

MIL-J-19690B(MC)

30 July 1971

SUPERSEDING

MIL-J-19690A(MC)

7 July 1966

MILITARY SPECIFICATION

JACKET, MAN'S: COTTON AND POLYESTER TWILL; WHITE

1. SCOPE

*1.1 Scope. This specification covers requirements for a white cotton and polyester twill jacket.

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

Schedule of sizesRegular

34 36 38 40 42 44

2. APPLICABLE DOCUMENTS

*2.1 The following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of the specification to the extent specified herein.

SPECIFICATIONS**FEDERAL**

- V-T-280 - Thread, Cotton Gimp, Buttonhole.
- V-T-285 - Thread, Polyester.
- CCC-C-446 - Cloth, Muslin, Cotton.
- DDD-L-20 - Label; For Clothing, Equipage And Tentage (General Use).
- DDD-T-86 - Tape, Textile, Cotton, General Purpose (Unbleached, Bleached, Or Dyed).

MILITARY

- MIL-B-3461 - Buttons, Insignia, Metal, Uniforms And Cap.
- MIL-B-17757 - Boxes, Fiber, Corrugated (Modular Sizes).
- MIL-C-28956 - Cloth, Twill; Cotton And Polyester.
- MIL-T-82163 - Trousers, Men's: Dress, White; And Special Mess, Black.

STANDARDS**FEDERAL**

- FED-STD-751 - Stitch, Seam, And Stitching.

MIL-J-196908(MC)

MILITARY

- | | |
|-------------|-------------------------------------------------------------------|
| MIL-STD-105 | - Sampling Procedures And Tables For Inspection By Attributes. |
| MIL-STD-129 | - Marking For Shipment And Storage. |

(Copies of specifications and standards required by suppliers in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

2.2 Other publications. The following document forms a part of this specification to the extent specified herein. Unless otherwise indicated, the issue in effect on date of invitation for bids or request for proposal shall apply.

UNIFORM CLASSIFICATION COMMITTEE
Uniform Freight Classification Rules

(Application for copies should be addressed to the Uniform Classification Committee, 202 Chicago Union Station, Chicago, Illinois 60606.)

3. REQUIREMENTS

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

*3.2 First article approval. Unless otherwise specified (see 6.2), before production is commenced, the first article consisting of the number of finished jackets specified by the procuring activity (see 6.2) shall be submitted or made available to the contracting officer or his authorized representative for approval. The approval of the first article authorizes the commencement of production, but does not relieve the supplier of responsibility for compliance with all provisions of this specification. The first article shall be manufactured by the supplier in the same facilities to be used for the manufacture of the production items.

3.3 Materials.

*3.3.1 Basic material. The basic material shall be cloth, cotton and polyester twill, white shade 2412 (see 6.3), conforming to class 1 of MIL-C-28956.

*3.3.2 Bias binding. The binding for the raw edges of seams, armholes, facing, bottom turnup and for making the jacket hanger shall be bias-cut from cloth, muslin, cotton conforming to class 3, type III of CCC-C-446, except the total nonfibrous material shall be between 5 and 10 percent. The bias binding shall have sized edges to prevent raveling.

*3.3.3 Polyester thread. The thread for seaming, stitching, buttonholes, and bartacks shall be polyester, white shade AG, Cable No. 66049, conforming to type I, class 1, size A, 3-ply of V-T-285.

***3.3.4 Gimp.** The buttonhole gimp shall be cotton, No. 8, soft or glazed finish, white shade AG, Cable No. 66049 conforming to type I or II of V-T-280.

***3.3.5 Tape.** The tape for the breakline of the lapels shall be cotton, pre-shrunk, unbleached, 1/4 inch wide, conforming to type III, class 2 of DDD-T-86, except the requirements for nonfibrous material shall not apply.

***3.3.6 Buttons.** When specified (see 6.2), buttons shall be furnished with the jacket. The insignia buttons shall be metal, gold plated, enlisted design, 27-line, conforming to type I, style 3, class A, subclass 2 of MIL-B-3461.

***3.3.6.1 Ring toggles.** When buttons are furnished, ring toggles for securing buttons to jacket shall conform to MIL-B-3461.

***3.3.6.2 Linked buttons.** When buttons are furnished, a pair of insignia buttons for the front closure shall be linked together with a multiple link chain conforming to MIL-B-3461.

***3.3.7 Labels.** Each jacket shall have a combined identification-instruction label and a size label. The labels shall show fastness for laundering.

***3.3.7.1 Identification-instruction label (combined).** The identification-instruction label shall conform to type I, classes 1 and 3 (combined) of DDD-L-20 and shall measure not less than 5-1/2 by 2-1/2 inches. The content and format shall be as follows:

Nomenclature (item description).

Contract number.

Name of contractor.

Fiber Contents Act information.

Laundering and Pressing Instructions.

Remove buttons

1. Hand laundering.

- a. Launder in warm water using mild soap.
- b. Scrub soiled areas.
- c. Rinse thoroughly in clear warm water.
- d. Dry without wringing.

2. Machine laundering.

- a. Use a mild detergent.
- b. Complete washing cycle for 30 minutes in 120° to 140°F water.
- c. Rinse thoroughly in clear warm water.
- d. Set automatic dryer for regular fabrics and dry for 15 minutes.

MIL-J-19690B(MC)

3. Pressing.

a. If pressing is required use a cool iron.

DO NOT USE AUTOMATIC IRON ABOVE RAYON SETTING

DO NOT USE HOT IRON

*3.3.7.2 Size label. The size label shall conform to type I, class 2 of DDD-L-20. The size shall consist of numerical size designation specified in 1.2 and the stock number as shown in the following example:

36
Stock number

The stock number may be omitted from the size label, but when omitted, it shall be incorporated in the identification-instruction label.

*3.4 Design. The jacket shall conform to the Marine Corps design shown in Figures 1 through 3, a semiformfitting, unlined jacket with one worked eyelet on each shoulder for detachable buttons, with one buttonhole on each front, designed to be held together at the front with linked buttons, with waist darts, four-piece plain back, plain sleeves, notched lapels and shoulder straps to button.

*3.5 Patterns. Standard patterns will be furnished by the Government. The standard patterns shall not be altered in any manner and shall be used only as a guide for cutting working patterns. The standard patterns provide 1/4-inch seam allowance for shoulder strap seams; 1/4-inch seam allowance for seams at the edge of lapels and front edges of jacket, 3/4-inch seam allowance for side seams, 5/8-inch seam allowance for center back and 3/8-inch seam allowance for all other seams, unless otherwise specified in Table I. These patterns show size, directional lines for cutting and are marked or notched for proper placement and assembly of component parts.

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

| Item | Pattern nomenclature | No. of cut parts |
|------|---------------------------------------------|---------------------|
| | Material: Cloth, cotton and polyester twill | |
| 1. | Front | 2 |
| 2. | Side front | 2 |
| 3. | Center back | 2 |
| 4. | Side back | 2 |
| 5. | Top sleeve | 2 |
| 6. | Under sleeve | 2 |
| 7. | Top collar | 1 |
| 8. | Under collar | 1 |
| 9. | Collar interlining | 1 |
| 10. | Front interlining | 2 |
| 11. | Front facing | 2 |
| 12. | Shoulder straps | 4 |

MARKER

13. Collarstand marker

Shaper

14. Finished lapel shaper

3.6 Construction.

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

3.6.1.1 Operations. The supplier 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 jackets.

*3.6.1.2 Stitches, seams, and stitchings. The stitch, seam, and stitching types specified in Table I shall conform to FED-STD-751. Whenever two or more stitch or seam types are specified for the same operation, any one of them may be used. The number of stitches per inch as specified in Table I indicates the minimum and maximum number permitted.

3.6.1.2.1 Ends of seams and stitching. Ends of seams and stitching (stitch type 301), except the ends of a continuous line of stitching, when not caught in another seam or stitching, 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 (all stitch types) shall be secured by stitching back of the break not less than 1/2 inch.

*3.6.1.3 Shade marking. The component parts of the jacket, except parts cut from ends, shall be marked to insure a uniform shade and size throughout the garment. Any method of shade marking may be used except:

- (a) Corrosive metal fastening devices.
- (b) Sew on tickets.
- (c) Adhesive-type tickets which show discoloration and the adhesive mass which adheres to the material upon removal of the tickets.
- (d) Any marking medium which would tend to leave a permanent mark.

MIL-J-19690B(MC)

TABLE I MANUFACTURING REQUIREMENTS

| OPN NO. | OPERATION | Stitch Type | Seam or Stitch's | Stitches Per Inch | THREAD | |
|------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|---------------------|-------------------------|--------|------------------------|
| | | | | | Needle | Bobbin or Looper |
| 1. | <p><u>Cutting.</u></p> <p>a. Cut jackets in strict accordance with patterns furnished by the Government.</p> <p>b. Cut all parts in direction indicated by directional lines on pattern.</p> <p>c. Cut all parts from one piece of basic material, except the interlining for collar, undercollar, front interlining, and under ply of shoulder straps which may be cut from ends. All parts cut from ends shall harmonize with jacket.</p> <p>d. Cut the cloth, muslin for binding the raw edges of seams, armholes, bottom turnup, and for making the jacket hanger on the bias, 1-1/8 inches wide.</p> | | | | | |
| 2. | <p><u>Replacement of damaged parts.</u></p> <p>a. Replace at time of cutting any parts of the jacket containing holes or serious weakening defects such as smashes, multiple floats and slubs likely to develop into holes.</p> <p>b. Replace any part damaged during manufacturing process by needle chews which may be expected to develop into a hole, scissors or knife cuts, tears, holes, mends, burns and large exposed drill holes.</p> | | | | | |
| 3. | <p><u>Shade marking.</u></p> <p>a. Mark or ticket all component parts (see 3.6.1.3) cut from one piece of basic material to insure uniform shade and size throughout the jacket.</p> <p>b. Adhesive tickets, when used, shall be on the inside of the jacket.</p> | | | | | |

TABLE I MANUFACTURING REQUIREMENTS

| OPN NO. | OPERATION | Stitch Type | Seam or Stitch's | Stitches Per Inch | THREAD | |
|------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|---------------------|---------------------------------|--------|------------------------|
| | | | | | Needle | Bobbin or Looper |
| 4. | <p><u>Make hanger.</u></p> <p>Finished appearance. The jacket hanger shall be uniformly stitched and shall finish smooth and flat, without distortion, puckers, raw edges or pleats. The hanger shall be uniformly 1/4 inch wide.</p> <p>a. The hanger shall be made from a strip of bias binding folded and stitched to finish 1/4 inch wide.</p> <p>b. Fold strip in half lengthwise, turning edges to inside, and seam 1/16 inch from turned edges.</p> <p>c. Cut the hanger 3-1/4 \pm 1/4 inches long.</p> | 301 | EFp-1 | 10-14 | A | A |
| 5. | <p><u>Make shoulder straps.</u></p> <p>Finished appearance. The shoulder straps shall be uniformly stitched and shall finish smooth and flat without twists, gathers, pleats, puckers, or raw edges and shall be uniform appearance. The edges shall be neatly and completely worked out. The buttonholes shall be clean cut, well made, correctly positioned, and well worked over gimp to fit a 27-line insignia button. The purling of the buttonhole shall be on the outside of the strap.</p> <p>a. The shoulder strap shall be made of two plies of basic material.</p> <p>b. Position the two plies with edges even and uniformly seam together 1/4 inch from front and back edges and around collar end. Evenly trim the excess material around the collar ends for proper turning.</p> <p>c. Turn the straps completely, working the seam out to the edges.</p> <p>d. Edgestitch the straps uniformly 1/8 inch from the seamed edges.</p> <p>e. Make a horizontal eyelet-end square-bar type buttonhole, cut 3/4 inch long, in each strap midway between</p> | 301 | SSe-2 (a) | 10-14 | A | A |
| | | 301 | SSe-2 (b) | 10-14 | A | A |
| | | Button-hole | | 60 (minimum per button-hole not | A | A |

MIL-J-19690B(MC)

TABLE I MANUFACTURING REQUIREMENTS

| OPN NO. | OPERATION | Stitch Type | Seam or Stitch's | Stitches Per Inch | THREAD | |
|------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|-----------------------------------------------|--------------------------|--------|------------------------|
| | | | | | Needle | Bobbin or Looper |
| 5. | <p><u>Make shoulder straps.</u> (cont'd)</p> <p>the back and front edges, and with the inside edge of the buttonhole eyelet placed so that in the finished jacket, the edge of the shoulder button shall be 1/4 to 1/2 inch from the edge of collar. Pull the gimp and thread through to the underside of strap. The purling of the buttonhole shall be on the outside of strap. The buttonhole may be made after straps have been attached to the jacket.</p> <p>f. Securely bartack the end of the buttonholes and trim the ends of the gimp and thread.</p> <p>g. Press the straps smooth and flat with a heated pressing iron or pressing machine.</p> | | | including bartack) | | |
| | | Bar-tack | | 21 (minimum per bartack) | A | A |
| 6. | <p><u>Make undercollar.</u></p> <p>Finished appearance. The collar interlining and undercollar shall be uniformly seamed together and shall finish smooth and flat without twists, gathers, pleats, puckers, or other distortions.</p> <p>a. The undercollar assembly shall consist of two plies of basic material.</p> <p>b. Mark the breakline of the undercollar on the interlining side with collarstand marker.</p> <p>c. Position the interlining on the undercollar with edges even and notches matching and join together at the mark for the breakline. Continue to stitch along the sides and upper edge 1/8 to 3/16 inch from raw edges.</p> <p>d. The breakline stitching shall measure 1-1/4 \pm 1/8 inches at the vertical center of the undercollar.</p> | | | | | |
| | | 301 | SSv-1 SSa-1 (sides and upper raw edges) | 10-14 | A | A |
| 7. | <p><u>Assemble topcollar and undercollar.</u></p> <p>Finished appearance. The collar shall be uniformly edgestitched and shall finish smooth and flat without puckers,</p> | | | | | |

TABLE I MANUFACTURING REQUIREMENTS

| OPN NO. | OPERATION | Stitch Type | Seam or Stitch'g | Stitches Per Inch | THREAD | |
|------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|---------------------|-------------------------|--------|------------------------|
| | | | | | Needle | Bobbin or Looper |
| 7. | <u>Assemble topcollar and undercollar.</u> (cont'd) gathers, pleats, or other distortions. The corners and seamed edges shall be well worked out. The seams shall finish at the edge of the collar. a. Position undercollar assembly on the top collar with side and top edges even and notches matching, and join together at the side and top edges with 1/4-inch seam. b. Trim corners for proper turning. Turn the collar, completely working out the corners and seamed edges. c. Edgestitch the collar uniformly 1/8 inch from the seamed edge. d. Trim gorge edge of topcollar even with the gorge of undercollar and leave sufficient material on the topcollar between the gorges to allow slight fullness across width when collar is creased. e. Press entire collar smooth and flat with a heated pressing iron or pressing machine, straightening the seamed edges. | 301 | SSe-2 (a) | 10-14 | A | A |
| | | 301 | SSe-2 (b) | 10-14 | A | A |
| 8. | <u>Seam sleeves at forearm.</u> Finished appearance. The forearm seam shall finish smooth and flat without twists, gathers, pleats, puckers or raw edges. The seam shall start and finish evenly. The binding shall be uniformly stitched and the basic material shall be securely caught in the stitching. a. Position the top and undersleeves with notches matching and seam together at the forearm 3/8 inch from raw edges. b. Bind together the raw forearm edges of top and undersleeve with bias binding. Both edges of the binding shall be turned under and caught in the stitching 1/16 inch from the inner folded edges. c. Turn back and topstitch the topsleeve uniformly 1/8 inch from raised edge. | 301 | LSq-2 (a) | 10-14 | A | A |
| | | 301 | BSc-1 | 10-14 | A | A |
| | | 301 | LSq-2 (b) | 10-14 | A | A |

MIL-J-19690B(MC)

TABLE I MANUFACTURING REQUIREMENTS

| OPN NO. | OPERATION | Stitch Type | Seam or Stitch's | Stitches Per Inch | THREAD | |
|------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|----------------------|-------------------------|--------|------------------------|
| | | | | | Needle | Bobbin or Looper |
| 9. | <u>Seam sleeves at backarm.</u> | | | | | |
| | Finished appearance. The backarm seam shall finish smooth and flat without twists, gathers, pleats, puckers, or raw edges. The seam shall start and finish evenly. The binding shall be uniformly stitched and the basic material shall be caught in the stitching. | | | | | |
| | a. Seam top and undersleeve together at the backarm with a 3/8-inch seam. | 301 | LSq-2 (a) | 10-14 | A | A |
| | b. Bind together the raw backarm edge of top and undersleeve with bias binding. Both edges of the binding shall be turned under and caught in the stitching 1/16 inch from the inner folded edges. | 301 | BSc-1 | 10-14 | A | A |
| | c. Turn sleeves right side out. Top-stitch the topsleeve uniformly 1/8 inch from the raised edge. | 301 | LSq-2 (b) | 10-14 | A | A |
| 10. | <u>Bind facings, stitch dart, and sew on identification instruction label.</u> | | | | | |
| | Finished appearance. The binding shall be evenly stitched and the basic material shall be securely caught in the stitching. The binding shall not be tight or full causing puckers, gathers, pleats or other distortions. The darts shall be tapered to a point at the upper end. The identification-instruction label shall be properly positioned and securely sewn to the right facing. | | | | | |
| | a. Fold the facing, matching the notches of dart and stitch the entire length of the dart 1/8 inch back from the notches at the lower end and tapering to a point at the upper end, securely backtacking the pointed end. | 301 | OSf-1 | 10-14 | A | A |
| | b. Bind the raw back edge of the facings and shoulder edges with bias binding. Both edges of the binding shall be turned under and caught in the stitching 1/16 inch from the inner folded edges. | 301 | BSc-1 | 10-14 | A | A |
| | c. Sew the identification-instruction label to the right facing with single row of stitching 1/16 inch from each edge of the label. | 301 | SSa-1 (each edge) | 10-14 | A | A |

MIL-J-19690B(MC)

| OPN NO. | OPERATION | Stitch Type | Seam or Stitch'g | Stitches Per Inch | THREAD | |
|------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|---------------------|-------------------------|--------|------------------------|
| | | | | | Needle | Bobbin or Looper |
| 10. | Bind facings, stitch dart, and sew on identification instruction label. (cont'd) d. The label in the finished jacket shall be midway between the front and back edges of the facing and approximately 2 inches above the finished bottom edge of the jacket. | | | | | |
| 11. | <u>Assemble fronts.</u> Finished appearance. Front and side body panel shall be carefully joined, uniformly stitched and shall finish smooth and flat without twists, gathers, puckers, pleats, or raw edges. The seams shall start and finish evenly. The darts shall be tapered to a point at the upper end. The binding shall be uniformly stitched and the basic material shall be securely caught in the stitching. a. Fold the front, matching the notches of the waist dart and stitch the entire length of the dart 1/8 inch back from the notches at the lower end and tapering to a point at the upper end, securely backtacking the pointed end. b. Position front and side front panel and join with a 3/8-inch seam. c. Bind together the raw edges of the front and side front panel with bias binding. Both edges of the binding shall be turned under and caught in the stitching 1/16 inch from the inner folded edges. d. Turn back and topstitch the side front panel 1/8 inch from the raised edge. | 301 | OSf-1 | 10-14 | A | A |
| | | 301 | LSq-2 (a) | 10-14 | A | A |
| | | 301 | BSc-1 | 10-14 | A | A |
| | | 301 | LSq-2 (b) | 10-14 | A | A |
| 12. | <u>Assemble back.</u> Finished appearance. The back and side backs shall be carefully joined, uniformly topstitched and shall finish smooth and flat without twists, gathers, puckers, pleats or raw edges. The seams shall start and finish evenly. | | | | | |

MIL-J-19690B(MC)

TABLE I MANUFACTURING REQUIREMENTS

| OPN NO. | OPERATION | Stitch Type | Seam or Stitch'g | Stitches Per Inch | THREAD | |
|------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|---------------------|-------------------------|--------|------------------------|
| | | | | | Needle | Bobbin or Looper |
| *12. | <u>Assemble back.</u> (cont'd) | | | | | |
| | The binding shall be uniformly stitched and the basic material shall be securely caught in the stitching. The center back seam outlet shall be turned toward the left side, and the side back seam shall be turned toward the center. | | | | | |
| | a. Position the center back with edges even and notches matching, and join at the center with a 5/8-inch seam. | 301 | LSq-2 (a) | 10-14 | A | A |
| | b. Position the left and right side back to the respective back with notches matching and join with a 3/8-inch seam. | 301 | LSq-2 (a) | 10-14 | A | A |
| | c. Bind together the raw edges of center back and side back seam, respectively, with bias binding. Both edges of the binding shall be turned under and caught in the stitching 1/16 inch from inner folded edges. | 301 | BSc-1 | 10-14 | A | A |
| | d. Turn back and topstitch the left and right side backs, respectively, uniformly 1/8 inch from the raised edges. | 301 | LSq-2 (b) | 10-14 | A | A |
| 13. | e. Turn back and topstitch the left back at the center seam 1/8 inch from the raised edge. | 301 | LSq-2 (b) | 10-14 | A | A |
| | <u>Join fronts and back.</u> | | | | | |
| | Finished appearance. The fronts and back shall be carefully joined at the sides with the back uniformly topstitched. The seam shall finish smooth and flat without twists, gathers, pleats, puckers, or raw edges, and shall start and finish evenly. The binding shall be uniformly stitched and the basic material shall be securely caught in the stitching. | | | | | |
| | a. Position the back and fronts with edges even and join at the sides with a 3/4-inch seam. | 301 | LSq-2 (a) | 10-14 | A | A |

TABLE I MANUFACTURING REQUIREMENTS

| OPN NO. | OPERATION | Stitch Type | Seam or Stitch's | Stitches Per Inch | THREAD | |
|------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|---------------------|-------------------------|--------|------------------------|
| | | | | | Needle | Bobbin or Looper |
| 13. | <u>Join fronts and back. (cont'd)</u> b. Bind together the raw edges of the left and right side seam allowances, respectively, with bias binding. Both edges of binding shall be turned under and caught in the stitching 1/16 inch from the inner folded edges. c. Turn and topstitch the back at the sides uniformly 1/8 inch from the raised edge. | 301 | BSc-1 | 10-14 | A | A |
| | | 301 | LSq-2 (b) | 10-14 | A | A |
| 14. | <u>Press darts.</u> a. The front dart and facing dart shall be pressed smooth and flat with a heated pressing iron or pressing machine. b. Press the front darts with folded edges toward the back and facing dart with folded edges toward the front. | | | | | |
| 15. | <u>Seam interlining to fronts.</u> a. The front interlining shall be made of a single ply of basic material. b. Position the interlining on the inside of the respective fronts, with front, top and armhole edges even. Seam interlining to fronts 1/8 inch from shoulder and front edge of jacket. | 301 | SSa-1 | 6-10 | A | A |
| 16. | <u>Mark lapels and bottom edges.</u> a. Mark the lapels in accordance with the shaper furnished for proper location of notch, and for positioning of bridle tape. b. Mark jacket 1-1/4 inches from lower edge for bottom turnup. c. Trim bottom edge of front interlining even with the mark for bottom turnup. Trim the bottom ends of the side and back seams, if necessary. | | | | | |
| 17. | <u>Bind bottom turnup.</u> Finished appearance. The binding shall be uniformly stitched and the basic material shall be securely caught in the stitching. The binding shall not | | | | | |

MIL-J-19690B(MC)

TABLE I MANUFACTURING REQUIREMENTS

| OPN NO. | OPERATION | Stitch Type | Seam or Stitch's | Stitches Per Inch | THREAD | |
|------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|----------------------|-------------------------|--------|------------------------|
| | | | | | Needle | Bobbin or Looper |
| 17. | <p><u>Bind bottom turn-up. (cont'd)</u></p> <p>be tight or full causing puckers, gathers, pleats, or other distortion.</p> <p>a. Bind the raw edges of the bottom turnup with bias binding. Both edges of the binding shall be turned under and caught in the stitching 1/16 inch from the inner folded edges.</p> <p>b. The binding shall extend the entire bottom edge, from the cutout of each front.</p> | 301 | BSc-1 | 10-14 | A | A |
| 18. | <p><u>Stitch bridle tape to lapel.</u></p> <p>a. Position the 1/4 inch wide bridle tape on the interlining side of the front along the mark for the breakline of the lapel with the front edge of the tape in line with the notch at the gorge.</p> <p>b. Stitch the tape to the breakline of the lapel, through all plies, 1/16 inch from the front and back edges, holding the tape tautly and properly distributing the fullness.</p> <p>c. The tape shall extend from the gorge notch to approximately 5 inches above the base of lapel.</p> <p>d. Press the lapels smooth and flat with a heated pressing iron or pressing machine, to remove the fullness.</p> | 301 | SSa-1 (each edge) | 10-14 | A | A |
| 19. | <p><u>Join facing to fronts.</u></p> <p>Finished appearance. The facing and fronts shall be carefully joined, uniformly stitched and shall finish smooth and flat without twists, gathers, puckers, pleats or other distortions.</p> <p>a. Position each front to their respective front facing with front gorge edges even and lapel notches matching.</p> <p>b. Seam front and facing together at the mark from the lapel notch to the</p> | 301 | SSa-1 | 10-14 | A | A |

TABLE I MANUFACTURING REQUIREMENTS

| OPN NO. | OPERATION | Stitch Type | Seam or Stitch'g | Stitches Per Inch | THREAD | |
|------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|---------------------|-------------------------|--------|------------------------|
| | | | | | Needle | Bobbin or Looper |
| 19. | <p><u>Join facing to fronts.</u> (cont'd)</p> <p>base of lapel, and from this point continue to seam 1/4 inch from front and bottom edge. The stitching at the bottom edge shall extend the width of facing.</p> <p>c. Trim point of lapels lower corner and notch for proper turning.</p> | | | | | |
| 20. | <p><u>Seam shoulders.</u></p> <p>Finished appearance. The shoulder seams to be carefully joined, uniformly stitched, and shall finish smooth and flat without twists, gathers, puckers, pleats, or raw edges.</p> <p>a. Join fronts and back at shoulder with a 3/8 inch seam, working in the fullness on the backs so that the shoulders may be properly shaped.</p> <p>b. Turn the back at the seam and top-stitch 1/8 inch from the raised edge.</p> | 301 | LSq-2 (a) | 10-14 | A | A |
| | | 301 | LSq-2 (b) | 10-14 | A | A |
| 21. | <p><u>Stitch hanger and label to jacket.</u></p> <p>Finished appearance. The size label and jacket hanger shall be properly positioned and securely stitched to the jacket.</p> <p>a. Stitch upper edge of size label and the ends of the hanger to the inside center back of jacket at the neck.</p> <p>b. In the finished jacket, the hanger opening shall be 1-1/2 to 2 inches long when measured along the lower edge of the top collar.</p> | 301 | SSa-1 | 10-14 | A | A |
| 22. | <p><u>Join collar to jacket.</u></p> <p>Finished appearance. The collar shall be carefully joined to the jacket and shall finish smooth and flat without gathers, pleats, puckers, or other distortions.</p> <p>a. Insert ends of collar between fronts and facings and seam gorge from collar notch to approximately 3/4 inch beyond the bridle tape.</p> | 301 | SSa-1 | 10-14 | A | A |

TABLE I MANUFACTURING REQUIREMENTS

| OPN NO. | OPERATION | Stitch Type | Seam or Stitch's | Stitches Per Inch | THREAD | |
|------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------|---------------------------------------------------------------------------------------------------------------|-------------------------|--------|------------------------|
| | | | | | Needle | Bobbin or Looper |
| 22. | <u>Join collar to jacket.</u> (cont'd) b. Notch all plies at the end of seam and continue to seam bottom edge of undercollar through collar interlining to front and back parts from gorge seam to gorge seam. | 301 | LSq-2 (a) | 10-14 | A | A |
| 23. | <u>Baste facing and bottom turnup.</u> a. Turn facing to the inside of the fronts, working completely to the point of lapels and the lower front corners. b. Baste the bottom turnups of the jacket, forming the curve and a point at the center back in accordance with the mark. c. The bottom turnup may be pressed and creased at the mark in lieu of basting. d. Baste along top front edges of lapels and front edges of jacket, and along the bottom edge, lapping the facing over the turnup. | 101 Or Hand 101 Or Hand | | | | |
| 24. | <u>Stitch topcollar to jacket.</u> a. Turn under lower raw edges of top collar, lapping the folded edge on the facing and on the center back. Seam top collar to jacket 1/16 inch from folded edge, from gorge notch to gorge notch. | 301 | LSb-1 | 10-14 | A | A |
| 25. | <u>Edgestitch jacket.</u> Finished appearance. The edgestitching shall be of uniform width without twisting, pleating or puckering. a. Edgestitch the jacket 1/8 inch from edge along the top and front edge of lapels and front and bottom edge of jacket, with the stitching at the bottom edge extending the width of the facing, and with the facing overlapping the bottom turnup. Continue to stitch 1/16 inch from edge along the upper bound back edge of facing up to the end of turnup, and from this point continue to stitch the entire turnup along the upper bound edge. | 301 | SSe-2 (top and front edges show finished seam) SSc-1 (bottom edge of facing) | 10-14 | A | A |

TABLE I MANUFACTURING REQUIREMENTS

| OPN NO. | OPERATION | Stitch Type | Seam or Stitch'g | Stitches Per Inch | THREAD | |
|------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|----------------------------------------------------------------------------------------|-------------------------------|--------|------------------------|
| | | | | | Needle | Bobbin or Looper |
| 25. | <u>Edgestitch jacket.</u> (cont'd) | | LSa-1 (back edge of facing) EFb-1 (upper bound edge of turnup) | | | |
| | b. Stitch facing to front at armhole 3/16 to 1/4 inch from raw edge catching the front interlining in the stitching. | 301 | SSa-1 | 10-14 | A | A |
| 26. | <u>Set shoulder straps.</u> Finished appearance. The shoulder straps shall be positioned and uniform- ly stitched to the jacket without twists, puckers, pleats, or other distortion. On the finished jacket, the straps shall measure 2-3/8 +1/8 inches wide at the armholes and shall taper to 1-3/4 +1/8 inches wide at the eyelet end of the buttonhole. a. Position the shoulder straps with the rounded end 1/4 to 3/8 inch above the lower edge of undercollar and with the back edge of the strap 3/8 to 1/2 inch back of the shoulder seam at the armhole edge. b. Seam the shoulder strap to the jacket 1/4 inch from the armhole edge, trimming the straps evenly at the armholes. | 301 | SSa-1 | 10-14 | A | A |
| 27. | <u>Make eyelet in shoulders.</u> Finished appearance. The eyelets shall be well worked with the purling on the outside and shall finish with a 1/8-inch diameter opening. All stitches shall be securely caught in the fabric. a. Mark location of eyelet in shoulders for removable button to correspond with eyelet of buttonhole in shoulder straps, so that on the finished jacket the straps shall lie smooth and flat without twist- ing or bulging. b. Make one eyelet at the mark on each shoulder through front and interlining only. | Eyelet | | 22 mini- mum per eyelet | A | A |

MIL-J-19690B(MC)

TABLE I MANUFACTURING REQUIREMENTS

| OPN NO. | OPERATION | Stitch Type | Seam or Stitch'g | Stitches Per Inch | THREAD | |
|------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|---------------------|-------------------------|--------|------------------------|
| | | | | | Needle | Bobbin or Looper |
| 28. | <u>Set sleeves.</u> | | | | | |
| | Finished appearance. The sleeves shall be carefully set without twists, pleats, or gathers and with the fullness properly distributed. | | | | | |
| | a. Position sleeves on outside of jacket at the armhole with backarm seam of sleeves matching the side back seam of jacket, and with notch in topsleeve and front matching. | | | | | |
| | b. Join the sleeves to armhole with a 3/8-inch seam, catching the armhole edge of front interlining and facing, the end of the shoulder straps and side and side back seams in the stitching. The fullness shall be distributed in accordance with good commercial practice. | 301 | SSa-1 | 10-14 | A | A |
| | c. Join sleeves to the jacket with a second row of stitches 1/8 inch from armhole edge in order that the armhole may be bound with less difficulty. | 301 | SSa-1 | 10-14 | A | A |
| | d. Press the entire armhole smooth and flat with a heated pressing iron, removing the fullness. | | | | | |
| 29. | <u>Bind armhole; bartack binding.</u> | | | | | |
| | Finished appearance. The binding shall be uniformly stitched and the basic material shall be securely caught in the stitching. The binding shall not be tight or full causing puckers, gathers, or pleats. | | | | | |
| | a. Bind the raw edges of armhole seam together with 1-1/8-inch-wide bias binding, with the edges of the binding turned under and leaving approximately 1/2 inch extension on the top end. The stitching shall be 1/16 inch from the inner folded edges of the binding. | 301 | BSc-1 | 10-14 | A | A |
| | b. Turn the top end of the binding to inside of armhole, lapping the top end on the opposite end, and secure to armhole with a 3/8-to 1/2-inch long bartack. The bartack shall be made on a line with the row of stitches for the binding and shall be stitched through | Bartack | | 28(minimum per bartack) | A | A |

TABLE I MANUFACTURING REQUIREMENTS

| OPN NO. | OPERATION | Stitch Type | Seam or Stitch's | Stitches Per Inch | THREAD | |
|------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|---------------------|--------------------------------------|--------|------------------------|
| | | | | | Needle | Bobbin or Looper |
| 29. | <u>Bind armhole; bartack binding.</u> (cont'd) all plies of material at the point of bartacking. | | | | | |
| 30. | <u>Pink sleeves.</u> Finished appearance. The sleeve ends shall be evenly and uniformly pinked, and shall be left unfinished. a. Pink the raw bottom edge of the sleeve 1/8 inch in depth, leaving the bottom of sleeve unfinished. | | | | | |
| 31. | <u>Make buttonholes.</u> Finished appearance. The buttonholes shall be clean cut, well made and correctly positioned. The stitches shall be securely caught in the basic material. The buttonholes shall be well worked over gimp to fit 27-line insignia buttons. The ends of the gimp and thread shall be pulled through to the underside of buttonholes and the ends of buttonholes securely bartacked. The purling of the buttonholes shall be on the outside of fronts. a. Mark the left and right fronts for the location of one buttonhole on each front in accordance with mark on the pattern. b. Make a horizontal, eyelet-end, square bar type buttonhole, cut 3/4 inch long, at each mark, with the purling on the buttonholes to finish on the outside of the fronts. The inside edge of the eyelet end of buttonholes shall be 5/8 inch from the front edge of jacket. c. Securely bartack the end of each buttonhole, and trim the ends of the gimp and thread. | Button- hole | | 65 per button- hole minimum | A | A |
| | | Bar- tack | | 21 (per bartack) | A | A |
| 32. | <u>Clean jacket.</u> a. Pull and remove any basting thread. Trim any ends of stitching and remove any loose ends of thread from jacket. Remove any spots, stains and shade | | | | | |

MIL-J-19690B(MC)

TABLE I MANUFACTURING REQUIREMENTS

| OPN NO. | OPERATION | Stitch Type | Seam or Stitch'g | Stitches Per Inch | THREAD | |
|------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|---------------------|-------------------------|--------|------------------------|
| | | | | | Needle | Bobbin or Looper |
| 32. | <u>Clean jacket.</u> (cont'd) tickets and markings without injury to the material. | | | | | |
| 33. | <u>Press jacket.</u> Finished appearance. The jacket shall be well pressed throughout with heated pressing irons or pressing machines of a type suitable to obtain the desired shape and appearance in accordance with good manufacturing procedures. a. Block the shoulders to remove the fullness and press shoulders smooth on a shoulder shaping machine with shoulder straps properly positioned over shoulder seam and pressed flat. b. Press entire armhole, removing the fullness. c. Block armholes on pressing buck, shrinking in the top sleeves. d. Press the sleeves smooth and flat, creasing at backarm and the forearm. The backarm crease shall be on the backarm seam. The forearm crease shall extend uniformly to a point 3 to 3-1/2 inches below the armhole. The backarm crease shall be in line with forearm crease. e. Press the lapels smooth and flat from the breakline to the front edge, straightening the edges and working the fullness towards the center of the lapel and removing the fullness by shrinking. f. Press the lapels uniformly, creasing on the lapel breakline from gorge seam to approximately midway the length of lapel and then roll press the remainder of lapel to front edge of jacket. g. Press the collar on a collar machine, creasing on the breakline and shaping to obtain the proper contour while pressing. The creased edge of collar shall be in line with the creased edge of lapels. | | | | | |

MIL-J-19690B(MC)

TABLE I MANUFACTURING REQUIREMENTS

| OPN NO. | OPERATION | Stitch Type | Seam or Stitch'g | Stitches Per Inch | THREAD | |
|------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|---------------------|-------------------------|--------|------------------------|
| | | | | | Needle | Bobbin or Looper |
| 33. | <p><u>Press jacket.</u> (cont'd)</p> <p>h. Press the fronts smooth and flat, straightening the front edges of the jacket, working the fullness towards the chest and shrinking and properly shaping the chest. Care shall be exercised in pressing the fronts so that the bottom edges are even.</p> <p>i. Press bottom edge of jacket smooth and flat.</p> <p>j. Press the sides, working the fullness towards the back.</p> <p>k. Press the back smooth and flat, removing the fullness.</p> | | | | | |
| 34. | <p><u>Attach buttons</u> (when required).</p> <p>a. When insignia buttons are required for the shoulders of the jacket, they shall be attached by inserting the shank of the button through the eyelet on the shoulders and securing on the inside with metal ring toggles.</p> <p>b. When insignia buttons are required, for front closure, they shall be attached to the jacket with the multiple link chain on the inside of jacket and one button through each buttonhole to the outside.</p> | | | | | |

MIL-J-19690B(MC)

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

Table II - Finished measurements ^{1/}

| Size | Back length (inches) ^{2/} | Sleeve length (inches) ^{3/} |
|------|---------------------------------------|-----------------------------------------|
| 34 | 20-1/2 | 20-1/2 |
| 36 | 20-3/4 | 20-1/2 |
| 38 | 21 | 20-1/2 |
| 40 | 21-1/4 | 20-1/2 |
| 42 | 21-1/2 | 20-1/2 |
| 44 | 21-5/8 | 20-1/2 |

^{1/} Tolerance: $\pm 3/8$ inch.

^{2/} The back length measurement shall be taken along center back seam from lower edge of under collar to lower edge of back.

^{3/} Sleeve length measurement shall be taken along forearm seam from pit of armhole to the pinked end of sleeves.

***3.8 Workmanship.** The finished jackets shall conform to the quality and grade of product established by this specification. The occurrence of defects shall not exceed the levels set by the applicable acceptable quality levels (AQL's).

4. QUALITY ASSURANCE PROVISIONS

***4.1 Responsibility for inspection.** Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the supplier may use his own or any other facilities suitable for the performance of the inspection requirements specified herein unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

***4.2 Inspection.** Inspection shall be in accordance with the provisions set forth in MIL-STD-105, except where otherwise indicated herein.

***4.2.1 First article inspection.** When first article is required, inspection shall be performed on a completely fabricated jacket for conformance to all provisions of this specification.

***4.2.2 Component and material inspection.** In accordance with 4.1 above, components and materials shall be tested in accordance with all the requirements of referenced specifications, figures and standards unless otherwise excluded, amended, modified or qualified in this specification or applicable purchase document.

***4.2.2.1 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 specified requirements for operations or subassemblies.

MIL-J-19690B(MC)

*4.2.3 Examination of end item. The end item shall be examined for defects listed in 4.2.3.1, 4.2.3.2 and 4.2.3.3. The sample unit shall be one jacket.

*4.2.3.1 General defects. General defects shall be classified as follows:

| Examine | Defect | Classification | |
|------------------------------|--------------------------------------------------------------------------------------------------------------------|----------------|--------------|
| | | Major | Minor A B |
| Material defects and damages | a. Any hole or weakening defect such as smash, multiple float, loose slub, etc. that may develop into a hole. | X | |
| | b. Shade bar, unsightly slub, etc. on outside. | X | |
| | c. Scissor or knife cut, tear, mend, burn, large exposed drill hole or needle chews which may develop into a hole. | X | |

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 effect on serviceability are to be classified as follows:

| | | | |
|--------------------------------------|-------------------------------------------------------------------------------------------------------|---|---|
| Material defects - No defect | | | |
| Workmanship damages - Minor B defect | | | |
| Shaded parts | a. Any outside part badly shaded. | X | |
| | b. Parts permitted to be cut from ends badly shaded. | | X |
| Cleanness | a. One or more ink spots or stains of an obvious permanent nature. | X | |
| | b. One or more removable spots or stains clearly noticeable. | | X |
| | c. Thread ends not trimmed or loose threads or shade tickets, if used, not removed throughout jacket. | | X |

MIL-J-19690B (MC)

| Examine | Defect | Classification | |
|------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|--------------|
| | | Major | Minor A B |
| | d. Shade markings of an obvious permanent nature exposed on outside of jacket (to be scored only when so conspicuously located as to be clearly noticeable). | X | |
| Component and assembly | a. Any defective component. | X | |
| | b. Any component not as specified. | X | |
| | c. Any component part omitted. | X | |
| Cutting | Any component part of basic material not cut in accordance with specification requirements. | | X |
| Pressing | a. Burned or scorched. | X | |
| | b. Pressing omitted (entire garment). | | X |
| | c. Poorly pressed (unless otherwise specified). | | X |
| Seams and stitching | a. Accuracy of seaming: | | |
| | 1. Seams twisted, puckered or pleated, affecting appearance (unless otherwise classified). | | X |
| | 2. Part of garment caught in any unrelated operation or stitching. | | X |
| | 3. Thread breaks or ends of all stitching (when not caught in other seams or stitchings) not securely backstitched. | | X |
| | b. Gage of stitching (edge or raise stitching): | | |
| | 1. Irregular, i.e., unevenly gaged, or various stitching not uniform, affecting appearance. | | X |
| | 2. Beyond range of width specified or varies more than 1/16 inch when no range is specified. | | X |
| | 3. Edge or raise stitching sewn too close to edge, resulting in damage to cloth. | X | |

| Examine | Defect | Classification | |
|---------|--------|----------------|-------|
| | | Major | Minor |
| | | A | B |

c. Open seams:

- 1/8 inch or more but not more than 1/4 inch. X
- more than 1/4 inch but not more than 1 inch. X
- more than 1 inch. X

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

d. Raw edges:

1. On outside:
 - more than 1/8 inch but not more than 1/4 inch. X
 - more than 1/4 inch but not more than 1 inch. X
 - more than 1 inch. X
2. On inside:
 - more than 1/2 inch but not more than 1 inch. X
 - more than 1 inch. X

NOTE: Raw edges not securely caught in stitching shall be classified as an open seam. Raw edge is classified as such only when it occurs at places where edge is required to be turned under.

e. Run-offs (see classification of open seams).

- f. Seam and stitch type:
Wrong seam or stitch type. X

g. Stitch tension:

1. Loose tension, resulting in a loose seam. X
2. Loose tension on edge or raise stitching, resulting in loosely exposed bobbin thread or top thread. X
3. Tight tension (stitches break when normal strain is applied to seam or stitching). X

MIL J-19690B (MC)

| Examine | Defect | Classification | |
|---------|--------|----------------|-------|
| | | Major | Minor |
| | | A | B |

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

h. Stitches per inch:

- | | | |
|---------------------------|---|---|
| 1. Less than minimum. | X | |
| 2. More than the maximum. | | X |

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

| | | | |
|----------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---|--------|
| Buttonholes and eyelets (construction) | 1. Stitches skipped or broken (on edge or raise stitching, when seam is seamed, turned and stitched); -more than 1/4 inch but not more than 3/4 inch. -more than 3/4 inch. | | X |
| | a. Wrong type buttonhole or eyelet. | X | |
| | b. Inside diameter of eyelets less than 1/8 inch or more than 3/16 inch. | | X |
| | c. Buttonhole or eyelet not securely caught on fabric, causing stitching to pull away from fabric. | X | |
| | d. Buttonholes not corresponding to size of buttons, so that they do not button properly. | X | |
| | e. Bartack omitted or loose on 1 or more buttonholes; -front buttonhole. -shoulder loops. | | X X |
| | f. Bartack misplaced; -on 1 buttonhole. -2 or more buttonholes. | | X X |
| | g. Gimp omitted in one or more buttonholes. | | X |
| | h. Ragged edges, affecting appearance. | | X |
| | i. Constructed with purling on the reverse side. | | X |

| Examine | Defect | Classification | |
|----------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------|----------------|--------------|
| | | Major | Minor A B |
| | j. One or more broken stitches in one or more buttonholes. | | X |
| | k. Two or more skipped stitches in one or more buttonholes. | | X |
| Metal buttons, toggles, and front button links (when required) | Missing, or any part of button assembly defective; not specified type, size or finish; one button two or more buttons. | | X X |

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 shank or shell, or poorly plated or badly shaded. Toggles and links shall be considered defective if they have sharp, cracked or split edges.

*4.2.3.2 Detailed defects applicable to specific parts (outside of jacket). Detailed defects applicable to specific parts on outside of jacket shall be classified as follows:

| Examine | Defect | Classification | |
|-----------------------------------|-----------------------------------------------------------------------------------------------------------------|----------------|--------------|
| | | Major | Minor A B |
| Collar (construction and setting) | a. Top or undercollar puckered or pleated at joining seam to lapel(s), front(s), or back, affecting appearance. | | X |
| | b. Excessive fullness or puckers in topcollar, affecting appearance. | | X |
| | c. Ends poorly shaped, or not uniform in shape, affecting appearance. | | X |
| | d. Collar edge curled, caused by tight topcollar, affecting appearance. | | X |
| | e. Collar edge not properly forced out. | | X |
| | f. Undercollar not topstitched to interlining along foldline of undercollar. | | X |
| | g. Collar ends not securely caught in seaming at lapel notches. | | X |
| | h. Collar off center by 1/4 inch or more at front ends, with shoulder seams matched. | | X |

MIL-J-19690B(MC)

| Examine | Defect | Classification | |
|---------|-----------------------------------------------------------------------------------------------------------------------------------------|----------------|--------------|
| | | Major | Minor A B |
| Lapels | i. Ends of collar less than 1-1/8 inches or more than 1-3/8 inches wide. | | X |
| | j. Width of collar at center less than 2-3/4 inches or more than 3 inches. | | X |
| | a. Poorly shaped or not uniform in shape, affecting appearance. | | X |
| | b. Facing twisted or full, affecting appearance. | | X |
| | c. Lapel edge curled, caused by a short or tight facing. | | X |
| | d. Corner or edge of step and lapel not properly forced out or front exposed along edge. | | X |
| Fronts | e. Length of lapel step less than 1-1/4 inches or more than 1-1/2 inches. | | X |
| | f. Width of lapels less than 2-3/4 inches or more than 3-1/4 inches (measured from the crease line straight across to the lapel point). | | X |
| | a. Length of fronts uneven by: -1/4 inch but not more than 1/2 inch, -more than 1/2 inch. | X | X |
| | b. Front darts: -left and right darts uneven in length by more than 1/2 inch. | | X |
| | c. Front buttonholes: | | |
| | 1. Less than 7 inches or more than 8 inches from bottom corner of fronts. | | X |
| | 2. At unequal distance from bottom corners by: -more than 1/4 inch but not more than 1/2 inch. -more than 1/2 inch. | X | X |

| Examine | Defect | Classification | |
|-----------------|---------------------------------------------------------------------------------------------------------------------|----------------|--------------|
| | | Major | Minor A B |
| Shoulder straps | 3. Positioned less than 1/2 inch or more than 3/4 inch from front edge. | | X |
| | a. Misplaced so that they will not lie flat when buttoned, causing a bulge or twist on strap, affecting appearance. | | X |
| | b. Short, i.e., rounded ends of straps extending under collar edge less than 5/8 inch. | | X |
| | c. Long, i.e., rounded end extending beyond collar creaseline. | | X |
| | d. Width at each end not as specified. | | X |
| | e. Edge of shoulder button less than 1/4 inch or more than 3/8 inch from collar edge. | | X |
| | f. Shoulder strap buttonhole: | | |
| | 1. Off-center of the width of strap by 1/4 inch or more. | | X |
| | 2. Buttonhole finished with purling on the underside. | | X |
| Sleeves | a. Reversed, i.e., left sleeve in right armhole, right sleeve in left armhole. | X | |
| | b. Tight at armhole, causing puckers or pleats on front and back, affecting appearance. | | X |
| | c. Ends of backarm seams not matching with the ends of the back seams. | | X |
| | d. Sleeve ends not pinked. | | X |
| Bottom hem | a. Less than 1-1/8 inches or more than 1-3/8 inches wide. | | X |
| | b. Fold at center back of jacket omitted or not properly formed. | | X |

MIL-J-19690B(MC)

| Examine | Defect | Classification | |
|-----------------------------------------------------|-------------------------------------------|----------------|--------------|
| | | Major | Minor A B |
| Jacket hanger | a. Omitted or ends not securely stitched. | | X |
| | b. Length more or less than specified. | | X |
| Size label | a. Omitted, incorrect, or illegible. | X | |
| Identification - instruction label (combined) | a. Omitted, incorrect, or illegible. | | X |
| | b. Not stitched on four sides. | | X |

***4.2.3.3 Finished measurements.** Any measurement deviating from the nominal dimensions and tolerance specified 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.

4.2.3.4 Inspection levels and AQL's. Inspection levels and AQL's expressed in defects per 100 units (DHU) shall be as follows:

4.2.3.1 and 4.2.3.2

Inspection Level III of MIL-STD-105

| | |
|------------------------------------------------|----------|
| AQL's Major | 1.5 DHU |
| Major and Minor A (combined) | 10.0 DHU |
| Total Major, Minor A and Minor B (combined) | 40.0 DHU |

4.2.3.3

Inspection Level S-3 of MIL-STD-105

| | |
|-----------|---------|
| One class | 4.0 DHU |
|-----------|---------|

***4.2.4 Examination of preparation for delivery requirements.** An examination shall be made to determine compliance with packaging, packing and marking requirements of Section 5 of this specification. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully packed, selected just prior to closing operation. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot size shall be the number of shipping containers in the inspection lot. The inspection lot shall be S-2 and the AQL shall be 2.5 DHU.

| <u>Examine</u> | <u>Defect</u> |
|---------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Marking (exterior and interior) | Omitted; incorrect; illegible; of improper size, location, sequence or method of application. |
| Materials | Any component missing. Any component damaged, affecting serviceability. |
| Workmanship | Inadequate application of components, such as incomplete closure of case liners, container flaps, loose strapping, inadequate stapling, Bulging or distortion of containers. |
| Content | Number of jackets per shipping container is more or less than required. Improper number of intermediate packages per container. For this defect, one intermediate package from each container in the sample shall be examined. |

5. PREPARATION FOR DELIVERY

5.1 Packaging. Packaging shall be level A or C, as specified (see 6.2).

*5.1.1 Level A. Each jacket, in the buttoned position, shall be folded to approximately 12 by 11 inches and placed in individual polyethylene bags measuring 18 by 12 inches with a 1-inch lip along the 12-inch dimension. The polyethylene flexible film shall be 0.0015 inch thick. Prior to or during the final heat sealing operation, excess air within the bag shall be expelled. Each bag shall contain a label (see 5.3).

*5.1.2 Level C. Jackets shall be packaged in accordance with the manufacturers' commercial practice.

5.2 Packing. Packing shall be level A, B, or C, as specified (see 6.2).

5.2.1 Level A.

*5.2.1.1 Method 1. Twenty-five (25) jackets of one size only, packaged as specified in 5.1, shall be packed in a fiberboard shipping container with liner, conforming to class weather resistant, grade V2s, size 3A of MIL-B-17757. The fiberboard used for fabricating the liner shall be grade V3c. Each shipping container shall be assembled, closed, and reinforced as specified in the appendix thereto. Towards the end of the contract, or when there is less than the required amount per container of the same size, mixed sizes may be packed within the same shipping container.

*5.2.1.2 Method 2. When specified (see 6.2), three level B shipping containers (75 jackets of one size only), shall be packed in a fiberboard shipping container conforming to class weather resistant, size No. 4 of MIL-B-17757 assembled, closed, and reinforced as specified in the appendix thereto. Towards the end of the contract, or when there is less than the amount per container of the same size, mixed sizes may be packed within the same shipping container.

MIL-J-19690B (MC)

*5.2.2 Level B. Twenty-five (25) jackets of one size only, packaged as specified in 5.1, shall be packed in a fiberboard shipping container with liner conforming to class domestic, size 3A of MIL-B-17757. The fiberboard used for fabricating the container and the liner shall be grade 275. Each shipping container shall be assembled and closed as specified in the appendix thereto. Towards the end of the contract, or when there is less than the required amount per container of the same size, mixed sizes may be packed within the same shipping container.

5.2.3 Level C. Jackets, folded as specified in 5.1, shall be packed in a manner to insure carrier acceptance and safe delivery at destination. Containers shall be in accordance with Uniform Freight Classification Rules or regulations of other carriers applicable to the mode of transportation.

*5.3 Marking. In addition to any special marking required by the contract or order, shipping containers shall be marked in accordance with the requirements of MIL-STD-129. A white paper label with the following information legibly printed or stamped thereon in black shall be inserted within each polyethylene bag in order to permit ready identification:

Nomenclature

Size _____ Stock number _____

Contract number

Name of contractor

5.3.1 Mixed sizes. Each shipping container packed with mixed sizes shall have securely attached to the end and side, directly under the printing or stenciling, a white paper label 5 by 4 inches with the words "MIXED SIZES" plainly stamped or printed thereon and under these words shall be legibly printed the correct quantity and sizes contained therein.

6. NOTES

*6.1 Intended use. The jackets described herein are intended for wear only by those stewards on special assignments as authorized by the Commandant of the Marine Corps. The jacket is to be worn with trousers conforming to class 4, style b of MIL-T-82163.

*6.2 Ordering data. Purchasers should exercise any desired options offered herein, and procurement documents should specify the following:

*6.2.1 Procurement requirements.

- (a) Title, number and date of this specification.
- (b) Sizes required (see 1.2).
- (c) Whether first article is required (see 3.2).
- (d) Number of jackets in first article (see 3.2).
- (e) Whether buttons are required (see 3.3.6).
- (f) Selection of applicable levels of packaging and packing (see 5.1 and 5.2).
- (g) When level A, method 2, packing is required (see 5.2.1.2).

MIL-J-19690B(MC)

***6.2.2 Contract data requirements.** Data conforming to Data Item Descriptions. DI-R-4803, DI-R-4805, DI-T-4901, DI-T-4902, DI-T-4903 and DI-T-4904 will usually be required for delivery in connection with this specification. When so required, such data will be specified for delivery on a DD Form 1423 included in the contract.

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

***6.4 First article.** Examination, test and approval shall be as specified by the contracting officer (see 3.2).

***6.5 Marginal notations.** The margins of this specification are marked with an asterisk to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship of the last previous issue.

Preparing activity:
Navy - MC
Project No. 8405-N469

MIL-J-19690B(MC)

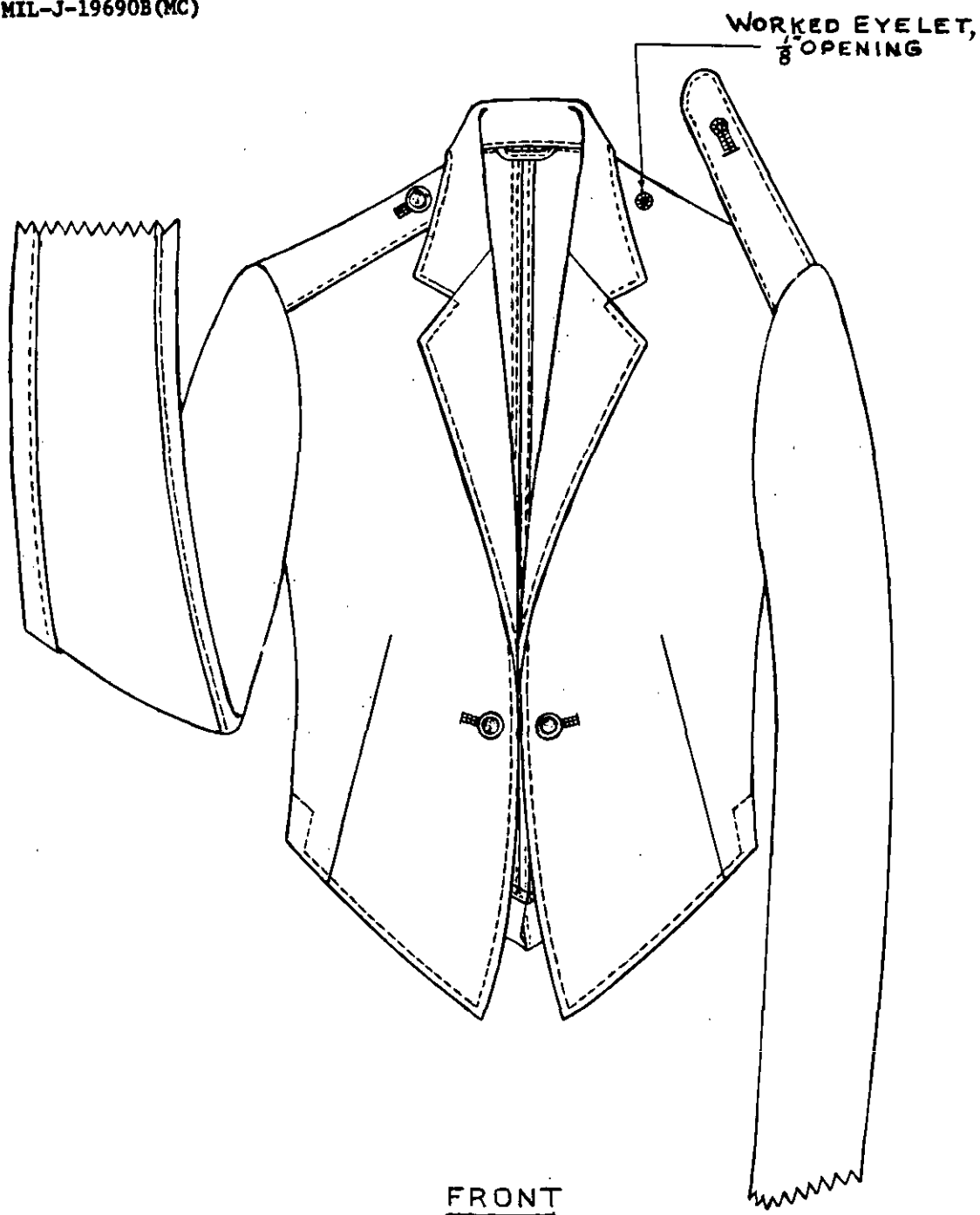


Figure 1. Jacket, Man's: Cotton and Polyester Twill, White

M.C.S.A.
826:R.G.F.
30 Jul '71

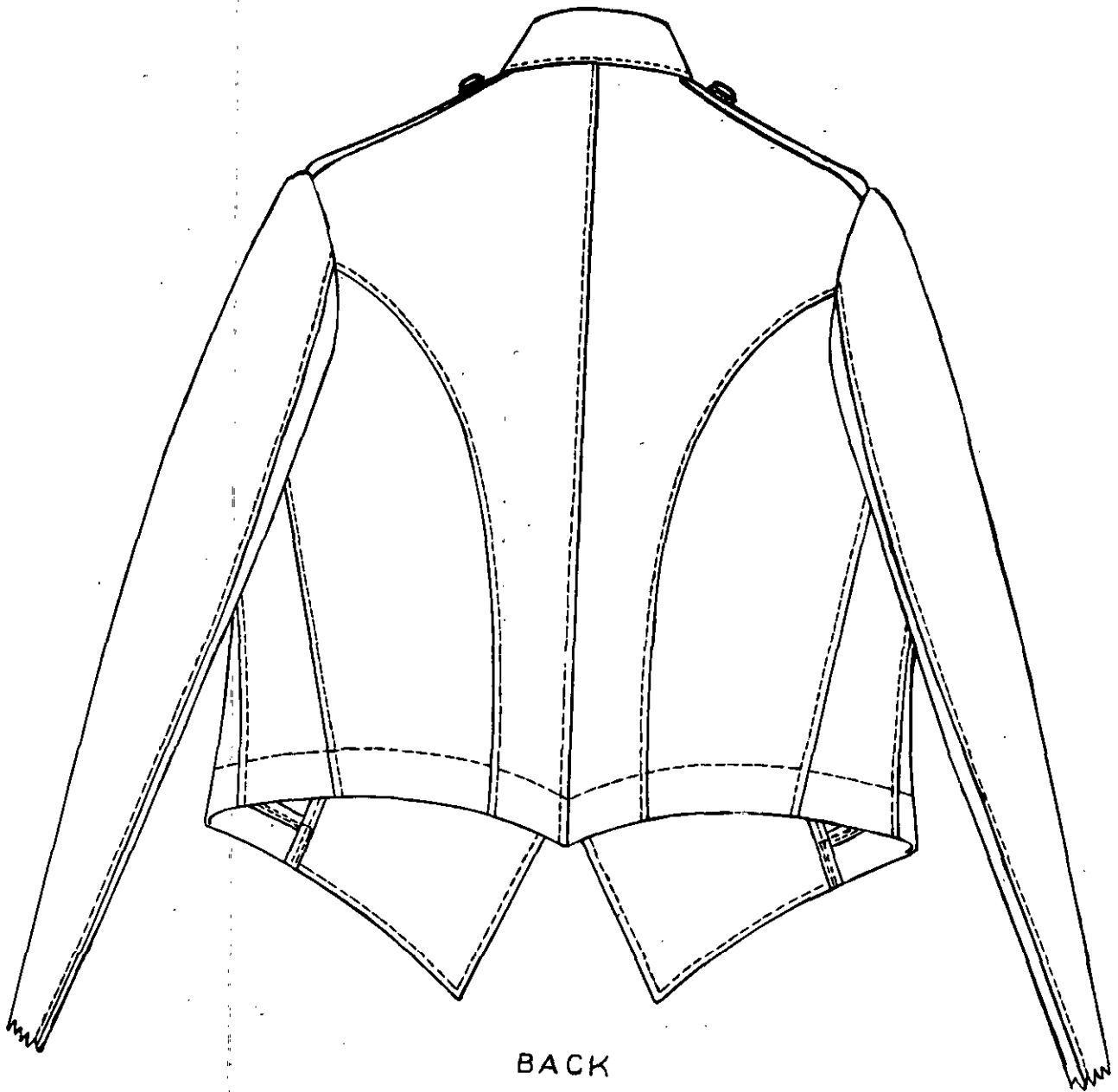


Figure 2. Jacket, Man's: Cotton and Polyester Twill, White

M.C.S.A.
826/R.G.F.
30 Jul 71

MIL-J-19690B(MC)

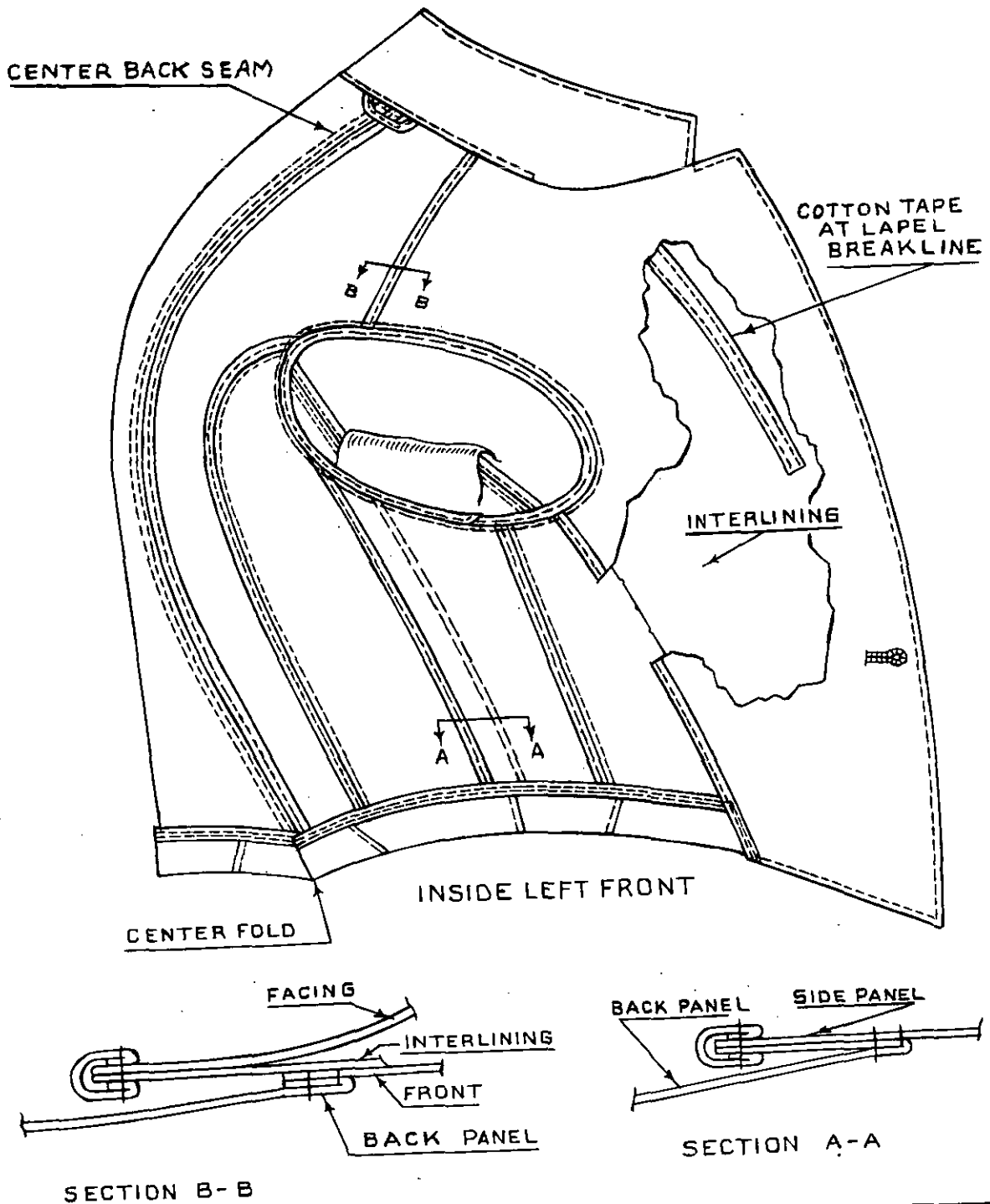


Figure 3. Jacket, Man's: Cotton and Polyester Twill, White

M.C.S.A.
826:R.G.F.
30 Jul '71

FOLD

POSTAGE AND FEES PAID

OFFICIAL BUSINESS

Commanding General (826)
Marine Corps Supply Activity
1100 South Broad Street
Philadelphia, Pennsylvania 19146

FOLD

SPECIFICATION ANALYSIS SHEET

Form Approved
Budget Bureau No. 22-R255

INSTRUCTIONS: This sheet is to be filled out by personnel, either Government or contractor, involved in the use of the specification in procurement of products for ultimate use by the Department of Defense. This sheet is provided for obtaining information on the use of this specification which will insure that suitable products can be procured with a minimum amount of delay and at the least cost. Comments and the return of this form will be appreciated. Fold on lines on reverse side, staple in corner, and send to preparing activity. Comments and suggestions submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or serve to amend contractual requirements.

SPECIFICATION

ORGANIZATION

CITY AND STATE

CONTRACT NUMBER

MATERIAL PROCURED UNDER A

☐ DIRECT GOVERNMENT CONTRACT ☐ SUBCONTRACT

1. HAS ANY PART OF THE SPECIFICATION CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE?

A. GIVE PARAGRAPH NUMBER AND WORDING.

B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES

2. COMMENTS ON ANY SPECIFICATION REQUIREMENT CONSIDERED TOO RIGID

3. IS THE SPECIFICATION RESTRICTIVE?

☐ YES ☐ NO (If "yes", in what way?)

4. REMARKS (Attach any pertinent data which may be of use in improving this specification. If there are additional papers, attach to form and place both in an envelope addressed to preparing activity)

SUBMITTED BY (Printed or typed name and activity - Optional)

DATE

DD FORM 1426
1 JAN 66

REPLACES EDITION OF 1 OCT 64 WHICH MAY BE USED.

S/N-0102-014-1801

C-25254