

MIL-0-43537C(GL)  
 17 June 1988  
 SUPERSEDING  
 MIL-0-43537B(GL)  
 29 March 1977

# MILITARY SPECIFICATION

## OVERCOAT, MAN'S, ARMY GREEN 44, WITH REMOVABLE LINER

- \* This specification is approved for use by the U.S. Army Natick Research, Development and Engineering Center, Department of the Army, and is available for use by all Departments and Agencies of the Department of Defense.

### 1. SCOPE

1.1 Scope. This document covers a wool or polyester and wool gabardine overcoat and a detachable wool liner.

1.2 Classification. The overcoats shall be of one type and two classes in the sizes listed below:

Class 1 - Wool Gabardine, AG 44

Class 2 - Polyester and Wool, Gabardine, AG 44

### Schedule of sizes (chest size)

X-short	Short	Regular	Long	X-long
	30	30		
32	32	32	32	
34	34	34	34	34
36	36	36	36	36
38	38	38	38	38
40	40	40	40	40
42	42	42	42	42
	44	44	44	44
	46	46	46	46
		48	48	48

- \* Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: U.S. Army Natick Research, Development, and Engineering Center, Natick, MA 01760-5014 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8405

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## 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 specification to the extent specified herein. Unless otherwise specified, the issues of these documents shall be those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation.

## SPECIFICATIONS

## FEDERAL

- \* A-A-203 - Paper, Kraft, Untreated  
 V-B-871 - Button, Sewing Hole, and Button, Staple, (Plastic)  
 V-F-106 - Fasteners, Slide, Interlocking  
 V-T-276 - Thread, Cotton  
 V-T-280 - Thread, Gimp, Cotton, Buttonhole  
 V-T-295 - Thread, Nylon  
 V-T-301 - Thread, Silk  
 CCC-C-438 - Cloth, Buckram, Woven and Nonwoven  
 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

## MILITARY

- MIL-C-326 - Cloth, Silesia, Cotton  
 MIL-C-368 - Cloth, Satin, Rayon and Cloth, Twill, Rayon  
 MIL-B-371 - Braid, Textile, Tubular  
 MIL-B-1860 - Buckle, Slide, Plastic  
 MIL-C-3191 - Cloth, Flannel, Wool, Lining, 12 Ounce  
 MIL-C-10176 - Cloth, Gabardine; Wool, Polyester and Wool  
 MIL-C-15062 - Cloth, Flannel, Wool, Undercollar Cloth  
 MIL-P-15064 - Pads, Shoulder and Sleeve-Head  
 MIL-C-15065 - Coat Fronts  
 MIL-C-16375 - Cloth, Wigan, Cotton  
 MIL-C-29137 - Cloth, Felt Fabric Composite, Undercollar  
 \* MIL-L-35078 - Loads, Unit: Preparation of Semi-perishable Subsistence Items; Clothing, Personal Equipment and Equipage  
 MIL-C-43718 - Cloth, Polyester; Polyester and Cotton; Polyester and Rayon, for Pockets

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## STANDARDS

### FEDERAL

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

### MILITARY

- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
  - MIL-STD-129 - Marking for Shipment and Storage
  - \* MIL-STD-147 - Palletized Unit Loads
  - \* MIL-STD-731 - Quality of Wood Members for Containers and Pallets
  - MIL-STD-1391 - Provisions for Evaluating Quality of Overcoats, Men's
- \* (Copies of specifications, standards, and handbooks required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting activity.)
- \* 2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of the documents which are DOD adopted shall be those listed in the issue of the DODISS specified in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS shall be the issues of the nongovernment documents which are current on the date of the solicitation.

### \* AMERICAN SOCIETY FOR TESTING AND MATERIALS

#### D 3951 - Standard Practice for Commercial Packaging

(Copies may be obtained from the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.)

- \* (Nongovernment standards and other publications are normally available from the organizations which prepare or which 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 specification and the references cited herein, the text of this specification shall take precedence. Nothing in this specification, however, shall supersede applicable laws and regulations unless a specific exemption has been obtained.

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## 3. REQUIREMENTS

- \* 3.1 First article. When specified in the contract or purchase order, a sample shall be subjected to first article inspection (see 4.3, 6.2, and 6.4).
- \* 3.2. Guide samples. Guide samples, when furnished, are solely for guidance and information to the contractor (see 6.3). Variations from this document may appear in the samples, in which case this document shall govern.
- \* 3.3 Materials. Materials shall be as specified herein (see 6.5).
  - 3.3.1 Basic material for overcoat.
    - \* 3.3.1.1. Class 1 overcoat. The basic material for the class 1 overcoat shall be wool, gabardine, Army Green 44, conforming to type I, class 5 of MIL-C-10176.
    - \* 3.3.1.2 Class 2 overcoat. The basic material for the class 2 overcoat shall be polyester and wool, gabardine, Army Green 44, conforming to type II, class 10 of MIL-C-10176.
  - 3.3.2 Basic material for liner. The basic material for the liner shall be wool flannel lining, conforming to MIL-C-3191, except the color shall be Army Green 280 and the colorfastness requirement to light shall not apply.
  - 3.3.3 Lining. The material for lining overcoat and liner; for slide fastener bellows piece and facing for lower pocket openings; for binding side and center back seams, edges of vent and back edges of front facing, lower pocket openings (when applicable) and neck facing of overcoat; for binding outer edges, vent edges, slash openings, sleeve and armhole opening of liner; shall be Army Green 45, rayon cloth conforming to class 1 of MIL-C-368.
  - 3.3.4 Interlining for fronts. The interlining for fronts shall conform to type III of MIL-C-15065, except the applicable pattern parts listed in 3.5.1 of this document shall be used.
  - 3.3.5 Collar and belt interlining. The material for interlining collar and belt shall be cotton buckram cloth, natural or bleached, conforming to type I, class 2 of CCC-C-438.
  - 3.3.6 Undercollar material. The undercollar material shall be wool flannel conforming to MIL-C-15062 or a felt-fabric composite conforming to MIL-C-29137. The color shall be Army Green 48. The colorfastness requirements to perspiration and crocking in both documents shall not apply.
  - 3.3.7 Wigan for sleeve bottoms. The material for interlining sleeve bottoms shall be cotton wigan conforming to type I of MIL-C-16375.

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- \* 3.3.8 Sheeting for inside hanging pocket. The lining for inside hanging pockets shall be a soft filled cotton sheeting, having a smooth suede finish on one side, dyed black or other suitable colors in dark shades, conforming to the following requirements when tested as specified in 4.4.1.1:

Weight per square yard (minimum)	6.0 ounces
Yarns per inch (minimum)	Warp - 44
	Filling - 40
Breaking strength (load-pounds minimum):	Warp - 60
	Filling - 35

The dyed and finished cloth shall contain no more labile sulfur than shown by the standard sample when tested as specified in 4.4.1.1. The finished material shall show "good" fastness to wet-dry-cleaning when tested as specified in 4.4.1.1.

3.3.9 Silesia. The material for stay pieces and interlining of shoulder loops shall be cotton silesia, dyed black, conforming to type I of MIL-C-326, except that the non-fibrous material content and colorfastness requirements for perspiration and crocking shall not apply. As an alternate to the silesia, cloth conforming to class 1 of MIL-C-43718 may be used.

3.3.10 Sleeve head pad. The sleeve head pad shall conform to type IV of MIL-P-15064.

3.3.11 Tapes. The tape shall be bleached or unbleached, preshrunk, conforming to type I, class 1 or 2 of DDD-T-86, except that the non-fibrous material content shall not apply, in the following widths:

3/8 or 1/2 inch for staying front edges  
 5/8 inch for bridle at breakline of overcoat  
 1/4 inch for staying armholes, gorge, and vent of overcoat  
 3/8 inch for pocket welt

3.3.12 Braid. The braid for coat hanger shall be dyed Army Green 44 and shall conform to type IX, class 1 of MIL-B-371.

3.3.13 Shoulder pad. The shoulder pad shall conform to type I of MIL-P-15064.

3.3.14 Labels. Each overcoat shall have an identification label, a size label, an instruction label, and a size ticket. Each liner shall have an identification and size label. The labels shall conform to type VI of DDD-L-20 and shall show fastness to drycleaning.

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3.3.14.1 Identification label. The identification label shall conform to class 1.

3.3.14.2 Size label. The size label shall conform to class 2.

\* 3.3.14.3 Instruction label. The instruction label shall conform to class 3 except that the text shall be as shown on figure 3 with the letters for caption not less than 5/32 inch in height and all other letters not less than 1/8 inch in height. The size of the label shall be  $4 \pm 1/8$  by  $2-1/4 \pm 1/8$  inches.

3.3.14.4 Size ticket. The size ticket shall be made of a suitable commercial cardboard and shall measure  $2-1/8$  by  $1-1/2$  inches. The size shall be printed on the ticket; for example, "36R" with letters and numerals not less than 1/4 inch in height, together with title of document.

3.3.14.5 Combination label. The identification label (class 1) and the instruction label (class 3) may be combined into one label. The combination label shall conform to the requirements of the class 3 label.

### 3.3.15 Thread.

3.3.15.1 Cotton thread. The cotton thread shall conform to V-T-276 in the following types and sizes:

Use	Type	Ticket No.	Ply
Seaming and stitching overcoat	IA3	30, 50 70	3 2
Button sewing:			
Hand	IA3 or IB3	12 or 16	4
Machine	IA3 or IB3	20	4

NOTE: The cotton thread for basting shall be of commercial grade.

A monofilament synthetic thread may be used for those basting operations where the thread is required to be removed, provided the garment is subsequently given a treatment by a dry-cleaning agent in which the synthetic thread is soluble. When this thread is used, any residue remaining on the garment after the dry-cleaning process shall be brushed off or removed.

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- \* 3.3.15.2 Polyester thread. Polyester thread may be used as an alternate to the cotton thread specified in 3.3.15.1. The polyester thread shall conform to the following sizes of MIL-T-43548:

Use	Ticket Number	Ply
Seaming and stitching overcoat	30, 50 70	2 or 3 2
Button Sewing:		
Hand	30	2 or 3
Machine	30	2 or 3

- \* 3.3.15.3 Silk thread. The silk thread shall conform to V-T-301 in the types, sizes, classes and manufacturing uses as follows, except the requirements governing weighting or loading shall not apply.

Uses	Type	Size	Class
Machine-made buttonholes	I	A and B	--
Hand tailored buttonholes	II	10	I, Subclass A or B
Hand felling	III	A or C	--
Machine type felling	III	A	--
Outside trim topstitching	I	O	--

- \* 3.3.15.4 Nylon thread. Nylon thread may be used as an alternate to the silk thread specified in 3.3.15.3. The nylon thread should conform to the following types and sizes of V-T-295. If an automatic machine which sews and shanks (wraps) the button in one operation is used, the thread shall conform to type III, size ff, waxed physical and colorfastness requirements.

Use	Type	Size	Class
Hand or machine type felling	IV	A and C	A
Making buttonholes and bartacks	V	10	A
Machine stitching	VI	O	A

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3.3.15.4 Color. The threads shall be dyed Army Green E. C.A. 66034.

3.3.15.5 Colorfastness. The dyed thread (except for seaming linings) shall show fastness to wet-dry-cleaning and light equal to or better than the standard sample. The thread for seaming of linings shall show fastness to wet-dry-cleaning equal to or better than the standard sample. When no standard sample is available, the dyed thread shall show "good" fastness to wet-dry-cleaning and light as applicable.

3.3.16 Gimp. The cotton gimp for reinforcing buttonholes shall conform to type I or II, size 8 of V-T-280.

3.3.16.1 Color. The gimp shall be dyed Army Green E, C.A. 66034.

3.3.16.2 Colorfastness. The dyed gimp shall show fastness to wet-dry-cleaning equal to or better than the standard sample. When no standard sample is available, the dyed gimp shall show "good" fastness to wet-dry-cleaning.

\* 3.3.17 Slide fastener. The slide fastener for the overcoats with liner shall be type IV, style, 1, size LS, with short tab pull and brass chain, conforming to V-F-106. The length of the fastener shall be 84 inches for regular, long and X-long sizes; and 78 inches for short and X-short sizes.

3.3.17.1 Tape for slide fastener. The slide fastener tape shall be dyed Green, Shade X, Cable No. 66524. The dyed tape shall show fastness to wet-dry-cleaning equal to or better than the standard sample.

3.3.18 Buckle. The buckle shall be a 2-1/4 inch slide buckle conforming to class 3 of MIL-B-1860. The color of the buckle shall be Army Green Shade BR, Cable No. 62015.

3.3.19 Buttons. The buttons shall conform to type II, class D; style 20 or 21, sizes 24-line, 30-line and 45-line; and style 15, 18-line; glossy finish, button shade Army Green BR, Cable 62015, conforming to V-B-871.



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\* 3.4 Design. The design of the overcoat shall be: a double-breasted model, lined to waist, with a convertible collar, and an all-around belt with buckle supported by belt loops; lower welt pockets with a through opening, sleeve tabs, and shoulder loops to button; and a center back vent, lapped on the right. The overcoat shall be provided with a detachable liner which can be fastened into the overcoat. The liner shall be sleeveless, with all outside edges and edges of slash opening and armholes bound. The overcoat is designed so that it may be worn with or without the liner.

3.5 Patterns. Standard patterns will be furnished by the Government. The patterns show size, seam allowance, shape, shape and placement of pockets, directional lines for marking in, and include shapers for lapels, undercollar and undercollar stand, and marker for width of pocket welts. The standard patterns shall not be altered in any way and are to be used only as a guide for making the contractor's working patterns, which shall be identical to the standard patterns.

3.5.1 List of pattern parts. The components of the overcoat shall be cut from materials as specified according to the pattern parts indicated:

List of pattern parts

Material	Pattern nomenclature	Cut parts
Cloth, wool, gabardine	Front part	2
	Back part	2
	Top sleeve	2
	Undersleeve	2
	Top collar	1
	Shoulder loops	2
	Belt	1
	Front facings	2
	Sleeve tab	4
	Neck facing	1
	Top collar stand	1
	Inside hanging pocket	2
	Pocket welt	2
Cloth, rayon, lining	Front body lining	2
	Back lining (yoke)	2 <u>1</u> /
	Top sleeve lining	2
	Undersleeve lining	2
	Pocket facing	2
	Back liner lining	2 <u>1</u> /
	Front liner lining	2

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List of pattern parts (cont'd)

Material	Pattern nomenclature	Cut parts
Cloth, wool, flannel lining	Back liner	2 <u>1</u> /
	Front liner	2
Cloth, wool, flannel	Back undercollar	2
	Front undercollar	2
Cloth, cotton, wigan	Sleeve wigan	2
Cloth, cotton, sheeting	Inside hanging pocket	2
Cloth, cotton warp, hair-wool filling	Front canvas	2
	Wedge (shoulder dart)	2
	Chest piece	2
Cloth, cotton, buckram	Front undercollar	2
	Back undercollar	2
	Belt interlining	1
Cloth, cotton, flannel unbleached, double-napped	Felt piece	2
- or -		
Cloth, cotton-wool felt		
Cloth, cotton, silesia	Shoulder loop interlining	2
- or -		
alternate cloth (see 3.3.9)	Shapers:	
	Lapel shaper (working)	
	Finished lapel and collar shaper	
	Undercollar shaper (with 3/16 inch seam)	
	Collar stand marker	
	Welt marker	
	Undercollar shaper (finished)	
	Topcollar shaper	
	Neck and gorge marker	

1/ Alternate pattern parts provided for constructing the back lining (yoke), back liner, and back liner lining in one piece.

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\* **3.6 Construction.** The construction shall conform in all respects to the requirements in table I and herein.

\* **3.6.1 Stitches, seams, and stitching.** Stitch, seam, and stitching types, specified in table I, shall conform to FED-STD-751. Where two or more seam or stitching types are given for the same operation, any one of them may be used. Seam allowances shall be maintained with seams sewn so that no raw edges, runoffs, 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. The edge and top stitching shall be uniformly gaged throughout the garment.

**3.6.1.1 Type 301 stitching.** Ends of all stitching shall be backstitched or overstitched 1/2 inch minimum except when caught in other stitching or turned under in a hem. Thread tension shall be maintained so that there will be no loose stitching resulting in puckering of material sewn. The lock shall be embedded in the material sewn.

**3.6.1.1.1 Repairs of type 301 stitching.** Repairs of type 301 stitching shall be as follows:

a. When thread breaks or bobbin run-outs occur during sewing, the stitching shall be repaired by restarting the stitching a minimum of one inch behind the end of the stitching. 1/

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

1/ When making the above repairs, the ends of the stitching are not required to be backstitched.

**3.6.1.2 Type 401 stitching.** Thread tension shall be maintained so that there will be no loose stitching. Both ends of all seams or stitching produced with a 401 stitch type, when not turned under in a hem or held down by other stitching, shall have a 1/2 to 3/4 inch chain extending beyond each end. The looper (under thread) shall always be on the inside of the overcoat and on the coatside of the liner. All repairs shall be in accordance with 3.6.1.1.1a or 3.6.1.1.1b. Repairs may be made using 301 stitch type.

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

3.6.1.4 Thread ends. All thread ends that are visible on the finished item shall be trimmed to a length of not more than 1/4 inch.

3.6.2 Buttonholes. All buttonholes shall be cut first type buttonholes of the eyelet end, square bar type, worked over gimp, with the gimp pulled through to the underside. The ends of the buttonholes shall be bartacked in a separate operation from the buttonhole making, with 21 stitches per bartack using silk size A upper and lower thread; or buttonholes may be tacked by hand, using No. 10 silk, with not less than 6 stitches per tack; or front buttonholes may be made by hand, using No. 10 silk.

\* 3.6.3 Bartacks. Bartacks shall measure 1/4 to 1/2 inch long and be free from thread breaks and loose stitching.

\* 3.7 Repairs. Repairs such as mends, darns, patches or splices are not permitted on the coat.

3.8 Manufacturing operations requirements. The overcoats shall be made by and with the use of all operations listed in table I. The contractor is not required to follow the exact sequence of operations or sub-operations shown unless otherwise specified. Any additional basting or holding stitching used to facilitate manufacture is permissible provided that the threads are removed or do not show in the finished overcoat or liner.

\* 3.9 Figures. Figures 1 through 5 are furnished for information purposes only. If there are any inconsistencies between the written document and the figures, the written document shall control.

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

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NO.	TABLE I MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	ROBBIN/ LOOPER	COVER
1.	<p><u>Cutting.</u></p> <p>a. Cut all parts out of one piece of material in strict accordance with patterns furnished which show directional lines, size, shape, placement of pockets and notches for assembling of all parts, except inside hanging pockets and underply of sleeve tabs, which may be cut from ends. The use of perforated paper markers is prohibited on the gabardine cloth. Drill holes for component marking is prohibited.</p> <p>b. Parts cut from ends shall approximate the shade of overcoat.</p> <p>c. The welt pieces shall be cut in such a manner that the twill line of the fronts and welts will run in the same direction in the finished overcoats.</p> <p>d. Cut slash opening on fronts of wool liner as indicated on pattern.</p> <p>e. Belt sizes 42 and larger may be cut in two pieces with the seam running across the width of the belt. In the finished belt, the piecing shall be towards buckle end of belt.</p> <p>f. Cut belt loops and keeper (strip cut) in the direction of the warp, of sufficient width and length to finish in accordance with operations 23, 24 and 48b.</p> <p>g. The pocket openings may be die cut in the cutting room as indicated by pocket opening mark on pattern. The pocket opening shall not be tongue notched in the cutting room.</p>						

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NO.	TABLE I (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	ROBBIN/ LOOPER	COVER
1.	<p><u>Cutting.</u> (cont'd)</p> <p>h. Center top collar shaper on top collar and recut to conform to the shaper.</p>						
2.	<p><u>Cut linings.</u></p> <p>Cut all parts of the lining for the overcoat and liner in the direction of the warp in accordance with patterns furnished. The overcoat lining parts shall match each other except sleeve lining and pocket facing parts. Sleeve lining parts shall match each other. The liner lining parts shall match each other.</p>						
3.	<p><u>Cut trimmings.</u></p> <p>a. Cut all trimmings in strict accordance with patterns furnished, which show size and markings for proper assembling.</p> <p>b. Cut the undercollar cloth and collar interlining in accordance with directional lines on patterns.</p> <p>c. Cut the silesia for the shoulder seams, forepart of armholes and back neck on the bias <math>3/4</math> to 1 inch wide.</p> <p>d. Cut the pocket lining in the warp or filling direction.</p>						

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	FOBBIN/ LOOPER	COVER
3.	<p><u>Cut trimming.</u> (cont'd)</p> <p>e. Cut the rayon binding for the overcoat and liner 7/8 to 1 inch wide on the bias from the lining material. Cut the rayon bellows strip from lining material on the bias 2 inches wide. Cut the rayon binding for lower pocket openings (when applicable) from the lining material, on the bias, 1-1/8 inches wide.</p>						
4.	<p><u>Replacement of defective components.</u></p> <p>During the spreading, cutting and manufacturing process, components having material defects or damages that are classified as defects in MIL-STD-1391 shall be removed from production and replaced with non-defective and properly matched components.</p>						
5.	<p><u>Marking.</u></p> <p>The component parts of the overcoat shall be marked to insure a uniform shade and size throughout the garment. Any method of marking may be used except:</p>						
*	<p>a. Corrosive metal fastening devices. No metal device or sew-on type markings shall be used on the rayon lining.</p> <p>b. Adhesive-type tickets which discolor the material or leave traces of paper or adhesive on the material after removal of the tickets.</p> <p>NOTE: The use of an ink pad numbering or machine rubber stamp or pencil is allowed, provided the numbering does not show on the outside of the garment, and wherever possible, is covered by the seam allowance.</p>						

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN/LOOPER COVER
6.	<p><u>Bind side seams.</u></p> <p>Finished appearance. The binding shall be evenly stitched and the fabric securely caught in the stitching. The binding shall not be tight or full, puckered, gathered, or pleated.</p> <p>Bind side seams of fronts (see operation 3.e) with underside edge of the binding raw.</p>	301	BSb-1	12-16	50	50
7.	<p><u>Fronts of coat.</u></p> <p>Finished appearance. All parts, such as tape at armholes, strip of silesia at shoulder seams, etc., shall be neatly and uniformly sewn. The tape and silesia shall be sewn with thread matching the basic material.</p> <p>a. Seam a strip of bias cut silesia on fronts, along shoulder seams, 1-1/2 inches from gorge outlet to 1/2 inch from armholes.</p> <p>b. Sew the 1/4 inch tape on armhole to extend from side seam to a point 3/4 to 1 inch above lower armhole notch of front.</p> <p>c. Sew a strip of the bias cut silesia on armholes to extend from 1/2 inch down from shoulder seam to lower armhole notch of front.</p> <p>d. Sew a 1/4 inch tape on gorge from shoulder seam to a point 3/4 to 1 inch from lapel notch.</p> <p>e. A tolerance of <math>\pm 1/2</math> inch will be permitted for positioning tapes and bias cut silesia strips.</p>	301	SSaa-1	10-14	50	50
		301	SSaa-1	10-14	50	50
		301	SSaa-1	10-14	50	50
		301	SSaa-1	10-14	50	50



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NO.	MANUFACTURING OPERATIONS (CONT'D) REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	HOBBS/ LOOPER COVER
7.	<p><u>Fronts of coat.</u> (cont'd)</p> <p>f. Press fronts from top of lapel to bottom of coat in pairs face to face approximately 8 inches from front edge with a steam pressing machine. Pressing to be accomplished prior to basting interlining to fronts.</p>					
8.	<p><u>Make pocket welt.</u></p> <p>Finished appearance. The twill line of the forepart of overcoat and welt shall be in the same direction when finished. The tape and welt shall be sewn with thread matching the basic material. The welts shall be uniformly made and stitched.</p> <p>a. Position the 3/8 inch tape on the underside of the welt with one side of the tape aligned with the center (foldline) of the welt. Stitch tape to welt with one row of stitching 1/16 to 1/8 inch from the edge of tape nearest the foldline.</p> <p>b. Notch on front of welt indicates top of welt and also the side on which tape is sewed.</p> <p>c. Fold welt as indicated on pattern and seam both ends with a 1/4 inch seam.</p> <p>d. Trim corners, turn and work out points.</p> <p>e. Place a row of stitching <math>1/2 \pm 1/16</math> inch from edges.</p> <p>f. Press welt; keeping edge straight.</p> <p>g. Mark pocket welt with the pocket welt marker for proper width.</p>	301	SSau-1	12-16	50	50
*		301	SSaa-2(a)	12-16	50	50
		301	SSae-2(b) and OSf-1	12-16	0 silk	0 silk

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NO.	TABLE I (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	ROBBIN/ LOOPER	COVER
9.	<u>Set pocket welt.</u>  Finished appearance. The welts shall be uniform in appearance and placement and shall lie flat and smooth without twisting, pleating, puckering or raw edges. All stitching shall be uniform in width.  a. Set pocket welt on front as indicated by marks on pattern. Seam welts to fronts with the ends of stitching securely tacked.  b. Fold lining pocket facing in half lengthwise and seam to fronts, parallel to welt seam and 3/8 inch from welt seaming stitch.  c. Cut pocket opening, turn lining facing and stitch 1/16 + 3/32 inch from edge with ends of stitching tacked. Notches shall not be exposed on inside or outside ends of welt.  d. Stitch back edge of lining facing 1/16 to 1/8 inch from folded edge through fronts with ends of stitching tacked.  e. In lieu of operations "b" and "d" above, the edge of the pocket openings opposite the welt may be bound with 1-1/8 inch wide bias binding with edges of binding turned in and caught in the stitching 1/16 inch from folded edges (see operation 3.e).  f. Raise stitch front of overcoat through welt 1/16 inch from seam.	301	SSa-1	12-16	50	50	
		301	SSa-1	12-16	50	50	
*		301	SSe-2 shown finished seam	12-16	0 silk	0 silk	
		301		12-16	0 silk	0 silk	
		301	BSc-1	12-16	0 silk	0 silk	
		301		12-16	0 silk	0 silk	

- or -

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NO.	MANUFACTURING OPERATIONS (CONT'D) REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
10.	<p><u>Position and stitch labels.</u></p> <p>Stitch identification and instruction labels on all four sides to back side of left wool hanging pocket on inside of coat. Stitch identification label directly below the instruction label. The top edge of the identification label may be caught in the bottom edge stitching of the instruction label. The two labels or the combination label shall be centered on the pocket.</p>	301	LSbj-1	12-16	50	50	
11.	<p><u>Make inside hanging pocket.</u></p> <p>a. Seam hanging pocket lining to wool hanging pocket, 1/4 to 5/16 inch from edge, around bottom on top of straight side. Turn pocket and stitch 1/4 to 3/8 inch from turned edge.</p>	301	SSe-2	12-16	50	50	
*	<p>b. Turn in back edge of cut opening of hanging pocket 1/4 to 5/16 inch and seam through hanging pocket, turn under tongue notch and stitch from notch to top forming the pocket facing.</p> <p>c. The felted side of lining shall finish on inside pocket.</p>	301	Lsd-1	12-16	50	50	
12.	<p><u>Set inside hanging pocket.</u></p> <p>Finished appearance. The pocket shall be uniform in appearance and placement and shall lie flat and smooth without twisting, pleating or puckering. The stitching shall be uniform in width.</p> <p>a. Set pocket to edge of pocket welt on the inside and stitch to seam allowance of welt from notch of hanging lining to top of welt with a 5/16 inch seam with ends of stitching securely tacked.</p>	301	SSa-1	12-16	50	50	

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NO.	TABLE I (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	ROBBIN/ LOOPER	COVER
12.	Set inside hanging pocket. (cont'd)						
	b. Smooth out the hanging pocket on the inside, position welt on outside and stitch top and bottom ends of welt with two rows of stitching through front and pocket. The inner row shall be superimposed on the 1/2 inch edge stitching on welt, the outer row shall be 1/16 to 3/32 inch from edge and the stitching at the back corners of hand opening shall be diagonal.	301	SSa-2	12-16	0 silk	0 silk	
13.	c. Close pocket by seaming front and top of pocket 1/2 inch from edge.	301	SSa-1	12-16	50	50	
	d. Press pockets with steam pressing machine.						
	<u>Baste overcoat to interlining.</u>						
	a. Place forepart of overcoat on interlining.						
	b. Baste from below shoulder through center of interlining to bottom, clearing pocket.	301 or Hand			Commercial		
	c. Baste from lapel breakline across shoulder and around armhole. Lay over inside pocket toward side seam and baste along side of interlining to bottom.	301 or Hand			Commercial		
	d. Baste along breakline of lapel and continue basting down front to bottom.	301 or Hand			Commercial		
	e. Trim interlining away to clear tacking at top of pocket, permitting pocket to lie smooth and flat on the interlining.						
	f. Baste pocket through interlining and front across top and down front edge of pocket.	301 or Hand			Commercial		

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NO.	TABLE I, (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	NOBBIN/ LOOPER	COVER
13.	<u>Baste overcoat to interlining.</u> (cont'd)  g. Position and baste bridle tape along and behind breakline, holding tape taut enough to work in 1/2 to 3/4 inch fullness. Tape shall extend above gorge seam and within 2 to 2-1/2 inches from bottom of lapel. The tape and interlining shall be stamp marked to assure proper fullness.  h. Trim excess interlining at shoulders, armholes, and collar gorge.	301 or Hand			Commercial		
14.	<u>Sew on shoulder pads.</u>  Insert shoulder pads in proper position between chest piece and felt and tack around curved edges through felt, pad and interlining.	301 or Hand			Commercial		
15.	<u>Tack inside hanging pocket.</u>  Tack top and front edge of inside hanging pocket with two rows of blindstitching, the first row on the edge, the second row adjacent thereto.	301 or 103 or Hand	SSm-2	4-6	50 50 50	50	
16.	<u>Pad lapels.</u>  Pad each lapel to interlining with not less than 12 rows of blindstitching, allowing lapel to roll. Blindstitch on both edges of bridle tape to interlining.	301 or 103 or Hand	SSm-12 and SSm-2	6-8 6-8 2-4	70 70 70	70	
17.	<u>Make backs.</u>  Finished appearance. The binding shall be evenly stitched and the fabric securely caught in the stitching. The binding shall not be tight or full causing puckers, gathers or pleats.						

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NO.	MANUFACTURING OPERATIONS (cont'd)	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	ROBBIN/ LOOPER	COVER
17.	<u>Make backs.</u> (cont'd)						
	a. Bind center seam of right back of overcoat from neck to bottom of right vent (see operation 3.e).	301	BSc-1	12-16	50	50	
	b. Bind left vent from bottom and around curve of vent.	301	BSc-1	12-16	50	50	
18.	<u>Stay left vent.</u>  Finished appearance. The tape shall be sewn with thread matching the basic material.						
19.	Stitch the 1/4 inch tape of left vent in line with the back seam, holding tape slightly taut.	301	SSau-1	12-16	50	50	
	<u>Join center back seam of overcoat and make vent.</u>  Finished appearance. The gage of stitching shall be uniform in width and the raw edge on the inside shall be inclosed.						
	a. Join center back seam. Place the left back on the right back with the edge of left back center seam even with the notch on right back at top and single stitch 1/8 inch from edge from top of vent at notch to neck.	301 or 401	LSs-2(a)	12-16	30	30	
	b. Fold at bottom notch and stitch left vent from bottom to top of vent 1/2 inch from edge.	301	OSf-1	12-16	0 silk	0 silk	
	c. Turn and raise stitch center back seam 1/2 inch from edge.	301	LSs-2(b)	12-16	0 silk	0 silk	

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NO.	MANUFACTURING OPERATIONS (REQUIRED)	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	ROBBIN/ LOOPER	COVER
19.	<p>Join center back seam of overcoat and make vent. (cont'd)</p> <p>d. The width of the 1/2 inch stitching of center back seam and vent shall match.</p> <p>e. Tack top of vent with a double row of diagonal stitching through both sides of vent, 1-1/4 to 1-1/2 inches in length and 1/4 to 3/8 inch apart, continue the stitching across each end forming a box of the stitching. The box stitching shall start at the center joining seam of the back with the bottom row in line with the end of the joining seam.</p>	301		12-16	0 silk	0 silk	
20.	<p><u>Tape armhole of backs.</u></p> <p>Finished appearance. The tape shall be sewn with thread matching the basic material.</p> <p>Sew 1/4 inch tape on armhole on backs from side seam to 1 + 1/2 inches from shoulder seams, holding tape taut in order to draw up the material 3/8 to 5/8 inch.</p>	301 or 401	SSaa-1	10-14	50 50	50 70	
21.	<p><u>Stay neck of back.</u></p> <p>Finished appearance. The stay shall be sewn with thread matching the basic material.</p> <p>a. Sew a 3/4 to 1 inch wide bias stay of silesia to back neck. The ends of stay shall clear the shoulder seam allowance with the top edge of stay 3/8 + 1/4 inch from top of back.</p>	301	SSaa-1	10-14	50	50	

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NO.	MANUFACTURING OPERATIONS (CONT'D) REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
22.	<p><u>Join side seams.</u></p> <p>Finished appearance. The gage of the stitching shall be uniform in width and the raw edges of the inside shall be inclosed.</p> <p>a. Join side seams with the backs on fronts with the edges of backs in line, and even with the top and bottom notches of fronts.</p> <p>b. Turn and raise stitch 1/2 inch from edge.</p>	301 or 401	LSs-2(a)	12-16	30	30	
23.	<p><u>Make belt loops, belt keeper.</u></p> <p>Finished appearance. The finished strips shall be uniform in width, <math>1/2 + 1/8</math> inch wide.</p> <p>a. Make the belt loops and belt keeper from basic material.</p> <p>b. (1) Fold strip for each loop and keeper in half lengthwise and seam 1/8 inch from side raw edges.</p> <p>(2) Turn strip with the seam in the center on the underside and press flat with a heated pressing iron or machine.</p> <p>- OR -</p> <p>c. Make loops and keeper by folding raw edges to center with the raw edges abutted and blindstitch edges together. Stitching shall not be visible on outside of loop.</p>	301	EFu-1	12-16	50	50	
*		103	SSm-2	6-8	50		



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NO.	TABLE I, (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	NOBBIN/ LOOPER	COVER
24.	<p><u>Sew on four belt loops.</u></p> <p>Finished appearance. The belt loops shall be of uniform length, <math>2-1/2 \pm 1/8</math> inches long.</p> <p>a. Position belt loops on fronts as indicated by marks on pattern.</p> <p>b. Raw edge on ends of loops shall be stitched to overcoat so that the stitching is not visible on the outside of loops. The raw ends of the loop shall not extend more than <math>1/4</math> inch from the stitching.</p> <p>c. Seam the tops and bottom of two loops on the side seams.</p> <p>d. Seam the top of the remaining two loops through fronts and interlining only, and seam the bottom of the loops through fronts and tops of patch pockets.</p> <p style="text-align: center;">- or -</p> <p>e. Sew on the loops by hand.</p> <p><u>Press seams (see 3.10).</u></p> <p>Finished appearance. The seams shall not be distorted nor stretched when pressing.</p> <p>a. Press side seams flat, holding side seam short.</p> <p>b. Press tape at armhole of back.</p> <p>c. Press center back seam flat, holding seam short.</p>	301	SSa-1	12-16	50		
		301	SSa-1	12-16	50		
		Hand		10-14	C silk		
25.							

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NO.	TABLE 1. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	ROBBIN/ LOOPER	COVER
26.	<u>Make front and back yoke lining.</u>  Finished appearance. The seams shall not be tight nor full causing puckers, gathers or pleats. The seams shall be evenly sewn with no raw edges showing.						
*	a. When two-piece construction is used, join center seam of back yoke with a 1/4 to 5/16 inch seam on the right side of material. Turn and stitch 3/8 to 7/16 inch from edge on underside, inclosing raw edge.  b. Join side seams with a 3/4 inch seam allowance.  c. Hem bottom of lining by turning 1/4 inch and folding bottom as indicated by notches on patterns and stitch 1/16 inch from turned edge. The side seams shall be toward the back.	301 or 401	SSae-2	12-16	50 50	50 70	
27.	<u>Press fronts, lapels and chest.</u>  Press right and left fronts, lapels and chest of coat on a convex shaped steam pressing block to conform to the shape of the body.	301 301	SSa-1 EFb-1	12-16 12-16	50 50	50 50	
28.	<u>Shape fronts.</u>  a. Position shaper at point of shoulder and mark lapels.  b. Shape lapels and trim.  c. Shape and trim fronts.						

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NO.	TABLE I. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	ROBBIN/LOOPER	COVER
28.	<p><u>Shape fronts.</u> (cont'd)</p> <p>d. Trim bottom of right front, taking off 1/4 inch at front edge, tapering to nothing, for a distance of 5 + 1 inches, making right front edge shorter than left front edge.</p> <p>e. Trim bottom edge of coat matching lengths of vent, and clip piping from side seams and vent to facilitate the binding operation of bottom.</p> <p>f. Trim interlining from edges of lapel and fronts 1/4 to 5/16 inch.</p> <p>g. The interlining at bottom may be cut diagonally.</p> <p><u>Bind bottom edge.</u></p> <p>Finished appearance. The binding shall be evenly stitched and the fabric caught in the stitching. The binding shall not be tight or full causing puckers, gathers or pleats.</p> <p>Bind bottom edge of overcoat (see operation 3e) with the underside edge of the binding raw.</p> <p><u>Front facing.</u></p> <p>Press front facing in pairs, face to face, with a steam pressing machine. The facings shall be pressed prior to basting facing to front.</p> <p><u>Join neck facing for supporting liner.</u></p> <p>a. Seam the ends of neck facing to the shoulders of right and left facings with 5/16 to 3/8 inch seam.</p> <p>b. Press seam open, flat and smooth.</p>						
*							
29.		301	BSb-1	12-16	50	50	
30.							
31.							
*		301	SSa-1	12-16	50	50	

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NO.	TABLE I. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	ROBBIN/ LOOPER	COVER
32.	<p><u>Bind facing.</u></p> <p>Finished appearance. The binding shall be evenly stitched and the fabric caught in the stitching. The binding shall not be tight nor full causing puckers, gathers or pleats.</p> <p>Bind the back edge of front facing and bottom edge of neck facing (see operation 3e).</p>	301	BSc-1	12-16	50	50	
33.	<p><u>Make linings.</u></p> <p>a. Fold the side edges of the 2 inch wide bias cut rayon bellows strip toward the inside 1/2 inch.</p> <p>b. Place bellows strip on underside of facing with the raw edges upward and stitch front edge 1/8 + 1-3/8 inches from bound edge of facing through strip and facing.</p> <p>c. Fold front of body lining 1/2 inch and set folded edge between facing and bias rayon bellows strip 1-3/8 + 1/8 inches from bound edge of facing. The bias rayon bellows strip shall extend above turn up of body lining.</p> <p>d. Continue stitching along folded edge of body lining, from marks as indicated on pattern, to finish shoulder seam of facing leaving end of lining open 1/2 to 3/4 inch.</p>	301		12-16	50	50	

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NO.	TABLE I (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D	
					NEEDLE	COVER
34.	<p><u>Press linings.</u></p> <p>Press linings, and neck facings by hand with a heated pressing iron or steam pressing machine. Form and press center back pleat on yoke as indicated by marks on pattern. The outside folded edge of the pleat shall face the left back (as worn). Press side seams toward back.</p>					
35.	<p><u>Baste facings to fronts.</u></p> <p>Finished appearance. Facings shall be fitted and basted to fronts in accordance with good manufacturing practices, properly placing and distributing fullness at chest and lapels.</p> <p>a. Mark shoulder for finished seams.</p> <p>b. Match and fit facings to fronts, placing finished seam of facing on shoulder of front as marked; baste, placing fullness at chest and lapels.</p>	301 or Hand			Commercial	
36.	<p><u>Tape, fell, press, turn, and baste edges of fronts.</u></p> <p>Finished appearance. Edges, lapel points and corners shall be worked out. The bottom turnout shall be uniform in width.</p> <p>a. Tape and stitch edges of coat from the lapel notch across top of lapel, down front (<math>3/8 + 1/16</math> inch seam allowance) and across bottom to back edge of facing, continuing only the stitching across bottom, using a gage for turnout as indicated on pattern. Tape is to be <math>3/8</math> or <math>1/2</math> inch wide. The stitching at bottom of overcoat may terminate at back edge of facing.</p>	301	SSaa-1	12-16	50	50

NO.	TABLE I, (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	ROBBIN/ LOOPER	COVER
36.	<p><u>Tape, fell, press, turn, and baste edges of fronts.</u> (cont'd)</p> <p>b. Fell back edge of tape to interlining on fronts and lapels.</p> <p>c. Remove bastings, press edges flat and smooth with a heated pressing iron or machine.</p> <p>d. Trim the edges of facings from point of lapel to bottom. The edges may be trimmed with a blade attachment in the taping operation.</p> <p>e. Press edges open.</p> <p>f. Notch corner of lapel, trim top edge of lapels; turn coat, work out lapel and bottom corners.</p> <p>g. Baste edges of lapels, fronts, and bottoms, matching vent lengths.</p> <p>h. Place a second row of basting along bottom turnout. The bottom turnout shall finish 1 to 1-1/4 inches in width. The second row of basting may be omitted.</p>	103 or 301 or Hand	SSm-1	4-8 4-8 2-4	50 50 30		
		101 or Hand			Commercial		
		101 or 301 or Hand			Commercial		

NO.	TABLE I. (CONT'D) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D	
					NEEDLE	ROBBIN/ LOOPER COVER
37.	<u>Baste facing along fronts.</u>  a. Baste facings across top of lapel and continue down front edge to bottom of facing. Place a row of basting diagonally from lapel breakline to point of lapel, placing fullness in lapel to allow lapel to roll.  b. Baste fronts in center of facings from top of lapel to bottom of facing.  c. Baste along breakline of lapel allowing fullness in facing to permit lapel to roll.  d. Bast along rayon strip and front body lining stitching, putting in fullness over chest.  <u>Tack facings to interlining.</u>	Hand or 301   Hand or 301  Hand or 301  Hand or 301	         SSm-1	         4-8 4-8 1-2	Commercial  Commercial  Commercial  Commercial	
38.	<u>Fit and baste lining of coat.</u>  a. Baste pleat in shoulders of front and continue basting around armholes, across back and along neck, centering pleat at center back and placing fullness in yoke.  b. Trim excess interlining from bottom of body lining bellows strip.  c. Baste bellows strip to pocket and front. Bellows strip shall extend to bottom of fronts.	301 or 103 or Hand			50 50 30	50
39.		Hand or 301			Commercial	Commercial

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NO.	TABLE I (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	WOBBIN/ LOOPER	COVER
40.	<u>Trimming.</u> Trim gorge and trim the lining at armholes and shoulders.						
41.	<u>Fell bellows strip, and bottom of coat.</u> a. Fell bellows strip with a blindstitch.	103 or 301 or Hand		6-8 6-8 6-8	0 silk 0 silk A silk	0 0 silk	
	b. Fell bottom of coat with a blindstitch machine or by hand.	301 or Hand or 306		6-8 6-8 6-8	0 silk A (2-1/2 to 3) 0 silk	0 silk silk silk	
42.	<u>Join and press shoulder seams.</u> Finished appearance. The fullness at the shoulder shall be evenly distributed so that shoulder will attain correct shape when finished. a. Join shoulder seam of overcoat with 5/16 inch seam working in fullness on backs. b. Open and press, holding shoulders short (an underpressing machine over a suitable block may be used).	301 or 401	SSa-1	12-16	30 30	30 50	



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NO.	MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	ROBBIN/ LOOPER	COVER
43.	<p><u>Make shoulder loops.</u></p> <p><i>Finished appearance. The shoulder loops shall finish smooth and flat, without twists, pleats, puckers or raw edges and be of uniform appearance. The gage of stitching shall be uniform in width. The buttonholes shall be the cut first type, correctly positioned. The stitching shall be caught in the fabric with the gimp pulled through to the underside and the purling on the outside.</i></p> <p>a. Make loops of one piece of the basic material as indicated by pattern and interline with silesia.</p> <p>b. Fold loops and seam raw edges of side and point of loop.</p> <p>c. Press seam open and flat.</p> <p>d. Stitch or baste silesia interlining to shoulder loops along underside of seam.</p> <p>e. Turn loops, with the seam on the underside and off center of loop and free of buttonhole.</p> <p>f. Single stitch around edge 1/2 inch from edge.</p> <p>g. Press shoulder loops smooth and flat.</p> <p>h. Loop shall finish 1-3/4 + 1/8 inches at pointed end and 2 + 1/8 inches wide at sleeve head.</p>	301	SSa-1	12-16	50	50	
		301	SSa-1	10-14	50	50	
		301	OSf-1 and SSae-2(b)	12-16	0 silk	0 silk	
				12-16	0 silk	0 silk	

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NO.	TABLE I. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	ROBBIN/ LOOPER	COVER
43.	<u>Make shoulder loops.</u> (cont'd)  i. Make a 5/8 to 3/4 inch cut buttonhole in center of each loop (tolerance + 1/8 inch) with the front of eyelet 5/8 to 3/4 inch from the point of loop (see 3.6.2).	Button-hole		50-52 per button-hole	B silk	A silk	
44.	<u>Set shoulder loops.</u>  Finished appearance. The shoulder loops shall be uniform in size and setting.  a. Baste or stitch loop to shoulder at armhole.  b. The back edges of loops shall be placed 1/2 inch back of the shoulder seam at armhole with the point centered on shoulder seam. The point of loop shall be positioned not more than 1/4 inch from lower edge of under collar.  c. The position of loop on either shoulder seam shall not vary more than 1/4 inch.  d. Trim even at armhole.	301 or Hand	SSa-1	10-14 2-4	50 30	50	
45.	<u>Baste shoulder.</u>  Baste in from armhole up to and along shoulder seam to the gorge, continue basting down from shoulder seam 3 + 1/2 inches, catching interlining and lining in the basting.	301 or Hand				Commercial	

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	DOBBIN/ LOOPER	COVER
48.	<p><u>Make belt.</u></p> <p>Finished appearance. The belt shall finish smooth and flat without twists, pleats, puckers or raw edges and shall be of uniform appearance. The gage of stitching shall be uniform width. The belt shall finish <math>2-1/8 \pm 1/8</math> inches wide.</p> <p>a. The belt shall be made of one ply of the basic material and interlined with buckram. When the belt is cut in two pieces, the pieces shall be joined the width of the belt and the seam pressed open and flat.</p> <p>b. Position the belt keeper across the width of the belt as indicated by marks on pattern. Belt keeper may be tacked into position.</p> <p>c. Fold belt in half lengthwise with the belt keeper inclosed within the fold and stitch full length of belt.</p> <p>d. Turn one seam allowance back to one side. Position interlining to belt with center of interlining in line with belt joining seam and front raw edge of belt and stitch interlining to one seam allowance of belt. Interlining shall finish evenly distributed across width of belt.</p> <p>e. Shift position of belt so that belt joining seam is centered on belt and the interlining is centered and evenly distributed across belt.</p>	301 or 401	SSa-1	12-16	30 or 50 30 or 50	30 or 50 50 or 70	
		301 or 401		12-16	30 or 50 30 or 50	30 or 50 50 or 70	

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NO.	MANUFACTURING OPERATIONS (REQUIREMENTS)	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	BOBBIN/LOOPER	COVER
48.	<u>Make belt.</u> (cont'd)						
	f. Stitch across front edge of belt.	301		12-16	30 or 50	30 or 50	
	g. Turn belt to outside; force out front corners and edges.						
	h. Edge stitch both sides and front edge, $1/2 + 1/8$ inch from edge.	301		12-16	0 silk	0 silk	
	i. Fold unfinished end of belt over buckle bar $2-1/4 + 1/4$ inches.						
49.	j. Turn under raw edge and double stitch to belt $1/4$ to $3/8$ inch gage.	301	EFb-2	12-16	0 silk	0 silk	
	k. Press belt.						
	<u>Make undercollar.</u>						
	a. Seam the four undercollar pieces with a $1/4 + 1/16$ inch seam.	301	SSa-1	12-16	50	50	
	b. Press the seams open and flat.						
	c. Join interlining pieces.	301	LSa-1	12-16	50	50	
	d. Mark breakline of undercollar with the under-collar stand marker.						
	e. Stitch undercollar to interlining at the break-line.	301	SSa-1	12-16	50	50	

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS (cont'd)	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	FOOT/LOOPER	COVER
49.	<p><u>Make undercollar.</u> (cont'd)</p> <p>f. Quilt interlining to undercollar with not less than seven rows of blindstitching on undercollar and not less than two rows on stand.</p> <p>g. Crease undercollar at breakline and press on a suitable pressing buck.</p> <p>h. Center undercollar shaper on quilted undercollar with the inside arc of the shaper aligned with the creased breakline (operation 49 g above) and mark the outer edge of collar and placement of notches. Trim undercollar on marked line and trim interlinings 3/16 to 1/4 inch around edge of collar and the neck edge of the stand.</p>	301 103	SSm-9 SSm-9	12-16 4-8	50 50	50	
50.	<p><u>Make top collar.</u></p> <p>a. Join top collar stand to top collar with 1/4 to 3/32 inch seam, distributing proper fullness on collar stand between center notch and each end. Open seam and stitch on each side of seam 1/16 inch from edge.</p>	301	SSz-3	12-16	50	50	
*	<p>b. Stitch undercollar to top collar, matching notches and distributing fullness. Do not catch interlining in the seaming.</p> <p>c. Turn collar; force out edge and baste collar edge with at least two rows of stitching, distributing the collar fullness evenly and rolling the join-seam to the underside. The first row shall be 1/8 to 1/4 inch from edge. Place an additional row of basting along breakline continuing to collar ends.</p>	301  Hand or machine	SSa-1  -	12-16  -	50  Commercial	50	

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NO.	MANUFACTURING OPERATIONS (cont'd)	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	ROBBIN/ LOOPER	COVER
50.	<p><u>Make top collar.</u> (cont'd)</p> <p>d. Check finished collar with finished undercollar shaper positioned as indicated in operation 49h.</p> <p>e. Trim bottom edge of top collar leaving a seam allowance for joining to overcoat.</p>	301	SSa-1	12-16	50	50	
51.	<p><u>Set collar and hanger.</u></p> <p>a. Seam top collar to gorge facing to a point not less than 1 inch back of lapel breakline.</p> <p>b. Open and tack gorge seam, catching the top edge of front interlining and end of bridle tape to collar seam.</p> <p>c. Mark seam allowance for undercollar setting with neck and gorge marker. Baste undercollar to neck, placing fullness across shoulder with center seam of undercollar centered between joining stitch and raise stitching of back.</p> <p>d. Tack neck outlet and lining across back to collar canvas with a blindstitch.</p> <p>e. Turn under bottom edge of top collar and baste bottom edge of top collar to neckline.</p> <p>f. Fell undercollar to overcoat by hand or machine. The raw edge of the undercollar shall be enclosed within the felling.</p>	<p>Hand or 301</p> <p>Hand or 301</p> <p>Hand or 301</p> <p>301 or 103 or Hand</p> <p>Hand or 301</p> <p>Hand or 306 or Machine (hand type felling)</p>	<p>SSa-1</p> <p>SSm-1</p>	<p>4-8 4-8 4-8</p> <p>6-8 6-8 6-8</p>	<p>50 50 30</p> <p>Commercial</p> <p>Commercial</p>	<p>50</p> <p>50 50 30</p> <p>Commercial</p> <p>C silk O silk A silk</p>	

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NO.	TABLE I, (CONT'D) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	BOBBIN/ LOOPER	COVER
51.	<u>Set collar and hanger.</u> (cont'd)						
	g. Tack corners of undercollar to lapel by hand.	Hand		8-10 per tack	C or A silk		
*	h. Position hanger at center back, + 1/2 inch with ends even with raw edge of back and neck facing. Hanger shall finish 2-1/2 + 1/2 inches in length between bartacks or stitchings, spaced 2 + 1/4 inches apart.						
	i. Stitch ends of hanger 1/4 + 1/8 inch from each end of hanger, through facing, back and with a horizontal bartack at each end or with three rows of horizontal stitching at each end.	Bartack or 301		21-28 per bartack 12-16	50 50	50 50	
	j. Fell bottom edge of top collar by hand.	Hand		8-10	C silk		
	k. If the collar is attached to the overcoat completely by hand, the facing gorge seam shall be marked, turned in, basted and neatly tacked to canvas.	Hand		6-8	C silk		
	l. Top collar shall be shaped, turned in, and basted with the turned-in edges of facing and top collar joined with neatly felled hidden seams.	Hand		8-10	C silk		
	m. In lieu of operations 51 d, e, and i, stitch lower edge of top collar across neck from gorge seam to gorge seam. Hanger need not be caught through undercollar, but shall be caught through back.	301	SSa-1	12-16	50	50	



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NO.	MANUFACTURING OPERATIONS (CONT'D) REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	ROBBIN/ LOOPER	COVER
52.	<p><u>Edge stitching.</u></p> <p>Finished appearance. The edge stitching shall be of uniform width without twisting, pleating or puckering.</p> <p>NOTE: Operations 52a and 52b shall be performed in sequence as specified and shall be performed prior to operation 60.</p> <p>a. Single stitch edges of collar, lapel, front and across bottom to back edge of facing <math>1/2 + 1/8</math> inch from edge. The stitching at lapel and collar notch shall be vertical across lapel to notch and concealed in the gorge seam from notch to required width.</p> <p>b. Press edges of collar, lapels and fronts on edge pressing machine.</p> <p><u>Sleeve tabs.</u></p> <p>Finished appearance. The sleeve tabs shall be uniform in appearance and shall lie flat and smooth without twisting, pleating, puckering or raw edges. The gage of stitching shall be uniform in width and the points well forced out. The buttonholes shall be the cut first type, correctly positioned. The stitching shall be caught in the fabric, and gimp pulled through to the underside and the purling on the top side.</p> <p>a. Stitch the two plies of sleeve tab together <math>1/4</math> to <math>3/32</math> inch from edge. The tab shall finish <math>2 + 1/16</math> inches wide.</p> <p>b. Trim as necessary, turn to outside, work out seam to edge, and edge stitch <math>1/2</math> inch from edge.</p>	301	SSae-2(b)	12-16	0 silk	0 silk	
53.		301	SSae-2(a)	10-16	50	50	
*		301	SSae-2(b)	12-16	0 silk	0 silk	

NO.	MANUFACTURING OPERATIONS (CONT'D)	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	ROBBIN/ LOOPER	COVER
53.	<p><u>Sleeve tabs.</u> (cont'd)</p> <p>c. Press tabs flat and smooth.</p> <p>d. Make one 5/8 to 3/4 inch cut first buttonhole in tab with the eyelet 5/8 to 3/4 inch from end as indicated by pattern (see 3.6.2).</p>	Buttonhole		50-52 per buttonhole	B silk	A silk	
54.	<p><u>Make sleeves.</u></p> <p>Finished appearance. The sleeves shall be uniform in appearance and width. The seams shall be pressed smooth and flat and shall be without puckers, gathers, pleats or raw edges. Blindstitches, tacking turnout of sleeves shall not catch the sleeve, only the wigan. The sleeve tabs shall be parallel with creased bottom edge of sleeve.</p> <p>a. Overlap top sleeve on undersleeve 1/2 inch in, as indicated on pattern, and with the notches matching, stitch backarm seam 5/16 inch from edge of top sleeve; turn seam toward top sleeve and raise stitch 1/2 inch from joining seam. The pattern provides a seam allowance of 5/16 inch for top sleeve and 5/16 inch plus 1/2 inch outlet for undersleeve.</p> <p>b. Tack sleeve wigan to backarm seam and at inseam, positioned with the bottom of wigan 1/2 to 3/4 inch below turnout notches.</p> <p>c. Press turnout of sleeve as indicated by notches on patterns and press backarm seam of sleeves.</p> <p>d. Position and stitch sleeve tabs on undersleeve as indicated by marks on patterns.</p>	301 or 401 and 301	LSs-2(a)  LSs-2(b)	12-16  12-16	30 30 0 silk	30 50 0 silk	
		301		8-12	50	50	
		301	SSa-1	12-16	50	50	

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NO.	TABLE I MANUFACTURING OPERATIONS REQUIREMENTS (cont'd)	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	ROBBIN/ LOOPER	COVER
54.	<u>Make sleeves.</u> (cont'd)						
*	e. Join in seam of sleeve with a 3/8 inch seam catching the sleeve tabs in the seam.	301 or 401	SSa-1	12-16	30 30	30 50	
	f. Press in seam of sleeve open, with the seam allowance of the sleeve tab pressed toward the undersleeve.						
	g. Blindstitch turnout of sleeves through the wigan. The blindstitching shall not be caught in sleeves except at in seams.	103 or Hand	SSm-1	4-8 1-2	50 30		
55.	<u>Make sleeve lining.</u>						
	Seam forearm and backarm of sleeve lining separately.	301 or 401	SSa-1	12-16	50 50	50 70	
56.	<u>Tack sleeve linings and turn sleeve.</u>						
	Finished appearance. The sleeve linings shall not be short, causing distortion to the sleeve. The fullness shall be properly distributed. Backarm seams and in seam of sleeves and sleeve linings shall coincide						
	a. Sleeve linings shall extend 3/4 to 1 inch above top of sleeve. Tack forearm seam of lining to forearm of sleeve. Tack back arm of lining to back arm of sleeve, putting fullness in sleeve lining. When tacking is done by hand, both ends of stitching shall be securely backstitched.	301 or Hand		4-8 1-2	50 30	50	
	b. The tacking shall start 6 + 1/2 inches down from top of sleeve and finish 6 + 1 1/2 inches up from finished bottom.						

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NO.	MANUFACTURING OPERATIONS (REQUIREMENTS)	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	BOBBIN/LOOPER	COVER
56.	Tack sleeve linings and turn sleeve. (cont'd)						
	c. Turn sleeve inside out and baste turnout of sleeve lining. Bottom of sleeve lining shall finish 3/4 to 1-1/4 inches from bottom of finished sleeve. Turn and pair sleeves.	Hand or 101					
57.	<u>Set sleeves.</u> Seam in sleeves, notch to notch with a 5/16 inch seam as indicated by pattern distributing fullness, catching the shoulder loop in the seam.	301 or 401	SSa-1	12-16	30 30	Commercial	
58.	<u>Press armhole fullness.</u> Finished appearance. The pressing of the armhole seam shall be done in such a manner as to avoid stretching of the armhole. a. Press fullness of sleeve flat all around armhole with a heated pressing iron on a suitable shaped pressing buck, shrinking fullness and holding armhole short. b. Press armhole seam open across top from the back arm seam to not less than 4-1/3 inches forward of shoulder seam, except that portion of shoulder loop seam allowance at armhole shall not be pressed back. Shoulder loop shall remain smooth and flat.						

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NO.	MANUFACTURING OPERATIONS (CONT'D) REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	HOBBS/ LOOPER	COVER
59.	<u>Baste and tack armhole.</u>						
	a. Baste balance of shoulder lining distributing proper fullness across shoulder.	Hand or 301			Commercial		
	b. Baste all around outside of armhole, placing back end of shoulder, shoulder pad and interlining in proper place or back part of armholes may be basted from the lining side.	Hand or 301			Commercial		
	c. Tack all around armhole through shoulder pad, interlining and lining.	Hand or 301		2-4	30 white or dyed		
	d. Trim away excess lining and interlining.			4-6	white or dyed		
60.	e. Tack sleeve head wadding to armhole from front notch to back seam of sleeve; securely tacking the sleeve head wadding through silesia catching interlining. (When armhole is tacked by machine, the sleeve head wadding shall be attached to the armhole tacking operation.)	Hand or Machine		2-4	30 white or dyed		
	<u>Mark position of buttonholes on fronts.</u>			4-6	30 white or dyed		
	a. Mark position of buttonholes, three on left front and one on right front (top buttonhole) as indicated by patterns and one on the lapel of each front 1-1/2 + 1/8 inches down and parallel with edge of lapel. Inside edge of eyelets shall be 7/8 to 1 inch from front edge.						
	b. Make front buttonholes as marked. The front and lapel buttonholes shall be cut 1-1/8 to 1-1/4 inches (see 3.6.2).	Buttonhole or Hand		70-80 per buttonhole not including tack	B silk	A silk	
					No. 10		

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NO.	MANUFACTURING OPERATIONS (CONT'D) REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	BOBBIN/LOOPER	COVER
60.	Mark position of buttonholes on fronts. (cont'd)						
	c. The purling of the front buttonholes shall finish on the front of overcoat and the purling of the lapel buttonholes shall finish on the face of the lapel.						
61.	Hand or machine felling.						
	a. Fell lining at armholes with the fullness distributed, or the sleeve lining may be stitched to armhole on the inside from backarm seam along arm-pit to center front of armhole and fell remainder of sleeve lining to armhole.	Machine type - Hand fell or Hand or 301 and Machine type Hand fell or 301 and Hand	SSa-1	6-10 6-10 12-16 6-10 12-16 6-10	A silk C silk 50 A silk 50 C silk	- - 50 - 50 -	
	b. Fell sleeve lining at bottom turn-up or the bottom of sleeve lining may be felled to the sleeve on the inside. The sleeve in either method may be felled without basting (see operation 56.c).	Hand or 301		8-10 6-8	C silk 0 silk	0 silk	
	c. Fell shoulders, if optional machine stitching (see operation 46.a) is not used.	Hand		8-10	C silk		
	d. Blindstitch along top of neck facing, catching lining in the stitching. The stitching shall be in line with an overlapping $1/2 + 1/8$ inch the stitching joining lining to facing (see operation 46.b).	Hand		8-10	C silk		
*	e. Tack bottom of yoke to side seam of overcoat.	Hand or 301		8-10 12-16	C silk 50	50	

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NO.	MANUFACTURING OPERATIONS (CONT'D) REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	BOBBIN/LOOPER	COVER
61.	Hand or machine felling. (cont'd) f. Fell bottom corners of body lining to bellows. g. Fell and tack back corners of facing and lower ends of bellows strip. h. Fell and tack bottom corners of vent the width of hem. Continue the felling $1/2 + 1/8$ inch beyond machine felling.	Hand Hand Hand		8-10 8-10 8-10	C silk C silk C silk		
62.	<u>Clean coat.</u> Pull basting threads. Trim all ends of stitching. Remove loose threads and shade tickets. Remove all spots and stains.						
63.	<u>Pressing operations: Machine press.</u> a. Place overcoat on hanger after each pressing operation until completion of pressing. b. Press edges and bottom (edge pressing machine). c. Press fronts (front machine). d. Press backarm and forearm seams of sleeves. e. Press back (back machine). f. Press collar with an Ulster-type collar machine.						

- or -

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NO.	TABLE I, (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	ROBBIN/ LOOPER	COVER
63.	<p>Pressing operations: Machine press. (cont'd)</p> <p>g. If a regular overcoat type collar machine is used, the pressing shall be performed in the following manner:</p> <p>(1) Press right and left gorge short to crease of collar for a distance of 4 to 6 inches from shoulder seam.</p> <p>(2) Break right and left collar and lapel comparing widths, checking to make sure they are alike.</p> <p>(3) Press collar on breakline, from shoulder seam to shoulder seam, straight without stretching, with the pressing extending 1 to 1-1/2 inches from the breakline.</p> <p>(4) Press remainder of collar leaf flat and smooth stretching the leaf edge where necessary, thus obtaining a concave or an Ulster-type collar.</p> <p>(5) Remove crease line from a point 3 + 1 inches below the gorge seam to obtain a soft roll. This operation shall also be performed if an Ulster-type collar machine is used.</p> <p>(6) Straighten edges of lapels and collar.</p> <p>(7) Under no conditions, shall the collar be pressed round and flat.</p> <p>h. Press armholes, shoulder loops, and shoulders (armhole machine).</p>						



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NO.	MANUFACTURING OPERATIONS (CONT'D) REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/LOOPER	COVER
63.	<p><u>Pressing operations: Machine press. (cont'd)</u></p> <p>i. Press backarm seam short midway between elbow and armhole.</p> <p>j. Crease front, armpit and back part of armhole solid on the inside edge of armhole.</p> <p>k. Block sleeve head and armhole at top.</p> <p>l. Press lapels.</p>						
64.	<p><u>Set slide fastener on overcoat.</u></p> <p>NOTE: Pressing operations: Machine press (see operation 63) shall precede the setting of slide fastener operation 64. Finish pressing operation (see operation 65) shall follow the setting of the slide fastener. The sequence of operations in this case, shall not be changed.</p> <p>a. Position the slide fastener on the overcoat facings so that the ends of the fastener are equidistant from bottom edge of the liner and the overcoat. The separating pin of the slide fastener shall be on the right facing.</p> <p>b. Position the slide fastener on the underside of coat facings with the front edge of the chain 3/8 to 1/2 inch from the bound edge.</p> <p>c. Turn in the end of tape 1/2 to 3/4 inch and stitch the length of tape 1/8 to 3/16 inch from the back edge of chain.</p>	301	SSa-1	10-14	50	50	

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS <u>TABLE 1 (cont'd)</u>	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	BOBBIN/LOOPER	COVER
64.	Set slide fastener on overcoat. (cont'd)  d. Place a second row of stitching, the length of the tape 1/16 to 1/8 inch from the back edge of the tape.  e. Operations 65c and d may be performed simultaneously.  <u>Finish press.</u>  a. Press lining smooth with hand pressing iron. Press pleats in lining.  b. Remove gloss, wrinkles and impressions from under lapels, collar and shoulder loops, sleeve tabs and pockets.  c. When sleeves are creased in pressing operations, finish press to remove the creases of sleeve.  d. Touch up any spots missed by the machine pressing.  <u>Mark for buttons.</u>  a. Mark the location of the three 45-line buttons on each front. The buttons on each front shall be 6 ± 1/8 inches from each edge. The buttons shall be horizontally aligned.  b. Mark location of the 30-line button at top of right front to provide a proper and smooth closure of the collar when the convertible feature is used. Collar, when buttoned, shall not open more than 1 inch nor shall there be any overlap.	301	SSa-1	10-14	50	50	
65.							
66.							

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS (cont'd)	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
66.	<p><u>Mark for buttons.</u> (cont'd)</p> <p>c. Mark location of 24-line buttons for shoulder loops. The point of loop when buttoned shall not overlap the undercollar edge, nor be more than 1/4 inch from edge of undercollar.</p> <p>d. Mark location of one 24-line button on each top sleeve to correspond to buttonhole in sleeve tab.</p>						
67.	<p><u>Sew on buttons.</u></p> <p>a. Sew the 45-line and 30-line buttons on right front as indicated by marks on pattern and the 24-line buttons on each shoulder and on each sleeve as indicated by marks on pattern. The three lower front buttons shall be sewn through stay buttons except when the automatic machine is used, the stay buttons are not required. The bottom front button shall be sewn through interlining and one side of pocket.</p> <p>b. Sew the 45-line buttons on left front as indicated by marks on pattern. The top button shall be sewn through front and a 45-line anchor button on inside of coat.</p>	<p>Hand or</p> <p>301 or</p> <p>101 or</p> <p>801 (see figure 5)</p> <p>Hand or</p> <p>301 or</p> <p>101</p>		<p>4 per button double thread</p> <p>14-16 per button</p> <p>20-22 per button</p> <p>7 (min)</p> <p>1 deep set per button</p> <p>4 per button double thread</p> <p>14-16 button</p> <p>20-22 per button</p>	<p>12</p> <p>16</p> <p>20</p> <p>20</p> <p>5 nylon</p> <p>12</p> <p>16</p> <p>20</p>		

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NO.	TABLE I. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	ROBIN/ LOOPER	COVER
67.	<u>Sew on buttons.</u> (cont'd)  NOTE: All buttons, except the left front buttons shall be tightly wrapped to form a 1/4 inch shank with the ends of the thread tacked off. The anchor button shall also have a 1/4 inch shank. When the automatic machine is used, the shanking shall have a minimum of ten wraps with three locking stitches.						
68.	<u>Sew on size tickets.</u>  Tack the four corners of size ticket at bottom underside of right sleeve.	Hand or Machine			30		
69.	<u>Join seams of liner.</u>  Wool liner  Finished appearance. The side seams and center back seam shall be joined without puckers, gathers, pleats or raw edges. The stitching shall be uniform in width.  a. Join side seams and center back seam of liner, (when two piece construction is used) with a double-lapped, double-stitched seam 1/4 to 5/16 inch gage.  b. Position identification label, 1 to 1-1/4 inches from neck at center (+ 1/2 inch) back facing overcoat in finished liner and stitch on all four sides.  c. Join shoulder seams and press seams open.	301 or 401  301  301 or 401	LSc-2   SSa-1	12-16  6-8  12-16	30 30  30 30  30 30	30 50  30 or 50  30 50	

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					NEEDLE	BOBBIN/ LOOPER	COVER
70.	Join seams of rayon yoke lining.						
*	<p>a. Join side, center back (when two piece construction is used) and shoulder seams of rayon yoke separately with a 5/16 to 3/8 inch seam, with the ends of stitching tacked.</p> <p>b. Center size label over center back seam with the top of the label not more than 1-1/2 inches from neck edge of lining and stitch on all four sides. The stitching shall not be through the printing. The top of the label may be caught in the binding stitching (operation 72a).</p> <p>NOTE: In lieu of joining shoulder seams of liner (see operation 69c) and joining shoulder seams of liner lining (see operation 70), the raw edges of shoulders may be bound and then joined (see operations 72c and 72e).</p> <p><u>Attach lining.</u></p> <p>a. Position the rayon lining and wool liner face to face with the upper part of lining towards the bottom of liner and the bottom of rayon lining even with notches, as indicated on pattern, and seam across bottom 1/4 to 3/32 inch.</p> <p>b. Turn rayon lining toward the top of wool liner (notch to notch) and stitch and trim all around raw edges of rayon lining with corresponding edges of wool liner forming bellows pleat at bottom of lining.</p>	301	SSa-1	12-16	50	50	
		301	LSbj-1	10-16	50	50	
71.							
*		301		12-16	50	50	
		301		12-16	50	50	

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS (CONT'D)	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
72.	<u>Bind edges.</u>  Finished appearance. The bindings shall be uniformly stitched with no raw edges showing. The fabric shall be caught in the stitching.						
*	a. Bind edges of vent, bottom, fronts and neck of liner in one operation, catching the top of size label under the binding when applicable. When the back is of two piece construction, the binding shall start and finish at top of vent. When the back is of one piece construction, the binding shall start and finish other than at the top of vent and the end shall be turned in and caught in the stitching. The ends of the binding shall overlap not less than 1/2 inch with the end of the binding turned over on itself and securely stitched or bartacked.	301 or 401 or Bartack	BSc-1	12-16  21-28 per bartack	50 50 50	50 70 50	
*	b. Bind all around armholes, overlapping the ends not less than 1/2 inch with the end of the binding turned over on itself and securely stitched or bartacked.	301 or 401 or Bartack	BSc-1	12-16  21-28 per bartack	50 50 50	50 70 50	
	c. When shoulder seams are bound, bind vent, bottoms, fronts, neck of liner, armholes and shoulders in one operation.	301 or 401	BSc-1	12-16	50 50	50 70	
	d. Bind the edge of the slash openings, beginning at top and finishing at top of openings.	301 or 401	BSc-1	12-16	50 50	50 70	
	e. When shoulder seams are bound, join shoulder seams of liner with bound seam allowances towards coat and press seams open.	301	SSa-1	12-16	50	50	

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NO.	TABLE I. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	JOBBIN/ LOOPER	COVER
73.	<p><u>Set slide fastener on liner.</u></p> <p>a. Position the slide fastener on the underside of liner with the back edge of the chain immediately adjacent to the bound edge of liner.</p> <p>b. Turn in the raw end of the tape 1/2 to 3/4 inch, and double stitch the length of tape with one row of stitching superimposed on the binding stitch and the second row 1/16 to 1/8 inch from the back edge of tape.</p>	301	LSa-2	10-14	50	50	
74.	<p><u>Clean liners.</u></p> <p>Trim all threads and remove thread ends, all spots, stains and shade tickets.</p>						
75.	<p><u>Press liners.</u></p> <p>a. Press liners.</p> <p>b. Finish press rayon linings smooth with a heated pressing iron.</p>						
76.	<p><u>Attach liner to overcoat.</u></p> <p>a. Attach wool liner to overcoat by means of the slide fastener, checking the finished operation to insure free and easy manipulation of the slider. There shall be no bulging or distortion of the overcoat or the liner when fastener is engaged. The liner shall match the overcoat in size.</p>						

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NO.	MANUFACTURING OPERATIONS (cont'd) REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
76.	<u>Attach liner to overcoat.</u> (cont'd)						
	b. When the liner is removed from the overcoat, the slider shall remain on the liner portion of the fastener.						
77.	<u>Clean overcoat and attach belt.</u> Brush overcoat, examine, attach belt and fold.						



3.11 Finished measurements. The finished dimensions for the overcoat shall conform to table II and the liner, table III.

TABLE II. Overcoat finished measurements (in inches)

Sizes	30	32	34	36	38	40	42	44	46	48	Tolerance
1/2 Breast <u>1/</u>	18	19	20	21	22	23	24	25	26	27	$\pm \frac{1}{2}$
Back length <u>2/</u> - X-Short		39-1/4	39-1/2	39-3/4	40	40-1/4	40-1/2				$\pm \frac{3}{4}$
- Short	41	41-1/4	41-1/2	41-3/4	42	42-1/4	42-1/2	42-3/4	43		$\pm \frac{3}{4}$
- Regular	43-1/4	43-1/2	43-3/4	44	44-1/4	44-1/2	44-3/4	45	45-1/4	45-1/2	$\pm \frac{3}{4}$
- Long		45-3/4	46	46-1/4	46-1/2	46-3/4	47	47-1/4	47-1/2	47-3/4	$\pm \frac{3}{4}$
- X-Long			48	48-1/4	48-1/2	48-3/4	49	49-1/4	49-1/2	49-3/4	$\pm \frac{3}{4}$
Sleeve length <u>3/</u> - X-Short		15-1/2	15-1/2	15-1/2	15-1/2	15-1/2	15-1/2				$\pm \frac{1}{2}$
- Short	16-1/2	16-1/2	16-1/2	16-1/2	16-1/2	16-1/2	16-1/2	16-1/2	16-1/2		$\pm \frac{1}{2}$
- Regular	17-1/2	17-1/2	17-1/2	17-1/2	17-1/2	17-1/2	17-1/2	17-1/2	17-1/2	17-1/2	$\pm \frac{1}{2}$
- Long		18-1/2	18-1/2	18-1/2	18-1/2	18-1/2	18-1/2	18-1/2	18-1/2	18-1/2	$\pm \frac{1}{2}$
- X-Long			19-1/2	19-1/2	19-1/2	19-1/2	19-1/2	19-1/2	19-1/2	19-1/2	$\pm \frac{1}{2}$
Belt length <u>4/</u>	39	41	43	45	47	49	51	53	55	57	$\pm \frac{1}{2}$

1/ Half breast - With overcoat buttoned and liner removed, measure from folded edge to folded edge in line with the top button.

2/ Back length - Measure from undercollar felled-seam down center back to bottom of overcoat.

3/ Sleeve length - Measure underarm seam from armhole seam to bottom of sleeve.

4/ Belt length - Measure from end of belt to fold on bar of buckle.

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TABLE III. Liner measurements (in inches)

Sizes	30	32	34	36	38	40	42	44	46	48	Tolerance
1/2 Breast 1/	15	15-3/4	16-1/2	17-1/2	18	18-3/4	19-1/2	20-1/4	21	21-3/4	+ 3/4 _

1/ Half Breast - Measure from front bound edge to center of back in line with base of armhole.

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- \* 3.12 Workmanship. The finished overcoats shall conform to the quality and grade of product established by this document. As a final step in the contractor's production control plan before formation of the lot, each overcoat shall be buttoned on a model form and examined. An overcoat containing a selected defect shall not be included in the end item lot. The selected defects are those defects listed in MIL-STD-1391 indicated by an asterisk (\*). The occurrence of defects shall not exceed the applicable acceptable point value or defect limit.

## 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 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 document where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.1.1 Responsibility for compliance. All items must meet all requirements of sections 3 and 5. The inspection set forth in this document shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the document shall not relieve the contractor of the responsibility of assuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling in quality conformance does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to acceptance of defective material.

4.1.2 Responsibility for dimensional requirements. Unless otherwise specified in the contract or purchase order, the contractor is responsible for assuring that all specified dimensions have been met. When dimensions cannot be examined on the end item, inspection shall be made at any point, or at all points in the manufacturing process necessary to assure compliance with all dimensional requirements.

4.1.3 Certificate of compliance. When a certificate of compliance is submitted, the Government reserves the right to inspect such items to determine the validity of the certification.

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

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

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- \* 4.3 First article inspection. When a first article is required (see 6.2), it shall be examined for visual and dimensional defects in accordance with the provisions of MIL-STD-1391. The presence of any defect shall be cause for rejection of the first article.
- \* 4.4 Quality conformance inspection. Unless otherwise specified, sampling for inspection shall be performed in accordance with MIL-STD-105.
- \* 4.4.1 Component and material inspection. In accordance with 4.1 above, components and materials shall be inspected in accordance with all the requirements of referenced documents unless otherwise excluded, amended, modified or qualified in this document or applicable purchase document.
- \* 4.4.1.1 Testing of cloth, cotton sheeting. In addition to testing provisions contained in subsidiary documents, testing shall be performed on the component listed in table IV for characteristics noted. The method of testing specified in FED-STD-191, wherever applicable and as listed in table IV shall be followed. All requirements are applicable to the sample unit. Unless otherwise specified in subsidiary documents, sampling shall be in accordance with the following:

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

The lot shall be unacceptable if one or more sample units fail to meet any test requirement specified. All test reports shall contain the individual values utilized in expressing the final result. The sample unit for testing the cotton sheeting cloth shall be one yard full width. The lot size shall be expressed in yards.

TABLE IV. Test methods

<u>Characteristic</u>	<u>Requirement paragraph</u>	<u>Test method</u>
Material identification	3.3.8	1200 <u>1/</u>
Weight	3.3.8	5041
Yarns per inch	3.3.8	5050
Breaking strength	3.3.8	5100
Colorfastness to wet-dry cleaning	3.3.8	5622
Sulfur dyes	3.3.8	2020

1/ Accept on contractor's certificate of compliance.

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- \* 4.4.1.2 Certification. The contractor shall furnish a certificate of compliance for Government approval for the material identification requirement specified in 3.3.8.
- \* 4.4.2 In-process inspection. Inspection of sub-assemblies shall be made to ascertain that construction details which cannot be examined in the finished product are in accordance with specified requirements. The Government reserves the right to exclude from consideration for acceptance, any material or service for which in-process inspection has indicated nonconformance.
- \* 4.4.3 End item examination. Sampling and examination for the end item and packaging shall be performed in accordance with MIL-STD-1391. The end item shall conform to the dimensions specified in tables II and III.
- \* 4.4.4 Palletization examination. The fully packaged and palletized end items shall be examined for the defects listed below. The lot size shall be expressed in units of palletized unit loads. The sample unit shall be one palletized unit load, fully packaged. The inspection level shall be S-1, and the AQL, expressed in terms of defects per hundred units, shall be 6.5.

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

## 5. PACKAGING

- \* 5.1 Preservation. Preservation shall be level A or Commercial as specified (see 6.2).
- \* 5.1.1 Level A. Each overcoat with liner attached shall be laid flat back down and a paperboard insert conforming to figure 4 placed inside the overcoat fitting into the collar and shoulder area. The overcoat shall be buttoned and belted, 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 folded overcoat shall measure not more than 25 by 18 inches.

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- \* 5.1.2 Commercial. Overcoats shall be preserved in accordance with ASTM D 3951.
- \* 5.2 Packing. Packing shall be level A, B or Commercial as specified (see 6.2).
  - \* 5.2.1 Level A packing. Six overcoats of one size only, preserved as specified in 5.1, shall be packed flat in a fiberboard shipping container conforming to style RSC-L, grade V2s of PPP-B-636. The inside of each container shall be fitted with a box liner conforming to type CF, class weather-resistant, variety DW, grade V15c or PPP-B-636. Level A unit packs shall be packed flat, alternated top to bottom, six in depth within a shipping container. Inside dimensions of each container shall approximate 25-1/2 inches in length, 18-1/2 inches in width and 10 inches in depth. Approximate dimensions are furnished as a guide only. Each container shall have the contents completely covered on the top and bottom with a sheet of 30-pound minimum basis weight kraft paper conforming to A-A-203. 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, except that the inspection shall be in accordance with MIL-STD-1391. Shipping containers shall be arranged in unit loads in accordance with MIL-L-35078 for the type and class of load specified (see 6.2). Strapping shall be limited to nonmetallic strapping except for type II, class F loads.
  - \* 5.2.2 Level B packing. Six overcoats of one size only, preserved as specified in 5.1, shall be packed flat in a fiberboard shipping container conforming to style RSC-L, type CF (variety SW), or SF, class domestic, grade 275 of PPP-B-636. The inside of each container shall be fitted with a box liner conforming to type CF, class domestic, variety DW, minimum grade 275 of PPP-B-636. Level A unit packs shall be packed flat, alternated top to bottom, six in depth within a shipping container. Inside dimensions of each container shall approximate 25-1/2 inches in length, 18-1/2 inches in width and 10 inches in depth. Approximate dimensions are furnished as a guide only. Each shipping container shall have the contents completely covered on the top and bottom with a sheet of 30-pound minimum basis weight kraft paper conforming to A-A-203. Each shipping container shall be closed in accordance with method II as specified in the appendix of PPP-B-636, except that the inspection shall be in accordance with MIL-STD-1391.
    - \* 5.2.2.1 Weather-resistant fiberboard containers. 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 PPP-B-636, except that the inspection shall be in accordance with 5.3 of MIL-STD-1391.
  - 5.2.3 Commercial packing. Overcoats, preserved as specified in 5.1, shall be packed in accordance with ASTM D 3951.

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- \* 5.3 Palletization. When specified (see 6.2), overcoats packed as specified in 5.2.2 and 5.2.3 shall be palletized on a 4-way entry pallet in accordance with load type Ia of MIL-STD-147. Pallet types shall be type I (4-way entry), type IV or type V in accordance with MIL-STD-147. Pallets shall be fabricated from wood groups I, II, III, or IV of MIL-STD-731. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding means K and L or film bonding means O or P. Pallet pattern shall be number 90 in accordance with appendix of MIL-STD-147. Interlocking of loads shall be effected by reversing the pattern of each course.
- \* 5.4 Marking. In addition to any special marking required by the contract or purchase order, unit packs (bundles), shipping containers and palletized unit loads shall be marked in accordance with MIL-STD-129 or ASTM-D-3951, as applicable.

## 6. NOTES

6.1 Intended use. The overcoat is intended for wear as a service overcoat by male military personnel of the Department of the Army.

- \* 6.2 Ordering data. Acquisition documents should specify the following:
  - a. Title, number and date of this document.
  - b. When first article is required (see 3.1, 4.3 and 6.4).
  - c. Size required (see 1.2).
  - d. Selection of applicable levels of preservation and packing (see 5.1 and 5.2).
  - e. When weather-resistant grade fiberboard shipping containers are required for level B shipments (see 5.2.2.1).
  - \* f. When palletization is required (see 5.4).
  - \* g. Type and class of unit load required (see 5.2.1).
- \* 6.3 Samples. For access to samples address the contracting activity issuing the invitation for bids.
- \* 6.4 First article. When a first article is required, it shall be inspected and approved under the appropriate provisions of FAR 52.209. The first article should be a preproduction sample. The contracting officer should specify the appropriate type of first article and the number of units to be furnished. The contracting officer should include specific instructions in all acquisition instruments regarding arrangements for selection, inspection, and approval of the first article.
- \* 6.5 Recycled material. It is encouraged that recycled material be used when practical as long as it meets the requirements of this document (see 3.3).

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\* 6.6 Subject term (key word) listing.

Coats  
Overcoat, man's  
Uniforms

- \* 6.7 Changes from previous issue. The margins of this document 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 contractors are cautioned to evaluate the requirements of this document based on the entire content, irrespective of the marginal notations and relationship to the previous issue.

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\* DLA - CT

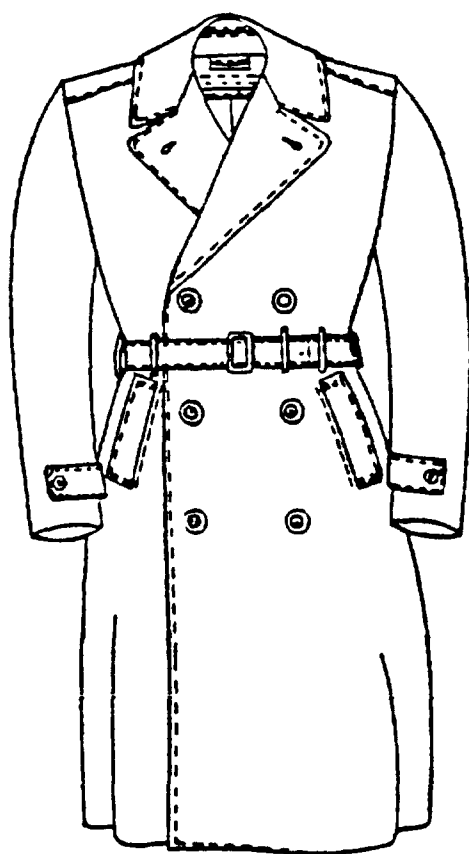
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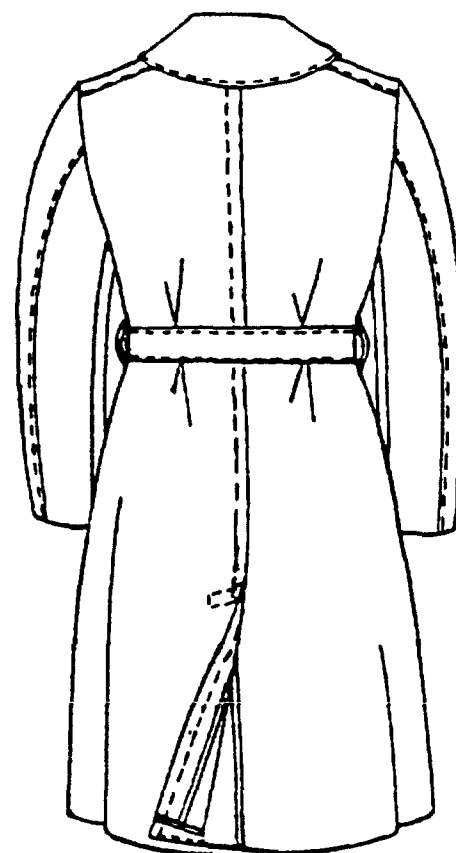
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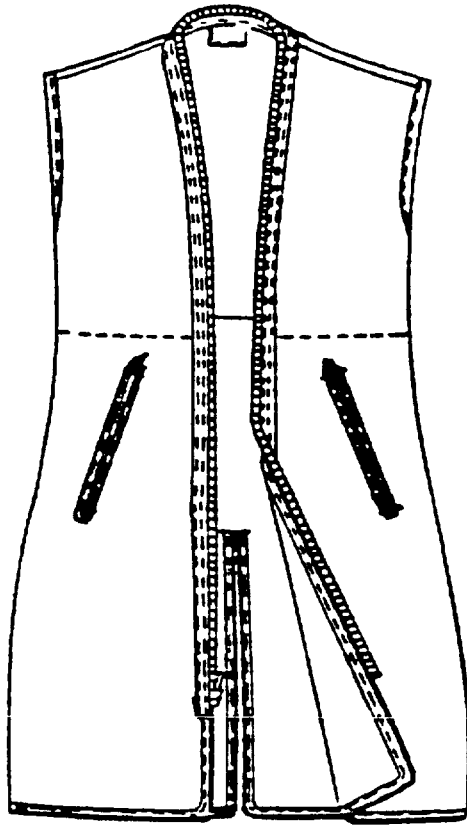
*FRONT*



*BACK*

*FIGURE 1, OVERCOATS, MEN'S, WITH REMOVABLE LINER*

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*FRONT*

*FIGURE 2 OVERCOATS, MEN'S, WITH REMOVABLE LINER;  
LINER*

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To keep your overcoat looking smart insist on it being properly pressed.

PRESSING INSTRUCTION

Dry clean only

Avoid pressing dry or with too hot an iron

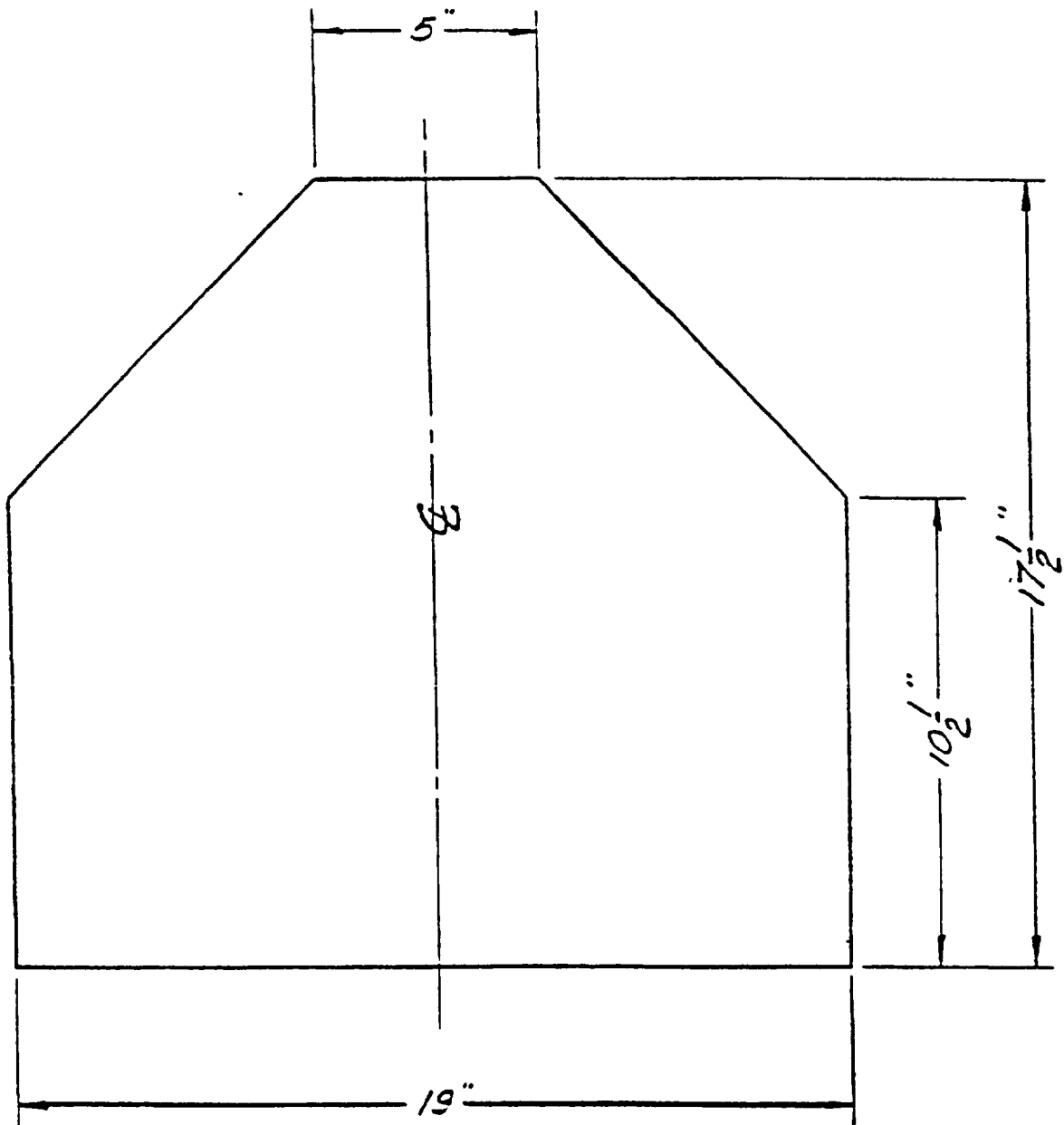
Remove all gloss from edges and seams by pressing with a soft, damp cloth.

Do not crease sleeves

Soft roll lapels to within 3 inches of gorge seam.

*FIGURE 3 OVERCOATS, MEN'S, WITH REMOVABLE LINER  
CLOTH INSTRUCTION LABEL*

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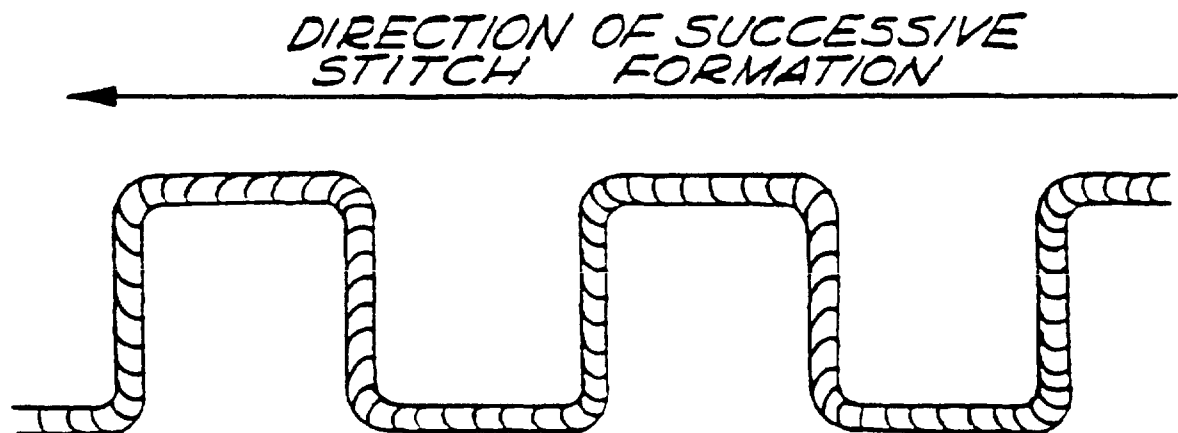


NON-BENDING PAPERBOARD 0.048" THICK

FIGURE-4-INSERT, PAPERBOARD

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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 5 - STITCH TYPE 801*

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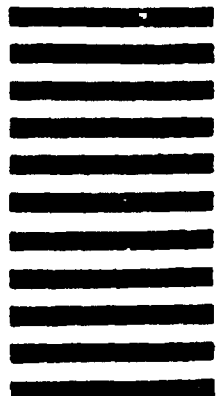
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## STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

1. DOCUMENT NUMBER MIL-O-43537C(GL)		2. DOCUMENT TITLE OVERCOAT, MAN'S, ARMY GREEN 44, WITH REMOVABLE LINER	
3a. NAME OF SUBMITTING ORGANIZATION		4. TYPE OF ORGANIZATION (Mark one)	
		<input type="checkbox"/> VENDOR <input type="checkbox"/> USER <input type="checkbox"/> MANUFACTURER <input type="checkbox"/> OTHER (Specify) _____	
b. ADDRESS (Street, City, State, ZIP Code)			
5. PROBLEM AREAS			
a. Paragraph Number and Wording			
b. Recommended Wording			
c. Reason/Rationale for Recommendation.			
6. REMARKS			
7a. NAME OF SUBMITTER (Last, First, MI) - Optional		b. WORK TELEPHONE NUMBER (Include Area Code) - Optional	
c. MAILING ADDRESS (Street, City, State, ZIP Code) - Optional		8. DATE OF SUBMISSION (YYMMDD)	