

INCH-POUND

MIL-J-43967C  
17 April 1989  
SUPERSEDING  
MIL-J-43967B  
21 March 1985

MILITARY SPECIFICATION

JERSEY, REVERSIBLE

This specification is approved for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

- \* 1.1 Scope. This specification covers a reversible jersey.
- \* 1.2 Classification. The jersey shall be of the following types and sizes, as specified (see 6.2).

Type I - Black outside and gold inside.

Type II - Navy outside and yellow inside.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: U.S. Army Natick Research, Development, and Engineering Center, Natick, MA 01760-5014 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

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## MIL-J-43967C

<u>Schedule of sizes</u>	<u>Chest measurement (inches)</u>
X-Small	30-32
Small	34-36
Medium	38-40
Large	42-44
X-Large	46-48
XX-Large	50-52

## 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  
 DDD-L-20 - Label: For Clothing, Equipage, and Tentage  
 (General Use)  
 PPP-B-636 - Boxes, Shipping, Fiberboard

## MILITARY

- \* 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

## STANDARDS

## FEDERAL

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

MIL-J-43967C

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
- MIL-STD-1491 - Glossary of Knitting Imperfections

\* (Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from the Naval Publications and Forms Center, (ATTN: NPODS), 5801 Tabor Avenue, Philadelphia, PA 19120-5099.)

\* 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 19103-1187.)

\* (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 Guide sample. Samples, when furnished, are solely for guidance and information to the contractor (see 6.4). Variation from the document may appear in the sample, in which case the document shall govern.

\* 3.2 First article. When specified (see 6.2), a sample shall be subjected to first article inspection (see 6.3), in accordance with 4.3.

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

## MIL-J-43967C

3.3.1 Knitted cloth.

3.3.1.1 Jersey knit, cotton body and collarette cloth. The cloth for the inner and outer body and collarette of the jersey shall be made of single or 2-ply carded cotton yarn. The cloth shall be circular knit with a flat jersey stitch.

3.3.1.2 Shrinkage. The jersey knitted cloth shall be pre-shrunk by a mechanical shrinking process before being cut for the jersey. The preshrinking process used shall not be identified by name or trademark on the jersey or package. The finished jersey shall not shrink nor elongate more than 12.0 percent in any of the measurements A and B (see figures 1 and 2) when tested as specified in 4.4.4.

3.3.1.3 Alternate rib knit collarette. The alternate rib knit collarette cloth shall be made of single or 2-ply carded cotton yarns. The cloth shall be circular knit with a 1 X 1 rib knit.

3.3.1.4 Physical requirements. The knitted cloth shall conform to the requirements shown in table I when tested as specified in 4.4.1.1.

TABLE I. Physical requirements

Characteristics	Jersey knit cloth	Ribbed knit cloth
	Minimum	Minimum
Wales per inch	29	19
Courses per inch	35	25
Bursting strength, pounds	50	120
Weight (oz./sq.yd.)	--	8.0

\* 3.3.1.5 Color.

\* 3.3.1.5.1 Type I jersey. The color of the jersey knitted cloth shall be Black 421 and Gold 422. The jersey knit or the alternate rib knit collarette shall be Black 421 to match the outer fabric of the reversible jersey.

\* 3.3.1.5.2 Type II jersey. The color of the jersey knitted cloth shall be navy shade 3378 and yellow shade 3512. The color of the collarette shall be navy 3378 to match the outer fabric of the reversible jersey.

3.3.1.6 Finish. The cloth for the jersey shall be scoured, bleached or dyed. Resin finishes are prohibited (see 4.4.1.1.).

## MIL-J-43967C

\* 3.3.2 Thread. The thread shall be a cotton or rayon covered polyester core conforming to MIL-T-43548, ticket number 50, 2 or 3 ply for stitching and overedging or as an alternate, 162 denier high tenacity (18TEX) polyester thread having a minimum breaking strength of 1.5 lbs. The color of the thread shall match the black 421 knitted cloth for Type I, and navy 3378 knitted cloth for Type II. The thread shall show colorfastness to laundering (after 3 cycles) and light equal to or better than the standard sample or equal to or better than a rating of "good."

3.3.3 Label. Each jersey shall have a combination size, identification and instruction label conforming to type VI, class 14 of DDD-L-20. The body of the instructions shall be as follows:

## CARE INSTRUCTIONS

HAND OR MACHINE WASH IN COLD

OR WARM WATER (MAX. 110°F)

DO NOT BLEACH. TUMBLE DRY AT REGULAR

COTTON SETTING. WASH AND DRY EACH

JERSEY SEPARATELY.

\* 3.4 Design. The jersey shall be made of two layers of fabric to result in a reversible style. The color of the outer layer of the type I jersey shall be black and the color of the inner layer shall be gold. The color of the outer layer of the type II jersey shall be navy, and the color of the inner layer shall be yellow. The color of the collarete shall match the outer layer of the jersey.

\* 3.5 Figures. Figures 1 and 2 are furnished solely for guidance and information. Should variation from the written document appear in the figures, the written document shall govern.

3.6 Patterns. The jersey shall be made from the contractor's own patterns such that the jersey will conform to the finished measurements in table III.

\* 3.7 Construction. The construction shall conform in all respects to the requirements specified in table II and herein.

3.7.1 Stitches, seams and stitching. All stitches, seams and stitching shall conform to FED-STD-751. The type of seam, stitching and stitches per inch shall be as specified in table II. Seam allowances shall be maintained with seams sewn so that no raw edges, run-offs, twists, pleats, puckers or open seams occur. All seams shall start and finish evenly. Thread tension shall be maintained so that there is no tight or loose stitching.

## MIL-J-43967C

3.7.2 Type 504 stitching. The gage of the overedge stitching specified for stitching and seaming the shirt shall be  $3/16 \pm 1/16$  inch. The guide and knives for the overedge machine shall be set to trim only the ravelled edges of the fabric.

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

3.7.4 Thread breaks and ends of seams. Ends of all seams and stitching when not caught in other seams or stitching shall be securely tacked as specified in table II, operation 8. Thread breaks shall be secured by stitching back of the break not less than 1/2 inch.

3.7.4.1 Bartacks. Bartacks shall be  $3/4 \pm 1/16$  inch in length and  $1/8 \pm 1/32$  inch in width and shall contain 42 stitches. Bartacks shall be free from thread breaks, and loose or tight stitching.

\* 3.8 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 forwarded, the component shall conform to that pattern.

3.9 Manufacturing operations requirements. The jersey shall be made by and with the use of all operations in table II. Unless otherwise specified in table II, the contractor is not required to follow the exact shown sequence of operations listed. Any additional basting or holding stitching used to facilitate manufacture is permissible, providing the thread is removed or does not show on the jersey.

MIL-J-43967C

NO	TABLE II MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	BOBBIN/ LOOPER	COVER
1.	<p><u>Cutting.</u></p> <p>a. Cut the reversible jersey in strict accordance with the manufacturer's patterns which shall show directional lines, sizes and all notches for proper assembly of all parts.</p> <p>b. Cut all component parts (inner and outer) of the jersey knit cloth for the jersey lengthwise of the material in the direction of the wales except for the collarettes.</p> <p>c. Cut the jersey knit collarette from the same piece of jersey knit used for the outer material of the jersey in lengths, widths and directional lines as specified by the manufacturer's patterns.</p> <p style="text-align: center;">- OR -</p> <p>d. Cut the alternate rib knit collarette in lengths, widths and directional lines as specified by the manufacturer's patterns.</p>						
2.	<p><u>Replacement of defective components.</u></p> <p>Care shall be exercised during the spreading, cutting and manufacturing operations to assure that material defects and damages specified in 4.4.2 are excluded and replaced with non-defective and properly matched material.</p>						

MIL-J-43967C

NO	TABLE II (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	BOBBIN/ LOOPER	COVER
3.	<p><u>Shade and size marking.</u></p> <p>Mark, ticket or bundle all component parts to insure a uniform shade and proper assembly throughout the reversible jersey. Any method of marking may be used except:</p> <ul style="list-style-type: none"> <li>a. Corrosive-metal fastening devices.</li> <li>b. Sew-on type tickets.</li> <li>c. Adhesive type tickets which discolor the material or leave traces of paper or adhesive on the material after removal of the ticket.</li> <li>d. Pin tickets.</li> </ul>						
4.	<p><u>Seam bottom and attach combination label.</u></p> <p>Superimpose the inner and outer edges of the colored jersey cloths face to face and the edges of the combination label and stitch together. Identification and size portion of the label shall be visible on the front outer face of the jersey. The label shall be caught in the bottom seaming.</p>	504	SSa-1	10-14	50	50	50
5.	<p><u>Join bottom of sleeves.</u></p> <p>Position the inner and outer sleeves face to face and stitch sleeve opening.</p>	504	SSa-1	10-14	50	50	50



MIL-J-43967C

NO	TABLE II (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	BOBBIN/ LOOPER	COVER
6.	<p><u>Close sleeve and join shoulder.</u></p> <p>Position and seam sleeves individually color to color into armholes. Close top of sleeves from the end of sleeve, across armhole seam, joining the shoulders, in one continuous operation, the stitching shall terminate at the neck opening. The seams of the armholes shall be turned toward the neck opening.</p> <p style="text-align: center;">-OR-</p> <p><u>Join shoulder and underarm seam.</u> Close both shoulders from armhole to neck opening on inner body. Repeat procedure on outer body. Fold sleeves, inside out, and stitch underarm (from inner sleeve armhole, across sleeve opening seam, and finishing at outer sleeve armhole). Position inner sleeve to body; set inner sleeve. Move body aside; set outer sleeve to outer body. Repeat procedure for second side.</p>	504	SSa-1	10-14	50	50	50
7.	<p><u>Attach collarette.</u></p> <p>a. <u>Jersey knit collarette.</u> The collarette shall be made of single thickness of the basic material. The color of the collarette and thread shall be the same color as the outer fabric of the jersey.</p> <p>1. Seam the collar to the inner and outer jersey with the wales running perpendicular to the shoulder seam. The outside edge of the collarette shall be turned under <math>3/8 + 1/8</math> inch. The inside raw edge shall be covered by the looper thread. The stitching gage shall be <math>3/16 + 1/16</math> inch. The collarette</p>	504	SSa-1	10-14	50	50	50
		406	BSb-1	10-14	50	50	50

MIL-J-43967C

NO	TABLE II (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	BOBBIN/ LOOPER	COVER
7.	<p><u>Attach collarete.</u> (cont'd)</p> <p>ends shall overlap each other by 2 + 1/4 inch. The under portion of the overlapped collarete shall not be visible on the outside of the jersey. The top portion of the collarete shall terminate at the right shoulder seam.</p> <p>2. The end of the collarete shall be bartacked across the width of the collarete.</p> <p>3. The collarete shall finish <math>7/8 + 1/8</math> inch.</p> <p style="text-align: center;">- or -</p> <p>b. <u>Alternate collarete.</u> The alternate collarete shall be made of double thickness of ribbed knit cloth and shall be seamed to the jersey with the wales running perpendicular to the shoulder seam. The color of the collarete and thread shall be the same as the outer fabric of the shirt.</p> <p>1. Seam raw ends of collarete together forming a continuous collarete.</p> <p>2. Fold collarete to double thickness. (Seam allowance of the ends of the collarete to the inside.)</p> <p>3. Position bottom raw edges of the collarete to the neckline of the inner and outer jersey and with the end joining seam of the collarete superimposed on the left shoulder seam, join collarete to neckline of the jersey.</p>	Bartack	SSa-1	42 stitches per bartack	50	50	50
		504	SSa-1	10-14	50	50	50
		504	SSa-1	10-14	50	50	50

MIL-J-43967C

NO	TABLE II (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	BOBBIN/ LOOPER	COVER
7.	<p><u>Attach collarete.</u> (cont'd)</p> <p>4. Cover stitch the collar seam allowance. The stitching shall cover all raw edges of the collarete, with gage of stitching 3/16 inch. The collarete shall finish <math>7/8 + 1/8</math> inch.</p>	406	SSh-2b	10-14	50	50	50
8.	<p><u>Tacking.</u></p> <p>The ends of all stitchings when not caught in other seams or stitching shall be securely tacked by the following method:</p> <p>a. The first and last ends of the stitching chain shall be stitched back into the seam.</p> <p style="text-align: center;">- or -</p> <p>b. The ends of stitching may be chained off by a minimum length of 1/2 to 3/4 inch.</p>	504	SSa-1	10-14	50	50	50
9.	<p><u>Clean jersey.</u></p> <p>a. Trim and remove raw edges, and the ends of thread of stitching.</p> <p>b. Remove all spots and stains.</p>						
10.	<p><u>Fold jersey.</u></p> <p>Smooth out, flat fold jersey neatly for packaging (see section 5).</p>						

MIL-J-43967C

3.10 Finished measurements and weights. The finished measurements and weights of the jersey shall conform to the requirements in table III. All measurements and tolerances are expressed in inches.

The jersey shall be laid flat on a table and the measurements shall be taken as described below:

- A. 1/2 Chest. Measure from folded edge to folded edge of the body at a point 5 inches below armpit.
- B. Length. Taken on a straight line from the junction of the shoulder and collarette seams to bottom edge of jersey.
- C. Underarm sleeve length. Taken on a straight line from the junction of the bottom of the armhole and top of the side, along the bottom of the sleeve to the bottom of sleeve opening.
- D. Armhole. Taken from the junction of the shoulder and top of armhole and sleeve seams along armhole sleeve joining seam to bottom of armhole.
- E. Sleeve opening. Measure along bottom edge of sleeve from edge to folded edge.
- F. Neck opening. Neck opening shall be measured by grasping collarette at center back and center front, forming a straight line and measuring.

MIL-J-43967C

TABLE III. Finished measurements (inches) and weights (lbs., oz.)

Sizes	Width (A)	Length (B)	Sleeve underarm (C)	Armhole		Neck opening circumference (F)	Weight per dozen minimum, lbs., oz.
				length (flat) (D)	Sleeve opening (E)		
X-Small (30-32)	15	27	6	8-1/2	6	18	4 7
Small (34-36)	17	28	6-1/2	9	7	185	5 7
Medium (38-40)	19	29	6-1/2	10-1/2	7-3/4	19	6 2
Large (42-44)	21	30-1/2	6-1/2	10-1/2	7-3/4	20	7 0
X-Large (46-48)	23	32	7-1/2	11	8-1/4	20	8 0
XX-Large (50-52)	25	33	7-1/2	11-1/2	8-1/2	20	8 14
Tolerance	+ 1/2	+ 1	+ 1/4	+ 1/4	+ 1/4	+ 1	- -

## MIL-J-43967C

3.11 Workmanship. The finished reversible jersey shall conform to the quality of product established by this specification and the occurrence of defects shall not exceed the applicable acceptable quality levels.

## 4. 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 ensure 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).

## MIL-J-43967C

\* 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 and tested as specified in 4.4.4.

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.

\* 4.4.1.1 Component and material certification. A certificate of compliance may be acceptable as evidence that the components and materials listed below conform to the specified requirements.

<u>Component or material</u>	<u>Requirement paragraph</u>
Material identification	3.3.1.1 and 3.3.1.3
Yarn ply	3.3.1.1 and 3.3.1.3
Type of knit	3.3.1.1 and 3.3.1.3
Preshrinkage	3.3.1.2
Wales and courses per inch	3.3.1.4
Bursting strength	3.3.1.4
Weight per square yard	3.3.1.4
Finish	3.3.1.6
Alternate thread identification and breaking strength (when used)	3.3.2

4.4.2 End item visual examination. The jerseys shall be examined for the defects listed in table IV. The lot size shall be expressed in units of jerseys. The sample unit shall be one jersey. The inspection level shall be I and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 2.5 for major defects and 6.5 for total (major and minor combined) defects.

## MIL-J-43967C

TABLE IV. End item visual defects

Examine	Defect	Classification	
		Major	Minor
Material defects	Any hole, cut, tear, dropped stitch or run, thin place, or mend <u>1/</u>	101	
	Uneven, ridgy, or cockled cloth <u>1/</u>		201
	Loose knitting causing sleaziness		202
	Any slub (more than three times normal diameter of yarn and clearly visible) on outside of jersey <u>1/</u>		203
	Snag <u>1/</u>		204
	Foreign matter, neps, or specks <u>1/</u>		205
Color	Colors not as specified	102	
	Color of collarette not as specified	103	
	Thread color does not match color of outer fabric	104	
Shaded parts	Variation in shade within a part or between parts	105	
Cleanness	Spot or stain clearly noticeable on inside or outside of jersey - up to 1/4 inch inclusive		206
	- more than 1/4 inch	106	
	Any marking clearly visible on outside or inside	107	
	One or more markings tickets not removed		207
	Two or more untrimmed ends more than 3/4 inch in length inside or outside of jersey		208
Component and assembly	Any component part or required operation omitted or added (unless otherwise classified herein)	108	
	Any operation not performed as specified (unless otherwise classified herein)		209

1/ For knitted fabric imperfection definitions, see MIL-STD-1491.



## MIL-J-43967C

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

Examine	Defect	Classification	
		Major	Minor
Component and Assembly (cont'd)	Collarette not of specified thickness of cloth	109	
Cutting	Any component part not cut in accordance with specified pattern, directional lines on patterns, or document requirements	110	
Seams and stitching	Accuracy of seaming and stitching: Seams or part twisted, puckered, or pleated	111	
	Part of material caught in unrelated operation or stitching: - caught in up to and including 1/4 inch of stitching		210
	- caught in more than 1/4 inch of stitching	112	
	End of stitching when not caught in other seams or stitching not back- tacked as specified		211
	Stitching overlapping end of thread break less than 1/2 inch		212
	Ends of a continuous line of stitching overlapped less than 1/2 inch on all other continuous stitching		213
	Raw edges more than 1/4 inch long		214
	Gage of stitching and seam allowances: Irregular, i.e., unevenly gaged or corresponding stitchings not uniformly gaged (to be scored only when condition exists along major portion of seam)		215
	Width of seam allowance not as speci- fied or not within range of gage specified or varies more than 1/16 inch when no range is specified		216
	Stitches skipped, broken, missing, or run-off: All stitching except overedging: -up to 1/4 inch inclusive		217
	-more than 1/4 inch	113	

## MIL-J-43967C

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

Examine	Defect	Classification	
		Major	Minor
Seams and stitching (cont'd)	On overedging: (see "open seam" classification)		
	Seam and stitch type: -seam type or stitch type not as specified	114	
	Stitches per inch (to be scored only when condition exists on more than one-half the length of seam): - less than minimum or more than maximum specified		218
	Stitch tension: Loose tension resulting in a loose seam: - 1/2 to 3/4 inch inclusive - more than 3/4 inch	115	219
	Loose tension (exposed loops of top or bottom threads) more than 1/2 inch in length		220
	Tight tension (stitches break when strain is applied in direction of the seam or stitching)	116	
	Open seam: (on overedge stitching) - 1/4 to 1/2 inch inclusive - more than 1/2 inch	117	221
	NOTE: One or more broken or two or more continuous skipped or run-off stitches on joining seams constitutes an open seam.		
	Any seam not facing toward direction specified		222
	Chain stitch run-off not secured as specified		223
	Combination (size, identification and instruction label)	Omitted, incorrect, or illegible	118
Not positioned or attached as specified			224
Collarette - jersey knit	Collarette ends overlapped less than 1-3/4 or more than 2-1/4 inches		225

## MIL-J-43967C

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

Examine	Defect	Classification	
		Major	Minor
Collarette - jersey knit (cont'd)	Under portion of the overlapped collarette visible on outside of jersey for 1 inch or more		226
	Tacking omitted (see table II, operation 8)	119	
	Bartack omitted on collarette	120	
	Bartack or tack misplaced on collarette not serving intended purpose	121	
	Bartack or tack insecure on collar-ette		227
Collarette - jersey knit and alternate rib knit	Not attached to body of jersey as specified	122	
	Other than specified	123	
	Collarette not uniform in width		228
	Width less than 3/4 or more than 1 inch		229

4.4.3 End item dimensional examination. The finished jerseys shall be examined to determine compliance with dimensional requirements specified in 3.10. Before the examination is performed, the samples shall be conditioned in a normal atmosphere and in a relaxed supported state for a minimum of 1 hour. Any measurements deviating from the specified dimension and tolerance shall be scored a defect. Sleeves unequal in length by more than 1/2 inch shall be scored as a measurement defect. The lot size shall be expressed in units of jerseys. The sample unit shall be one jersey. 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 End item testing. The finished jerseys shall be tested as specified in table V. The methods of testing specified in FED-STD-191, wherever applicable, and as listed in table V shall be followed. The sample size for the shrinkage or elongation characteristic shall be as specified below. For the weight characteristic, the sample shall be one dozen jerseys of each size in the lot. If any jersey fails the shrinkage or elongation test, or if any size of jersey fails the weight per dozen test, the lot shall be rejected.

<u>Lot size (jerseys)</u>	<u>Sample size (jerseys)</u>
800 or less	2
801 to 20,000 inclusive	3
20,001 and over	5

## MIL-J-43967C

TABLE V. End item tests

<u>Characteristic</u>	<u>Requirement paragraph</u>	<u>Test method</u>
Shrinkage or elongation:		
Body width	3.3.1.2	7556 <u>1/</u>
Body length	3.3.1.2	7556 <u>1/</u>
Weight (conditioned jerseys) per dozen	Table III	<u>2/</u>

1/ Jerseys shall not be moistened or pressed before measuring. Measurements shall be taken to the nearest 0.1 of an inch with jerseys laid flat as shown on figures 1 and 2. Shrinkage or elongation shall be reported to the nearest 0.1 of a percent. Elongation shall be reported prefixed with a (-) sign.

2/ The twelve jerseys of each size shall be allowed to reach equilibrium, under standard conditions as defined in FED-STD-191, upon reaching equilibrium, each size (one dozen) shall be weighed as a unit under standard conditions and results reported to nearest 1 ounce.

\* 4.4.5 Packaging examination. The fully packaged jerseys 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.

<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 per container is more or less than required.

## MIL-J-43967C

- \* 4.4.6 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 dimensions	Length, width, or height exceeds specified maximum requirements
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. Each jersey shall be neatly folded in accordance with standard commercial practice. Each jersey shall be inserted in a close fitting clear polyethylene film bag conforming to A-A-50083.

5.1.2 Commercial. The jerseys 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. Sixty jerseys of the same type and 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. Each shipping container shall be closed in accordance with method III, water-proofed 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 4.4.5. 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.

## MIL-J-43967C

\* 5.2.2 Level B packing. Sixty jerseys of the same type and 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 200 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, minimum grade 200 of PPP-B-636. Each 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 4.4.5.

5.2.2.1 Weather-resistant fiberboard shipping containers. When specified (see 6.2), the fiberboard shipping container 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 4.4.5.

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

\* 5.3 Palletization. When specified (see 6.2), jerseys 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 bonded with primary and secondary straps in accordance with bonding means K and L or film bonding means O or P. Pallet pattern shall be in accordance with 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.

## 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 type I reversible jerseys are intended for use by Army personnel. The type II reversible jerseys are intended for use by Navy personnel.

\* 6.2 Acquisition requirements. Acquisition documents must specify the following:

- a. Title, number, and date of this specification.
- b. Type and 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).

## MIL-J-43967C

- d. When a first article is required (see 3.2, 4.3, and 6.3).
- e. Levels of preservation and packing (see 5.1 and 5.2).
- f. When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).
- g. 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 include specific instructions in acquisition documents regarding arrangements for selection, inspection, and approval of the first article.

6.4 Sample. For access to samples, address the contracting activity issuing the invitation for bids.

\* 6.5 Subject term (key word) listing.

Clothing, special purpose  
Overgarment  
Pullover shirt

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

## Custodians:

Army - GL  
Navy - NU  
Air Force - 99

## Preparing activity:

Army - GL  
(Project 8415-0665)

## Review activities:

Army - MD  
Air Force - 82  
DLA - CT

## User activity:

Air Force - 45

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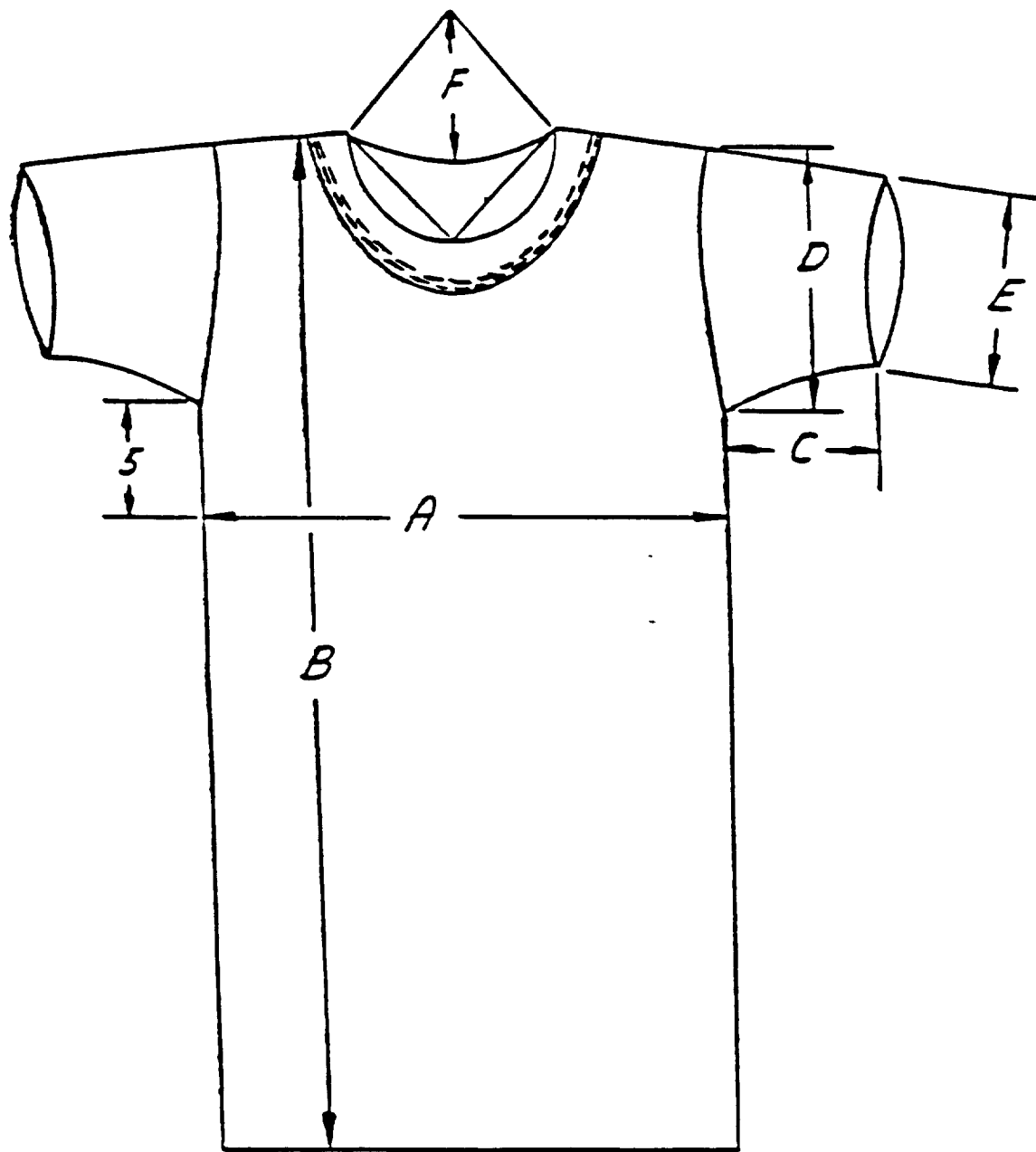


FIGURE-1 JERSEY, REVERSIBLE

2-1-1128



MIL-J-43967C

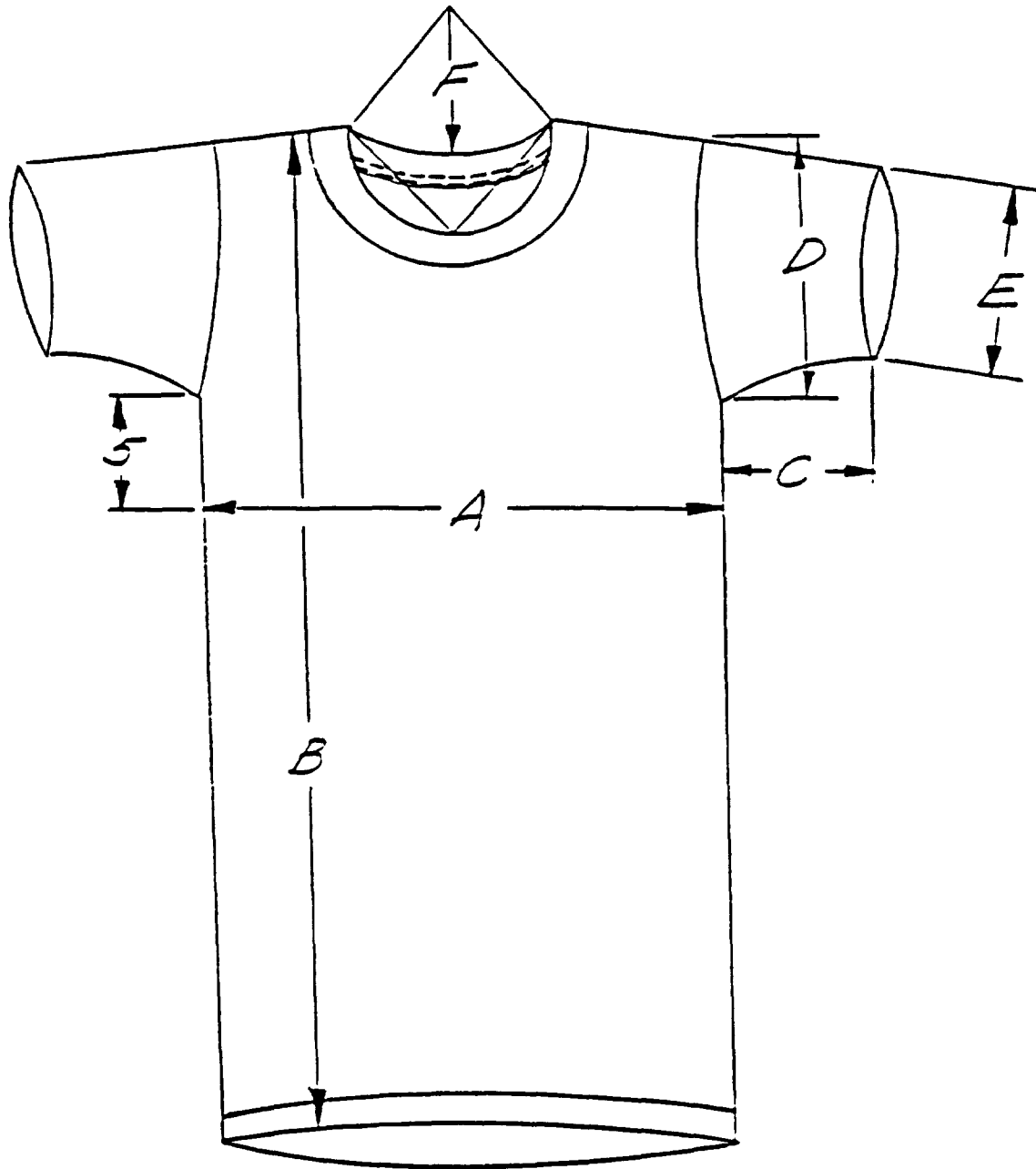


FIGURE 2 JERSEY, REVERSIBLE  
ALTERNATE COLLARETTE

2-1-1353

# STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

<b>1. DOCUMENT NUMBER</b> MIL-J-43967C		<b>2. DOCUMENT TITLE</b> Jersey, Reversible	
<b>3a. NAME OF SUBMITTING ORGANIZATION</b>		<b>4. TYPE OF ORGANIZATION (Mark one)</b> <input type="checkbox"/> VENDOR <input type="checkbox"/> USER <input type="checkbox"/> MANUFACTURER <input type="checkbox"/> OTHER (Specify): _____	
<b>b. ADDRESS (Street, City, State, ZIP Code)</b>			
<b>5. PROBLEM AREAS</b>			
<b>a. Paragraph Number and Wording:</b>			
<b>b. Recommended Wording:</b>			
<b>c. Reason/Rationale for Recommendation:</b>			
<b>6. REMARKS</b>			
<b>7a. NAME OF SUBMITTER (Last, First, MI) - Optional</b>		<b>b. WORK TELEPHONE NUMBER (Include Area Code) - Optional</b>	
<b>c. MAILING ADDRESS (Street, City, State, ZIP Code) - Optional</b>		<b>8. DATE OF SUBMISSION (YYMMDD)</b>	

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