

MIL-O-43527B(GL)

30 April 1973

SUPERSEDING

MIL-O-43527A(GL)

30 June 1970

## MILITARY SPECIFICATION

## OVERCOAT, WOMAN'S, ARMY GREEN 44, AND REMOVABLE LINER

## 1. SCOPE

1.1 Scope. This specification covers a woman's wool gabardine overcoat and a removable liner.

1.2 Classification. The overcoat and liner shall be one type in the following sizes and may be procured separately (see 6.2):

Schedule of sizes

<u>X-Short</u>	<u>Short</u>	<u>Regular</u>	<u>Long</u>
8	8	8	8
10	10	10	10
12	12	12	12
14	14	14	14
16	16	16	16
	18	18	18
	20	20	20

## 2. APPLICABLE DOCUMENTS

2.1 The following documents, of the issue in effect on date of invitation for bids or request for proposal, form a part of this specification to the extent specified herein.

## SPECIFICATIONS

## FEDERAL

- V-B-871 - Button, Sewing Mole, and Button, Staple, (Plastic)
- V-T-276 - Thread, Cotton
- V-T-280 - Thread, Cotton Gimp, Buttonhole

FSC 8410

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- V-T-295 - Thread, Nylon
- V-T-301 - Thread, Silk
- DDD-L-20 - Label; For Clothing, Equipage, and Tentage,  
(General Use)
- DDD-T-86 - Tape, Textile; Cotton, General Purpose (Unbleached,  
Bleached, or Dyed)
- PPP-B-636 - Boxes, Shipping, Fiberboard
- PPP-T-45 - Tape, Gummed, Paper, Reinforced and Plain, For  
Sealing and Securing

## MILITARY

- MIL-C-297 - Cloth, Interlining, Cotton Warp, and Spun Hair-Wool  
Filling
- MIL-C-326 - Cloth, Silesia, Cotton
- MIL-C-368 - Cloth, Satin, Rayon and Cloth, Twill, Rayon
- MIL-B-371 - Braid, Textile (Tubular)
- MIL-C-10176 - Cloth, Gabardine: Wool, Polyester and Wool
- MIL-P-15064 - Pads, Shoulder and Sleeve-Head
- MIL-C-16375 - Cloth, Wigan, Cotton
- MIL-F-21840 - Fastener Tapes, Hook and Pile, Synthetic
- MIL-C-43525 - Cloth, Satin, Acetate Face, and Rayon/Acrylic Back
- MIL-C-43718 - Cloth, Twill, Polyester and Cotton

## STANDARDS

## FEDERAL

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

## MILITARY

- MIL-STD-129 - Marking for Shipment and Storage
- MIL-STD-1392 - Provisions for Evaluating Quality of Overcoats,  
Women's

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

- \* 2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless a specific issue is identified, the issue in effect on date of invitation for bids or request for proposal shall apply:

National Motor Freight Traffic Association, Inc., Agent

National Motor Freight Classification

(Application for copies should be addressed to the American Trucking Associations, Inc., Tariff Order Section, 1616 P Street, N.W., Washington, D.C. 20036.)

Uniform Classification Committee, Agent

Uniform Freight Classification

(Application for copies should be addressed to the Uniform Classification Committee, Room 1106, 222 South Riverside Plaza, Chicago, Illinois 60606.)

3. REQUIREMENTS

3.1 Guide samples. Guide samples, when furnished, are solely for guidance and information to the supplier (see 6.3). Variation from this specification may appear in the sample, in which case this specification shall govern.

3.2 Materials.

3.2.1 Basic material. The basic material shall be wool gabardine, Army Green 44, conforming to type I, class 5 of MIL-C-10176.

3.2.2 Liner material. The material for the liner shall be acetate face and rayon acrylic back cloth conforming to MIL-C-43525.

3.2.3 Lining. The material for lining the overcoat and for binding the liner shall be 4.5 ounce rayon cloth, Army Green 45, conforming to class 3 of MIL-C-368. At the option of the supplier the lining material may be used for the hanger loop and the button loops on the liner sleeves (see 3.2.11 and operation 1.h).

3.2.4 Collar and front interlinings. The material for interlining the collar and fronts shall be cotton warp and spun hair-wool filling cloth conforming to MIL-C-297. The material for the collar shall be type III, class 1, and for the front interlinings shall be type I, class 2.

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3.2.5 Shoulder pads. The shoulder pads shall conform to type III of MIL-P-15064.

3.2.6 Sleeve hem interlining. The material for interlining the sleeve hems shall be cotton wigan conforming to type I of MIL-C-16375.

\* 3.2.7 Stays and pocket reinforcements. The material for the pocket reinforcements and bridle stays shall be cotton silesia, natural, bleached or black, conforming to type I of MIL-C-326. Polyester and cotton cloth conforming to type I or II of MIL-C-43718 may be substituted for use on pocket reinforcements only.

3.2.8 Stay tapes. The taping material for the stays shall be cotton, 1/4 inch wide for armholes and 3/8 to 1/2 inch wide for front edges, preshrunk, conforming to type I, class 1 or class 2 of DDD-T-86 except that the requirements for nonfibrous material shall not apply.

3.2.9 Fastener tape. The material for fastening the liner to the overcoat at back of neck shall be 3/4 or 1 inch wide, shade black 3230, hook and pile tape conforming to type II, class 1 of MIL-F-21840.

3.2.10 Hem ribbon. The material for finishing the hem of the overcoat shall be a plain weave continuous filament rayon tape with selvage edges, conforming to the following requirements when tested as specified in 4.2.

Width (inches)	$1/2 \pm 1/16$
Weight, ounces/gross yards (minimum)	5.0
Yarns per inch (minimum)	
- Warp	66
- Filling	52

The tape shall approximate the shade of the basic material and shall show "good" fastness to wet drycleaning and crocking when tested as specified in 4.2.1.

3.2.11 Hanger loop and liner sleeve button loops. The material for the hanger loop and liner sleeve button loops shall be cotton or rayon flat tubular braid, 1/8 to 3/16 inch wide, conforming to type IX, class 1 of MIL-B-371. The color shall approximate the basic material color and shall show "good" fastness to crocking and wet drycleaning.

3.2.12 Lapel button loop. The material for the lapel button loop shall be flat cotton braid, 1/16 to 1/8 inch wide, having a minimum breaking strength of 25 pounds lengthwise, when tested as specified in 4.2.1. The color shall match the basic material and shall show "good" fastness to crocking and wet drycleaning when tested as specified in 4.2.1 (see option in 3.2.13).

3.2.13 Thread. The thread for the liner shall be cotton, type IA3, ticket No. 50, 3 ply, conforming to V-T-276. The thread for the overcoat except where silk is indicated shall be cotton, type IA3 or IB3, ticket Nos. 50, 3 ply and 70, 2 ply for seaming and stitching, ticket Nos. 12, 4 ply or 16, 4 ply for hand sewn buttons and ticket No. 20, 4 ply for machine sewn buttons, conforming to V-T-276. If an automatic machine which sews and shanks (wraps) buttons is used, the thread shall be a waxed nylon monocord special No. 5 having a minimum breaking strength of 16 pounds and a minimum length per pound of 2150 yards, and shall be tested for these requirements and for colorfastness (3.2.13.1) in accordance with test methods outlined in V-T-295 and the sample unit for testing shall be one tube. The silk thread shall be type I, ticket Nos. A and B for machine-made buttonholes; type II, class 1, subclass B, ticket No. 10 for hand tailored buttonholes and lapel button loop (option); type III, ticket No. A or C for hand felling and ticket No. A for machine (simulated hand) felling; and type I, ticket Nos. 0 and 00 for outside trim stitching conforming to V-T-301 except that the requirement for extractable matter shall not apply for type III thread. Any type basting thread or the cotton thread used for seaming and stitching may be used for basting. A monofilament synthetic basting thread may be used for those operations where the thread is required to be removed, providing the garment is subsequently given a treatment by a drycleaning agent in which the synthetic thread is soluble. When this thread is used, any residue remaining on the garment after the drycleaning process shall be brushed off or removed.

3.2.13.1 Color and colorfastness. The thread shall be dyed Green E, C.A. 66034, and shall show colorfastness to light and wet drycleaning, equal to or better than the standard sample. When no standard sample is available, the dyed thread shall show "good" fastness to light and wet drycleaning.

3.2.14 Gimp. The gimp for reinforcing the overcoat buttonholes shall be cotton No. 8 conforming to type I or II of V-T-280. The gimp shall be dyed Green E, C.A. 66034, and shall show colorfastness to wet drycleaning equal to or better than the standard sample. When no standard sample is available, the gimp shall show "good" fastness to wet drycleaning.

3.2.15 Buttons. The buttons shall be Army Green shade BR, Cable No. 62015, style 20 or 21, size 45-line for front closure, 24-line for attaching liner to overcoat and lapel closure, and 30-line for all other buttons, conforming to type II, class D of V-B-871.

\* 3.2.16 Labels. Each overcoat and each liner shall have a size label and a combination identification-instruction label conforming to type I of DDD-L-20.

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The cloth coating requirements of type I, class 3 of DDD-L-20 shall apply to the combination label. The fastness to dry cleaning requirements of DDD-L-20 shall apply to all labels. When the overcoat is procured with liner, the item description for overcoat and liner shall be "Overcoat, Woman's, Army Green 44, with Removable Liner". When overcoat and liner are procured separately, the item descriptions shall be "Overcoat, Woman's, Army Green 44" and "Liner, for Overcoat, Woman's, Army Green 44", as applicable.

3.2.16.1 Size label. The size label shall conform to class 2. The size label for the liner shall include the following:

Liner may be worn with the Woman's Quarpel Raincoat

3.2.16.2 Combination identification-instruction label. On the combination label, the identification label information shall conform to class 1 and the instruction label shall conform to class 3, except that the item identification shall not be repeated. The instruction information shall read "Dry clean only".

3.3 Design. The overcoat is fully lined, full length, double-breasted, box type with buttons on the inside for attaching the liner. It has a convertible rounded collar and buttoned-down shoulder loops. The liner, which may be worn with the Woman's Quarpel Raincoat, is three-quarter length and has sleeves with button loops (see figures).

3.4 Figures. Figures are furnished for information only. To the extent of any inconsistencies between the written specification and the figures, the specification shall control.

3.5 Patterns. Standard patterns for use in cutting working patterns shall be furnished by the Government. The working patterns shall be identical to the Government patterns and shall not be altered in any way, except as indicated by footnote 2 to table I. The patterns provide a 3/8 inch seam allowance for all seams except as otherwise indicated in table II.

3.5.1 Pattern parts. The component parts of the overcoat and liner shall be cut from materials as specified and in accordance with the number of parts required for the manufacturing process, as shown in table I.

TABLE I. Pattern parts

<u>Material</u>	<u>Pattern nomenclature</u>	<u>Cut parts</u>
	<u>Overcoat</u>	
Wool gabardine	Center front	2
	Side front	2
	Back	2
	Front facing	2
	Front sleeve	2
	Back sleeve	2
	Top collar	1
	Undercollar	1
	Top collar stand	1
	Undercollar stand	1
	Shoulder loop	2
	Pocket welt	4
	Pocket <u>1/</u>	2
	Buttonhole tab	2
	Rayon lining cloth	Front
Back <u>2/</u>		2
Front sleeve		2
Back sleeve		2
Pocket <u>1/</u>		2
Cotton, warp, spun hair-wool filling cloth (type III, class I)	Collar interlining	1
	Undercollar stand interlining	1
Wigan cloth	Sleeve interlining	2
Silesia cloth (or substitute, see 3.2.7)	Pocket reinforcement	2
	<u>Liner</u>	
Acetate face and rayon/acrylic back cloth	Front	2
	Back	1
	Sleeve	2

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TABLE I. Pattern parts (cont'd)

<u>Material</u>	<u>Pattern nomenclature</u>	<u>Cut parts</u>
	<u>Coat front</u>	
Cotton warp, spun- hair-wool filling cloth (type I, class 2)	Center front	2
	Side front	2
	<u>Shapers</u>	
	Undercollar shaper	
	Undercollar marker	
	Collar (finished)	
	Lapel	
	Button and buttonhole marker	

1/ Same pattern part: under pocket (wool gabardine) and top pocket (rayon).

2/ May be cut in one piece by eliminating seam allowance.

### 3.6 Construction.

3.6.1 Stitches, seams, and stitching. Stitch, seam, and stitching types specified in table II shall conform to FED-STD-751. When two or more seam or stitch types are given for the same operation, any one may be used. Where stitch type 401 is used, the looper thread shall be on the inside of the overcoat. Seam allowances shall be maintained with seams sewn so that no raw edges, run-offs, twists, pleats, puckers or open seams will result. All seams shall start and finish evenly. Thread tension shall be maintained so that there is no tight or loose stitching. Edge stitching and top stitching shall be uniformly gaged throughout garment.

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

3.6.3 Thread breaks and ends of seams. Unless otherwise specified, ends of all seams and stitching (except darts) when not caught in other seams or stitching shall be backtacked not less than 1/4 inch. The ends of a continuous line of stitching shall be overlapped not less than 1/2 inch, except



that when attaching labels or fastener tapes by automatic machines, the overlap shall be at least 3 stitches. Thread breaks shall be secured by stitching back of the break not less than 1/2 inch. Skipped stitches or thread breaks on 401 seaming may be repaired by using a 301 stitch type. The thread ends of the darts shall be trimmed to a length of not less than 1/2 inch.

3.7 Buttonholes. The buttonholes for the overcoat shall be eyelet-end-square-bar, cut-first type, worked over gimp with the ends of the gimp pulled through to the underside and barred by hand or machine. The buttonholes for the liner shall be straight cut, tacked at both ends. Except for the buttonhole on buttonhole tab, the purling shall be on the outside of the overcoat. When a purl type buttonhole is used on the liner, the purling shall be on the rayon side.

\* 3.8 Manufacturing operations requirements. The overcoat and liner shall be manufactured in accordance with operation requirements specified in table II. The supplier is not required to follow the exact sequence of operations listed. Any additional basting or holding stitching used to facilitate manufacture is permissible providing the thread is removed or does not show on the finished overcoat or liner.

3.8.1 Shade and size marking. The component parts of the overcoat and liner shall be marked to insure a uniform shade and size throughout the garment. Any method of marking may be used except:

- (a) Corrosive metal fastening devices.
- (b) Adhesive type tickets which leave traces of paper or adhesive on the material after removal of the tickets.

3.8.2 Pressing. The pressing as required in table II shall remove gloss, wrinkles, creases and ticket or thread impressions.

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D	
					NEEDLE	BOBBIN or LOOPER
1.	<p><u>Cutting.</u></p> <p>a. Spread the material without tension and in the correct number of plies so that the top and bottom ply shall match and correspond to the pattern.</p> <p>b. Cut the overcoats and liners in accordance with patterns furnished which show directional lines, size, placement of pockets and buttonhole tab, and notches for the proper assembly of parts. Directional lines shall be placed in the warp direction.</p> <p>c. Cut all basic material parts of the coat out of the same piece of material except the undercollar, undercollar stand, under side of pocket velts and the underpocket which may be cut from ends. Parts cut from ends shall match the shade of the coat. The twill lines on all parts of the finished overcoat shall run from lower left to upper right.</p> <p>d. Cut the pocket reinforcements, and the 3/4 inch silesia bridle stays on the straight. Cut the wigan for sleeve interlinings on the bias.</p> <p>e. Cut all napped rayon parts of the liner from the same piece of material except sleeves which may be cut from ends. When sleeves are cut from ends the shade shall match each other.</p> <p>f. Cut all lining parts from the same piece of material except top pockets and sleeves which may be cut from ends. When sleeves are cut from ends the shade shall match each other.</p>					

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P/O.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN or LOOPER
1.	<p><u>Cutting.</u> (cont'd)</p> <p>g. Cut the stripping for binding the liner from the lining material on the bias and of sufficient width to finish 3/16 to 1/4 inch wide when attached as specified in operation 7.</p> <p>h. Cut stripping from the lining material for the hanger loop (option) and the button loops on liner sleeves (option) on the straight or on the bias and of sufficient width to finish 3/16 to 1/4 inch wide (see operation 4).</p> <p>i. Cut the hanger loop braid or stripping (option) of sufficient length to finish 2-3/4 + 1/4 inches when attached to the finished overcoat (see operation 33.h).</p> <p>j. Cut the buttonloop braid or stripping (option) of sufficient length to form a finished 3/4 to 7/8 inch loop when attached to sleeve (see operation 8.c).</p> <p>k. Cut the hook tape and pile tape in equal lengths 3/4 to 1 inch long.</p>					
2.	<p><u>Marking.</u></p> <p>Mark, ticket or bundle all component parts to insure a correct size and uniform shade throughout the garment.</p>					

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					NEEDLE	BOBBIN or LOOPER
*3.	<p><u>Replacement of damaged parts.</u></p> <p>Care shall be exercised during the spreading, cutting and manufacturing operations to assure that material defects and damages, as classified in MIL-STD-1392, are excluded and replaced with non-defective and properly matched material.</p>					
4.	<p><u>Make stripping for hanger loop and buttonhole loops for liner sleeves (optional).</u></p> <p>Fold stripping in half lengthwise, turn in the raw edges and join with one or two rows of stitching.</p> <p style="text-align: center;"><u>Make liner</u></p>	301 301	EFp-1 or EFp-2	10-16 10-16	50-3 50-3	50-3 50-3
*5.	<p><u>Attach hook part of fastener tape and size and combination identification-instruction label to liner back.</u></p> <p>a. Center hook part of fastener tape on the napped side of liner back not more than 1/2 inch below the bound neck edge and stitch on all four sides. The tape shall not be off center by more than 1/4 inch.</p> <p>b. Center size label not more than 1 inch from bottom edge of fastener tape and stitch on all four sides. Center the combination identification-instruction label not more than 1/2 inch below size label and stitch on all four sides. The top of the combination identification-instruction label may be caught in the size label stitching. The labels shall not be off center by more than 1/2 inch. The stitching shall not be through the printing.</p>	301 301	LSbj-1 LSbj-1	10-14 10-14	50-3 50-3	50-3 50-3

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN or LOOPER
6.	<p><u>Make darts on fronts.</u></p> <p>a. Fold darts as indicated by marks on patterns and stitch, tapering to nothing, 3/4 to 1 inch beyond drill hole. Top of darts may also be marked with drill holes providing they are located within the dart.</p> <p>b. Press darts toward armholes.</p>	301	OSf-1	12-16	50-3	50-3
7.	<p><u>Bind liner parts.</u></p> <p>a. With the raw edges of the binding turned in, bind the raw edges of front, back and sleeve parts. The ends of the binding shall be overlapped with raw edge turned under or, if binding terminates at the end of a joining seam, the ends shall be folded back to the napped side of the liner and caught in the stitching or caught in the joining seams when assembling liner (operation 2). The binding shall not be tight, twisted, puckered or pleated.</p>	301	ESc-1	10-16	50-3	50-3
8.	<p><u>Make liner sleeves.</u></p> <p>a. Stitch sleeve underarm seams on the napped side of the material with a 1/2 inch seam allowance.</p> <p>b. Press seams open.</p> <p>c. Fold the loop piece (operation 1.h and 1.j) in half and position at wrist on the napped side of sleeve over the spread-open underarm seam. Turn in</p>	301 301 or	SSa-1 LSb-2 or LSq-2	12-16 12-16 12-16	50-3 50-3 50-3	50-3 50-3 50-3

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					NEEDLE	BOBBIN or LOOPER
8.	<p>Make <u>liner sleeves</u>. (cont'd)</p> <p>the raw ends and with the sides abutted, tack to sleeve with two rows of stitching, two bartacks or with automatic straight 1/2 inch tacks. The loops shall extend beyond the end of the sleeve.</p> <p>- or -</p> <p>d. The loop may be caught in the binding of sleeve (operation 7.a) at wrist with the side of the loop not more than 1/8 inch from the underarm joining seamline. Turn down loop and tack to sleeve, through binding, with a bartack or an automatic straight 1/2 inch tack.</p> <p>- or -</p> <p>e. In binding sleeve parts (operation 7.a) the end of the binding may be extended at bottom of sleeve on edge facing front, where worn. The extended piece shall be looped with the end of the binding placed under seam allowance, and the loop shall be tacked to sleeve through binding not more than 1/8 inch from underarm joining seam-line, with a 1/2 inch bartack or automatic straight tack. (If this option is used, the cutting of button loop stripping or braid (operation 1.j) is not required.</p>	<p>Bartack Bartack or 301 or 301</p> <p>LSb-2 or LSq-2 LSb-2 LSq-2</p> <p>Bartack or 301</p> <p>Bartack or 301</p>	<p>28 per bartack 28 per bartack 28 per tack 28 per tack</p> <p>28 per bartack 28 per tack</p> <p>28 per bartack 28 per tack</p>	<p>50-3 50-3 50-3 50-3</p> <p>50-3 50-3</p> <p>50-3 50-3</p>	<p>50-3 50-3 50-3 50-3</p> <p>50-3 50-3</p> <p>50-3 50-3</p>	

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN or LOOPER
9.	<p><u>Assemble liner.</u></p> <p>a. Stitch shoulder seams on the napped side of the material with a 1/2 inch seam allowance, leaving the seam open for a distance of 5/8 to 3/4 inch to form slit buttonhole. The end of the slit shall be not more than 1/2 inch from the neck end of the shoulder seam.</p> <p>b. With the seams spread open, tack the end of each slit with a 1/4 to 1/2 inch tack or bartack across the line of stitching.</p> <p>c. Stitch the side seams with a 1/2 inch seam allowance. Backtack the ends of seams not less than 1/2 inch.</p> <p>d. Press shoulder and side seams open.</p> <p>e. Set sleeves with the body of liner (face side up) lapped on the sleeve 1/2 inch (1/4 inch seam allowance) and with the stitching starting and finishing 2-1/4 to 2-3/4 inches from the side seams.</p>	301	SSa-1	12-16	50-3	50-3
		Bartack or 301		Not less than 14 per 1/4 inch of bartacking 28 per tack	50-3	50-3
		301	SSa-1	12-16	50-3	50-3
		Bartack		28 per bartack	50-3	50-3
		301	LSa-1	12-16	50-3	50-3

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					NEEDLE	BOBBIN or LOOPER
10.	<p><u>Make buttonholes in liner.</u></p> <p>Make three 5/8 inch vertical finished cut-length buttonholes on each front as indicated by pattern with the inside edge of the buttonhole 1/2 to 3/4 inch from bound edge (see 3.7).</p>	304 or  304		46-52 per buttonhole including tack 46-52 per buttonhole including tack	50-3 or 50-3	50-3  50-3
11.	<p><u>Clean liner.</u></p> <p>a. Trim all ends of stitching and remove loose threads.</p> <p>b. Remove spots, stains and shade tickets.</p>					
12.	<p><u>Make shoulder loops.</u></p> <p>a. Fold loop lengthwise and seam.</p> <p>b. Shift the seam to form point, and with the seam spread open, stitch around the pointed end.</p> <p>c. Press seam open.</p> <p>d. Trim ; turn loop, work out seam at pointed edge and baste edge or press loop.</p>	301 or 401  301 or 401  Hand or Machine	SSa-1 SSa-1  SSE-3(a) SSE-3(a)	12-16 12-16  12-16 12-16	50-3 50-3  50-3 50-3	50-3 70-2  50-3 70-2

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					NEEDLE	BOBBIN or LOOPER	
12.	<p><u>Make shoulder loops.</u> (cont'd)</p> <p>e. Edge stitch with two rows of stitching <math>3/8</math> to <math>7/16</math> inch apart. The outside row of stitching shall be <math>1/16</math> to <math>3/32</math> inch from edge.</p> <p>f. Make a <math>3/4</math> to <math>7/8</math> inch finished cut-length buttonhole on the center of each shoulder loop with the inside edge of the eyelet <math>3/4</math> to <math>7/8</math> inch from the pointed end. The buttonhole shall not be off center by more than <math>1/8</math> inch.</p> <p>g. Bar end of buttonholes.</p> <p>h. Remove bastings (if applicable) and press shoulder loops.</p>	301	Sse-3(b) and OSf-2	12-16	0 silk	0 silk	
		301		12-16	0 silk	0 silk	
		Buttonhole or Hand		46-52 per buttonhole 46-52 per buttonhole	A or B Silk 10 Silk	A or B Silk	A or B Silk
		Machine or Hand		21 per bar 6 per bar	A or B Silk 10 Silk	A or B Silk	A or B Silk
13.	<p><u>Make collar.</u></p> <p>a. Stitch top collarstand to top collar with <math>1/4</math> inch seam allowance.</p> <p>b. Press seam open.</p> <p>c. Quilt the undercollar interlining to the undercollar with the rows of stitching not more than <math>1/2</math> inch apart.</p>	301 or 401	SSa-1 SSa-1	12-16 12-16	50-3 50-3	50-3 70-2	
		103 or 306	SSm-4 to 8 SSm-4 to 3	4-6 4-6	50-3 50-3	50-3 50-3	

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN or LOOPER
13.	<p><u>Make collar.</u> (cont'd)</p> <p>d. Quilt the undercollar stand interlining to the undercollar stand with the rows of stitching not more than 1/2 inch apart.</p> <p>e. Mark undercollar on the basic material side of the quilted undercollar with the undercollar shaper centered on the undercollar; trim excess material along gorge seams. Mark stitching line on the interlining side of the undercollar with the undercollar marker centered and with the gorge seam ends of undercollar and undercollar marker even.</p> <p>f. Stitch undercollar stand to the undercollar. Turn seam toward the collar stand and raise stitch 1/16 to 1/8 inch from joining seam.</p> <p>g. Trim off the seam allowance of interlining along neck edge if necessary.</p> <p>h. Place top collar on quilted undercollar with the outer edge of top collar even with the marked line on undercollar and baste together around outer edge of top collar, 1/8 to 1/4 inch from edge, distributing the top collar fullness evenly.</p> <p>i. Stitch undercollar to top collar, as marked, maintaining the distributed fullness.</p>	<p>103 or 306</p> <p>SSm-2 to 5 SSm-2 to 5</p> <p>301 or 401 and 301</p> <p>Hand or Machine</p> <p>301 or 401</p>	<p>SSm-2 to 5 SSm-2 to 5</p> <p>SSa-1 SSa-1</p>	<p>4-6 4-6</p> <p>12-16 12-16 12-16</p> <p>12-16 12-16</p>	<p>50-3 50-3</p> <p>50-3 50-3 50-3</p> <p>50-3 50-3</p>	<p>50-3 50-3</p> <p>50-3 70-2 50-3</p> <p>50-3 70-2</p>

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOSBIN or LOOPER
TABLE II						
13.	<p><u>Make collar.</u> (cont'd)</p> <p>j. Remove basting, trim excess material from seamed edges, turn collar, force out edges and baste collar edge with two rows of stitching with the outer row 1/8 to 1/4 inch from edge, distributing top collar fullness evenly and rolling the joining seam to the underside. Place an additional row of basting 1/2 to 3/4 inch above the collar to collar stand joining-seam.</p> <p>k. Check finished collar with finished collar shaper.</p>	<p>Hand or Machine</p>				
14.	<p><u>Make pocket welts.</u></p> <p>a. Stitch the two welt pieces together. Trim corners if necessary, turn, force out corners and edges and edge stitch with two rows of stitching 3/8 to 7/16 inch apart. The outside row of stitching shall be 1/16 to 3/32 inch from edge.</p> <p>b. Press welts.</p>	<p>301 or 401 and 301</p>	<p>SSe-3(a) SSe-3(a) SSe-3(b)</p>	<p>12-16 12-16 12-16</p>	<p>50-3 or 0 silk 50-3 or 0 silk 0 silk</p>	<p>50-3 or 0 silk 70-2 or 00 silk 0 silk</p>
15.	<p><u>Make buttonhole tab.</u></p> <p>a. Stitch the two tab pieces together with a 1/4 inch seam allowance. Trim points, turn, force out corners and edges and edge stitch with two rows of stitching 3/8 to 7/16 inch apart. The outside row of stitching shall be 1/16 to 3/32 inch from edge.</p> <p>b. Press tab.</p>	<p>301 or 401 and 301</p>	<p>SSe-3(a) SSe-3(a) SSe-3(b)</p>	<p>12-16 12-16 12-16</p>	<p>50-3 50-3 50-3</p>	<p>50-3 70-2 50-3</p>

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE 00	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D	
					NEEDLE	BOBBIN or LOOPER
15.	<p>Make <u>buttonhole tab.</u> (cont'd)</p> <p>c. Make a 3/4 to 7/8 inch finished cut-length buttonhole on the center of tab with the inside edge of the eyelet 3/4 to 7/8 inch from the pointed end. The buttonhole shall not be off-center by more than 1/8 inch.</p> <p>d. Bar end of buttonholes.</p>	<p>Buttonhole or Hand</p> <p>Machine or Hand</p>		<p>46-52 per buttonhole 46-52 per buttonhole</p> <p>21 per bar 6 per bar</p>	<p>E silk 10 Silk</p> <p>A or B Silk 10 Silk</p>	<p>A silk</p> <p>A or B Silk</p>
16.	<p>Make <u>overcoat sleeves.</u></p> <p>a. Overlap front sleeve on back sleeve 1/2 inch in and, with the notches matched, stitch 3/8 inch from edge of front sleeve. Turn seam toward front of sleeve and raise stitch 1/2 inch from joining seam. The pattern provides a seam allowance of 3/8 inch on front sleeve and 3/8 inch plus a 1/2 inch outlet for back sleeve.</p> <p>b. Place sleeve wigan across sleeve with the bottom edge 1/2 to 3/4 inch below turn-up notches and stitch to top and underarm seam allowances.</p>	<p>301 or 401 and 301</p> <p>Hand Hand or Machine Machine</p>	<p>LSs-2(a) LSs-2(a) LSs-2(b)</p> <p>LSbj-1 and SSa-1 LSbj-1 and SSa-1</p>	<p>12-16 12-16 12-16</p>	<p>50-3 or 0 silk 50-3 or 0 silk 0 silk</p>	<p>50-3 or 0 silk 70-2 or 00 silk 0 silk</p>

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN or LOOPER
16.	<p><u>Make overcoat sleeves.</u> (cont'd)</p> <p>c. Baste wigan to sleeve along the fold line, as indicated by marks on pattern. This operation may be omitted providing the sleeve hem has been evenly folded (operation d).</p> <p>d. Turn up bottom of sleeve 2-1/2 inches as indicated by marks on pattern and baste along folded edge.</p> <p>e. Press bottom of sleeve. Remove bastings.</p> <p>f. Stitch underarm seam, matching notches.</p> <p>g. Press sleeve, pressing underarm seam open.</p> <p>h. Blind stitch top of sleeve hem to sleeve wigan.</p> <p>i. Turn sleeve to right side.</p> <p>NOTE: Operations d and e may be performed after stitching underarm seam (operation f).</p> <p><u>Attach buttonhole tab.</u></p> <p>Position buttonhole tab on the right facing as indicated by pattern with the raw edge aligned with the front edge and stitch 1/4 inch from the raw edge. Turn and stitch down enclosing the raw edges. The purling of the buttonhole shall face the wearer on the finished overcoat.</p>	<p>Hand or Machine</p> <p>Hand or Machine</p> <p>301</p> <p>103 or Hand</p> <p>301</p>	<p>SSV-1 SSV-1</p> <p>FFa-1 FFa-1</p> <p>SSa-1</p> <p>LSb1-2</p>	<p>12-16</p> <p>4-6 4-6</p> <p>10-14</p>	<p>50-3</p> <p>50-3 50-3</p> <p>50-3</p>	<p>50-3</p>
17.						

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D	
					NEEDLE	BOBBIN or LOOPER
13.	<p><u>Make overcoat lining.</u></p> <p>a. Fold darts on back parts as indicated by marks on pattern and stitch, tapering to nothing <math>3/4</math> to 1 inch beyond the drill hole.</p> <p>b. Fold the waist and underarm darts on the front parts as indicated by marks on pattern and stitch, tapering to nothing <math>3/4</math> to 1 inch beyond drill hole.</p> <p>c. If back is cut in two pieces, stitch the two back parts together. Stitch the fronts to the back. The pattern provides a <math>1/2</math> inch seam allowance.</p> <p>d. Form pleat on center back as indicated by pattern with the outside folded edge turned toward the left (as worn). Baste pleat into position from top to bottom.</p> <p>e. Stitch the pile part of the fastener tape over the pleat on back not more than <math>7/8</math> inch from the raw edge of neck, and stitch on all four sides. The tape shall not be off-center by more than <math>1/4</math> inch.</p> <p>f. Press the center back pleat; press the side seams toward the back; press the front darts toward the sides and the back darts toward the center back.</p> <p>g. Join shoulder (leaving seam allowance free for joining to facing) forming pleats on fronts as indicated by patterns. The outside folded edge of the pleats shall face the armholes. The pleats may be stitched into position prior to joining shoulders.</p>	301 or 401	OSf-1 OSf-1	12-16 12-16	50-3 50-3	50-3 70-2
		301 or 401	OSf-1 OSf-1	12-16 12-16	50-3 50-3	50-3 70-2
		301 or 401	SSa-1 SSa-1	12-16 12-16	50-3 50-3	50-3 70-2
		Hand or Machine				
		301	LSbj-1	10-14	50-3	50-3
		301 or 401	SSa-1 SSa-1	12-16 12-16	50-3 50-3	50-3 70-2

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN or LOOPER
18.	<p>Make overcoat lining. (cont'd)</p> <p>h. Join top and underarm seams of sleeves.</p> <p>i. Press both lining sleeve seams toward the front.</p> <p>j. Set sleeves matching notches, distributing the fullness (at sleeve cap) evenly between the notches and with the shoulder seams turned toward back.</p> <p>k. Hem lining (with the pleat basted in position) starting and finishing <math>3/4</math> to 1 inch from each edge and securing ends of stitching. The hem shall finish <math>2-1/2 + 1/4</math> inches wide.</p> <p>l. Center size label over center back pleat, <math>1/2</math> to <math>3/4</math> inch from fastener tape. Stitch label to lining across top of label. (Label shall not be off center by more than <math>1/2</math> inch.)</p>	<p>301 or 401</p> <p>301 or 401</p> <p>103 or 306</p> <p>301</p>	<p>SSa-1 SSa-1</p> <p>SSa-1 SSa-1</p> <p>EFb-1 EFb-1</p> <p>LSbj-1</p>	<p>12-16 12-16</p> <p>12-16 12-16</p> <p>6-8 6-8</p> <p>8-16</p>	<p>50-3 50-3</p> <p>50-3 50-3</p> <p>50-3 50-3</p> <p>50-3</p>	<p>50-3 70-2</p> <p>50-3 70-2</p> <p>70-2</p> <p>50-3</p>
*19.	<p>Make side fronts of overcoat and attach combination identification-instruction label.</p> <p>a. Join darts on side fronts as indicated by pattern tapering to nothing <math>3/4</math> to 1 inch below drill hole.</p> <p>b. Press darts toward back.</p> <p>c. Place the combination identification-instruction label on outside of the right top pocketing (lining material) with top edge <math>3/4</math> to 1 inch from the straight edge of pocketing, and stitch on all four sides. On the finished pocket the label shall be centered (<math>1/2</math> inch off center tolerance) at the pocket opening.</p>	<p>301 or 401</p> <p>301</p>	<p>SSa-1 SSa-1</p> <p>LSbj-1</p>	<p>12-16 12-16</p> <p>12-16</p>	<p>50-3 50-3</p> <p>50-3</p>	<p>50-3 70-2</p> <p>50-3</p>

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN or LOOPER
*19.	<p>TABLE II</p> <p>Make side fronts of overcoat and attach combination identification-instruction label. (cont'd)</p> <p>d. Mark pocket cut-line, as indicated by patterns.</p> <p>e. Baste pocket reinforcements on the underside of the side fronts as indicated on pattern.</p> <p>f. Position underpocket on the outside of coat front with the straight edge aligned with the cut-line indicated by patterns and stitch to coat through pocket reinforcement piece, <math>1/4 \pm 1/16</math> inch from the raw edge.</p> <p>g. Position pocket welt on outside of coat front with the raw edge abutting the raw edge of the underpocket and baste or stitch into position.</p> <p>h. Place top pocket (lining material) over the pocket welt with the straight edge even with the raw edge of the pocket welt and stitch through all plies <math>1/4 \pm 1/16</math> inch from edge.</p> <p>i. Cut pocket opening. Slash seam of underpocket-joining-seam perpendicular to the line of stitching.</p> <p>j. Press underpocket joining seam open.</p> <p>k. Slash top pocket-welt joining seam at each end with a diagonal cut to the line of stitching.</p> <p>l. Turn top pocket and underpocket to the inside and stitch top pocket to underpocket, closing pocket.</p>	<p>Hand or Machine</p> <p>301</p> <p>Hand or Machine</p> <p>301</p> <p>301 or 401</p>	<p>SSa-1</p> <p>SSa-1</p>	<p>12-16</p> <p>12-16</p> <p>12-16</p> <p>12-16</p>	<p>50-3</p> <p>50-3</p> <p>50-3</p> <p>50-3</p>	<p>50-3</p> <p>50-3</p> <p>50-3</p> <p>70-2</p>

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN or LOOPER
*19.	<p>Make side fronts of overcoat and attach combination identification-instruction label. (cont'd)</p> <p>m. With the top pocket and underpocket in their finished positions close top and bottom of welts. The stitching shall superimpose the two rows of the welt edge stitching and the outside row shall extend around the curve as far as the inside row.</p>	301		12-16	0 silk	0 silk
20.	<p>Make back.</p> <p>a. Fold shoulder darts on backs, as indicated by marks on pattern, tapering to nothing 3/4 to 1 inch beyond the drill hole.</p> <p>b. Stitch right back to left back (3/4 inch seam allowance). Turn seam toward left back and raise stitch 1/2 inch from joining seam.</p> <p>c. Press backs with shoulder darts facing the center back.</p>	301 or 401	OSf-1 OSf-1	12-16 12-16	50-3 50-3	50-3 70-2
21.	<p>Make coat front interlining.</p> <p>Overlap (1/4 to 3/8 inch) front section over side front, and seam.</p> <p>Assemble fronts.</p>	301	LSa-1	4-8	70-2	70-2
22.	<p>a. Stitch center fronts to side fronts, matching notches and distributing the bust fullness evenly between the notches.</p>	301 or 401	SSa-1 SSa-1	12-16 12-16	50-3 50-3	50-3 70-2

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN or LOOPER
22.	<p><u>Assemble fronts.</u> (cont'd)</p> <p>b. Press fronts with the seams pressed open.</p> <p>c. Fit interlinings (coat fronts) to fronts keeping the interlinings slightly full to support shape of fronts. Baste fronts to interlinings through center; across shoulder and around armhole; and along break-lines.</p> <p>d. Position bridle stay (see operation 1.d) along inside of breakline, on interlinings, diagonally from neck to 1-1/2 to 2 inches from front edge. Baste center of stay even and smooth, starting from top for a distance of 1-1/2 to 2 inches; then hold stay taut, working in fullness for a distance of 3-3/4 to 4-3/4 inches; baste remainder of stay smooth without fullness; continue basting the interlining to front, down front to bottom.</p> <p>e. Stitch top, front and bottom edges of hanging pockets to interlinings with one row of blind stitching.</p> <p>f. Trim excess interlining at shoulders, armholes and collar gorges.</p> <p>g. Pad lapels of overcoat to interlining with not less than 10 rows of blindstitching. Fullness shall be equally distributed between rows in order to roll lapel.</p> <p>h. Blindstitch both edges of bridle stay to interlining.</p>	<p>Hand or Machine</p> <p>Hand or Machine</p> <p>103 or 306 or Hand</p> <p>103 or 306 or Hand</p> <p>103 or 306 or Hand</p>	<p>SSm-1 SSm-1 SSm-1</p> <p>SSm-10 SSm-10 SSm-10</p> <p>SSm-2 SSm-2 SSm-2</p>	<p>4-6 4-6 2-4</p> <p>6-8 6-8 2-4</p> <p>6-8 6-8 2-4</p>	<p>50-3 50-3 50-3</p> <p>50-3 50-3 50-3</p> <p>50-3 50-3 50-3</p>	<p>50-3</p> <p>50-3</p> <p>50-3</p>

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN or LOOPER
23.	<p><u>Shape fronts.</u></p> <p>a. Mark lapels as indicated by lapel shaper. (This becomes trim line after stitching.)</p> <p>b. Trim interlinings <math>5/16 \pm 1/16</math> inch along lapel, along front edge and across bottom. The interlinings may be cut diagonally at bottoms.</p> <p><u>Attach front facings.</u></p> <p>a. Baste facings to fronts, working in fullness over the bust area.</p> <p>b. Stitch facings to fronts, 1/4 inch from edge, through stay tape; stitching from lapel notch across top of lapel and down front catching the lapel button loop (see 3.2.13) in the stitching. The loop shall fit a 24-line button; shall be positioned across and behind the curve of the lapel, and shall lie close to the back of the lapel. The stay tape shall be sewed slightly loose along lapel edges. The right and left front shall be equal in length.</p> <p>NOTE: The buttonhole loop may be made by hand, using silk, size 10, buttonhole thread. When the loop is made by hand it need not be caught in the facing-to-front joining seam.</p> <p>c. Fell the back edge of the tape to the interlining from lapel notch to bottom.</p>	Hand or Machine	SSab-1 SSab-1	10-14 10-14	50-3 50-3	50-3 70-2
24.		103 or 306 or Hand	SSm-1 SSm-1 SSm-1	6-8 6-8 2-4	50-3 50-3 50-3	50-3

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN or LOOPER
24.	<p><u>Attach front facings.</u> (cont'd)</p> <p>d. Slash seam allowance at collar notch on top of lapel, trim edges, and turn facing. Do not trim too close to stitching at bottom of coat to assure that coat may be lengthened when required.</p> <p>e. Press edges of lapels and fronts flat, remove bastings and press edge seams open.</p>					
25.	<p><u>Assemble backs to fronts.</u></p> <p>a. Join side seams by overlapping the back on fronts 3/8 inch in from edge and stitching 3/8 inch from edge of back. Turn seams toward back and raise stitch 1/2 inch from joining seam. The pattern provides a seam allowance of 3/8 inch for backs and 3/8 inch plus a 3/8 inch outlet for fronts.</p> <p>b. Tape back armholes with 1/4 inch stay tape (see 3.2.8) from shoulder seam-line to 1/2 to 1 inch beyond side seam.</p> <p>c. Join shoulders, aligning the back dart seams with the front bust seams, catching the interlining in the seaming.</p> <p>d. Press shoulder seams open. Press lapels and right and left fronts on suitable shaped pressing bucks with a steam pressing machine to conform to the shape of the body.</p>	<p>301 or 401 and 301</p> <p>301 or 401</p> <p>301 or 401</p>	<p>LSs-2(a) LSs-2(a) LSs-2(b)</p> <p>SSab-1 SSab-1</p> <p>SSa-1 SSa-1</p>	<p>10-14 10-14 10-14</p> <p>10-14 10-14</p> <p>12-14 12-14</p>	<p>50-3 50-3 50-3</p> <p>50-3 50-3</p> <p>50-3 50-3</p>	<p>50-3 70-2 50-3</p> <p>50-3 70-2</p> <p>50-3 70-2</p>

NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN or LOOPER
26.	<p>Mark bottom hem and <u>attach ribbon</u>.</p> <p>a. Mark a 2-1/2 inch hem on bottom of overcoat.</p> <p>b. Stitch hem ribbon to bottom of overcoat with the ribbon overlapped on coat 1/8 to 1/4 inch.</p>	301 or 401	LSa-1 LSa-1	12-14 12-14	50-3 50-3	50-3 70-2
27.	<p><u>Paste coat edges and hem bottom</u>.</p> <p>a. Turn facings to finished position; work out edges and corners. Baste edges around coat from lapel step to lapel step, turning up overcoat hem 2-1/2 inches and rolling the facing joining-seams toward the underside of the lapels from collar to end of breaklines. Baste a second row 1/2 to 3/4 inch from first row maintaining the rolled-in edge.</p> <p>b. Blindstitch overcoat hem.</p>	Hand or Machine			50-3 50-3 50-3 C silk	
28.	<p><u>Set shoulder loops</u>.</p> <p>a. Match shoulder loops and trim if necessary.</p> <p>b. Position shoulder loops so that on the finished overcoat the back edge of the loop, at armhole, is 1/2 + 1/8 inch in back of shoulder seam and the point of the loop finishes on the shoulder not more than 1/2 inch from the collar-setting seam. Baste or stitch shoulder loops into position.</p>	103 or 105 or 301 or Hand	Efa-1 Efa-1 Efa-1 Efa-1	6-8 6-8 6-8 3-5		50-3

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN or LOOPER
29.	<p><u>Set sleeves.</u></p> <p>a. Stitch sleeves to armholes, notch to notch, distributing the sleeve head fullness between the notches, catching the shoulder loop in the seam.</p> <p>b. Top stitch around armhole of coat <math>1/2 + 1/16</math> inch from sleeve-setting seam. The shoulder loop shall not be caught in the stitching.</p> <p>c. Press fullness of sleeve flat all around armhole, shrinking fullness and holding armhole short. Press seam open across cap from back notch to not less than 3 nor more than 4 inches forward of shoulder seam. The shoulder loop seam allowance shall not be turned back.</p>	301  301	SSa-1	12-16  12-16	50-3  0 silk	50-3  0 silk
30.	<p><u>Set shoulder pad.</u></p> <p>a. Center pad on each shoulder with the edge of pad even with the armhole edge and stitch to sleeve seam allowance across the straight edge of pad.</p> <p>b. Tack point of shoulder pad to the interlining at shoulder.</p>	301 or Hand  Hand or Machine		4-6 4-6		
31.	<p><u>Press overcoat.</u></p> <p>Press entire coat on suitable pressing equipment. Sleeves, collar and lapels shall not be creased and the contour of the fronts shall be maintained.</p>					

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					NEEDLE	BOBBIN or LOOPER
32.	<p><u>Attach lining to overcoat.</u></p> <p>a. Stitch lining to overcoat along the front facings, distributing the bust fullness evenly. The bottom edge of the lining may be inserted between the ends of the facing hem.</p> <p>b. Stitch the unfinished portion of the shoulder seams with the back darts turned toward the center back and the lining-to-facing joining seams turned toward the sides.</p>	301 or 401	SSa-1 SSa-1	12-16 12-16	50-3 50-3	50-3 70-2
33.	<p><u>Set collar.</u></p> <p>a. Stitch undercollar to neck from lapel notch to lapel notch.</p> <p>b. Stitch top collar to front facings from lapel notch to the end of collar stand. Repeat the procedure at other end of collar.</p> <p>c. Slash seam allowances of top collar and undercollar at the end of each gorge (not less than 1 inch back of breakline).</p> <p>d. Press gorge seams of undercollar open. Press the remainder of the seam toward collar.</p> <p>e. Press gorge seams of top collar open.</p> <p>f. Stitch seam allowances of gorge seams together, catching the ends of the bridle stays in the stitching.</p>	301  301	SSa-1  SSa-1	12-16  12-16	50-3  50-3	50-3  50-3

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN or LOOPER
33.	<p><u>Set collar.</u> (cont'd)</p> <p>g. Baste lining to coat around neck.</p> <p>h. Turn under seam allowance of top collar and baste to neck through all plies catching the hanger loop (see operation 1.h and 1.i) in the seam. The hanger loop shall be centered (1/4 inch off center tolerance).</p>	<p>Hand or Machine</p> <p>Hand or Machine</p>				
34.	<p><u>Fit and baste facings.</u></p> <p>a. Baste facings to fronts diagonally from lapel breakline to the curve (corner) of lapel and along breakline, maintaining the fullness of facings to allow lapels to roll.</p> <p>b. Baste facings to front 1-1/2 + 1/2 inches from back edge of facing, distributing the fullness in facing over the bust area.</p>	<p>Hand or Machine</p> <p>Hand or Machine</p>				
35.	<p><u>Tack lining to overcoat.</u></p> <p>a. Stitch lining sleeve seam allowances to shoulder pad along the straight edge of the pad, keeping the lining and overcoat seams, seam on seam.</p> <p>b. Stitch underarm seam allowance of sleeve lining to underarm seam allowance of overcoat for a distance of 5 + 1/2 inches starting 5 + 1/2 inches from arm-hole.</p>	<p>Hand</p> <p>Hand or Machine</p>		<p>2 minimum</p> <p>2 minimum 4 to 6</p>		

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN or LOOPER
35.	<p><u>Tack lining to overcoat.</u> (cont'd)</p> <p>c. Baste sleeve linings to bottom of sleeves retaining the outlets for lengthening the sleeves. The finished bottom edge of sleeve lining shall measure <math>1-1/2 + 1/4</math> inches from bottom edge of overcoat sleeve.</p> <p>d. Stitch back edge of facing to interlining from 2 to 3 inches from shoulder to 2 to 4 inches from top of overcoat hem.</p>	Hand or Machine		2 minimum 4 to 6		
* 36.	<p><u>Fell coat.</u></p> <p>a. Hand or machine fell top collar to neck of overcoat from gorge seam to gorge seam securely tacking hanger, and ends of the collar seam.</p> <p>b. Hand fell back edge of facings from bottom of overcoat to bottom of lining hem.</p> <p>c. Fell or blindstitch sleeve lining to overcoat sleeve.</p>	Hand or machine (hand type felling)		6-8 6-8	A or C silk A silk	
		Hand		6-8	A or C silk	
		Hand or 103 or 314		6-8 6-8	A or C silk 50-3 50-3	50-3

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					SIZE	DESCRIPTION
37.	<p><u>Edge stitch coat.</u></p> <p>a. Edge stitch front edges and collar edge of overcoat with two rows of stitching 3/8 to 7/16 inch apart with the outer row 1/16 inch from edge. The inner row of stitching shall be a straight line from lapel to collar intersecting the lapel-collar notch.</p>	301	SSe-3(b)	12-16	0 silk	0 silk
38.	<p><u>Make buttonholes.</u></p> <p>a. Mark position of buttonholes (three on right front and one on left front) as indicated by pattern. The inside edge of the eyelets shall be 7/8 to 1 inch from edge.</p> <p>b. Make three 1-1/8 to 1-1/4 inches finished cut-length buttonholes on right front as marked and one 3/4 to 7/8 inch cut-length buttonhole on left front as marked.</p> <p>c. Bar end of buttonholes.</p>	Buttonhole or Hand  Machine or Hand		70-80 per buttonhole 46-54 per buttonhole	A or B silk 10 silk	A or B silk  A or B silk
39.	<p><u>Finish pressing.</u></p> <p>Finished appearance. The pressed overcoat and lining shall be free of gloss, wrinkles, creases, spots and impressions. The bust seams shall not break or "cave-in" below shoulder. Sleeves shall hang and balance evenly. The sleeves shall not be creased and the collar ends and lapels shall roll.</p>			21 per bar 6 per bar	A or B silk 10 silk	A or B silk

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN or LOOPER
39.	<p><u>Finish pressing.</u> (cont'd)</p> <p>a. Press entire coat. Press edges flat. If fronts are not pressed on a right and left front pressing machine manipulate fronts during pressing to retain the shaping. Press breakline in collar 3 to 3-1/2 inches long. Press armholes solid from the inside, creasing along the seam allowance. The armpit and back of armhole shall be pressed flat without stretching.</p> <p>b. Press lining.</p> <p>c. Place overcoat on hanger or place on form until thoroughly dry.</p> <p><u>Attach buttons.</u></p> <p>a. Mark position for buttons on right and left front (three each side) as indicated by button marker.</p> <p>b. Mark position for shoulder buttons to correspond to the eyelet end of buttonholes in shoulder loops.</p> <p>c. Mark position for button on left front to correspond with lapel button loop. The front shall lie flat and the collar ends, at the neck edge, shall not spread apart more than 1/4 inch nor overlap, when coat is buttoned.</p>					
*40.						

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN or LOOPER
#40.	<p>Attach buttons. (cont'd)</p> <p>d. Mark position for button on left front to correspond to the buttonhole in tab on right front.</p> <p>e. Sew the buttons as indicated below. All buttons except the three on the right front shall be shanked with a minimum of four tight wrappings except for automatic shanking which shall have a minimum of ten wraps with three locking stitches. The ends of the thread on hand sewn buttons shall be tacked off.</p> <p>(1) Three 45-line buttons on each front on marks. The middle button of the right side shall be sewn through interlining and facing and shall have a 30-line shanked stay (anchor) button. The stitchings of the other buttons shall be through the interlinings but not through the facings except that on the middle button of the right side the stitching shall be through the interlining and the facing. On machine sewn buttons, the stitching may be through the interlining and the facing. The bottom buttons shall be sewn through interlining and one side of pocket. The buttons shall not be out of horizontal alignment by more than 1/4 inch.</p> <p>(2) One 30-line button on each shoulder, or marks, to correspond with buttonholes on shoulder loops.</p>	<p>301 or</p> <p>101 or</p> <p>Hand or</p> <p>801 (see fig. 4)</p>		<p>14-16 per button</p> <p>14-16 per button</p> <p>4-6 per button</p> <p>7 (min.) 1 deep set per button</p>	<p>20-4</p> <p>20-4</p> <p>12-4 or 16-4</p> <p>5-nylon</p>	20-4

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS TABLE II	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D	
					NEEDLE	BOBBIN or LOOPER
*40.	<p><u>Attach buttons.</u> (cont'd)</p> <p>(3) One 30-line button on left front, on marks, to correspond with the buttonhole in the tab.</p> <p>(4) One 24-line button on the left front, under the collar, to correspond with the lapel button loop.</p> <p>(5) One 24-line button on the underarm seam of each sleeve to correspond with the button loops on the liner sleeves. The center of the button shall be 1/2 to 3/4 inch from the end of the lining and shall be stitched through the lining and the sleeve turn-up.</p> <p>(6) One 24-line button on right and left front lining, 1-1/4 + 1/4 inches below shoulder seam, through the facing-to-lining joining seam allowances to correspond with the buttonhole slits on each shoulder of liner.</p> <p>(7) Three 24-line buttons on right and left front lining, through the facing-to-lining joining seam allowances to correspond with the center of buttonholes on the fronts of the liner. The buttons shall not be out of vertical alignment by more than 1/4 inch.</p> <p><u>Clean overcoats.</u></p> <p>a. Trim all ends of stitching and loose threads.</p> <p>b. Remove all bastings.</p> <p>c. Remove all spots, stains, shade tickets, gloss and dart and seam impressions.</p>					
41.						

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3.9 Measurements. The finished measurements of the overcoat and liner shall conform to all the measurements shown in table III. The tolerance for all measurements shall be  $\pm 1/2$  inch, except that the tolerance for sleeve lengths of the overcoat shall be plus  $3/8$  inch, minus  $5/8$  inch and for the back length of the overcoat shall be plus  $3/4$  inch, minus  $1-1/4$  inches.

TABLE III. Measurements in inches

Size	8	10	12	14	16	18	20
<u>OVERCOAT</u>							
<u>1/2 Bust 1/</u>							
- Extra short and Short	18-1/4	19	19-3/4	20-1/2	21-1/4	22	23
- Regular and Long	18-3/4	19-1/2	20-1/4	21	21-3/4	22-1/2	23-1/2
<u>Crossback 1/</u>							
- Extra short and Short	14-1/8	14-1/2	14-7/8	15-1/4	15-5/8	16	16-1/2
- Regular and Long	14-5/8	15	15-3/8	15-3/4	16-1/8	16-1/2	17
<u>Sleeve length</u>							
- Extra short	21-1/2	21-3/4	22	22-1/4	22-1/2	-	-
- Short	22-3/4	23	23-1/4	23-1/2	23-3/4	24	24-1/4
- Regular	24	24-1/4	24-1/2	24-3/4	25	25-1/4	25-1/2
- Long	25-5/8	25-7/8	26-1/8	26-3/8	26-5/8	26-7/8	27-1/8
<u>Back length</u>							
- Extra short	37	37-1/4	37-1/2	37-3/4	38	-	-
- Short	38-1/2	38-3/4	39	39-1/4	39-1/2	39-3/4	40
- Regular	40-3/4	41	41-1/4	41-1/2	41-3/4	42	42-1/4
- Long	43-3/4	44	44-1/4	44-1/2	44-3/4	45	45-1/4
<u>LINER</u>							
<u>1/2 Bust 1/</u>							
- Extra short and Short	16-1/4	17	17-3/4	18-1/2	19-1/4	20	21
- Regular and Long	16-1/2	17-1/4	18	18-3/4	19-1/2	20-1/4	21-1/4
<u>Sleeve length</u>							
- Extra short	19-1/2	19-3/4	20	20-1/4	20-1/2	-	-
- Short	20-3/4	21	21-1/4	21-1/2	21-3/4	22	22-1/4
- Regular	22	22-1/4	22-1/2	22-3/4	23	23-1/4	23-1/2
- Long	23-1/2	23-3/4	24	24-1/4	24-1/2	24-3/4	25

TABLE III. Measurements in inches (cont'd)

Size	8	10	12	14	16	18	20
<u>LINER</u> (cont'd)							
Back length							
- Extra short	32	32-1/4	32-1/2	32-3/4	33	-	-
- Short	33-1/2	33-3/4	34	34-1/4	34-1/2	34-3/4	35
- Regular	35-1/2	35-3/4	36	36-1/4	36-1/2	36-3/4	37
- Long	38	38-1/4	38-1/2	38-3/4	39	39-1/4	39-1/2

1/ No extra short in sizes 18 and 20.

### 3.9.1 Method of measuring.

3.9.1.1 Overcoat. The overcoat shall be buttoned without liner, placed flat upon a table and measured as follows:

- Half bust - Measure from folded edge to folded edge at base of armhole.
- Cross back - Measure from armhole to armhole, 4-1/2 inches down from collar setting seam.
- Sleeve length - Measure from armhole down center of sleeve to bottom edge.
- Back length - Measure from collar seam down center back to bottom of overcoat.

3.9.1.2 Liner. The liner shall be placed flat upon a table and measured as follows:

- Half bust - Fold liner in half (down center back) and measure from front edge to back folded edge at base of armhole.
- Sleeve length - Measure from armhole seam down center of sleeve to bottom edge.
- Back length - Measure from neck edge to bottom of liner.

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- \* 3.10 Workmanship. The finished overcoat and liner shall conform to the quality of product established by this specification. As a final step in the supplier's production control plan, before formation of a lot, each overcoat shall be buttoned on a model form and examined for defects. An overcoat containing a selected defect shall not be included in the end item lot. Selected defects are those defects listed in MIL-STD-1392 indicated by an asterisk (\*). The occurrence of defects shall not exceed the applicable point value or defect limit.

#### 4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the supplier 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 the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

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

4.2 Quality conformance inspection. Sampling for inspection shall be performed in accordance with MIL-STD-1392, except where otherwise indicated hereinafter.

4.2.1 Component and material inspection. In accordance with 4.1 above, components and materials shall be inspected and tested in accordance with all the requirements of referenced specifications, drawings and standards unless otherwise excluded, amended, modified or qualified in this specification or applicable purchase documents. In addition to testing provisions contained in subsidiary specifications, testing shall be performed on components listed in table IV for characteristics listed. Wherever applicable, tests shall be conducted in accordance with methods prescribed in FED-STD-191. When the data in the "Determinations per sample unit" or the "Results reported as" columns are not specified in the table, they shall be as required by the referenced test method.

4.2.1.1 Sampling for testing. Unless otherwise specified in subsidiary specifications, the sampling for testing shall be in accordance with the table below. The lot shall be unacceptable if one or more sample units fail to meet any test requirement specified. The sample unit for testing the ribbon (see 3.2.10), and the lapel button loop braid (see 3.2.12) shall be 1-1/2 yards for each. The lot sizes shall be expressed in "yards". All test reports shall contain the individual values utilized in expressing the final result.



<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

TABLE IV. Component tests

<u>Component</u>	<u>Characteristic</u>	<u>Requirement paragraph</u>	<u>Test method</u>	<u>Determinations per sample unit</u>	<u>Results reported as</u>
Hem ribbon	Material identification	3.2.10	1500	-	<u>1/</u>
	Width	3.2.10	5020	1	Pass or fail
	Weight	3.2.10	5041	-	-
	Yarns	3.2.10	5050	-	-
	Colorfastness				
	- wet drycleaning	3.2.10	5622	-	-
	- crocking	3.2.10	5651	-	-
Braid (button loop)	Material identification	3.2.12	1200	-	<u>1/</u>
	Width	3.2.12	5020	1	Pass or fail
	Breaking strength	3.2.12	5100 <u>2/</u>	-	-
	Colorfastness				
	- crocking	3.2.12	5651	-	-
	- wet drycleaning	3.2.12	5622	-	-

1/ Unless otherwise specified, a certificate of compliance shall be submitted and will be acceptable for this characteristic.

2/ Breaking strength shall be determined on the width of the braid or ribbon and the jaw dimensions shall be greater than the width of the braid or ribbon.

4.2.2 Process inspection. Inspection of sub-assemblies shall be made to ascertain that the construction details, which cannot be examined in the finished product, are in accordance with requirements specified. Construction methods of sub-assemblies not in accordance with specified requirements shall not be considered acceptable.

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4.2.3 Examination of end item. The end item examination provisions for the finished overcoats and liners shall be as specified in MIL-STD-1392.

\* 4.2.4 Dimensional examination. The dimensional examination provisions for the finished overcoats and liners shall be as specified in MIL-STD-1392.

\* 4.2.5 Examination of preparation for delivery requirements. The examination for compliance with packaging, packing and marking requirements shall be as specified in MIL-STD-1392.

## 5. PREPARATION FOR DELIVERY

5.1 Packaging. Packaging shall be level A or C as specified (see 6.2).

5.1.1 Level A.

5.1.1.1 Prepackaging.

5.1.1.1.1 Overcoat with liner. Each overcoat with liner shall be laid flat, back down, and an insert conforming to figure 3 placed inside the overcoat, fitting into the shoulders and collar. The overcoat shall be buttoned and the sleeves positioned full length resting naturally over the pockets. The bottom shall be folded up over the front until the overcoat length measures approximately 36 inches. The top with the inclosed insert shall then be folded down over the bottom the full length of the insert. Each overcoat, folded as specified, shall measure not more than 24 by 18 inches.

5.1.1.1.2 Overcoat, only. Each overcoat shall be laid flat, back down, and an insert conforming to figure 3 placed inside the overcoat, fitting into the shoulders and collar. The overcoat shall be buttoned and the sleeves positioned full length resting naturally over the pockets. The bottom shall be folded up over the front until the overcoat length measures approximately 36 inches. The top with the inclosed insert shall then be folded down over the bottom the full length of the insert. Each overcoat, folded as specified, shall measure not more than 24 by 18 inches.

5.1.1.1.3 Liner. Each liner shall be laid flat, back down, and with the fronts meeting at the center. The sleeves shall be positioned full length over the fronts. The bottom shall be folded up over the front until the liner measures approximately 36 inches. The top shall then be folded down over the bottom. Each liner, folded as specified, shall measure not more than 24 by 18 inches.

### 5.1.1.2 Intermediate packaging.

- \* 5.1.1.2.1 Overcoat with liner. Five overcoats with liners of one size only, prepackaged as specified in 5.1.1.1.1, stacked one on another and alternated collar to bottom, shall be placed in an intermediate fiberboard box conforming to style FTC, type CF, variety SW, class domestic, grade 175 of PPP-B-636. Inside dimensions of the fiberboard box shall approximate 24-1/2 inches in length, 18-1/2 inches in width, and 7 inches in depth. Not less than three ounces of naphthalene flakes shall be uniformly distributed throughout the contents of each box, except where coats are made from cloth pretreated with a moth repellent. Box closure shall be secured with 3 inch minimum width gummed paper tape conforming to type III of PPP-T-45 applied at the center of the length opening and extending on the bottom and up the sides at least three inches.

5.1.1.2.2 Overcoat, only. Five overcoats of one size only, prepackaged as specified in 5.1.1.1.2, stacked one on another and alternated collar to bottom, shall be placed in an intermediate fiberboard box conforming to style FTC, type CF, variety SW, class domestic, grade 175 of PPP-B-636. Inside dimensions of the fiberboard box shall approximate 24-1/2 inches in length, 18-1/2 inches in width, and 4-1/2 inches in depth. Not less than three ounces of naphthalene flakes shall be uniformly distributed throughout the contents of each box, except where coats are made from cloth pretreated with a moth repellent. Box closure shall be secured with 3 inch minimum width gummed paper tape conforming to type III of PPP-T-45 applied at the center of the length opening and extending on the bottom and up the sides at least three inches.

5.1.1.2.3 Liner. Fifteen liners of one size only, prepackaged as specified in 5.1.1.1.3, stacked one on another and alternated shoulder to bottom, shall be placed in an intermediate fiberboard box conforming to style FTC, type CF, variety SW, class domestic, grade 175 of PPP-B-636. Inside dimensions of the fiberboard box shall approximate 24-1/2 inches in length, 18-1/2 inches in width, and 7 inches in depth. Box closure shall be secured with 3 inch minimum width gummed paper tape conforming to type III of PPP-T-45 applied at the center of the length opening and extending on the bottom and up the sides at least three inches.

5.1.2 Level C. Overcoats with liner, overcoats only, or liners only shall be packaged to afford adequate protection against physical damage during shipment from the supply source to the first receiving activity. The supplier may use his standard practice when it meets this requirement.

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

5.2.1 Level A.

5.2.1.1 Overcoat with liner. Ten overcoats with liners of one size only, packaged as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC, grade V2s of PPP-B-636. Level A packages shall be packed flat two in depth within a shipping container. Inside dimensions of each shipping container shall approximate 26-1/2 inches in length, 20-1/2 inches in width, and 15 inches in depth. Approximate dimensions are furnished as a guide only. Each shipping container shall be closed in accordance with method III, waterproofed in accordance with method V, and reinforced as specified in the appendix of PPP-B-636. Toward the end of the contract or when there are less than the required amount per container of the same size, mixed sizes may be packed within the same container.

5.2.1.2 Overcoat, only. Fifteen overcoats of one size only, packaged as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC, grade V2s of PPP-B-636. Level A packages shall be packed flat three in depth within a shipping container. Inside dimensions of each shipping container shall approximate 26-1/2 inches in length, 20-1/2 inches in width, and 15 inches in depth. Approximate dimensions are furnished as a guide only. Each shipping container shall be closed in accordance with method III, waterproofed in accordance with method V, and reinforced as specified in the appendix of PPP-B-636. Toward the end of the contract or when there are less than the required amount per container of the same size, mixed sizes may be packed within the same container.

5.2.1.3 Liner. Thirty liners of one size only, packaged as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC, grade V2s of PPP-B-636. Level A packages shall be packed flat two in depth within a shipping container. Inside dimensions of each shipping container shall approximate 26-1/2 inches in length, 20-1/2 inches in width, and 15 inches in depth. Approximate dimensions are furnished as a guide only. Each shipping container shall be closed, in accordance with method III, waterproofed in accordance with method V, and reinforced as specified in the appendix of PPP-B-636. Toward the end of the contract or when there are less than the required amount per container of the same size, mixed sizes may be packed within the same container.

5.2.2 Level B.

5.2.2.1 Overcoat with liner. Ten overcoats with liners of one size only, packaged as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC, type CF (variety SW) or type SF, class domestic, grade 275 of PPP-B-636. Level A packages shall be packed flat

two in depth within a shipping container. Inside dimensions of the shipping container shall approximate 26-1/2 inches in length, 20-1/2 inches in width, and 15 inches in depth. Approximate dimensions are furnished as a guide only. Each shipping container shall be closed in accordance with method II as specified in the appendix of the container specification. Toward the end of the contract or when there are less than the required amount per container of the same size, mixed sizes may be packed in the same container.

5.2.2.2 Overcoat, only. Fifteen overcoats of one size only, packaged as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC, type CF (variety SW) or type SF, class domestic, grade 275 of PPP-B-636. Level A packages shall be packed flat three in depth within a shipping container. Inside dimensions of the shipping container shall approximate 26-1/2 inches in length, 20-1/2 inches in width, and 15 inches in depth. Approximate dimensions are furnished as a guide only. Each shipping container shall be closed in accordance with method II as specified in the appendix of the container specification. Toward the end of the contract or when there are less than the required amount per container of the same size, mixed sizes may be packed in the same container.

5.2.2.3 Liner. Thirty liners of one size only, packaged as specified in 5.1, shall be packed in a fiberboard shipping container conforming to style RSC, type CF (variety SW) or type SF, class domestic, grade 275 of PPP-B-636. Level A packages shall be packed flat two in depth within a shipping container. Inside dimensions of the shipping container shall approximate 26-1/2 inches in length, 20-1/2 inches in width and 15 inches in depth. Approximate dimensions are furnished as a guide only. Each shipping container shall be closed in accordance with method II as specified in the appendix of the container specification. Toward the end of the contract or when there are less than the required amount per container of the same size, mixed sizes may be packed in the same container.

5.2.2.4 When specified (see 6.2), the shipping container shall be a grade V3c, V3s or V4s fiberboard box fabricated in accordance with PPP-B-636 and closed in accordance with method III as specified in the appendix of the container specification.

5.2.3 Level C. Overcoats with liners, overcoats only, or liners only, packaged as specified in 5.1, shall be packed in a manner to insure carrier acceptance and safe delivery at destination at the lowest transportation rate for such supplies. Containers shall be in accordance with Uniform Freight Classification Rules or National Motor Freight Classification Rules, as applicable.

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

5.3.1 Labels, mixed sizes. Each shipping container, packed with mixed sizes of the same description, shall have securely attached to the end and side, directly under the printing or stencilling, a white paper label 5 by 4 inches with the words "MIXED SIZES" plainly stamped or printed thereon, and under these words shall be legibly stamped or printed the correct quantity and sizes contained therein.

6. NOTES.

6.1 Intended use. The overcoats are intended for wear as part of the service uniform of the female personnel of the Department of the Army.

6.2 Ordering data. Procurement documents should specify the following:

- (a) Title, number and date of this specification.
- (b) Size and item required (see 1.2).
- (c) Selection of applicable levels of packaging and packing (see 5.1 and 5.2).
- (d) When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.4).

6.3 Samples. For access to sample of the end item and shade samples, address the procuring office issuing the invitation for bids.

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

Custodian:

Army - GL

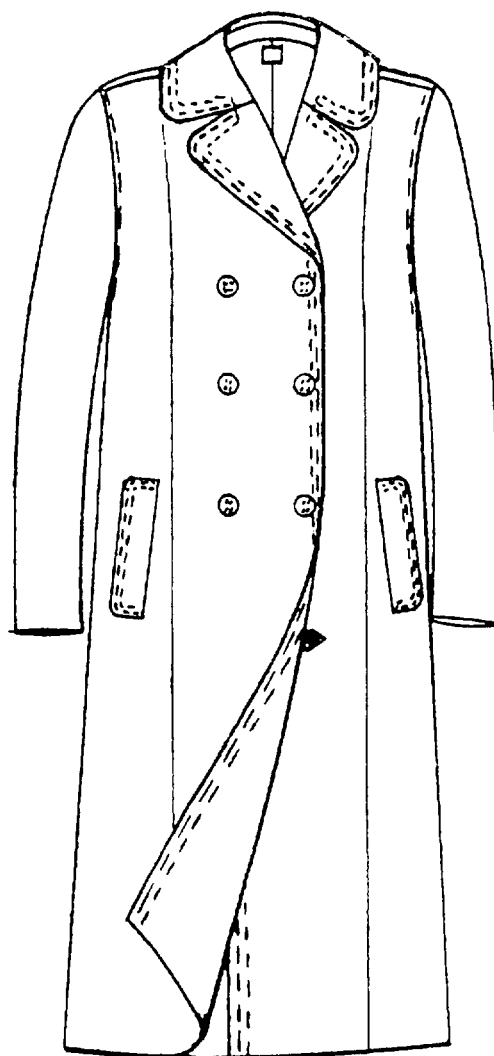
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Army - MD

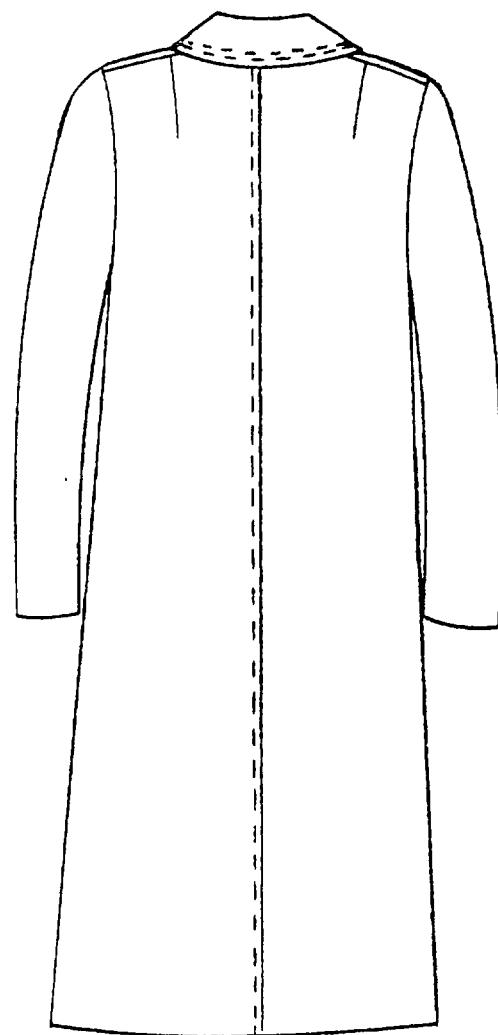
Preparing activity:

Army - GL

Project No. S410-A229



*FRONT VIEW*



*BACK VIEW*

*FIGURE 1 OVERCOAT, WOMAN'S, ARMY GREEN 44  
2-1-882*

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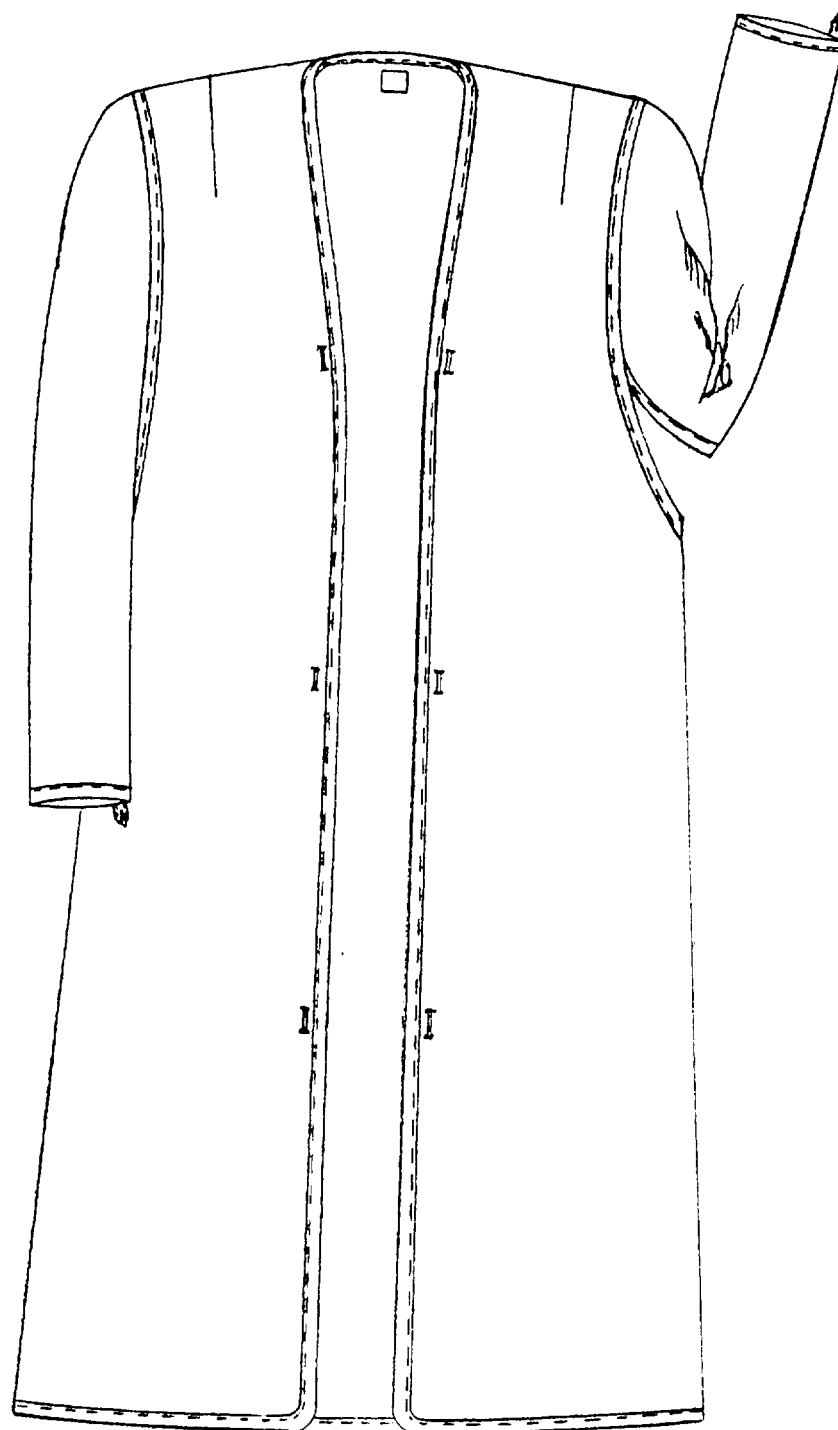
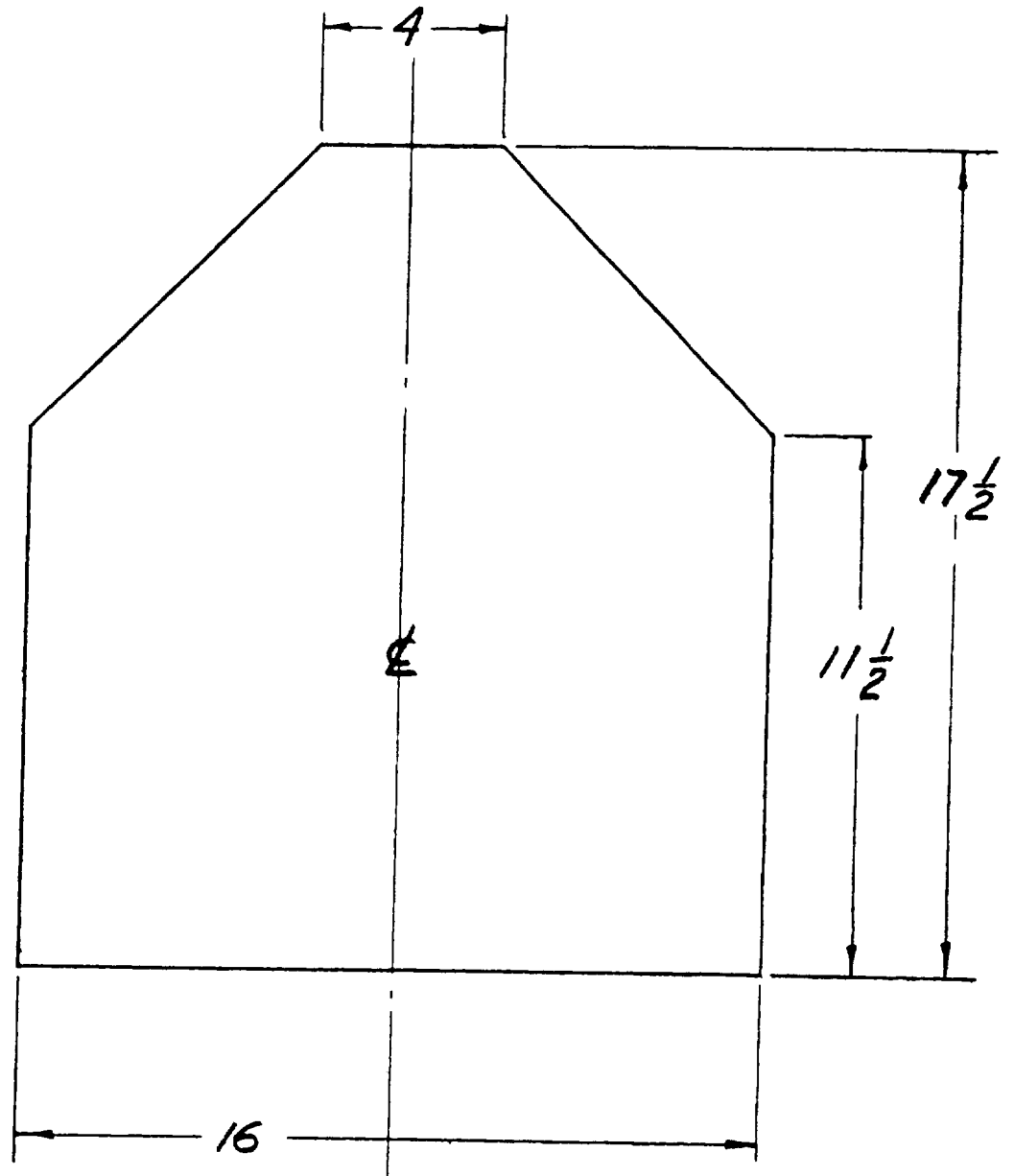


FIGURE - 2 OVERCOAT, WOMAN'S, ARMY GREEN 44  
REMOVABLE LINER





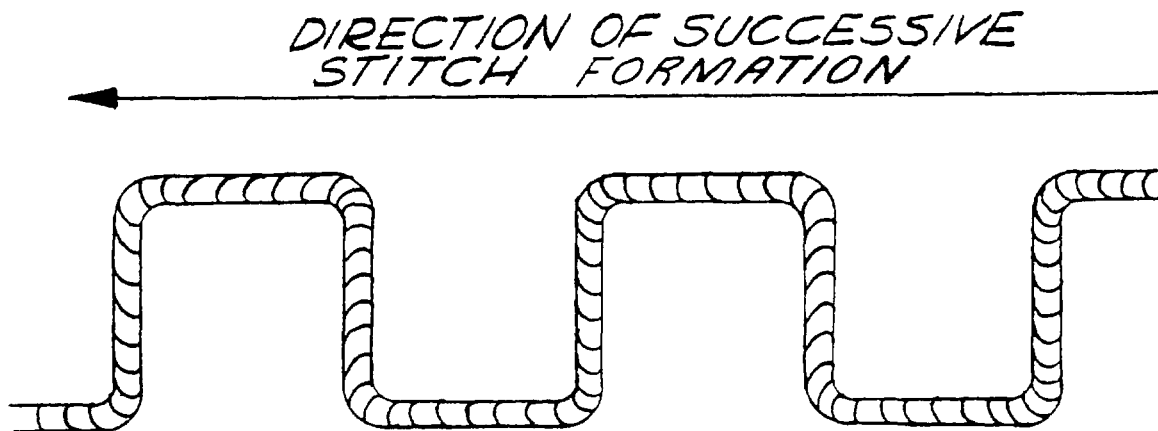
*NON-BENDING PAPERBOARD 0.048" THICK*

*FIGURE 3. INSERT, PAPERBOARD*

*2-1-476*

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Stitch Class 800.- This class of stitch shall be formed with one or more needle threads and has for a general characteristic that the thread does not interloop with itself or any other thread or threads. The thread is passed completely through the material by means of a double pointed center eye needle and returned by another path. This class of stitch simulates hand stitching.



This type of stitch shall be formed with one needle thread which is passed completely through the material and returned by another path after the material has been moved forward one stitch length.

*FIGURE 4-STITCH TYPE 801*

SPECIFICATION ANALYSIS SHEET		Form Approved Budget Bureau No. 22-R255
<p><b>INSTRUCTIONS:</b> This sheet is to be filled out by personnel, either Government or contractor, involved in the use of the specification in procurement of products for ultimate use by the Department of Defense. This sheet is provided for obtaining information on the use of this specification which will insure that suitable products can be procured with a minimum amount of delay and at the least cost. Comments and the return of this form will be appreciated. Fold on lines on reverse side, staple in corner, and send to preparing activity. Comments and suggestions submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or serve to amend contractual requirements.</p>		
<p><b>SPECIFICATION</b> MIL-O-43527E(CL) Overcoat, Woman's, Army Green 44, and Removable Liner</p>		
<p><b>ORGANIZATION</b></p>		
<p><b>CITY AND STATE</b></p>		<p><b>CONTRACT NUMBER</b></p>
<p><b>MATERIAL PROCURED UNDER A</b>  <input type="checkbox"/> DIRECT GOVERNMENT CONTRACT      <input type="checkbox"/> SUBCONTRACT</p>		
<p><b>1. HAS ANY PART OF THE SPECIFICATION CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE?</b>  <b>A. GIVE PARAGRAPH NUMBER AND WORDING.</b></p>		
<p><b>B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES</b></p>		
<p><b>2. COMMENTS ON ANY SPECIFICATION REQUIREMENT CONSIDERED TOO RIGID</b></p>		
<p><b>3. IS THE SPECIFICATION RESTRICTIVE?</b>  <input type="checkbox"/> YES      <input type="checkbox"/> NO (If "yes", in what way?)</p>		
<p><b>4. REMARKS</b> (Attach any pertinent data which may be of use in improving this specification. If there are additional papers, attach to form and place both in an envelope addressed to preparing activity)</p>		
<p><b>SUBMITTED BY</b> (Printed or typed name and activity - Optional)</p>		<p><b>DATE</b></p>

DD FORM 1426  
1 JAN 66

REPLACES EDITION OF 1 OCT 64 WHICH MAY BE USED.

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