

INCH-POUND

MIL-DTL-82172D(MC)

8 October 1997

SUPERSEDING

MIL-C-82172C(MC)

21 June 1995

## DETAIL SPECIFICATION

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

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

### 1. SCOPE

1.1. Scope. This specification covers requirements for scarlet, wool, drum and bugle corps coats.

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

AMSC N/A

FSC 8405

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1.2. Classification. The coats shall be of one type in the following classes and sizes as specified (see 6.2):

Class 1 - Drum Major

Class 2 - Director

Schedule of sizes

(Short, Regular, Long, Extra Long)

34 35 36 37 38 39 40 41 42 44 46

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

## 2. APPLICABLE DOCUMENTS

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

### 2.2. Government documents.

2.2.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those listed in the issue of the Department of Defense Index of Specifications and Standards (DoDISS) and supplement thereto, cited in the solicitation (see 6.2).

## SPECIFICATIONS

### FEDERAL

A-A-50186	- Cloth, Cotton, Buckram
A-A-50196	- Thread, Silk
A-A-50198	- Thread, Gimp, Cotton, Buttonhole

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- A-A-50199 - Thread, Polyester Core, Cotton or Polyester Covered
- A-A-52071 - Tape, Textile, Cotton, General Purpose (Unbleached, Bleached or Dyed)
- A-A-52094 - Thread, Cotton
- A-A-52097 - Cloth, Wigan, Cotton
- A-A-52106 - Cloth, Twill or Plain Weave Polyester and Polyester Blend
- DDD-L-20 - Label: For Clothing, Equipage and Tentage (General Use)
- V-B-871 - Button, Sewing Hole, and Button, Staple (Plastic)

## DEPARTMENT OF DEFENSE

- MIL-C-368 - Cloth, Satin, Rayon and Cloth, Twill, Rayon
- MIL-DTL-3461 - Button, Insignia, Metal, Uniform and Cap
- MIL-P-15064 - Pads, Shoulder and Sleeve-Head
- MIL-L-17507 - Lace, Ornamental
- MIL-E-17568 - Embroidery Materials, Metallic and Synthetic
- MIL-C-21115 - Cloth, Tropical: Wool, Polyester/Wool
- MIL-E-29652 - Eyelets, Metallic and Eyelet Washers, Metallic
- MIL-DTL-82114 - Coat Front - For Coats, Musicians
- MIL-DTL-82194 - Ornamentation - For Jacket, Man's Evening Dress

## STANDARDS

## FEDERAL

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

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

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

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

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

ASTM E1282 - Standard Guide for Specifying the Chemical Compositions and Selecting Sampling Practices and Quantitative Analysis Methods for Metals and Alloys

(Application for copies should be addressed to American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.)

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

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

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

### 3. REQUIREMENTS

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

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

#### 3.3. Materials.

3.3.1 Basic material. The basic material shall be cloth, wool, tropical, scarlet, shade 2502 (see 6.3), 10.5 ounce, conforming to type I, class 1 of MIL-C-21115.

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

3.3.3 Cloth, twill or plain weave polyester or polyester blend. The stays for the armhole and shoulder seams, reinforcement pieces for the collar eyelets, bindings for the lower edge of the collar, and neck edge of the coat front interlining shall be cut from cloth, polyester or polyester blend, conforming to A-A-52106, except the requirement for nonfibrous material and seam efficiency shall not apply. The polyester or polyester blend shall be khaki, shade 3707 for the armhole and shoulder seam stays, the collar eyelet reinforcement pieces and the binding for the neck edge of front interlining; and black for the binding for the lower edge of the collar interlining.

3.3.4 Collar interlining. The material for the collar interlining shall be cloth, cotton, buckram, double texture, laminated, starch finish, natural color, conforming to type IV of A-A-50186. The weight of the laminated cloth shall be 21 to 23 ounces per square yard.

3.3.4.1. Plastic. The plastic strip used in the collar interlining shall be clear plastic stock, 0.020 inch thick. It shall be cut using the cotton buckram pattern.

3.3.4.2. Plastic interlining. The plastic interlining must withstand wet (dry) cleaning. It must not melt or become distorted under wet (dry) cleaning or pressing.

3.3.5 Reinforcement disc. The reinforcement discs for buttons secured to the side seam, with ring toggles, shall be punched from the cloth, cotton, buckram specified in 3.3.4. The reinforcement discs shall be 7/8 inch in diameter with 1/8 inch diameter hole at the center.

3.3.6 Padding for collar. The material for padding the collar shall be suitable cotton felt, white, weighing 4.25 to 4.75 ounces per square yard.

3.3.7 Coat fronts. The coat fronts shall conform to the requirements of class 1 of MIL-DTL-82114.

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3.3.8 Shoulder pads. The shoulder pads shall conform to the requirements of type I, class 2 of MIL-P-15064.

3.3.9 Sleeve-head pads. The sleeve-head pads shall conform to the requirements of type IV of MIL-P-15064.

3.3.10 Stay tape. The stay tape for the armhole shall be cotton, unbleached, 1/4 inch wide, conforming to type II, class 1 of A-A-52071, except the requirement for nonfibrous material shall not apply.

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

3.3.12 Binding. The binding for the collar interlining shall be cut 1 inch wide from the following materials:

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

b. Lower edge of collar interlining - cloth, polyester and cotton as specified in 3.3.3.

3.3.13 Wigan. The material for reinforcing the bottom edge of the sleeves shall be cloth, cotton, wigan, 2.5 ounces, conforming to A-A-52097.

3.3.14 Threads.

3.3.14.1. Silk thread. The silk thread shall conform to A-A-50196 as follows; except the requirements for extractable material shall not apply:

Use	Type	Ticket No.	Ply
Bartacks and all outside seaming and stitching.	I	A	-
Machine felling	-	0	-
Making buttonholes in coat.	I	B and F	3
Hand felling; and hand sewing.	III	C	2

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3.3.14.2. Cotton thread. The cotton thread shall conform to A-A-52094 as follows:

Use	Type	Ticket No.	Ply
All inside seaming and stitching.	III	A	3
Serging and overedge stitching.	I	70	2
Machine tacking armholes and sewing on buttons.	II	24	4

The thread for basting shall be good commercial grade cotton. As an alternate to the cotton thread, a polyester core, cotton or polyester covered thread conforming to A-A-50199, ticket No. 50, 2 ply or ticket No. 70, 2 ply may be used.

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

Thread	Color	Wet (dry) cleaning	Light
Cotton	Scarlet	Good	---
Silk	Scarlet	Fair	Fair
Silk	Black	Good	Good

3.3.15 Gimp. The buttonhole gimp shall be cotton, ticket No. 8, soft or glazed finish, conforming to type I or II of A-A-50198. The color of the gimp shall be scarlet, shade W, cable No. 66040, and shall show good fastness to wet (dry) cleaning.

3.3.16 Ornamental braid. The ornamental braid for the coat fronts shall conform to the following requirements:

Cover

Material (covering)	Metal thread
Color of wire	Light gold
Metal wire (undercoating)	Silver and copper
Plating material	Gold
Winding thread	Two ply white or yellow cotton thread

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Core (stuffer)

Material	Cotton thread (soft)
Number of threads	7 minimum
Ply of thread	2 minimum
ColorGold	

WeavePlain braided

Number of carrier	12 minimum
Ends/carriers	6-8 (total 79)
ShapeTubular	
Width	3/8 + 1/16 inch minimum
Weight/linear yard	154.5 grams

Metal content (%)

Gold	0.3 minimum
Silver	0.6 minimum
Copper	Remainder (traces of nickel and zinc)

Fastness to

WaterGood	
Wet (dry) cleaning	Good

3.3.16.1. Collar gold lace. The gold lace for the collar shall conform to type II, class 1, style A of MIL-L-17507.

3.3.17 Buttons.

3.3.17.1. Insignia button. The insignia buttons shall be metal, gold plated, 27-line for shoulders, belt loops, and ornamental sleeve patches; and 40-line for fronts, conforming to type I, style 3, class A, subclass 2 of MIL-DTL-3461.

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

3.3.17.3. Sewing button. The lower button on the coat front shall conform to type II, class D, style 20, 40-line of V-B-871 and match the shade of the basic fabric.

3.3.18 Collar closure hook and eye. The hook and eye for closing the collar shall be brass, black, japanned finish, or

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black chemical finish, followed by a clear lacquer coating and conform to the requirements of Figure 9.

3.3.18.1. Eyelets. The eyelets for the collar shall be brass, rolled flange type, with the barrel scored six to eight scores. The eyelets shall conform to MIL-E-29652, sheet 1A-BE108 and be enameled a black shade.

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

3.3.19.1. Combination instruction/identification label. The combination instruction/identification label shall conform to type V, classes 2 and 14 (combined) of DDD-L-20 except all printing and the space between the lines of printing shall be minimum 10 point (approximately 1/8 inch). The content and format shall be as follows:

Collar size:  
Nomenclature:  
Contract number:  
Wool Products Act information:  
DRY CLEAN ONLY

3.3.19.2. Size label. The size label shall conform to type V, class 2 of DDD-L-20. The label shall consist of the numerical size designation specified in 1.2 followed by the letters S (short), R (regular), L (large), or XL (extra large), as shown by the following example:

40 R

3.3.20 Vinyl piping. The white vinyl cord for piping the upper edge of the collar shall be tubular, with 7/16 inch-wide welt and serrated edges (see 6.5).

3.3.21 Sleeve ornamentation. The sleeve ornamentation for the class 2 coat shall conform to type III, class 2 of MIL-DTL-82194 except that the embroidery yarns used shall be tarnish resistant, synthetic, metallic yarn conforming to MIL-E-17568. This ornamentation shall normally be furnished by the Government and attached during manufacturing of the coat.

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3.3.22 Bias binding. The binding for the underarm shields shall be bias cut of the lining material specified in 3.3.3. The binding shall be 5/8 to 7/8 inch wide and have sized edges.

3.4. Design. The coat shall be the U.S. Marine Corps design shown on Figures 1 through 9: a five-button, single breasted, form-fitting, fully lined coat, having a one-piece front with gold braid; waist and chest darts; a four-piece back without a center vent; belt loop to button; ornamented sleeve ends; shoulder straps to button; and a standup collar with hooks and eyes for front closure and with a metal eyelet at each end for a removable branch of service insignia. The collar shall have gold lace sewn to the top, lower and ends of the outer edges of the collar as shown in Figures 1, 2, 7 and 8. The front and bottom edges of the coat; the top, bottom and scalloped back edges of the ornamental sleeve patches; and the edges of the shoulder straps shall be piped with the material specified in 3.3.11.

3.5. Patterns. Standard patterns will be furnished to the contractor by the Government. The standard patterns shall not be altered in any way and shall be used only as a guide for cutting the contractor's working patterns. The contractor's working patterns shall be identical to the standard pattern. The standard patterns shall provide a 5/8 inch allowance for center back, 3/4 inch allowance for side seams; and 3/8 inch allowance for all other seams, except as otherwise specified in Table I. Standard patterns show size and are marked and notched for proper cutting, placement, and assembly of component parts.

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

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ITEM	PATTERN NOMENCLATURE	NO. OF CUT PARTS
	Material: Basic, cloth, wool, tropical	
1	Front	2
2	Front facing, right	1
3	Front facing, left	1
4	Side back	2
5	Center back	2
6	Top sleeve	2
7	Under sleeve	2
8	Collar, outer ply	2
9	Shoulder straps, top ply	2
10	Shoulder straps, under ply	2
11	Ornamental sleeve patch, top ply	2
12	Ornamental sleeve patch, under ply	2
13	Belt loops	2
	Material: Cloth, rayon, lining	
14	Front	2
15	Side back	2
16	Center back	2
17	Top sleeve	2
18	Under sleeve	2
19	Underarm shield	2
20	Collar lining	1
21	Collar eyelet cover	2
	Material: Cloth, cotton, buckram	
22	Collar interlining	1
	Material: Cloth, twill or plain weave, polyester or polyester blend	
23	Collar interlining	1
	Material: Cloth, cotton, wigan	
24	Reinforcement (bottom edges of sleeves)	2
	Material: Mylar plastic	
25	Collar interlining	
	Markers	
26	Sleeve turnup and sleeve ornament	

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3.6. Construction.

3.6.1 Manufacturing requirements. The coat shall be manufactured in accordance with the operations and the stitch, seam, and stitching types specified in Table I.

3.6.1.1. Operations. The contractor is not required to follow the exact sequence of operations as listed in Table I, but all operations specified shall be used to manufacture the coats.

3.6.1.2. Stitches, seams and stitching. The stitch, seam and stitching types specified in Table I shall conform to FED-STD-751. The number of stitches per inch as specified in Table I, indicates the minimum and maximum number permitted. All overedge stitching shall be done on serging machines with a knife attachment properly set to trim the raveled edge without cutting the material.

3.6.1.3. Thread breaks and ends of seams. Ends of seams and stitching (stitch type 301), except ends of a continuous line of stitching when not caught in other seams or stitchings, shall be backtacked not less than 1/4 inch. The ends of a continuous line of stitching shall be overlapped not less than 1/2 inch. Thread breaks shall be secured back of the break line not less than 1/2 inch.

3.6.1.4. Shade markings. The component parts of the coat, cut from one piece of wool and lining materials, including pairs of sleeve linings and underarm shields when cut from ends, shall be shade marked to ensure a uniform shade and size throughout the garment. Any method of shade marking may be used except:

- a. 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 coats in strict accordance with patterns furnished by the Government.</p> <p>b. Cut all materials in the direction indicated by the directional lines on the patterns.</p> <p>c. Cut all scarlet wool parts from one piece of basic material, except the following parts may be cut from ends: under ply of the shoulder straps, and under ply of ornamental sleeve patch. Parts cut from ends shall harmonize with the shade of the coat.</p> <p>d. Cut the body and collar linings, the collar eyelet covers, and the top ply of the underarm shields from one piece of rayon lining material. All other rayon lining parts may be cut from ends. When pairs of sleeve linings are cut from ends, the shade of the sleeve linings shall match. Cut the strips for coat hanger and lining securing straps 1-1/8 inches wide.</p> <p>e. Cut polyester or polyester blend stays for armhole and shoulder seams on the bias, 3/4 inch wide and <math>4 \pm 1/4</math> inches long. Cut the polyester and cotton for binding the neck edge of the coat front interlining on the bias, 3/4 inch wide and approximately 5 inches long. Cut the polyester and cotton for the collar interlining on the straight in accordance with the pattern furnished.</p> <p>f. Cut the cotton buckram and mylar plastic for interlining the collar on the straight in accordance with the pattern furnished.</p> <p>g. Cut the cotton felt for padding the collar 1-1/4 inches wide and of sufficient length to fold over the ends of the interlining for each size collar.</p>					

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
1	<p><u>Cutting.</u> (cont'd)</p> <p>h. Cut the piping material (see 3.3.11) for piping the front and bottom edges of coats, edges of shoulder straps, and ornamental sleeve patches (class 1) on the straight. The piping shall be cut 5/8 to 3/4 inch wide for shoulder straps and ornamental sleeve patches, and 1 inch wide for front and bottom edges of the coat. Cut the applicable binding material (see 3.3.12) for the top and bottom edges of the collar interlining on the straight, 1-1/8 inches wide.</p> <p>i. Cut the wigan for reinforcing the bottom of sleeves on the bias in accordance with the pattern.</p> <p>j. Punch the reinforcement discs for buttons secured to the side seam from cloth, cotton buckram. The reinforcement disc shall be 7/8 inch diameter with a 1/8 inch diameter hole at the center.</p>					
2	<p><u>Replacement of damaged parts.</u></p> <p>a. At time of cutting, replace all parts of coat containing holes; seriously weakening defects such as smashes, multiple floats, loose or weakening slubs, etc., expected to develop into holes; shade bars and dye streaks; or unsightly slubs, etc., affecting appearance.</p> <p>b. Replace any part damaged during the manufacturing process by needle chews, which may be expected to develop into holes; scissors or knife cuts; tears; holes; mends or burns in the material affecting appearance.</p>					
3	<p><u>Shade marking.</u></p> <p>a. Mark or ticket (see 3.6.1.4) all component parts cut from one piece of basic and lining materials, and pairs of sleeve linings when cut from ends, to insure uniform shade and size throughout the coat.</p>					

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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> (cont'd)  b. The use of tickets with any metal fastening devices is prohibited on the rayon lining.					
4	<u>Make coat hanger and lining securing straps.</u>  Finished appearance. The coat hanger and lining securing straps shall finish 1/4 to 3/8 inch wide.  a. Fold the 1-1/8 inch wide strip of lining material in half lengthwise. Turn the edges to the inside and seam 1/16 inch from the turned edges.  b. Cut the coat hanger 3-3/4 $\pm$ 1/4 inches long.  c. Cut the lining securing straps 4-1/2 $\pm$ 1/4 inches long.	301	EFp-1	12-16	A	A
5	<u>Make collar eyelet covers.</u>  Finished appearance. The collar eyelet covers shall finish 1-3/4 $\pm$ 1/8 inches wide.  a. Turn under the side edges of the collar eyelet covers. Stitch 1/16 to 1/8 inch from the folded edges, catching the turned under portions in the stitching.  b. Fold each cover in half across the width. Seam 1/16 to 1/8 inch from the folded side edges.	301  301	EFa-1 (each side edge)  SSa-1	12-16  12-16	A  A	A  A
6	<u>Make underarm shields.</u>  Finished appearance. The shields shall be finished smooth and flat without puckers, pleats, gathers, or other distortions.  a. Position the two plies of material for the underarm shields with edges even. Seam the two plies together along the curved side and bottom edges 3/8 inch from the edges.	301	SSa-1	12-16	A	A



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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
7	<u>Make belt loops.</u> (cont'd)					
	f. Securely bartack the end of the buttonhole, catching the ends of the gimp and thread in the bartack. Trim the ends of the gimp and thread.	Bartack		21 per bartack	A (silk)	A (silk)
8	<u>Make shoulder straps.</u>					
	Finished appearance. The shoulder straps shall be uniform in appearance and shall finish smooth and flat without twists, gathers, puckers, pleats, or other distortions. The piping shall be evenly worked out and shall extend uniformly 1/8 inch beyond the seamed edges of the shoulder strap. The buttonholes shall be clean-cut, well made, well worked over gimp to fit a 27-line insignia button. The gimp and thread shall be pulled through to the underside of the straps. The purling of the buttonhole shall be on the outside.					
	a. The shoulder straps shall be made of two plies of basic material piped with a 5/8 to 3/4 inch wide strip of piping material specified in 3.3.11.					
	b. Turn under one edge of the piping 5/16 inch and stitch through all plies, 1/16 inch from the turned raw edge.	301	EFa-1	12-16	A	A
	c. Position the right side of the top ply of the shoulder strap on the hemmed piping with the raw edges of shoulder strap in line with the piping stitching line.					
	d. Stitch shoulder strap to piping along the back, front, and collar end, 1/8 inch from the inner edge of the piping.	301	SSe-2 (a)	10-16	A (silk)	A (silk)
	e. Trim and notch the piping in accordance with good manufacturing practice in order to prevent pulling and to eliminate gathers and bulges around the collar end.					



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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
9	<p><u>Make ornamental sleeve patches (class 1 only).</u></p> <p>Finished appearance. The ornamental sleeve patch shall be uniform in appearance and shall finish smooth and flat without twists, gathers, pleats, puckers, or other distortions. The piping shall be evenly worked out and shall extend uniformly 1/8 inch beyond the seamed edges of the sleeve patch. The eyelets shall be well worked with the purling on the outside of the sleeve patch and shall finish with a 1/8 to 3/16 inch diameter opening.</p> <p>a. The ornamental sleeve patch shall be made of two plies of basic material piped with a 3/4 inch wide strip of the piping material specified in 3.3.11.</p> <p>b. Turn under one edge of the piping 5/16 inch. Stitch through all plies, 1/16 inch from the turned raw edge.</p> <p>c. Position the right side of the top ply of the sleeve patch on the hemmed piping, with the raw edges of the sleeve patch in line with the piping stitching line.</p> <p>d. Join the sleeve patch to the piping along the top, bottom and scalloped edge 1/8 inch from the inner edge of the piping.</p> <p>e. Trim and notch the outer edge of piping along the scalloped edge in order to prevent pulling and bulges on the edges.</p> <p>f. Position the top ply of the sleeve patch on the under ply, face to face, with the outer edge of the piping and the raw edge of the under ply even.</p> <p>g. Stitch along the top, bottom, and scalloped edge, through all plies 3/16 inch from the inner raw edge of the piping. Trim any excess material if necessary.</p>	301	EFa-1	12-16	A	A
		301	SSe-2 (a)	12-16	A (silk)	A (silk)
		301	SSk-1 (a) (without cord)	12-16	A (silk)	A (silk)

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TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
9	<p><u>Make ornamental sleeve patches (class 1 only).</u> (cont'd)</p> <p>h. Turn the sleeve patches, working out the piping completely and forming smooth corners and point at the scalloped side edge.</p> <p>i. Topstitch the sleeve patches uniformly, 3/16 inch from the folded edge of the piping.</p> <p>j. Press the sleeve patches smooth and flat with a heated pressing iron or pressing machine.</p> <p>k. Mark each sleeve patch, as indicated by marks on pattern, for the location of three eyelets.</p> <p>l. Make one eyelet at each mark, through all plies of the sleeve patches, for attaching insignia button.</p>	301	SSk-1 (b) (without cord and topstitched)	12-16	A (silk)	A (silk)
		Eyelet		22 per eyelet	A (silk)	A (silk)
10	<p><u>Stitch and press dart in under sleeve.</u></p> <p>a. Fold the under sleeve, matching the cut edges of the sleeve darts. Stitch the entire length of the dart, 1/4 inch from the cut edges of the armhole, and taper the line of stitching to zero at the lower folded edges.</p> <p>b. Turn the cut edges of the dart toward the forearm edge and press the entire dart smooth and flat with a heated pressing iron.</p>	301	SSa-1 (cut edges) OSf-1 (folded edges)	12-16	A	A
11	<p><u>Seam sleeves at forearm.</u></p> <p>Finished appearance. The forearm seam shall finish smooth and flat without twists, gathers, puckers, or pleats and shall start and finish evenly.</p>					

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
11	<u>Seam sleeves at forearm.</u> (cont'd)  a. Position the top sleeve with upper forearm edge in line with the notch in the armhole edge of under sleeve. The notches in the lower forearm edge of top and under sleeve shall match. Seam top and under sleeves together, 3/8 inch from the forearm edge of the top sleeve, forming a tapered outlet on the under sleeve.  b. Spread open the seam and press flat with a heated pressing iron.  c. Mark sleeve end for turnup; and mark the top sleeve for positioning the ornamental sleeve patch with the pattern marker.	301	SSbd-1 and SSa-1	12-16	A	A
12	<u>Baste wigan reinforcement to sleeve.</u>  a. Position the sleeve on the wigan reinforcement piece with the marks and notches matching.  b. Baste the sleeve and wigan piece together at the mark for the bottom turnup.  c. Tack the sleeve to the reinforcement piece along the forearm seam allowance, and along the backarm edges of the top and under sleeve.	Hand or 101	SSa-1	8-12  8-12	A  A	A  A
13	<u>Join ornamental sleeve patches to sleeves (class 1 only).</u>  Finished appearance. The ornamental sleeve patch shall be uniformly stitched to the top sleeve without twists, gathers, puckers, pleats, or raw edges. The folded front edge of the patch shall not be topstitched. The position of the ornamental sleeve patch shall be as shown in Figure 4. The scalloped edge of the sleeve patch shall be stitched to the sleeve only at the corners and point in order to facilitate removal of insignia buttons when pressing the coat.					

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
13	<p><u>Join ornamental sleeve patches to sleeves (class 1 only).</u> (cont'd)</p> <p>a. Mark the ornamental sleeve patch on the under ply, 1/4 inch from the raw edge. Position the sleeve patch on the sleeve with the marks matching and the bottom edge of sleeve patch even with mark for the bottom turnup of the sleeve.</p> <p>b. Seam the sleeve patch to the sleeve at the mark.</p> <p>c. Turn back the sleeve patch at the seamline and stitch through the sleeve and wigan along the upper and bottom piped edges. The line of stitching shall be adjacent to the stitching line of the sleeve patch piped edge and shall extend from the turned edge to approximately 1/2 inch over the pointed ends. At the center point, the stitching shall extend approximately 1/2 inch on each side of the point.</p>	301	LSa-1	12-16	A (silk)	A (silk)
		301	LSbj-1	12-16	A (silk)	A (silk)
14	<p><u>Seam sleeves at backarm.</u></p> <p>Finished appearance. The backarm seam shall finish smooth and flat without twists, gathers, puckers, or pleats and shall start and finish evenly.</p> <p>a. Join the top and under sleeve together at the backarm with a 3/8 inch seam, catching the ends of the wigan reinforcement piece in the stitching.</p> <p>b. Spread open the seam and press smooth and flat without a heated pressing iron.</p>	301	SSa-1	12-16	A (silk)	A (silk)
15	<p><u>Baste and tack sleeve turnup to reinforcement.</u></p> <p>a. Turn up the bottom edge of the sleeve to the inside at the mark and baste along the turned edge.</p>	Hand or 101				

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
15	<u>Baste and tack sleeve turnup to reinforcement.</u> (cont'd)  b. Tack the raw edge of the turn up portion to the reinforcement wigan piece with blind stitching.	301 or Hand	EFc-1	4-6  4-6	A  C (silk)	A
16	<u>Stitch and press dart in under sleeve linings.</u>  a. Fold the under sleeve lining, matching the cut edges of the under sleeve dart. Stitch the entire length of the dart, 1/4 inch from the cut edges at the armhole, and taper the line of stitching to zero at the lower folded edge.  b. Turn the cut edges of the dart toward the forearm edge and press the entire dart smooth and flat with a heated pressing iron.	301	SSa-1 (cut edges) OSf-1 (folded edge)	12-16	A	A
17	<u>Seam sleeve lining at forearm.</u>  Finished appearance. The forearm seam shall finish smooth and flat without twists, gathers, puckers or pleats and shall start and finish evenly.  a. Position the top sleeve lining with upper forearm edge in line with the notch in the armhole edge of under sleeve lining. The notches at the lower forearm edge of the top and under sleeve lining shall match. Seam the top and under sleeve lining together, 3/8 inch from the forearm edge of topsleeve lining, forming a tapered outlet on the under sleeve lining.	301	SSbd-1 and SSa-1	12-16	A	A
18	<u>Seam sleeve lining at backarm.</u>  Finished appearance. The backarm seam shall finish smooth and flat without twists, gathers, puckers, or pleats and shall start and finish evenly.  a. Join the top and under sleeve linings at the backarm with a 3/8 inch seam.	301	SSa-1	12-16	A	A

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
19	<u>Assemble sleeve and sleeve lining.</u>  Finished appearance. The lining shall be seamed to the sleeve without twists, gathers, puckers or pleats.  a. Position the sleeve lining on the sleeve with the upper edge of the lining extending approximately 1 inch beyond the armhole edge of the sleeve.  b. Tack the sleeve lining to the forearm and backarm seam allowance, respectively, of the top sleeve, commencing at the top edge of the wigan reinforcement piece and extending to approximately 6 inches from the armhole edge at backarm and approximately 4-1/2 inches from armhole edge at forearm.  c. Pull sleeve through lining.	301 or Hand	SSa-1	6-8  4-6	A	A
20	<u>Fell turnup of sleeve lining.</u>  Finished appearance. The sleeve lining shall not be short, tight, or twisted at bottom of sleeves.  a. Turn under the bottom edge of the sleeve lining to finish 1 to 1-1/4 inches above the finished end of the sleeve. Baste to turnup of sleeve; or the sleeve lining may be felled to bottom sleeve without basting.  b. Fell the folded edge of the sleeve lining to the turnup of the sleeve with blind stitching.	Hand or 101  Hand or 301	EFc-1 (b)	8-10  6-8	C (silk) 0 (silk)	0
21	<u>Press sleeves.</u>  Turn the sleeve right side out and assemble in pairs. Press the lower half of sleeve smooth and flat, creasing at the forearm and backarm. the backarm crease shall be on the backarm seam. Remove the basting at lower end of the sleeve.					

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
22	<p><u>Assemble collar interlining.</u></p> <p>Finished appearance. The interlining is made of one ply of plastic (mylar), one ply of laminated buckram and one ply of polyester or polyester blend cloth. The interlining shall be constructed without twists, pleats or distortions.</p> <p>a. Position one ply of plastic, laminated buckram, and polyester or polyester blend cloth together and join with a 1/8 inch seam on the upper and lower edges. The interlining shall finish with the polyester or polyester blend cloth positioned on the inside and the plastic (mylar) on the outside (see Figure 7).</p> <p>b. Lap the raw edge of the collar eyelet cover 1/2 to 5/8 inch on the top inside edge of the collar interlining. Seam the covers to the interlining 1/4 inch from the raw edge of the cover. In the finished coat, the collar eyelet covers shall be centered over the eyelet in the collar.</p>	301	SSa-1 (each edge)	12-16	A	A
		301	LSa-1	12-16	A	A
23	<p><u>Pipe outer ply of collar.</u></p> <p>Finished appearance. The piping shall extend at lower, upper, and side edges of the outer ply. Shall be uniformly stitched without twists, gathers, puckers, or pleats.</p> <p>a. The outer ply shall consist of two plies of basic material piped at lower edges with 3/4 inch side strip of the piping material specified in 3.3.11. The upper edge is piped with the white vinyl specified in 3.3.20.</p> <p>b. Position the two plies of the outer collar together (face up and edges even) and stitch together from end to end, 1/8 inch from upper and lower edges.</p>	301	SSa-1	12-16	A (silk)	A (silk)

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
23	<u>Pipe outer ply of collar.</u> (cont'd)					
	c. Seam the 3/4 inch wide strip of piping and vinyl to the two plies of the collar from end to end, 1/8 inch from upper and lower edges.	301	SSe-2	12-16	A (silk)	A (silk)
	d. Turn back the piping and outer ply at the lower edges, uniformly working the folded edge of the piping beyond the edges. Topstitch the outer ply uniformly, 3/16 inch from the folded edge of the piping. The vinyl piping on the upper collar edge shall be trimmed even with the end of the collar.	301	Bsm-3 (b)	12-16	A (silk)	A (silk)
24	<u>Assemble collar.</u>					
	a. Center the interlining assembly on the outer collar. Fold the upper and lower edges of the collar over the interlining assembly and stitch together with a 1/4 inch seam from the folded edge.	301	SSa-1	12-14	A	A
	b. The piping shall be positioned 1/8 inch above the folded upper edge and on the inside of the collar. The piping and collar shall be stitched together from end to end with a 1/8 inch seam from the edge of collar. (The piping shall be as specified in 3.3.11.)	301	SSa-1	12-14	A	A
	c. Lap the upper edge of the collar over the top raw edge of collar lining, approximately 1/2 inch, with the lining and eyelet cover facing up. Stitch collar to lining and eyelet cover 3/16 inch in along the upper edge. The stitching shall extend from center to center of eyelet covers.	301	SSa-1	12-14	A	A
	d. Stitch the gold lace to the finished folded edges of the top collar 1/16 inch in from the finished scarlet edges. The lining and eyelet covers shall be facing up. The lace may be stitched without basting provided the proper appearance and neatness requirements are maintained.	301	SSa-1	12-14	A	A

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
24	<u>Assemble collar.</u> (cont'd)  e. Turn the collar lining and eyelet covers at the seam to the inside of collar and press smooth and flat with a heated pressing iron or pressing machine.					
25	<u>Make collar extension tab.</u>  Finished appearance. The collar extension tab shall extend 3/4 to 7/8 inch beyond the folded edge at the left end of the collar.  a. Turn the top and bottom edges, and the end of the collar lining at the left end of the collar, to the inside of the lining. Baste the turned portion along the top, front, and bottom edges to the body of the lining forming the collar extension tab.  b. Stitch the collar extension tab 1/16 inch from the top, front and bottom edges. Continue the stitching at the back of tab to top row, forming a 1-3/8 to 1/2 inch wide box stitch.	Hand          301	          SSc-1 (top and bottom edges) OSf-1 (front edge) SSa-1 (back edge)	          12-16	          A (silk)	          A (silk)
26	<u>Fell ends of collar.</u>  Finished appearance. The upper piped edges of the collar at each end shall not be visible on the outside of the finished collar.  a. Fold the ends of collar to the inside, against the ends of interlining. Tack collar to reinforcement pieces and eyelet covers with overcast stitching.  b. Attach metal eyelets on each end of the collar midway between the top and bottom edges and 1-1/2 inch $\pm$ 1/8 inch from the finished ends.	Hand    Eyelet		    2-3    22 per eyelet	    C (silk)   A (silk)	    A (silk)

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
27	<p><u>Fold and stitch dart in front lining.</u></p> <p>Finished appearance. The darts shall finish without gathers, puckers, or pleats. The stitching shall be 3/8 inch from the folded edge at the center.</p> <p>a. Fold the front lining and stitch the waist darts in accordance with marks indicated on the pattern. Taper the upper and lower ends to a flat point and securely tack the points.</p>	301	OSf-1	12-16	A	A
28	<p><u>Sew on identification label.</u></p> <p>Finished appearance. The identification label shall be positioned so that in the finished coat, the label shall be midway between front and back edges of the right facing with the bottom edge of the label shall be approximately 4 inches from the bottom finished edge of the coat.</p> <p>a. Sew the identification label to the outside of the right facing with a single row of stitches 1/16 to 1/8 inch from each edge.</p>	301	SSa-1 (each edge)	12-16	A	A
29	<p><u>Join front lining to wool facing.</u></p> <p>Finished appearance. The lining shall be carefully joined to the facing so that, in the finished coat, the lining shall be smooth and flat along the facing without creases, bulges, overlapping of excess material, or other distortion.</p> <p>a. Position the lining on the wool facing with the top edges even.</p> <p>b. Seam front edges of the lining to the back edge of the facing, 3/8 inch from the edge. The stitching shall extend from the top edge of facing to approximately 1-1/4 inches from the bottom edge.</p>	301	SSa-1	12-16	A	A

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
30	<u>Assemble back lining.</u>  Finished appearance. The side back lining shall be carefully joined without gathers, puckers, or pleats. The seams shall start and finish evenly.  a. Position and join the left and right side back linings to the respective center back lining with a 3/8 inch seam.  b. Position the backs and join together at the center with a 3/8 inch seam.	301     301	SSa-1     SSa-1	12-16     12-16	A     A	A     A
31	<u>Join side back and front linings.</u>  Finished appearance. The side, back, and front linings shall be carefully joined without gathers, puckers, or pleats. The seams shall start and finish evenly.  a. Position and join the front and side back linings at the sides with a 3/4 inch seam.	301	SSa-1	12-16	A	A
32	<u>Overedge stitch lining and facing seams.</u>  a. Overedge stitch together the raw edges of the facing lining seam, side seam, side back seam, and center back seam allowance.	503 or 504		6-8  6-8	70/2  70/2	70/2  70/2
33	<u>Press lining seams and waist darts.</u>  a. Turn the edge of facing lining seam, the side seams and the side back seams toward the back and press smooth and flat.  b. Turn the waist darts toward the side seam and press smooth and flat.					
34	<u>Assemble fronts.</u>  Finished appearance. The chest and waist darts shall finish without gathers, puckers, or pleats. The stitching for the waist darts shall be 3/8 inch from the folded edge at the center.					

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
34	<u>Assembly fronts.</u> (cont'd)					
	a. Fold the fronts, matching the notches of the chest darts. Stitch the entire length of the darts 3/8 inch from the notches at the upper end. Taper the line of stitching to zero at the lower end.	301	SSa-1 (cut edge) OSf-1 (folded edge)	12-16	A	A
	b. Fold fronts and stitch the waist dart in accordance with the marks indicated on the pattern. Taper the upper and lower ends to a flat point and securely tack the points.	301	OSf-1	12-16	A	A
35	<u>Press darts on fronts.</u>					
	a. Turn the folded edge of the chest dart toward the armhole and press smooth and flat.					
	b. Turn the folded edge of the waist dart toward the side seam and press smooth and flat.					
36	<u>Assemble side backs and center back.</u>					
	Finished appearance. The side and center backs shall be joined without gathers, puckers, or pleats. The seams shall start and finish evenly.					
	a. Position the center back with notches matching and join with a 5/8 inch seam.	301	SSa-1	12-16	A	A
	b. Position and join the left and right side backs, with notches matching, to the respective center back with a 3/8 inch seam.	301	SSa-1	12-16	A	A
37	<u>Join fronts and back.</u>					
	Finished appearance. The fronts and back shall be joined without gathers, puckers, or pleats. The seam shall start and finish evenly.					
	a. Position and join fronts to the back at the sides with a 3/4 inch seam.	301	SSa-1	12-16	A	A
	b. Overedge stitch all raw edges of the joining seams for fronts and back.	503 or 504	EFd-1  EFd-1	6-8  6-8	70/2  70/2	70/2  70/2

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
37	<u>Join fronts and back.</u> (cont'd)  c. Spread open the side and back seams and press smooth and flat with a heated pressing iron.					
38	<u>Seam reinforcement stay to armhole and shoulder.</u>  Finished appearance. The polyester and cotton reinforcement stay shall be sewn to the armhole and shoulder edges of the fronts without gathers, puckers, or pleats. The top end of the armhole stay and lower edge of the shoulder stay shall form a right angle at the armhole without the stays overlapping each other.  a. Seam the 3/4 inch wide polyester and cotton stays to the underside of the front at the shoulder edge and upper front edge of the armhole, 1/8 inch from the outer edge. The stay at the armhole shall extend from 1/2 inch below the shoulder seam down the front edge of armhole approximately 4-1/2 inches. The stay on the shoulder shall extend from approximately 1/2 inch from armhole and neck.	301	SSaa-1	12-16	A	A
39	<u>Tape armholes.</u>  a. Sew the cotton tape to the armhole starting with one end approximately 1 inch above the notch in the fronts and continuing along the lower and back edges of the armhole to approximately 1/2 inch from the shoulder edge.  b. The tape shall be stitched with slight tension along the lower front edge of the armhole and shall be held taut while stitching along the back edge.	301	SSaa-1	12-16	A	A
40	<u>Press shoulder blades and armholes tapes.</u>  a. Press the shoulder blades and the armhole tape smooth and flat with a heated pressing iron or suitable type pressing machine.					

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
41	<p><u>Mark and dress left front.</u></p> <p>a. Mark and shape the left front edge from the top notch to the bottom front notch.</p> <p>b. The mark line shall be 1 inch from the upper edge to 1-1/8 inches at the waistline. Continue on a straight line from the waistline to the notch at the bottom edge.</p> <p>NOTE: The dressing and shaping shall be performed in the sewing room.</p> <p>c. Where necessary, trim any frayed edges along the right front and bottom.</p>					
42	<p><u>Stitch piping to coat.</u></p> <p>Finished appearance. The piping shall be uniformly stitched to the coat without twists, gathers, puckers, or pleats. The piping shall extend from the collar notch at top edge of the right front, along the bottom and up to the collar notch at the top edge of the left front.</p> <p>a. Position the 1 inch wide strip of piping material on the outside of left and right fronts, with edge even with top, front, and bottom edges of coat. Stitch the piping to coat 1/8 inch from edge. The piping shall extend from the bottom right front edge to the collar notch at the top edge of left front.</p> <p>b. Turn the piping to the inside, folding the corners smooth and flat and working out the folded edge of piping uniformly, 1/8 inch beyond the edges of the coat.</p> <p>c. Topstitch the coat to the piped edges uniformly, 3/16 inch from the folded edge of the piping, catching the turned under portion of the piping in the stitching.</p>	<p>301</p> <p>301</p>	<p>SSa-1</p> <p>SSe-2</p>	<p>12-16</p> <p>12-16</p>	<p>A (silk)</p> <p>A (silk)</p>	<p>A (silk)</p> <p>A (silk)</p>

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
42	<u>Stitch piping to coat.</u> (cont'd)  d. Notch out any excess piping material at the top and bottom front covers to eliminate bulkiness. Trim the inner edge of piping only on the left front from the upper front down to approximately 1 to 1-1/2 inches below waistline, so that the piping will not interfere with the front buttonholes.  e. Serge stitch the raw edge of the piping at the bottom edge of the coat only.  f. Press the piped edges of coat smooth and flat with a heated pressing iron or pressing machine.	503 or 504	EFd-1  EFd-1	6-8  6-8	70/2  70/2	70/2  70/2
43	<u>Interline fronts.</u>  a. Position the left and right fronts on the respective coat front interlinings. Baste the interlining and fronts together from approximately 3-1/2 inches down from the shoulder edge to approximately 2 inches from the bottom edge of the front.  b. Baste along the shoulder, allowing room for setting the shoulder pad, working the fullness in the fronts towards the armhole. Baste along the front of the armhole approximately 1-1/2 inches from the edge. Continue to baste down the back edge of interlining, across the waist dart, to approximately 2 inches from the bottom edge of fronts. Baste along the top edge from the basting stitches for the shoulder to approximately 1-1/2 inches from the front edge. Continue to baste approximately 1-1/2 inches from the front edge to the bottom edge of the fronts.	Hand or 301   Hand or 301	Hopper   Hopper			
44	<u>Trim coat front interlining.</u>  a. Trim the top edge of coat interlining even with the top edge of fronts from the point of the shoulder to the collar notch.					

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
44	<p><u>Trim coat front interlining.</u> (cont'd)</p> <p>b. Notch the top edge of the interlining in line with collar notch.</p> <p>c. Remove stitches joining the front edge of polyester and cotton to coat front interlining, approximately 1/2 inch back from the front and top edges of fronts.</p> <p>d. Turn the fronts inside out and trim the interlining only, approximately 1/4 inch back from the front and top edges of fronts.</p> <p>e. Trim the shoulder edge of the coat front interlining to approximately 3/4 inch from shoulder at armhole edge of fronts. Taper the trimming to 3/4 inch at the neck.</p>					
45	<p><u>Bind front and top edge of interlining.</u></p> <p>a. Fold the polyester and cotton twill back and over the top and front raw edge of the interlining. Stitch the front turned under portion of the polyester and cotton twill to the body of the interlining with three rows of stitches, 1/4 inch apart, placing the first row 1/8 inch from folded front edge and catching the upper turned under portion in the stitching.</p>	301	EFa-3	12-16	A	A
46	<p><u>Bind top neck edge of interlining.</u></p> <p>Finished appearance. The polyester and cotton binding shall be uniformly stitched to the top edge of the coat front interlining from the collar notch to the shoulder point.</p> <p>a. Lap the 3/4 inch wide binding on the outside of the coat front interlining from the collar notch to the shoulder point approximately 1/4 inch. Stitch the binding to the interlining 1/8 inch from the raw edge of the binding.</p>	301	LSa-1	12-16	A	A

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
46	<u>Bind top neck edge of interlining.</u> (cont'd)					
	b. Smoothly fold the free edge of the binding over the top edge and to the underside of the interlining. Secure the free edge of binding to the interlining with a row of stitches 1/8 inch from the raw edge of the binding.	301	EFa-1	12-16	A	A
47	<u>Fell piping to coat front interlining.</u>					
	a. Place the inner edge of piping on the outside of the interlining at the top, front and bottom edges. Baste the piping to the interlining through the fronts.	101				
	b. Fell the upper front and lower inner edge of the piping to the coat front interlining.	301 or Hand	EFc-1	4-6  4-6	A  C (silk)	A
	c. Pull and remove basting stitches from the piping.					
	d. Press the left and right fronts on a suitable type of heating pressing machine, with the chest to conform to the shape of the body.					
48	<u>Mark fronts for positioning the braid and buttonholes (see Figure 5).</u>					
	a. Mark the location of five buttonholes on the outside of the left front. The top and bottom buttonholes shall be in accordance with the mark on the pattern. The remaining three buttonholes shall be evenly spaced.					
	b. Extend the four upper buttonhole lines towards the armhole edge. The first buttonhole line A-C shall extend to within 1-1/2 inches from armhole edge and 5/8 inch from the front piped edge. The lower buttonhole line B-D shall be 1 inch shorter than line A-C as shown in Figure 5.					

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
	c. Bisect lines A-C and B-D and connect the bisecting points E-F with a straight line (see Figure 5).					
48	<u>Mark fronts for positioning the braid and buttonholes (see Figure 5).</u> (cont'd)  d. Position the left front on the right front face to face, with collar notches and armhole edges even. Trace the same line on the right front to coincide with the lines on the left front; the lines on the right front shall extend 3/4 to 1 inch from the front piped edge. The bisecting line on the right front shall be identical to line E-F on the left front.  e. Draw a circle 7/8 + 1/32 inch in diameter on each horizontal line, centered to the bisect line E-F. The edge of each circle shall touch the horizontal line forming a figure 8 design as shown on Figure 5.					
49	<u>Baste gold braid to fronts (see Figures 5 and 6).</u>  a. The braid shall be basted as shown in Figure 6 to the fronts on the marks shown in Figure 5. On the left side of the coat, the edge of the braid shall follow the edge of the buttonhole marks.	Hand				
50	<u>Stitch gold braid to fronts (see Figure 1).</u>  a. The braid shall be stitched to the fronts as shown in Figure 1, 1/16 inch from each edge of the braid, except the stitching shall not cross over the center of the figure 8 design. The braid on the left front shall be unstitched for approximately 3 inches from front end of the buttonhole loop braid.	301	SSa-1 (each side)	12-16	A (silk)	A (silk)
51	<u>Set belt loops.</u>  Finished appearance. The belt loops shall finish vertically straight.					

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
51	<u>Set belt loops.</u> (cont'd)  a. Center the belt loops vertically on the side seam with the pointed end towards the bottom of the coat and the raw edge of the loop 1 inch below the mark for the front bottom buttonhole as indicated by the pattern.  b. Seam loops to the coat 1/4 inch from the raw edge.  c. Turn the loop at the seam, with the pointed end towards the top edge of coat, and secure loop to coat with a row of stitches, 1/4 inch from the raised edge.	301  301	LSq-2 (a)  LSq-2 (b)	12-16  12-16	A (silk)  A (silk)	A (silk)  A (silk)
52	<u>Join facing to fronts.</u>  a. Position the left and right fronts to the respective front facings (face to face), with the waistline notch of the front in line with the notch on the facing and with the front piped edge approximately 3/8 inch from the front edge of the facing. Mark the facing along the top, front, and bottom edges.  b. Lap the front edge of the right and left fronts, respectively at the marks on the outside of the facing. Join the front and facing together as close as possible to, but not on top of, the stitching joining the piping to the front. The stitching shall extend from top to bottom edge of coat front edge only.  c. Trim excess facing material where necessary.	301	LSa-1	12-16	A (silk)	A (silk)
53	<u>Baste front edges.</u>  a. Turn the facing-lining assemblies to the inside of fronts. Baste along the front edge of left and right fronts, working the facing back from the folded edge of the piping.	101 or Hand				

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
54	<u>Baste facing (second time).</u>  a. Baste the facing to the fronts, approximately 1-1/4 inches from the top, front and bottom edges of the coat, holding the lower corner of the coat in such a manner as to cause the lower front edge of the fronts to roll inward towards the back edge of the facing.  b. Turn under and baste the top edge of the facing to the fronts from the collar notch to the front edge, catching the turned under portion of the facing in the basting.  c. Baste the facing to the fronts as close as possible to the facing-lining seam, placing the fullness over the chest and distributing the fullness in the facing in accordance with good commercial practice. The basting shall extend approximately 3 inches from shoulder edge of facings to approximately 1-1/4 inches from the lower edge of facing.  d. Turn under the bottom edge of the facing at the mark and baste along the folded edge.	Hand or 301   Hand or 301   Hand or 301   Hand or 301	Hopper   Hopper   Hopper   Hopper			
55	<u>Tack facings to interlining.</u>  a. Tack the right and left facing-lining seam allowances to the respective coat front interlinings from approximately 2-1/2 inches from the bottom edge of the coat to approximately 3 inches from the shoulder edge.	Hand or 103	SSm-1	4-6  4-6	C (silk) A (silk)	
56	<u>Baste front linings to coat.</u>  a. Fold the front lining in accordance with the notches, forming the chest pleat. Baste along the entire center of the pleat. The folded edge of the pleat on the outside of the lining shall be towards the armhole.	Hand or 301	Hopper			

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
56	<u>Baste front linings to coat.</u> (cont'd)					
	b. Baste the front lining to the coat. Start at the lower end of chest pleat, continue along lower edge of armhole approximately 2 inches from the edge, and end at the side seam. Match side seams of coat and lining. Continue basting as close as possible to the side seam and then across the bottom towards the front approximately 4 inches from the piped bottom edge of the coat.	Hand or 301	Hopper			
57	<u>Baste back lining to coat.</u>					
	a. Fold the back lining, forming approximately a 1 inch wide pleat at the center back. Baste the back lining to the coat along the center pleat from the top end, to approximately 4 inches from bottom finished edge of the coat.	Hand or 301	Hopper			
	b. Baste back lining to coat. Starting at side seam and continue approximately 3 inches from the armhole and shoulder edges.	Hand or 301	Hopper			
58	<u>Hem bottom edge of lining.</u>					
	Finished appearance. The hem shall be uniformly stitched and shall finish smooth and flat without twists, gathers, puckers, or pleats. The hem shall be $3/4 \pm 1/8$ inch wide. The lining securing straps shall be positioned on the side seam outlets of the lining with one edge even with the serged edge.					
	a. Hem the bottom edge of body lining with the raw edge turned under and one end of the securing straps positioned and caught in the stitching, 1/16 inch from the upper folded edge of hem.	301	EFb-1	12-16	A	A

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
59	<p><u>Tack the lining securing straps to bottom of coat.</u></p> <p>Finished appearance. The lining securing straps, when tacked to the bottom edge of the coat, shall not cause twists or other distortions to either the coat or the lining. The end of the surging straps shall finish between the piping at bottom edge of coat and side seam allowance. In the finished coat, the lining shall not be visible below the bottom edge of the coat.</p> <p>a. Position and securely tack the free end of the securing straps to the piping at the bottom edge of coat through the side seam allowance.</p> <p>b. Position the bottom edge of the lining so that, in the finished coat, the lining shall not be visible below the bottom edge of the coat. Fold the lining securing straps across the width and stitch approximately 1/4 inch from the folded end in order to hold the lining in position.</p>	301	SSbh-3	12-16	A	A
		301	OSf-1	6-10	A	A
60	<p><u>Fell facings.</u></p> <p>a. Fell the facing to the piping at the bottom edge of the coat. Start at the bottom edge of the lining and continue along the back and bottom edges of the facing to the front edge of the coat.</p> <p>b. Fell the folded edge of the facings to the piping along the top edge from collar notch to front edge of coat.</p>	Hand		8-10	C (silk)	
		Hand		8-10	C (silk)	
61	<p><u>Trim lining and interlining.</u></p> <p>a. Trim the excess coat front interlining and front lining at the armhole.</p> <p>b. Trim back lining even at the neck.</p>					

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
61	<u>Trim lining and interlining.</u> (cont'd)  c. Trim the shoulder edge of the front and back linings to approximately 3/4 inch from shoulder at the armhole edge. Taper the trimming to 3/8 inch at the neck.					
62	<u>Baste shoulder pad to coat.</u>  a. Insert shoulder pads between interlining and chest padding of coat fronts. Securely tack the pads to the interlining and chest padding only.	Hand or 301	Hopper			
63	<u>Make buttonholes.</u>  Finished appearance. The buttonholes shall be clean cut, well made, well worked over gimp to fit 40 line insignia buttons. The stitching of the buttonholes shall be securely caught in the basic material. The gimp and thread shall be pulled through to the underside of the front. The purling of the buttonholes shall be on the outside of the fronts. The inside edge of the eyelet end of the buttonhole shall be 5/8 inch from the front edge of the coat. The buttonholes shall be cut first type.  a. Remove the basting on the unstitched portion of the braid.  b. Mark the left front for the location of five buttonholes. The marks for the top and bottom buttonholes shall be in accordance with the patterns. The marks for the remaining three buttonholes shall be evenly spaced.  c. Make one horizontal eyelet end, square bar type buttonhole, cut 1-1/4 inches long, at each of the marks.	Button- hole		60 per button- hole (not incl. bartack)	B (silk)	F (silk)

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
	d. Securely bartack the end of each buttonhole, catching the ends of the gimp and thread in the bartack. Trim the ends of the gimp and thread.	Bartack		21 per bartack	A (silk)	A (silk)
63	<u>Make buttonholes.</u> (cont'd)					
	e. Rebaste the unstitched portion of the braid around the buttonholes and completely stitch that portion of the braid through facing as shown on Figure 6.					
64	<u>Seam shoulders.</u>  Finished appearance. The shoulder seam shall finish without a distorted appearance.					
	a. Join the back to the fronts at the shoulders with a 3/8 inch seam, working in the fullness on the back in accordance with good manufacturing practice.	301	SSa-1	12-16	A	A
	b. Spread open the shoulder seam and press flat, holding the shoulders short and exercising much care in pressing in order not to effect a distorted appearance in the finished seam. The pressing shall be accomplished with a heated pressing iron or pressing machine over a suitable block.					
	c. Position the front lining and coat front interlining at the neck, shoulder and armhole edges of the fronts. Baste all plies together on the outside along the front edge of armhole and continue along the shoulder seam and gorge, catching the shoulder pad in the basting. Turn the coat on the inside.	Hand or 301	Hopper			
65	<u>Baste back lining and facing-lining assembly at shoulders.</u>					
	a. Turn under and lap the shoulder edge of the back lining on the facing-lining assembly. Baste lining to the coat along the folded edge of the back lining with the top end of the chest pleat caught in the basting.	Hand				

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
66	<p><u>Seam neckline with size label and coat hanger.</u></p> <p>Finished appearance. The neckline shall finish smooth and flat, without twists, pleats, or puckers. The size label shall be positioned between the ends of the coat hanger. The ends of the coat hanger shall be positioned so that, in the finished coat, the hanger opening shall be <math>2 \pm 1/8</math> inches long when measured along the lower edge of collar lining.</p> <p>a. Join facings and back lining to coat at the neckline, from collar notch to collar notch, with a 1/4 inch seam. The upper edge of the size label and the ends of the hanger shall be positioned and caught in the stitching at the inside center back.</p> <p>b. Press the neckline of the coat smooth and flat with a heated pressing iron or pressing machine.</p>	301	SSa-1	12-16	A	A
67	<p><u>Set collar with lining.</u></p> <p>Finished appearance. The collar shall be carefully joined to the coat without distortion of the collar.</p> <p>a. Mark the neckline on the inside 3/8 to 1/2 inch from top edge for proper positioned of collar.</p> <p>b. Position the collar with the lower edge lapped on the outside top edge of the coat at the mark.</p> <p>c. Seam the collar to the coat from end to end as close as possible to, but not on top of, the stitching for the piping at the lower edge of collar. The stitching shall not be through the collar lining.</p>	301	LSa-1	12-16	A (silk)	A (silk)

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
68	<p><u>Set shoulder straps.</u></p> <p>Finished appearance. The shoulder straps shall be uniformly stitched to the coat without twists, puckers, pleats, or other distortions. On the finished coat, the straps, including the piping, shall be <math>2\text{-}3/8 \pm 1/8</math> inches wide at the armhole seam and shall taper to <math>1\text{-}3/4 \pm 1/8</math> inches wide at the buttonhole eyelet end.</p> <p>a. Position the shoulder straps with the raw edge in line with the armhole and the back finished edge of the strap <math>1/2</math> inch behind and in line with the shoulder seam. The correct position of the button shall be in alignment with shoulder strap buttonhole and when buttoned, there is no distortion of strap or shoulder.</p> <p>b. Seam the shoulder straps to the coat <math>1/4</math> inch from the armhole edge. Trim the shoulder straps even with the armhole where necessary. Turn the coat on the inside.</p>	301	SSa-1	12-16	A (silk)	A (silk)
69	<p><u>Set sleeves.</u></p> <p>Finished appearance. The armhole sleeve seam shall finish without twists, gathers, puckers, or pleats.</p> <p>a. Position sleeve on outside of coat at the armhole, with backarm seam of sleeve matching the side back seam, and the notch in top sleeve and front matching.</p> <p>b. Join the sleeve to the coat with a <math>3/8</math> inch seam, catching the end of the shoulder straps in the stitching.</p>	301	SSa-1	12-16	A	A

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
69	<u>Set sleeves.</u> (cont'd)  c. Press the entire armhole smooth and flat with a heated pressing iron, exercising care not to stretch the armhole. Spread open upper part of the armhole-sleeve seam from the backarm seam of the sleeve to approximately midway between shoulder seam and notch at the front edge of armhole. Press smooth and flat with a heated pressing iron.  d. Fold the excess material at the armhole pit up to the line of stitching of the armhole sleeve seam, forming a hinge effect. The fold shall extend from the armhole notch to approximately 4 inches from the backarm seam.  e. Press the fold smooth and flat with a heated pressing iron.					
70	<u>Baste armhole.</u>  a. Baste around the entire armhole on the inside, holding the back lining, shoulder pad, and front lining in place. Distribute fullness evenly. Turn the coat on the outside.  b. Baste around the outside armhole adjacent to the armhole seam, forcing out the armhole in the basting. The basting shall extend from the backarm seam of sleeve to the front notch of coat.	Hand or 301   Hand or 301	Hopper   Hopper			
71	<u>Set underarm shields.</u>  a. Baste or tack underarm shields at the base of the armhole.	Hand or 301				
72	<u>Stitch sleeve-head pads and linings at armhole.</u>  Finished appearance. The armhole shall not be distorted or puckered due to stitching the sleeve-head pads and linings at the armhole.					

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
72	<u>Stitch sleeve-head pads and linings at armhole.</u> (cont'd)  a. Position the sleeve-head pad on the sleeve with the folded edge of the pad approximately 1/8 inch back from the raw edge of the armhole-sleeve seam and with the one end of the pad matching the notch in the fronts.  b. Stitch the sleeve-head pad to the sleeve front, end to end, through the armhole-sleeve seam allowance, 1/8 inch from the folded edge of the pad, catching the front and back linings and the shoulder pad in the stitching. Continue stitching the linings around the remainder of the armhole, catching the underarm shields in the stitching and trimming away the excess material.  c. The underarm shield may be basted to the armhole prior to stitching.	301	SSa-1	4-6	A	A
73	<u>Tack underarm shield to lining.</u>  Finished appearance. The tacking for the underarm shield shall finish approximately 1/2 inch from the seamed edges.  a. Tack the underside of the underarm shield to the body lining along the side and bottom edges.	Hand		4-6	C (silk)	
74	<u>Fell back lining and facing-lining assembly at shoulders.</u>  a. Fell the back lining and the facing-lining assembly together at the shoulders. Place the stitching over the folded edge of the back lining and secure the top end of the chest pleat in the felling.  b. Fell the folded edge of facing to the piping along the top edge from the collar notch to front edge of coat.	Hand		8-10	C (silk)	
		Hand		8-10	C (silk)	

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
75	<p>Fell sleeve lining at armhole.</p> <p>a. Position the sleeve lining at the armhole with the back and forearm seams of the sleeve and sleeve lining matching.</p> <p>b. Turn under the armhole edge of the sleeve lining. Lap the lining on the outside of the front and back linings and the top edge of the underarm shield. Fell the sleeve lining to the coat around the entire armhole. Place the stitching over the folded edge of the sleeve lining, catching the underarm shield in the filling, and distribute the fullness in accordance with good commercial practice. Backstitch the lower armhole edge from backarm seam of the sleeve to the front edge of the shield.</p> <p style="text-align: center;">-or-</p> <p>c. Machine stitch the lower edge of the sleeve lining, at the armhole, on the inside, from forearm seam to backarm seam. Hand fell the remaining portion as specified in operation 74.b.</p> <p style="text-align: center;">-or-</p> <p>d. Machine stitch the lower edge of the sleeve lining at the armhole, on the inside, from forearm seam to backarm seam. Stitch the remaining portion of the sleeve lining at the armhole with machine simulated hand felling.</p> <p>NOTE: It is required that the simulated hand felling produced by machine shall be equal to or better than the hand felling.</p>	Hand		8-10	C (silk)	
		301	SSa-1	12-16	A	A
		Machine		8-10	C (silk)	

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
76	<u>Mark for eyelets on shoulders.</u>  a. Mark each shoulder for the location of one eyelet, for removable insignia buttons, to align with the eyelet of buttonhole in the shoulder straps. On the finished coat, the shoulder strap shall lie smooth and flat without twisting or bulging.					
77	<u>Make eyelets.</u>  Finished appearance. The eyelet shall be well worked with purling of the eyelet on the outside of the shoulder. The eyelets shall finish with a 1/8 inch diameter opening.  a. Make one eyelet at the mark on each shoulder through all plies.	Eyelet		22 per eyelet	A (silk)	A (silk)
78	<u>Sew hook and eye to collar.</u>  Finished appearance. The hook and eye shall be positioned to properly engage each other, effecting a flat, smooth closure at the front of collar without misalignment.  a. Position and securely sew the hook to the right end and the eye to the left end of the collar. The hook and eye shall be positioned with their front edges even with the respective front ends of the collar and securely sewn to the collar at the top and bottom of the forward edge of the hook and eye. The stitching on each side shall not be more than 3/8 inch from the front end of the collar through the individual holes at the rear of the hook and eye.	Hand		16 per hook 16 per eye	C (silk)	
79	<u>Finish collar.</u>  a. Securely tack the lower corners of the collar to the coat.	Hand		8-10	C (silk)	

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
79	<p><u>Finish collar.</u> (cont'd)</p> <p>b. Turn under the end and top edge of the lining at the right end of the collar. Position the folded edge of the lining under the hook. Fell the folded end of the collar lining to the end of the collar and continue felling along the top folded edge to the end of the stitching joining the lining to the collar.</p> <p>c. Turn under and fell the lower edge of the collar lining to the coat from end to end. Catching the turned under portion of the lining at the right end in the felling.</p> <p>NOTE: The lower edge of collar lining may be basted to coat prior to felling.</p> <p>d. Fell the collar extension tab to the left end of the collar. Continue along the folded top edge to the end of the stitching joining the lining to the collar.</p> <p>e. Turn the collar eyelet covers to the inside of the collar. Fell the front edge from the top to bottom edge. Continue the felling along the bottom edge for a distance of 1/2 inch from front edge.</p>	<p>Hand</p> <p>Hand</p> <p>Hand</p> <p>Hand</p>		<p>8-10</p> <p>8-10</p> <p>8-10</p> <p>8-10</p>	<p>C (silk)</p> <p>C (silk)</p> <p>C (silk)</p> <p>C (silk)</p>	
80	<p><u>Clean coat.</u></p> <p>a. Pull any basting thread, trim and remove any loose ends of thread; and remove any spots, stains and tickets without injury to the material.</p>					
81	<p><u>Press coat.</u></p> <p>a. The coat shall be well pressed throughout with a heated pressing iron or pressing machine of a type suitable to obtain the desired shape and appearance in accordance with good manufacturing practices.</p>					

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
81	<p><u>Press coat.</u> (cont'd)</p> <p>b. Press the fronts smooth and flat, straightening and shaping the front edges and working fullness towards the chest. Care shall be exercised in pressing the fronts so that the bottom edges are even.</p> <p>c. Press the entire collar smooth and flat.</p> <p>d. Press the fronts on a body machine, shrinking and properly shaping the chest.</p> <p>e. Press the sides working the fullness towards the back.</p> <p>f. Press the back smooth and flat, removing all fullness.</p> <p>g. Press the sleeves smooth and flat, creasing at the backarm and forearm. The backarm crease shall be on the backarm seam. The forearm and backarm creases shall extend uniformly to a point approximately 3 to 3-1/2 inches below the base of the armhole.</p> <p>h. Block the shoulders to remove the fullness and press shoulders smooth on a shoulder shaping machine. Press the shoulder straps flat.</p> <p>i. Press the armholes solid from the inside, creasing the armhole at the front, and creasing the excess material at the armpit. The armpit and back of the armhole shall be held short while pressing.</p> <p>j. Block the armholes on a pressing buck, shrinking the top sleeves.</p> <p>k. Press lower edge of coat smooth, flat and even.</p> <p>l. Remove all wrinkles and impressions from under shoulder straps.</p>					

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
81	<p><u>Press coat.</u> (cont'd)</p> <p>m. Press body lining throughout, removing all back wrinkles and creases. Press the front and back lining pleats smooth and flat.</p> <p>n. Remove all gloss marks.</p> <p>o. Remove any wrinkles and creases missed by previous pressing operations.</p>					
82	<p><u>Mark and sew button at waist.</u></p> <p>a. Mark the location for one button at the waist.</p> <p>b. Sew one 40-line plastic button at the waist mark.</p>					
83	<p><u>Make openings in back.</u></p> <p>Finished appearance. The openings for inserting button shanks on the back side seams shall be well made and placed without damage to the adjacent material.</p> <p>a. Cut a 1/4 inch vertical opening in back side seams to align with eyelet end of belt loop buttonholes. The ends of the openings shall be machined or hand tacked.</p>	Hand		4-6 per	A	A
84	<p><u>Attach buttons.</u></p> <p>Finished appearance. The buttons shall be aligned with the buttonholes to secure a smooth and complete closure without bulging or misalignment.</p> <p>a. Insert the shank of one 27-line insignia button through each eyelet on shoulders, ornamental sleeve patch and belt loops on back.</p> <p>b. Attach reinforcement disc (see 3.3.5) over the shank of buttons on each belt loop. Secure buttons to shoulders, belt loops, and ornamental sleeve patch with a metal ring toggle.</p>					

## MIL-DTL-82172D(MC)

TABLE I. Manufacturing requirements - Continued.

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/IN	NDL	BOB/ LPR
84	<u>Attach buttons.</u> (cont'd)  c. Sew four 40-line insignia buttons to the fronts aligned with the eyelet ends of the buttonholes.  d. The insignia buttons on the front shall be sewn with the head of the eagle upright.	Hand	8 wraps (double thread)	24/4		

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

TABLE II. Finished measurements. 1/

Size (inches)	Breast <u>2/</u> (inches)	Back length <u>3/</u> (inches)	Sleeve length <u>4/</u> (inches)
Short			
34	35	28-3/4	17-1/2
35	36	28-7/8	17-1/2
36	37	29	17-1/2
37	38	29-1/8	17-1/2
38	39	29-1/4	17-1/2
39	40	29-3/8	17-1/2
40	41	29-1/2	17-1/2
41	42	29-5/8	17-1/2
42	43	29-3/4	17-1/2
44	45	30	17-1/2
46	47	30-1/4	17-1/2
Regular			
34	35	29-3/4	18-1/2
35	36	29-7/8	18-1/2
36	37	30	18-1/2
37	38	30-1/8	18-1/2
38	39	30-3/8	18-1/2
39	40	30-3/8	18-1/2
40	41	30-1/2	18-1/2
41	42	30-5/8	18-1/2
42	43	30-3/4	18-1/2
44	45	31	18-1/2
46	47	31-1/4	18-1/2

## MIL-DTL-82172D(MC)

TABLE II. Finished measurements - Continued. 1/

Size (inches)	Breast <u>2/</u> (inches)	Back length <u>3/</u> (inches)	Sleeve length <u>4/</u> (inches)
Long			
34	35	30-3/4	19-1/2
35	36	30-7/8	19-1/2
36	37	31	19-1/2
37	38	31-1/8	19-1/2
38	39	31-1/4	19-1/2
39	40	31-3/8	19-1/2
40	41	31-1/2	19-1/2
41	42	31-5/8	19-1/2
42	43	31-3/4	19-1/2
44	45	32	19-1/2
46	47	32-1/4	19-1/2
Extra Long			
34	35	32-1/4	20-1/2
35	36	32-3/8	20-1/2
36	37	32-1/2	20-1/2
37	38	32-5/8	20-1/2
38	39	32-3/4	20-1/2
39	40	32-7/8	20-1/2
40	41	33	20-1/2
41	42	33-1/8	20-1/2
42	43	33-1/4	20-1/2
44	45	33-1/2	20-1/2
46	47	33-3/4	20-1/2

1/ Tolerance for all measurements  $\pm 3/8$  inch.

2/ Breast measurements shall be taken, with coat buttoned, from folded edge to folded edge in line with the pit of the armhole; multiply by 2.

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

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

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

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

#### 4. VERIFICATION

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

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

4.2. Inspection conditions. Unless otherwise specified, all inspections shall be performed in accordance with the provisions set forth in ANSI/ASQC Z1.4.

4.3. First article inspection. When a first article is required (see 6.2), it shall be examined for the defects specified in 4.4.2.1 through 4.4.2.5. The presence of any defect or failure to pass any test shall be cause for rejection of the first article. The number of units to be inspected shall be specified by the contracting officer (see 6.2).

#### 4.4. Conformance inspection.

4.4.1 Component and material inspection. Components and materials shall be tested in accordance with all the requirements of the referenced specifications, figures and standards, unless otherwise excluded, amended, modified or qualified in this specification or applicable purchase order. In addition to testing provisions contained in subsidiary specifications, figures and standards, testing shall be performed on the components listed in Table III for the characteristics noted.

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TABLE III. Test methods.

Components	Characteristics	Reqmt. para	Test method	No. det. per sample unit	Results reported as
Padding, felt (for collar)	Material identification	3.3.6	1200	1	Pass or fail
	Weight oz. per sq. yd.	3.3.6	5041	5	Avg. of the 5 det. to nearest 0.1 oz.
	Color	3.3.6	Visual	1	Pass or fail
Ornamental braid (front and sleeve)	Cover thread: - material identification	3.3.16	1200	1	Pass or fail
	- color		Visual	1	Pass or fail
	- ply		Visual	1	Pass or fail
	Cover wire: - metal undercoat	3.3.16	Std com'l	1	Pass or fail
	- metal plating		Std com'l	1	Pass or fail
	Core (stuffer): - material identification	3.3.16	1200	1	Pass or fail
	- number of threads		Visual	1	Pass or fail
	- ply of threads		Visual	1	Pass or fail
	Color	3.3.16	Visual	1	Pass or fail
	Weave	3.3.16	Visual	1	Pass or fail
	No. of carriers	3.3.16	Visual	1	Pass or fail
	Ends/carriers	3.3.16	Visual	1	Pass or fail
	Shape	3.3.16	Visual	1	Pass or fail
	Width (in.)	3.3.16	5020	1	Pass or fail
	Metal content (%): - gold - silver - alloy	3.3.16	4.4.1.3	2 2 2	To nearest 0.1%
	Fastness to: - water - wet (dry) cleaning	3.3.16 3.3.16	5630 5620	1 1	Good, fair or poor Good, fair or poor
Hook and eye	Material identification	3.3.18	Std com'l	1	Pass or fail
	Finish	3.3.18	Std com'l	1	Pass or fail
	Finish	3.3.18	4.5.2	1	Pass or fail

4.4.1.1. Sampling for testing. Unless otherwise specified in subsidiary specifications, sampling shall be in accordance with the following. The lot shall be unacceptable if one or more sample units fail to meet any test requirements specified. The

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unit for expressing lot sizes and sample unit for testing each component shall be in accordance with applicable subsidiary specifications as follows:

Lot size	Sample size
800 or less	2
801 to 22,000 inclusive	3
22,001 and over	5

<u>Component</u>	<u>Expressed as</u>	<u>Sample unit for testing</u>
Padding for collar	yards	1/4 yard full width
Hook and eye	100 each	two each

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

4.4.2 Examination of the end item. The end item shall be examined for the defects listed in 4.4.2.2 through 4.4.2.5. The sample unit shall be one completely fabricated coat.

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

Major defect - When seriously affecting appearance or serviceability.

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

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

Examine	Defects	Classification		
		Major	Minor A    B	
Buttonholes (construction)	a. One or more omitted, added, or wrong type.	101		
	b. Not corresponding to size of button:	102	201	
	- too small, not permitting button to enter buttonhole.			
	- too large, 3/8 inch or more longer than the diameter of button (measured at inside of purling).			
	c. Buttonhole not securely caught on fabric, causing stitching to pull away from fabric.	103		
	d. Bartack missing or loose on:	104	202	
	- one buttonhole.			
	- two or more buttonholes.			
	e. Bartack misplaced, not serving intended purpose on:		203	301
	- one buttonhole.			
	- two or more buttonholes.			
	f. One or more broken stitches in:	105	204	
	- one buttonhole.			
	- two or more buttonholes.			
	g. More than two skipped stitches in:		205	302
	- one buttonhole.			
	- two or more buttonholes.			
	h. Ragged edges, affecting appearance; or exposed interlining not colored with reddish indelible ink.			303
	i. Any uncut buttonhole.		206	

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Examine	Defects	Classification		
		Major	Minor A      B	
Buttonholes (construction) (cont'd)	j. Gimp omitted in one or more buttonholes; or end of gimp not pulled through to underside.		207	
	k. Stitches per buttonhole (not including bartack) less than the minimum specified: - one or two stitches. - three or more stitches.		208	304
	l. One or more buttonholes finished with purling on the underside.	106		
Buttons or ring toggles	a. One missing, loose, broken, defective, or improper size or type.		209	
	b. Two or more missing, loose, defective, or improper size or type.	107		
	c. One or more buttons sewn with the head of the eagle in other than upright position.			305
NOTE: Buttons shall be considered defective if they have sharp, rough, cracked, or split edges; unsound soldering; scratches; dents; blemishes or imbedded foreign matter; loose shanks; or are poorly plated or badly shaped.				
Cleanness	a. One or more spots or stains, of a permanent nature, clearly noticeable: - on the outside. - on the inside.	108	210	
	b. One or more removable spots or stains clearly noticeable: - on the outside. - on the inside.		211	306
Cleanness (cont'd)	c. Thread ends not trimmed throughout garment, or one or more bastings not removed, or two or more shade tickets not removed.			307

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Examine	Defects	Classification		
		Major	Minor A B	
Components and assembly	a. Any component part or required operation omitted (unless otherwise classified herein).	1		
	b. Any defective component or defect of assembly (not herein classified).	2		
Cutting	a. Any component part of the basic wool material not cut in accordance with directional lines on patterns or in accordance with the specification requirements.	109		
	b. Piping material cut on the bias.		212	
	c. Any lining part not cut in accordance with directional lines on patterns, or in accordance with specification requirements.		213	
Eyelet (construction)	a. One or more omitted or added.	110		
	b. Wrong type.		214	
	c. Eyelet not securely caught on fabric, causing stitching to pull away from fabric.	111		
	d. Diameter of inside opening less than 1/8 inch or more than 1/4 inch.			308
	e. One or more eyelets uncut.		215	
	f. One or more broken stitches in: - one eyelet. - two or more eyelets.		216	309
Eyelet (construction) (cont'd)	g. More than two skipped stitches in one or more eyelets.			310
	h. One or more eyelets finished with purling on the underside.		217	
Hooks and eyes	a. Not specified type or size.		218	

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Examine	Defects	Classification		
		Major	Minor A      B	
Material defects and damages	b. Hook or eye not securely tacked to ends of collar.		219	
	c. Not aligned, causing collar ends to be uneven by 1/4 inch or more when front is buttoned and hooks and eyes are fastened.		220	
	a. Any weakening defects such as smash, multiple float, or loose slub.	3		
	b. Any hole.	4		
	c. Shade bar, unsightly slub, etc., affecting appearance: - on outside. - on inside.	5		221
	d. Scissors or knife cut, tear, mend, or burn.	6		
	e. Needle chews that may develop into a hole.	7		

NOTE: Material defects and workmanship damages are to be classified as indicated above only when the condition is one which definitely weakens the fabric or when it is so conspicuously located as to be clearly noticeable. Weakening or nonweakening conditions which are inconspicuous and have negligible affect on serviceability are to be classified as follows:

Material defects	- No defect
Workmanship damages	- Minor B defect

Pressing	a. Burned or scorched.	8		
Pressing (cont'd)	b. Pressing omitted entire garment.		222	
	c. Armhole stretched.	9		
	d. Poorly pressed (unless otherwise indicated).			311
	e. Basting or pressing impressions not removed on major portion of coat.		223	

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Examine	Defects	Classification		
		Major	Minor A      B	
	f. Gloss not removed on major portion of coat.			312
	g. Armholes not blocked or poorly blocked, affecting appearance.		224	
	h. Edges bulky; i.e., not pressed solid, affecting appearance.		225	
	i. Inside of armhole not creased as required.		226	
	j. Sleeve not creased at front or backarm seam.		227	
	k. Wrinkles or pressing impressions not removed under side or center back seam allowance.		228	
	l. Linings not pressed smooth.		229	
	m. Armhole seam not pressed open across top as required.		230	
Seams and stitchings	a. Accuracy of seaming:			
	1. Any seam twisted, puckered, or pleated, affecting appearance.	112		
	2. Part of garment caught in any unrelated operation or stitching.	10		
Seams and stitchings (cont'd)	3. Unsightly hand felling or blindstitching exposed on outside of coat, affecting appearance.		231	
	4. Ends of all stitching (when not caught in other seams or stitching) not backtacked as required.		232	
	5. Wrong color of thread or two shades of thread used on outside of coat, affecting appearance.	11		

NOTE: One or more broken stitches or two or more continuous skipped or run off stitches constitute an open seam.

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Examine	Defects	Classification	
		Major	Minor A      B

NOTE: Raw edges shall be classified as such when they occur at places where an edge is required to be turned under. Raw edges not caught in stitching shall be classified as open seams.

e. Run offs (see classification of open seams).			
f. Stitch tension:			
1. Loose tension resulting in loose seam.	115		
2. Loose tension on raised or edge stitching, resulting in loosely exposed bobbin or top thread.		239	
3. Tight tension (stitches break when normal strain is applied).	116		

NOTE: Puckering is evidence of tight tension. When puckering is evident, the inspector shall test seam by exerting pull in lengthwise direction of seam.

g. Stitches per inch (excluding labels).			
1. Less than minimum specified:			
- one or two stitches.			319
- three stitches.		240	
- four or more stitches.	117		

NOTE: To be scored only if condition exists on major portion of seam.

Seams and stitchings (cont'd)	h. Stitch and seam type:		
	1. Wrong stitch or seam type.	241	
	i. Stitching skipped or broken (on edge or raised stitching when seam is seamed, turned, and stitched):		
	- 1/4 inch or more but not more than 1/2 inch.		320
	- more than 1/2 inch.	242	

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Examine	Defects	Classification		
		Major	Minor A      B	
Shaded parts	a. Any outside part shaded. b. Any lining part badly shaded except sleeve lining. c. Sleeve lining parts badly shaded, or parts not matching each other.	12	243	321

4.4.2.3. Detailed defects (outside of coat). Detailed defects on the outside of coat, with coat buttoned on a form or spread out on a table, shall be classified as follows:

Examine	Defects	Classification		
		Major	Minor A      B	
Collar (construction and setting)	a. Interlining omitted. b. Interlining tight or twisted, causing puckers on collar, affecting appearance.	118	244	
	c. Tight at joining to front or back, causing puckers or pleats at neck of coat, affecting appearance.	13		
Collar (construction and setting) (cont'd)	d. Piping irregular, affecting appearance.		245	
	e. Collar ends overlapping when fastened.		246	
	f. Collar ends spread open more than 3/8 inch when fastened.		247	
	g. Front finished ends of collar uneven in width by 3/16 inch or more.		248	
	h. One ply of outer basic material.	119		
	i. Binding strip at top or bottom edge of interlining omitted.		249	

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Examine	Defects	Classification		
		Major	Minor A      B	
	j. Binding strip at top or bottom edge of interlining other than material specified.		250	
	k. Binding strip at top edge of interlining positioned more than 1/8 inch beyond the top edge of the piping on the outer ply of the collar.		251	
	l. Binding strip at the top edge of interlining irregular in width, affecting appearance; or not exposed beyond top edge of piping on outer ply of collar.		252	
	m. Collar irregular in width by 1/4 inch or more.		253	

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Examine	Defects	Classification		
		Major	Minor A B	
Collar (construction and setting) (cont'd)	n. Center of eyelets from finished ends of collar: - less than 1-3/8 inches but not less than 1-1/4 inches.			322
	- more than 1-5/8 inches but not more than 1-3/4 inches.			323
	- less than 1-1/4 inches or more than 1-3/4 inches.		254	
	o. One or both eyelets off center with top and bottom edges of collar by more than 1/4 inch.			324
	p. Collar off-center by more than 3/8 inch.		255	
Alignment of front buttons and buttonholes	a. Not aligned, causing a noticeable bulge or twist on the fronts when buttoned, affecting appearance.		256	
Length of buttoned fronts	a. Left front at corner shorter than right front at bottom by: - more than 1/8 inch but not more than 1/4 inch. - more than 1/4 inch.	120	257	
	b. Left front at corner longer than right front by: - more than 1/4 inch but not more than 3/8 inch. - more than 3/8 inch.			325
			258	
	c. Right front at corner exposed beyond edge of left front by more than 1/8 inch.		259	
Shoulder (construction)	a. Improperly joined or set, causing shoulder or back to twist.	14		
Shoulder pads	a. Not completely caught in armhole tacking.		260	

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Examine	Defects	Classification	
		Major	Minor A B
Shoulder pads (cont'd)	b. Misplaced, not serving the intended purpose; i.e., too far back or too far forward.		261
	c. One or both pad omitted.		262
Shoulder straps	a. Misplaced; i.e., one strap further forward or back from position of other strap, affecting appearance.		263
	b. Misplaced, so that it will not lie flat when buttoned, causing bulge or twist on strap.	15	
	c. Poorly shaped.		326
	d. Shoulder seam exposed beyond the back edge of the shoulder strap (except rounded end).		264
	e. Width of shoulder strap at armhole seam (including piping): - less than 2-1/4 inches but not less than 2-1/8 inches.		327
	- more than 2-1/2 inches but not more than 2-5/8 inches.		328
	- less than 2-1/8 inches or more than 2-5/8 inches.		265
	f. Width of shoulder strap across center of buttonhole eyelet (including piping): - less than 1-5/8 inches but not less than 1-1/2 inches.		329
	- more than 1-7/8 inches but not more than 2 inches.		330
	- less than 1-1/2 inches or more than 2 inches.		266
	g. Rounded end of shoulder strap positioned less than 1/4 inch or more than 3/8 inch from collar edge.		331
Shoulder straps (cont'd)	h. Piping irregular in width, affecting appearance.		267

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Examine	Defects	Classification		
		Major	Minor A      B	
Position of shoulder strap button and buttonhole	i. Upper side of strap full or twisted, affecting appearance.			332
	j. Back edge of strap less than 1/4 inch or more than 1/2 inch from shoulder seam at armhole.			333
	a. Button not aligned with buttonhole causing a bulge or twist on strap or puckers on shoulders, affecting appearance.		268	
	b. Buttons not uniformly set by more than 1/4 inch.		269	
	c. Buttonhole 1/4 inch or more off center.		270	
	d. Buttonhole from outer edge of piping: - less than 5/8 inch, but not less than 1/2 inch, or more than 3/4 inch. - less than 1/2 inch.			334
Armholes (construction)	a. Badly stretched, affecting appearance.	16		
	b. Taped too tight, causing puckering around armhole seam, affecting appearance.	17		
	c. Crooked seam, affecting appearance.		272	
	d. Tape stitching exposed and visible on outside surface.			335
Armholes (construction) (cont'd)	e. Sleeve-head pads not completely tacked to armholes; or misplaced, not serving intended purpose.		273	
	f. One or both sleeve-head pads omitted.		274	

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Examine	Defects	Classification		
		Major	Minor A B	
Sleeves	<p>a. Setting and hang:</p> <p>1. Sleeve fullness misplaced, affecting appearance.</p> <p>2. Backarm seam of sleeve not matching side back seam by: - more than 1/4 inch but not more than 1/2 inch. - more than 1/2 inch.</p> <p>3. Hang of sleeves on the same coat in opposite direction by more than 2 inches.</p> <p>4. Sleeve tight in armhole, i.e., roll effect not present.</p> <p>b. Sleeve lining:</p> <p>1. Twisted, tight, or short, causing bulge, twist, or puckering on outside of sleeves.</p> <p>2. Sleeve lining too long, causing lining to sag at bottom more than 1/2 inch.</p> <p>3. Sleeve lining seams out of alignment more than 3/4 inch with sleeve seams at armholes or at bottom of the sleeves.</p> <p>4. Cut dart on under sleeve omitted.</p> <p>5. One or both darts not pressed flat.</p>	121	275	
			276	
			277	
			278	
		18		
				336
				337
				338
				339
Sleeves (cont'd)	<p>c. Construction of sleeves:</p> <p>1. Wigan twisted, tight or pleated, causing ridges or puckering on outside of bottom of sleeves, affecting appearance.</p> <p>2. Tacking on bottom turnup to body of sleeve omitted or insecure.</p>		279	
			280	

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Examine	Defects	Classification	
		Major	Minor A B
Sleeves (cont'd)	3. Sleeve bottom edge uneven by more than 1/4 inch.		340
	4. Tacking on one or both sleeve lining seams to sleeve seams omitted or insecure.		341
	5. Bottom edge of sleeve lining turnup less than 1 inch or more than 1-1/4 inches up from bottom edge of sleeve.		342
	d. Ornamental sleeve pieces:		
	1. Piping irregular, affecting appearance.		281
	2. Ornamental piece stitched to sleeve too full or twisted, affecting appearance.		282
	3. Length of ornamental piece (including piping):		
	- less than 5-7/8 inches but not less than 5-5/8 inches.		343
	- more than 6-1/8 inches but not more than 6-3/8 inches.		344
	- less than 5-5/8 inches or more than 6-3/8 inches.		283
	4. Width at top and bottom pts (including piping):		
	- less than 2-3/8 inches but not less than 2-1/8 inches.		345
	- more than 2-5/8 inches but not more than 2-7/8 inches.		346
	- less than 2-1/8 inches or more than 2-7/8 inches.		284
	5. Width at center point (including piping):		
	- less than 2-5/8 inches but not less than 2-3/8 inches.		347
	- more than 2-7/8 inches but not more than 3-1/8 inches.		348
	- less than 2-3/8 inches or more than 3-1/8 inches.		285

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Examine	Defects	Classification		
		Major	Minor A      B	
Sleeves (cont'd)	6. Poorly shaped, affecting appearance.		286	
	7. Set on crookedly, affecting appearance.		287	
	8. Misplaced; i.e., one piece further forward or back from position of other piece, affecting appearance.		288	
	9. Bottom edge not horizontal with bottom edge of sleeve by more than 1/8 inch.		289	
	10. Ornamental piece stitched to sleeve with pointed ends toward forearm seam of sleeve.	122		
	e. Position of buttons on ornamental pieces (measurements made from center of button):			
	1. From top and bottom edges (including piped edge):			
	- less than 3/4 inch but not less than 1/2 inch.			349
	- more than 1 inch but not more than 1-1/4 inches.			350
	- less than 1/2 inch or more than 1-1/4 inches.		290	
	2. Top or bottom button from scalloped edge (including piped edge):			351
	- less than 5/8 inch but not less than 3/8 inch.			352
	- more than 7/8 inch but not more than 1-1/8 inches.		291	
	- less than 3/8 inch or more than 1-1/8 inches.			

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Examine	Defects	Classification		
		Major	Minor A B	
	3. Center button from pointed edge (including piped edge): - less than 7/8 inch but not less than 5/8 inch. - more than 1-1/8 inches but not more than 1-3/8 inches. - less than 5/8 inch or more than 1-3/8 inches.		292	353 354
	4. Center button not in line with pointed edge by more than 1/4 inch.		293	
Body (outside)	a. Fitting of body lining: 1. Tight, short, or twisted, causing fullness or twist on outside of coat, affecting appearance.	19		
	b. Fitting of front interlinings: 1. Tight, short, or twisted, causing fullness or twist on outside of coat, affecting appearance.	20		
Body (outside) (cont'd)	2. Too full, causing coat front to have a wavy appearance.	21		
Chest darts	a. One or both omitted.	123		
	b. Ends of one or both darts not properly tapered, causing bulge or fullness, affecting appearance.		294	
	c. Darts not of uniform length by 1/4 inch or more.			355
	d. Cut edges of dart not turned towards armhole.			356
	e. Not pressed smooth and flat, affecting appearance.		295	
Waist darts	a. One or both omitted.	124		

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Examine	Defects	Classification		
		Major	Minor A	B
	b. Top or lower end of one or both darts not properly tapered, causing bulge or fullness, affecting appearance.		296	
	c. Length of darts not uniform in length by 1/4 inch or more.			357
	d. Folded edge not pressed toward side seam.			358
	e. Not pressed smooth and flat.		297	
	f. Alignment of both waist darts: - top or bottom end out of horizontal alignment by 1/4 inch or more.			359
Ornamental front braid (position, construction and setting)	a. One or more rows of braid omitted or added.	125		
	b. One or more rows of braid on left front not horizontally aligned with corresponding row on right front by more than 1/2 inch.	126		
Ornamental front braid (position, construction and setting) (cont'd)	c. One or more rows of braid not formed with a figure 8.	127		
	d. Diameter of figure 8 circle less than 27/32 inch or more than 7/8 inch.			360
	e. Stitching of one or more rows of braid not started or ended as indicated by Figure 6.			361
	f. Stitching on one or more rows of braid not uniform in width, affecting appearance.			362
	g. Ends of stitching on one or more rows of braid not securely tacked.		298	

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Examine	Defects	Classification		
		Major	Minor A B	
Front and bottom edges	h. One or more rows of braid not lying smooth; i.e., puckered, twisted, pleated or having excessive fullness, affecting appearance.	22		
	i. One or more rows of braid set on tight, causing puckers, twists or pleats on front.	23		
	j. Braid not pressed smooth or flat.			363
	k. Braid loop around one or more buttonholes not properly positioned, restricting use of the buttonhole.		299	
	l. Front edge of one or more rows of braid on left front finished less than 1/4 inch from piping joining seam.		201a	
	m. Any row of braid on left front out of vertical alignment by more than 1/8 inch.		202a	
	a. Front edges stretched, affecting appearance.		203a	
	b. Tape or piping set on tight, causing puckering on front, affecting appearance.		204a	
	c. Front or bottom piping irregular, affecting appearance.		205a	
	d. Bottom edge stretched, puckered, or uneven, affecting appearance.			364
	e. Bottom corner of left front poorly shaped, affecting appearance.		206a	
	f. Left front rolling outward below bottom button.	24		

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Examine	Defects	Classification		
		Major	Minor A B	
Front facings	g. Front edge irregular, affecting appearance.	25	207a	365
	h. Piping tight on front or bottom edge, causing puckering outside of coat, affecting appearance.		208a	
	i. Left front not dressed as specified.		209a	
	a. Short, tight or twisted, causing fullness or twists on fronts, affecting appearance.			
Back side panel seams	a. Curved panel seam on back of coat stretched or distorted, affecting appearance.		210a	
Belt loops (construction and position)	a. Poorly shaped or not of uniform shape or size, affecting appearance.		211a	
	b. Pointed end of one or both loops not toward top of coat.		212a	
Belt loops (construction and position) (cont'd)	c. Bottom end of one or both loops out of horizontal alignment with bottom front buttonhole by: - more than 3/4 inch below or more than 3/8 inch above.		213a	
	d. One or both not stitched on the side seam.		214a	
	e. One or both not vertically straight; i.e., set on an angle, affecting appearance.		215a	
	f. Alignment of both loops: - top or bottom end out of horizontal alignment by more than 1/4 inch.		216a	
	g. One or more edges not properly forced out; i.e., having a fold or lip of 1/8 inch or more.			

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Examine	Defects	Classification	
		Major	Minor A B
Belt loop buttonhole and button (posi- tion and button attachment)	h. Bottom of loop not centered on side seam by more than 1/4 inch.		366
	a. Button not aligned with buttonhole, causing a bulge or twist on loop or puckers on coat, affecting appearance.		217a
	b. Buttons not uniformly set by more than 1/4 inch.		367
	c. Buttonhole 1/4 inch or more off center.		218a
	d. Buttonhole from pointed end of loop: - less than 1/2 inch or more than 3/4 inch.		368
Cut opening for belt loop buttons	e. Reinforcement disc beneath one or both buttons omitted.		369
	a. One or both omitted.	128	
	b. Opening not constructed vertically.		219a
	c. One or more ends on one or both openings not securely tacked.		220a
	d. Opening constructed through body lining.	129	
Front buttonholes (position)	e. Misplaced; i.e., more than 1/4 inch from marks indicated by patterns or not positioned on side seam.		221a
	a. Position from front edge including piped edge: - less than 1/2 inch but not less than 3/8 inch.		370
	- more than 3/4 inch but not more than 7/8 inch.		371
	- less than 3/8 inch or more than 7/8 inch.		222a

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Examine	Defects	Classification	
		Major	Minor A B
Front buttons (position)	b. More than 1/4 from equal spacing.		223a
	c. Top or bottom buttonhole positioned more than 1/2 inch from pattern marks.		224a
	d. Unevenly spaced from front edge by more than 3/16 inch.		225a
	a. Out of vertical alignment by 1/4 inch or more.		226a
	b. Center of top button not in vertical alignment with right end of collar by 1/4 inch or more.		227a

4.4.2.4. Detailed defect (inside of coat). Detailed defects on inside of coat shall be classified as follows:

Examine	Defects	Classification	
		Major	Minor A B
Right front eyelet cover (construction, presence and position)	a. Front raw edges not stitched together prior to seaming to right facing.		228a
	b. Upper or lower seamed edge not hand felled to facing.		229a
	c. Upper or lower seam edge not securely handstitched to facing.		372
	d. Omitted.	130	
	e. Front corner of eyelet cover exposed beyond upper edge of right front.		373
	f. Front edge of cover positioned less than 1/4 inch or more than 3/4 inch in from front edge of right front.		230a

## MIL-DTL-82172D(MC)

Examine	Defects	Classification		
		Major	Minor A      B	
Labels	<p>a. Any required label missing, incorrect, illegible; or size label not securely caught in stitching.</p> <p>b. Identification label not stitch on four sides.</p> <p>c. Bottom edge of identification label less than 3 inches or more than 5 inches from bottom finished edge of coat.</p> <p>d. Identification label not stitched to outside of right facing.</p>	131	231a	374  375
Hanger	<p>a. Hanger omitted or ends not securely stitched.</p> <p>b. Less than 1-7/8 inches or more than 2-1/8 inches long measured along the lower edge of the collar lining.</p>	132	232a	
Hanger (cont'd)	<p>c. Hanger not stitched to neck of coat prior to seaming collar to neck of coat.</p> <p>d. Finished width less than 1/4 inch or more than 3/8 inch wide.</p>		233a	376
Front facings	<p>a. Fullness or pleats on facings between eyelets; buttonholes; or between front edge and eyelet or buttonholes.</p> <p>b. Tacking on back edge to one or both interlinings:</p> <ul style="list-style-type: none"> <li>- omitted.</li> <li>- insecure or incomplete for a distance of more than 4-1/2 inches below shoulder seams; or more than 4 inches above bottom edge of coat.</li> </ul>		234a  235a	377

## MIL-DTL-82172D(MC)

Examine	Defects	Classification	
		Major	Minor A B
Body linings	c. Felling at bottom edge of front facings or back omitted or insecure on one or both facings.		236a
	d. Felling along folded edge of one or both facings at collar notch omitted or insecure.		237a
	a. Excessive puckering or pleated.		378
	b. Twisted, not affecting smoothness on outside of coat.		379
	c. One or both chest pleats on shoulder omitted.		238a
	d. Folded edge of one or both chest pleats facing front edge of coat.		380
	e. Pleat omitted at center of back lining.		239a
	f. Pleat less than 1/2 inch in depth at center of back lining.		381
	g. Bottom hem less than 5/8 inch or more than 7/8 inch wide.		382
	h. Lining too long; i.e., exposed beyond bottom edge of coat.		240a
Body linings (cont'd)	i. Facing-lining seam, side seams, and side back seams not towards back or not pressed smooth and flat.		241a
	j. Waist darts not towards the side seams or not pressed smooth and flat.		242a
	a. One or both omitted or insecure.		243a
Lining (securing straps)	b. Less than 1/4 inch or more than 3/8 inch wide.		383

## MIL-DTL-82172D(MC)

Examine	Defects	Classification	
		Major	Minor A B
	c. One or both positioned more than 1 inch from side seam.		384
	d. End of one or both straps not finished between the piping at the bottom edge of the coat and the side seam allowance.		385
	e. One or both not folded and stitched across width.		386
	f. One or both not properly attached to the lining hem or coat, causing twist or distortion to either the lining or the coat.	244a	
	g. One or both exposed beyond bottom edge of the coat.	245a	
Serge or over-edge stitching	a. Basic material: - omitted on one or more raw edges for seams joining fronts and back where specified.	246a	
Serge or over-edge stitching (cont'd)	b. Lining joined seams: - omitted on one or more seams where specified.	247a	
Underarm shields	a. One or both omitted.	248a	
	b. Not two-piece lining construction.	249a	
	c. Tacking on one or both shields along side or bottom edge to body lining omitted or insecure.		387
	d. Top edge not caught in armhole tacking or stitching when tacked by hand.		388
	e. Puckered, pleated, or twisted.		389
	f. One or both shields misplaced, not serving intended purpose.		390

## MIL-DTL-82172D(MC)

Examine	Defects	Classification		
		Major	Minor A      B	
Inside of armhole	a. Backstitching at armpit of armhole, from backarm seam of sleeve to front edge of shield, omitted.	133		391
Collar lining extension piece	a. Omitted.			
	b. Extended less than 1/2 inch or more than 1 inch beyond left end of collar.			392
	c. Felling omitted or insecure at end or top edges.		250a	
	d. Stitching at top, front and bottom edges, or across width of collar tab (forming box stitch) omitted.		251a	
Collar lining and eyelet covers	a. Ends of collar lining not securely tacked.		252a	
	b. One or both eyelet covers omitted.		253a	
Collar lining and eyelet covers (cont'd)	c. One or both eyelet covers not covering eyelet.		254a	
	d. Width of collar eyelet less than 1-5/8 inches or more than 1-7/8 inches.			393
	e. Felling on front edge and along lower corner of one or both eyelet covers omitted.		255a	
	f. Felling along lower corners of one or both eyelet covers extending for a distance of more than 3/4 inch.			394

4.4.2.5. Finished measurements. Any measurement deviating from the nominal dimensions and tolerances included in Table II shall be classified as a size measurement defect. Sleeve lengths uneven by 1/2 inch or more shall be classified as a size measurement defect.

## MIL-DTL-82172D(MC)

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

4.5.1 Metal composition. Chemical composition shall be determined in accordance with ASTM E1282.

4.5.2 Test for tackiness. At room temperature (60°F to 80°F), press a piece of tissue paper against the lacquered surface for 30 seconds, using any pressure capable of being exerted by the thumb and two fingers. The tissue shall not adhere to the lacquered surface, but shall be free when pressure is released.

4.5.3 Quantity of gold and silver. At least two pieces, 1 yard each, shall be assayed for the quality of gold and silver. Unravel braid to separate enough metal yarn for analysis. Place metal yarn in 70 percent sulfuric acid as many times as may be required to dissolve cotton yarn and to isolate bare metal. The quantities of gold and silver may be determined by standard commercial methods of assay, but in case of dispute, shall be determined in accordance with 4.5.3.1 and 4.5.3.2, respectively.

4.5.3.1. Gold content. Boil sufficient braid to bear 1 gram of alloy (accurately weighed) with 60 milliliters (ml) 1:1 nitric acid (HNO<sub>3</sub>) in a 400-ml beaker using a small flame or hot plate. Continue boiling until all metals except the gold are in solution. Dilute to 200-ml with hot water. Filter through a rapid ashless filter paper and wash several times with hot water. Take the filter paper with the gold (cutting off any excess filter paper), wrap it in a 2 inch by 2 inch piece of silver-free lead foil, and roll it into a ball. Place the ball in the hollow of a bone ash cupel and add lead shot around the ball. Place cupel in a muffle furnace for one hour at 1,000°C. Remove from the furnace and examine hollow for flakes of gold impurities and discolored gold bead. If any are noticed, add additional lead shot and return cupel to the muffle furnace for one hour. Otherwise, cool the gold bead and weigh. The gold content shall be calculated as follows:

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

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

## MIL-DTL-82172D(MC)

4.5.3.2. Silver content. Dilute the filtrate, from 4.5.3.1, to a 1000-ml volumetric flask, and dilute to the mark. Pipette a 200-ml aliquot from the flask into a 400-ml beaker. Heat to boiling and add hydrochloric acid (3:100) drop by drop from a pipette until precipitation is complete (1 ml of hydrochloric acid solution precipitates about 0.039 grams of silver). When solution has cooled and precipitate has settled, determine whether precipitation is complete by adding a few drops of the hydrochloric acid (3:100). If solution remains clear, filter on a weighed porcelain Gooch crucible. Wash the precipitate several times with HNO<sub>3</sub> (1:200) and finally with cold water. Protect the silver chloride from the light; dry in an oven for not less than two hours; cool; and weigh. The silver content shall be calculated as follows:

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

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

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

## 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.)

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

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. Sizes required (see 1.2).
- e. Whether first article is required (see 3.2).
- f. Number of coats in first article (see 4.3).

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

6.4. Figures. Figures 1 through 9 are furnished for information purposes only. To the extent of any inconsistencies between the written specification and the figures, the written specification will govern.

6.5. Vinyl piping. Pearl Binding Corporation of Philadelphia, PA has been found to manufacture vinyl piping meeting the requirements of 3.3.20.

6.6. Subject term (keyword) listing.

Dress  
Enlisted  
Music

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

Preparing Activity:  
Navy - MC  
Project No. 8405-N322

MIL-DTL-82172D(MC)

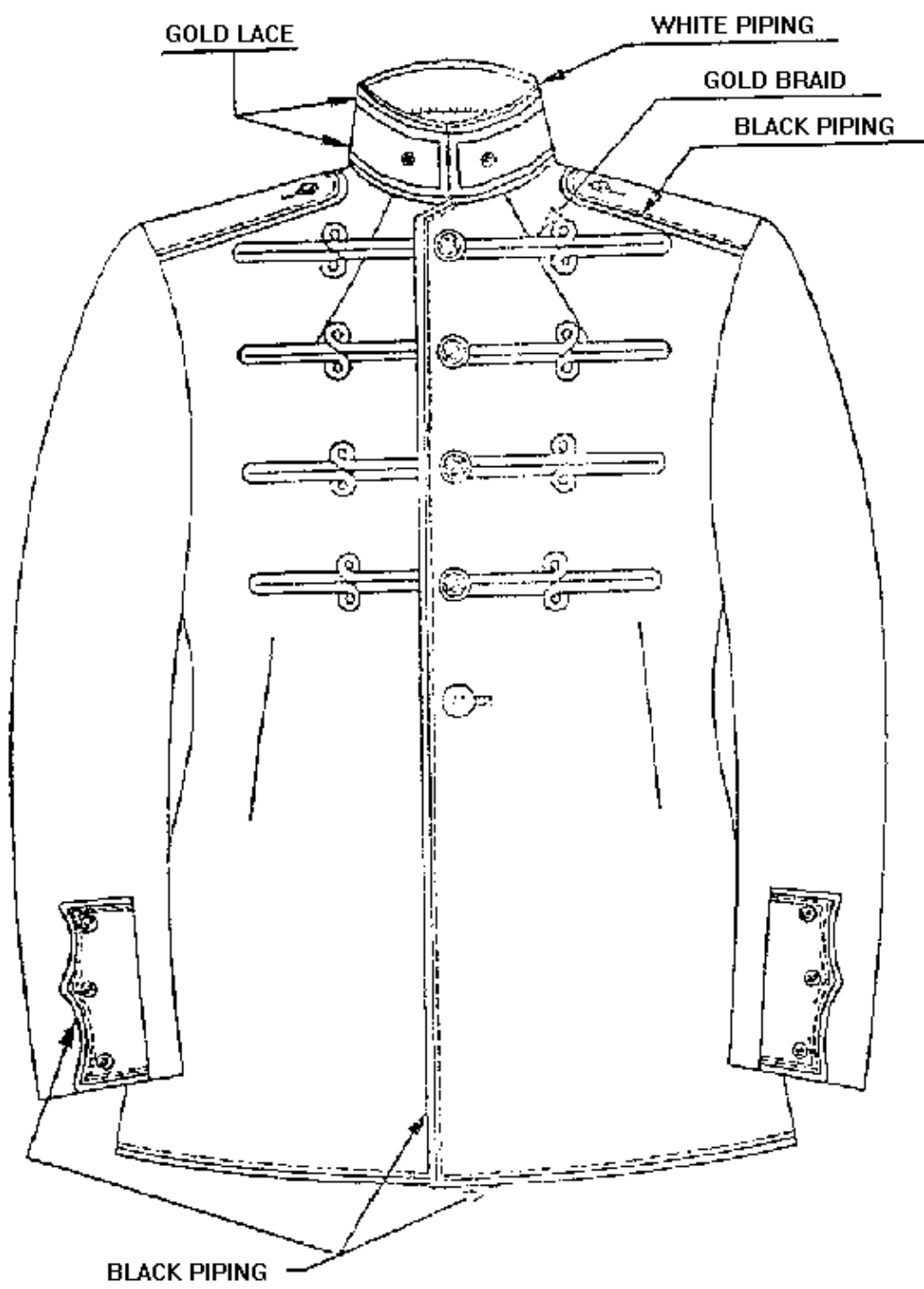


Figure 1. Coat, Man's - Summer and Winter, Scarlet, Drum and Bugle Corps, Drum Major

MIL-DTL-82172D(MC)

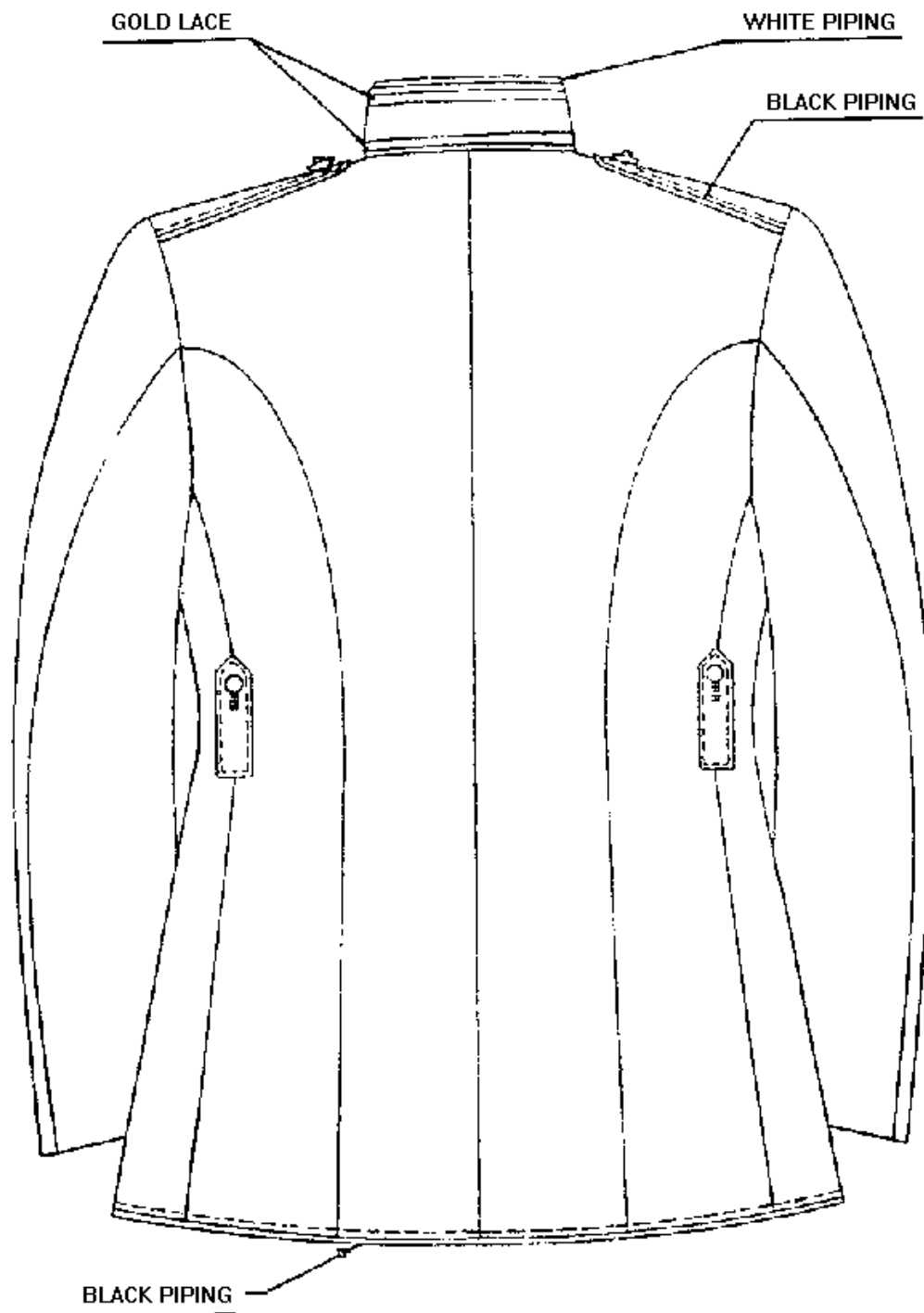


Figure 2. Coat, Man's - Summer and Winter, Scarlet,  
Drum and Bugle Corps, Drum Major

MIL-DTL-82172D (MC)

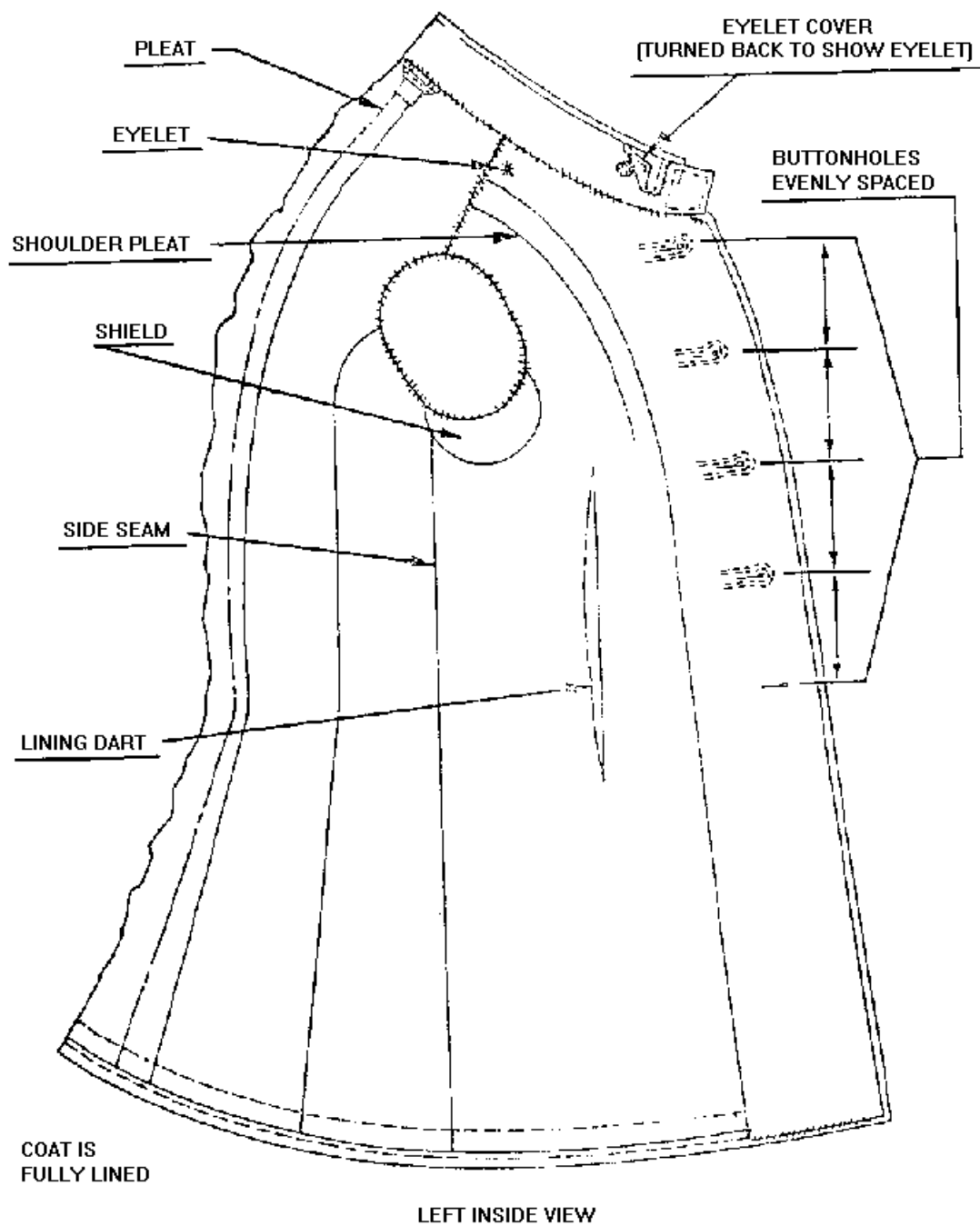


Figure 3. Coat, Man's - Summer and Winter, Scarlet, Drum and Bugle Corps, Drum Major

MIL-DTL-82172D(MC)

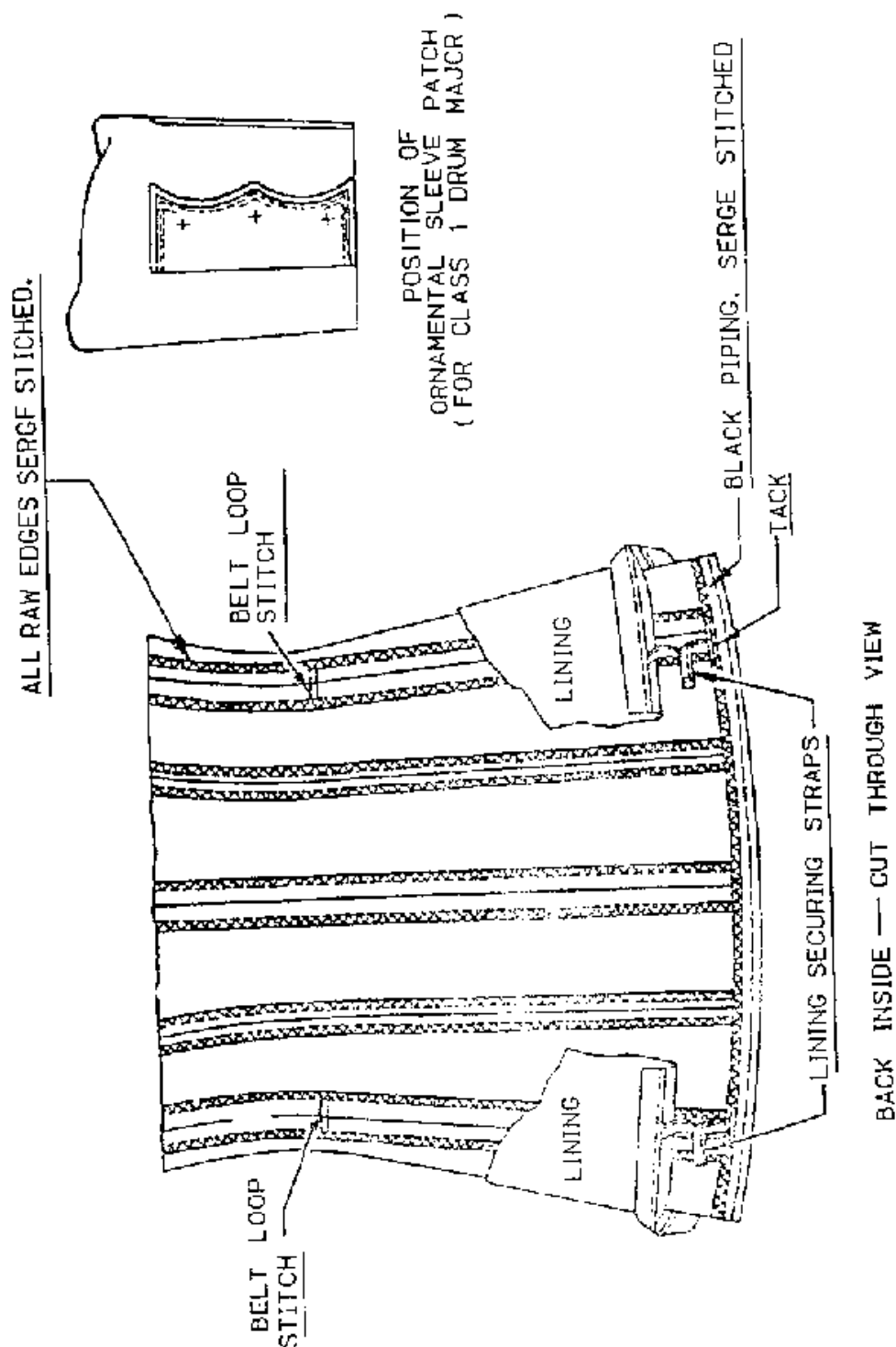
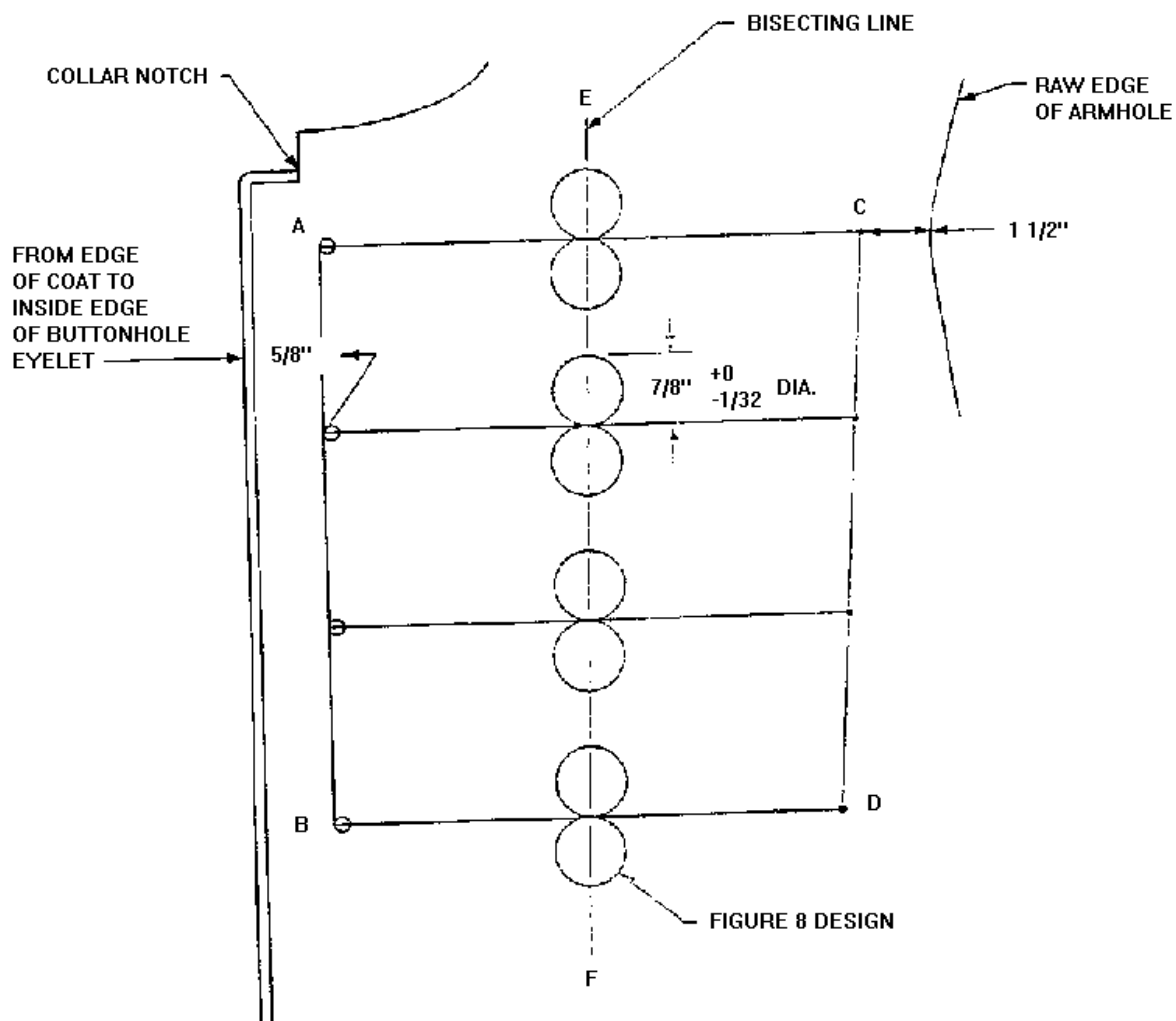


Figure 4. Coat, Man's - Summer and Winter, Scarlet, Drum and Bugle Corps, Drum Major and Director

MIL-DTL-82172D(MC)



BRAID PLACEMENT DIAGRAM - LEFT FRONT

Figure 5. Coat, Man's - Summer and Winter, Scarlet,  
Drum and Bugle Corps, Drum Major and Director

MIL-DTL-82172D(MC)

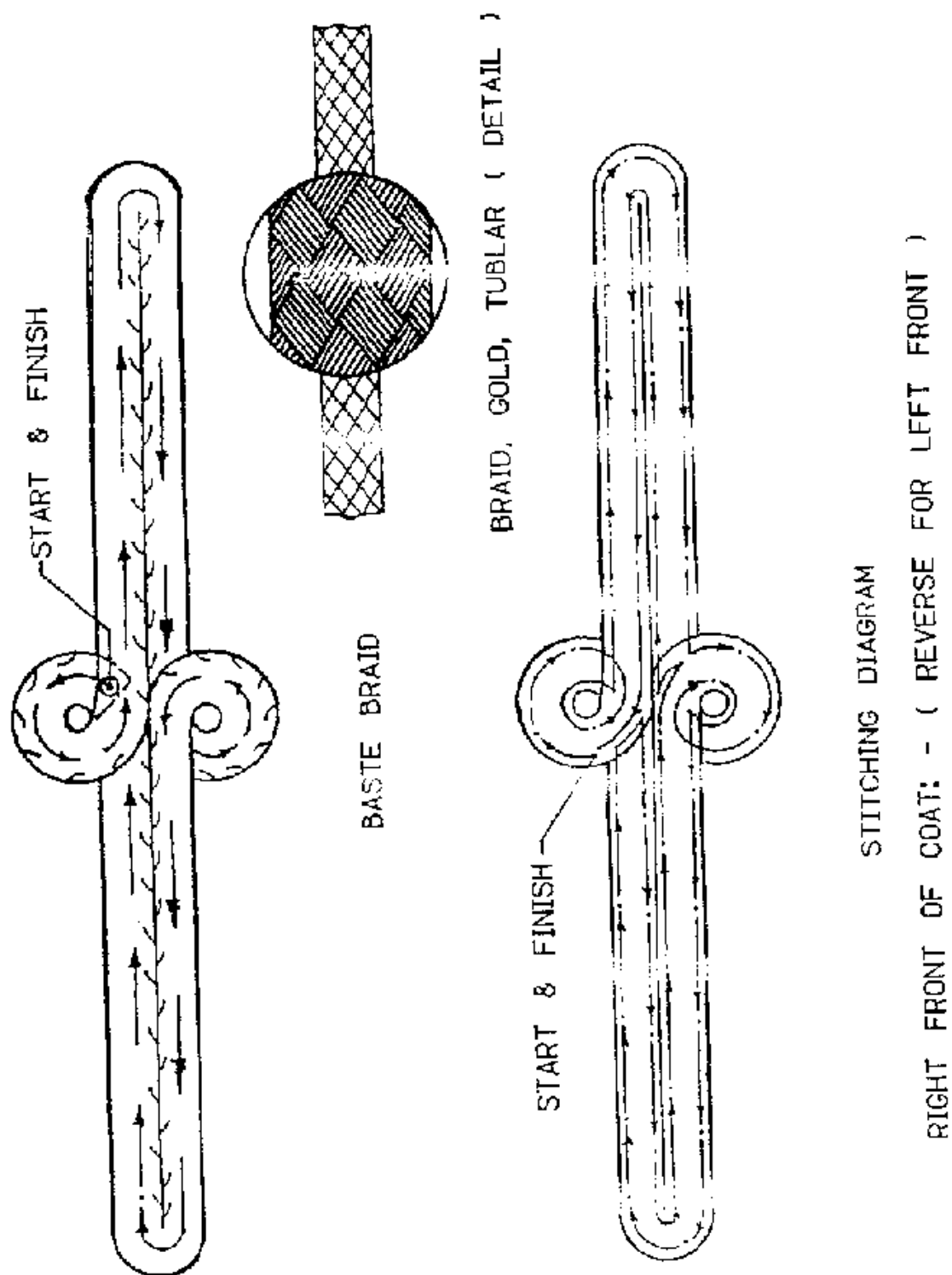


Figure 6. Coat, Man's - Summer and Winter, Scarlet, Drum and Bugle Corps, Drum Major and Director

MIL-DTL-82172D (MC)

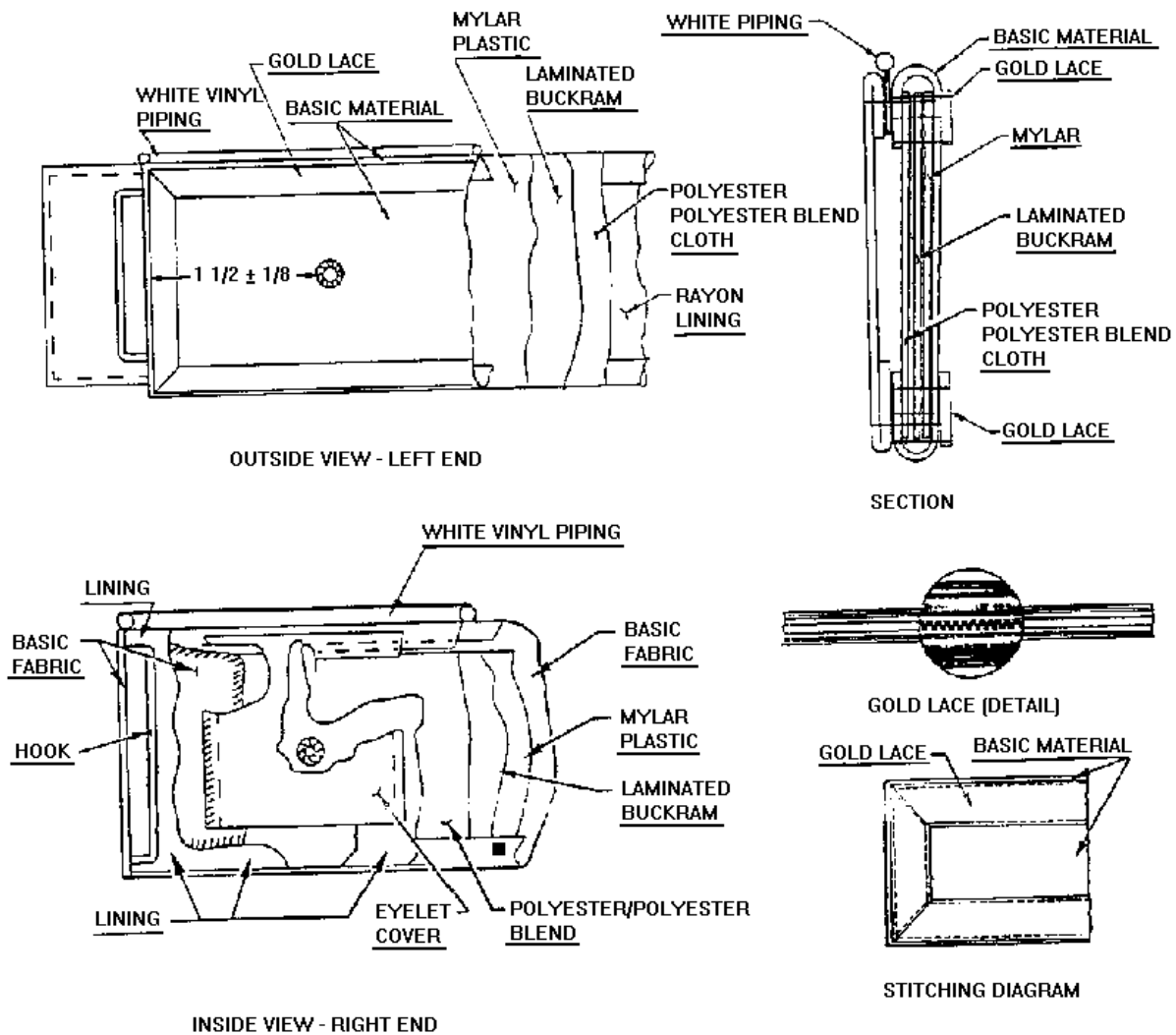


Figure 7. Coat, Man's - Summer and Winter, Scarlet, Drum and Bugle Corps, Drum Major and Director

MIL-DTL-82172D(MC)

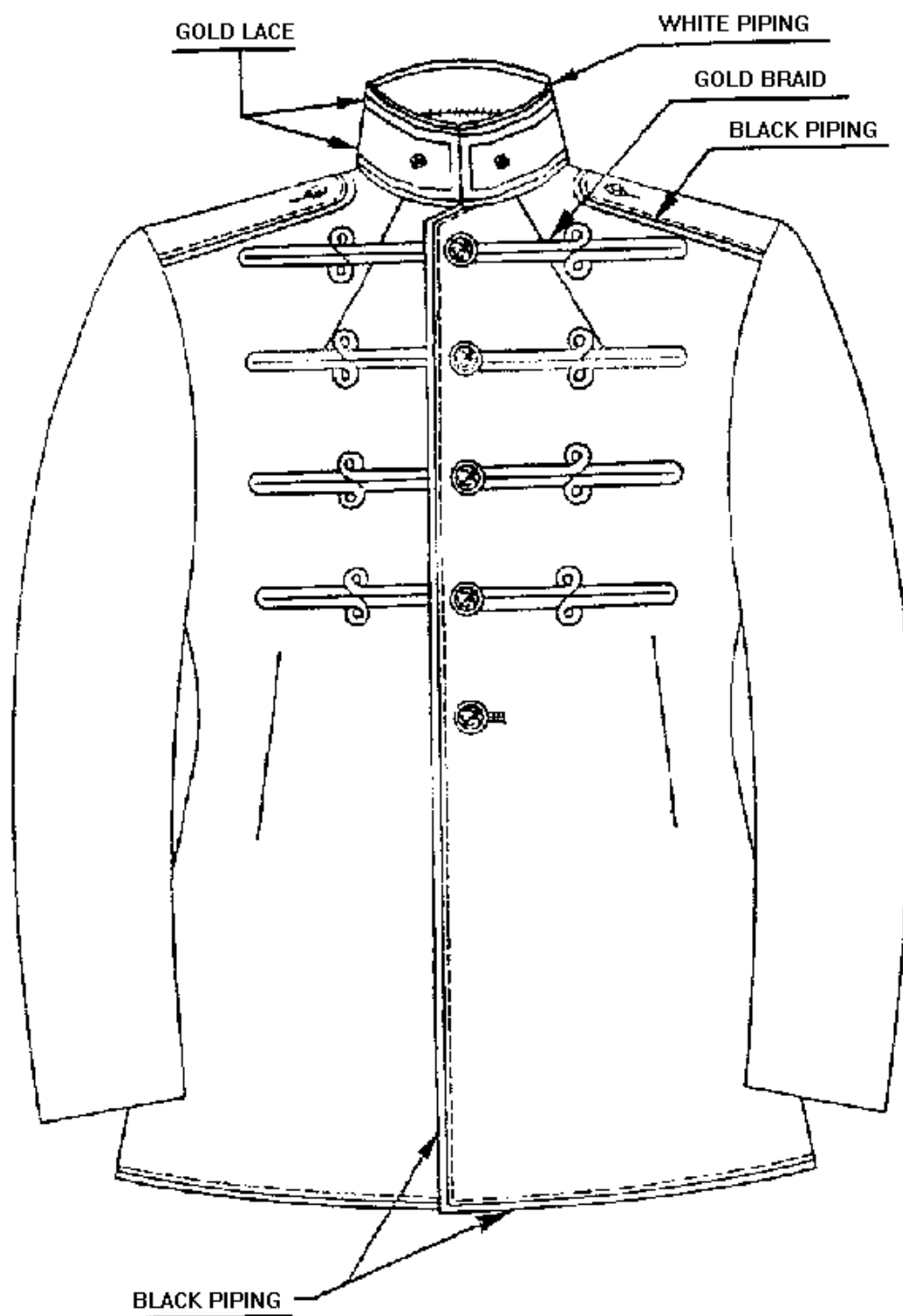


Figure 8. Coat, Man's - Summer and Winter, Scarlet, Drum and Bugle Corps, Director

MIL-DTL-82172D(MC)

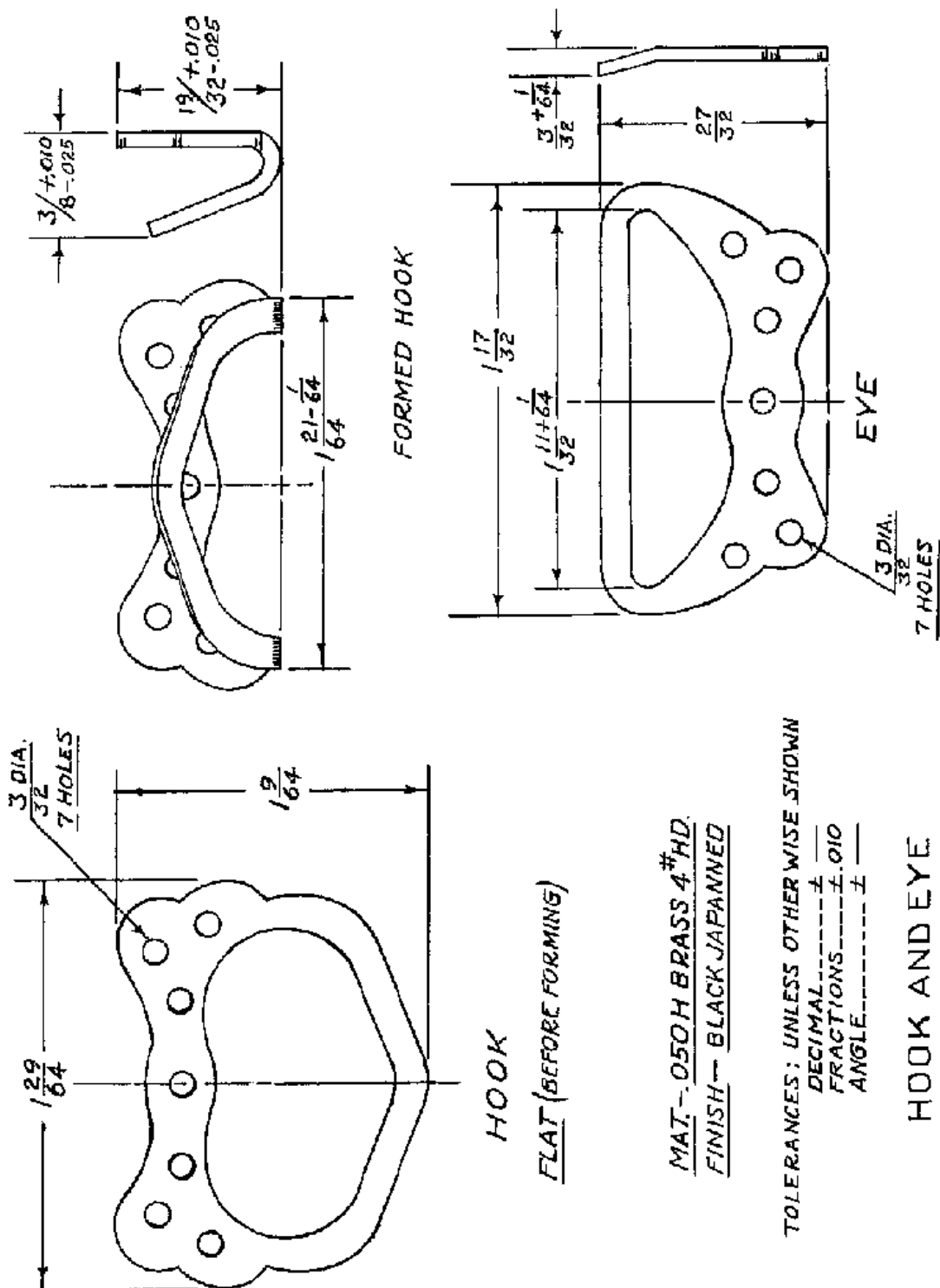


Figure 9. Coat, Man's - Summer and Winter, Scarlet, Drum and Bugle Corps, Drum Major and Director

# STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

## INSTRUCTIONS

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

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

### I RECOMMEND A CHANGE:

1. DOCUMENT NUMBER  
MIL-DTL-82172D(MC)

2. DOCUMENT DATE (YYMMDD)  
971008

3. DOCUMENT TITLE COAT, MAN'S - FULL DRESS, SUMMER AND WINTER, SCARLET U.S. MARINE BAND, DRUM MAJOR

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) AUTOVON  
(if applicable)

7. DATE SUBMITTED  
(YYMMDD)

### 8. PREPARING ACTIVITY

a. NAME  
COMMANDER, MARCORSYSCOM, PSE-D

b. TELEPHONE Include Area Code)  
(1) Commercial (2) AUTOVON  
(703)784-4584 278-4584

c. ADDRESS (Include Zip Code)  
2033 BARNETT AVE, SUITE 315  
QUANTICO, VA 22134-5010

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