified and the finished component conforms to the required configuration. When a government furnished shaper pattern is forwarded, the component shall conform to that pattern.

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TABLE II. Manufacturing Operations Requirements

No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
1	Cutting. a. Cut all parts of the coat (cotton/nylon sateen, cotton-nylon oxford, cotton buckram and the knitted cloth) in strict accordance with patterns furnished which show directional lines, placement for components, and notches for proper assembly of parts. Directional lines shall be placed in the warp direction. The hood, waist tunnel strip, and pocket flap lining may be cut in the warp or filling direction. The pocket openings may be pre-cut (see operation 11.b.). b. Cut basic material parts of coat from one piece of material except lower pocket bearers and welts, flap linings, undercollar, waist tunnel strip, neck reinforcement, button and buttonhole reinforcement pieces, hood eyelet reinforcement pieces, hood tunnel piece, lower inside hanging pockets, and front interlining, which may be cut from ends. Parts cut from ends shall approximate the shade of the coat, except that the waist tunnel strip, front interlining (cotton oxford or fusible cloth), and reinforcement pieces need not approximate nor match the shade of the coat. c. Sleeve linings (cotton/nylon oxford) may be cut from ends but shall approximately match each other. d. Cut hood tunnel piece from cotton-nylon oxford on the bias, 1-3/4 ± 1/8 inches wide and of sufficient length to encompass the face opening. The tunnel piece may be strip cut and placed on rolls. e. Cut drawcords in lengths as follows (measurements in inches): XS S M L XL Tol. Waist drawcord (one each) 44 48 52 56 60 ±1 Bottom drawcord (one each) 50 54 58 62 66 +2, -1 Hood drawcord (one each) 34 34 34 34 34 ±1					

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
1	Cutting. (cont'd) f. Impregnate or dip ends of drawcords (see 3.3.8). g. Cut 1 inch wide nylon fastener tape in accordance with the following:					

Location	Portion of fastener	Cut Length (inches)	Number per coat	Operation reference
Collar tab				
	Loop	2-1/4 ± 1/8	1	6
Undercollar				
	Hook	1 to 1-1/8	1	9.i
		2 to 2-1/4	1	9.i
Nametape and U.S. Army tape				
	Loop	5-1/4 ± 1/8	2	16
Sleeve tab				
	Hook	1 to 1-1/8	2	23.h.
Outside of underarm				
	Loop	3 to 3-1/4	2	23.i.

h. Cut 2 inch wide nylon fastener tape in accordance with the following:

Location	Portion of fastener	Cut Length (inches)	Number per coat	Operation reference
Rank				
	Loop	1-3/4 ± 1/8	1	37

i. Cut 4 inch wide nylon fastener tape in accordance with the following:

Location	Portion of fastener	Cut Length (inches)	Number per coat	Operation reference
Upper sleeve				
	Loop	7 ± 1/8	2	24

j. Cut the tape (see 3.3.6) for collar tab 2-3/4 ± 1/8 inches long (see operation 6).

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
1	Cutting. (cont'd) k. Cut the reinforcement pieces for buttonholes and eyelets (where specified) from one ply of basic material or buckram, or two plies of the cotton oxford cloth. l. Cut cotton-nylon sateen cloth (basic material) for class 1 coat with dull side (filling effect) of the fabric to finish on the outside of the garment.					
2	Marking. a. Mark, ticket or bundle all outside parts of the coat and hood to insure a uniform shade or shades and size, except those cut from ends (see operation 1.b). Mark, ticket or bundle all lining parts for uniformity of size. b. Any method of marking may be used except: (1) Metal fastening devices. (2) Sew on tickets. (3) Adhesive type tickets which leave traces of adhesive on the material after removal of the tickets.					
3	Replacement of defective components. During the spreading, cutting and manufacturing process, components having material defects or damages that are classified as defects in 4.4.3 shall be removed from production and replaced with non-defective and properly matched components.					
4	Labeling. Stitch labels on all four sides to the lining of coat as follows: a. Instruction label to the right front and toward the bottom, 3 to 4 inches back of the facing. b. Combination identification-size label to the back of lining (off-center), 1-1/2 to 2 inches down from the collar seam. Stitching shall not catch or restrict the back pleat.					

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
4	Labeling. (Cont'd) c. Combination size, identification and instruction label (when used) to be positioned as specified in operation 4.b. d. The ends of label stitching shall be overlapped not less than three stitches.					
5	Make four pocket flaps. Finished appearance. Sockets shall be reinforced with one ply of buckram or basic material or two plies of the cotton oxford cloth cut not less than 1 inch by 1 inch. a. Mark the position for socket of snap fastener on flap lining, as indicated by pattern, and clinch socket to lining of flap and reinforcement piece. A 1/4 inch off center tolerance is permitted. b. Join plies of each flap along side and bottom edges; turn, work out points and edges, and stitch flap 3/16 to 1/4 inch from side and bottom edges.	301 or 401 and 301	SSe-2(a) SSe-2(a) SSe-2(b)	8-14 8-14 10-14	30 30 30	30 50 30
6	Make collar tab. Fold loop portion of nylon fastener tape (see operation 1.g) in half lengthwise; insert one end of the cotton tape (see operation 1.j) into the full depth of the fold and stitch loop tape to cotton tape on three sides 1/16 to 1/8 inch from edges. The stitching may continue across the folded edge.	301 301	BSa-1 and OSf-1	10-14 10-14	30 30	30 30
7	Make hood. Finished appearance. The hood shall have four pleats on back neck and two darts at top. The eyelets for drawcord shall be securely clinched through the reinforcement piece and hood. The drawcord shall not be caught in the stitching of the tunnel. a. Place raw edges of darts together and stitch on outside of hood, 3/16 to 1/4 inch from raw edges, with stitch tapering to bottom end of dart.	301 or 401	SSae-2(a) SSae-2(a)	10-14 10-14	30 30	30 50

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
7	Make hood. (Cont'd)					
	b. Fold pleat to inside at stitch line and edge stitch on inside of hood 1/4 to 3/8 inch from edge. Raw edge shall not be exposed on outside of hood.	301 or 401	SSae-2(b) SSae-2(b)	10-14 10-14	30 30	30 50
	c. Join hood at center with a double-lapped and double-stitched seam.	301 or 401	LSc-2 LSc-2	10-14 10-14	30 30	30 50
	d. Clinch eyelets through hood and double reinforcement piece of basic material at front opening positioned as indicated by marks on pattern.					
	or					
	e. Make 1/2 to 5/8 inch cut length buttonhole parallel with the front of the hood. The buttonhole shall be centered on the eyelet marks, and made through hood reinforcement piece of basic material positioned as indicated on patterns with eyelet end toward the bottom of the hood. The cut length shall be 1/2 to 5/8 inch.	Buttonhole		44-56 per buttonhole including tacks	30	30
	f. Make 3/16 to 1/4 inch diameter finished opening sewn through reinforcement piece	Eyelet		21 per eyelet	30	30
	g. Hood tunnel shall finish on inside of hood and shall finish 1 ± 1/8 inches wide. Either of the two methods may be followed:					
	h. Stitch tunnel piece to front edge of hood; turn and stitch 1/16 to 1/8 inch from edge.	301	SSe-2	10-14	30	30
	i. Turn under raw edge of facing and stitch 1/16 to 1/8 inch from edge forming drawcord tunnel.	301	LSd-1	10-14	30	30
	j. The inner edge may be pre-hemmed prior to performing operation 7.i.	301	EFa-1	10-14	30	30
	or					
	k. Thread drawcord through eyelets and knot ends of drawcord. Drawcord may be inserted after operation 7.l. is performed.					
	l. Turn in both raw edges of tunnel piece and raw edge of hood and double-stitch 1/16 to 1/8 inch from turned edges forming drawcord tunnel.	301	LSk-2	10-14	30	30
	m. Place a 1/2 inch bartack across facing through hood joining seam catching drawcord in the stitching.	Bartack		28 per bartack	30	30
	n. Overedge stitch bottom raw edge of hood.	502 or 503	SSa-1	6-8	70 1/	70 1/

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
7	Make hood. (Cont'd) o. Form pleats with outside folded edges toward the center seam of hood and prestitch across pleats 3-7/8 ± 1/8 inches from bottom edge. Stitching may extend across entire width of hood. (This operation may be performed when hood curtain is attached to hood.) p. Thread drawcord through eyelets and knot ends of drawcord. 1/ or 40 conforming to type IV or V, class 1, subclass B of V-T-285.	301		10-14	30	30
8	Make hood curtain and stitch to hood. a. Overedge stitch around all raw edges of hood curtain. b. Overlap the top edge of hood curtain 3-7/8 ± 1/8 inches over the bottom edge of hood on inside and stitch hood curtain to hood 1/8 to 3/16 inch from edge beginning at back edge of tunnel strip. The ends of the curtain shall begin and finish at the back edges of hood tunnel strip. The pleats of the hood shall be formed and caught in the stitching if not previously accomplished in operation 7.o. 1/ or 40 conforming to type IV or V, class 1, subclass B of V-T-285.	502 or 503 301	EFd-1 EFd-1 LSa-1	6-8 6-8 10-14	70 1/ 70 1/ 30	70 1/ 70 1/ 30
9	Make undercollar. Finished appearance. The undercollar shall be interlined with buckram or alternate fusible and shall contain a slide fastener which shall finish flat and smooth without puckers. Slide of fastener shall finish on left side of collar (as worn) when fastener is closed. a. Mark undercollar for slide fastener at marks indicated on patterns.					

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
9	Make undercollar. (Cont'd)					
	b. Center (± 1/8 inch off-center tolerance) buckram interlining under undercollar and seam together with a double row of parallel horizontal stitching across the length of the slide fastener cut mark. The rows of stitching shall be 1//4 to 3/8 inch gage with the two rows of stitching1/8 to 3/16 inch from slide fastener cut mark.	301 or 401	SSa-2 SSa-2	8-14 8-14	30 30	30 50
	or					
	c. When using the alternate fusible material for collar interlining, center the interlining under undercollar and fuse together for the entire length of the undercollar.					
	d. Cut slide fastener opening as an alternate, when fusible collar interlining is used the off center tolerance shall be ± 1/8 inch, tongue notching each end of opening.					
	e. Turn under raw edges of slide fastener opening 1/4 to 5/16 inch. Position folded edges of opening on slide fastener tape 1/8 to 3/16 inch from back edge of chain and stitch 1/16 to 3/32 inch along folded edges and ends of opening catching the tongue notched ends in the stitching.	301		10-14	30	30
	f. Bartack both ends of slide fastener with a 1/2 to 7/8 inch bartack, with the stitching superimposed on edge stitching. The bartack shall not be caught in or catch stitching of any unrelated operation (see Table VI, defect 205).	Bartack		28 per bartack	30	30
	g. Position the 2 to 2-1/4 inch hook portion of nylon fastener tape on the right end of undercollar (as worn) as indicated on pattern and stitch on all four sides, 1/16 to 1/8 inch from edges, overlapping the ends off stitching at least three stitches or tape may be stitched with two 1 inch box stitch patterns.	301	LSbj-1	10-14	30	30
	h. Position the tape end of collar tab on left end of undercollar, as indicated on pattern, and stitch or tack tab with a 1 inch bartack the width of tab to undercollar through interlining with stitching 1/8 to 3/16 inch from raw edge. Turn tab toward front and raise stitch or tack the tab with a 1 inch bartack 3/16 to 14 inch from folded edge.	301 or Bartack and 301	LSbl-2(a) LSbl-2(b)	10-14 42 per bartack 10-14	30 30 30	30 30 30

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
9	Make undercollar. (Cont'd)					
	i. Position the 1 to 1-1/8 inch hook portion of nylon fastener tape on the undercollar to correspond with the loop tape tab when it is folded towards back. Stitch the hook portion of tape on all four sides, 1/16 to 1/8 inch from edges, overlapping the ends of stitching at least three stitches.	301	LSbj-1	10-14	30	30
	j. Make two vertical buttonholes in the under-collar and interlining (for classes 1 and 2 coats only), as indicated on pattern, with the inside edge of tapered end 1/2 ± 1/8 inch above collar seam. The purling shall finish on the inside of undercollar.	Buttonhole		44-46 per buttonhole including tack	30	30
10	Make bi-swing back.					
	a. Form inside pleat of bi-swing, as indicated on pattern, with the material face to face and stitch 1/16 to 1/8 inch from folded edge.	301 or 401	OSf-1 OSf-1	8-14 8-14	30 30	30 30
	b. Form outside pleat of bi-swing, as indicated on pattern, with the material back to back and stitch 1/16 to 1/8 inch from folded edge.	301	OSf-1	8-14	30	30
	c. The bi-swing may be turned to finish position and stitched across shoulder 1/16 to 1/8 inch from raw edge.	301 or 401	SSa-1 SSa-1	6-14 6-14	30 30	30 50
	d. Stitch across bottom end of bi-swing pleat 1/2 to 1 inch from bottom edge and parallel with bottom edge. The stitching shall be through the two inner plies only.	301	SSa-1	8-14	30	30
11	Make and set lower pockets.					
	Finished appearance. The lower pockets shall be uniform in size, placement and appearance; the width of openings and depth of pockets shall be uniform. The flaps shall be uniformly set and stitched. The top of pockets shall extend to the waist tunnel and be caught in the bottom row of the waist tunnel stitching (see operation 16). The pockets shall not extend below bottom of coat.					

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
11	Make and set lower pockets. (Cont'd)					
	a. Turn in lower raw edges of pocket bearers and welts and stitch to ends of applicable pocket piece positioned as indicated on pattern. Selvage edge need not be turned in.	301	LSd-1	10-14	30	30
	b. *When pocket opening is pre-cut.*					
	(1) Fold coat at cut-opening so that lower seam allowance protrudes. Align the raw edge of the welt end of pocket and the cut edge of the opening and stitch welt (and top of pocket) to the lower part of pocket opening. Stitch should be 1/4 inch from the raw edge.	301	LSq-2(a)	10-14	30	30
	(2) Turn pocket to inside through opening forming a 3/8 to 1/2 inch wide welt and raise stitch 1/16 to 1/8 inch from welt to coat joining seam.	301	LSq-2(b)	10-14	30	30
	(3) Fold coat at cut-opening so that top seam allowance protrudes. Position the pocket flap between the seam allowance of the opening and pocket bearer with the raw edge of the flap and the cut edge of the opening even. Stitch flap to the upper part of pocket opening 1/4 inch from raw edges.	301	LSq-2(a)	10-14	30	30
	(4) Turn up coat front and raise stitch flap through all plies 3/16 to 1/4 inch from flap joining seam. Continue the stitching along both ends of opening with the tongues turned in and caught in the stitching.	301	LSq-2(b)	10-14	30	30
	c. *When pocket opening is not pre-cut.*					
	(1) Position pocket flap to outside of coat front with the raw edges aligned with the cut-line, as indicated by pattern. Stitch flap to coat 1/4 inch from raw edge.	301	LSbl-2(a)	10-14	30	30
	(2) Position welt end of pocket with the raw edge aligned with cut-line and stitch to front 1/4 inch from raw edge of welt (and top of pocket).	301	LSbl-2(a)	10-14	30	30
	(3) Cut opening and tongue notch ends. Turn pocket to inside through opening forming a 3/8 to 1/2 inch welt, and raise stitch 1/16 to 1/8 inch from the welt to coat joining seam.	301		10-14	30	30

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
	(4) Turn up pocket and stitch through seam allowance of cut-opening and raw edges of flap through bearer and underply of pocket.	301	LSbl-2(a)	10-14	30	30
	d. Safety stitch the plies of pocket along sides and across bottom folded edge. The lower corners may be slightly rounded. If overedging is equipped with knife, the bottom folded edge of pocket shall not be cut. 1/ or 40 conforming to type IV or V, class 1, subclass B of V-T-285.	515 or 516 or 519	SSa-2	10-14	50 (chain stitching)	50 1/ (all overedge threads)
	e. *Applicable to construction in operation 11.c. only*. Turn down flap and raise stitch through all plies 3/16 to 1/4 inch from flap joining seam. Continue the stitching above both ends with the tongues turned in and caught in the stitching.	301		10-14	30	30
	f. Vertically bartack both ends of pocket opening with a 1/2 inch bartack superimposed on stitching.	Bartack		28 per bartack	30	30
	g. Attach the stud part of snap fastener through front of coat and outer ply of pocket, to correspond with socket part on pocket flap.					
12	Make and set two breast pockets. Finished appearance. The outside bellows patch pockets shall be uniform in appearance, without twists, puckers, pleats, or raw edges. NOTE: The breast pocket shall be set on with fullness at the top of the pocket. The width of the top of the pocket shall be governed by the size of the finished flap.					
	a. Seam and raise stitch bottom corner of bellows portion of pockets, or stitch the corners with two rows of stitching 1/16 to 3/32 inch apart.	301 or 301	LSq-2 SSa-2	10-14 10-14	30 30	30 30
	b. Form bellows along back and bottom ends of pocket and stitch 1/16 to 1/8 inch from inside and outside folded edges forming bellows.	301	OSf-1	10-14	30	30
	c. Make a triangular hem at top of pocket, 2 ± 1/4 inches wide at center with raw edge turned under and single stitch 1/16 to 1/8 inch from edge. The top back of the bellows shall be inserted within the hem and caught in the stitching.	301	EFb-1	10-14	30	30

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
12	Make and set two breast pockets. (Cont'd)					
	d. Turn in the front edge of the pocket side and bottom raw edges of bellows portion of pocket and single stitch 1/16 to 1/8 inch from edge to fronts, as indicated on pattern. The raw edges of bellows portion of pocket may be turned in and stitched prior to joining pocket to front.	301	LSd-1	10-14	30	30
	e. Bartack ends of pocket opening with vertical 1/2 inch bartacks superimposed on the edge stitching forming bellows at back end of pocket and super-imposed on the stitching joining pocket to front at front edge of pocket.	Bartack		28 per bartack	30	30
	f. Bartack bottom corners of pocket with horizontal 1/2 inch bartacks superimposed on the stitching joining bellows portion at back end of pocket and superimposed on the stitching forming bellows at front edge of pocket. The bartack at back edge of pocket shall not close the bellows.	Bartack		28 per bartack	30	30
	g. Attach stud part of snap fastener through pocket and hem to correspond with socket in flap.					
13	Seam breast pocket flaps.					
	Finished appearance. The flaps shall be so positioned to cover ends of pocket and finish smooth and flat.					
	Seam flaps to coat 1/2 to 3/4 inch above pocket opening with the stitching 1/8 to 3/16 inch from edge. Turn flap down and raise stitch 3/16 to 1/4 inch, with the ends of stitching backstitched.	301	LSbl-2	10-14	30	30
14	Join side and shoulder seams of coat.					
	a. Join side seams and shoulder seams with double-lapped and double-stitched seams. The back shall lap the fronts at side seams and the fronts shall lap the back at shoulder seams.	301 or 401	LSc-2 LSc-2	10-14 10-14	30 30	30 50
	or					
	b. Join shoulder seams and side seams; and turn and raise stitch the back at side seams and fronts at shoulder seams 3/16 to 5/16 inch from turned edges.	301or 401	LSq-2 LSq-2	10-14 10-14	30 30	30 50

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
14	Join side and shoulder seams of coat. (Cont'd)					
	c. Bartack lower end of bi-swing at side seam with a vertical 1/2 inch bartack superimposed on inner row of side seam stitching (double stitched seam), or the raise stitching.	Bartack		28 per bartack	30	30
	d. Position the shoulder loops on shoulder with back edge of loop 3/4 to 1 inch back from shoulder seam and stitch raw edge of loop to edge of armhole.	301	SSa-1	8-14	30	30
15	Attach waist tunnel for drawcords.					
	Finished appearance. The drawcord shall not be caught in the tunnel stitching. The distance between the two rows of stitching shall be 7/8 to 1 inch.	301	LSd-1 each edge	8-14	30	30
	a. Turn in top, bottom, and ends of the tunnel strip and stitch top and bottom of strip to inside of coat positioned as indicated on pattern, 1/16 to 1/8 inch from turned edges with drawcord inserted, catching the turn-in at end of strip in the stitching and the top of hanging pockets in the bottom row of tunnel stitching. Ends of tunnel strip may be prehemmed prior toattaching tunnel strip. The drawcord may be inserted into tunnel after strip has been attached to coat.	301	EFa-1	10-14	30	30
	or					
	b. In lieu of turning in the top and bottom raw edges, overedge stitch top and bottom edges, sides of the tunnel strip, and stitch to coat.	502 or 503 and 301	EFd-1 EFd-1 LSbj-1 each edge	6-8 6-8 10-14	50 1/ 50 1/ 50 1/	50 1/ 50 1/ 50 1/
	c. Knot ends of drawcord.					
	1/ or 40 conforming to type IV or V, class 1, subclass B of V-T-285.					
16	Placement of loop tape for name and U.S. Army tapes.					
	Position the loop portion of the nylon fastener tape (see operation 1.g) for the name and U.S. Army tapes directly above the right and left chest pockets, as indicated on pattern.	301	LSbj-1	10-14	30	30

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
17	Make front facing.					
	a. Seam facings to interlinings at front and back 1/8 to 3/16 inch from edges. (This operation may be omitted when joining fronts to facings in operation 21.a).	301 or 401	Ssa-1 Ssa-1	8-14 8-14	30 30	30 50
	b. Attach six (6) snap fastener sockets through left facing and interlining positioned as indicated on pattern.					
	c. Sew three buttons through left facing and interlining positioned as indicated on pattern.	301 or 101		14-16 per button 14-16 per button	30 30	30
18	Join side and shoulder seams of lining and hem bottom.					
	a. Form pleat on back of lining at neck, as indicated on pattern. Position the neck reinforcement strip on the underside of lining at neck edge and stitch along shoulder and neck edges catching pleat in the stitching.	301	SSa-1	6-14	30	30
	b. Join lining at side seams and shoulder seams with double-lapped and double-stitched seams. The seam may lap in either direction.	301 or 401	LSc-2 LSc-2	10-14 10-14	30 30	30 50
	or					
	c. Join side seams and shoulder seams; turn and raise stitch seams 3/16 to 5/16 inch.	301 or 401	LSq-2 LSq-2	10-14 10-14	30 30	30 50
	d. Turn in bottom of lining as indicated on pattern, and with the raw edge turned in stitch 1/16 to 1/8 inch from turned edge. The hem shall finish 5/8 to 3/4 inch wide.	301	EFb-1	10-14	30	30
19	Join lining fronts to facings.					
	a. Stitch front edge of the front piece of lining to facings; turn and raise stitch lining 1/16 to 1/8 inch from turned edge.	301 or 401	LSq-2 LSq-2	10-14 10-14	30 30	30 50
	or					
	b. Join lining to facing with a double-lapped and double-stitched seam with the lining lapping the facings.	301 or 401	LSc-2 LSc-2	10-14 10-14	30 30	30 50

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
20	Make waist drawcord exits in lining. Finished appearance. The cord exits shall be metal eyelets or made with buttonholes or sewn eyelets, with the purling on the side of the lining nearest the wearer and completely reinforced on the inside (see operation 1.k.).					
	a. Make one buttonhole in each front part of lining through reinforcement positioned as indicated on pattern, with the eyelet end toward the front opening of coat. The cut length shall be 1/2 to 5/8 inch.	Buttonhole		44-46 per buttonhole including tack	30 30	30
	or					
	b. Make a 3/16 to 1/4 inch diameter finished opening sewn eyelet through reinforcement piece.	Eyelet		21 per eyelet	30	30
	or					
	c. Clinch eyelets through fronts and reinforcement pieces.					
21	Sew neck buttons on lining. Sew two buttons to lining, positioned as indicated on pattern, through the neck reinforcement strip. The center of each button shall be 1/2 to 3/4 inch from collar seam.	301 or 101		14-16 14-16	30 30	
22	Make sleeve linings.					
	a. Form two pleats on back arm seam, as indicated on pattern, and stitch across top edges. The pleats may be formed during operation 22.b. The fold of pleats on the outside of the sleeve nearest the wearer shall be toward bottom of sleeve.	301	SSa-1	6-14	30	
	b. Join back arm seam and forearm seam with double-lapped and double-stitched seam. The pleats shall be caught in the stitching (see operation 22.a).	301 or 401	LSc-2	10-14 10-14	30 30	
	or					
	c. Join back arm seam and forearm seam with a single row of stitching with a 1/2 inch seam allowance. The pleats shall be caught in the stitching (see operation 22.a).	301 or 401	SSa-1 SSa-1	10-14 10-14	30 30	

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
23	Make coat sleeves.					
	a. Form two pleats on back arm seam, as indicated on pattern, and stitch across top edges. The pleats may be formed during operation 23.h. The fold of pleat on outside of sleeve shall be toward bottom of sleeve.	301	SSa-1	6-14	30	
	or					
	b. Join back arm seam of sleeve with a stitch, turn and raise stitch seam 3/16 to 1/4 inch from turned edge. The pleats shall be caught in the seaming stitches. The fold in the pleats on the outside of sleeve shall be toward the bottom of the sleeve.	301 or 401	LSq-2	10-14	30	
	c. Join forearm seam of sleeve with a stitch, turn and raise stitch seam, 3/16 to1/4 inch from turned edge with top sleeve lapping the under sleeve.	301 or 401	LSq-2 LSq-2	10-14 10-14	30 30	
	or					
	d. Join forearm seam of sleeve with double-lapped and double-stitched seam.	301 or 401	LSc-2 LSc-2	10-14 10-14	30 30	
	e. Stitch facing to bottom of sleeve with stitching continuing along top and side of sleeve tab.	301 or 401	SSe-2(a) SSe-2(a)	10-14 10-14	30 30	
	f. Turn facing to inside and stitch 3/16 to 1/4 inch from edge.	301	SSe-2(b)	10-14	30	
	g. Join back arm seam of sleeve with a double-lapped, double-stitched seam, 3/16 to 5/16 inch gage. The pleats shall be caught in the seaming (see operation 23.a).	301 or 401	LSc-2	10-14 10-14	30 30	
	h. Center (1/8 inch tolerance) a hook portion of nylon fastener tape (see operation 1.g.) on the underside of tab positioned 3/8 to 5/8 inch from pointed end and stitch to tab 1/16 to 1/8 inch from edges.	301	LSbj-1	10-14	30	
	i. Position a loop portion of nylon fastener tape (see operation 1.g) on outside of underarm, even with the underarm joining seam with the top edge of tape parallel to top edge of facing and stitch to underarm 1/16 to 1/8 inch from edges.	301	LSbj-1	10-14	30	

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
24	Placement of loop tape for patches (on upper sleeve). Position the loop portion of the nylon fastener tape (see operation 1.g) for the patches approximately 1/2 inch down from the finished armhole/shoulder seam, as indicated on patterns.	301	LSbj-1	10-14	30	
25	Make and set sleeve tabs. Finished appearance. The tabs shall finish smooth and flat and shall be uniform in appearance. The gauge of stitching shall be uniform in width and the points shall be forced out. The tabs shall finish not less than 2-1/4 inches long (measured from inside stitch line on back arm joining seams).					
	a. Join plies of tab; turn, work out points and edges and stitch 3/16 to 1/4 inch from edges.	301 or 401 and 301	SSe-2(a) SSe-2(a) SSe-2(b)	8-14 8-14 10-14	30 30 30	
	b. Center (1/8 inch tolerance) a hook portion of nylon fastener tape (see operation 1.g) to the underside of tab positioned 3/8 to 5/8 inch from narrow end and stitch to tab 1/16 to 1/8 inch from edge.	301	LSbj-1	10-14	30	
	c. Seam tabs to sleeves, with wide end of tab even with sleeve bottom. Stitch 1/8 to 3/16 inch from raw edge, superimposing row of stitching on inside stitch line of the back arm seam. Turn tab down and raise stitch 3/16 to 1/4 inch, with the ends backstitched. Raise stitched seam should be superimposed on outside stitch line of the back arm seam.	301	LSb-1	10-14	30	

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
26	Stitch sleeve lining to coat sleeves. Insert sleeve lining into coat sleeve, turn under bottom raw edge of lining, overlap on sleeve facing 1/4 to 3/8 inch and stitch lining to sleeve 1/16 to 1/8 inch from turned edge. When applicable, excess lining material shall be evenly distributed on the coat sleeve by forming a pleat in the lining no greater than 3/8 inch on the bottom side of the sleeve only. Sleeve seams shall align so as to meet sleeve button placement requirements. The sleeve tab shall not be caught in the stitching. The bottom lining may be prehemmed	301	LSb-1	10-14	30	
27	Set sleeves of coat (outer shell). a. Sew sleeve to armhole of coat with notches matching, distributing fullness and catching shoulder loop in the stitching, positioned as indicated on pattern.	301 or 401	LSq-2(a) LSq-2(a)	10-14 10-14	30 30	
	b. Turn sleeve to finished position, turn seam allowance toward shoulder and raise stitch around sleeve 3/16 to 1/4 inch from seam. The shoulder loops shall not be caught in raise stitching.	301	LSq-2	10-14	30	
28	Join top collar to lining. Join top collar to lining, turn collar to finished position and with the seam allowances toward top of collar raise stitch 1/16 to 1/8 inch from turned edge	301 or 401 and 301	LSq-2(a) LSq-2(a) LSq-2(b)	10-14 10-14 10-14	30 30 30	
29	Join undercollar and hood to coat. Finished appearance. The collar shall finish smooth at neck line without being tight, puckered, twisted or pleated. Sequence of operations 30.a., 30.b, and 30.c shall not be changed. a. Position bottom edge of undercollar to coat and stitch collar to coat.	301 or 401	LSq-2(a) LSq-2(a)	10-14 10-14	30 30	30 50
	b. Position bottom edge of hood curtain to inside bottom edge of undercollar as indicated by pattern, with front ends of curtain matching notches, and stitch curtain to undercollar. or	301 or 401		10-14 10-14	30 30	30 50

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
29	Join undercollar and hood to coat. (Cont'd)					
	c. Operation 29.a and 29.b. may be combined into one operation.	301 or 401		10-14 10-14	30 30	30 50
	d. Turn up curtain and undercollar and raise stitch undercollar, 3/16 to 1/4 inch from turned edge.	301 or 401	LSq-2(b) LSq-2(b)	10-14 10-14	30 30	30 50
30	Set sleeve lining to coat lining.					
	Sew sleeve linings to coat lining at armhole, notches matching and distributing fullness. The seam allowance shall be enclosed between the outer shell and inner shell.	301 or 401	SSa-1 SSa-1	10-14 10-14	30 30	30 50
31	Sew inner shell to outer shell.					
	Finished appearance. The facings shall be uniformly stitched to fronts without distortion of the edges. The collar shall finish smooth and flat without twists, gathers, puckers or raw edges. The collar points shall be forced out and be uniform in appearance.					
	a. Seam inner shell to outer shell along fronts and around collar.	301 or 401	SSe-2(a) SSe-2(a)	10-14 10-14	30 30	30 50
	b. Turn coat, work out collar points, and single stitch 3/16 to 1/4 inch from edge along fronts and around collar.	301	SSe-2(b)	10-14	30	30
	c. Insert waist drawcord ends through lining drawcord exits.					
	d. Stitch top and undercollar together above the slide fastener with a row of stitching 5/8 to 3/4 inch from top edge of collar and with ends of stitching terminating at edge stitching of collar.	301		10-14	30	30
	Make collar buttonholes.					
	Make a buttonhole through all plies of collar at each end, positioned diagonally, as indicated on patterns and the inside edge of eyelet 1/2 ± 1/8 inch from edge of collar point. The purling shall finish on the top collar.	Buttonhole		44-46 per buttonhole including tack	30	30

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
33	Make exit buttonhole for bottom drawcord. a. Make a 1/2 to 5/8 inch cut length horizontal buttonhole at bottom of left front, as indicated on pattern, through a reinforcement piece. The eyelet shall be toward the front opening.	Buttonhole		44-46 per buttonhole including tack	30	30
	or b. Make a 3/16 to 1/4 inch diameter finished opening, sew eyelet through front and a reinforcement piece. c. Clinch eyelet as indicated by mark on pattern through front and a reinforcement piece.	Eyelet		21 per eyelet	30	30
34	Hem bottom of coat, insert drawcord. Finished appearance. The hem shall be uniform in width measuring 1 ± 1/4 inch wide, without pleats, puckers or twists. The drawcord shall not be caught in the stitching of the hem. The end of the drawcord shall be knotted to prevent return into the hem. The lining shall not be caught in the stitching. a. Thread drawcord through exit buttonhole at bottom of coat. Drawcord may be threaded after formation of hem. or b. Turn up bottom of coat to the inside, as indicated on pattern, with the drawcord in the turn-up; turn in the raw edge and single stitch through coat with the stitching continued across end of left hem, the end of the right hem shall be partially closed and have an opening of 3/8 to 1/2 inch for drawcord exits.	301	EFb-1	10-14	30	30
35	Sew on slide fastener. Finished appearance. The left and right parts of the slide fastener shall be stitched without gathers or pleats. The slider shall run smoothly without material interference. All bartacks shall be 1/2 inch in length.					

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
35	Sew on slide fastener. (Cont'd)					
	a. Position slide fastener on right front with front edge of scoops positioned as indicated on pattern (NOTE: Marks on front pattern for slide fastener teeth placement apply for right front only.), turn under top raw edge of tape and stitch through front, interlining and facing with two rows of stitching 3/16 to 1/4 inch apart and the back row of stitching 1/16 to 3/32 inch from back edge of tape and from the top to bottom of tape.	301	LSr-2(a)	10-14	30	30
	b. Position slide fastener on left facing with front edge of scoops positioned as indicated on pattern, turn under top raw edge of tape and stitch through all plies with two rows of stitching 3/16 to 1/4 inch apart. The back row of stitching shall be 1/16 to 3/32 inch from back edge of tape and the top raw edge of tape may be turned under and caught in the stitching.	301		10-14	30	30
	c. Bartack top of right and left fastener tapes with 1/2 inch vertical tacks superimposed on front rows of stitching next to coops. Diagonal bartack may be used and shall catch both rows of double stitching.	Bartack		28 per bartack	30	30
	d. Bartack bottom of slide fastener tapes with diagonal 1/2 inch bartack, catching both rows of double stitching and with top of bartack catching inner row of stitches.	Bartack		28 per bartack	30	30
36	Attach snap fasteners on right front.					
	a. Close slide fastener, mark position of six stud portions of snap fasteners on right front to correspond to sockets on left front. Open slide fastener, attach and clinch studs to right front as marked. The studs shall not catch the slide fastener tape.					
	b. Attach a socket portion of snap fastener to the underside of right front as indicated on pattern. The socket shall be clinched through all plies (for classes 1 and 2 only).					

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No.	Manufacturing Operations Requirements	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread Needle	Thread Bobbin/
37	Placement of loop fastener tape for rank. Position the loop portion of the nylon fastener tape (see operation 1.h) for the rank centered between the second and third snap fastener on front flap, as indicated on patterns.	301	LSbj-1	10-14	30	30
38	Sew on buttons. a. Sew three buttons on inside of right fronts, through front, interlining and facing positioned as indicated on pattern.	301 or 401		14-16 per button 14-16 per button	30 30	30
	b. Sew two buttons on the inside of each undersleeve at bottom edge of lining on forearm lining seam and back arm lining seam positioned 5/8 ± 1/8 inch from bottom edge of lining. The stitching shall go through all plies and measurements shall be taken from the center of the button.	301 or 101		14-16 per button 14-16 per button	30 30	30 30
	c. Sew a button on outside of left front through all plies positioned as indicated on pattern to accommodate hood (for classes 1 and 2 only).	301 or 101		14-16 per button 14-16 per button	30 30	30 30
	d. Sew a button on each shoulder seam (coat shell only) to correspond with the buttonhole in the shoulder loop. The loops shall lie flat and smooth.	301 or 101		14-16 per button 14-16 per button	30 30	30 30
39	Clean coats. a. Trim all ends of stitching to 1/2 inch maximum length throughout (inside and outside) and remove loose threads from the coat. b. Remove all spots, stains, and shade or size markings.					

3.8 Finished measurements. The coat shall conform to the finished measurements shown in Table III.

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TABLE III. Finished measurements (inches)

	XX-Short	X-Short	Short	Regular	Long	X-Long	XX-Long	Tol.
1/2 Chest measurement 1/								
X-Small	---	20-3/4	20-3/4	20-3/4	20-3/4	---	---	± 3/4
Small	22-3/4	22-3/4	22-3/4	22-3/4	22-3/4	---	---	± 3/4
Medium	24-3/4	24-3/4	24-3/4	24-3/4	24-3/4	24-3/4	---	± 3/4
Large	---	---	26-3/4	26-3/4	26-3/4	26-3/4	26-3/4	± 3/4
X-Large	---	---	28-3/4	28-3/4	28-3/4	28-3/4	---	± 3/4
XX-Large	---	---	---	---	---	30-3/4		
Back length 2/								
X-Small	---	28	29-1/2	31	32-1/2	---	---	± 1
Small	27	28-1/2	30	31-1/2	33	---	---	± 1
Medium	27-1/2	29	30-1/2	32	33-1/2	35	---	± 1
Large	---	---	31	32-1/2	34	35-1/2	37	± 1
X-Large	---	---	31-1/2	33	34-1/2	36	---	± 1
XX-Large	---	---	---	---	---	36-1/2	---	± 1
Sleeve length 3/								
X-Small	---	17-1/4	18-1/4	19-1/4	20-1/4	---	---	± 3/4
Small	16-1/4	17-1/4	18-1/4	19-1/4	20-1/4	---	---	± 3/4
Medium	16-1/4	17-1/4	18-1/4	19-1/4	20-1/4	21-1/4	---	± 3/4
Large	---	---	18-1/4	19-1/4	20-1/4	21-1/4	22-1/4	± 3/4
X-Large	---	---	18-1/4	19-1/4	20-1/4	21-1/4	----	± 3/4
XX-Large	---	---	---	---	---	21-1/4	---	± 3/4

1/ One-half chest measurement shall be measured at the base of the armhole, from folded edge to folded edge with front closed.
2/ The back length shall be measured along center back from undercollar seam to extreme bottom edge of coat.
3/ The sleeve length shall be measured from base of armhole along forearm seam to bottom of sleeve.

3.9 Workmanship. The end item shall conform to the quality of product established by this specification and the occurrence of defects shall not exceed the applicable acceptable quality levels.

4. VERIFICATION

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

1. First article inspection (see 4.2)
2. Quality conformance inspection (see 4.3)

4.2 First article inspection. The first article, submitted in accordance with 3.1, shall be inspected for compliance with design, configuration, workmanship and dimensional requirements. The presence of excessive defects, as defined by contract, (see 4.6) or failure to pass any test shall be cause for rejection of the first article.

4.3 Quality conformance inspection. Sampling for inspection shall be performed in accordance with ANZI/ASQC Z1.4, as defined by contract, except where otherwise indicated.

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4.4 Certification. The contractor shall furnish a certificate of compliance stating that the ends of the drawcords conform to the requirements in 3.3.8.

4.5 Component and end item inspection. In accordance with 4.1, components and end items shall be tested in accordance with all the requirements of referenced documents unless otherwise excluded, amended, modified, or qualified in this document or applicable procurement documents. The government reserves the right to inspect all components and end items to determine conformance to requirements.

4.5.1 Alternate fusible interlining testing.

4.5.1.1 Bond strength test. When used, the interlining shall meet the requirements stated in 3.3.2 when tested according to AATCC TM 136, paragraph 11.

4.5.2 Thread and gimp testing.

4.5.2.1 Breaking strength and elongation test. The thread and gimp shall meet the requirements Stated in 3.5.1.1 and 3.5.1.2 when tested according to ASTM-D-2256

4.5.3 Colorfastness test. The thread and gimp shall meet the requirements stated in 3.3.10.3 when tested according to AATCC TM 61, Test 3A (3 cycles).

4.6 End item visual examination. The end items shall be examined for the defects listed in Table IV. The lot size shall be expressed in units of coats. All fabric and garment defects shall be scored in accordance with Table IV which, are clearly noticeable at normal viewing and affect serviceability and appearance of the garment. Material defects are defined in Section I of FED-STD-4. If needed, closer inspection will be performed to verify compliance to specification requirements. Shade shall be evaluated at a distance of 3 feet.

TABLE IV. End item visual defects

Examination	**Defect**
Material	Hole, cut, tear, smash, burn, exposed drill hole, run, thin place, multiple float, loose slub, needle chew, visible mends. Color streaked, barred, mottled or not as specified; area of poor dye penetration extending more than 1/4 inch in any direction on outside part Misweave, loom stop/start or broken or missing pick or end Knots greater than Sears Scale Level C Slubs greater than Sears Scale Level D
Stitching and Seams	Irregular stitching, loose or tight stitch tension, broken, skipped or missing thread or stitch Outside seam open more than ¼" or inside seam open more than 2" Needle chew, selvage exposed, edge or raise stitching sewn too close to edge resulting in damage to cloth Outside visible raw edge or inside raw edge greater than 1 inch Seam or component part twisted, puckered, pleated, distorted, wavy Any part of coat caught in an unrelated operation or stitching Stitch or seam type not as specified, thread color not as specified, seam allowance not as specified, gage not correct or not consistent over major portion of seam, stitching not catching or securing proper layers of cloth Double needle intersecting seams staggered by more than 1/4 inch Run off of more than 1/2 inch for edge and raised stitching

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Examination	Defect
	Ends of stitching when not caught in other stitching backtacked less than 1/4" or ends of a continuous line of stitching overlapped less than 1/2", except label stitching overlapped with less than three stitches Buttonholes & eyelets: Any omitted, misplaced, ragged edges, caught in other stitching or component, not secured through proper layers of fabric, not serving intended purpose, 2 or more broken stitches Not specified size, length, orientation, placement, stitch type or gimp Cloth uncut, end of buttonhole not securely tacked Reinforcement pieces not present where required or not stitched through Metal eyelet (when used): barrel split, not securely clinched or clinched too tight cutting surrounding fabric, Bartacks: omitted, misplaced, not specified size or number of stitches, insecure, not serving intended purpose, loose stitching Pleats: Any missing, misplaced, crooked, irregular, not stitched as specified, not folded as specified Caught in unrelated stitching, incorrect stitching or formation causing deformation of other parts
Component Parts	Any component part of coat omitted, not as specified, not joined as specified; distorted, full, tight, twisted or caught in unrelated stitching The edge of any component part required to be forced out having folds of more than 1/8” Fullness or irregularity creating unwanted fold, pleat, pucker, bulge, curl or crease in fabric or garment Partner parts not symmetrical or even Not correct dimensions according to specification or pattern Armhole tight, causing puckers or pleats on front or back
Pockets and Flaps	Pockets twisted, curled, puckered, crooked, not stitched as specified, not serving intended purpose Pocket flaps poorly shaped, not completely covering pocket opening, not positioned as specified Snap fastener off center with point of pocket flap by more than 1/4 inch Pocket construction not as specified, not positioned as specified Bellows exposed, stitched without fullness at opening, or stitched closed beyond end of bartack by more than 1/8” Pocket companions not uniform in size or shape Fastener clinched through outside of flap Companion pockets out of alignment 1/2 inch or more Hanging pocket too long, exposed below bottom of coat Lower edge of welt exposed 1/8 inch or more beyond side edge of flap Corner of pocket or flap not backstitched Brest Pocket Flap placed less than 1/2 or more than 3/4 inch above pocket opening, measured from top of pocket to setting underside seam of flap Pocket not parallel with front edge by 3/8 inch or more

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Examination	Defect
Tunnels	Any tunnel not specified width, not stitched as specified Tunnel twisted, puckered, crooked, irregular, inconsistent width Outside shell shows bulge, twist, shortness, fullness, or delamination due to tunnel stitching Eyelet of buttonhole not toward front edge of coat
Hook & Loop	Misplaced, damaged or omitted, not serving intended purpose, twist or distortion when closed Out of alignment by more than 1/4 inch Color, type or cut size not as specified Not stitched as specified; pieces not securely stitched down on cloth Stitching on tape selvage rather than hook or loop pile Stitched more than 3/16" from edge, or leaving sharp or ragged edges Yarns at selvage or cut edges of tape raveling or not secure Pieces not cut straight (at approximately 90 degrees) Pieces not securely linked/spliced and properly aligned to each other
Slide Fasteners	Not specified length, type or color Incorrectly attached or positioned, not serving intended purpose Surrounding cloth twisted, distorted, damaged, or puckered when open or closed Any part of assembly bent, broken, omitted or otherwise defective affecting function Not set on flat and smooth Slide not on correct side Thong omitted or not as specified Not clinched through proper layers of cloth Front closure slide fastener: one or both bartacks at either end of tape omitted or both rows of stitching not caught in stitching when diagonal bartack is used
Buttons	Any omitted, loose, broken, misplaced, incorrect style or color, not functioning properly with buttonhole, not aligned with buttonhole, causing puckering or pleating Stitching not locked at end of cycle (tug at loose end of thread when accessible to see if it will ravel) Not caught through proper layers of cloth
Drawcords	Any omitted, caught in stitching, incorrect style or color One or both ends not dipped or impregnated less than 1/2 inch in length, knot at one or both ends missing Cut length not within specified tolerance (Note: Drawcords shall be measured with knots untied)
Snap Fasteners	Omitted, mismatched, split, broken or bent, incorrect style or color, not functioning properly Clinched in a way that causes cutting of adjacent material or free rotation or detachment of components Incorrectly positioned causing bulge, twist or potential incorrect fit of accessory parts Male and female sockets on wrong sides Unrelated component caught by stud attachment point

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Examination	Defect
Lining	Too tight, too full, short or twisted, causing fullness or twist on outside of coat Lining too long, exposed beyond bottom of coat or sleeve Lining seams out of alignment with seams of shell by more than 1/2 inch
Interlining	Bubbling, delamination, bleed through, wrinkling, puckering Any resin transfer Misplaced, omitted or added where not specified Color fading of fused parts, i.e., fused parts shaded from rest of garment
Shade	Shade variation within part or between parts
Evenness	Length of coat fronts uneven by more than 1/2 inch at top or bottom when closed Parts not symmetrical, properly aligned, or centered, as applicable; If at front of coat, features out of alignment by more than ½” Sleeve lengths vary by more than 1/2 inch Cuff and cuff tab out of alignment with bottom folded edge of sleeve
Cleanness	Spot, stain, odor, more than 5 untrimmed thread ends (more than ½”) Shade or production markings visible, basting threads visible
Labels	Any label omitted, incorrect, illegible, not attached where specified Not stitched on all four sides Bar code/UPC code omitted, not readable by scanner Human readable interpretation (HRI) omitted or illegible Bar code/UPC code not visible on folded, packaged item Bar code attachment causes damage to the item
Packaging	Any coat not packaged in accordance with contract or purchase order

4.7 End item dimensional examination. The end items shall be examined for conformance to the dimensions specified in Table III. Any dimension not within the specified tolerance and any sleeve length uneven in length by 1/2 inch or more shall be classified as a defect. The lot size shall be expressed in units of coats. The inspection and the AQL, expressed in terms of defects per hundred units shall be specified in the contract or purchase order.

5. PACKAGING

5.1 Packaging. For acquisition purposes, the packaging requirements shall be as specified in the contract or purchase order (see 6.2). When actual packaging of material is to be performed by 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's System 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.)

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6.1 Intended use. The coats are intended for wear by personnel of the Department of Defense.

6.2 Acquisition requirements. Acquisition documents should specify the following:

a. Title, number and date of this document.
b. Class and sizes required (see 1.2).
c. Issue of DODISS to be cited in the solicitation and, if required, the specific issue of individual documents referenced (see 2.2.1 and 2.2)
d. When first article sample is required (see 3.1)
e. Packaging requirements (see 5.1).

6.3 First article. When a first article is required, it will be inspected and approved under the appropriate provisions of FAR 52.209-4. The first article should be a pre-production sample. The contracting officer should specify the appropriate type of first article and the number of units to be furnished. The contracting officer should include specific instructions in all acquisitions documents regarding arrangements for selection, inspection and approval of the first article.

6.4 Samples and shade samples. For access to samples and shade samples of the material, address the contracting activity issuing the invitation for bids or request for proposal.

6.5 Prong type snap fastener. A source of supply for the series 200 prong type snap fastener specified in 3.3.13 is Universal Fastener, P.O. Bo 467, Lawrenceburg, KY 40343.

6.6 Bonding strength dispute. In case of a dispute, the average of the first 3 inches of the five highest and five lowest boding strength peaks from a chart recording on a CRE Tensile Tester, running at 12 in./min. will determine the bonding strength. If splitting is observed, then just the highest peak will be regarded as the bonding strength.

6.7 Temperature strip. Suggested sources for temperature strips are as follows:

MRCINC, Reatec Division, Telephone Number (215) 687-4300
Paper Thermometer Co., Telephone Number (603) 547-2034

Also each fusible manufacturer supplies their own brand of temperature strips.

6.8 Supersession data. The class 3 desert camouflage pattern (6 color), cotton/nylon twill coat has been deleted as it is no longer required.

6.9 Subject term (key word) listing.
Clothing
Camouflage
Water repellent
Field Coat

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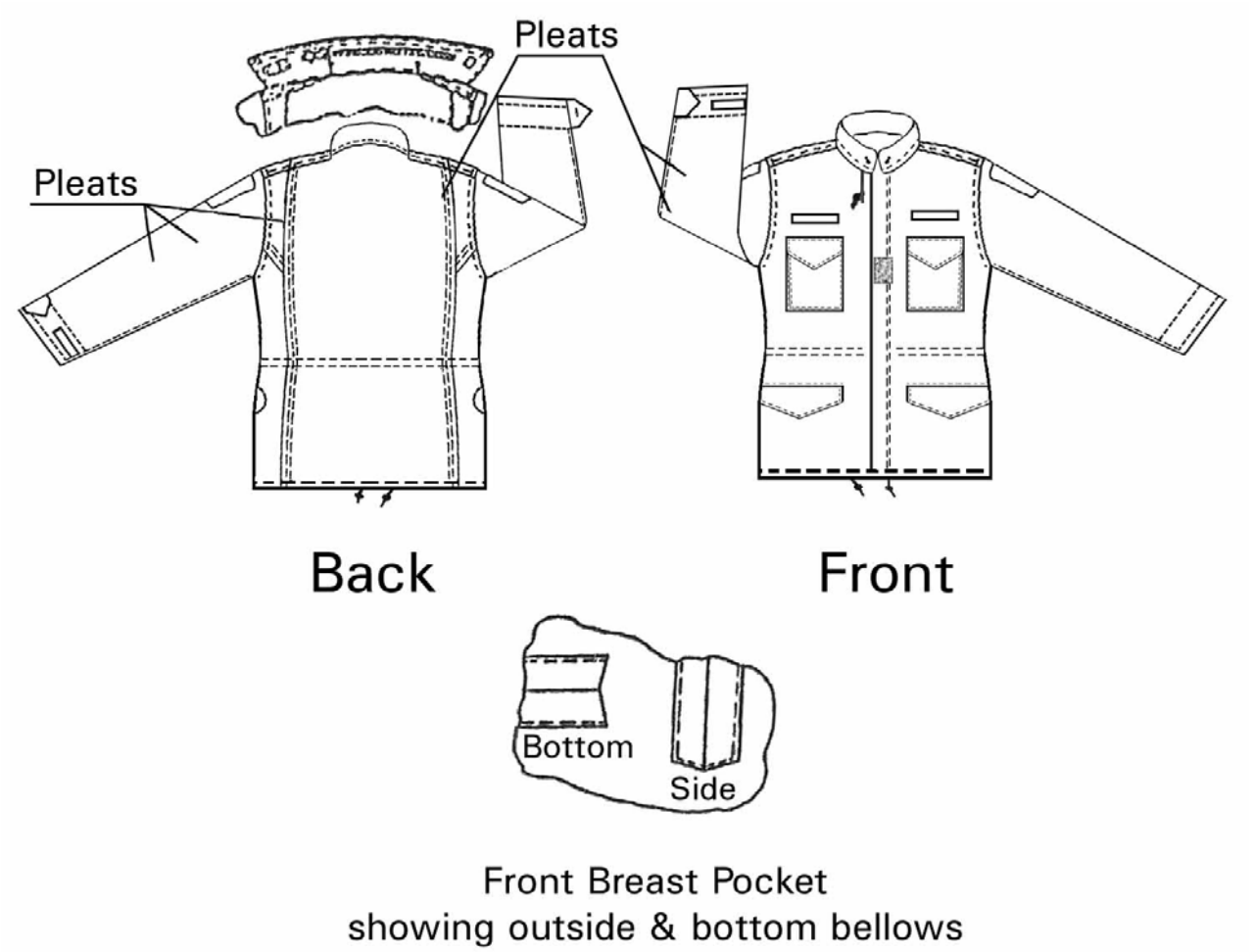

Figure 1. COAT, COLD WEATHER, FIELD

Custodian:
Army - GL

PREPARING ACTIVITY:
DLA – CT
Project No. – 8415-2005-002

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