

MIL-J-21708G

1 July 1987

SUPERSEDING

MIL-J-21708F

28 October 1985

MILITARY SPECIFICATION

JACKET, COLD WEATHER

1. SCOPE

1.1 Scope. This specification covers the requirements for lined cold weather jacket.

1.2 Classification. The jacket shall be of the following types, classes and sizes (see 6.2):

1.2.1 Type I - Men's.Sizes

Small (34-36)	Medium (38-40)	Large (42-44)
X-Large (46-48)	XX-Large (50-52)	

1.2.2 Type II - Women's.Sizes

Small (33-35)	Medium (37-39)	Large (41-43)
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1.2.3 Classes.

Class 1 - Blue 3375, Flame Retardant Plain Weave

Class 2 - Green OG-107, Cotton/Nylon Sateen

2. APPLICABLE DOCUMENTS

2.1 Government documents.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Officer in Charge, Navy Clothing and Textile Research Facility, 21 Strathmore Road, Natick, MA 01760-2490 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8415

DISTRIBUTION STATEMENT A.

Approved for public release; distribution is unlimited.

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2.1.1 Specifications, standards, and handbooks. Unless otherwise specified, the following specifications, standards, and handbooks of the issue listed in that issue of the Department of Defense Index of Specifications and Standards (DoDISS) specified in the solicitation form a part of this specification to the extent specified.

SPECIFICATIONS

FEDERAL

- V-F-106 - Fasteners, Slide, Interlocking
 NN-P-71 - Pallet, Material Handling, Wood Stringer Construction 2 Way and 4 Way Entry (Partial)
- DDD-L-20 - Label, For Clothing, Equipage and Tentage (General Use)

MILITARY

- MIL-C-297 - Cloth, Interlining, Cotton Warp, and Spun Hair-wool Filling
 MIL-E-480 - Enamel, Baking, Phenol-or Urea-Formaldehyde
 MIL-W-530 - Webbing, Textile, Cotton, General Purpose, Natural or in Colors
 MIL-B-543 - Buckle, Tongueless and Web Strap
 MIL-T-3530 - Thread and Twine, Mildew Resistant or Water Repellent Treated
 MIL-C-3735 - Cuffs, Knit, Wrist and Ankle, and Cloth, Knitted
 MIL-P-15011 - Pallet, Material Handling, Wood, Post Construction, 4 Way Entry
 MIL-C-17155 - Cloth, Knitted, Nylon Fleece
 MIL-B-17757 - Boxes, Shipping Fiberboard (Modular Sizes)
 MIL-F-21840 - Fastener Tapes, Hook and Pile, Synthetic
 MIL-C-24931 - Cloth, Plain Weave, Aramid, Water Repellent
 MIL-C-24932 - Cloth, Knitted, Flame Resistant, Rayon/Wool Pile
 MIL-C-43191 - Cloth, Wind Resistant, Sateen, Cotton and Nylon
 MIL-T-43548 - Thread, Polyester Core: Cotton-, Rayon-, or Polyester-covered
 MIL-T-83193 - Thread, Aramid, Spun Staple

STANDARDS

FEDERAL

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

MILITARY

- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
 MIL-STD-147 - Palletized Unit Loads
 MIL-STD-129 - Marking for Shipment and Storage

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

2.1.2 Other Government documents, drawings, and publications. The following other Government documents, drawings, and publications form a part of this specification to the extent specified herein.

LAWS AND REGULATIONS

U.S. POSTAL SERVICE MANUAL

(Copies of the manual may be obtained from the Superintendent of Documents, US Government Printing Office, Washington, DC 20402.)

2.2 Other publications. The following document(s) form a part of this specification to the extent specified herein. Unless otherwise specified, the issue of documents which are DOD adopted shall be those listed in the issue of the DODISS specified in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS shall be the issue of the nongovernment documents which is current on the date of the solicitation.

NATIONAL MOTOR FREIGHT TRAFFIC ASSOCIATION, INC., AGENT

National Motor Freight Classification

(Applications for copies should be addressed to the American Trucking Association, ATTN: Traffic Department, 1616 P Street, N.W., Washington, DC 20036).

UNIFORM CLASSIFICATION COMMITTEE, AGENT

Uniform Freight Classification

(Application for copies should be addressed to the Uniform Classification Committee, Room 1106, 222 South Riverside Plaza, Chicago, Illinois 60606).

THE COLOR ASSOCIATION OF THE UNITED STATES, INC.

Standard Shade for Thread - 1968

(Application for copies of color cards should be addressed to the Color Association of the U.S. Inc., 343 Lexington Avenue, New York, NY 10016).

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

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3. REQUIREMENTS

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

3.2 First article. When specified, the contractor shall furnish sample unit(s) for first article inspection and approval (see 4.3 and 6.2).

3.3 Materials.3.3.1 Basic material.

3.3.1.1 Class 1. The basic material for the class 1 jacket shall be aramid plain weave, water repellent fabric conforming to MIL-C-24931. The color shall be shade blue 3375.

3.3.1.2 Class 2. The basic material for the class 2 jacket shall be cotton/nylon sateen with a fluorocarbon type water repellent treatment, conforming to class 2 of MIL-C-43191, except that the requirements for infrared reflectance shall not apply. The color shall be shade green OG-107, piece number 3125.

3.3.2 Lining.

3.3.2.1 Class 1. The lining material for the class 1 jacket shall be flame resistant rayon/wool knitted pile fabric conforming to MIL-C-24932. The color shall be shade blue 3375.

3.3.2.2 Class 2. The lining material for the class 2 jacket shall be knitted nylon fleece conforming to type I or MIL-C-17155.

3.3.3 Interlining. The interlining for the collar shall be cotton warp and spun hair-wool filling, conforming to type I or type II of MIL-C-297.

3.3.4 Binding. The material for binding the underarm vent in the lining shall be made from basic material specified in 3.3.1. The binding shall be bias cut on a 45 (+ 5) degree angle in strips of 1-1/8 (+ 1/8) inches wide. The ends of the strips shall be joined by seam type SSa-1 and stitch 301 with 10 to 12 stitches per inch. The seams shall finish 1/8 to 3/16 inch wide and shall be spread open.

3.3.5 Webbing. The material for the waist adjustment (take-up) straps shall be cotton, type IIa, class 3, 3/4 inch wide conforming to MIL-W-530. The color shall approximate the shade of the basic material.

3.3.6 Cuffs, Wrist. The material for the class 1 jacket wrist cuffs shall be aramid knitted, conforming to type IV, class 2, size 1 of MIL-C-3735. The color shall match the basic material. The wrist cuffs for the class 2 jacket shall be Wool knitted, OD conforming to type I, class 2, size 1 of MIL-C-3735, except the requirements for dry cleaning and shrink resistant treatment shall not apply.

3.3.7 Thread.

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3.3.7.1 Class 1. The thread for the class 1 jacket shall be an aramid thread, conforming to MIL-T-83193. As an alternate, a para-aramid, spun staple thread, size 35 Tex may be used. The color of the thread shall approximate shade Blue, A.R., G.A. 66058. The thread shall meet commercially acceptable colorfastness requirements for aramid thread.

3.3.7.2 Class 2. The thread for the class 2 jacket for seaming, stitching, bartacks and buttonholes shall be polyester core covered thread conforming to ticket Nos. 30 and 50, 2 or 3 ply of MIL-T-43548. The thread shall be water repellent treated to conform with Type II, class 3 of MIL-T-3530. The color shall conform to shade Olive Drab S-1, C.A. 66022 of the Standard Shade for Thread. The polyester core, polyester covered thread is not allowed.

3.3.7.3 Colorfastness. The dyed thread shall show colorfastness to laundering equal to or better than the standard sample when tested as specified in MIL-T-43548. When no standard sample is available, the dyed thread shall show a minimum of "good" colorfastness to laundering when tested as specified in MIL-T-43548.

3.3.8 Hook and pile fastener tape. The hook and pile fastener tapes shall conform to type II, class 1, 1 inch wide of MIL-F-21840. The color shall match shade Blue 3364 for the class 1 jacket and shade green OG 106 for the class 2 jacket.

3.3.9 Labels. Each jacket shall have a combination identification /instruction label and a size label conforming to the requirements of 3.3.9.1 and 3.3.9.2. The printing shall show fastness to laundering.

3.3.9.1 Combination label. The combination label shall conform to type VI, class 15 of DDD-L-20, and shall bear the following inscription and format for the class 1 jacket:

JACKET, COLD WEATHER, FLAME RESISTANT, CLASS 1 (EXAMPLE)
 FIBER CONTENT: SHELL 100% ARAMID
 LINING 65% RAYON/ 35% WOOL PILE /
 100% ARAMID BACK
 CONTRACT NO.: DLA-100-00-0-0000 (EXAMPLE)
 NAME OF CONTRACTOR:

LAUNDERING INSTRUCTION

1. Wash in hot water (120° - 140° F) using detergent.
2. Rinse thoroughly 2 or 3 times in hot water. Tumble dry.
3. DO NOT USE STARCH OR BLEACH. DO NOT DRY CLEAN.

OR

Follow NAVEDTRA Manual
 414-01-45-81
 Formula II

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The following inscription and format shall be for the class 2 jacket:

JACKET, COLD WEATHER, CLASS 2 (EXAMPLE)
 FIBER CONTENT: SHELL - 50% COTTON/50% NYLON
 LINING - 100% NYLON
 CONTRACT NO.: DLA-100-00-0-0000 (EXAMPLE)
 NAME OF CONTRACTOR:

Note. The laundering instructions shall be the same as the class 1 jacket.

3.3.9.2 Size label. The size label shall conform to Type VI, Class 2 of DDD-L-20, and shall bear the following inscription.

SIZE. MEDIUM (38-40) (EXAMPLE)
 STOCK NUMBER 8415-00-000-0000 (EXAMPLE)

3.3.10 Buckle. The buckle for the waist adjustment (take-up) straps shall be type II, class 1, style 4, construction A or B, size 3/4 inch conforming to MIL-B-543, except that the buckle shall have baked-on enamel finish conforming to type I or type II of MIL-E-480 (see 4.4.1). The color of the enamel shall approximate the shade of the basic material.

3.3.11 Slide fastener. The slide fastener for the front closure shall conform to type IV, style 8, size M, short tab pull of V-F-106, except that all metal components of the slide fastener shall be fabricated of brass and purchased from the same supplier (see 4.4.1).

3.3.11.1 Tape and thong for slide fastener. The tape for slide fastener shall be cotton or synthetic or a combination. The top extension beyond scoops shall be 1-3/8 inches minimum. The thong shall be as specified in V-F-106, except that the finished length of the thong after assembly shall be 4-1/2 (+ 1/2) inches and the thongs shall be made of basic material. Both tapes shall approximate the shade of the basic material and show good fastness to laundering as specified in V-F-106.

3.3.12 Length of slide fastener. The length of the slide fastener for Type I small (34-36) and medium (38-40), and type II, all sizes shall be 20 (+ 1/4) inches. For Type I large (42-44), X-large (46-48) and XX-large (50-52) the slide fastener shall be 21 (+ 1/4) inches.

3.4 Design. The class 1 jacket shall be made of water repellent, flame resistant fabric and lined with a knitted flame resistant rayon/wool pile fabric. It shall have a front slide fastener and hook and pile front closure, a quilted interlined collar with a throat tab, welted slash pockets, a left patch pocket with hook and pile fastener closure flap, one piece sleeve, aramid knitted wristlet, and adjustable take-up straps on the sides. The class 2 jacket shall be of the same design except that the material shall be a water repellent, wind resistant cotton/nylon sateen cloth and lined with a nylon knitted fleece. (see Figures 1 and 2)

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3.4.1 Figures. The figures are furnished for information purposes only. In the event of any inconsistencies between the specification and the figures, the specification shall govern.

3.5 Patterns. Standard patterns to be used to cut working patterns will be furnished by the government (see 6.3). The patterns allow 1/2 inch for all double lapped and double stitched seams and 1/2 inch for lining seams, except as otherwise indicated in Table I. The working patterns shall be identical to the Government patterns. Neither the Government patterns nor the working patterns shall be altered in any way.

3.5.1 List of pattern parts. The component parts for the type I and type II jackets shall be cut from the material as specified and in accordance with the pattern parts required for the manufacturing process as follows:

<u>Materials</u>	<u>Nomenclature of pattern parts</u>	<u>Cut parts</u>
Cloth, basic material	Front, left side	1
	Front, right side	1
	Back	1
	Sleeve	2
	Wristlet stand	2
	Facing, left side	1
	Facing, right side	1
	Topcollar	1
	Undercollar	1
	Left breast patch pocket	1
	Left breast pocket flap	1
	Pocket with welt, outer ply <u>1/</u>	2
	Pocket, inner ply	2
	Throat flap	2
Cloth, lining material	Front lining	2
	Back lining	1
	Sleeve lining	2
Cloth, cotton warp and spun hair-wool filling, interlining	Collar, interlining	1
Template	Left front patch pocket	-

1/ A separate pocket and welt pattern piece is supplied for use with the automatic welt machine.

NOTE: Pattern part for jacket hanger is not provided, cut in accordance with table I, operation 9.

3.6 Construction.

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3.6.1 Stitches, seams, and stitchings. Stitch, seam and stitching types specified in Table I shall conform to FED-STD-751. Whenever two or more methods for seam or stitch types are given for the same part of the operation, any one may be used. Seam allowance shall be maintained with seams sewn so that no raw edges, runoffs, twists, pleats, puckers or open seams result. All seams shall start and finish evenly. Thread tension shall be maintained so that there is no tight or loose stitching. Where stitch type 401 is used, the looper (underthread) shall finish between the jacket and the liner. Double lapped seams (LSc-2) shall be double stitched 1/4 to 5/16 inch gauge with the outer row of stitching 1/16 to 1/8 inch from the folded edge.

3.6.2 Thread breaks and ends of seams. Ends of all seams and stitchings when not caught in other seams or stitchings shall be backtacked not less than 3/8 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 required by stitching back of break not less than 1/2 inch. Skipped stitches or thread breaks (401 stitch types) may be repaired by using 301 stitch type. When ends of overedge stitching are not caught in other seams or stitching, the ends shall be tacked.

3.6.3 Stitches per inch. The minimum and maximum number of stitches per inch shall be as specified in Table I.

3.7 Construction. The pocket shall be constructed in accordance with all operations shown in Table I. The contractor is not required to follow the exact sequence of operations as listed, provided the finished jacket is identical to that produced by following the exact sequence as shown in Table I. Unless otherwise indicated, all operations apply to Type I and Type II jackets.

3.7.1 Abbreviations in table of operations. The abbreviations used in Table I are as follows:

Stch	-	Stitch
in	-	inch
Ndl	-	Needle
Bob	-	Bobbin
Lpr	-	Looper
Mchne	-	Machine
Brck	-	Bartack
Comrcl	-	Commercial
smlr	-	similar
Btnhl	-	Buttonhole
incl	-	including
dbl	-	double

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TABLE I CONSTRUCTION OF JACKETS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL BOB/ LPR	
1.	<u>Cutting</u>					
	a. Cut the jacket in strict accordance with the patterns furnished, which show size, shape, warp directional lines, notches and other marks for proper assembly of all parts.					
	b. The pile or fleece side of the knitted fabric shall be the face side and shall finish on the exposed surface of the finished jacket.					
	c. Cut all components from same piece of material, except the inner pocket ply, undercollar, binding wristlets stand piece and hanger which may be cut from ends. Parts cut from ends shall approximate the shade of the outside of finished jacket.					
	d. Wristlets shall match each other in shade when paired for each jacket. The hook and pile fastener tape shall be cut so that no splices of the tape are used on the jacket.					
2.	<u>Replacement of defective components</u>					
	During the spreading, cutting and manufacturing process, components having material defects or damages that are classified as defects in Section 4 shall be removed from production and replaced with non-defective and properly matched components.					
3.	<u>Marking</u>					
	a. All parts shall be marked, ticketed or bundle to assure a uniform shade, size and proper assembly throughout the jacket, except those parts cut from ends. Parts cut from ends must match the main assembly.					
	b. The use of corrosive metal fastening devices or sewn-on tickets is prohibited.					

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TABLE I CONSTRUCTION OF JACKETS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	c. Adhesive type tickets which discolor or adhere to the material upon removal of the tickets are prohibited.					
	d. The use of ink pad numbering machine, rubber stamp, or pencil is acceptable provided the numbers do not show on the outside of the jacket, wherever possible, numbers shall be covered by the seam allowance.					
4.	<u>Type II only - Make darts</u> The darts shall be tapered on the inside without twists or puckers. Thread ends at lower end of the darts shall not be trimmed closer than 1/2 inch in length. When an automatic dart machine is used, the thread ends at the lower end of the dart shall be backstitched.					
	a. Fold and stitch darts as indicated by marks on pattern.	301 or OSf-1 automatic dart machine		10-14	50	50
	b. Press the folded darts towards the center front.					
5.	<u>Prepare patch pocket</u> a. Hem top of patch pocket in accordance with marks on pattern with the raw edge turned in. Stitch 1/16 to 1/8 inch from folded edge.	301	EFb-1	10-14	30	30
	b. The finished hem shall measure 1-1/2 (+ 1/8) inches wide.					
	c. Stitch pile tape across top on outside of pocket hem according to marks on pattern. The tape may be stitched before making the hem.	301	LSbj-1	10-14	30	30
6.	<u>Prepare patch pocket flap and throat flap.</u> a. Fold pocket flap lengthwise in accordance with marks on pattern and stitch the side edges 3/8 inch from raw edge.	301 or 401	SSe-2(a)	10-14	30 30	30 50
	b. Stitch sides and top edge of throat flap together 3/8 inch from raw edge.	301 or 401	SSe-2(a)	10-14	30 30	30 50

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TABLE I CONSTRUCTION OF JACKETS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	c. Trim the corners and turn to finished position. Work out corners and edgestitch 1/16 inch from folded edge, the sides and bottom edge of pocket flap and sides and top edge of throat flap.	301	SSe-2(b) and OSf-1	10-14	30	30
	d. Stitch hook tape to flaps according to marks on the patterns. The tape on the pocket flap may be stitched before joining the flap(operation a and b). The hook tape on the throat flap shall be on both sides.	301	LSbj-1	10-14	30	30
	e. Overedge the top edge of the pocket flap and the bottom edge of the throat flap.	503 or 504	SSa-1	8-10	50	50
7.	<u>Set flap to left jacket front</u>					
	a. Stitch, 1/8 inch from overedge edge, the edge of flap to left jacket front in accordance with marks on pattern. Turn flap down and topstitch 3/16 to 1/4 inch from folded edge concealing overedgeing.	301	LSs-2	10-14	30	30
NOTE: Topstitching of flap may be accomplished after operation 8b.						
8.	<u>Set patch pocket to left jacket front</u>					
	a. The pocket shall be precreased to conform with template.					
	b. Set the patch pocket to left jacket front, centered and parallel 1/4 to 3/8 inch below flap top-stitching. Stitch the pocket 1/16 inch from folded edge.	301	LSd-1	10-14	30	30
	c. Stitch a 3/8 inch vertical bartack at each end of the patch pocket opening superimposed on the topstitching.	Bartack		28 per bartack	50	50
	d. The finished flap for all sizes shall measure 2 (+ 1/8) inches deep for types I and II and 5 1/2 (+ 1/8) inches wide for types I and 5 1/4 (+ 1/8) inches wide for type II. The finished pocket opening shall be 5-1/4 (+ 1/8) inches for the type I; and 5 (+ 1/8) inches for the type II.					

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TABLE I CONSTRUCTION OF JACKETS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
9.	<u>Make jacket hanger</u>					
	a. The hanger shall be cut from a strip of the basic material no less than 3 3/4 inches in length.					
	b. Fold strip in half lengthwise, face side out, turn in raw edges parallel to the fold and stitch 1/16 inch from folded edge.	301	EFp-1	10-14	30	30
	c. The finished width of hanger shall measure 3/8 to 1/2 inch.					
10.	<u>Make Collar</u>					
	a. Position undercollar interlining against inside of undercollar and quilt across the length, the undercollar to collar interlining with two rows of parallel horizontal stitching. The rows of stitching shall be 3/4 to 1 1/4 inches apart with bottom row 2 3/8 (+ 1/8) inches from the neck edge (see Figure 1).	301 or 401	SSv-2	10-14	30 30	30 50
	b. Stitch the overedged side of the throat flap to the face side of undercollar according to marks on pattern with tab towards the center of collar, turn flap towards collar edge and edgestitch flap. Stitch both pieces of pile tape to undercollar according to mark on the pattern. The pile tape and throat flap may be stitch to under collar before quilting to collar interlining.	301	LSbj-1	10-14	30	30
	c. Seam undercollar and topcollar along top and side edges, face to face, 1/4 to 5/16 inch from raw edge. Trim points.	301 or 401	SSe-2(a)	10-14	30 30	30 50
	d. Turn collar to finished position, work out points and stitch the seamed edges 3/16 to 1/4 inch from folded edge.	301	SSe-2(b)	10-14	30	30
11.	<u>Make welt slash pockets</u>					
	a. Fold under the outer pocket piece, as indicated by marks on pattern, and seam along raw edge, 1/8 to 3/16 inch.	301	EFa-1	10-14	30	30

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TABLE I CONSTRUCTION OF JACKETS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	b. Position and stitch 3/8 inch from raw edge the outer pocket piece to each front with the raw edge of pocket even and in line with the marks indicated on pattern forming a 5/8 (+ 1/8) inch welt.	301	LSq-2(a)	10-14	30	30
	c. Position and stitch 3/8 inch from raw edge, the inner pocket piece to each front with the pocket raw edge in line with the marks indicated on pattern and abutting the raw edge of the outer pocket piece.	301	LSq-2(a)	10-14	30	30
	d. Cut pocket opening midway between the double row of stitching. Tongue notch ends of pocket opening. Care shall be taken not to cut too deeply into the corners of the pocket. Turn pocket pieces through pocket opening.					
	e. Raise stitch, 1/16 to 1/8 inch from folded edge, base of welt through front and outer pocket piece with the seam allowance turned against the fronts.	301	LSq-2(b)	10-14	30	30
	f. Turn under tongue notch at each end of pocket opening.					
	g. With the pocket pieces and tongue notches in position, stitch 1/16 to 1/8 inch from folded edge, through all plies of material, the ends of welt and straight edge of inner pocket piece with the seam allowance turned against the fronts.	301	LSs-1 and LSq-2(b)	10-14	30	30
	h. Stitch, 1/2 (+ 1/8) inch from raw edge, the inner and outer pocket pieces at sides and bottom edge.	301	SSa-1	10-14	30	30
	i. Stitch a 3/4 (or two, 3/8) inch horizontal bartack at each end of pocket welt superimposed on the topstitching.	Bartack		28 per 3/8 inch brtck or 42 per 3/4 inch brtck	50	50
	OR					

The pocket may be made on an automatic pocket welt machine.

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TABLE I CONSTRUCTION OF JACKETS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	j. The finished pocket openings for all sizes shall measure 6 3/4 (+ 1/4) inches long.					
12.	<u>Join shoulder seam</u> Stitch shoulder seams with a double stitched and double lapped seam, with back lapped over fronts.	301 or 401	LSc-2	10-14	30 30	30 50
13.	<u>Join sleeves to armholes of outershell</u> a. Stitch sleeves to armholes of outershell in accordance with notches on pattern with a double stitched and double lapped seam, with fronts and back lapped over sleeves.	301 or 401	LSc-2	10-14	30 30	30 50
14.	<u>Close sleeves and join back and fronts at sides.</u> a. Close underarm seam of sleeves and join back and fronts at sides with a double stitched and double lapped seam. Front of sleeve shall overlap the back of sleeve and the fronts shall overlap the back at side seam.	301 or 401	LSc-2	10-14	30 30	30 50
15.	<u>Join collar to outershell</u> a. Join, 3/16 to 1/4 inch from raw edge, the finished collar to outershell of jacket aligning center of back with center of undercollar and ends of collar at notches indicated on pattern. b. The finished collar shall measure as follows 4-1/2 (+ 1/4) inches along center back of collar from outer edge to neckline seam. 3 5/8 (+ 1/4) inches along front ends of collar from neckline seam to point.	301	SSa-1	10-14	30	30
16.	<u>Attach front facings to front lining and slide fastener tapes - Type I only</u> a. Join, 3/16 to 1/4 inch from edge, outer edge of right facing to edge of front lining. Turn under inner edge of right facing 3/8 inch and topstitch to front lining 1/16 to 1/8 inch from the folded edge. Turn under inner edge of left facing in accordance with notches on pattern and topstitch to front lining 1/16 to 1/8 inch from folded edge.	301	SSa-1 and LSd-1 and LSb-1	10-14	30	30

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NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	b. Align the left half slide fastener tape with folded edge of left facing, with separating pin at the bottom. Top of slide fastener stop shall be $3/4 (+ 1/4)$ inch from seam joining collar to neck. <u>Stitch the slide fastener tape to facing $1/16$ to $1/8$ inch from edge.</u>	301	SSa-1	10-14	30	30
	c. Align the right half of slide fastener tape with front raw edge of face side of right facing and front lining, with the pull side of slide fastener uppermost and the slide fastener stop the same distance from the top as the stop of the left front. Join all plies of material $1/8$ inch from edge.	301	SSa-1	10-14	30	30
17.	<u>Attach front facings to front lining and slide fastener tapes - Type II only</u>					
	a. Join $3/16$ to $1/4$ inch from edge, outer edge of left facing to edge of front lining. Turn under inner edge of left facing $3/8$ inch and topstitch to front lining $1/16$ to $1/8$ inch from the folded edge. Turn under inner edge of right facing in accordance with notches on pattern and topstitch to front lining $1/16$ to $1/8$ inch from folded edge.	301	SSa-1 and LSd-1 and LSb-1	10-14	30	30
	b. Align the right half of slide fastener tape with folded edge of right facing, with separating pin at the bottom. Top of slide fastener stop shall be $3/4 (+ 1/4)$ inch from seam joining collar to neck. <u>Stitch the slide fastener tape to facing $1/16$ to $1/8$ inch from edge.</u>	301	SSa-1	10-14	30	30
	c. Align the left half of slide fastener tape with front raw edge of face side of left facing and front lining, with the pull side of slide fastener uppermost and slide fastener stop the same distance from the top as the stop of the right front. Join all plies of material $1/8$ inch from edge.	301	SSa-1	10-14	30	30

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TABLE I CONSTRUCTION OF JACKETS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
18.	<u>Attach label to lining back.</u> a. Set top edge of the identification-instruction label to the face side of lining approximately 1-1/2 inches down from neck raw edge of back. Stitch edge of label on all four sides. The size label may be stitch above this label or may be stitched to the neck as stated in operation 23.a.	301	LSbj-1	10-14	30	30
19.	<u>Join shoulders in lining.</u> a. Stitch shoulder seams of front and back lining.	301 or 401	SSa-1	10-14	30 30	30 50
20.	<u>Join sleeve lining to body lining.</u> a. Stitch sleeve lining to body lining at armholes for a distance indicated on pattern spreading shoulder seams open. b. Join underarm seam to sleeve lining.	301 or 401	SSa-1	10-14	30 30	30 50
21.	<u>Join side seams of lining.</u> a. Stitch side seams of front and back lining.	301 or 401	SSa-1	10-14	30 30	30 50
22.	<u>Bind sleeve lining underarm opening.</u> a. Bind sleeve lining underarm opening as indicated on pattern with armhole, underarm and side seams spread open. End the binding approximately 3 1/2 inches from either side of the underarm seam with a 1 1/2 inch overlap and ends caught in the stitching. b. No more than one splice shall be permitted for each armhole.	301 or 401	BSc-1	10-14	30 30	30 50
23.	<u>Complete assembly of outershell and lining, attach hanger and wristlets and hem bottom</u> a. Join 3/8 inch from the edge, face to face, the front and neck edges of lining and outershell simultaneously catching the ends of slide fastener tape, hanger at center back neck, size label at center back and forming a hem on outershell fronts as indicated by notches on pattern with the seam at top of hem turned downward. b. The finished hanger shall have a free opening of 2-1/4 (+ 1/4) inches.	301	SSa-1	10-14	30	30

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TABLE I CONSTRUCTION OF JACKETS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	c. Join the ends of wristlet stand piece, face to face, 5/8 inch from edge.	301	SSa-1	10-14	30	30
	d. Fold the knitted wristlets in half.					
	e. Safety stitch the ends of the knitted wristlet to the face side of the wristlet stand piece, 3/8 inch gauge.	515, 516 or 519	SSa-2	8-10	30	50 (chain- stitch- ing) 50 50 (over- edge stitch)
	f. Insert the wristlet stand between the outershell and lining sleeve bottoms, matching inseams. The wristlet assembly may be prestitched to the outershell and stitch 3/8 inch from the raw edges. The wristlet to stand seam shall finish against the sleeve hem.	301	Similar to SSk-1	10-14	30	30
	g. Turn jacket to finished position. Push back knitted wristlet through bottom of sleeve forming a hem 2 3/4 (+ 1/8) inches wide. Tack the hem to the inseam and also at the opposite side of sleeve, through all plies, using a 3/8 inch horizontal bartack positioned approximately 1/4 inch below the seam joining the wristlet stand to outershell and pile sleeves.		Bartack		28 per bartack	50 50
	h. Stitch top edge of hem at bottom of jacket through all plies of material, matching side seams.	301	Efb-1	10-14	30	30
	i. The finished hem shall measure 1 1/4 (+ 1/8) inches wide.					

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TABLE I CONSTRUCTION OF JACKETS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
<u>Type I only</u>						
	j. Edgestitch, 3/16 to 1/4 inch from edge, the top and front edges of left front flap, bottom of jacket, and front edge of right front, in a continuous operation.	301	SSe-2(b) and OSf-1	10-14	30	30
	k. Stitch, 1/4 to 5/16 inch from the inner edge of slide fastener chain, through all plies of material, with the row of stitching measuring 2-5/8 (+ 1/8) inches in from the finished left front edge and terminating at the turned under edge of the hem.	301	SSv-1	10-14	30	30
	l. Stitch a 3/8 inch vertical bartack at the bottom of each tape through all plies of material; one on the left front between the two rows of stitching, the other on the right front between the edge stitching and the turned edge.	Bartack		28 per bartack	50	50
<u>Type II only</u>						
	m. Edgestitch, 3/16 to 1/4 inch, from edge, the top and front edges of right front flap, bottom of jacket, and front edge of left front, in a continuous operation.	301	SSe-2(b) and OSf-1	10-14	30	30
	n. Stitch, 1/4 to 5/16 inch from the inner edge of slide fastener chain, through all plies of material, with the row of stitching measuring 2 5/8 (+ 1/8) inches in from the finished right front edge and terminating at the turned under edge of the hem .	301	SSv-1	10-14	30	30
	o. Stitch a 3/8 inch vertical bartack at the bottom of each tape through all plies of material, one on the right front between the two rows of stitching, and the other on the left front between the edgestitching and the turned edge.	Bartack		28 per bartack	50	50
<u>Types I and II</u>						
	p. Join the sleeve portion of the underarm opening to the outershell. The end of the binding shall be concealed between the plies and caught in stitching. The row of stitching shall coincide with the row of stitching on the binding and shall extend at each end to the double row of stitching on outershell armhole seam.	301	LSa-1	10-14	30	30

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TABLE I CONSTRUCTION OF JACKETS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
24.	<u>Make and attach adjustment straps</u>					
	a. Thread, fold, position and stitch waist adjustment stap assemblies in accordance with operations 24b, 24c, 24d, and Figures 1 and 2.	301		8-10	30	30
	b. Each attached strap assembly shall be horizontally aligned with the lower edge $1 \frac{3}{4}$ (<u>+ 1/4</u>) inches from the finished bottom edge of jacket.					
	c. Turn in top ply of short strap with the folded edge located $3 \frac{3}{4}$ (<u>+ 1/4</u>) inches in front of the side seam.					
	d. Turn in unhemmed edge of long strap with the folded edge located $3 \frac{3}{4}$ (<u>+ 1/4</u>) inches in back of the side seam.					
	e. The finished length of the waist adjustment strap assembly for all sizes shall be as follows:					
	Short strap - $2 \frac{1}{8}$ (<u>+ 1/8</u>) inches					
	Long strap - $6 \frac{3}{4}$ (<u>+ 1/4</u>) inches					
	Short strap shall be measured from folded edge to fold over buckle bar. Long strap shall be measured from folded edge to hemmed end.					
25.	<u>Mark and position closure hook tape.</u>					
	a. For the Type I jacket mark the position of four vertical 2 by 1 inch hook tape on the left front (flap) as follows:					
	1. The center of the top tape shall be $1 \frac{1}{2}$ (<u>+ 1/8</u>) inches from top edge of finished front (flap).					
	2. The center of the bottom tape shall be 4 (<u>+ 1/8</u>) inches from the finished bottom of jacket.					
	3. The two intermediate tapes shall be evenly spaced.					
	4. The outer edge of the tapes shall be not less than $\frac{3}{8}$ inch nor more than $\frac{1}{2}$ inch from finished front edge.					

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TABLE I CONSTRUCTION OF JACKETS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	b. Mark closure hook tapes for the Type II jacket as indicated in operation 25a above, except the tapes shall be marked on the right front (flap).					
26.	<u>Attach closure hook tapes to fronts.</u> a. Stitch the four sides of the four hook tapes. The long side shall be in the vertical position and placed as marked in operation 25.	301	LSbj-1	10-14	30	30
27.	<u>Attach closure pile tape.</u> a. Position and stitch pile tape to fronts to correspond with the hook tape in operation 25. The tape shall be 2 by 1 inch and with the long side in the vertical position. The outer edge of the tape shall be 3/8 to 1/2 inch from front. The tape shall be stitched on all four sides.	301	LSBJ-1	10-14	30	30
28.	<u>Attach slide fastener thong.</u> Thread thong through the eyelet in slide fastener short tab pull and knot both ends securely together.					
29.	<u>Clean jacket.</u> a. Trim and remove all loose thread. b. Remove all spots and stains. c. Remove all shade tickets and markings.					
NOTE: Caution shall be made so not to harm the materia when trimming.						
30.	<u>Close jacket and secure flap</u> Close front slide fastener and completely close the front flap.					

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3.8 Sizes and measurements. The sizes and measurements of the finished jacket shall be in accordance with Tables II and III. The measurements and tolerances are in inches. The measurements shall be taken as indicated below (see Figure 1).

Table II - Sizes and measurements of jacket, Type I

Size	Chest (A)	Waist (B)	Bottom (C)	Length of jacket (D)	Sleeve inseam (E)
Small (34-36)	43	40	41	28 5/8	23 1/2
Medium (38-40)	47	44	45	29	23 1/2
Large (42-44)	51	48	49	29 3/8	23 1/2
X-Large (46-48)	55	52	53	29 3/4	23 1/2
XX-Large (50-52)	59	56	57	30 1/8	23 1/2
Tolerances	± 1	± 1	± 1	$\pm 1/2$	$\pm 1/2$

Table III - Sizes and measurements of jacket, Type II

Size	Chest (A)	Waist (B)	Bottom (C)	Length of jacket (D)	Sleeve inseam (E)
Small (33-35)	42	40	43	27 1/2	21 1/2
Medium (37-39)	46	44	47	28	21 1/2
Large (41-43)	50	48	51	28 1/2	21 1/2
Tolerances	± 1	± 1	± 1	$\pm 1/2$	$\pm 1/2$

NOTE: Measurements for (A), (B), and (C) shall be taken with front slide fastener completely closed, front side up and front flap completely closed, laid flat and smooth.

Chest (A) - Double the measurement taken across the front of jacket at pit of armhole from folded edge to folded edge.

Waist (B) - Double the measurement taken across the front on a line level with the next to the last hook and pile tape, from folded edge to folded edge.

Bottom (C) - Double the measurement taken across the bottom edge of the jacket, from folded edge to folded edge.

Length of jacket (D) - The measurement shall be taken along the center of back from neckline seam to bottom edge of jacket.

Sleeve inseam (E) - The measurement shall be taken along the sleeve seam, from the base of the arm (pit) to the bottom edge of sleeve.

3.9 Workmanship. The finished jackets shall conform to the quality established by this specification. The occurrence of defects shall not exceed the applicable acceptable quality levels.

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4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the contractor may use his own or any other facilities suitable for 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.

4.1.1 Responsibility for compliance. All items must meet all requirements of sections 3 and 5. The inspection set forth in this specification shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the contractor of the responsibility of assuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling in quality conformance does not authorize submission of known defective material, either indicated or actual, nor does it commit the government to acceptance of defective material.

4.1.2 Certificate of compliance. Where certificates of compliance are submitted, the Government reserves the right to check test such items to determine the validity of the certification.

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

1. First article inspection (see 4.3).
2. Quality conformance inspection (see 4.4).

4.3 First article inspection. When required, the first article submitted in accordance with 3.2 shall be inspected for compliance with design, construction, workmanship, appearance, and dimensional requirements.

4.4 Quality conformance inspection. Sampling for inspection shall be performed in accordance with MIL-STD-105, except where otherwise indicated.

4.4.1 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, drawings, and standards unless otherwise excluded, amended, modified, or qualified in this specification or applicable purchase document. In addition, the contractor shall furnish a certificate of compliance for the enamel finish requirements of 3.3.10 and all components of slide fastener shall be furnished by the same supplier (see 3.3.11).

4.4.2 Examination of the end item. Defects found during the examination shall be classified in accordance with 4.4.2.1 through 4.4.2.2. The lot size shall be expressed in units of jackets. The sample unit shall be one finished jacket. The applicable inspection levels and acceptable quality levels (AQL's) shall be in accordance with 4.4.2.3.

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4.4.2.1 Visual examination. The jacket shall be examined for defects in color, design, material, construction, workmanship and marking and the defects classified in accordance with the following:

CLASSIFICATION OF DEFECTS

Defect	Classification	
	Major	Minor
	A	B
I. MATERIAL DEFECTS AND WORKMANSHIP DAMAGES		
a. Hole, cut, tear, smash, scorched area, knot or slub, burn, drill hole or open place:		
1. On outside (longest dimension in any direction):		
(a) -up to 1/4 inch inclusive		X
(b) -more than 1/4 inch	X	
2. On inside (longest dimension in any direction):		
(a) -up to 1/4 inch inclusive		X
(b) -more than 1/4 inch	X	
b. Misweave, area of no dye penetration, dye streak, thin place, visible mend, broken, loose or missing yarn, course yarn, shade bar, or woven in waste more than 1/2 inch (largest dimension in any direction):		
-on outside		X
c. Permanent fold, pleat or crease in cloth (when caught in seaming or stitching):		
-on outside		X
d. Needle chew on outside:		
1. Up to 1/4 inch inclusive		X
2. More than 1/4 inch	X	
e. Not specified material	X	
II. LINING		
a. Lining not napped or area of no nap (bald spot)	X	
b. Loose knit causing sleaziness, slubby yarn or dropped stitch		X

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Defect	Classification	
	Major	Minor
	A	B
III. WRISTLETS		
a. Stretch lacking, i.e., knitting tension too tight	X	
b. Run, dropped stitch or loosely knit	X	
c. Mend or thin area		X
IV. SHADED PARTS		
a. On outside:		
1. Any part shaded (except parts which may be cut from ends)	X	
2. Any part cut from ends badly shaded (except sleeve linings)		X
3. Variation in shade within a part	X	
V. CLEANNES		
a. Spot or stain on outside (largest dimension in any direction):		
1. Up to 3/8 inch inclusive		X
2. More than 3/8 inch up to 3/4 inch inclusive	X	
3. More than 3/4 inch	X	
b. Thread ends not trimmed:		
1. Three or more thread ends not trimmed to less than 1/4 inch or less on outside	X	
2. Five or more thread ends not trimmed to less than 1/2 inch or less on inside		X
d. Two or more shade or size tickets not removed		X
e. Any size or shade marking on outside: score as spot or stain		X

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Defect	Classification	
	Major	Minor
	A	B
VI. COMPONENTS AND ASSEMBLY		
a. Any component part or operation omitted (unless otherwise classified herein.)	X	
b. Any component not as specified (type, size, color, etc)	X	
c. Any component part tight, twisted, distorted, pleated or puckered (unless otherwise classified herein)		X
d. Any operation not as specified (unless otherwise classified herein)	X	
e. Any component part not assembled as specified (unless otherwise classified herein)	X	
VII. CUTTING		
Any component part not cut in accordance with specified pattern, directional lines on patterns or not in accordance with specification requirements.	X	
VIII. SEAMS AND STITCHING		
a. Accuracy of seaming:		
1. Seam puckered (unless otherwise classified)		X
2. Seam irregular, pleated or wavy (unless otherwise classified)	X	
3. Part of jacket caught in any unrelated operation or stitching	X	
4. End of stitching when not caught in another seam or stitching not backstitched as specified (except attaching labels)		X
5. Stitching overlapping ends of thread break less than 1/2 inch		X
6. Ends of continuous line of stitching overlapped less than 1/2 inch		X
b. Gauge of stitching and seam allowance:		
1. Gauge irregular or not within range specified or varies more than 1/16 inch when no range is specified (score only when the condition exists on the length of the seam for a distance of 1 inch or more)		X
2. Edge, top or raise stitching sewn too close to edge, resulting in damage to cloth	X	

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Defect	Classification	
	Major	Minor
	A	B
3. Seam allowance not as specified by 1/16 inch or more (score only when condition exists on the length of the seam for a distance of 1 inch or more)	X	
c. Open seam:		
1. On outside.		
(a) -up to 1/2 inch inclusive		X
(b) - more than 1/2 inch up to 3/4 inch inclusive		X
(c) - more than 3/4 inch	X	
2. On inside:		
(a) -more than 3/8 inch up to 2 inches inclusive		X
(b) -more than 2 inches	X	
d. Runoff, skipped or broken stitches:		
1. On joining seams, score as open seam		
2. Edge or raise stitching (more than 1/4 inch)		X
e. Raw edges:		
1. On outside:		
(a) -up to 1/2 inch, inclusive		X
(b) -more than 1/2 inch	X	
2. On inside:		
More than 1 inch		X
f. Seam and stitch type		
1. Not specified seam or stitch type		X
2. Any line of stitching omitted	X	
3. Any line of stitching not beginning or ending where specified (unless otherwise classified herein)		X
4. Looper thread of 401 stitch type on outside	X	

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Defect	Classification	
	Major	Minor
	A	B
g. Stitch tension:		
1. Loose tension resulting in a loose seam:		
(a) -up to 1/2 inch, inclusive		X
(b) -more than 1/2 inch up to 3/4 inch inclusive		X
(c) -more than 3/4 inch	X	
2. Loosely exposed loops of lower or top thread		X
3. Tight tension (stitches break when normal strain is applied in the direction of the seam or stitching)	X	
h. Stitches per inch (to be scored only when the condition exists on the major portion of seam or stitching):		
1. More than the maximum specified		X
2. Less than the minimum specified:		
(a) -by one or two stitches		X
(b) -by three or more stitches		X
i. Bartack, backtack, tack or tacking, one or more:		
1. Missing, insecure, misplaced not serving intended purpose or not specified size or type:		
(a) -for attachment (unless otherwise specified)		X
(b) -for reinforcement		X
j. Direction of lap of seam (on outershell):		
1. Sleeve lapped on front or back	X	
2. Front lapped on back at shoulder		X
3. Back lapped over front at sides and inseams		X

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Defect	Classification	
	Major	Minor
k. Staggered seams:	A	B
1. Side seams staggered at armhole seam by more than 1/2 inch	X	
2. Position of outershell not corresponding to lining seams by more than 1/4 inch		X
IX. ADJUSTMENT STRAPS		
a. One or both straps incorrectly threaded through buckle		X
b. One or both straps omitted, improperly positioned or insecure	X	
c. One or both straps secured other than specified manner		X
d. Short, not permitting garment to be smooth when strap is extended full length		X
e. Lower edge of webbing less than 1-1/2 inches or more than 2 inches from bottom edge of jacket		X
f. Folded edge of webbing on front or back less than 3-1/2 inches or more than 4 inches from folded edge of side seam		X
g. Out of horizontal alignment by more than 1/2 inch	X	
h. Reversed assembly, i.e., pull of adjustment strap not towards back when worn	X	
i. Finished hem or turn under not in conformance with dimensions and tolerances specified	X	
j. Finished length of the waist adjustment strap assembly deviating from the measurements and tolerances specified below: *		
1. Short strap:		
(a) -less than 2 inches or more than 2-1/4 inches	X	
2. Long strap:		
(a) -less than 6-1/2 inches or more than 7 inches	X	
* Measurements shall be taken as described in operation 24e.		

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Defect	Classification	
	Major	Minor
	A	B
X. BINDING		
a. Containing more than one splice	X	
b. Overlapped end less than 2-1/2 inches from either side of underarm seam		X
c. Badly twisted	X	
d. End of binding at armhole of lining:		
1. Not caught in stitching	X	
2. Not concealed between lining and outershell		X
e. Binding not securely caught to fabric causing binding to pull away from fabric	X	
f. Other than bias cut		X
g. Binding tight, causing puckering or pleating		X
XI. BUCKLE		
a. Any omitted, or having broken, rough or sharp edge	X	
b. Coating omitted		X
XII. HOOK AND PILE TAPE		
a. One or more omitted or added	X	
b. Tape not corresponding in size so that they do not close properly	X	
c. Tape not securely stitched in fabric causing stitching to pull away from fabric	X	
d. One or more broken stitches in one or more tapes		X
e. Wrong type, class or color		X
f. Center of top tape less than 1-3/8 inches or more than 1-5/8 inches from top edge of finished flap		X
g. Center of bottom tape less than 3-7/8 inches or more than 4-1/8 inches from finished bottom jacket		X
h. Outer edge of tape less than 3/8 inch or more than 1/2 inch from finished front edge.		X

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Defect	Classification	
	Major	Minor
	A	B
XIII. DART (Type II only)		
a. Omitted or not specified type	X	
b. Not positioned as specified		X
c. Length of darts uneven in length by 1/2 inch or more		X
XIV. COLLAR		
a. General		
1. Badly twisted		X
2. Tight at joining to neck causing fullness on front or back		X
3. Interlining:		
(a) -omitted		X
(b) -pleated, affecting smoothness of topcollar		X
(c) -tight or twisted causing puckers on undercollar		X
4. Width at center back less than 4-1/4 inches or more than 4-3/4 inches		X
b. Collar edge:		
1. Not properly forced out causing a fold of 1/8 inch or more (to be scored only when the condition exists on 1/2 the length of the collar edge)		X
2. Pointed corners poorly shaped or not of uniform shape		X
c. Collar points:		
1. Less than 3-3/8 inches or more than 3-7/8 inches long		X
2. Uneven in length by:		
(a) -more than 1/4 inch but not more than 1/2 inch		X
(b) -more than 1/2 inch	X	

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Defect	Classification	
	Major	Minor
	A	B
d. Topcollar:		
1. Tight, causing edges to curl up		X
2. Having a diagonal twist	X	
3. Excessive fullness or puckering	X	
e. Undercollar:		
1. One or both horizontal rows of stitching omitted		X
2. Bottom row of horizontal stitching less than 2-1/4 inches or more than 2-1/2 inches from neck edge		X
3. Parallel rows of stitching less than 1/2 inch or more than 1-1/2 inches apart		X
4. Throat flap missing, misplaced or not serving intended purpose		X
5. Hook and pile tape not positioned as specified		X
XV. FRONT FACINGS		
a. Short, tight or twisted causing puckers on outside of jacket		X
b. Irregular in width by 1/4 inch or more		X
XVI. FRONT FLAP		
a. Edges irregular or not properly forced out		X
b. Slide fastener stitching less than 2-1/2 inches or more than 2-3/4 inches from left front edge (Type I) or from right front edge (Type II)		X
c. Slide fastener tape stitched to left front edge (Type I) or right front edge (Type II) with one row of stitching		X
XVII. HANGER AND THROAT FLAP		
a. Omitted		X
b. Not securely attached or other than type construction specified		X
c. Free opening of hanger less than 2 inches or more than 2-1/2 inches		X
d. Finished width of hanger less than 3/8 inch or more than 1/2 inch		X
e. Not attached as specified		X

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Defect	Classification	
	Major	Minor
	A	B
XVIII. HEM		
a. Outside of garment puckered, twisted or pleated by stitching forming hem	X	
b. Irregular in width by 1/4 inch or more		X
c. Bottom hem less than 1-1/8 inches or more than 1-3/8 inches wide		X
d. Sleeve hem less than 2-5/8 inches or more than 2-7/8 inches wide		X
XIX. LABEL		
a. Omitted	X	
b. Misplaced		X
c. Not stitched on all four sides (when applicable)		X
d. Size label omitted, illegible or incorrect	X	
e. Inscription omitted, illegible or incomplete		X
XX. LINING		
a. Short, tight or twisted	X	
b. Too full		X
XXI. POCKETS		
a. Breast pocket and flap:		
1. Pocket hem less than 1-3/8 inches or more than 1-5/8 inches wide		X
2. Pocket corners exposed beyond flap edge	X	
3. Patch pocket positioned less than 1/4 inch or more than 3/8 inch from flap topstitching		X
4. Patch pocket deviating more or less than 1/8 inch from pattern template	X	
5. Flap less than 1-7/8 inches or more than 2-1/8 inches deep or less than 5-3/8 inches or more than 5-5/8 inches wide for type I; or less than 4-7/8 inches or more than 5-1/8 inches wide for type II jacket		X

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Defect	Classification	
	Major	Minor
	A	B
b. Welt:		
1. Out of alignment with each other by more than 1/2 inch	X	
2. Less than 6-1/2 inches or more than 7 inches long		X
3. Less than 1/2 inch or more than 3/4 inch wide		X
4. Distance from pocket welts to center front of coat uneven by more than 1/2 inch when measured from the same point on each welt horizontally to the slide fastener teeth	X	
XXII. SLEEVE		
a. Sleeve pleated; or excessive fullness at armhole	X	
b. Sleeve tight at armhole seam causing puckers on front or back	X	
c. Sleeve lining short, twisted or too full	X	
XXIII. SLIDE FASTENER		
a. Any part of slide fastener assembly defective or missing, cut or tear in slide fastener tape, scoops of chain unevenly matched or stitching too close to metal edge not permitting slider to pass freely	X	
b. Tape set too loose or too tight causing bulge, twist or fullness on front opening		X
XXIV. THONG		
a. Omitted or not secured properly to short tab pull		X
b. Less than 4 inches or more than 5 inches long after assembly to slide fastener short tab pull		X
XXV. WRISTLET		
a. Omitted, insecurely attached or other than type or size specified	X	
b. Attached in other than specified manner or location		X

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4.4.2.2 Dimensional examination. The jacket shall be examined for defects in accordance with the following.

a. Any measurement deviating from nominal dimensions and tolerances specified in Table II and Table III shall be scored as a measurement defect.

b. Sleeve lengths unequal in length by more than 1/2 inch shall be scored as a size measurement defect.

4.4.2.3 Inspection levels and acceptable quality levels. The inspection levels and acceptable quality levels (AQL's) expressed in defects per 100 units, for visual and dimensional examination shall be as follows:

	<u>AQL's</u>	<u>Inspection levels</u>
For examination in 4.4.2.1		
Major	2.5	II
Major and Minor A, combined	10.0	II
Total (Major, Minor A, and Minor B combined)	25.0	II
For examination in 4.4.2.2		
One class	4.0	S-3

4.4.3 Examination of packaging requirements. An examination shall be made to determine that packaging, packing and marking comply with Section 5 requirements of this specification. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully prepared for delivery with the exception that it need not be closed. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot size shall be on the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 and the AQL shall be 2.5 defects per hundred units.

<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, damaged or not as specified.
Workmanship	Inadequate application of components, such as: incomplete closure of container flaps, loose strapping, improper taping, inadequate stapling; bulged or distorted container.
Content	Number of jackets per shipping container is more or less than required. Size shown on one or more jackets not as specified on shipping container. <u>1/</u>

1/ For this defect, one jacket from each shipping container in sample shall be examined.

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4.4.4 Palletization examination. An examination shall be made to determine that the palletization complies with the section 5 requirements. Defects shall be scored in accordance with the list below. The sample unit shall be one palletized unit load fully packaged. The lot size shall be the number of palletized unit loads in the end item inspection lot. The inspection level shall be S-1 and the AQL, expressed in terms of defects per hundred units, shall be 6.5.

<u>Examine</u>	<u>Defect</u>
Finished dimensions	Length, width, or height exceeds specified maximum requirements.
Palletization	Pallet pattern not as specified. Interlocking of loads not as specified. Load not bonded with required straps as specified.
Weight	Exceeds maximum load limits.
Marking	Omitted, incorrect, illegible, of improper size, location, sequence, or method of application.

5. PACKAGING

5.1 Preservation-packaging. Preservation-packaging shall be level A or C (see 6.2).

5.1.1 Level A. Each jacket shall be folded as follows:

- a. Close slide fasteners, engage hook and pile tape on fronts and pocket.
- b. Place jacket face-down and fold sleeves across back.
- c. Fold jacket in half by bringing the bottom up to the top of jacket. The approximate size of the folded jacket shall be 14-1/2 inches by 23 inches.

5.1.2 Level C. Jackets shall be packaged to afford adequate protection against physical damage during shipment from the supply source to the first receiving activity. The package and the quantity per package shall be the same as that normally used by the contractor for retail distribution.

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

5.2.1 Level A. Eight (8) jackets, of one size, type and class only, packaged as specified in 5.1, shall be packed in a fiberboard shipping container assembled, closed and reinforced conforming to Type CF, class weather resistant, variety DW, grade 15c, size 3A of MIL-B-17757. The liner will be type CF, class domestic, in accordance with the requirements specified in MIL-B-17757. Level A packages shall be stacked flat, one in width, one in length and eight in depth with every other jacket reversed and the longer dimension of the jacket parallel to the side panel of the container. Each container shall have the contents completely covered on the top and bottom with a sheet of commercial grade kraft paper. Toward the end of the contract, or when there are less than the required amount per container of the same size, mixed sizes may be packed within the same shipping container.

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5.2.2 Level B. Eight (8) jackets of one size, type and class only, packaged as specified in 5.1, shall be packed in a fiberboard shipping container assembled, closed and reinforced conforming to type CF, class domestic, variety DW, grade 275, size 3A of MIL-B-17757. The liner will be type CF, class domestic, in accordance with the requirements specified in MIL-B-17757. Level A packages shall be stacked flat one in width, one in length and eight in depth with every other jacket reversed and the longer dimension of the jacket parallel to the side panel of the container. Each container shall have the contents completely covered on the top and bottom with a sheet of commercial grade kraft paper. Toward the end of the contract, or when there are 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, packaged as specified in 5.1, shall be packed in a manner to insure carrier acceptance and safe delivery at destination at the lowest transportation rate for such supplies. The quantity per shipping container shall be the same as that normally used by the contractor for retail distribution. Containers shall comply with the US Postal Service Manual, Uniform Freight Classification Rules or National Motor Freight Classification Rules, as applicable.

5.3 Marking. In addition to any special marking required by the contract or order, shipping containers shall be marked in accordance with MIL-STD-129.

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

5.4 Palletization. When specified (see 6.2) item packed as specified shall be palletized on a 4-way entry pallet in accordance with load type 1A of MIL-STD-147. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding means C, K, and L or O or P. Pallet pattern shall be in accordance with the appendix of MIL-STD-147. The pallet shall be 4-way, Type IV, Type V, class 1, size 2; or Type VIII, fabricated from wood group I, II, III or IV, Grade A of NN-P-71, or 4-way, Style 1, Size A, Type I, Class 1 of wood groups specified, of MIL-P-15011. Interlocking of loads shall be effected by reversing the pattern of each course. If the container is of a size which does not conform to any of the patterns specified in MIL-STD-147, the pallet pattern used shall be approved by the contracting officer.

6. NOTES

6.1 Intended use. The jacket specified herein is intended to be worn in conjunction with the Cap and Trousers, Cold Weather items as part of an outfit.

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6.2 Ordering data. Procurement documents should specify the following:

- a. Title, number and date of this specification.
- b. Type, class and sizes required (see 1.2).
- c. When first article sample is required (see 3.2) the contracting officer should include specific instructions in acquisition documents regarding arrangements for examination, quantity and testing and approval of the first article.
- d. Level of packaging and packing required (see 5.1 and 5.2).
- e. When palletization is required (see 5.4).

6.3 Samples and patterns. For access to samples and patterns, address the procuring activity issuing the invitation for bids.

6.4 Subject term (key word) listing.

Jacket, fire retardant plain weave
Jacket, cotton/nylon sateen
Jacket, cold weather with lining
Outfit, cold weather
Jacket, unisex (man's and woman's)
Clothing, cold weather

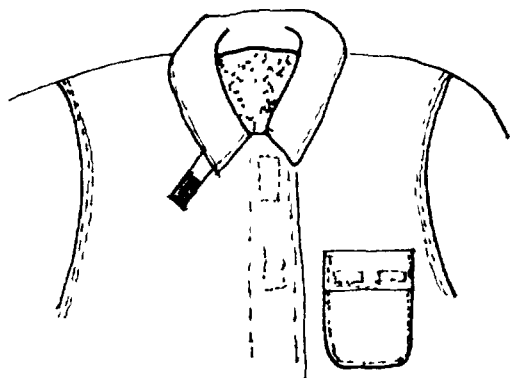
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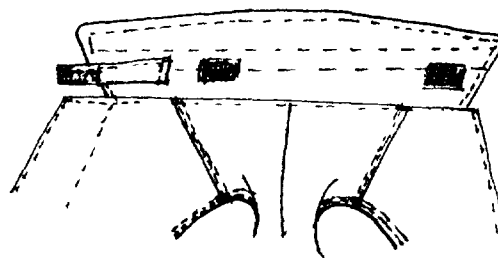
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Project No. 8415-0582

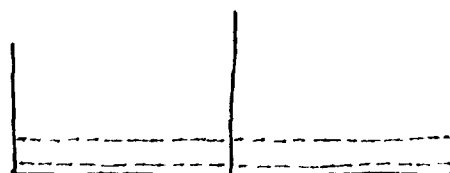
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FRONT CLOSURE
TYPE II JACKET



CONSTRUCTION OF
BACK COLLAR



BOTTOM OF JACKET

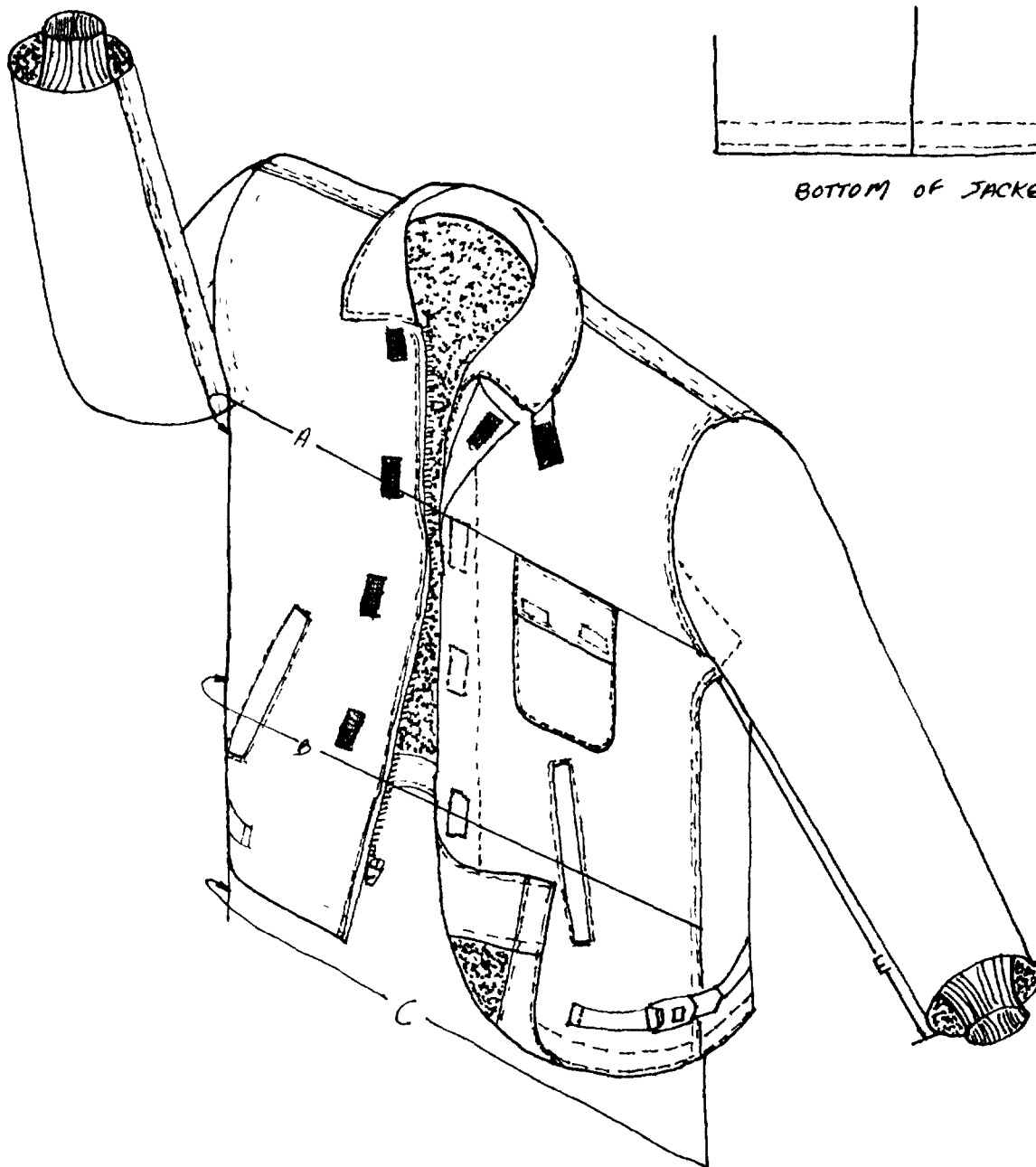
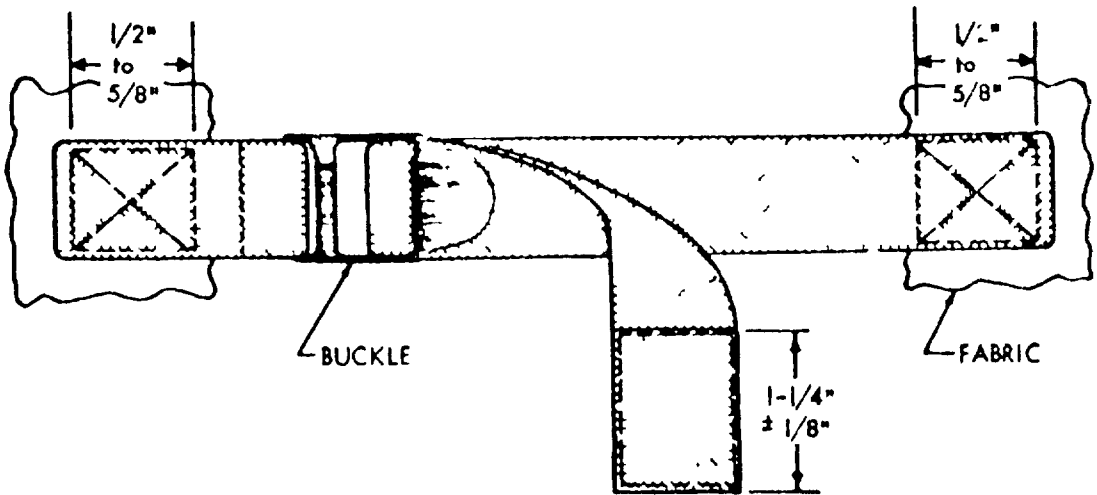
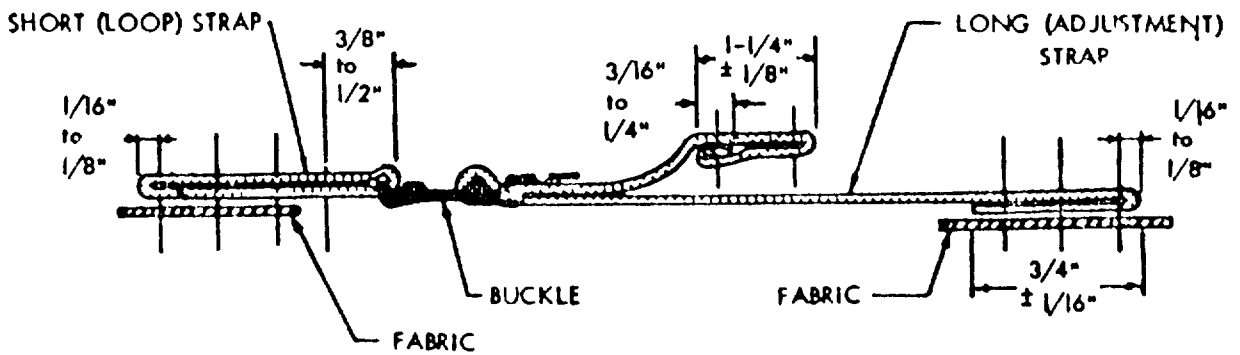


FIGURE 1 - JACKET, COLD WEATHER, FLAME RESISTANT

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TOP VIEW



SIDE VIEW

FIGURE-2 - JACKET, COLD WEATHER, FLAME RESISTANT

INSTRUCTIONS. In a continuing effort to make our standardization documents better, the DoD provides this form for use in submitting comments and suggestions for improvements. All users of military standardization documents are invited to provide suggestions. This form may be detached, folded along the lines indicated, taped along the loose edge (*DO NOT STAPLE*), and mailed. In block 5, be as specific as possible about particular problem areas such as wording which required interpretation, was too rigid, restrictive, loose, ambiguous, or was incompatible, and give proposed wording changes which would alleviate the problems. Enter in block 6 any remarks not related to a specific paragraph of the document. If block 7 is filled out, an acknowledgement will be mailed to you within 30 days to let you know that your comments were received and are being considered.

NOTE This form may not be used to request copies of documents, nor to request waivers, deviations, or clarification of specification 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.

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DEPARTMENT OF THE NAVY



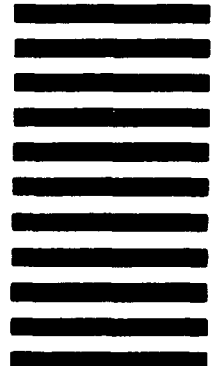
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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

1 DOCUMENT NUMBER
MIL-J-21708G

2 DOCUMENT TITLE
JACKET, COLD WEATHER

3a. NAME OF SUBMITTING ORGANIZATION

4 TYPE OF ORGANIZATION (Mark one)

VENDOR

USER

MANUFACTURER

OTHER (Specify) _____

b ADDRESS (Street, City, State, ZIP Code)

5 PROBLEM AREAS

a. Paragraph Number and Wording

b Recommended Wording

c Reason/Rationale for Recommendation

6 REMARKS

7a. NAME OF SUBMITTER (Last, First, MI) - Optional

b WORK TELEPHONE NUMBER (Include Area Code) - Optional

c MAILING ADDRESS (Street, City, State, ZIP Code) - Optional

8 DATE OF SUBMISSION (YYMMDD)