

INCH-POUND

MIL-J-87251 (USAF)

4 November 1988

SUPERSEDING

(See Section 6)

MILITARY SPECIFICATION

JACKET, WOMAN'S: LIGHTWEIGHT WITH REMOVABLE LINER

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 a woman's lightweight jacket with a removable liner.

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

Schedule of lengths and sizes

Short	6	8	10	12	14	16	18		
Regular	6	8	10	12	14	16	18	20	22
Long	6	8	10	12	14	16	18	20	22
Extra long		8	10	12	14	16	18	20	22

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: ASD/ENES, Wright-Patterson AFB OH 45433-6503, 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 8410

DISTRIBUTION STATEMENT A: Approved for public release, distribution is unlimited.

MIL-J-87251 (USAF)

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-1696	Bag, Plastic (Garment)
A-A-50083	Bag, Plastic, Folded Garment
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, Gimp, Cotton, Buttonhole
NN-P-71	Pallets, Material Handling, Wood, Stringer Construction, 2-Way and 4-Way (Partial)
DDD-L-20	Label: For Clothing, Equipage, and Tentage, (General Use)
PPP-B-601	Boxes, Wood, Cleated Plywood
PPP-B-636	Boxes, Shipping, Fiberboard

MILITARY

MIL-P-116	Preservation, Methods of
MIL-C-3735	Cuffs, Knit, Wrist and Ankle, and Cloth, Knitted
MIL-C-10176	Cloth, Gabardine: Wool, Polyester and Wool
MIL-P-15011	Pallets, Material Handling, Wood Post Construction, 4-Way Entry
MIL-F-21840	Fastener Tapes, Hook and Pile, Synthetic
MIL-C-21852	Cloth, Taffeta, Nylon
MIL-T-43548	Thread, Polyester Core: Cotton-, Rayon-, or Polyester-Covered
MIL-C-43718	Cloth, Polyester; Polyester and Cotton; Polyester and Rayon, for Pockets
MIL-C-44192	Container, Shipping and Storage, Coat (Hanger Pack)
MIL-C-44296	Cloth, Fusibles

STANDARDS

FEDERAL

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

MIL-J-87251 (USAF)

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-2073-1	DoD Materiel Procedures for Development and Application of Packaging Requirements

(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 Ave., Philadelphia PA 19120-5099.)

2.1.2 Other Government documents, drawings, and publications. The following other Government documents, drawings, and publications form a part of this document to the extent specified herein. Unless otherwise specified, the issues are those cited in the solicitation.

LAWS AND REGULATIONS

Rules and Regulations Under the Wool Products Labeling Act of 1939

(Application for copies should be addressed to the Superintendent of Documents, U.S. Government Printing Office, Washington DC 20402-0001.)

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.

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM D 3951 Standard Practice for Commercial Packaging (DoD adopted)

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race St., Philadelphia PA 19103-1187.)

THE COLOR ASSOCIATION OF THE UNITED STATES

Department of Defense (DoD) Standard Color Card of Official Standardized Shades for Sewing Threads

Department of Defense (DoD) Standard Shades for Buttons

(Application for copies should be addressed to The Color Association of the United States, 343 Lexington Ave., New York NY 10016-0927.)

(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.)

MIL-J-87251 (USAF)

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 shall take precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 First article. When specified (see 6.2), a sample shall be subjected to first article inspection (see 6.4) in accordance with 4.3.

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

3.3 Materials (see 6.5)

3.3.1 Basic material. The basic fabric shall be polyester/wool gabardine, USAF Color Blue, Shade No. 1605, conforming to type II, class 12 of MIL-C-10176. The fabric shall have a durable water resistant finish (see 3.3.1.1).

3.3.1.1 Spray rating. The results of three individual determinations on the sample unit for spray rating shall be equal to or better than ratings 90, 90, 90 initial and 80, 80, 80 after 1 dry cleaning (see 4.4.1.1).

3.3.2 Lining. The material for lining the sleeves and body, and the liner outershell shall be nylon taffeta cloth conforming to type IV of MIL-C-21852 and shall be USN Color Blue, Shade No. 3376.

3.3.3 Insulating cloth. The insulating cloth for the liner shall be Thinsulate Style CS100 having a minimum weight of 3.0 (excluding scrim) ounces per square yard and a minimum thickness of 0.3 or Thermolite T-0 having a minimum weight of 3.0 ounces per square yard and a minimum thickness of 0.3 (see 6.6). Lightweight jacket manufacturers shall submit a certificate of compliance stating that the batting insulation conforms to requirements specified for applicable types, class, and style (see 4.4.1.1).

3.3.4 Fastener tapes. The hook and loop pile fastener tapes for attaching the liner to the jacket shall be 1 inch wide by 1-1/2 inches long and shall be Black 3230 conforming to type I or type IA, class 1 of MIL-F-21840.

3.3.5 Interlining. The fusible cloth interlining for the pocket welts, collar, collarstand and shoulder loops shall conform to type V, class 2, style A of MIL-C-44296. The color shall be charcoal gray or black.

3.3.6 Bias binding. The edges of the liner shall be bound with a nylon bias-cut binding. The binding shall be 3/4 to 7/8 inch wide. The color shall match the nylon taffeta lining used to cover the insulating cloth.

MIL-J-87251 (USAF)

3.3.7 Pocketing. The material for the pocketing shall conform to class 1 of MIL-C-43718. The color shall be black.

3.3.8 Knitted wrist cuffs. The knitted wrist cuffs for the sleeves shall conform to type III of MIL-C-3735 and shall be dyed to match USAF Color Blue, Shade No. 1606.

3.3.9 Labels. Each jacket, outershell and liner, shall have a size label and a combination personal identification, identification and instruction label conforming to DDD-L-20. The colorfastness to dry cleaning requirements of DDD-L-20 shall apply to the jacket outershell label.

3.3.9.1 Size label. The size label for the jacket outershell and liner shall conform to type VI, class 2. The sizes and lengths (short, regular, long and extra long) of the jacket may be abbreviated as follows:
8S, 8R, 8L, and 8XL.

3.3.9.2 Combination personal identification, identification and instruction label. The combination personal identification, identification and instruction label shall conform to type VI, classes 10 and 15 and shall include the following information:

a. Jacket outershell:

Name:

Service No.:

Jacket, Woman's: Lightweight with Removable Liner

Contract No.: DLA-100-00-0-0000 (Example) 1/

Wool Products Labeling Act information as applicable 1/

Contractor: 1/

DRY CLEAN ONLY

b. Jacket liner:

Name:

Service No.:

Jacket, Woman's: Lightweight with Removable Liner

Contract No.: DLA-100-00-0-0000 (Example) 1/

Contractor: 1/

DRY CLEAN - DO NOT STEAM PRESS

OR

Machine wash, delicate cycle.

Tumble dry, low heat.

DO NOT STEAM PRESS

1/ Contractor shall include the applicable information.

MIL-J-87251 (USAF)

3.3.10 Slide fastener. The slide fastener for the front closure shall conform to type IV, style 8, size M of V-F-106. The chain shall be brass or aluminum with a short tab pull. The tape shall be cotton/warp and nylon filling, cotton, or polyester and shall be dyed to approximate the shade of the basic fabric. The metal components shall have a black chemical finish. All metal components shall be from the same contractor.

3.3.11 Button. The button for the collar closure shall conform to type II, class D, style 20 or 21, size 24 line of V-B-871 and shall be DoD Shade Blue BU, C.A. 62002 (see DoD Standard Shades for Buttons).

3.3.12 Thread. The thread for seaming, stitching, buttonhole making and bartacks shall conform to type IA3, ticket No. 50 or No. 60, 3 ply of V-T-276 or to cotton-covered or rayon-covered polyester thread, ticket No. 50, 2 or 3 ply conforming to MIL-T-43548. The thread for sewing on the button shall conform to type IA3, ticket No. 20, 4 ply of V-T-276. The color shall be DoD Shade Blue AB, C.A. 66044 (see DoD Color Card) and shall have good colorfastness to wet dry cleaning.

3.3.13 Gimp. The gimp for reinforcing the buttonhole shall conform to type I or type II, size No. 8 of V-T-280 and shall be DoD Shade Blue AB, C.A. 66044 (see DoD Color Card). The dyed gimp shall have colorfastness to wet dry cleaning equal to or better than the standard sample (see 6.3). If a standard sample is not available, the dyed gimp shall have good colorfastness to wet dry cleaning.

3.4 Design. The jacket shall be single breasted with a covered slide fastener front closure, collar and collarstand with a throat tab that buttons, two slash pockets, hanger loop, set-in sleeves with knitted cuffs, straight bottom, and an epaulet on each shoulder. The jacket shall have a removable liner attached with hook and loop pile fastener tapes.

3.5 Patterns. Standard patterns will be furnished by the Government and provide a seam allowance of 1/2 inch for side seams, sleeve seams, knit cuffs, and shoulder seams; 3/8 inch for armholes and joining the collarstand to the body; and 1/4 inch for the collar and stand extension. The standard patterns shall not be altered in any way, and are to be used as a guide for cutting the contractor's working patterns. The standard patterns show size, seam allowance, directional lines for cutting, and are marked or notched for proper placement and assembly of the component parts. The working patterns shall be identical to the standard patterns.

3.5.1 Pattern parts. The components of the jacket and liner shall be cut from the materials specified in accordance with the number of pattern parts indicated in table I.

3.6 Construction. The jacket shall be constructed in accordance with table II and herein. The thread and the fabric shall not be lubricated by any means prior to or during the seaming. Figures are furnished for guidance and information only. If there are any inconsistencies between the specification and the figures, the specification shall govern.

MIL-J-87251 (USAF)

TABLE I. List of pattern parts.

Material	Pattern nomenclature	Cut parts
Basic material (see 3.3.1)	Front	2
	Back	1
	Front facing	2
	Topsleeve	2
	Undersleeve	2
	Shoulder loop	4
	Pocket welt	2
	Pocket facing	2
	Collar	2
	Collarstand	2
	Back neck facing	1
Lining (see 3.3.2)	Front	2
	Back	1
	Topsleeve	2
	Undersleeve	2
Liner (see 3.3.2)	Front	4
	Back	2
Insulating cloth (see 3.3.3)	Front	2
	Back	1
Fusible interlining (see 3.3.5)	Collar	1
	Collarstand	1
	Pocket welt	2
	Shoulder loops	2
	Front edge reinforcement	2
Polyester (see 3.3.7)	Pocket	4

3.6.1 Stitches, seams, and stitchings. All stitch, seam, and stitching types specified in table II shall conform to FED-STD-751. Whenever two or more methods of seam or stitch types are specified for the same operation, any one of them may be used.

3.6.1.1 Stitches per inch. The number of stitches per inch specified in table II shall be interpreted to be the minimum and the maximum number of stitches per inch permitted.

MIL-J-87251 (USAF)

3.6.1.2 Thread breaks and ends of seams and stitchings. The ends of all seams and stitchings produced with stitch type 301, when not caught in other seams or stitchings, shall be backstitched not less than 1/4 inch. Thread breaks (all stitch types) shall be secured by stitching back of break 1/2 to 1 inch. For those seams with thread breaks, utilizing stitch type 401, a 301 stitch shall be used to secure thread breaks by stitching back of break 1/2 to 1 inch.

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

a. When thread breaks, skipped stitches, run-offs, or bobbin runouts occur during sewing, the stitching shall be repaired by superimposing and restarting the stitching a minimum of 1/4 inch back of the end of the stitching (see NOTE).

b. Except for prestitching, thread breaks, two or more consecutive skipped stitches or run-off stitches noted during inspection of the item (in process or end item) shall be repaired by overstitching. The stitching shall start a minimum of 1/4 inch in back of the defective area, continue over the defective area, and continue a minimum of 1/4 inch beyond the defective area onto the existing stitching. Loose or excessively tight stitching shall be repaired by removing the defective stitching, without damaging the materials, and restitching in the required manner (see NOTE).

NOTE: When making the above repairs, the ends of the repairing stitch must be backstitched and thread ends trimmed close to the jacket or liner.

3.6.1.4 Types 101, 503, 504, 515, 516, 517, 518, and 519 stitchings.

Thread tension shall be maintained so that there will be no loose or excessively tight stitching resulting in puckering of the material. All repairs shall be in accordance with 3.6.1.3.

3.6.1.5 Automatic stitching. Automatic stitching machines may be used to perform any of the required stitch patterns provided the requirements of the stitch pattern, stitches per inch, and size and type of thread are met; and at least three tying, overlapping, or backstitches are used to secure the ends of the stitching.

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

MIL-J-87251 (USAF)

TABLE II. Manufacturing operations.

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
1.	<p><u>Cut parts.</u></p> <p>a. Cut the jacket in accordance with the patterns which have markings for placement of pockets, buttons, and button-hole; sizes; warp directional lines; and notches for proper assembly of all parts.</p> <p>b. Cut the strip for the hanger loop from the outershell fabric. The strip shall be 4 inches long and 2 inches wide.</p> <p>c. Cut 8 strips of loop pile fastener tape, 1-1/2 inches long and 8 of hook fastener tape, 1-1/2 inches long.</p> <p>d. Cut nylon bias binding for liner to proper length.</p>			
2.	<p><u>Replace defective parts.</u></p> <p>a. Replace at the time of cutting any parts containing holes or seriously weakening defects such as smashes, multiple floats, slubs, snags, or pulls.</p> <p>b. Replace any part damaged during the manufacturing process by needle chews, tears, holes, mends, burns, or scissor or knife cuts.</p>			
3.	<p><u>Mark parts.</u></p> <p>Mark or ticket all parts to insure a uniform shade throughout the jacket and the proper assembling of all parts. If shade marking is used, the marking shall not show through and be visible on the outside of the jacket (see 3.7.1).</p>			

MIL-J-87251 (USAF)

TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
4.	<u>Fuse parts</u> (see 3.7.3). a. Fuse the top collar, top collar-stand, shoulder loops, and pocket welts. b. Fuse the front edges of the outer-shell with the fusible front edge reinforcement piece.			
5.	<u>Quilt liner cloth.</u> Cut liner from quilted nylon cloth in accordance with the patterns, which have placement of loop pile fasteners, and warp directional lines marked. NOTE: Quilt lining by placing insulating material between two layers of nylon taffeta and stitching along warp in rows 4 \pm 1/2 inches apart.	301	SSa-1	6-10
6.	<u>Make shoulder loops.</u> a. Join the under ply and the top ply of the shoulder loop around the side edges and the pointed end with a 1/4-inch seam. b. Trim, turn, force out the edges and the pointed end. Press flat. Single stitch 1/4 inch from the edge. The shoulder loop shall be 2 inches wide at the armhole and 1-1/2 inches wide at the neck.	301 or 401 301	SSe-2(a) SSe-2(b)	10-14 10-14
7.	<u>Make collar.</u> a. Join the undercollar to the top collar around the top and the side edges.	301 or 401	SSe-2(a)	10-14

MIL-J-87251 (USAF)

TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
7.	<u>Make collar.</u> - Contd			
	b. Trim, turn, force out the edges, and press flat.			
	c. Raise stitch collar 1/4 inch from the edge.	301	SSe-2(b)	10-14
8.	<u>Make collarstand and attach collar.</u>			
	a. Place the collar between the top collarstand and the undercollarstand as indicated by the notches on the patterns. Stitch from end to end along the top edge of the collarstand around the stand extension with a 1/4-inch seam.	301	SSq-2	10-14
	b. Turn the top collarstand and the undercollarstand to the finished position. Raise stitch 1/16 inch to 1/8 inch from the turned edge with the stitching continued around the ends of the collarstand, through all plies, finishing 1/2 inch from the ends.	301	SSq-2	10-14
	NOTE: Finished width of collar at center back shall be 2-3/8 \pm 1/8 inches wide.			
9.	<u>Make and attach hanger loop.</u>			
	a. Double stitch the hanger either with a cover stitch on the underside or with the edges folded under.	401 or 301	EFh-1 EFp-1	10-14 10-14
	b. Turn under each end of the hanger; center it to the collarstand, and backstitch or bartack the folded ends. The finished hanger shall be 3/8 \pm 1/8 inch wide with a free opening 2-1/2 \pm 1/4 inches long between the bartack at the ends.	301 or bartack	LSd-1	

MIL-J-87251 (USAF)

TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
10.	<u>Make outershell sleeves.</u>			
	a. Join the forearm seam of the outershell sleeve.	301	SSa-1	10-14
	b. Join the backarm seam of the outershell sleeve.	301	SSa-1	10-14
	c. Press seam open and flat.			
11.	<u>Make sleeve linings.</u>			
	a. Join the forearm seam of the sleeve lining.	301	SSa-1	10-14
	b. Join the backarm seam of the sleeve lining.	301	SSa-1	10-14
	c. Overedge stitch the raw edges of the shoulder seams together.	503 or 504	EFd-1	10-12
	OR			
	d. The raw edges of the linings may be joined by seaming and overedge stitching in one operation.	515 or 516 or 517 or 518 or 519	SSa-2	10-14
	e. Press seam smooth and flat.			
12.	<u>Make bust darts.</u>			
	a. Stitch each bust dart, tapering to nothing at the point.	301	SSa-1	10-14
	b. Press darts flat and toward armhole.			

MIL-J-87251 (USAF)

TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
13.	<p><u>Make slash pockets.</u></p> <p>Make a single welt pocket in each front at the pattern marks. The welt shall be $7/8 \pm 1/8$ inch wide and $6 \pm 1/8$ inches long.</p> <p>a. Fold in half lengthwise and press the two welt pieces.</p> <p>b. Turn under the inner edge of the two facing pieces and sew to each pocketing $1/16$ inch from the edge.</p> <p>c. Place the pocketing with the attached facing and the welt with the pocketing on top at the drill marks.</p> <p>d. Sew the pieces on the fronts at the drill marks.</p> <p>e. Cut the opening for the pocket. Tongue notch the corners.</p> <p>f. Turn the pocketing and welt through the slits.</p> <p>g. 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>h. Seam the tongues at the ends on the inside through the welt and the facing with a single row of stitching.</p> <p>i. Raise stitch the seam joining to 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.</p>	<p></p> <p>301</p> <p></p> <p>301</p> <p></p> <p>301</p> <p>301</p> <p>301</p>	<p></p> <p>LSd-1</p> <p></p> <p>SSa-1</p> <p></p> <p>LSq-2(b)</p> <p>SSa-1</p> <p>LSq-2(b)</p>	<p></p> <p>10-14</p> <p></p> <p>10-14</p> <p></p> <p>10-14</p> <p>10-14</p> <p>10-14</p>

MIL-J-87251 (USAF)

TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
13.	<u>Make slash pockets.</u> - Contd			
	j. Sew around the pocketing with a single row of stitching 1/2 inch from the edge.	301	SSa-1	10-14
	k. Bartack the corners of each pocket opening with a 3/4 inch bartack on the inside catching the tongues and welt.	Bartack		42 stitches per bartack
14.	<u>Join outershell shoulder seams.</u>			
	a. Join outershell front to outershell back at shoulder seams.	301	SSa-1	10-14
	b. Press seam open and flat.			
15.	<u>Join outershell side seams.</u>			
	a. Join outershell front to outershell back at side seams.	301	SSa-1	10-14
	b. Press seam open and flat.			
16.	<u>Join the front facing to lining.</u>			
	a. Join the front facing to the lining.	301	SSa-1	10-14
	b. Press seam flat and toward side seam.			
	OR			
	c. The raw edges of the front facing and lining may be joined by seaming and overedge stitching in one operation.	515 or 516 or 517 or 518 or 519	SSa-2	10-14
17.	<u>Join back neck facing to lining.</u>			
	a. Turn the bottom raw edge of the back neck facing under 1/4 inch and press.			

MIL-J-87251 (USAF)

TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
17.	<u>Join back neck facing to lining.</u> - Contd			
	b. Place the back neck facing on the lining and edge stitch the neck and bottom hem to the lining.	301	SSa-1	10-14
	c. Press flat.			
18.	<u>Attach labels.</u>			
	a. Sew size label at center back, with top of label 1/4 inch above seam joining facing and lining. Stitch label on all four sides.	301	SSa-1	10-14
	b. Center the combination personal identification, identification and instruction label and sew to left (as worn) facing, 9 +1/2 inches from bottom of jacket.	301	SSa-1	10-14
19.	<u>Join lining shoulder seams.</u>			
	a. Join front and back linings at shoulder.	301 or 401	SSa-1	10-14
	b. Overedge stitch the raw edges of the shoulder seams together.	503 or 504	EFd-1	10-12
	OR			
	c. The raw edges of the linings may be joined by seaming and overedge stitching in one operation.	515 or 516 or 517 or 518 or 519	SSa-2	10-14
20.	<u>Join lining side seams.</u>			
	a. Join front and back linings at side seams.	301 or 401	SSa-1	10-14
	b. Overedge stitch the raw edges of the side seams together.	503 or 504	EFd-1	10-12
	OR			

MIL-J-87251 (USAF)

TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
20.	<u>Join lining side seams.</u> - Contd			
	c. The raw edges of the linings may be joined by seaming and overedge stitching in one operation.	515 or 516 or 517 or 518 or 519	SSa-1	10-14
	d. Press seam smooth and flat.			
21.	<u>Set sleeves.</u>			
	a. Join the sleeves to the jacket, catching the shoulder loops in seam.	301	SSa-1	10-14
	NOTE: The loops shall be centered on the shoulder seams in accordance with the notches on the pattern and stitched to the armhole 1/4 to 3/8 inch from collarstand seam.			
	b. Press seam flat and toward sleeve.			
	c. Attach shoulder loops to jacket, stitching from shoulder loop point to center point to shoulder loop point.	301	SSa-1	10-14
22.	<u>Attach sleeves to lining.</u>			
	a. Join sleeve lining to lining body.	301	SSa-1	10-14
	b. Press seam flat and away from sleeve.			
	c. Overedge stitch the raw edges of the sleeve together.	503 or 504	EFd-1	10-12
	OR			
	d. The raw edges of the linings may be joined by seaming and overedge stitching in one operation.	515 or 516 or 517 or 518	SSa-2	12-14

MIL-J-87251 (USAF)

TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
23.	<u>Attach knit wristlet.</u>			
	a. Stitch knit cuff to outershell sleeve, stretching cuff to fit sleeve.	301	SSa-1	10-14
	b. Stitch knit wristlet to sleeve linings, stretching wristlet to fit lining.	301	SSa-1	10-14
	c. Fold cuff in half, bringing right sides together and cuff facing up toward sleeve.			
	d. Stitch cuff together along original stitching line.	301	SSa-1	10-14
	e. Turn sleeve to right side and press.			
	NOTE: Finished cuff shall measure 3 $\pm 1/8$ inches wide.			
24.	<u>Attach loop pile fastener tapes.</u>			
	Attach loop pile fastener tape to the facing at the pattern marks. Stitch on all four sides $1/16$ inch from edge.	301	SSa-1	10-14
25.	<u>Attach slide fastener.</u>			
	a. Position the slide fastener between the right and the left front edges of the outer shell and the facing. Stitch through all plies.	301	LSq-2(a)	10-14
	b. Turn and roll the front edge of the outershell out so that the chain is covered and stitch $3/8$ to $1/2$ inch from the folded outershell edge and $1/8$ inch from the facing (see figure 1).	301		10-14
	NOTE: The slide fastener chain shall finish $3/8 \pm 1/8$ inch below the finished edge of the neckline and within $1/2 \pm 1/8$ inch from the finished bottom.			

MIL-J-87251 (USAF)

TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
26.	<u>Hem bottom of jacket.</u> Turn up the bottom of the jacket with the raw edges turned under. Stitch 1/16 inch from folded edge, catching the lower edge of the slash pocket in the bottom hem. The bottom hem at the front shall be mitered so that it will not interfere with the slide fastener. The width of the finished hem shall be 1 \pm 1/8 inches.	301	EFb-1	12-14
27.	<u>Raise stitch knitted cuffs.</u> Raise stitch sleeve wristlet 1/4 inch above cuff.	301	SSa-1	10-14
28.	<u>Attach collar to jacket.</u> a. Stitch the undercollarstand to the neck seam of the jacket. b. Fold the lower edge of the top collarstand 3/8 inch and stitch through all plies 1/16 inch from folded edge.	301 301	SSa-1 SSa-1	10-14 10-14
29.	<u>Buttonhole.</u> Mark and make one horizontal buttonhole on the collarstand extension as indicated by pattern marks. The front end of the finished buttonhole shall be 3/8 to 1/2 inch from the end of the collarstand extension.	Button-hole		52-54 stitches per buttonhole
30.	<u>Button.</u> a. Sew one button on the right side of the undercollarstand to correspond with the buttonhole on the collarstand extension.	301 or 101 or hand		14-16 20-22 4-6 per button

MIL-J-87251 (USAF)

TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
30.	<u>Button.</u> - Contd			
	b. Sew one button on the left side of the collarstand to secure the throat tab when not in use. The buttons shall be sewn to the undercollarstand only. The location shall correspond with the buttonhole when the collarstand extension is folded under the collar.	301 or 101 or hand		14-16 20-22 4-6 per button
31.	<u>Clean jacket.</u>			
	The jacket shall be cleaned of all spots and stains and shall be pressed smooth (see 3.7.2). Care shall be taken to remove gloss marks and creases.			
32.	<u>Make liner.</u>			
	a. Overedge stitch raw edges of shoulders and side seams.	503 or 504	EFd-1	10-12
	b. Join the liner shoulder seams.	301 or 401	SSa-1	10-14
	c. Join the liner side seams.	301 or 401	SSa-1	10-14
	OR			
	d. The raw edges of the liner, shoulders and side seams, may be joined by seaming and overedge stitching in one operation.	515 or 516 or 517 or 518	SSa-2	10-12
	OR			
	e. The raw edges of the liner, shoulders and side seams, may be finished with binding.	301 or 401	BSc-1	10-14

MIL-J-87251 (USAF)

TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
33.	<u>Attach hook fastener tape to liner.</u> Place the hook fastener tape on the wrong side of the liner, according to pattern marks. Stitch on all four sides, 1/16 inch from edge.	301	SSa-1	10-14
34.	<u>Attach labels to liner.</u> Center the size and combination personal identification, identification and instruction labels on the liner 1-1/2 inches below the finished neck edge. Stitch on all four sides (labels shall face the jacket outershell).	301	SSa-1	10-14
35.	<u>Bind outer edges of liner and armholes.</u> a. Bind edges of the fronts, back and armholes with bias-cut binding. Binding shall overlap at the sides. b. Bartack binding at ends.	301 or 401 Bar-tack	BSc-1	10-14 28 per bartack
36.	<u>Clean liner.</u> The liner shall be cleaned of all spots and stains.			
37.	<u>Attach liner to jacket outershell.</u> Attach liner by matching and pressing hook and loop pile fastener tapes of liner and jacket, starting with the lower corner of the jacket.			

MIL-J-87251 (USAF)

3.7.1 Shade and size marking. The component parts of the jacket and liner shall be marked, ticketed, or bundled to insure a uniform shade and size throughout the jacket. Any method may be used except:

- a. Corrosive metal fastening devices.
- b. Sew-on shade tickets.
- c. Adhesive type tickets whose adhesive causes discoloration or adheres to the material upon removal of the tickets.

NOTE: The use of an ink pad numbering machine, rubber stamp, or pencil is allowed, provided the numbering does not show on the outside of the jacket or liner.

3.7.2 Pressing. Unless otherwise specified, all pressing specified in table II shall be accomplished by heated pressing iron or machine.

3.7.3 Fusing press operating procedures and conditions. A single layer of fusible interlining shall be fused to a single layer of basic material on a dry, electrically heated fusing press which has the capacity of controlling and retaining pressure, dwell time, and temperature for a minimum of 8 hours. Pair or sandwich fusing which can create differential shrinkage, stitching, and uneven bonding shall not be permitted. A steam sourced fusing press shall not be allowed for any initial fusing operations. For optimum results, the fusible material manufacturers recommendations for fusing dwell time, pressure and temperature, based upon the fusing equipment used and basic material being fused, shall be utilized. Basic preproduction and production maintenance procedures, including a fusing press information chart, shall be required to assure proper fusing press performance relative to temperature control, evenness in pressure head or roller contact, dwell time and cleanliness.

3.8 Finished measurements. The finished jacket shall conform to the measurements specified in table III and the finished liner shall conform to the measurements specified in table IV. When measuring, the jacket shall be placed flat upon a table with the slide fastener closed.

3.9 Workmanship. The finished jacket and liner shall conform to the quality of product established by this document and the occurrence of defects shall not exceed the acceptable quality levels.

MIL-J-87251 (USAF)

TABLE III. Finished measurements (inches) of jacket.

Size	1/2 Chest <u>1/</u>	Back <u>2/</u>	Sleeve <u>3/</u>	Collar <u>4/</u>	1/2 Bottom <u>5/</u>
<u>Short</u>					
6	19-3/4	20-5/8	14	13-1/2	18-1/4
8	20-1/2	20-3/4	14	14	19
10	21-1/4	20-7/8	14	14-1/2	19-3/4
12	22	21	14	15	20-1/2
14	22-3/4	21-1/8	14	15-1/2	21-1/4
16	23-1/2	21-1/4	14	16	22
18	24-1/4	21-3/8	14	16-1/2	22-3/4
<u>Regular</u>					
6	19-3/4	21-5/8	15	13-1/2	18-1/4
8	20-1/2	21-3/4	15	14	19
10	21-1/4	21-7/8	15	14-1/2	19-3/4
12	22	22	15	15	20-1/2
14	22-3/4	22-1/8	15	15-1/2	21-1/4
16	23-1/2	22-1/4	15	16	22
18	24-1/4	22-3/8	15	16-1/2	22-3/4
20	25	22-1/2	15	17	23-1/2
22	25-3/4	22-5/8	15	17-1/2	24-1/4
<u>Long</u>					
6	19-3/4	22-5/8	16	13-1/2	18-1/4
8	20-1/2	22-3/4	16	14	19
10	21-1/4	22-7/8	16	14-1/2	19-3/4
12	22	23	16	15	20-1/2
14	22-3/4	23-1/8	16	16	22
16	23-1/2	23-1/4	16	16	22
18	24-1/4	23-3/8	16	16-1/2	22-3/4
20	25	23-1/2	16	17	23-1/2
22	25-3/4	23-5/8	16	17-1/2	24-1/4
<u>Extra Long</u>					
8	20-1/2	24	17	14	19
10	21-1/4	24-1/8	17	14-1/2	19-3/4
12	22	24-1/4	17	15	20-1/2
14	22-3/4	24-3/8	17	15-1/2	21-1/4
16	23-1/2	24-1/2	17	16	22
18	24-1/4	24-5/8	17	16-1/2	22-3/4
20	25	24-3/4	17	17	23-1/2
22	25-3/4	24-7/8	17	17-1/2	24-1/4
Tolerance	+1/2	+ 1/2	+1/2	+1/4	+1/4

MIL-J-87251 (USAF)

TABLE III. Finished measurements (inches) of jacket. - Continued

- 1/ Measure the 1/2 chest with slide fastener closed from folded edge to folded edge at base of armhole
- 2/ Measure back length at center back from collar setting seam to bottom edge of outershell.
- 3/ Measure sleeve length from base of armhole to end of sleeve outershell.
- 4/ Measure collar length long inside from collar end to collar end across collarstand.
- 5/ Measure 1/2 bottom with slide fastener closed from folded edge to folded edge 1 inch above the bottom edge.

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 acceptance of defective material.

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

4.2 Classification of 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-87251 (USAF)

TABLE IV. Finished measurements (inches) of liner.

Size	1/2 Chest <u>1/</u>	Back <u>2/</u>
<u>Short</u>		
6	18-1/2	18-5/8
8	19-1/4	18-3/4
10	20	18-7/8
12	20-3/4	19
14	21-1/2	19-1/8
16	22-1/4	19-1/4
18	23	19-3/8
<u>Regular</u>		
6	18-1/2	19-5/8
8	19-1/4	19-3/4
10	20	19-7/8
12	20-3/4	20
14	21-1/2	20-1/8
16	22-1/4	20-1/4
18	23	20-3/8
20	23-3/4	20-1/2
22	24-1/2	20-5/8
<u>Long</u>		
6	18-1/2	20-5/8
8	19-1/4	20-3/4
10	20	20-7/8
12	20-3/4	21
14	21-1/2	21-1/8
16	22-1/4	21-1/4
18	23	21-3/8
20	23-3/4	21-1/2
22	24-1/2	21-5/8
<u>Extra Long</u>		
8	19-1/4	22
10	20-1/4	22-1/8
12	20-3/4	22-1/4
14	21-1/2	22-3/8
16	22-1/4	22-1/2
18	23	22-5/8
20	23-3/4	22-3/4
22	24-1/2	22-7/8
Tolerance	$\pm 1/2$	$\pm 1/2$

MIL-J-87251 (USAF)

TABLE IV. Finished measurements (inches) of liner. - Continued

- 1/ Measure 1/2 chest with the binded liner edges abutted from folded edge to folded edge at base of armhole.
- 2/ Measure back length at center back from the top of the binded edge to the bottom of the liner binded edge.

4.3 First article inspection. When a first article is required (see 6.2), it shall be examined for the defects specified in 4.4.3.1 and 4.4.3.2. The presence of any defect shall be cause for rejection of the first article.

4.4 Quality conformance inspection. Unless otherwise specified, sampling for inspection shall be 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 document or applicable purchase document.

4.4.1.1 Component testing. In addition to any testing required by 4.4.1, components listed in table V shall be tested for the characteristics noted. The methods of testing specified in FED-STD-191 wherever applicable and as listed in table V shall be followed. A certificate of compliance shall be submitted for the metal components of the slide fastener (see 3.3.10). All test reports shall contain individual values used in expressing the final results. The lot and sample sizes shall be as follows:

<u>Lot size</u>	<u>Sample size</u>
800 or less	2
801 up to and including 22,000	3
22,001 and over	5

The lot shall be unacceptable if one or more sample units fail to meet any test requirement specified. The lot size units and the sample units shall be as follows:

<u>Component</u>	<u>Lot size unit</u>	<u>Sample unit</u>
Basic fabric (after water resistant treatment)	Yard	5 yards full width
Insulating material (liner)	Yard	1 yard full width

MIL-J-87251 (USAF)

4.4.2 In-process inspection. Inspection shall be made at any point or during any phase of the manufacturing process to determine whether construction details which cannot be examined in the finished product are in accordance with specified requirements. This inspection shall include verification that the working patterns conform to the Government patterns in all respects. Whenever nonconformance is noted, corrections shall be made to the items affected and lot in process. Items which cannot be corrected shall be removed from production.

4.4.2.2 Adhesion testing of fusibles. Prior to fusing each 1,000 parts, a sample of equivalent area to a part shall be fused for visual and adhesion testing. After visual examination for bubbling, delamination and bleed through, the sample shall be cut to a 1-inch width and peeled in the warp direction using a spring scale or suitable device capable of measuring the peel strength in ounces. Any sample failing the minimum peel strength requirement specified in 3.3.5 or showing any bubbling, delamination or bleed-through shall be cause for rejection of the previous 1,000 fused parts. No fusing shall be performed after the rejection of a 1,000 part lot until the machine has been properly adjusted to produce a passing sample. The rejected lot shall then be replaced with a shade matched lot which has been fused correctly. Rejection of the previously fused parts shall not apply to the first sample tested after machine warm-up.

TABLE V. Component tests.

Component	Characteristic	Requirement paragraph	Test method
Basic fabric	Spray rating: <u>1</u> / Initial After 1 dry cleaning	3.3.1	5526 5508/ 5526
Insulating material	Weight Thickness	3.3.3 3.3.3	<u>2</u> / <u>2</u> /

1/ Three determinations of the initial spray rating on each sample unit shall be equal to or better than 90, 90, and 90. Three determinations of the spray rating in each sample unit after 1 dry cleaning shall be equal to or better than 80, 80, and 80.

2/ A certificate of compliance shall be furnished for this requirement.

MIL-J-87251 (USAF)

4.4.3 End item examination

4.4.3.1 Visual examination. The end item shall be examined for the defects listed in tables VI and VII. The lot size shall be expressed in units of one jacket. The sample unit shall be one jacket. The inspection level shall be II and the acceptable quality level (AQL), expressed in terms of defects per hundred units (dhu), shall be 2.5 dhu for major defects, 15.0 dhu for major and minor A (combined) defects, and 40.0 dhu for total (major and minor A and B combined) defects.

4.4.3.2 Dimensional examination. The end item shall be examined for conformance to the finished measurements listed in table III for the jacket and table IV for the liner. Any measurement deviating from the finished dimension specified herein or sleeve lengths of any jacket uneven 1/2 inch or more shall be classified as a defect. The lot size shall be expressed in units of one jacket. The sample unit shall be one jacket. The inspection level shall be S-3 and the AQL shall be 4.0 dhu.

4.4.4 Inspection of packaging. Except when commercial packaging is specified, the sampling and inspection of the preservation and interior packaging marking shall be in accordance with groups A and B quality conformance inspection requirements of MIL-P-116. The sampling and inspection of the packing for shipment and storage shall be in accordance with the quality assurance provisions of the applicable container specification shown in section 5. The inspection of marking for shipment and storage shall be in accordance with MIL-STD-129. The inspection of commercial packaging shall be as specified in the contract.

4.4.5 Palletization examination. An examination shall be made to determine that the palletization complies with the requirements of section 5. Defects shall be scored in accordance with the list below. The sample unit shall be one palletized unit load fully packaged. The lot size shall be the number of palletized unit loads in the inspection lot. The inspection level shall be S-1 and the AQL shall be 6.5 dhu.

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

	Defect	Major	Minor A	Minor B
1.	<u>Material defects and workmanship damages.</u> Any weakening defect such as hole, needle chew, scissor or knife cut, tear, mend, pull, snag, burn, smash, multiple float, or loose slub that might develop into hole: - on outside of jacket. - on inside of jacket. Shade bar or unsightly slub on outside of jacket. Shade bar or unsightly slub on inside of jacket (except sleeve linings). Shade bar or unsightly slub on sleeve linings. One or more exposed drill holes.	X X	 X	 X
2.	<u>Shaded parts.</u> Any shaded parts on outside of jacket. Any lining parts on inside of jacket, except sleeve linings, badly shaded. Back yoke badly shaded. Any sleeve lining parts badly shaded.	 	 X X X	 X
3.	<u>Cleanness.</u> Any spot or stain clearly noticeable: - on outside of jacket. - on inside of jacket.	 	 X	 X

MIL-J-87251 (USAF)

TABLE VI. General defects. - Continued

	Defect	Major	Minor A	Minor B
3.	<u>Cleanness.</u> - Contd			
	One or more bastings not removed.			X
	Thread ends not trimmed throughout major portion of jacket or two or more shade tickets not removed.			X
4.	<u>Component and assembly.</u>			
	Any defective component or defect of assembly (not classified herein).	X		
	Any component or required operation omitted (not classified herein).	X		
	Any component not cut in accordance with direction lines on patterns or specified requirements.	X		
5.	<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	
	Any bartack not specified length.			X
6.	<u>Seams and stitchings.</u>			
	Seam irregular, twisted, puckered, or pleated.	X		
	Part of jacket caught in any unrelated operation or stitching:			
	- caught in up to, and including 1/4 inch of stitching.		X	
	- caught in more than 1/4 inch of stitching.	X		

MIL-J-87251 (USAF)

TABLE VI. General defects. - Continued

	Defect	Major	Minor A	Minor B
6.	<u>Seams and stitchings.</u> - Contd			
	Thread(s) used on outside of jacket not same or not satisfactorily matching shade of jacket.		X	
	Thread breaks or ends of stitching (if not caught in other seams or stitchings) not securely backtacked.		X	
	Looper thread of stitch type 401 exposed on outside of jacket.		X	
	Gage of stitching (edge, top, or raise stitching): - irregular, i.e., unevenly gaged or corresponding stitchings not uniformly gaged, affecting appearance. - not within range of gage specified or varying more than 1/16 inch if range is not specified.		X	X
	Open seam over 1/8 inch but not over 1/4 inch. <u>1/</u>			X
	Open seam over 1/4 inch. <u>1/</u>		X	
	Stitches skipped or broken (on edge, top, or raise stitching when seam is seamed, turned, and stitched): <u>1/</u> - more than 1/4 inch but not more than 1/2 inch - more than 1/2 inch		X	X
	Raw edges on outside of jacket: <u>2/</u> - more than 1/8 inch but not more than 1/4 inch - more than 1/4 inch		X	X
	Raw edges on inside of jacket: <u>2/</u> - more than 1/2 inch but not more than 1 inch. - more than 1 inch		X	X

MIL-J-87251 (USAF)

TABLE VI. General defects. - Continued

	Defect	Major	Minor A	Minor B
6.	<u>Seams and stitchings.</u> - Contd Run offs on edge, top, or raise stitching if not resulting in open seam (outside only): <u>3/</u> - more than 1/2 inch but not more than 1 inch - more than 1 inch Seam or stitch not specified type. Loose tension resulting in loose seam. Loose tension on edge, top, or raise stitching recognized by loosely exposed loops of top or lower thread. Tight tension (stitches break when strain is applied in direction of seam or stitching). Stitches per inch (to be scored only when the conditions exists on major portion or half the length of seam and stitching): - less than the minimum. - more than the maximum.			
			X	X
			X	
		X		
			X	
		X		
			X	X
7.	<u>Buttonhole.</u> Buttonhole omitted. Buttonhole too small, not permitting button to enter buttonhole. Buttonhole too large, i.e., 3/8 inch or more longer than diameter of button. Buttonhole stitching not securely caught in fabric, causing stitching to pull away from fabric. One or more broken stitches in one buttonhole.			
		X		
		X		
			X	
		X		
				X

MIL-J-87251 (USAF)

TABLE VI. General defects. - Continued

	Defect	Major	Minor A	Minor B
7.	<u>Buttonhole.</u> - Contd			
	Buttonhole with ragged edges, affecting appearance.			X
	Buttonhole not specified type, uncut buttonhole.		X	
	Gimp not pulled through to underside.			X
	Gimp omitted on buttonhole.		X	
	More than two continuous skipped stitches in one or more buttonholes.		X	
8.	<u>Buttons.</u>			
	Buttons defective, missing, loose, or blistered.		X	

- 1/ A break in a line of stitching or continuous skipped or run-off stitches (except on edge, top, or raise stitching) shall be classified as an open seam.
- 2/ A raw edge shall be classified as such when it occurs along an edge required to be turned under and the edge is securely caught in the stitching, however if the edge has been cut, torn, slashed, or slit it shall be classified as an open seam.
- 3/ Run offs on joining seams, if resulting in an open seam, shall be classified as an open seam.

MIL-J-87251 (USAF)

TABLE VII. Defects applicable to specific parts.

	Defect	Major	Minor A	Minor B
1.	<u>Collar and stand.</u>			
	Collar tight at joining to neck seam causing puckers or pleats on fronts, back, or facings.		X	
	Collar edge irregular.		X	
	Collar poorly shaped or not uniform shape or size.		X	
	Top collar width at center back less than 2-1/4 inches or more than 2-1/2 inches.			X
	Top collar tight, i.e., causing edge of collar to curl or bulging on undercollar.		X	
	Top collar badly twisted, puckered or excessive fullness.		X	
	Collarstand tight, puckered, or pleated at joining to top collar and undercollar or at neck seam causing puckers or pleats on fronts, back, or facings.		X	
	Finished width of collarstand at center back less than 1-5/8 inches or more than 1-7/8 inches.			X
2.	<u>Cuffs.</u>			
	Cuff full or twisted, affecting appearance.		X	
	Width of finished cuff less than 2-7/8 inches or more than 3-1/8 inches.		X	
	Cuffs not specified class or color.		X	

MIL-J-87251 (USAF)

TABLE VII. Defects applicable to specific parts. - Continued

	Defect	Major	Minor A	Minor B
3.	<u>Bottom hem.</u> Jacket bottom puckered, twisted, or pleated by stitching forming bottom hem. Width of finished bottom hem less than 7/8 inch or more than 1-1/8 inches.	X		X
4.	<u>Hanger.</u> Hanger omitted or ends of hanger not securely backstitched or tacked. Length of hanger between tacks at ends less than 2-1/4 inches or more than 2-3/4 inches. Width of hanger less than 1/4 inch or more than 1/2 inch. Hanger off center 1 inch or more with center of collarstand.		X	X X X
5.	<u>Label.</u> Label missing or size marking omitted, incorrect, or illegible. Information (except size) missing, incorrect, or illegible. Label not stitched on four sides to front facing. Label not in proper location.	X		X X X

MIL-J-87251 (USAF)

TABLE VII. Defects applicable to specific parts. - Continued

	Defect	Major	Minor A	Minor B
6.	<u>Slash pockets.</u> Left and right slash pockets not in corresponding diagonal position with each other affecting appearance. Slash pockets 1/2 inch or more out of alignment. Length of slash pocket opening less than 5-7/8 inches or more than 6-1/8 inches. Width of welt less than 3/4 inch or more than 1 inch.	X	X	X
7.	<u>Sleeves.</u> Sleeve sagging, twisted, bulging, or short. Sleeve fullness misplaced or concentrated in one area. Sleeve lining too long, causing lining to sag at bottom.	X	X	
8.	<u>Shoulder loops.</u> Upper side of shoulder loop full or twisted, affecting appearance. Shoulder loop poorly shaped, affecting appearance. Shoulder loop misplaced so that shoulder seam is exposed or does not lie flat causing bulge or twist on shoulder loop. Shoulder loop misplaced, i.e., one shoulder loop further forward or back from position of other shoulder loop, affecting appearance.	X	X	

MIL-J-87251 (USAF)

TABLE VII. Defects applicable to specific parts. - Continued

	Defect	Major	Minor A	Minor B
8.	<u>Shoulder loops.</u> - Contd			
	Shoulder loop long, i.e., point extending beyond collar creaseline.	X		
	Width of shoulder loop at neck less than 1-3/8 inches or more than 1-5/8 inches.		X	
	Width of shoulder loop at armhole end less than 1-7/8 inches or more than 2-1/8 inches.		X	
9.	<u>Side seams, fronts, and front closure.</u>			
	Length of closed fronts uneven at neck 1/4 inch or more or at bottom 1/4 inch or more.		X	
	Slide fastener tape set on too loosely or too tightly causing excessive bulging on opening, affecting appearance open or closed.		X	
	Slide fastener not specified type, size, or style or any part of assembly omitted, bent, or broken.	X		
	Slide fastener exposed more than 1/16 inch or gapping more than 1/16 inch when closed.		X	
	Jacket part stitched too close to metal chain not permitting slider to pass.	X		
	Top end of slide fastener chain more than 3/4 inch from raw edge of neckline.		X	
	Top end of slide fastener chain less than 1/2 inch from raw edges of neckline.		X	

MIL-J-87251 (USAF)

TABLE VII. Defects applicable to specific parts. - Continued

	Defect	Major	Minor A	Minor B
10.	<u>Fusible material.</u>			
	Omitted in pocket welts, collar, collarstand, or shoulder loops.	X		
	Delamination of fused components:			
	- partial or complete delamination on any fused component.	X		
	- bubbling on any fused component.	X		
	Any strike through or bleed through.	X		
	Any resin transfer to jacket:			
	- on any fused component.	X		
	- non-fused component.	X		
11.	<u>Hook and loop pile fastener tapes.</u>			
	Hook and loop pile fastener tapes:			
	- missing from jacket or liner.	X		
	- out of alignment with marks on pattern by 1/4 inch or more.	X		
12.	<u>Liner.</u>			
	Size shown on liner not same as jacket.			X
	Liner tight or short causing puckering of jacket.	X		
	Ends of binding not caught in bartack or stitching.			X
	Fabric not securely caught in binding.		X	
	Fronts uneven in length by more than 3/4 inch.		X	
	Finished width of binding not as specified.			X
	Ends of binding overlapped less than 1/2 inch.			X

MIL-J-87251 (USAF)

5. PACKAGING

5.1 Preservation. In accordance with the requirements of MIL-STD-2073-1, preservation shall be level A, C, Commercial, or in hanger packs, as specified (see 6.2).

5.1.1 Level A. Each jacket, with slide fastener closed, shall be laid out flat, front down. Fold the sides of the jacket to the center of the back lengthwise and place sleeves lengthwise over the folded sides. Fold jacket in half by bringing bottom edge up to the collar. The complete folded jacket shall measure approximately 14 inches in length by 11 inches in width. Each folded jacket shall be inserted in a snug-fitting, clear polyethylene film bag conforming to A-A-50083.

5.1.2 Level C. Each jacket shall be preserved in accordance with MIL-STD-2073-1 requirements for this level.

5.1.3 Commercial. Each jacket shall be preserved in accordance with the applicable requirements of ASTM D 3951.

5.1.4 Hanger pack. Each jacket shall be preserved in a plastic bag conforming to type II of A-A-1696.

5.2 Packing. In accordance with the requirements of MIL-STD-2073-1, packing shall be level A, B, C, or Commercial, or in hanger packs, as specified (see 6.2).

5.2.1 Level A. Fifteen jackets, of one size only, preserved as specified in 5.1, shall be packed in a snug-fitting, exterior-type shipping container conforming to PPP-B-601, overseas type. Closure and strapping shall be in accordance with the appendix of the container specification.

5.2.2 Level B. Fifteen jackets, of one size only, preserved as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to type CF, class domestic, variety SW, grade 200, style RSC-L of PPP-B-636. The liner shall be as specified in PPP-B-636. Closure and strapping shall be in accordance with the appendix of the container specification.

5.2.2.1 Weather-resistant fiberboard container. When specified (see 6.2), the shipping container shall be a grade V3c, W5c, or W6c fiberboard box fabricated in accordance with PPP-B-636 and closed in accordance with the appendix of the container specification, except that the inspection shall be in accordance with 4.4.4.

5.2.3 Level C. Fifteen jackets, of one size only, preserved as specified in 5.1, shall be packed in accordance with MIL-STD-2073-1 requirements for this level.

5.2.4 Commercial. Fifteen jackets, of one size only, preserved as specified in 5.1, shall be packed in accordance with the applicable requirements of ASTM D 3951.

MIL-J-87251 (USAF)

5.2.5 Hanger pack. Twelve jackets of one size only, preserved as specified in 5.1, shall be packed in a type I container, using a style A or B hanger bar, in accordance with MIL-C-44192.

5.3 Palletization. When specified (see 6.2), jackets packed as specified in 5.2, shall be palletized on a 4-way, type I, style 1, 1A, or 1B, size A, class 1 pallet fabricated in accordance with MIL-P-15011 or on a 4-way, type IV, V, or VIII, class 1, size 2, grade A pallet fabricated in accordance with NN-P-71. Each prepared load shall be in accordance with load type I or Ia and bonded with the applicable strap bonding or film bonding means specified in MIL-STD-147. The pallet pattern shall be in accordance with the appendix of MIL-STD-147. Interlocking of loads shall be effected by reversing the pattern of each course. If the container is of a size which does not conform to any of the patterns specified in MIL-STD-147, the pallet pattern used shall be approved by the contracting officer.

5.3.1 Hanger pack. When specified (see 6.2), jackets packed as specified in 5.2 shall be palletized in accordance with the appendix of MIL-C-44192 using pallet load pattern number 95.

5.4 Marking. In addition to any special marking required by the contract or purchase order, unit packages, the shipping containers or hanger packs as specified (see 6.2), and palletized unit loads shall be marked in accordance with MIL-STD-129, ASTM D 3951, or the appendix of MIL-C-44192, as applicable.

5.4.1 Bar code markings. Bar code markings, when specified (see 6.2), shall be in accordance with MIL-STD-129.

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

5.4.3 Labels, mixed sizes. At the end of the contract, shipping containers packed with mixed sizes shall have securely attached to the end and side, directly under the printing or stenciling, a white paper label with the words 'MIXED NSN'S' plainly stamped or printed thereon and under these words shall be legibly stamped or printed the correct quantity and NSN's contained therein.

6. NOTES

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

6.1 Intended use. The jacket, with removable liner, covered by this specification is intended to be worn by female personnel of the Department of the Air Force.

MIL-J-87251 (USAF)

6.2 Acquisition requirements. Acquisition documents should specify the following:

- a. Title, number, and date of this specification.
- b. Length 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 and 2.2).
- d. When a first article is required (see 3.1).
- e. Selection of applicable levels of preservation and packing or hanger packs (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).
- h. When bar code markings are required (see 5.4).

6.3 Samples. For access to samples of the end item and shade samples, address the contracting activity issuing the invitation for bids (see 3.2).

6.4 First article. When a first article inspection is required, the item should be a first article sample. The contracting officer should also include specific instructions in acquisition documents regarding arrangements for examinations, approval of first article test results and disposition of first articles. Invitations for bids should provide that the Government reserves the right to waive the requirement for samples for first article inspection to those bidders offering a product which has been previously acquired or tested by the Government, and that bidders offering such products, who wish to rely on such production or test, must furnish evidence with the bid that prior Government approval is presently appropriate for the pending contract. Bidders should not submit alternate bids unless specifically requested to do so in the solicitation.

6.5 Recycled material. It is encouraged that recycled material be used when practical as long as it meets the requirements of this document (see 3.3).

MIL-J-87251 (USAF)

6.6 Supply source. The insulating material (see 3.3.3) is available from the following manufacturers:

Thinsulate

3M Insulation and Specialty Fabrics
220-7W 3M Center
St. Paul MN 55144-0001

Thermolite

Dupont Fiber Fill Division
Larrel Run
Wilmington DE 19880-0705

6.7 Subject term (key word) listing.

Jacket, lightweight
Jacket, woman's
Liner, jacket, removable

6.8 Supersession data. This specification includes the requirements of Purchase Description AESC 87-2 and supersedes MIL-J-83486 (USAF).

Custodian:
Air Force - 11
DLA - DP

Preparing activity:
Air Force - 11

Reviewers:
Air Force - 82, 99
DLA-CT

(Project No. 8410-F678)

User:
Air Force - 45

MIL-J-87251 (USAF)

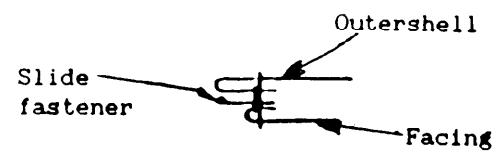
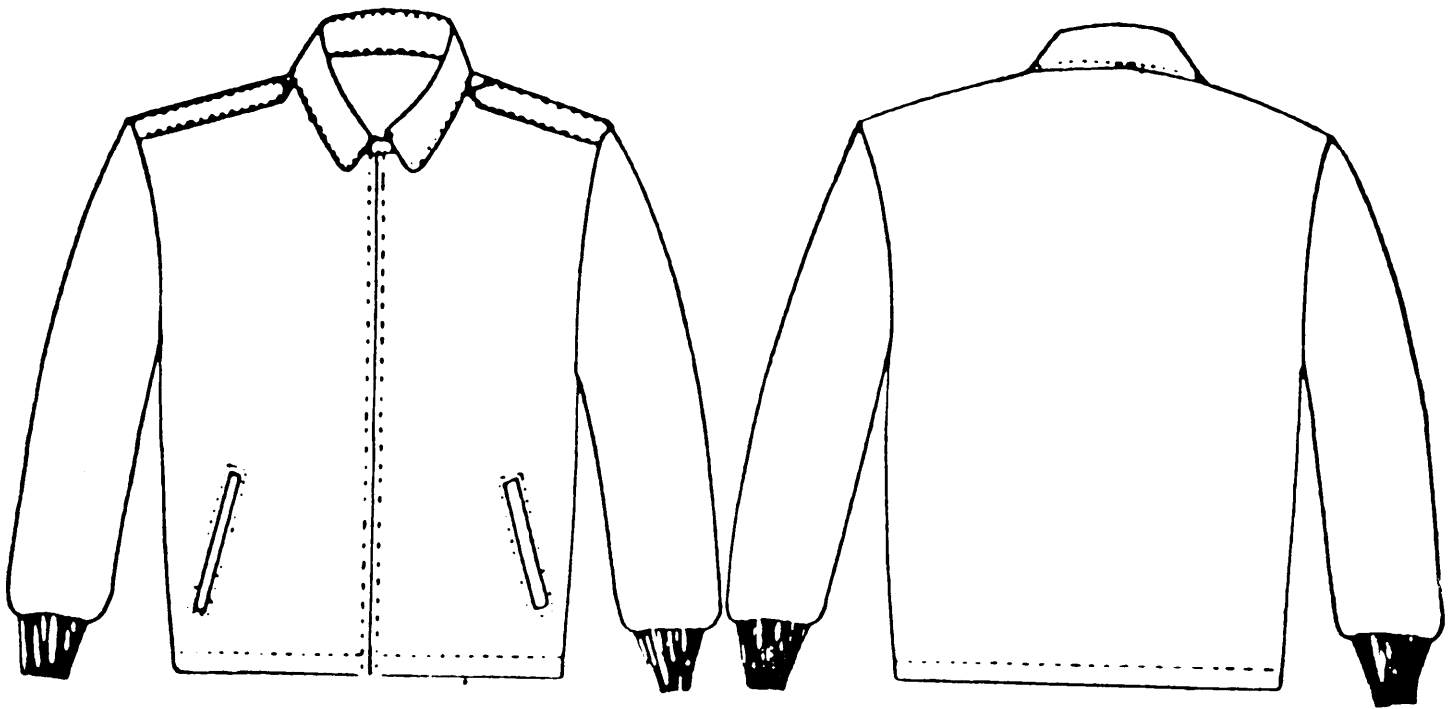


FIGURE 1. Outershell for woman's lightweight jacket (front and rear views).

MIL-J-87251 (USAF)

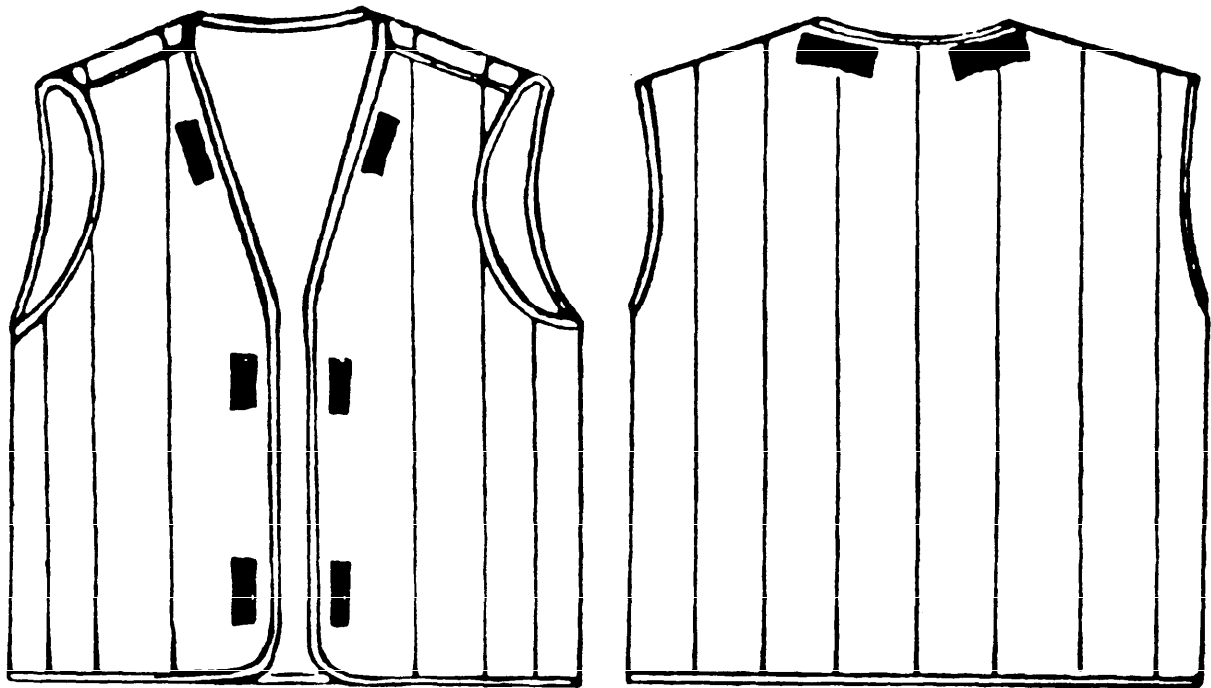


FIGURE 2. Liner for woman's lightweight jacket (front and rear views).

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

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

(Fold along this line)

(Fold along this line)

DEPARTMENT OF THE AIR FORCE

ASD/ENES

Wright-Patterson AFB OH 45433-6503



NO POSTAGE NECESSARY IF MAILED IN THE UNITED STATES

BUSINESS REPLY MAIL

FIRST CLASS PERMIT NO. 73236 WASHINGTON D. C.

POSTAGE WILL BE PAID BY THE DEPARTMENT OF THE AIR FORCE

ASD/ENES

Wright-Patterson AFB OH 45433-6503



STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

1. DOCUMENT NUMBER

MIL-J-87251(USAF)

2. DOCUMENT TITLE

Jacket, Woman's: Lightweight With Removable Liner

3a. NAME OF SUBMITTING ORGANIZATION

4. TYPE OF ORGANIZATION (Mark one)

☐

VENDOR

☐

USER

☐

MANUFACTURER

☐

OTHER (Specify): _____

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

5. PROBLEM AREAS

a. Paragraph Number and Wording:

b. Recommended Wording:

c. Reason/Rationale for Recommendation:

6. REMARKS

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

b. WORK TELEPHONE NUMBER (Include Area Code) - Optional

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

8. DATE OF SUBMISSION (YYMMDD)