

INCH-POUND

MIL-L-27546D (USAF)
23 April 1991

SUPERSEDING
MIL-L-27546C (USAF)
2 February 1972

MILITARY SPECIFICATION

LINER: FLYER'S JACKET, AND FLYER'S TROUSERS,
CWU-9/P

This specification is approved for use within 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 contains the requirements for one type of liner for flyer's jackets and trousers with the designation of CWU-9/P.

1.2 Classification. The jackets and trousers shall be of the following sizes as specified (see 6.2):

Schedule of sizes

Small	34 - 36
Medium	38 - 40
Large	42 - 44
Extra-Large	46 - 48

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

V-F-106	Fastener, Slide, Interlocking.
V-T-276	Thread, Cotton.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Technology & Industrial Services Division, San Antonio ALC/TIRDM, Kelly AFB Texas 78241 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8415

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

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JJ-W-155	Webbing, Textile (Cotton, Elastic).
DDD-L-20	Label: For Clothing, Equipage, and Tentage (General Use).
PPP-B-601	Boxes, Wood, Cleated Plywood.
PPP-B-636	Box, Shipping, Fiberboard.

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MIL-F-10884	Fasteners, Snap.
MIL-B-41826	Batting, Synthetic Fibers, Polyester (Unquilted and Quilted).

STANDARDS

FEDERAL

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

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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 STANDARDIZATION DOCUMENTS ORDER DESK, BLDG. 4D, 700 Robbins Avenue, Philadelphia PA 19111-5094.)

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.

DRAWINGS

AIR FORCE

61B4028	Liner, Flyer's, CWU-9/P, Trousers.
61B4033	Liner, Flyer's, CWU-9/P, Jacket.

(Copies of the drawing are available from the contracting activity or as directed by the contracting activity.)

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

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM D 3951	Standard Practice for Packaging, Commercial. (DoD Adopted)
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(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia PA 19103-1187.)

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

2.3 Order of precedence. In the event of a conflict between the text of this document and the references cited herein (except for related associated detail specifications, specification sheets, or MS standards), the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

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

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

3.2.1 Basic material. The basic material shall conform to type VIII, cover D, style a, and class 9 of MIL-B-41826.

3.2.1.1 Color, basic material. The color shall be sage green USAF Color Shade No. 1511 (see 6.2 and 6.5). Unless other wise specified, the cloth shall be dyed with applicable premetallized or acid dyes.

3.2.2 Sewing thread. Except for the thread used for quilting, all sewing thread used shall conform to V-T-276. Thread conforming to type IC2, 3 ply, ticket No. A shall be used for all seaming, sewing, and safety stitching; thread conforming to type IA3, 2 ply, ticket No. 70 shall be used for overedging (serging).

3.2.2.1 Color, thread. The color of the thread shall be sage green USAF Color Shade No. 1509 (see 6.5) and shall have good color fastness.

3.2.3 Elastic webbing. The elastic webbing, used for the waistband, shall conform to type I, class 13, of JJ-W-155. The webbing shall be 1-3/4 inches wide and the color shall be natural.

3.2.4 Knit cloth for anklets, wristlets, and colarettes. Knit cloth shall be used for the anklets, wristlets, and colarettes.

3.2.4.1 Yarns. The knit cloth shall be made of alternating cotton and nylon yarns. The cotton yarns shall be evenly carded, drawn, and spun into singles, with sufficient twist to meet the requirements of this specification. The nylon yarns shall be spun on the worsted system and plied into 2-ply yarns with sufficient twist to meet the requirements of this specification. All yarns shall be free from foreign matter.

3.2.4.2 Anklets. The anklets shall be made on a circular knitting machine using a 1 by 1 rib stitch, the ends having a tuck or expanding stitch of 1/2 inch minimum when cut and doubled and with one end of yarn per feed. Three courses of single, cotton yarn shall alternate with one course of 2-ply spun nylon yarn. The anklets shall be finished to a folded width of 3 inches (plus or minus 1/4 inch) and an open length of 9 inches (plus or minus 1/4 inch). They shall be constructed to have not less than 14 wales per inch and not less than 18 courses per inch. The weight of the anklets shall not be less than 12 ounces per one dozen pairs.

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3.2.4.3 Wristlets. The wristlets shall be made on a circular knitting machine using a 1 by 1 rib stitch, the ends having a tuck or expanding stitch of 1/2 inch minimum when cut and doubled and with one end of yarn per feed. Three courses of single, cotton yarn shall alternate with one course of 2-ply spun nylon yarn. The wristlets shall be finished to a folded width of 2-1/2 inches (plus or minus 1/4 inch) and an open length of 9 inches (plus or minus 1/4 inch). They shall be constructed to have not less than 14 wales per inch and not less than 18 courses per inch. The weight of the wristlets shall not be less than 9 ounces per one dozen pairs.

3.2.4.4 Collarettes. The cloth for the collarettes shall be made on a circular or on a flat-bed knitting machine using a 1 by 1 rib stitch and with one end per feed. Three courses of single, cotton yarn shall alternate with one course of two-ply, spun nylon yarn. The cloth shall have not less than 14 wales per inch and not less than 18 courses per inch. The weight of the cloth shall be not less than 12 ounces per square yard.

3.2.4.5 Color. The color of the anklets, wristlets, collarettes, and the tape of the slide fastener shall be sage green USAF color shade No. 1509 or 1511 (see 6.5).

3.2.4.5.1 Color match. The color shall match the approved shade, as specified in 3.2.4.5, under natural (north sky) daylight or artificial daylight having a color temperature of 7,500 degrees Kelvin and shall be a good approximation of the approved shade under incandescent lamplight at 2,800 degrees Kelvin.

3.2.4.5.2 Colorfastness. The knit cloth shall show "good" colorfastness to laundering, perspiration, and crocking when tested as specified in 4.4.1.

3.2.5 Slide fastener. The slide fastener for the front opening of the jacket shall conform to type IV, style 8, size LMS, with a short tab pull of V-F-106. The metal components shall be dark oxidized or natural brass. The width of the tape shall be 9/16 inch (plus or minus 1/32 inch); the tape shall show "good" colorfastness to laundering, perspiration, and crocking as specified in 4.4.1. The length of the slide fastener for all sizes of the jacket shall be 20 inches (plus or minus 1/14 inch with a minimum tape extension of 1-1/4 inches on the top end).

3.2.6 Snap fasteners. The snap fasteners shall conform to style 2A, finish 2, of MIL-F-10884. The color of the exposed surface of the cap portion of the snap fastener shall match the color of the outer-shell material, as specified in 3.2.1.1, or shall be black.

3.3 Design.

3.3.1 Jacket. The jacket shall be a shaped, loose-fitting style and shall have a separable slide-fastener, a straight front center opening concealed by an outside flap with four snap buttons, a knit collarette and cuffs, and a patch pocket on the outside left breast.

3.3.2 Trousers. The trousers shall have an elastic waistband, covered with the basic material, with snap buttons for closure, three snap buttons for the fly closure, and a patch pocket on the outside of each hip. The trousers shall terminate in knit anklets.

3.4 Construction. The jacket and trousers shall be constructed in accordance with drawings 61B4033 and 61B4028 respectively and table I, (see figure I). The manufacturer is not required to follow the exact sequence of operations therein, unless otherwise specified.

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3.4.1 Stitches, seams, and stitchings. Stitches, seams, and stitchings shall conform to FED-STD-751. Wherever two or more methods of seams or stitches are specified, either may be used. Where stitch type 401 is used, the looper (underthread) shall be on the inside of the garment. Unless specified, top stitching and edge stitching shall be 1/16 inch gage from the edge. Overedge or serging seams shall be 3/16 inch to 1/4 inch gage from the edge. Where safety stitch types 301 or 401 and 602 are used, the tolerance shall be plus 0 (zero), minus 3/16 inch.

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

3.4.1.2 Thread breaks and ends of seams. 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 beyond the break not less than 1/2 inch. Skipped stitches or thread breaks (stitch type 401) may be repaired using stitch type 301.

3.5 Patterns. Standard patterns, which provide an allowance of 1/2 inch for plain seams, will be furnished by the Government (see 6.4). The standard patterns shall not be altered in any way and shall be used only as a guide for cutting the manufacturer's working patterns. The manufacturer's working patterns shall be identical in size and shape to the standard patterns.

3.6 Finished measurements. The finished measurements of the jacket and trousers shall conform to tables II and III, respectively.

3.7 Color. Unless otherwise specified, and except for the insulating material (filler) which shall be natural, the component parts of garments shall be sage green.

3.8 Labels. Each jacket and trousers shall have a combination identification and size, and a laundering label. The labels shall conform to type VI, of DDD-L-20, shall show "good" colorfastness to laundering, and measure not less than 1-9/16 inches wide by 2-3/4 inches long.

3.8.1 Combination identification and size label. The combination identification and size label shall conform to class 1 and 2, and contain the following information:

1. Liner, Flyer's CWU-9/P (Jacket or Trousers 1/)
2. Contract number 1/
3. Textile Fiber Products Act information 1/
4. Contractor's Name 1/
5. Size 1/
6. Stock Number 1/

1/ The contractor shall insert the applicable information.

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3.8.2 Laundrying instruction label. The laundrying instruction label shall be titled: LINER, FLYER'S (CWU-9/P) (JACKET or TROUSERS 1/). The label shall conform to class 3, and contain the following information.

1. Machine washing. Use Permanent Press Cycle. Wash in warm water with mild detergent.

2. Hand washing. Wash in warm water using mild detergent. DO NOT WRING OR TWIST. Rinse in clean warm water.

3. DO NOT USE CHLORINE BLEACH OR STARCH.

4. Dry at low heat (do not exceed 130⁰ F). After drying, tumble at room temperature for 10 minutes. Remove immediately from dryer. To drip dry, remove from water and place on rust-proof hanger.

DO NOT REMOVE THIS LABEL

1/ The contractor shall insert the applicable information.

3.8.3 Garment instruction label. A garment instruction label shall be included inside the sealed polyethylene bag with the jacket and trousers (see 5.1.1). The label shall be made of bond paper measuring not less than 3-1/2 inches by 3-1/2 inches. The label shall contain the following information:

"The garment shall be unpacked and shaken out,
at a room temperature of approximately 70 degrees Fahrenheit,
before fitting to insure your correct size".

3.9 Workmanship. The liners shall be constructed in a thoroughly workmanlike manner. The completed liners shall be well finished and free from any defects that might affect appearance or serviceability.

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 section 3 and 5. The inspection set forth in this specification shall become part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the contractor of the responsibility of ensuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations, is an acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to accept defective material.

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

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

4.3 First article inspection. When required, the first article submitted in accordance with 3.1 shall be inspected for visual defects as specified in 4.4.2, and examined for dimensional defects as specified in table II and table III.

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

4.4.1 Component and material inspection. In accordance with 4.1, components listed in table IV and materials shall be inspected for the characteristics identified therein using the test methods specified in FED-STD-191.

4.4.1.1 Sampling for testing. Unless specifically requested by the Government, furnished materials shall not be tested. The sample unit for testing components shall be the quantity necessary to perform all required tests one time each. The inspection level for each component shall be S-1 of MIL-STD-105. Unless otherwise specified in the applicable component specification the acceptance quality level for each characteristic tested shall be 6.5 defects per 100 units. The unit size shall be 1 yard full width or 1 lot of 12 (1 dozen) as expressed. The sample size for knit cloth shall be expressed in yards or for the end item and component parts in lots of 12 (dozens).

4.4.2 Examination of end items. The end item shall be examined for defects. Defects found during this examination shall be classified as specified in 4.4.2.1, 4.4.2.2, and 4.4.2.3. The sample unit for this examination shall be one jacket liner or one trouser liner, as applicable, unless otherwise specified.

4.4.2.1 General defects. General defects shall be classified as specified in table V.

4.4.2.2 Detailed defects applicable to specific parts. Detailed defects applicable to specific parts shall be classified as specified in table VI.

4.4.2.3 Finished measurement defects.

4.4.2.3.1 Jacket. Any finished measurement of the back length, the chest, the sleeve outseam, the sleeve bottom top of knit, and the sweep deviating from the nominal measurements and tolerances specified in table II shall be classified as a finished measurement defect.

4.4.2.3.2 Trousers. Any finished measurement of the relaxed waist, the extended waist, the seat, the outseam, the inseam, and the bottom deviating from the nominal measurements and tolerances specified in table III shall be classified as a finished measurement defect.

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4.4.2.4 Inspection levels and acceptable quality level. The inspection level for 4.4.2.1 and 4.4.2.2 shall be II of MIL-STD-105, and the inspection level for 4.4.2.3 shall be S-3 of MIL-STD-105. The acceptable quality level for 4.4.2.1 and 4.4.2.2 shall be 2.5 defects per 100 units for major defects, 6.5 defects per 100 unit for major and minor A defects, and 25.0 defects per 100 units for major and minor A and B defects. The acceptable quality for 4.4.2.3 shall be 4.0 defects per 100 units.

4.4.3 Examination of preparation for delivery requirements. An examination shall be made to determine that packaging, packing, and marking comply with the Section 5 requirements of this specification. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully prepared for delivery with the exception that it need not be sealed. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot size shall be the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 and the AQL shall be 2.5 defects per 100 units.

<u>Examine</u>	<u>Defect</u>
Marking (exterior & interior)	Omitted; incorrect; illegible; of improper size, location, sequence, or method or application.
Materials	Any component missing, damaged or not as specified
Workmanship	Inadequate application of components, such as incomplete closure of container flaps; loose strapping; inadequate stapling. Bulged or distorted container.
Content	Number of bundles is more or less than required. Number of liners per bundle is more or less than required. 1/

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

5. PREPARATION FOR DELIVERY

5.1 Preservation. Preservation shall be level A, C, or Commercial as specified (see 6.2).

5.1.1 Level A. Each jacket and pair of trousers shall be preserved to the MIL-STD-2073/1 requirements for this level.

5.1.2 Level C. Jackets and trousers shall be preserved to the MIL-STD-2073/1 requirements for this level.

5.1.3 Commercial. Jackets and trousers shall be preserved in accordance with the applicable requirements of ASTM D 3951.

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

5.2.1 Level A. Four jackets or four pairs of trousers that have been preserved and packaged as specified in 5.1 shall be packed in exterior type shipping containers that conform to PPP-B-601 overseas type. The closure of the shipping container shall be in accordance with the appendix of the applicable shipping container specification.

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5.2.2 Level B. Four jackets or four pair of trousers that have been preserved and packaged as specified in 5.1 shall be packed in exterior type shipping containers that conform to PPP-B-636 class weather resistant. The closure of the shipping container shall be in accordance with the appendix of the applicable shipping container specification.

5.2.3 Level C. Jackets and trousers that have been preserved and packaged as specified in 5.1 shall be packed in accordance with the requirements of MIL-STD-2073/1.

5.2.4 Commercial. Jacket and trousers that have been preserved and packaged as specified in 5.1 shall be packed in accordance with the requirements of ASTM D 3951.

5.3 Marking.

5.3.1 Levels A, B, and C. In addition to any special or other identification markings required by the contract (see 6.2) each unit pack and exterior container shall be marked in accordance with MIL-STD-129.

5.3.2 Commercial. Garment shall be marked in accordance with the applicable requirements of ASTM D 3951.

5.4 Palletization. Unitized loads, commensurate with the level of packing specified in the contract or order shall be palletized in accordance with MIL-STD-147. Palletized loads shall be uniform in size and quantities to the greatest extent possible. If the container is of a size which does not conform to any of the pallet patterns specified in MIL-STD-147, the pallet pattern shall first be approved by the contracting officer.

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 liners covered by this specification are intended to be used during cold weather, for warmth, by male flight personnel of the Department of Defense.

6.2 Acquisition requirements. Acquisition documents must specify the following:

- a. Title, number, and date of the specification.
- b. Issue of DODISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.1).
- c. Size required (see 1.2).
- d. First article (see 3.1, 4.3, and 6.3).
- e. Color (see 3.2.1.1)
- f. Selection of applicable levels of preservation and packing (see 5.1 and 5.2).
- g. When palletization is required (see 5.4).

6.3 First article. The item covered by this specification requires first article approval. The first article shall be a production sample. The first article shall consist of one complete jacket and one complete pair of trousers. The contracting officer shall include specific instructions in all procurement instruments, arrangements for examination, and approval of first article (see 3.1 and 4.3).

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6.4 Standard Patterns. For access to standard patterns, address the procuring activity issuing the invitation for bids.

6.5 USAF color sample. USAF color samples may be obtained from the procuring activity or as directed by the contracting officer.

6.6 Subject term (key word) listing.

Underclothing

Undergarment

Protective

Warmth

Cold weather

Winter

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

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TABLE I. Manufacturing operations.

No.	Description of operation	Stitch type	Seam and stitching type	Stitches per inch
1.	CUTTING. all component parts shall be cut from one piece of material, except waistband which may be cut from ends and may be roll cut and shall be cut in strict accordance with the patterns that show size, shape, directional lines, placement of pockets, and instructions for assembling of parts.			
2.	<p>REPLACEMENT OF DAMAGED PARTS</p> <p>a. Care shall be exercised during the superseding and cutting operations to assure that material defects which may seriously affect appearance or serviceability shall not be included in any of the component parts.</p> <p>b. Any component part containing material defects which may seriously affect appearance or serviceability shall not be included in any of the liners.</p> <p>c. Any component part containing damages which occurred during the construction process that may affect appearance or serviceability shall be replaced.</p> <p>d. the directional lines on the patterns, all parts of the jacket and trousers, including the pockets, shall have the quilting design running in the lengthwise direction of the item.</p>			
3.	<p>SHADE MARKING</p> <p>a. All component parts shall be properly marked, ticketed, or bundled to insure uniform shade, size, and proper assembly throughout the garments.</p> <p>b. The use of metal fastening devices or of tickets sewn on by machine shall not be used for shade marking component parts.</p> <p style="text-align: center;">JACKET</p>			
4.	<p>PATCH POCKET. The finished pocket shall measure 5 inches (plus or minus 1/4 inch) wide at the opening and 5-5/8 inches (plus or minus 1/4 inch) in depth. The pocket shall set smoothly without fullness. The side edges shall be parallel to the center front closing.</p> <p>a. Overedge stitch the raw edge of the pocket all around.</p>	503 or 504	EFd-1	6-10

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TABLE I. Manufacturing operations. (Continued)

No.	Description of operation	Stitch type	Seam and stitching type	Stitches per inch
	b. Turn in the top edge, and hem the pocket 3/8 inch (plus or minus 1/8 inch), with a single row of stitching, 1/8 inch from the overedge.	301	EFa-1	10-14
	c. Position the patch pocket on the left front at the marks; turn in the sides and the bottom edge 3/8 inch, and single stitch 1/8 to 3/16 inch from the edge.	301	LSd-1	10-14
	d. Tack each end of the pocket opening at the top corner in line with the pocket stitching, with 1/2 inch, vertical bartack.	bar-tack		28 per bartack
5.	MAKE FRONTS. Overedge stitch the raw edge of the left front.	503 or 504	EFd-1	6-10
	a. Position the slide fastener on the left front, with the edge of the tape even with the overedged edge, and seam the tape full length through the shell, with a single row of stitching, 1/8 inch from the edge.	301	SSa-1	10-14
	b. Fold back the left front in accordance with the pattern and seam with a double row of stitching adjacent to the first row through and through, with the ends securely tacked.	301	EFa-2	10-14
	c. The left front facing shall finish 1-5/8 inches (plus or minus 1/4 inch) wide.			
	d. Overedge stitch the raw edge of the right front.	503 or 504	EFd-1	6-10
	e. Fold back the right front, in accordance with notches on patterns, and stitch with a double row of stitching. The first row to be as close as possible to the overedge edge and the second row shall be in the middle of the facing. The facing shall finish 1-3/4 inches (plus or minus 1/4 inch) wide.	301	EFa-2	10-14
	f. Position the right slide fastener on the front, with the scoops 7/8 inch (plus or minus 1/8 inch) from the front edge, and seam through the front and the fastener tape, with a double row of stitching, 3/16 inch to 1/4 inch gage, with first row of stitching 1/16 inch from the edge of the tape.	301	SSa-2	10-14
	g. Tack the bottom ends of the left and the right fastener tapes through and through with a 1/2 inch vertical bartack, parallel with the rows of stitching.	bar-tack		28 per bartack

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TABLE I. Manufacturing operations. (Continued)

No.	Description of operation	Stitch type	Seam and stitching type	Stitches per inch
	NOTE: The top ends of the left and the right parts of the fastener tape shall be exposed approximately 3/4 inch (plus or minus 1/4 inch) at the neckline and shall be caught in the collar seaming.			
6.	JOINING			
	a. Side seam. Join the fronts to the backs, with a single row of stitching, 3/8 inch from the edge.	301 or 401	SSa-1	10-14
	b. Shoulder seams. Join the shoulder seams, with a single row of stitching, 3/8 inch from the edge.	301 or 401	SSa-1	10-14
	c. Overedge stitch the raw edges of the side seams and the shoulder seams together.	503 or 504	EFd-1	6-10
	- OR -			
	d. Overedge stitch and join the side seams and the shoulder seams in one operation, 3/8 inch seam.	301 or 401 & 602	SSa-2 SSa-2	10-14 10-14
7.	MAKE SLEEVES			
	a. Join the sleeve seams, with a single row of stitching, 3/8 inch from the edge.	301 or 401	SSa-1	10-14
	b. Overedge stitch the raw edges together.	503 or 504	EFd-1	6-10
	- OR -			
	c. Overedge stitch and join the sleeves in one operation, 3/8 inch from the edge.	516 or 517 or 518 or 519	SSa-2	10-14
8.	PREPARE KNITTED CUFF. The knit cuff shall be flare type, folded in half, with the top raw edges meeting (seam on the inside of the fold) and shall be approximately 2-1/2 inches by 9 inches before folding.			
	a. Seam the prefolded raw edges of the knit cuff to the bottom of the sleeves, with a single row of stitching, 3/8 inch from the edge.	301 or 401	SSa-1	10-14
	b. Overedge stitch the raw edges of the knit cuff and the bottom of the sleeves together.	503 or 504	EFd-1	6-10
	- OR -			

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TABLE I. Manufacturing operations. (Continued)

No.	Description of operation	Stitch type	Seam and stitching type	Stitches per inch
9.	c. The prefolded knit cuffs may be joined and overedged to the bottom of the sleeves in one operation.	516 or 517 or 518 or 519	SSa-2	10-14
	9. SEW IN SLEEVES			
	a. Sew the sleeves of the jacket to the arm-hole, in accordance with the patterns, distributing sleeve fullness, with a single row of stitching, 3/8 inch from the edge.	301 or 401	SSa-1	10-14
	b. Overedge stitch the raw edges together. - OR -	503 or 504	EFd-1	6-10
10.	c. Overedge stitch and join the sleeves to the armholes in one operation, with a 3/8 inch seam	516 or 517 or 518 or 519	SSa-2	10-14
	NOTE: This operation shall be performed after joining of the shoulder and the side seam.			
	10. SEW ON COLLAR. The knit collar shall be cut in accordance with the patterns and shall be shaped. Fold the knit collar in half with the raw edges meeting.			
	a. Seam the prefolded knit collar to the neck, with a single row of stitching, 3/8 inch from the edge.	301 or 401	SSa-1	10-14
	b. Overedge stitch the raw edge of the knit collar and the neck together. - OR -	503 or 504	EFd-1	6-10
	c. The prefolded knit collar may be seamed to the neck by overedge and stitching in one operation.	516 or 517 or 518 or 519	SSa-2	6-10
	d. Turn the knit collar down, and raise stitch at the top of the neck, with a single row of stitching, 1/4 inch gage.	301	LSq-2(b)	10-14
	NOTE: Each front edge of the knit collar shall finish even with each front edge of the finished jacket.			
11.	HEM BOTTOM OF JACKET			
	a. Overedge stitch the bottom raw edge.	503 or 504	EFd-1	6-10

MIL-L-27546D(USAF)

TABLE I. Manufacturing operations. (Continued)

No.	Description of operation	Stitch type	Seam and stitching type	Stitches per inch
	<p>b. Turn up the bottom of the jacket to the inside, and single stitch through the jacket, adjacent to the overedge stitching; continue the stitching across the ends of the hem 1/16 to 1/8 inch from the front edges. The hem shall finish 1/2 inch (plus or minus 1/8 inch) wide.</p> <p style="text-align: center;">TROUSERS</p>	301	EFa-1	10-14
12.	PATCH POCKETS			
	a. Overedge stitch all raw edges of the pockets.	503 or 504	EFd-1	6-10
	b. Turn in the top edge of the pocket, and hem with a single row of stitching, 1/8 inch from the overedge edges. The finished hem shall measure 3/8 inch (plus or minus 1/8 inch) wide.	301	EFa-1	10-14
	c. Position the pockets on the backs at the marks; turn in the sides and the bottom edge 3/8 inch, and single stitch 1/8 to 3/16 inch from the edge.	301	LSd-1	10-14
	d. Tack each end of the hip pocket opening at the top corner in line with pocket stitching with a 1/2 inch vertical bartack.	bar-tack		28 per bartack
	NOTE: The finished pocket shall measure 6-1/4 inches (plus or minus 1/4 inch) wide at the opening, and 6 inches (plus or minus 1/4 inch) in depth from the bottom to the top edge of the pocket. The top of the finished pocket shall be centered on each hip, 3 inches (plus or minus 1/2 inch) down from the top of the trousers before the waistband is attached and 5 inches (plus or minus 1/2 inch) from the side seam to the center of the pocket.			
13.	MAKE FLIES			
	a. Overedge stitch the back edge of the left piece.	503 or 504	EFd-1	6-10
	b. The left fly shall be a double thickness of the material. Fold the back edge of the left fly at the notch, and seam the double thickness of material 1/8 inch from the back edge through the front. The left fly shall finish 1-1/2 inches (plus or minus 1/4 inch) wide.	301	EFa-1	10-14

MIL-L-27546D (USAF)

TABLE I. Manufacturing operations. (Continued)

No.	Description of operation	Stitch type	Seam and stitching type	Stitches per inch
	c. The right fly shall be one thickness of material. Overedge stitch the front edge of the right fly.	503 or 504	EFd-1	6-10
14.	JOIN CROTCH SEAM. Join the crotch seam from the bottom to the fly, with a single row of stitching, 3/8 inch from the edge.	301 or 401	SSa-1	10-14
	a. Overedge stitch the edge of the crotch seam together or individually.	503 or 504	EFd-1	6-10
15.	MAKE FLIES CONTINUED			
	a. Fold the left fly piece over the right fly piece, and stitch down with a single row of stitching, forming a 1 inch triangle at the base of the fly, continuing the stitching from the base of the fly to the crotch seam.	301	SSa-1 and LSq-2(b)	10-14
	b. Sew a 1/2 inch horizontal bartack on the outside through the right and left flies at the bottom of the fly opening.	bar- tack		28 per bartack
16.	JOIN SEAT SEAM			
	a. Join the seat seam from the bottom of the crotch seam to the top of the trousers, with a single row of stitching, 3/8 inch from the edge.	301 or 401	SSa-1	10-14
	b. Overedge stitch the edges of the seat seam together to the top of the trousers.	503 or 504	EFd-1	6-10
	- OR -			
	c. The crotch seam and the seat seam may be joined and overedged in one operation.	516 or 517 or 518 or 519	SSa-2	10-14
	d. Raise the seat seam from the bottom of the crotch to the top of the trousers before the waistband is attached, with a double needle operation, 1/4 inch gage, with the right overlapping the left.	401	LSq-3(b)	8-10
17.	JOIN INSEAMS AND OUTSEAMS			
	a. The inseams and the outseams shall be joined with a 3/8 inch seam.	301 or 401	SSa-1	10-14
	b. The overedge stitch the edges of the joined inseam and the outseam together.	503 or 504	EFd-1	6-10
	- OR -			

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TABLE I. Manufacturing operations. (Continued)

No.	Description of operation	Stitch type	Seam and stitching type	Stitches per inch
18.	c. The inseams and the outseams may be joined and overedged together in one operation.	516 or 517 or 518 or 519	SSa-1	10-14
	18. PREPARE KNIT ANKLETS			
	a. The anklets shall be flare type, folded in half, with the raw edges meeting and shall be 3 inches (plus or minus 1/4 inch) wide by 9 inches (plus or minus 1/4 inch) long before folding.			
	b. Seam the prefolded raw edges of the anklets to the bottom of the legs, with a single row of stitching, 3/8 inch from the edge.	301 or 401	SSa-1	10-14
19.	c. Overedge stitch the raw edges together.	503 or 504	EFd-1	6-10
	- OR -			
	d. The anklets may be joined and overedged in one operation.	516 or 517 or 518 or 519	SSa-2	10-14
	19. MAKE WAISTBAND. Fold the waistband in half lengthwise; insert between the waistband pieces the elastic webbing applicable for the size.			
	a. Turn the edges under approximately 1/2 inch; position over the plies of the body material and seam with four rows of stitching. The outside rows of stitching shall be 1/4 inch (plus or minus 1/16 inch) from the top of the lower edges. The double rows of stitching shall be evenly spaced and shall be 1/2 inch from the outside rows of stitching. The lower row of stitching shall be sewn through the top of the trousers and waistband. The finished waistband shall measure 2 inches (plus or minus 1/4 inch) wide.	401	LSbh-4 (similar to)	6-10
	b. Fold the raw edging of the waistband ends under 1/2 inch (plus or minus 1/4 inch), and edge stitch the extending ends of the waistband over the edges of the front opening of the trousers. Continue stitching through the waistband 1/8 inch from the turned edge all around, forming a boxstitch. Continue the stitching along the upper edge.	301 or 401	EFb-1	10-14

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TABLE I. Manufacturing operations. (Continued)

No.	Description of operation	Stitch type	Seam and stitching type	Stitches per inch
	NOTE: The right side finished fold relaxed shall be 1-3/4 inch (plus or minus 1/4 inch). The left side finished fold shall be 1-1/2 inch (plus or minus 1/4 inch).			
20.	ATTACH LABELS			
	a. Stitch the contractor's labels around four sides to the inside center back of the jacket 1/2 to 1 inch below the collar seam.	301	LSbj-1	10-14
	b. Stitch the contractor's labels on all four sides, below the lower row of waistband stitching on the back parts above the right patch hip pocket of the trousers on the inside.	301	LSbj-1	10-14
21.	MAKE HANGERS FOR JACKET AND TROUSERS			
	a. The hangers shall be made from a strip of the basic material. The hangers shall measure finished 1/2 inch (plus or minus 1/8 inch) wide by 3 inches (plus or minus 1/4 inch) long.			
	b. Fold the strip in half lengthwise, with the raw edges turned in, and double stitch 1/4 inch to 3/8 inch gage.	301	EFp-2	10-14
	c. The hanger for the jacket shall be centered on the neck of the garment and caught in the seaming of the collar to the neck, or each end of the hanger shall be secured with a vertical bartack.	301 or bar-tack	SSa-1 or LSd-1	28 per bartack
	d. The hanger for the trousers shall be centered on the seat seam of the garment. Attach each end of the hanger, with vertical bartack, 1/4 inch below the bottom edge of the waistband.	bar-tack	SSa-1	28 per bartack
22.	ATTACH SNAP FASTENERS			
	a. Jacket			
	(1) Mark the position, and securely attach the sockets of four snap fasteners on the left front, through the front and the facing. The socket parts shall be positioned approximately 5/8 inch from the front edge, with the top snap fastener 1/2 inch down from the collar seam and the bottom snap fastener 1 inch upward from the finished bottom hem; The remaining snap fasteners shall be evenly spaced on the front of the jacket.			

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TABLE I. Manufacturing operations. (Continued)

No.	Description of operation	Stitch type	Seam and stitching type	Stitches per inch
23.	<p>(2) Mark the position of the studs on the right front to correspond with the sockets on the left front, and securely clinch the studs of four snap fasteners through the right front with at least 1/2 of the stud through the facing.</p> <p>(3) Mark the position, and securely attach two sockets on the back edge of each side seam. The first snap fastener shall be 1-1/2 inches upward from the finished bottom hem; the second fastener shall be 1-1/2 inches upward from the first snap fastener. (A tolerance of plus or minus 1/4 inch will be allowed.)</p> <p>b. Trousers</p> <p>(1) Mark the position and securely clinch one stud part of a snap fastener on each out-seam, approximately 3 inches (plus or minus 1/4 inch) from the top of the trousers.</p> <p>(2) Mark the position, and securely attach the sockets of two snap fasteners on the left front end of the waistband. The socket parts shall be centered on the waistband, with the first snap fastener 1/2 to 5/8 inch from the edge; and the second snap fastener shall be approximately 1-1/4 inch from the first snap fastener. Mark and install the sockets of three snap fasteners on the left front fly 3/4 inch from the finished front end. The top snap fastener shall be 3/4 inch down from the waistband joining seam, and the second and the third snap fasteners shall be spaced 2-1/2 inches apart from the top snap fastener on the fly.</p> <p>(3) Mark the position of the studs on the right fly to correspond with the position of the sockets on the left front, and securely clinch the parts through the front. The closure shall have a smooth finished appearance. The stud parts shall be centered on the right of the waistband, with the first stud 1/2 inch from the waistband end and the second stud approximately 1-1/4 inch from the first stud.</p>			
	<p>CLEAN THE JACKET AND TROUSERS</p> <p>a. Trim and remove all ends of thread.</p> <p>b. Remove all spots and stains.</p> <p>c. Examine and fold the garment for packing.</p>			

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TABLE II. Finished measurements for Jackets, inches.

Measurement <u>1/</u>	Size				Tolerances	
	Small	Medium	Large	Extra Large	Plus	Minus
Back length	26	26-1/2	26-1/2	27	1	3/4
Chest	22	24	26	28	1/2	3/8
Sleeve outseam	35	35-1/2	36-1/4	37	1	3/4
Sleeve bottom top of knit	6	6-1/4	6-1/2	6-3/4	1/4	1/4
Sweep	19-1/2	21-1/2	24-1/2	25-1/2	1/2	3/8

1/ MEASUREMENTS:

The measurement of the back length shall be taken, at the center of the back, from the undercollar seam to the bottom of the jacket.

The measurement of the chest shall be taken with the jacket buttoned, from the folded edge to folded edge in line with the armhole.

The measurement of the sleeve outseam shall be taken at the center back at the collar seam, diagonally across the back, down the sleeve to the edge of the knit cuff.

The measurement of the sleeve bottom shall be taken across the top of the knit cuff, with the bottom stretched taut, using manual tension.

The measurement of the sweep shall be taken, at the bottom of the jacket, from the folded edge to folded edge with the jacket fully buttoned.

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TABLE III. Finished measurements for Trousers, inches.

Measurement <u>1/</u>	Size				Tolerances	
	Small	Medium	Large	Extra Large	Plus	Minus
Relaxed waist	12	14-1/2	17	19-1/2	1/2	1/4
Extended waist	19	21-1/2	24	26-1/2	<u>1/</u>	<u>1/</u>
Seat	21-1/2	23-1/2	25-1/2	27-1/2	1/2	3/8
Outseam	38-1/4	39-3/4	41-1/4	42-3/4	1	1/2
Inseam	26-3/4	27-1/4	27-3/4	28-1/4	3/4	3/4
Bottom	6	6-1/2	7	7-1/2	1/4	1/4

1/ MEASUREMENTS:

The measurement of the relaxed waist, the extended waist, the seat, and the bottom are one half of the full measurement.

The measurement of the relaxed waist shall be taken at 75°F plus or minus 5°F and shall be taken with the fly front fastened in largest position. Measure along the top edge of the waistband from folded edge to folded edge.

The measurement of the extended waistband shall be taken at 75°F plus or minus 5°F. Measure along the top edge of the waistband from folded edge to folded edge, with the waistband fastened in the largest position and stretched taut in a straight line, using manual tension.

The measurement at the top of the leg shall; be taken with the fly front closed in the largest position, measure from the center of the crotch to the outside folded edge * inches below the waistband.

The measurement of the outseam shall be taken from the top edge of the waistband down the outseam to the top of the knit.

The measurement of the inseam shall be taken from the crotch down the inseam to the top of the knit.

The measurement of the bottom shall be taken across the bottom of the leg at the top of the knit, with the bottom stretched taut, using manual tension.

* Specific measurement for each size to be furnished by DPSC.

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TABLE IV. Testing of Components

Characteristic	Requirement Para	Test Method
Material Identification	3.2.4.1	1200 and 1530
Ply	3.2.4.1	Visual
Type of knit	3.2.4.1	Visual
Yarns per inch:		
Wales	3.2.4.2 3.2.4.3 3.2.4.4	5070
Courses	3.2.4.2 3.2.4.3 3.2.4.4	5070
Weight oz.	3.2.4.2 3.2.4.3 3.2.4.4	Scale or 5041
Colorfastness:		
Laundering	3.2.4.5.2	5610
Perspiration	3.2.4.5.2	5680
Crocking	3.2.4.5.2	5651

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TABLE V. General defects.

No.	Defects	Major	Minor	
			A	B
I	Material defects or workmanship damages. Material defects or workmanship damages that are inconspicuous and do not definitely weaken the material shall not be classified as defects. If the material defect or workmanship damage definitely weakens the material or if the material defect or workmanship damage does not definitely weaken the material but is conspicuous when the item is worn, the material defect or workmanship damage shall be classified as follows:			
	a. Any hole, cut, tear, needle chew or weakening defect such as a smash, multiple float or loose slub (in any ply).	101		
	b. Darn or mend (in any ply).		201	
	c. Exposed drill hole (in any ply).			301
	d. One or more rows of stitching omitted in the quilting.	102		
	e. More than 1-1/2 inches of broken or missing stitches on the quilting.			302
	f. Thick or thin places.	103		
	g. Piecing or splicing of outer covering (either ply).	104		
II	Shaded parts.			
	a. Badly shaded parts, except parts permitted to be cut from ends. <u>1/</u>			
III	Cleanliness.			
	a. Spot or stain of a permanent nature. <u>1/</u>			
	b. Removable spot or stain, clearly noticeable.		202	
	c. Thread ends not trimmed or loose threads or any shade tickets not removed.		203	
	d. Shade stamp marking exposed on the outside. <u>1/</u>			
IV	Components and assembly.			
	a. Any defective component. <u>1/</u>			
	b. Any component part omitted. <u>1/</u>			
	c. Any required operation omitted or improperly performed. <u>1/</u>			

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TABLE V. General defects. (Continued)

No.	Defects	Major	Minor	
			A	B
V	Cutting	105		
	a. Any component part not cut in accordance with specified requirements.			
VI	Seams and stitching	106		
	a. Accuracy of seaming			
	(1) Seam twisted, puckered, or pleated. <u>1/</u>			
	NOTE: Nylon fabric has a tendency to pucker at joining seams and stitchings. The puckering when not so excessive as to seriously affect appearance shall not be classified as a defect.			
	(2) Part of garment caught in any unrelated operation or stitching. <u>1/</u>			
	(3) Thread(s) used on outside not same shade or not satisfactorily matching shade of garment.		204	
	(4) Thread breaks or end(s) of stitching, when not caught in other seams or stitching, not back-stitching		205	
	b. Gage of stitching (edge, top, or raise stitching).			
	(1) Irregular, i.e., unevenly gaged or corresponding stitchings not uniformly gaged, affecting appearance.		206	
	(2) Not within range of gage specified or varies more than 1/16 when no range is specified.			303
	c. Open seam. A break in a line of stitching or continuously skipped or run off stitches (except on edge, top, or raise stitching) shall constitute an open seam.			
	(1) Any open seam:			
	(a) over 1/4 inch to and including 1/2 inch,			304
	(b) over 1/2 inch to and including 3/4 inch,		207	
	(c) over 3/4 inch.			
	d. Stitches skipped or broken on edge, top, or raise stitching when seam is seamed, turned, and stitched.			
	(1) Any stitches skipped or broken:			
	(a) over 1/4 inch to and including 1/2 inch,			305
	(b) over 1/2 inch.		208	
	e. Raw edges. A raw edge is 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, it shall be scored as an open seam.			
	(1) Any raw edge			
	(a) 1/4 inch up to and including 3/4 inch,			306
	(b) more than 3/4 inch.		209	

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TABLE V. General defects. (Continued)

No.	Defects	Major	Minor	
			A	B
	(2) Any raw edge caused by omissions of overedge stitching for a distance of: (a) more than 3 inches, (b) more than 1 inch but not more than 3 inches.		210	307
	f. Run-offs			
	(1) On joining seams, when resulting in an open seam, score as open seam.			
	(2) On edge, top, or raise stitching when not resulting in open seam (outside only): (a) over 1/2 inch to and including 1 inch, (b) over 1 inch.		211	308
	g. Not specified seam or stitch type.		212	
	h. Stitch tension. Puckering is evidence of tight tension. When puckering is evident, seam shall be tested by exerting normal pull in the lengthwise direction of seam or stitching.			
	(1) Loose tension, resulting in loose seam.	107		
	(2) Loose tension on edge, top, or raise stitching, recognized by loosely exposed loops of top or lower thread.		213	
	(3) Tight tension (stitches break when normal strain is applied to seam or stitching) shall be scored as open seam.			
	i Stitches per inch (to be scored only when the condition exists on major portion of seam or stitching).			
	(1) Less than minimum number permitted by minus tolerance: (a) one stitch, (b) two stitches, (c) three or more stitches.	108	214	309
	(2) One or more stitches in excess of maximum number permitted by plus tolerance.			310
VII	Labels			
	a. Missing, incorrect, or illegible.	109		
	b. Not securely stitched on all four sides.		215	
VIII	Snap fasteners			
	a. One or more sockets or studs broken, bent, or otherwise defective, not functioning properly.	110		

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TABLE V. General defects. (Continued)

No.	Defects	Major	Minor	
			A	B
IX	b. Not properly clinched through fabric, i.e., vary loosely or vary tightly clinched, cutting surrounding fabric.	111		
	c. Sockets and studs not aligned causing noticeable bulge or twist on fronts when fastened. <u>1</u> /			
	Bartacks			
	a. Missing, insecure, or misplaced, not serving intended purpose:			
	(1) one bartack,			311
	(2) two bartacks,		216	
	(3) three or more bartacks.	112		
X	Polyethylene bag			
	a. Not completely sealed			312

1/ Classify as a major defect when affecting appearance or serviceability seriously and as a minor A defect when affecting appearance or serviceability but not seriously.

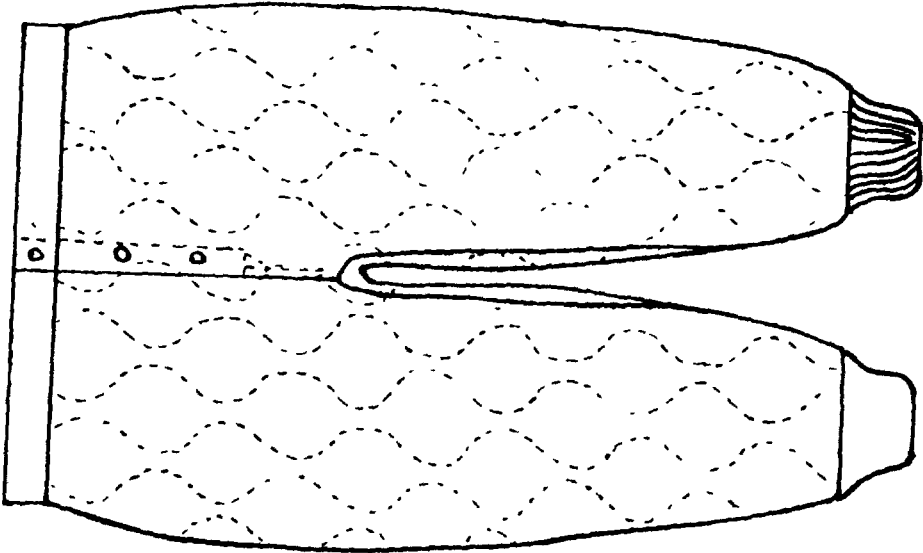
MIL-L-27546D(USAF)

TABLE VI. Detailed defects.

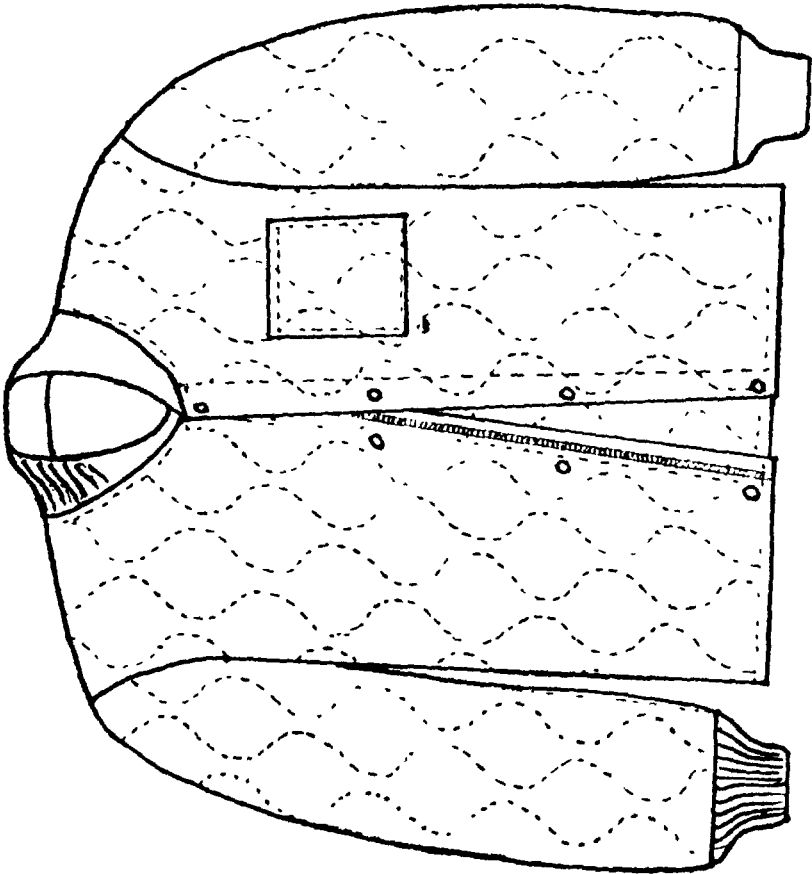
No.	Defects	Major	Minor	
			A	B
I	Jacket			
	a. Pocket			
	(1) Misaligned, affecting appearance.		201	
	(2) Finishing less than 4-3/4 or more than 5-1/4 inches wide.			301
	(3) Finishing less than 5-3/8 or more than 5-7/8 inches in depth.			302
	b. Slide fastener			
	(1) Length of slide fastener less than 19-3/4 or more than 20-1/4 inches long.			303
	(2) Broken, dented, or otherwise defective, affecting appearance or serviceability.	101		
	(3) Not type or size specified. <u>1/</u>			
	(4) Stitching too close to metal chain, affecting action of slider.	102		
	(5) Fastener tape set on too loosely or too tightly, causing noticeable bulging on tape or front edges. <u>1/</u>			
	c. Hanger			
II	(1) Ends not securely stitched or bartacked.		202	
	(2) Off center with center of back by 1 inch or more.			304
	d. Label			
	(1) Positioned less than 1/2 or more than 1 inch below collar seam.			305
	(2) Not stitched on all four sides		203	
	(3) Size shown on end item label not agreeing with size shown on inner or outer container (as applicable).			306
	a. Pockets			
	(1) Misaligned, affecting appearance.		204	
	(2) Finishing less than 6 or more than 6-1/2 inches wide.			307
	(3) Finishing less than 5-3/4 or more than 6-1/4 inches in depth.			308
	b. Hanger			
	(1) Ends not securely stitched or bartacked.		205	
	(2) Off center with center of back by 1 inch or more.			309
	d. Label			
	(1) Not stitched on all four sides		206	
	(2) Size shown on end item label not agreeing with size shown on inner or outer container (as applicable).			310

1/ Classify as a major defect when affecting appearance or serviceability seriously and as a minor A defect when affecting appearance or serviceability but not seriously.

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LINER, FLYER'S TROUSERS



LINER, FLYER'S JACKET

FIGURE 1

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Custodian:
Air Force - 99

Review activity:
DLA - DP

User activity:
Air Force - 45

Preparing activity:
Air Force - 82

Agent:
Air Force - 99

(Project 8415-F530)