

INCH-POUND

MIL-J-43923C(GL)

13 April 1990

SUPERSEDING

MIL-J-43923B(GL)

28 December 1984

MILITARY SPECIFICATION

JACKET, FLYER'S, LIGHTWEIGHT, (EXPANDABLE WRISTS AND WAIST)

This specification is approved for use by the Natick Research, Development, and Engineering Center, Department of the Army, and is available for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification covers a self-lined jacket made of a high temperature resistant aramid oxford cloth.

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

Schedule of sizes

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

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be used in improving this document should be addressed to: U.S. Army Natick Research, Development, and Engineering Center, Natick, MA 01760-5014 by using the Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8415

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2. APPLICABLE DOCUMENTS

2.1 Government documents.

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

SPECIFICATIONS

FEDERAL

A-A-50083 - Bag, Plastic, Folded Garment
 T-T-881 - Twine, Cotton, Seine
 V-F-106 - Fastener, Slide, Interlocking
 DDD-L-20 - Label: For Clothing, Equipage, and Tentage, (General Use)
 PPP-B-636 - Boxes, Shipping, Fiberboard

MILITARY

MIL-C-3735 - Cuffs, Knit, Wrist and Ankle, and Cloth, Knitted
 MIL-F-21840 - Fastener Tapes, Hook and Loop, Synthetic
 MIL-L-35078 - Loads, Unit: Preparation of Semiperishable Subsistence Items; Clothing, Personal Equipment and Equipage; General Specification For
 MIL-T-43548 - Thread, Polyester Core: Cotton-, Rayon-, or Polyester-Covered
 MIL-T-43636 - Thread, Aramid
 MIL-T-43709 - Tape, Textile, Aramid
 MIL-C-43842 - Cloth, Oxford, Aramid
 MIL-T-44100 - Thread, Para-Aramid, Spun, Intermediate Modulus
 MIL-T-83193 - Thread, Aramid, Spun Staple

STANDARDS

FEDERAL

FED-STD-191 - Textile Test Methods
 FED-STD-751 - Stitches, Seams and Stitchings

MILITARY

MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
 MIL-STD-129 - Marking for Shipment and Storage
 MIL-STD-147 - Palletized Unit Loads
 MIL-STD-731 - Quality of Wood Members for Containers and Pallets

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(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from the Standardization Documents Order Desk, Bldg. 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.)

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

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

D 3951 - Standard Practice for Commercial Packaging

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19102-1187.)

THE COLOR ASSOCIATION OF THE UNITED STATES

Standard Color Card of America

Department of Defense Standard Color Card for Sewing Threads

(Color cards may be available from the Color Association of the United States, 343 Lexington Avenue, New York, NY 10016-0927. If color cards are not available from the Color Association, individual color samples may be obtained from the contracting activity or as directed by the contracting activity.)

(Non-Government standards and other publications are normally available from the organizations that prepare or distribute the documents. These documents also may be available in or through libraries or other informational services.)

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

3. REQUIREMENTS

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

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

3.3 Materials. It is encouraged that recycled material be used when practical as long as it meets the requirements of this specification.

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3.3.1 Basic material. The basic material shall be 6.0 ounce high temperature resistant, aramid oxford cloth conforming to MIL-C-43842. The color shall be Olive Green 106.

3.3.2 Knit wrist cuffs and waistband material.

3.3.2.1 Wrist cuffs. The knit wrist cuffs shall be Olive Green 106 and shall conform to type IV, class 2 of MIL-C-3735.

3.3.2.2 Waistband. The knit waistband shall be Olive Green 106 and shall conform to type IV, class 3 of MIL-C-3735.

3.3.3 Fastener tapes. The nylon fastener tapes shall be Green, Shade 3421 and shall conform to type I, class 2, 1 inch and 5/8 inch widths of MIL-F-21840. Nylon tape, 1-1/2 inches wide may be substituted for the 5/8 inch tape.

3.3.4 Tape, aramid. The tape for hanger loops and for slide fastener thongs shall conform to MIL-T-43709.

3.3.5 Cord. The cord beading used for welts of front opening shall conform to type I, No. 18 of T-T-881.

3.3.6 Thread.

3.3.6.1 Thread, aramid. The aramid thread shall conform to type I, sizes B and E of MIL-T-43636, dyed Olive Drab S-1, C.A. 66022. As an alternate, thread sizes T-60 and T-90 conforming to MIL-T-83193 or sole thread size T-35 conforming to MIL-T-44100 may be respectively substituted to replace the size B and E of MIL-T-43636 threads.

3.3.6.2 Thread, polyester core. Cotton-, rayon-, or polyester-covered polyester core thread conforming to ticket No. 50, 2-ply of MIL-T-43548 may be used as an alternate thread for bartacking. The thread shall be dyed Olive Drab S-1, C.A. 66022 and shall show fastness to laundering equal to or better than the standard sample. When no sample is available, the thread shall show "good" fastness to laundering.

3.3.7 Fasteners, slide. The slide fasteners shall be brass with a black chemical finish, and shall conform to V-F-106.

3.3.7.1 Front. The fastener for the jacket front shall conform to type IV, style 8, size M, short tab pull, with the chain of the following lengths in inches :

<u>Size</u>	<u>Short</u>	<u>Regular</u>	<u>Long</u>
X-Small	19	20	21
Small	19-1/2	20-1/2	21-1/2
Medium	20	21	22
Large	20-1/2	21-1/2	22-1/2
X-Large	21	22	23

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3.3.7.2 Pencil and utility pocket. The fastener for the pencil and utility pocket shall conform to type I, style 7, size M, short tab pull, 4-3/4 inch chain.

3.3.7.3 Slide fastener tape. The slide fastener tape shall be made of a aramid nylon tape, shade S, Cable No. 66519, and shall show "good" fastness to laundering. Color matching of the fastener tape under incandescent lamplight at $2300 \pm 100K$ shall be exempt.

3.3.8 Resinous sealer. The material for dipping the ends of slide fastener thongs (see operation 1.c) to prevent fraying, shall be a colorless, non-combustible resin (see 6.5). As an alternate the ends may be cut by hot wire or a hot bladed strip cutter.

3.3.9 Labels. Each jacket shall have (a) a class 1 identification label, a class 2 size label, and a class 3 instruction label; (b) a class 2 size label and a class 15 combination identification and instruction label; or (c) a combination of the class 1 identification and class 2 size labels and a class 3 instruction label conforming to type VI of DDD-L-20. The labels shall show fastness to laundering. When a combination identification-instruction label is used, the item nomenclature shall not be repeated. The size label shall contain the following information for each respective size. Description information shall be printed in letters and numerals not less than 10-point and as follows:

X-Small - Short

Chest: Up to 33 inches
Height: Up to 67 inches
Stock No.:
NATO size: 6070/7484

X-Small - Regular

Chest: Up to 33 inches
Height: 67 to 71 inches
Stock No.:
NATO size: 7080/7484

X-Small - Long

Chest: Up to 33 inches
Height: 71 inches up
Stock No.:
NATO size: 8090/7484

Small - Short

Chest: 33 to 37 inches
Height: Up to 67 inches
Stock No.:
NATO size: 6070/8494

Small - Regular

Chest: 33 to 37 inches
Height: 67 to 71 inches
Stock No.:
NATO size: 7080/8494

Small - Long

Chest: 33 to 37 inches
Height: 71 inches up
Stock No.:
NATO size: 8090/8494

Medium - Short

Chest: 37 to 41 inches
Height: Up to 67 inches
Stock No.:
NATO size: 6070/9404

Medium - Regular

Chest: 37 to 41 inches
Height: 67 to 71 inches
Stock No.:
NATO size: 7080/9404

Medium - Long

Chest: 37 to 41 inches
Height: 71 inches up
Stock No.:
NATO size: 8090/9404

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Large - Short

Chest: 41 to 45 inches
 Height: Up to 67 inches
 Stock No.:
 NATO size: 6070/0414

Large - Regular

Chest: 41 to 45 inches
 Height: 67 to 71 inches
 Stock No.:
 NATO size: 7080/0414

Large - Long

Chest: 41 to 45 inches
 Height: 71 inches up
 Stock No.:
 NATO size: 8090/0414

X-Large - Short

Chest: 45 inches up
 Height: Up to 67 inches
 Stock No.:
 NATO size: 6070/1424

X-Large - Regular

Chest: 45 inches up
 Height: 67 to 71 inches
 Stock No.:
 NATO size: 7080/1424

X-Large - Long

Chest: 45 inches up
 Height: 71 inches up
 Stock No.:
 NATO size: 8090/1424

The instruction label shall contain the following information:

JACKET, FLYER'S: LIGHTWEIGHT, (EXPANDABLE WRISTS AND WAIST)

This jacket is of low flammability. No other special flame resistant treatments are required.

1. The jacket can be machine washed or dry cleaned in accordance with established procedures. Jacket may be hand laundered; make sure soap is thoroughly rinsed out.

2. WARNING: Launder with slide fasteners and hook and loop fasteners closed. Do not press hook and loop fasteners. After 10 laundering cycles and thereafter, launder in accordance with Formula IX (no bleach) of TM 10-280, field laundry and Natick Formula X, fixed laundry for the retreatment of anti-static agent.

3. DO NOT STARCH. Starch will burn. If starched, thorough laundering will return this garment to its fire retardant condition.

4. Color fading does not diminish the flame retardant properties of this garment

DO NOT REMOVE THIS LABEL

3.4 Design. The jacket is single breasted with a front slide fastener closure. Jacket has a collar with tab closure and diagonal side pockets with flaps with hook and loop closure. The left sleeve has a utility and pencil pocket. The cuffs and waistband are rib knit. Jacket is fully self-lined.

3.4.1 Figure. Figure 1 is furnished for information purposes only. To the extent of any inconsistencies between the written specification and the figure, the written specification shall govern.

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3.5 Patterns. Standard patterns which provide a 1/2 inch seam allowance for double-lapped, double-stitched seams attaching cuffs to sleeve and attaching waistband to jacket and 3/8 inch for all other seams will be furnished by the Government. The standard patterns shall not be altered in any way and are to be used for cutting contractor's working patterns. The working patterns shall be identical to the standard patterns.

3.5.1 List of pattern parts. The component parts of the jacket shall be cut from materials specified in accordance with the number of parts indicated in table I.

TABLE I. List of pattern parts

Material	Nomenclature	Cut parts
6 oz. aramid nylon oxford	Front	2
	Back	1
	Collar (top collar and interlining)	2
	Undercollar	1
	Neck tab	2
	Top sleeve	2
	Undersleeve	2
	Pocket	4
	Welt	2
	Utility pocket	1
	Pencil pocket upper	1
	Pencil pocket lower	1
	Slide fastener cover	1
	Front facing	2
	Front extension	2
	Front lining	2
	Back lining	1
	Top sleeve lining	2
	Undersleeve lining	2
	Pocket flap	2

3.6 Construction.

3.6.1 Stitches, seams and stitching. Stitch, seam and stitching types specified in table II shall conform to FED-STD-751. Where two or more seam or stitch types are given for the same part of an operation, any one of them may be used. Where stitch type 401 is used, the looper (underthread) shall be on the inside of the jacket. The gage of stitching on double lapped and double stitched seams shall be 1/4 to 5/16 inch, but the same gage shall be used on all double stitched seams throughout the jacket. The gage of stitching for safety stitch construction shall be 3/8 inch. The guides and knives on the safety stitch machines shall be set to trim only the ravelled ends of the fabric. Seam

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allowances shall be maintained with seams sewn so that raw edges, runoffs, twists, pleats or puckers will not result. All seams shall start and finish evenly. Thread tension shall be maintained so that there is no tight or loose tension. Seams required to be worked out having a depth between the fold of 1/16 inch or more shall be considered a defect.

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

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

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

b. Thread breaks or two or more consecutive skipped or runoff stitches noted during inspection of the item shall be repaired by overstitching. The stitching shall start a minimum of 1/2 inch in back of the defective area, continue over the defective area a minimum of 1/2 inch beyond the defective area onto the existing stitching. Loose or excessively tight stitching shall be repaired by removing the defective stitching without damaging the materials and restitching in the required manner. When damaged thread has been removed, needle holes do not constitute damage to the material. 1/

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

3.6.1.2 Type 401, 503, 504, 515, 516, and 519 stitching. Thread tension shall be maintained so that there will be no loose stitching. All repairs shall be in accordance with 3.6.1.1.1a and 3.6.1.1.1b. Repairs to stitch type 401 may be accomplished by use of stitch type 301.

3.6.2 Stitches per inch. The minimum and maximum number of stitches per inch shall be as specified in table II.

3.6.3 Bartacks. Bartacks shall measure 1/2 \pm 1/16 inch long and be free from thread breaks and loose stitching.

3.6.4 Thread ends. All thread ends that are visible on the finished jacket shall be trimmed to a length of not more than 1/4 inch.

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3.6.5 Repairs. Repairs such as mends, darns, patches or splices are not permitted on the jacket.

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

3.7 Manufacturing operations requirements. The jacket shall be made in accordance with the operation requirements specified in table II. The contractor is not required to follow exact sequence of operations listed, unless otherwise specified. Any additional basting or holding stitches used to facilitate manufacture are permissible, provided the thread does not show on the finished garment.

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NO.	Table II. MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
1.	<p><u>Cutting.</u></p> <p>a. Cut the jacket parts in strict accordance with the patterns which show size, shape, directional lines and placement of pockets for proper assembly.</p> <p>b. Cut the component parts out of one piece of material except the undercollar, collar interlining, neck tab, front pockets and sleeve linings which may be cut from ends. Parts cut from ends shall approximate the shade of the jacket.</p> <p>c. Cut the tape for slide fastener thongs of sufficient length to measure 2-1/2 to 3 inches (folded) when attached to slide fastener (see operation 4). Cut the tape for hanger loops 4-1/4 to 4-1/2 inches long. Sear or dip raw ends of each fastener thong.</p> <p>d. Cut hook and loop tapes in accordance with the following:</p> <p>(1) Four 5/8 inch hook and loop tapes 1-1/2 inches long for front pockets, or four 1-1/2 inch hook and loop tapes 5/8 inch long, as applicable.</p> <p>(2) Two 1 inch hook and loop tapes 1 inch long for neck tab and collar (see operations 9 and 10).</p>						

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NO.	Table II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D												
					NEEDLE	BOBBIN/ LOOPER	COVER										
1.	<p><u>Cut jacket.</u> (cont'd)</p> <p>e. Cut the cord beading for front opening 1/2 inch longer than the slide fastener chains (see 3.3.7.1).</p> <p>f. Cut the knit waistband (one each jacket) of sufficient length to comply with the finished waistband length requirements of operation 18f, and in the following widths:</p> <table><tr><td>X-Small</td><td>24 inches</td></tr><tr><td>Small</td><td>25 inches</td></tr><tr><td>Medium</td><td>26 inches</td></tr><tr><td>Large</td><td>27 inches</td></tr><tr><td>X-Large</td><td>28 inches</td></tr></table>	X-Small	24 inches	Small	25 inches	Medium	26 inches	Large	27 inches	X-Large	28 inches						
X-Small	24 inches																
Small	25 inches																
Medium	26 inches																
Large	27 inches																
X-Large	28 inches																
2.	<p><u>Replacement of defective components.</u></p> <p>During the spreading, cutting and manufacturing process, components having material defects or damages that are classified as defects in paragraph 4.4.2 shall be removed from production and replaced with non-defective and properly matched components.</p>																
3.	<p><u>Marking.</u></p> <p>a. Mark, ticket, or bundle all parts except those parts cut from ends to assure a uniform size and shade throughout the jacket.</p>																

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NO.	Table II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
3.	<u>Marking.</u> (cont'd) b. Any method of marking may be used except: (1) Metal fastening devices. (2) Sew-on tickets. (3) Adhesive type tickets which leave traces of adhesive on the material after removal of the tickets.	Bartack	-	28 per bartack	B	B	
4.	<u>Attach slide fastener thongs</u> Thread thongs through fastener tab pull and, with ends even, bartack together with two vertical bartacks, 1/2 to 3/4 inch apart, with the end of the top bartack 1/4 to 1/2 inch from the end of the metal tab pull.	515 or 516 or 519	SSa-2	10-12	E	B chain stitching E overedge stitching	
5.	<u>Make lining sleeves.</u> Join lining top sleeve to undersleeve with safety-stitched seams.	301 and 301	OSf-1	10-12 10-12	B B	B B	
6.	<u>Make lining back and attach label.</u> a. Stitch shoulder darts on back. Stitching shall extend 7/8 inch beyond marks. Turn inside fold of dart toward center back and stitch down the edge of fold with stitching 1/16 to 3/32 inch from fold.						

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NO.	Table II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D	
					NEEDLE	ROBBIN/ LOOPER COVER
6.	Make <u>lining back and attach label.</u> (cont'd)					
	b. Position size label centered on inside of back lining (1/2 inch off center tolerance) with the top of the label not less than 1-3/4 inches from neck raw edge, and stitch on all four sides, through lining. Stitching shall not be through the printing.	301	LSbj-1	10-12	B	B
	c. Combination identification-size label, when used, shall be positioned as indicated for size label.	301	LSbj-1	10-12	B	B
7.	<u>Attach labels to lining fronts.</u>					
	a. Position instruction label to inside of right front lining with bottom of label 1 to 1-1/2 inches from bottom raw edge and left side of label 1 to 1-1/2 inches from front raw edge. Stitch on all four sides. Stitching shall not be through the printing.	301	LSbj-1	10-12	B	B
	b. Position identification label directly above the instruction label with left side of labels lined up. Bottom of identification label shall be no more than 1/2 inch above top of instruction label. Stitch on all four sides. Label may be so positioned that the bottom may be caught in the top row of instruction label stitching. Stitching shall not be through the printing.	301	LSbj-1	10-12	B	B

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NO.	Table II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
7.	<u>Attach labels to lining fronts.</u> (cont'd) c. Combination identification-instruction label, when used, shall be positioned as indicated for instruction label.	301	LSbj-1	10-12	B	B	
8.	<u>Join lining parts.</u> a. Join lining fronts to back at sides and shoulders with a safety stitched seam. b. Turn seam allowances toward back and raise stitch 1/8 to 3/16 inch from joining seams. c. Set lining sleeves with a safety stitched seam.	515 or 516 or 519 301	LSbm-3(a) LSbm-3(b)	10-12 10-12	E chain stitching E overedge stitching E	B E E	
9.	<u>Make neck tab.</u> d. Turn seam allowance toward shoulder and raise stitch the seam around the top of the sleeve, from notch to notch, 1/8 to 3/16 inch from joining seam. a. Superimpose neck tab pieces and stitch around top, front and bottom edges, leaving the narrow end of tab open for turning. b. Trim corner, turn, work out edges and edge stitch 1/8 to 3/16 inch from edges.	515 or 516 or 519 301 301 or 401 301	LSbm-3(a) LSbm-3(b) SSe-2(a) SSe-2(b)	10-12 10-12 10-12 10-12	E chain stitching E overedge stitching E B B B	B E E	

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NO.	Table II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
9.	<u>Make neck tab.</u> (cont'd)						
	c. Position two 1 inch wide hook tapes (see operation 1.d (2)) (one each side) to the top end of the tab, as indicated by marks on pattern, and stitch on all four sides 1/16 to 3/32 inch from edge of tape.	301	LSbj-1	10-12	E	E	
10.	<u>Make collar.</u>						
	a. Superimpose undercollar on interlining. Position the two 1 inch loop tapes on undercollar, as indicated by marks on pattern and stitch to undercollar, through interlinings, on all four sides 1/16 to 3/32 inch from edge of tape.	301	LSbj-1	10-12	E	E	
	b. Position collar tab on undercollar, as indicated by marks on pattern, with finished end toward front of collar and stitch tab to undercollar, through interlining. Turn collar tab back and raise stitch 1/4 to 3/8 inch from turned edge.	301	LSbk-2(a) and LSbk-2(b)	10-12	B	B	
		301		10-12	E	E	
	c. Superimpose top collar on undercollar and join sides and top. Stitching shall be 3/8 inch from edge through top collar, interlining and undercollar. Trim point, turn, work out edges and point, and edge stitch ends and top 3/16 to 1/4 inch from edges. Stitching shall start and end 3/4 inch from bottom raw edges to allow for collar joining operation.	301 or 401 301	SSe-2(a) and SSe-2(b)	10-12 10-12	B B B	B B B	

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NO.	Table II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
11.	Make and attach utility and pencil pocket.						
	a. Turn outer edge of slide fastener cover under 1/2 inch. Turn inner edge under 7/8 inch, enclosing other turned edge. Position slide fastener on underside of cover, with edge of chain even with the folded edge of the 7/8 inch fold (inner edge) and stitch tape to cover with two rows of stitching 1/4 to 5/16 inch gage with the back row 1/16 to 3/32 inch from edge of fastener tape. Bridge of slide fastener shall finish toward top of sleeve.	301	LSbj-2	10-12	E	E	
	b. Turn under top raw edge of upper pencil pocket 1/4 inch and hem. Turn under top raw edge of lower pencil pocket 1/4 inch and hem. Both hems shall measure $1/4 + 1/16$ "h.	301 301	EFb-1 EFb-1	10-12 10-12	B B	B B	
	c. Position top edge of lower pencil pocket to bottom of upper pencil pocket as indicated by marks on pattern. Turn under side and bottom edges of the combined pencil pocket and stitch to the utility pocket as indicated by marks on pattern.	301	LSd-1	10-12	E	E	
	d. Place a vertical row of stitching through the center (1/8 inch off center tolerance) of upper and lower pencil pockets. Stitching shall be through all plies, forming two compartments in each pencil pocket.	301	SSv-1	10-12	B	B	

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NO.	Table II (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
11.	<p>Make and attach utility and pencil pocket. (cont'd)</p> <p>e. Place vertical bartacks on ends of pencil pocket openings, superimposed on rows of side stitching, and center stitching of upper and lower pencil pockets and at bottom of lower pencil pocket, at sides and center making a total of nine bartacks (see figure 1).</p> <p>f. Close bottom corners of utility pocket and stitch, forming a bellows bottom. Turn and work out edges and points.</p> <p>g. Turn back inner side edge of utility pocket 7/8 inch. Position free part of slide fastener tape on turned portion, with edge of slide fastener chain even with inner turned edge of pocket and stitch tape to pocket with two rows of stitching 1/4 to 5/16 inch gauge, with the back row 1/16 to 3/32 inch from edge of tape.</p> <p>h. Position pocket on left top sleeve on marks indicated on pattern. Turn under top, bottom and side raw edges and stitch pocket to sleeve.</p> <p>i. Bartack each end of slide fastener opening with a horizontal bartack extending from slide fastener cover to pocket. Bartack shall be $1/4 \pm 1/8$ inch from top and bottom edges of pocket.</p>	<p>Bartack</p> <p>301</p> <p>301</p> <p>301</p> <p>Bartack</p>	<p>-</p> <p>SSa-1</p> <p>-</p> <p>LSd-1</p> <p>-</p>	<p>28 per bartack</p> <p>10-12</p> <p>10-12</p> <p>10-12</p> <p>28 per bartack</p>	<p>B</p> <p>E</p> <p>E</p> <p>E</p> <p>B</p>		

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NO.	Table II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
12.	<u>Make jacket sleeves.</u> Join jacket top sleeve to undersleeve with double-lapped, double-stitched seam. Top sleeve shall be lapped on undersleeve.	301 or 401	LSc-2	10-12 10-12	E E	E B	
13.	<u>Make pocket welts and flaps.</u> a. Fold welt pieces in half and stitch sides. Turn, work out edges. b. Position two 5/8 by 1-1/2 hook portion of fastener tape to the welt as indicated by marks on pattern and stitch on all four sides 1/16 to 3/32 inch from edge of tape, through all plies. c. Position two 5/8 by 1-1/2 inch loop portion of fastener tape to flaps as indicated by marks on pattern and stitch on all four sides 1/16 to 3/32 inch from edge of tape. d. Fold pocket flap in half and stitch sides 3/8 inch from edges. e. Turn, work out edges and edge stitch 1/16 to 1/8 inch from side and folded edge.	301 301 301 301 or 401 301	SSa-1 LSbj-1 LSbj 1 SSe-2(a) SSe-2(b)	10-12 10-12 10-12 10-12 10 12 10-12	E E E E E E	E E E E B E	

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NO.	Table II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
14.	<u>Make fronts.</u>						
	a. Position pocket pieces on front, as indicated by marks on pattern, with pocket welt (hook tape face down), between front and top pocket (piece finishing against front). Stitch through pocket pieces, welt and front, with two rows of stitching 3/4 to 7/8 inch gage, equally spaced from cut line. Cut pocket opening and tongue-notch ends or as an alternate the pocket may be die cut.	301	LSbj-1	10-12	B	B	
	b. Turn seams allowance on unwelted side of opening, toward body of jacket, and raise stitch the length of the opening, through front, 1/8 to 3/16 inch from joining seam.	301	LSq-2(b)	10-12	E	E	
	c. Turn pocket pieces to inside. Raise stitch the length of the welted opening, through front, welt and pocket 1/8 to 3/16 inch from joining seam.	301	LSq-2(b)	10-12	E	E	
	d. Join outer edges of pocket pieces together with a safety stitch.	515 or 516 or 519	SSa-2	10-12	E chain stitching	B	
	e. With pocket smooth and flat, stitch down ends of welt, through welt and pocket with two rows of stitching 1/4 to 5/16 inch gage with the outer row 1/16 to 3/32 inch from end of welt. Continue stitching across top edge of welt to close box. Ends of welt shall cover ends of pocket opening.	301	-	10-12	E overedge stitching	E	

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NO.	Table II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
14.	<u>Make fronts.</u> (cont'd) f. Place a bartack on each end of pocket opening superimposed on inner row of the end stitching of welt. Bartack shall not extend on to jacket and shall end 1/16 to 3/16 inch from end of welt. g. Position raw edge of pocket flap to front as indicated by marks on pattern and stitch 1/4 inch from raw edge. h. Turn flap down and raise stitch 1/4 inch from turned edge.	Bartack	-	28 per bartack	B	B	
15.	<u>Make jacket backs.</u> Stitch shoulder darts on back. Stitching shall extend 7/8 inch beyond drill mark. Turn inside fold of dart toward center back and stitch down the edge of the fold.	301 or 401 301	LSbk-2(a) LSbk-2(a) LSbk-2(b)	10-12 10-12 10-12	E E E	E B E	
16.	<u>Join back to fronts.</u> Join back to fronts at shoulders and at sides with double-lapped, double-stitched seams, with fronts lapped on back.	301 and 301	OSf-1	10-12 10 1'	B B	B B	
17.	<u>Set sleeves.</u> a. Set jacket sleeves with a safety-stitched seam.	301 or 401 515 or 516 or 519	LSc-2 LSbm-3(a)	10-12 10-12 10-12	E E E	E B B	chain stitching E overedge stitching

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NO.	Table II, (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	ROBBIN/ LOOPER	COVER
17.	Set sleeves. (cont'd)						
	b. Turn seam allowance toward shoulder and raise stitch around the top of sleeve from notch to notch 1/8 to 3/16 inch from joining seam.	301	LSbm-3(b)	10-12	E	E	
18.	Make and attach waistband and close bottom of jacket.						
	a. Fold bottom edge of front extension to inside so the bottom raw edge aligns with notch. Fold bottom raw edge of front facing to the inside at the notch. With back edges of facing and extension even, interlock the folded edges of the facing and extension and tack the interlocked portion approximately 1/4 inch from back edge. The tack shall be parallel to the back edge. The joining of the facing and extension shall simulate an LSc seam.	301	-	6-12	B	B	
	b. Superimpose the front pieces (facing and extension) on ends of knit waistband, and with top and back raw edges of front pieces even with raw edges at ends of waistband, stitch front pieces to ends of waistband 1/2 inch from raw edges.	301	LSq-2(a)	10-12	E	E	
	c. Turn seam allowance toward front pieces and raise stitch 1/8 to 3/16 inch from joining seam.	301	LSq-2(b)	10-12	E	E	
	d. Superimpose waistband and front facing pieces on bottom of lining (face to face) and with raw edges even, stitch with a 1/2 inch seam allowance from front edge to front edge.	301	SSa-1	10-12	E	E	

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NO.	Table II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
18.	Make and attach waistband and close bottom of jacket. (cont'd) e. Superimpose opposite side of waistband (side with front extension pieces) on bottom of outer shell (face to face) and with raw edges even, stitch with a 1/2 inch seam allowance from front edge. Turn seam allowance toward top of jacket and raise stitch 1/16 to 1/8 inch from waistband joining seam. f. Fold waistband to finished position. Turn jacket up over waistband and with lining and jacket face to face, waistband enclosed between lining and jacket, and all raw edges even, stitch through all plies, closing the jacket bottom to within 1-1/2 to 2 inches from front edges of knit waistband. The waistband shall finish 3-1/2 to 4 inches in length.	301 301	LSq-2(a) and LSq-2(b)	10-12 10-12	E E	E E	
19.	Attach cuffs and tack linings. a. Stitch together raw edges of cuffs with an over-edge stitch. b. Position cuff between liner and jacket sleeves (face to face) and with raw edges of sleeve bottoms even with overedged edge of cuff, stitch parts together 1/2 inch from edge. or Position cuff between liner and jacket sleeves (face to face) and with all raw edges even, safety stitch the layers together. The finished seam shall be 1/2 inch wide.	301 503 or 504 301 or 401	SSa-1 SSa-1 SSq-2(a)	10-12 6-8 10-12 10-12	E B E E	E B E B	

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NO.	Table II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
19.	<p><u>Attach cuffs and tack linings.</u> (cont'd)</p> <p>c. Superimpose sleeve setting seam allowances of jacket and lining at underarm and stitch together, through seam allowances, tacking jacket to lining. Stitching shall be 1/2 inch long with ends tacked. A straight line tack may be used.</p> <p>d. Turn sleeves to finished position.</p> <p>e. Turn cuff joining seam allowance toward sleeve and stitch with one row of stitching, through all plies, 1/4 to 3/8 inch from cuff joining seam.</p>	301	SSa-1	10-12	E	E	
20.	<p><u>Finish front and attach slide fastener.</u></p> <p>a. Fold fronts back on marks indicated on pattern. Insert cord piece within fold and stitch entire front 1/8 to 3/16 inch from fold, enclosing cord in fold without catching cord in stitching.</p> <p>b. Position slide fastener tape on turned portion of front, with edge of chain even with corded edge, and stitch tape to facing with one row of stitching 1/4 + 1/16 inch from back edge of tape (top end of slide fastener tape shall be caught in collar joining seam (see operation 21)).</p> <p>c. Turn under front raw edge of lining. Position turned edge on slide fastener tape and stitch lining to jacket, through fastener tape. The front edges of lining may be pre hemmed.</p>	301	SSq-2(b)	10-12	E	E	
		301	OSf-1	10-12	E	E	
		301	LSbj-1	10-12	E	E	
		301	LSd-1	10-12	E	E	

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NO.	Table II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
20.	Finish front and attach slide fastener. (cont'd)						
	d. Place a vertical bartack 1/8 to 3/8 inch above bottom of slide fastener tape, with bartack superimposed across slide fastener tape stitching.	Bartack	-	28 per bartack	B	B	
21.	e. With bottom of front extension piece turned under stitch bottom closed through all plies with stitching 1/16 to 3/32 inch from turned edge. Stitching shall extend from jacket front to start of knit waistband.	301	-	10-12	E	E	
	Set collar.						
22.	a. Stitch lining to jacket at neck with one row of stitching 1/8 to 3/16 inch from raw edges, catching hanger at center back of neck (hanger on finished jacket shall measure 3-1/2 + 1/4 inches with ends 2-1/2 + 1/2 inches apart.)	301 or 401	SSa-1	10-12 10-12	B B	B B	
	b. Join undercollar and interlining to jacket, catching the ends of slide fastener tapes and hanger loop in line of stitching.	301	SSa-1	10-12	E	E	
22.	c. Turn collar up, turn under raw edge and stitch collar to lining, with stitching going through all plies. Complete edge stitching at each end of collar.	301	LSD-1	10-12	E	E	
	Clean jacket.						
22.	a. Trim and remove all thread ends.						
	b. Remove all spots and stains.						
22.	c. Remove all size markings.						
	d. Close slide fasteners and prepare for packaging.						

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3.8 Measurements. Finished measurements shall be as shown in table III; a $\pm 3/4$ inch tolerance is allowed on all measurements.

TABLE III. Finished measurements (inches)

	Short	Regular	Long
<u>Half chest 1/</u>			
X-Small	21	21	21
Small	23	23	23
Medium	25	25	25
Large	27	27	27
X-Large	29	29	29
<u>Back length 2/</u>			
X-Small	21-1/2	22-1/2	23-1/2
Small	22	23	24
Medium	22-1/2	23-1/2	24-1/2
Large	23	24	25
X-Large	23-1/2	24-1/2	25-1/2
<u>Sleeve length 3/</u>			
X-Small	14-1/4	15-1/4	16-1/4
Small	14-1/4	15-1/4	16-1/4
Medium	14-1/4	15-1/4	16-1/4
Large	14-1/4	15-1/4	16-1/4
X-Large	14-1/4	15-1/4	16-1/4

1/ Half chest - Jacket front closed, at base of armhole, from folded edge to folded edge.

2/ Back length - At center back, from collar joining seam to top of knit waistband.

3/ Sleeve length - From armhole along underarm seam to top of cuff.

3.9 Workmanship. The finished jacket shall conform to the quality of product established by this specification and 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 or purchase order, the contractor is responsible for the performance of all inspection requirements (examinations and tests) as specified herein. Except as otherwise specified in the contract or purchase order, the contractor 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 this specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.1.1 Responsibility for compliance. All items shall 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 ensuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations, is an acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to accept defective material.

4.1.2 Responsibility for dimensional requirements. Unless otherwise specified in the contract or purchase order, the contractor is responsible for ensuring that all specified dimensions have been met. When dimensions cannot be examined on the end item, inspection shall be made at any point, or at all points in the manufacturing process necessary to assure compliance with all dimensional requirements.

4.1.3 Certificate of compliance. When certificates of compliance are submitted, the Government reserves the right to inspect such items to determine the validity of the certification.

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

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

4.3 First article inspection. When a first article is required (see 3.1 and 6.2), it shall be examined for the defects specified in 4.4.2 and 4.4.3.

4.4 Quality conformance inspection. Unless otherwise specified, sampling for inspection shall be performed in accordance with MIL-STD-105.

4.4.1 Component and material inspection. In accordance with 4.1, components and materials shall be inspected in accordance with all the requirements of referenced documents unless otherwise excluded, amended, modified or qualified in this specification or applicable purchase document.

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4.4.2 End item visual examination. The end items shall be examined for the defects listed in table IV. The lot size shall be expressed in units of jackets. The sample unit shall be one jacket. The inspection level shall be II and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 2.5 for major defects, 15 for major and minor A combined defects, and 40 for total (major, minor A and minor B combined) defects.

TABLE IV. End item visual defects

Examine	Defects	Classification	
		Major	Minor A B
Material defects and damages	Hole, cut, tear, or needle chew:		
	- On outside	101	
	- On inside	102	
	Mend, darn, patch (in diameter or length:		
	- On outside	103	
	- On inside:		
	- 1/4 to 1/2 inch, inclusive		301
	- more than 1/2 inch		201
	Friction burn:		
	- When fibers are broken, use classification "a" above		
	- When fibers are not broken, more than 1/4 inch in length		302
	Drill hole exposed on outside		303
	Weakening defects:		
	- Smash	104	
Material defects: Cuffs and waistband	- Multiple float or loose slub:		
	- On outside		202
	- On inside		304
	- Unsightly slub or shade bar:		
	- On outside		203
	- On inside		305
Material defects: Cuffs and waistband	Any hole, cut, or tear	105	
	Run or dropped stitch	106	
	Abrasion mark resulting in a weak area	107	
	Not specified size	108	
Shaded parts	Shaded part (excluding undercollar, neck tab, front pocket pieces and sleeve linings)		204

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TABLE IV. End item visual defects (cont'd)

Examine	Defects	Classification	
		Major	Minor A B
Cleanness	Any spot or stain on outside		306
	Thread end not trimmed, or loose threads not removed throughout jacket		307
	One or more shade markings not removed		308
	Shade marking visible on outside		309
Component and assembly	Any component part or required operation omitted (unless otherwise classified herein)	109	
	Any operation not performed as specified (unless otherwise classified herein)		310
Cutting	Any component part not cut in accordance with directional lines as indicated by marks on pattern or not cut in accordance with document requirements	110	
Seams and stitching	Accuracy of seaming:		
	- Seam twisted, puckered, or pleated		205
	- Part of jacket caught in unrelated operation or stitching	111	
	- End of stitching, when not caught in other seam or stitching backtacked less than 1/4 inch		311
	- Thread break (all stitch types) stitched less than 1/2 inch beyond each end of break		206
	- Ends of a continuous line of stitching overlapped less than 1/2 inch on all seams except label stitching, or less than 3 stitches on labels		312
	Gage of stitching and seam allowance:		
	- Irregular, i.e., unevenly gaged, or corresponding stitching not uniform (to be scored only where condition exist along major portion of seam)		207

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TABLE IV. End item visual defects (cont'd)

Examine	Defects	Classification	
		Major	Minor A B
Seams and stitching - cont'd	- Not width specified or not within range of gage specified or varies more than 1/16 inch when no range is specified		208
	- Edge or raised stitching sewn too close to edge, resulting in damage to cloth	112	
	Open seam (stitches skipped, broken, or missing)		
	- Any seam open by:		
	- up to 1/4 inch inclusive		313
	- more than 1/4 up to 1 inch inclusive		209
	- more than 1 inch	113	
	Raw edge:		
	- 1/8 up to 1/4 inch inclusive		314
	- more than 1/4 up to 1 inch inclusive		210
	- more than 1 inch	114	
	Any raw edge caused by omission of overedge stitching for a distance of 3 inches or more		211
	Runoffs (on edge or raised stitching):		
	- 1/4 up to 1/2 inch inclusive		315
	- more than 1/2 inch		212
	Seam and stitch type:		
	- Seam or stitch type not as specified	115	
	- Looper thread of 401 stitch type on joining seam finishing on outside of seam	116	
	Stitch tension:		
	- Loose tension resulting in a loose seam	117	
	- Loose tension on raised or edge stitching		213
	- Tight tension (stitches break when strain is applied in direction of seam or stitching)	118	

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TABLE IV. End item visual defects (cont'd)

Examine	Defects	Classification	
		Major	Minor A B
Seams and stitching - cont'd	Stitches per inch (except on labels) (to be scored only when the condition exists on the major portion of the seam):		
	- more than the maximum specified or less than the minimum specified		214
	Stitches per inch less than the minimum specified on labels		316
	Stitches, skipped, broken, or missing on edge or raise stitching:		
	- up to 1 inch inclusive		317
	- more than 1 inch		215
Bartacks	One or more omitted, or misplaced, not serving intended purpose (unless otherwise classified herein)		216
	Not specified size		318
Slide fastener	Defective, affecting function	119	
	Not type or size specified		217
	Slide fastener tape cut or frayed	120	
	Thong missing		319
	Thong not specified size		320
	Slide fasteners attached with less than two rows of stitching through length of tape (each side)	121	
	End of thong not dipped or seared		218
	End of thong frays when tugged at		321
Collar	Fullness or puckers on top collar		219
	Tight at joining to neck seam, causing puckers or pleats on front or back		220
	Side ends not properly worked out, having a fold of more than 1/8 inch		221
	Twisted	122	
	Points at ends of collar uneven in length by 3/8 inch or more, or not uniform in shape		222
	Collar tab not finished flat		223
	Fastener misplaced, not serving intended purpose		224

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TABLE IV. End item visual defects (cont'd)

Examine	Defects	Classification	
		Major	Minor A B
Collar - cont'd	Fastener not specified size		322
Hanger loop	Missing or misplaced		225
	Not specified size		323
Fronts	Uneven at bottom by 1/2 inch or more or at top by 1/4 inch or more when closed		226
	Fastener tape set too loosely or too tight, causing distortion on tapes or front	123	
	Top end of tape not caught in collar joining seam	124	
	Cord edge of front opening overlapping by more than 1/8 inch or the distance between cord edges of opening greater than 1/8 inch when fastener is closed		227
	Cording at edges not extending the full length of the opening		228
Front pockets	Pockets or flaps out of alignment by 1/4 inch or more		229
	Welts or flaps not uniform in length by more than 1/4 inch		230
	Hook or loop fastener not specified size		231
	Fastener part missing	125	
	Welt not smooth and flat when pocket is closed		324
	Hook or loop portions of fastener tape not positioned as specified	126	
	Flaps not positioned as specified		232
Utility and pencil pocket	Pocket set on crookedly		233
	Fastener bridge not at top	127	
	Edge of pocket pleated or twisted in stitching		234
	Edge of slide fastener tape extending beyond edge of pocket by 1/8 inch or more	128	
	Pencil pocket compartments uneven in width by more than 1/4 inch		235

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TABLE IV. End item visual defects (cont'd)

Examine	Defects	Classification	
		Major	Minor A B
Sleeves	Reversed	129	
	Sleeve or body of shirt puckered or pleated at armhole		236
	Bottom of sleeve twisted	130	
	Armhole seam not raise stitched at shoulder		237
	Cuff not specified size		238
Direction of seams	Fronts not lapped on back at shoulder or at side		325
	Front sleeve not lapped on back sleeve		326
Waistband	Not specified size	131	
Labels	Missing, incorrect, or illegible: - size, or combination size and identification (when applicable)	132	
	- identification, instruction, or combination (when applicable)		239
	Not stitched on all four sides		240
	Stitching through printing		241
	Size label off center by more than 1/8 inch, or any other label not positioned as specified		242

4.4.3 End item dimensional examination. The end items shall be examined for conformance to the measurements specified in table III. Any measurement deviating from the specified requirement and sleeves uneven in length by 3/4 inch or more shall be classified as defects. The lot size shall be expressed in units of jackets. The sample unit shall be one jacket. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 4.0.

4.4.4 Packaging examination. The fully packaged end items shall be examined for the defects listed below. The lot size shall be expressed in units of shipping containers. The sample unit shall be one shipping container fully packaged. The inspection level shall be S-2 and the AQL, expressed in terms of defects per hundred units, shall be 2.5.

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<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 sealing or closure of flap, improper taping, loose strapping or inadequate stapling Bulged or distorted container
Content	Number of jackets per 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 shipping container in the sample shall be examined.

4.4.5 Palletization examination. The fully packaged and palletized end items shall be examined for the defects listed below. The lot size shall be expressed in units of palletized unit loads. The sample unit shall be one palletized unit load, fully packaged. 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 dimension	Length, width, or height exceeds specified maximum requirement
Palletization	Pallet pattern not as specified Interlocking of loads not as specified Load not bonded 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. Preservation shall be level A or Commercial, as specified (see 6.2).

5.1.1 Level A preservation. Each jacket, with slide fasteners closed, shall be neatly folded to measure approximately 23 inches in length by 14-1/2 inches in width. Each folded jacket shall be inserted in a close-fitting clear polyethylene film bag conforming to A-A-50083.

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5.1.2 Commercial preservation. The jacket shall be preserved in accordance with ASTM D 3951.

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

5.2.1 Level A packing. Fifteen jackets of one size only, preserved as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC-L, grade V2s of PPP-B-636. The inside of each shipping container shall be fitted with a box liner conforming to type CF, class weather-resistant, variety DW, grade V15c of PPP-B-636. Level A unit packs shall be packed flat fifteen in depth within a shipping container. Inside dimensions of each shipping container shall approximate 23-1/2 inches in length, 15 inches in width, and 15 inches in depth. Approximate dimensions are furnished as a guide only. Each shipping container shall be closed in accordance with method III, waterproofed in accordance with method V, and reinforced as specified in the appendix of PPP-B-636, except that the inspection shall be in accordance with 4.4.4. Shipping containers shall be arranged in unit loads in accordance with MIL-L-35078 for the type and class of load specified (see 6.2). Strapping shall be limited to nonmetallic strapping, except for type II, class F loads.

5.2.2 Level B packing. Fifteen jackets of one size only, preserved as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC-L, type CF (variety SW) or SF, class domestic, grade 275 of PPP-B-636. The inside of each shipping container shall be fitted with a box liner conforming to type CF, class domestic, variety DW, grade 275 of PPP-B-636. Level A unit packs shall be packed flat, fifteen in depth within a shipping container. Inside dimensions of each shipping container shall approximate 23-1/2 inches in length, 15 inches in width, and 15 inches in depth. Approximate dimensions are furnished as a guide only. Each shipping container shall be closed in accordance with method II as specified in the appendix of PPP-B-636, except that the inspection shall be in accordance with 4.4.4.

5.2.2.1 Weather-resistant fiberboard container. When specified (see 6.2), the shipping containers shall be a grade V3c, V3s, or V4s fiberboard box fabricated in accordance with PPP-B-636 and closed in accordance with method III as specified in the appendix of PPP-B-636, except that the inspection shall be in accordance with 4.4.4.

5.2.3 Commercial packing. Jackets, preserved as specified in 5.1, shall be packed in accordance with ASTM D 3951.

5.3 Palletization. When specified (see 6.2) jackets, packed as specified in 5.2.2 and 5.2.3, shall be palletized on a 4-way entry pallet in accordance with load type Ia of MIL-STD-147. Pallet types shall be type I (4-way entry), type IV or type V in accordance with MIL-STD-147. Pallets shall be fabricated from wood groups I, II, III or IV of MIL-STD-731. Each prepared load shall be

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bonded with primary and secondary straps in accordance with bonding means C and D or film bonding means F or G. Pallet pattern shall be number 3 in accordance with the appendix of MIL-STD-147. Interlocking of loads shall be effected by reversing the pattern of each course.

5.4 Marking. In addition to any special marking required by the contract or purchase order, unit packs, shipping containers and palletized unit loads shall be marked in accordance with MIL-STD-129 or ASTM D 3951, as applicable.

5.4.1 Polyethylene bagged unit packs. Polyethylene bagged unit packs shall have the required identification information legibly printed or stamped in black directly on the bag across the center face or on a white paper label inserted within the bag so as to permit ready identification.

6. NOTES

(This section contains information of a general or explanatory nature that may be helpful, but is not mandatory.)

6.1 Intended use. The jacket is intended for wear by Military personnel of the Department of Defense as part of the aviation crewman's clothing.

6.2 Acquisition requirements. Acquisition documents must specify the following:

- a. Title, number, and date of this specification.
- b. Size required (see 1.2).
- c. Issue of DODISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.1.1 and 2.2).
- d. When a first article sample is required (see 3.1, 4.3 and 6.3).
- e. Levels of preservation and packing (see 5.1 and 5.2).
- f. Type and class of unit load required (see 5.2.1).
- g. When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).
- h. When palletization is required (see 5.3).

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

6.4 Sample and shade samples. For access to sample of the end item and shade samples, address the contracting activity issuing the invitation for bids or request for proposal.

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6.5 Suggested resin. A suggested resin (3.3.8) for dipping the ends of slide fastener thongs is "No Fray No 64", Champion Packaged Products, Inc., 4939 South Austin Avenue, Chicago, IL 60638.

6.6 Subject term (key word) listing.

Aviation clothing
Outerwear

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

Custodians:

Army - GL

Review activities:

Army - MD
DLA - CT

Preparing activity:

Army - GL

(Project 8415-A704)

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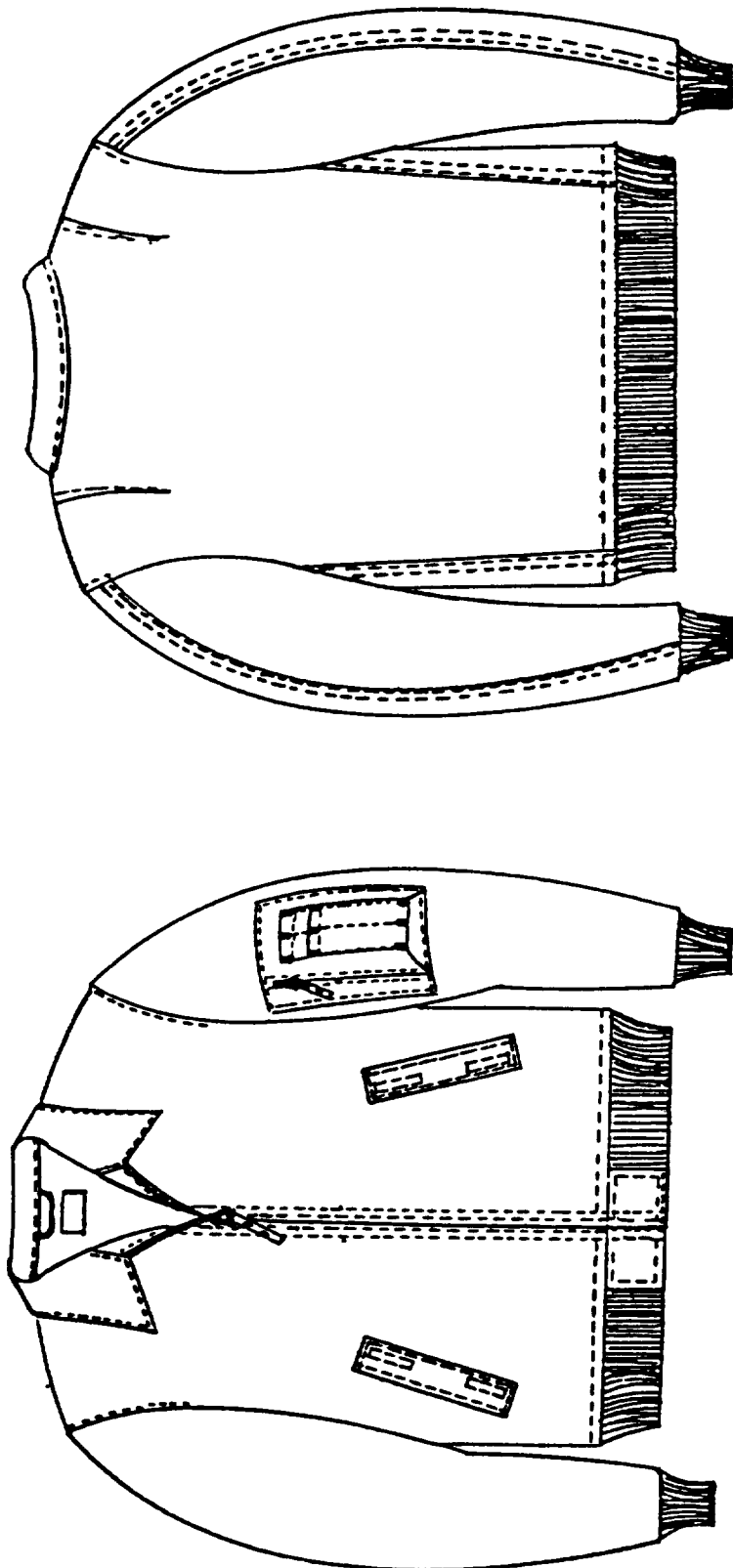


FIG 1-JACKET, FLYER'S: LIGHTWEIGHT
(EXPANDABLE WRISTS AND WAIST)

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

INSTRUCTIONS

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

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

I RECOMMEND A CHANGE:		1 DOCUMENT NUMBER MIL-J-43923C (GL)	2 DOCUMENT DATE (YYMMDD) 90/04/13
3 DOCUMENT TITLE JACKET, FLYER'S, LIGHTWEIGHT, (EXPANDABLE WRISTS AND WAIST)			
4 NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible Attach extra sheets as needed)			
5 REASON FOR RECOMMENDATION			
6. SUBMITTER			
a NAME (Last, First, Middle Initial)		b. ORGANIZATION	
c ADDRESS (Include Zip Code)		d TELEPHONE (Include Area Code)	
		7. DATE SUBMITTED (YYMMDD)	
		(1) Commercial	
		(2) AUTOVON (if applicable)	
B PREPARING ACTIVITY			
a NAME		b TELEPHONE (Include Area Code)	
U S Army Natick RD&E Center		(1) Commercial (2) AUTOVON	
		508-651-5221 256-5221	
c ADDRESS (Include Zip Code)		IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT Defense Quality and Standardization Office 5203 Leesburg Pike, Suite 1403, Falls Church, VA 22041-3466 Telephone (703) 756-2340 AUTOVON 289-2340	
Commander, U S Army Natick RD&E Center ATTN STRNC-ES Natick, MA 01760-5014			