



MIL-J-83472A(USAF)  
 23 December 1981  
 SUPERSEDING  
 MIL-J-83472 (USAF)  
 1 March 1976

## MILITARY SPECIFICATION

### JACKET, COLD WEATHER, SECURITY POLICE CWU-46/P

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

#### 1. SCOPE

1.1 Scope. This specification covers one type of cold weather jacket with a detachable collar. The jacket is designated CWU-46/P.

1.2 Sizes. The jacket shall be furnished in one of the following sizes as specified (see 6.2):

Short	30	32	34	36	38	40	42	44	46	48	50
Regular	30	32	34	36	38	40	42	44	46	48	50
Long	30	32	34	36	38	40	42	44	46	48	50.

#### 2.1 Government documents

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

#### SPECIFICATIONS

##### FEDERAL

P-D-680	Dry Cleaning Solvent
V-B-871	Button, Sewing Hole, and Button, Staple, (Plastic)
V-F-106	Fasteners, Slide. Interlocking
V-T-276	Thread, Cotton
V-T-280	Thread, Cotton, Gimp, Buttonhole
V-T-285	Thread, Polyester
DDD-L-20	Label: for Clothing, Equipage, and Tentage (General Use)
PPP-B-636	Boxes, Shipping, Fiberboard
PPP-T-45	Tape, Gummed, Paper, Reinforced and Plain, for Sealing and Securing

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: ASD, DEFENSE, Wright-Patterson AFB, OH 45433 by using the Department of Defense Standardization Document Improvement Proposal form, at the end of this document or by letter.

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MILITARY

MIL-F-495 Finish, Chemical, Black, for Copper Alloys  
 MIL-C-3735 Cuffs, Knit, Wrist and Ankle; and Cloth, Knitted  
 MIL-W-5664 Webbing, Textile, Elastic, Cotton  
 MIL-C-6590 Cloth, Pile (Synthetic Mouton, Knitted)  
 MIL-F-10884 Fasteners, Snap  
 MIL-F-21840 Fastener Tapes, Hook and Pile, Synthetic  
 MIL-B-41826 Batting, Synthetic Fibers: Polyester, (Quilted and Unquilted)  
 MIL-C-83453 Cloth, Twill, Nylon Warp, Rayon Filling

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  
 MS27980 Fasteners, Snap, Style 2 (Regular Wire Spring Clamp Type)

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

2.2 Other publications The following documents form a part of this specification to the extent specified herein. The issues of the documents which are indicated as DOD adopted shall be the issue listed in the current DODISS and the supplement thereto, if applicable.

The Color Association of the United States, Inc.

Department of Defense (DOD) Standard Shades for Buttons 1966

DOD Standard Color Card of Official Standardized Shades for Sewing Threads 1968

(Copies of these publications can be obtained from the The Color Association of the United States, Inc. 200 Madison Avenue; New York, New York 10016.)

2.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein, the text of this specification shall take precedence.

3. REQUIREMENTS

3.1 Materials

3.1.1 Basic fabric The basic fabric for the jacket and the material for the hanger, the patch pocket, the belt loops, and the collar interlining shall conform to type II of MIL-C-83453 and shall be USAF color shade No. 1017 (see 6.3).

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3.1.2 Quilted lining. The quilted lining shall conform to type III, class 3 style A of MIL-B-41826 except that one of the outer coverings and the quilting thread shall be USAF color shade no. 1157 (see 6.3).

3.1.3 Pocketing. The pocketing for the two slash pockets shall be a soft filled cotton sheeting or the basic fabric specified in 3.1.1. The soft filled cotton sheeting shall have a smooth suede finish on one side, shall be dyed grey or tan, and shall conform to the requirements specified in table I. Sulfur dyes or dyes that contain elementary sulfur or sulfur compounds capable of oxidation to sulfuric acid shall not be used.

TABLE I. Pocketing.

Characteristics	Requirements
Colorfastness to wet dry cleaning	Good
Colorfastness to crocking	Good
Weight	6 ounces per square yard, minimum
Yarn count	
Warp	44 threads per inch, minimum
Filling	40 threads per inch minimum
Breaking strength	
Warp	60 pounds, minimum
Filling	40 pounds, minimum

3.1.4 Buttons. The buttons shall be DOD Button Shade Blue BU, Cable No. 62002 (see DOD Standard Shades for Buttons 1966). The buttons shall conform to type II, class D, style 20 or 21 of V-B-871. The size of the button for the neck closure shall be 34 lines. The size of the buttons for the detachable collar shall be 24 lines.

3.1.5 Thread. Unless otherwise specified herein, the thread for all sewing shall be DOD Thread Shade Black AA, Cable No. 66043 (see DOD Standard Color Card of Official Standardized Shades for Sewing Threads 1968) and shall conform to type I, class 1, letter size B, 3 ply of V-T-285. As options, thread that conforms to type IA3, ticket No. 30, 3 ply of V-T-276 may be used to join the wristlets to the sleeve linings thread that conforms to type IA3, ticket Nos. 50 and 70, 2 or 3 ply of V-T-276 may be used to overedge the lining material.

3.1.6 Gimp. The gimp for reinforcing the buttonholes shall conform to type I or II, No. 8 of V-T-280 and shall be black.

3.1.7 Elastic webbing. The elastic webbing for shirring the waistband shall conform to class, 1, 2 inches wide, 0.35 inch thick (minimum), color black of MIL-W-5664. The length of elastic webbing shall conform to table II.

3.1.8 Snap fasteners. The snap fasteners shall conform to style 2, finish 2 of MIL-F-894 and shall consist of the following components: MS27980-7B (stud), MS27980-8B (washer), MS27980-1B (button), and MS27980-6B (socket).

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TABLE II. Lengths of elastic webbing.

Sizes of Jacket	Length of Elastic Webbing (Inches)
30	17
32	18-1/2
34	20
36	21-1/2
38	23
40	24-1/2
42	26
44	27-1/2
46	29
48	30-1/2
50	32

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3.1.9 Knitted synthetic mouton. The knitted synthetic mouton for the detachable collar shall conform to type I of MIL-C-6590 except that the color shall be USAF color shade no. 1157 (see 6.3)

3.1.10 Wristlets. The wristlets for the inside of the sleeves shall conform to type I, class 2, size 1 of MIL-C-3735 and shall be USAF color shade no. 1157 (see 6.3)

3.1.11 Slide fastener. The slide fastener for the front closure shall conform to type IV, style 8, size MH of V-F-106. The color of the slide fastener tape shall be USAF color shade no. 1157 (see 6.3). All metal components of the slide fastener shall be brass with a black chemical finish in accordance with MIL-F-495, except that the slider may be zinc with a black chemical finish. The length of the slide fastener shall conform to table III.

3.1.2 Fastener tape. The fastener tape for the nameplate shall be 2 inches wide. The color of the fastener tape shall approximately match the color of the basic fabric. The fastener tape shall conform to type I, class 1 of MIL-F-21840 except that the colorfastness to laundering shall not apply.

3.1.13 Vinyl coated fabric. The strips for the bottom of the sleeves shall conform to Style No. 121 (manufactured by the Scottalia Textile Mills; 247 West 38th Street, New York, New York), or equal, and shall meet the following requirements: The base fabric shall be 100 percent cotton, shall be sateen weave, and shall weigh 8 ounces per square yard. The coating shall be face 100 percent urethane. The finished coated vinyl cloth shall weigh a minimum of 15 ounces per square yard, shall be black, and shall be dry cleanable.

3.2 Design. The jacket shall be single breasted and shall have a front closure that consists of a button and a buttonhole at the neck, snap fasteners, and a slide fastener. The jacket shall have a quilted lining, a shirred waistband, and inside patch pocket on the right lining, notched collar and lapels, two welt-type of slash pockets with snap fasteners on the front, and a badge tab on the left front, fastener tape for a nameplate on the right front, a knitted wristlet inside each sleeve, and a detachable collar. The detachable collar shall have a topcollar that is made of knitted synthetic mouton and shall be attached to the jacket by means of buttonholes, buttons, and snap fasteners.

3.3 Construction. The jacket shall be constructed in accordance with table IV. Unless otherwise specified herein, the manufacturer will not be required to follow the exact sequence of operations as listed therein.

3.3.1 Stitches, seams, and stitchings. Stitches, seams, and stitchings specified in table III shall conform to FED-STD-751. Wherever two or more methods, seams, or stitches are specified for the same operation, any one of them may be used. All seams shall start and finish evenly. Seam allowances shall be maintained so that raw edges, run-offs, twists, pleats, puckers, or on seams will not result. Thread tension shall be maintained so that tension will not be tight or loose. The looper thread (under thread) of stitch 401 shall be on the inside of the jacket.

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TABLE III. Lengths of slide fastener.

Sizes of Jackets	Lengths of Slide Fasteners (Inches)
<u>Short</u>	
30	10-3/4
32	11
34	11-1/4
36	11-1/2
38	11-3/4
40	12
42	12-1/4
44	12-1/2
46	12-3/4
48	13
50	13-1/4
<u>Regular</u>	
30	11-3/4
32	12
34	12-1/4
36	12-1/2
38	12-3/4
40	13
42	13-1/4
44	13-1/2
46	13-3/4
48	14
50	14-1/4
<u>Long</u>	
30	12-3/4
32	13
34	13-1/4
36	13-1/2
38	13-3/4
40	14
42	14-1/4
44	14-1/2
46	14-3/4
48	15
50	15-1/4

TABLE IV. Sewing operations.

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
1	<p><u>Cut and shade mark parts</u></p> <p>(a) Lay the cloth in uniform lengths. Take care in spreading the cloth so that the plies will not be stretched or full and so that one side of the lay will be even. Unless otherwise specified herein, lay the patterns in accordance with the directional lines (warp direction of the cloth) indicated on the patterns. The knitted synthetic mouton for the removable collar may be cut in either the warp or the filling direction of the knitted synthetic mouton.</p> <p>(b) Cut the parts of the jacket in strict accordance with the patterns which show size, directional lines for cutting, markings, notches, and shape for the proper assembly of the parts.</p> <p>(c) Except for parts that may be cut from ends, cut all parts made of the basic fabric from one piece of the basic fabric. The hanger, the patch pocket, the belt loops, and the collar interlining may be cut from ends of the basic fabric but shall approximate the shade of the other parts made of the basic fabric. The waistband may be cut in one piece or two pieces. Pocketing, if cut from basic fabric, may be cut from ends.</p>			

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TABLE IV. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
2	<p>(d) Cut the parts made of quilted lining so that the exposed side of the quilted lining in the finished jacket will be blue. Except for the sleeve linings, cut all parts made of the quilted lining from one piece of the quilted lining. The sleeve linings may be cut from ends of the quilted lining but shall match each other.</p> <p>(e) Replace at the time of cutting any part that contains any material defect that could affect the appearance or the serviceability of the jacket.</p> <p>(f) Mark, ticket, or bundle all parts of the basic fabric and of the quilted lining, except the parts that are cut from ends, to ensure a uniform shade and size throughout the jacket. The marking may be any method except adhesive-type tickets that will leave traces of paper or adhesive on the material after the tickets are removed or metal fastening devices.</p> <p><u>Overedge stitch raw edges</u></p> <p>(a) Except for the front edges of quilted lining, overedge stitch all raw edges of the quilted lining.</p>	504 or 505	EFd-1	6-10

TABLE IV. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
3	<p><u>Replace damage parts</u></p> <p>(a) Replace during the manufacturing operations any part that contains any workmanship damage that could affect the appearance or serviceability of the jacket.</p>			
4	<p><u>Make and attach badge tab</u></p> <p>(a) Fold the badge tab so that the edges abut at the center and double stitch not less than 3/16-inch gage, using a cover stitch on the underside.</p> <p>(b) Make two cut-first eyelets in the badge tab as indicated by the pattern marks.</p> <p>Note: The opening of each eyelet in the badge tab shall be 1/8 inch to 3/16 inch in diameter.</p> <p>(c) Place the badge tab on the left front as indicated by the pattern marks and stitch 1/16 inch from the edge.</p>	406	EFh-1	6-10
5	<p><u>Make belt loops</u></p> <p>(a) Fold the stripping for the belt loops so that the edges abut at the center; double stitch the stripping not less than 3/16-inch gage, using a cover stitch on the underside, or attach using two 7/8-inch bartacks.</p>	304 or 404 eyelet	LSd-1	19-24 stitches per eyelet
		301	LSd-1	12
		406	EFh-1	6-10

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TABLE IV. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
6	<p>(b) Cut the stripping into four pieces that are each 4 inches long.</p> <p><u>Make sleeve lining</u></p> <p>(a) Join the elbow seam of each sleeve lining with a 1/2 inch seam.</p> <p>(b) Join the inseam of each sleeve lining (leaving approximately a 10-inch opening in the right inseam) with a 1/2 inch seam.</p>	301 or 401	SSa-1	
7	<p><u>Attach wristlets</u></p> <p>(a) Serge around the raw edges of each folded cuff.</p> <p>(b) Sew the serged top edges of the wristlets to the sleeve linings with 3/8-inch seams so that the bottom of each wristlet will be even with the bottom raw edges of the sleeve lining and so that the 3/8-inch seam will be hidden on the underside when wristlet is positioned as worn</p> <p>Note: No 7(a) shall be performed before No. 7(b).</p>	504 or 505	SSa-1	6-8
		301 or 401	SSa-2	10-12

TABLE IV. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
8	<p><u>Make sleeves</u></p> <p>(a) Join the inseam of each sleeve, with the topsleeve overlapping the undersleeve, 3/16 to 1/4 inch from the turned edge.</p> <p style="text-align: center;">OR</p> <p>(b) Join the inseam of each sleeve with a double-lapped, double-stitched seam.</p> <p>(c) Join the elbow seam of each sleeve with a double-lapped, double-stitched seam 3/16-inch to 5/16-inch gage.</p>	<p>301 or 401</p> <p>301 or 401</p> <p>301 or 401</p>	<p>LSq-2</p> <p>LSc-2</p> <p>LSc-2</p>	<p>12</p> <p>12</p> <p>12</p>
9	<p><u>Make detachable collar</u></p> <p>(a) Join the sides and the bottom of the lower collar attachment tab 1/4 inch from the edge.</p> <p>(b) Turn and raise the sides and the bottom of the lower collar attachment tab 1/4 inch from the edge.</p> <p>(c) Make five cut-after, taper-bar-type buttonholes in the lower collar attachment tab to fit a 24-line button, as indicated by the pattern marks, with the end of each buttonhole 3/8 inch (plus or minus 1/16 inch) from the edge. The purl shall finish on the top of the finished overcollar tab.</p>	<p>301 or 401</p> <p>301</p> <p>304</p>	<p>SSe-2(a)</p> <p>SSe-2(b)</p> <p>purl type or</p> <p>whip type</p>	<p>12</p> <p>12</p> <p>42-46 stitches per buttonhole including tack 11 stitches per buttonhole</p>

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TABLE IV. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	<p>(d) Place the lower collar attachment tab between the two topcollars (one of basic fabric and one of knitted synthetic mouton) as indicated by the pattern marks at the bottom of the collar and stitch across the bottom 3/8 inch from the edge.</p> <p>(e) Turn and raise on the undercollar across the bottom 1/8 inch from the edge.</p> <p>(f) Join the undercollar at the bottom with a 3/8-inch seam.</p> <p>(g) Turn and raise the undercollar at the bottom with a 1/4-inch seam.</p> <p>(h) Install the buttons and the sockets of the five snap fasteners in the undercollar as indicated by the pattern marks.</p> <p>(i) Place the undercollar on the topcollar, and stitch the sides and the top of the collar with a 1/4-inch over-edge stitch.</p> <p>(j) Turn and raise on the undercollar, starting 3 inches from the points of the collar, 1/16 inch from the edge.</p>	<p>301 or 401</p> <p>301</p> <p>301 or 401</p> <p>301</p> <p>516 or 519</p> <p>301</p>	<p>SSaw-2(a)</p> <p>SSaw-2(b)</p> <p>SSe-2(a)</p> <p>SSe-2(b)</p> <p>SSa-2</p> <p>LSq-2(b)</p>	<p>12</p> <p>12</p> <p>12</p> <p>12</p> <p>8-10</p> <p>8-10</p>

TABLE IV. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
10	<p><u>Make collar</u></p> <p>(a) Place the collar interlining on the undercollar, and install the studs and the eyelets of the five snap fasteners in the collar as indicated by the pattern marks.</p> <p>(b) Place the topcollar on the undercollar and stitch the sides and the top of the collar with a 3/8-inch seam</p> <p>(c) Turn the collar, force out the edges, and raise stitch the collar 1/4 inch from the edge.</p>	301 or 401	SSe-2(a)	12
11	<p><u>Make patch pocket</u></p> <p>(a) Fold the top hem of the patch pocket down in accordance with the pattern marks and stitch 1/2 inch from the folded edge.</p>	301	EFb-1	12
12	<p><u>Attach patch pocket</u></p> <p>(a) Place the patch pocket on the face side of the right front lining as indicated by the pattern marks and stitch 1/16 inch from the folded edge.</p>	301	LSd-1	12

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TABLE IV. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
13	<p><u>Attach facing</u></p> <p>(a) Place the left facing on top of the left front lining. Fold under the back edge of the left facing 3/8 inch and stitch 1/16 inch from the edge all around the left facing. Place the right facing on top of the right front lining. Fold under the back edge of the right facing and stitch 1/16 inch from the edge all around the right facing, with the folded edge of the right facing overlapping the patch pocket.</p>	301 or 401	LSD-1 and SSA-1	12
14	<p><u>Join lining</u></p> <p>(a) Join the side seams of the lining with a single row of stitching 3/8 inch from the edge.</p> <p>(b) Join the shoulder seams of lining with a single row of stitching 3/8 inch from the edge.</p> <p>(c) Join the sleeve linings to the armholes of the lining with a single row of stitching 3/8 inch from the edge.</p>	301 or 401	SSA-1	12
		301 or 401	SSA-1	12
		301 or 401	SSA-1	12

TABLE IV. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
15	<p><u>Make hanger</u></p> <p>(a) Fold the hanger in half, with the raw edges turned in, and stitch 1/16 to 1/8 inch from each edge.</p> <p style="text-align: center;">OR</p> <p>(b) Doublestitch the hanger 1/8 to 1/4 inch with a covering stitch on the underside.</p>	301	EFp-2	10-12
16	<p><u>Attach hanger</u></p> <p>(a) Position the hanger, 2-1/2 inches below the raw edge of the quilted lining, at the center of the back. Turn under the ends of the hanger and sew the hanger to the quilted lining with a double row of stitching 1/4 inch apart and 1/16 to 1/8 inch from the turned-under ends of the hanger.</p>	301 or Bartack	LSd-2 LSd-1	10-12 28 stitches per bartack

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TABLE IV. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
17	<p><u>Attach label</u></p> <p>(a) Position the combination identification and size label, on the quilted lining, at the center of the back, so that the top edge of the combination identification and size label will be 2-1/2 inches (plus or minus 1/4 inch) from the neck seam line in the finished jacket and directly below the hanger. Join the combination identification and size label on all four sides to the quilted lining with a single row of stitching 1/16 inch from the edge.</p>	301	LSbj-1	10-12
18	<p><u>Install slide fasteners and snap fasteners</u></p> <p>(a) Attach the slide fastener to the right front edge of the lining, at the notches, with a single row of stitching 3/8 inch from the edge.</p> <p>(b) Attach the slide fastener to the left front facing, at the pattern marks, with two rows of stitching, with the first row 1/8 inch from the edge and the second row 3/8 inch from the edge. Secure the lower end of the slide fastener with a 3/8-inch-long bartack superimposed on the 3/8-inch stitching.</p>	301 Bartack	SSa-1  SSa-1	12  12 28 stitches per bartack

TABLE III. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
19	<p>(c) Stamp the buttons and the sockets of the three snap fasteners in the left lining facing as indicated by the pattern marks.</p> <p><u>Make two slash pockets</u></p> <p>(a) Turn under the inner edge of the welt and the facing pieces and sew to the pocketing 1/16 inch from the edge.</p> <p>(b) Sew the two pieces of the pocketing on the fronts, at the drill marks, with a single row of stitching.</p> <p>(c) Cut the opening for the pocket, tongue notching each end.</p> <p>Note: The opening of each finished slash pocket shall be 6 inches (plus or minus 1/4 inch) wide.</p> <p>(d) Turn the pocketing through the slit; double over at the front edge for reinforcement to form a welt. Raise stitch the bottom of the welt through the front and the pocketing with a single row of stitching 1/16 inch from the edge.</p> <p>Note: The welt in each finished slash pocket shall be 7/8 inch (plus or minus 1/8 inch) wide.</p>	301	LSd-1	12
		301	SSa-1	12
		301	LSq-2	12

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TABLE IV. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
20	(e) Seam the tongues at the ends on the inside through the welt and the facing with a single row of stitching.	301	SSa-1	12
	(f) Raise stitch the seam joining the facing to the opening and the ends of the opening through the slash pocket with a single row of stitching 1/16 inch from the edge.	301	LSq-2	12
	(g) Sew around the pocketing with a single row of stitching 1/2 inch from the edge.	301	SSa-1	12
	(h) Bartack the corners of each pocket opening with a 7/8-inch bartack.	304		42 stitches per bartack
	<u>Install snap fasteners in slash pockets</u>	(a) Install a button and a socket of a snap fastener, centered on the width and the length of the welt, in the welt of each slash pocket.		

TABLE IV. Sewing Operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
21	<p>(b) Install a stud and an eyelet in the facing of each slash pocket to correspond with the button and the socket of the snap fastener in the welt of the slash pocket.</p> <p><u>Attach fastener tape</u></p> <p>(a) Position a piece of pile fastener tape that is 2 inches wide and 4 inches long above the right pocket at the pattern marks. Join the pile fastener tape on all four sides with a single row of stitching 1/16 inch from the edge, or attach the pile fastener with a T 640 Heat Bond Applicator Model 176 (manufactured by the Minnesota Mining and Manufacturing Co.; 3M Center; St. Paul Minnesota), or equal.</p> <p>(b) Affix a piece of hook fastener tape that is 2 inches wide and 4 inches long to the pile fastener tape.</p>	301	LSbj-1	12
22	<p><u>Make waistband</u></p> <p>(a) If the waistband is cut in two pieces, join the waistband at the center back with a single row of stitching 3/8 inch from the edge.</p>	301 or 401	SSa-1	12

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TABLE IV. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	<p>(b) Install the buttons and the sockets of the two snap fasteners, in accordance with the drill marks, in the left side of the waistband.</p> <p>Note: The socket of each snap fastener in the left side of the waistband shall be reinforced with a piece of the basic fabric.</p> <p>(c) Fold each belt loop lengthwise; and stitch each folded belt loop to the waistband, as indicated by the pattern marks, 1/8 inch from the edge.</p> <p>(d) Stitch the ends and the center of the elastic webbing to the underside of the waistband at the ends and the center of the waistband, respectively.</p> <p>(e) Fold the waistband in half, and sew through all three layers with two rows of stitching, with the first row 7/8 inch from the folded edge and the second row 1-3/4 inches from the folded edge.</p>	301 or 401	SSa-1	12
23	<p><u>Join outer shell</u></p> <p>(a) Join each side seam of the outer shell with a single row of stitching 3/8 inch from the edge.</p>	301 or 401	LSdd-2(a) SSa-1	12

TABLE IV. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	(b) Join each shoulder seam of the outer shell with a single row of stitching 3/8 inch from the edge.	301 or 401	SSa-1	12
	(c) Join the collar to the neck of the outer shell with a single row of stitching 3/8 inch from the edge.	301 or 401	SSa-1	12
	(d) Join the sleeves to the armholes of the outer shell with a single row of stitching 3/8 inch from the edge.	301 or 401	SSa-1	12
24	<u>Attach waistband</u>			
	(a) Join the side of the waistband without the belt loops to the bottom of the outer shell with a single row of stitching 3/8 inch from the edge.	301 or 401	SSa-1	12
25	<u>Join lining to outer shell</u>			
	(a) Join the lining to the outer shell at each wrist with a single row of stitching 3/8 inch from the edge.	301 or 401	SSa-1	12
	(b) Join the lining to the outer shell at the waistband with a single row of stitching 3/8 inch from the edge.	301 or 401	SSa-1	12

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TABLE IV. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
26	<p>(c) Sew the front edges of the outer shell to the lining, starting at the bottom of the waistband, up one of the fronts, across the neck, and down the other front to the bottom of the waistband.</p> <p><u>Turn and finish jacket</u></p> <p>(a) Turn the jacket right side out through the opening in the right sleeve inseam; turn in the raw edges the width of the seam, and stitch the opening 1/8 inch from the edge.</p> <p>(b) Raise starting 6 inches back on the waistband at the bottom and up the fronts to the collar 1/4 inch from the edge.</p> <p>(c) Close the slide fastener. Mark the location on the right front for the studs and the eyelets of the three snap fasteners to correspond with the buttons and the sockets of the three snap fasteners on the left front. Install the studs and the eyelets of the three snap fasteners at the marked location.</p> <p>(d) Stamp the studs and the eyelets of the two snap fasteners in the right side of the waistband, as indicated by the pattern marks, to correspond with the buttons and the sockets of the snap fasteners in the left side of the waistband.</p>	301 or 401  301  301	SSa-1  SSc-1  SSe-2(b) and SSa-2(b)	12  12  12

TABLE IV. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
27	<p>(e) Sew the fly, 1-3/4 inches from the left edge, starting 4 inches down from the collar seam and ending at the bottom of the waistband.</p> <p><u>Make buttonhole in left front</u></p> <p>(e) Make a cut-first or cut-after buttonhole in the left front at the neck opening, 1 inch from the top edge, with the eyelet 5/8 inch from the front edge.</p> <p>Note: The buttonhole shall be the eyelet-end, square-bar-type buttonhole, worked over gimp, to fit a 34-line button. The gimp shall be pulled through to the underside and caught in the bartacking. The purling of the buttonhole shall be on the facing side.</p> <p>(b) Bartack the buttonhole in a separate operation from the buttonhole making.</p> <p>Note: The bartack at the end of the buttonholes shall be not more than 3/16 inch long.</p>	<p>301</p> <p>Button-hole</p> <p>Bartack</p>	<p>SSa-1</p>	<p>12</p> <p>52 stitches per buttonhole not including bartack</p> <p>21 stitches per bartack</p>

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TABLE IV. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
28	<p><u>Attach vinyl strips</u></p> <p>(a) Fold the vinyl strips in half. Stitch a folded vinyl strip to the bottom of each sleeve so that the folded edge of the vinyl strip will extend 1/8 inch below the outer shell of the sleeve.</p>	301	SSa-1	12
29	<p><u>Sew on buttons</u></p> <p>(a) Position and sew a 34-line button on the right front at the neck opening to correspond with the buttonhole on the left front at the neck opening so that the neck opening, when buttoned, will be not more than 1-1/2 inches.</p>	101 or  301 or		21-24 stitches per button 14-16 stitches per button 4-6 double thread stitches per button

TABLE IV. Sewing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
30	<p>(b) Attach the detachable collar to the jacket. Mark the position for five 24-line buttons, in accordance with the overcollar-bottom button marker, on the inside of the jacket to correspond with the buttonholes in the lower collar attachment tab (overcollar bottom). Sew the five 24-line buttons to the jacket at the marked locations.</p> <p>Note: The center button shall be reinforced with a 1-inch-square piece of the basic fabric.</p> <p><u>Clean jacket and attach collar</u></p> <p>(a) Trim the ends of stitching. Remove the loose threads from the jacket.</p> <p>(b) Remove all spots and stains.</p> <p>(c) Remove the shade tickets.</p> <p>(d) Fasten the detachable collar to the jacket.</p>	101 or  301 or  Hand		21-24 stitches per button 14-16 stitches per button 4-6 double thread stitches per button

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3.3.1.1 Thread breaks and ends of seams and stitchings. Thread breaks of all stitch types shall be secured by stitching back of each end not less than 1/2 inch. Skipped stitches or thread breaks of stitch type 401 may be repaired using stitch type 301. Ends of all seams and stitchings produced with stitch type 301, except for ends of seams and stitchings caught in other seams or stitchings and ends of continuous line of stitching, shall be backtacked not less than 1/4 inch. The ends of a continuous line of stitching, except on labels, shall be overlapped not less than 1/2 inch. The ends of stitchings on labels shall be overlapped not less than three stitches.

3.3.1.2 Sewing tolerances. Unless otherwise specified herein, a tolerance of plus or minus 2 stitches per inch will be permitted for stitches per inch. A tolerance of plus or minus 1/16 inch will be permitted for 1/4-inch-gage and 5/16-inch-gage stitching. A tolerance of plus 0 or minus 1/8 inch will be permitted for 3/8-inch-gage stitching. A tolerance of plus 0 or minus 1/16 inch will be permitted for raise seam 1/4-inch-gage. A tolerance of plus 1/32 or minus 0 inch will be permitted for stitching 1/16 inch from the edge.

3.3.2 Cutting. The jacket shall be cut from the materials specified herein in accordance with the pattern parts listed in table V. The elastic webbing shall be cut the length that is specified in table II.

3.4 Patterns. When specified (see 6.2), standard patterns and the overcollar-bottom button marker (all sizes) will be furnished by the Government. The standard patterns shall be used by the manufacturer to cut the working patterns. The working patterns shall be identical in size and shape to the standard patterns. The standard patterns and the working patterns shall not be altered in any way.

3.5 Finished measurements. The finished measurements of the jacket shall conform to table VI. The finished measurements of the jacket shall be taken as follows: Measure the back length, at the center of the back, from the neck seamline at the bottom of the undercollar to the bottom of the waistband. Measure the sleeve inseam, along the seamline of the inseam, from the armhole seamline to the bottom of the sleeve. Measure the 1/2 chest, with the slide fastener and the front closed and with the jacket flat on a table, from folded edge to folded edge at the base of the armhole level.

3.6 Identification of product. The jacket shall have a combination identification and size label. The combination identification and size label shall conform to type I, classes 1 and 2 of DDD-L-20 except that the specification number and the words "Dry Clean Only" shall be included on the label. The combination identification and size label shall have colorfastness to both laundering and dry cleaning.

3.7 Workmanship. The jacket shall be manufactured in a thoroughly workmanlike manner.

TABLE V. Pattern parts and marker.

Materials	Pattern Parts and Marker	Parts Cut
Basic fabric (see 3.1.1)	Back	1
	Front (right)	1
	Front (left)	1
	Pocket welt	4
	Patch pocket	1
	Waistband	1 or 2
	Collar	3
	Overcollar	1
	Lower collar attachment tab	2
	Overcollar (bottom)	2
	Front facing	2
	Topsleeve	2
	Undersleeve	2
	Stripping for belt loops	4
Badge tab	1	
Quilted lining (see 3.1.2)	Front	2
	Back	1
	Topsleeve	2
	Undersleeve	2
Pocketing (see 3.1.3)	Slash pocket <u>1/</u>	4
Elastic webbing (see 3.1.7)	waistband	1
Knitted synthetic mouton (see 3.1.9)	Overcollar	1
Vinyl coated fabric (see 3.1.13)	Sleeve bottom	2
	Overcollar-bottom button marker (all sizes)	1

1/ As an option, the parts of the two slash pockets may be cut from the basic fabric.

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TABLE VI. Finished measurements

Size of Jacket	Finished Measurements in Inches 1/ 2/						
	Back Length			Sleeve Inseam			1/2 Chest
	Short	Regular	Long	Short	Regular	Long	
30	24	25	26	17-1/4	18-1/4	19-1/4	19-1/2
32	24-1/4	25-1/4	26-1/4	17-1/4	18-1/4	19-1/4	20-1/2
34	24-1/2	25-1/2	26-1/2	17-1/4	18-1/4	19-1/4	21-1/2
36	24-3/4	25-3/4	26-3/4	17-1/4	18-1/4	19-1/4	22-1/2
38	25	26	27	17-1/4	18-1/4	19-1/4	23-1/2
40	25-1/4	26-1/4	27-1/4	17-1/4	18-1/4	19-1/4	24-1/2
42	25-1/2	26-1/2	27-1/2	17-1/4	18-1/4	19-1/4	25-1/2
44	25-3/4	26-3/4	27-3/4	17-1/4	18-1/4	19-1/4	26-1/2
46	26	27	28	17-1/4	18-1/4	19-1/4	27-1/2
48	26-1/4	27-1/4	28-1/4	17-1/4	18-1/4	19-1/4	28-1/2
50	26-1/2	27-1/2	28-1/2	17-1/4	18-1/4	19-1/4	29-1/2

- 1/ The finished measurements shall be taken as specified :
- 2/ The tolerance for the finished measurements shall be plus or minus 1/8 inch for the back length and the sleeve inseam and plus or minus 1/4 inch for the 1/2 chest.

#### 4. QUALITY ASSURANCE PROVISIONS

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

4.2 Classification of inspection. The inspection required by this specification is classified as quality conformance inspection.

4.2.1 Quality conformance inspection. The quality conformance inspection shall consist of the following:

- a. Material and component inspection
- b. End item inspection
- c. Preparation for delivery inspection.

4.2.2 Material and component inspection. Materials and components shall be examined and tested in accordance with all of the applicable subsidiary documents referenced herein to the extent applicable. The unit for the expression of the lot size and the sample size for the materials and the components shall be as specified in the applicable subsidiary documents. In addition to the examinations and the tests specified in the applicable subsidiary documents referenced herein, the pocketing and the vinyl coated fabric shall be tested as specified in the table VII. All requirements for the pocketing and the vinyl coated fabric shall be applicable to the sample unit. The inspection level for the pocketing and the vinyl coated fabric shall be S-1 of MIL-STD-105. The acceptable quality level for pocketing and the vinyl coated fabric shall be 6.5 test failures per 100 units. The expression of the lot size of the pocketing and the vinyl coated fabric shall be yards. The sample unit for the pocketing and the vinyl coated fabric shall be 1 yard full width. The sample size for the pocketing and the vinyl coated fabric shall be as specified in table VIII.

4.2.2.1 Certificates of compliance. If a certificate of compliance is submitted for any requirement specified herein, the Government shall have the right to check test items to determine the validity of the certification

4.2.3 End item inspection. The end item shall be examined as specified in 4.2.3.1 and 4.2.3.2. The sample unit for these examinations shall be one jacket.

4.2.3.1 Visual examination. The end item shall be visually examined for the defects listed in table IX. The inspection level for this visual examination shall be II of MIL-STD-105. The acceptable quality level for this visual examination shall be 2.5 defects per 100 units (dhu) for major defects, 15.0 dhu for major and minor A defects, and 40.00 dhu for major and minor A and minor B defects.

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TABLE VII. Test methods.

Characteristics of Materials or Components	Test Methods of FED-STD-191
<u>Pocketing (see 3.1.3 and table I)</u>	
Material identification <u>1/</u>	1200
Sulfur dye	2020
Colorfastness to wet dry cleaning	5622
Colorfastness to crocking	5651
Weight	5041
Yarn count	5050
Breaking strength	5100
<u>Vinyl coated cloth (see 3.1.13)</u>	
Identification of material	
Base fabric	1/
Coating	1/
Weight	5041
Color	Visual
Dry cleanable	<u>2/</u>

- 1/ A certificate of compliance will be acceptable for this requirement.
- 2/ The specimen shall be a square that is 6-1/2 inches by 6-1/2 inches. A volume of 1,000 cc of solvent that conforms to type I of P-D-680 shall be used for each specimen. A container and a suitable apparatus to cause agitation of the dry cleaning solvent shall be used. The solvent temperature shall be raised to 80 degrees Fahrenheit. ~~The specimens shall~~ be introduced and agitated for a period of 15 minutes. ~~The specimens shall~~ be removed, dried, and conditioned for 24 hours to check ~~the~~ coating and the color which shall show no visual evidence of fading, cracking, or flaking.

TABLE VIII. Sample sizes.

Lot Sizes (Sample Units)	Sample Sizes
800 or less	2
801 to 22,000 inclusive	3
22,001 or more	5

4.2 3.2 Examination of finished measurements. The end item shall be measured as specified in 3.5 to determine conformance to the finished measurements specified herein. The inspection level for the examination of the finished measurements shall be S-3 of MIL-STD-105. The acceptable quality level for the examination of the finished measurements shall 4.0 dhu for defects (one class). Each finished measurement of the end item that deviates from the finished measurement specified in table VI shall be classified as a finished measurement defect. Sleeve lengths uneven 1/2 inch or more shall be classified as a finished measurement defect.

4.2.4 Preparation for delivery inspection. Shipping containers fully prepared for delivery shall be examined, for the defects listed in table X, to determine compliance with the packaging, packing, and marking requirements specified herein. The sample unit for this examination shall be one shipping container fully prepared for delivery except that it need not be sealed. The lot size shall be the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 of MIL-STD-105. The acceptable quality level shall be 2.5 dhu for defects (one class).

## 5 PACKAGING

5.1 Preservation and packaging. Preservation and packaging shall be level A or C as specified (see 6.2).

5.1.1 Level A. Each jacket (including the detachable collar) shall be folded to approximately 20 inches by 16 inches. The folded jacket shall be placed in a box that conforms to type CF, class domestic, style RSC, grade 200 of PPP-B-636. The outside dimensions of the box shall be approximately 20 inches by 16 inches by 6 inches. The box shall be closed by applying tape that conforms to PPP-T-45

5.1.2 Level C The jacket (including the detachable collar) shall be packaged one per unit ~~container~~. The unit container shall afford adequate protection against deterioration and physical damage during shipment from the supply source to the first receiving activity for immediate use. This level may conform to the supplier's commercial practice provided the latter meets the requirements for this level

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TABLE IX Classification of defects

Defect	Major	Minor A	Minor B
<u>Bartacks</u>			
One bartack missing, insecure, or misplaced not serving intended purpose			X
Two bartacks missing, insecure, or misplaced not serving intended purpose		X	
Three or more bartacks missing, insecure, or misplaced not serving intended purpose	X		
Any bartack less than specified length			X
<u>Buttons</u>			
Buttons not specified size, type, or color			X
One button missing, loose, or broken		X	
Two or more buttons missing, loose, or broken			
Any button more than 1/4 inch out of alignment with buttonhole			
<u>Buttonholes</u>			
One buttonhole omitted or added		A	
Two or more buttonholes omitted or added	X		
Stitches of one buttonhole not caught in fabric, causing stitches to pull away from fabric		X	
Stitches of two or more buttonholes not caught in fabric, causing stitches to pull away from fabric	X		
One or more broken stitches in one buttonhole		A	
One or more broken stitches in two or more buttonholes	A		
More than two skipped stitches in one or more buttonholes		Y	
Ragged edges in any buttonhole affecting appearance			X
Gimp of buttonhole for front closure omitted			
Any buttonhole uncut			
End of one buttonhole insecurely tacked			
Ends of two or more buttonholes insecurely tacked			

TABLE IX. Classification of defects. - Continued

Defect	Major	Minor A	Minor B
<u>Cleanness</u>			
Indelible ink shade stamping exposed on outside or spots or stains of permanent nature		X	
Removable spot or stain clearly noticeable		X	
Thread ends not trimmed or one or more shade tickets not removed			X
<u>Component and assembly</u>			
Any component defective	X		
Any component missing	X		
Any required operation omitted or improperly performed	X		
<u>Cutting</u>			
Any component not cut in accordance with directional lines on patterns or specified requirements	X		
<u>Material defects and workmanship damages</u>			
Any weakening material defect such as hole, smash, multiple float, or slub, which might develop into hole (except quilted lining and knitted fabric)	X		
Shade bars, slubs, or any other similar nonweakening material defects on outside of jacket (except quilted lining and knitted fabric)		X	
Shade bars, slubs, or any other similar nonweakening material defects on inside of jacket (except quilted lining and knitted fabric)			X
Exposed drill hole, cut, tear, mend, or needle chew that might develop into hole (except quilted lining and knitted fabric)	X		
Ruptured fibers in line of sewing (usually caused by broken, blunt, or hooked needles) affecting appearance or serviceability (except quilted lining and knitted fabric)		X	
Quilted lining containing any hole, scissor or knife cut, tear, burn, or needle chew that may develop into hole	X		

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TABLE IX. Classification of defects. - Continued

Defect	Major	Minor A	Minor B
Quilted lining containing any weakening defect such as smash, multiple float, or loose slub that may develop into hole		X	
Quilted lining containing darn or mend		X	
Quilted lining containing exposed drill hole			X
One or more rows of quilting stitching omitted in quilted lining	X		
More than 1-1/2 inches of broken or missing quilting stitches in quilted lining			X
Batting in quilted lining uneven resulting in thick or thin place	X		
One or more laps of batting of quilted lining	X		
One or more piecing or splicing of covering of batting of quilted lining	X		
Any area of quilted lining evidencing complete bobbin change			
<u>Seams and stitchings</u>			
Seam twisted, pleated, or badly puckered 1/		X	
Part of jacket caught in any unrelated operation or stitching	X		
Thread(s) used on outside not same shade or not satisfactorily matching shade of jacket		X	
Thread breaks or end(s) of stitching, if not caught in other seams or stitchings, not securely backstitched or tacked as specified		X	
Gage of edge, top, or raise stitching irregular, i.e., unevenly gaged or corresponding stitchings not uniformly gaged, affecting appearance		X	
Gage of edge, top, or raise stitching not within range of gage specified or varies more than 1/16 inch if no range is specified			X
Open seam over 1/4 inch on joining seam 2/		X	
Open seam over 1/8 inch but not over 1/4 inch on joining seam 2/			

TABLE IX. Classification of defects. - Continued

Defect	Major	Minor A	Minor B
Stitches skipped or broken over 1/4 inch but not over 1/2 inch on edge, top, or raise stitching when seam is seamed, turned, and stitched <u>2/</u>			X
Stitches skipped or broken over 1/2 inch on edge, top, or raise stitching when seam is seamed, turned, or stitched <u>2/</u>		X	
Raw edges on outside over 1/8 inch but not over 1/4 inch <u>3/</u>			X
Raw edges on outside over 1/4 inch <u>3/</u>		X	
Raw edges on inside over 1/2 inch but not over 1 inch <u>3/</u>		X	
Raw edges on inside over 1 inch <u>3/</u>	X		
Run-offs on joining seams, if resulting in open seam <u>2/</u>			
Run-offs on edge, top, or raise stitching, if not resulting in open seam (outside only), over 1/2 inch but not over 1 inch			X
Run-offs on edge, top, or raise stitching, if not resulting in open seam (outside only), over 1 inch		X	
Stitch or seam type not as specified		X	
Loose stitch tension, resulting in loose seam	X		
Loose stitch tension on edge, top, or raise stitching, recognized by loose exposed loops of top or lower thread		X	
Light tension <u>2/</u>			
One or two stitches per inch less than minimum specified <u>4/</u>			X
Three stitches per inch less than minimum specified <u>4/</u>		X	
Four or more stitches per inch less than minimum specified <u>4/</u>	X		
One or more stitches per inch more than maximum specified <u>4/</u>		X	

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TABLE IX. Classification of defects. - Continued

Defect	Major	Minor A	Minor B
<u>Shaded parts</u>			
Outside parts (visible when jacket is worn) shaded		X	
Quilted lining and inside parts (not visible when jacket is worn) badly shaded			X
<u>Snap fasteners</u>			
Snap fastener missing, loose, or not functioning properly		X	
Stud and socket of snap fastener not aligned, causing bulge when snap fastener is fastened		X	
Snap fastener clinched too tightly, cutting surrounding fabric	X		
<u>Fastener tape</u>			
Hooks or pile flattened or missing from any fastener tape area up to 25 percent		X	
Hooks or pile flattened or missing from any fastener tape area 25 percent or more	X		
Fastener tape not specified type	X		
<u>Slide fastener</u>			
Slide fastener not specified type, style, or size or any part of assembly omitted, bent, or broken	X		
Interference with movement of slider	X		
Slider not closed in specified direction		X	
<u>Fronts</u>			
Any portion of jacket or slide fastener tape puckered, twisted, or pleated at slide fastener tape joining seam when slide fastener is open or closed		X	
Fronts sagging, twisted, or bulging across chest or caused by tightness or lining		X	
Slash pockets 1/2 inch or more out of alignment with each other		X	
Fastener tape for wearer's nameplate misplaced more than 1/2 inch		X	

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TABLE IX. Classification of defects. - Continued

Defect	Major	Minor A	Minor B
Stitching omitted on one or more edges of pile fastener tape for wearer's nameplate		X	
Fastener tape for wearer's nameplate missing	X		
Welt of slash pocket irregular in width			X
Welt of slash pocket less than 3/4 inch wide or more than 1 inch wide			X
Length of slash pocket opening more than 6-1/4 inches			X
Length of slash pocket opening less than 5-3/4 inches but not less than 5-1/2 inches			X
Length of slash pocket opening less than 5-1/2 inches		X	
<u>Hanger</u>			
End(s) of hanger not securely stitched as specified		X	
Finished hanger less than 3-1/4 inches long or more than 3-3/4 inches long			X
Hanger less than 3/8 inch wide or more than 5/8 inch wide			X
Hanger 1 inch or more off center with center of back			X
Hanger stitched and bartacked through outer shell			X
<u>Detachable collar</u>			
Detachable collar tight on jacket collar			X
Edge of detachable collar irregular			X
Detachable collar twisted, causing puckers or pleats on jacket collar			X
<u>Waistband</u>			
Waistband not specified width		X	
Waistband twisted in attachment to bottom of jacket, affecting appearance		X	
<u>Sleeves</u>			
Sleeves sagging, twisted, bulging, or short, causing shortness, tightness, or incorrect positioning of quilted lining		X	

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TABLE 1X Classification of defects. - Continued

Defect	Major	Minor A	Minor B
Wristlets not specified class or color		X	
Wristlets twisted in sleeve lining, affecting fit		X	
Any hole in wristlet	X		
Vinyl for sleeve bottom missing	X		
Vinyl on sleeve bottom twisted, affecting appearance		X	
<u>Nondetachable collar</u>			
Collar tight at joining to neck seam, causing puckers or pleats on fronts, back, or facing		X	
Collar edge irregular		X	
Pointed ends of collar poorly shaped or not uniform shape or size		X	
Interlining tight or twisted, causing puckers on undercollar		X	
Collar off center more than 1/2 inch (step of lapels will vary in width)		X	
<u>Belt loops</u>			
Any belt loop not located as specified			X
Any belt loop missing		X	
<u>Combination identification and size label</u>			
Size on combination identification and size label missing, incorrect, or illegible	X		
Information (except size) on combination identification and size label incomplete, incorrect, or illegible		X	

TABLE IX. Classification of defects. - Continued

Defect	Major	Minor A	Minor B
Combination identification and size label misplaced or off center of back more than 1/2 inch			X
Stitching on one or more edges or combination and size label omitted		X	

- 1/ Some puckering is an inherent characteristic in joining seams and stitching of cloth parts. This normal puckering shall not be classified as a defect.
- 2/ A break in a line of stitching (except on edge, top, or raise stitching), run-offs on joining seams (if resulting in an open seam), and tight tension (stitches breaking when normal strain is applied to seam or stitching) shall be classified as open seams.
- 3/ A raw edge shall be classified as such when it occurs along an edge required to be turned under but the edge is securely caught in the stitching.  
If the edge is not securely caught in the stitching, the defect shall be classified as an open seam.
- 4/ Stitches per inch shall be classified as a defect only when the condition exists on the major portion of the seam or stitching.

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TABLE X. Examination of preparation for delivery.

Examine	Defects
Marking	Marking omitted; incorrect; illegible; or improper size, location, sequence, or method application
Material	Any component missing Any component damaged, affecting serviceability Any component not as specified
Workmanship	Inadequate application of components such as incomplete closure of container flaps, loose strapping, or inadequate stapling Bulging or distortion of container
Content	Number of jackets per container more or less than required

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

5.2.1 Level A. Four jackets of one size, packaged as specified, shall be packed in a box that is constructed, closed, and reinforced to conform to type CF or SF, class weather-resistant, grade V3c or V3s, style RSC or PPP-B-636. The inside dimensions of the box shall be approximately 24 inches by 20 inches by 16 inches. Towards the end of the contract or if the quantity of jackets of the same size is less than the quantity of jackets required per shipping container, mixed sizes (see 5.3.1) may be packed within the same shipping container.

5.2.2 Level B. Four jackets of one size, packaged as specified shall be packed in a box that is constructed and closed to conform to type CF or SF, class domestic, style RSC or PPP-B-636. The inside dimensions of the box shall be approximately 24 inches by 20 inches by 16 inches. Toward the end of the contract or if the quantity of jackets of the same size is less than the quantity of jackets required per shipping container, mixed sizes (see 5.3.1) may be packed within the same shipping container.

5.2.3 Level C. Jackets packaged as specified shall be packed to afford adequate protection against damage during direct shipment from the supply source to the first receiving activity for immediate use at the lowest transportation rate for such supplies. The container shall conform to the rules or regulations applicable to the mode of transportation. This level may be the supplier's commercial practice provided the latter meets the requirements for this level.

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

5.3.1 Mixed sizes. White paper labels shall be securely attached to the end and the side of each shipping container that is packed with mixed sizes (see 5.2.1 and 5.2.2). The labels shall be 5 inches by 4 inches. The labels shall have the words "mixed sizes" plainly printed thereon. Under these words shall be printed the quantity and the sizes of the jackets contained therein.

## 6. NOTES

6.1 Intended use. The jacket covered by this specification is intended to be worn, in moderate to cold temperature, by the male and the female security police of the Department of the Air Force.

6.2 Ordering data. Procurement documents should specify the following:

- (a) Title, number, and date of this specification
- (b) Size required (see 1.2)
- (c) Standard patterns furnished by Government (see 3.4)

(d) Selection of applicable levels of preservation and packaging and packing (see 5.1 and 5.2).

6.3 Color shades. Samples of color shades may be obtained from the procuring activity or as directed by the contracting officer.

6.4 Figures. Figures 1 and 2 show general style of the jacket are furnished for information only.

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

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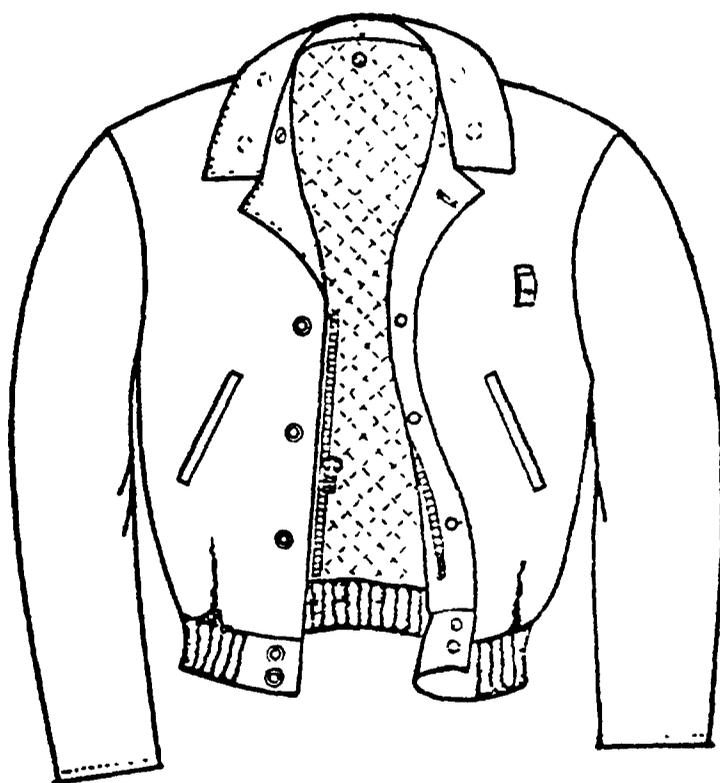
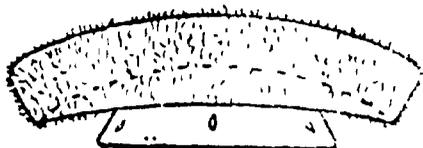
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Project No. 8415-F252

User:  
Air Force - 45

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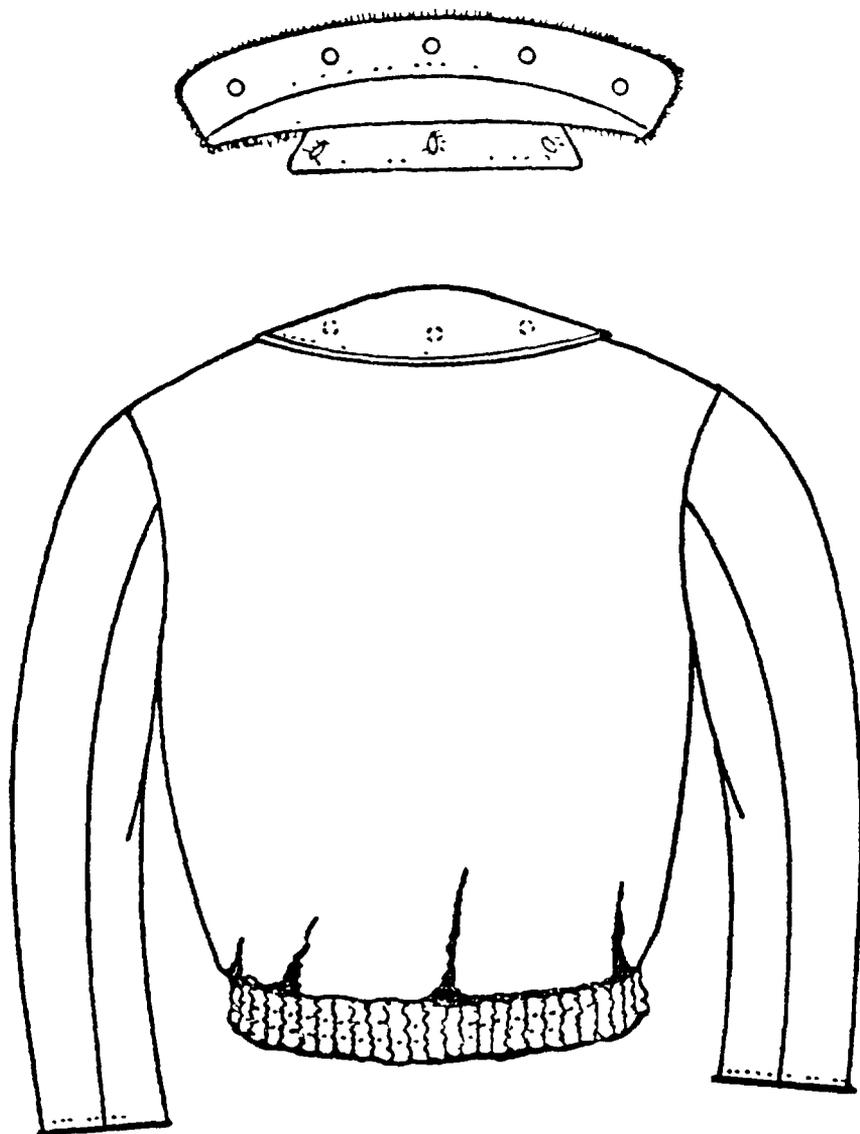


FIGURE 2. Jacket and detachable collar (back view).

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