

MIL-P-38184C
29 January 1975
 SUPERCEDING
 MIL-P-38184B(USAF)
 12 Jun 1970

MILITARY SPECIFICATION

PARKA, EXTREME COLD WEATHER CWU-8/P

This specification is mandatory for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 This specification covers one type of cold weather parka designated type CWU-8/P and furnished in the following sizes, as specified (see 6.2)

<u>Size</u>	<u>Equivalent Size</u>
Small	34-36
Medium	38-40
Large	42-44
Extra Large	46-48

2. APPLICABLE DOCUMENTS

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

SPECIFICATIONS

Federal

V-B-871	Button, Sewing hole, And Button Staple (Plastic)
V-F-106	Fasteners, Slide, Interlocking
V-T-276	Thread, Cotton
V-T-295	Thread, Nylon
KK-L-169	Leather, Horsehide, Chrome Tanned, For Gloves, Garments And Equipage
KK-L-271	Leather, Cattlehide, Strap, Vegetable Tanned
UU-P-268	Paper, Kraft, Untreated, Wrapping
CCC-C-440	Cloth, Cheesecloth, Cotton, Bleached And Unbleached
DDD-L-20	Label, For Clothing, Equipage, And Tentage, (General Use)

Military

MIL-B-371	Braid, Textile, Tubular
MIL-W-530	Webbing, Textile, Cotton, General Purpose, Natural Or In Colors
MIL-C-3735	Cuffs, Knit, Wrist And Ankle, And Cloth, Knitted
MIL-F-10884	Fasteners, Snap
MIL-C-17155	Cloth, Knitted, Nylon Fleece

FSC 8415

MIL-STD

MIL-B-17757	Boxes, Fiberboard, Corrugated (Modular Sizes)
MIL-C-18387	Cloth, Drill, Cotton, Fire Retardant Treated
MIL-F-21840	Fastener Tapes, Hook And File, Synthetic
MIL-C-83008	Cloth, Coated, Cotton And Nylon, Polyurethane (Microporous) Coated

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	Packing For Shipment And Storage

DRAWING

Air Force

63B4171	Parka-Man's CWU-8/P, Assembly Of
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(Copies of specifications, standards, drawings, and publications required by suppliers in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer)

3. REQUIREMENTS

3.1 Materials

- * 3.1.1 Outer shell. The basic fabric for the outer shell, the pocket flaps and the cover fly shall conform to type 1 of MIL-C-83008. The color shall be sage green USAF color shade No. 1509. (See 6.3)
- * 3.1.2 Interlining (insulation). The interlining material shall be a batting comprised of polypropylene quilted between cotton cheesecloth. The polypropylene filling shall be high crimped 6-denier fibers 2 inches (plus or minus 1/8 inch) in length. The fibers shall be processed by the "Curlator" method. The cheesecloth shall conform to type 1, class 2 of CCC-C-440. The three layers of the interlining shall be connected by quilting made with stitch type 301 of FED-STD-751, using 10 stitches (plus or minus 2 stitches) per inch. The quilting pattern shall conform to the design and dimensions shown on Figure 2. The number of quilting stitches per inch shall be counted as follows: Place a ruler from any stitch (point A) measuring down vertical 1 inch to point B). Mark this point and run another measure at a 90-degree angle back to the row of stitching being counted (point C). The number of stitches from point A to C will determine quilting stitches per inch. The fibers in the assembled batt shall be 1/4 inch (plus or minus 1/32 inch) thick before quilting and 1/4 inch (plus or minus 1/32 inch) thick after quilting. The fibers shall be evenly distributed between the two layers of

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cheesecloth to obtain the required finished thickness the full length and width of the batt. The finished, unbonded batt shall weigh not less than 5 nor more than 6 25 ounces per running yard for 38-1/2-inch (plus or minus 1/2-inch) width batt. In order to facilitate processing, the polypropylene fibers may be bonded with an approved bonding agent (see 6.5) uniformly applied. The maximum concentration of the applied bonding agent shall be in addition to the weight specified for the unbonded batt but shall not increase the weight of the unbonded batt by more than 10 percent

- * 3.1.2.1 Thickness. The thickness and recovery of thickness of the batt shall be determined as stated in 4.4.2.
- * 3.1.3 Lining. The fabric for the lining, the pocket lining and the interlining for the outer protective fly shall conform to MIL-C-18387 except fire retardant treatment shall not apply. The color of the lining shall approximate the color of the outer shell.

3.1.4 Pocketing. The fabric for the pockets shall be the same as the fabric used for the lining.

3.1.5 Thread. Except for quilting and sewing on buttons, the thread used for the fabrication of the parka shall conform to type IC2, 3 ply, ticket No. B of V-T-276. The color of the thread shall be sage green approximately matching the color of the outer-shell fabric. The thread shall be vat dyed and shall have good colorfastness to laundry, bleaching, and light

3.1.5.1 Quilting. The thread used for quilting shall conform to type X, class 2, size 00 of V-T-295. The color of the quilting thread shall be white or natural.

3.1.5.2 Sewing on buttons. The thread used for sewing on buttons shall conform to type IA2, 4 ply, ticket No. 20 of V-T-276. The color of the thread used for sewing on buttons shall be sage green approximately matching the color of the outer-shell fabric.

- * 3.1.6 Hood trimming. The hood trimmings, side flaps, forehead flap and hood facing strap shall conform to type I of MIL-C-17155. The color shall be sage green, USAF, shade 1511. (See 6.3)
- * 3.1.7 Two-part fastener tape. The two-part tape used to secure the hood closure shall conform to type I, class I of MIL-F-21840. The hook and pile tape shall be 3/4 inch wide and shall approximate the color of the basic fabric.
- 3.1.8 Snap fasteners. The snap fasteners shall conform to style 2, finish 2 of MIL-F-10884. The color of the exposed portion of the fastener shall match the shade of the outer-shell fabric.
- * 3.1.9 Wristlets. The cloth for the wristlets shall conform to type III, class II, size 2 of MIL-C-3735. The color shall approximate the color of the outer shell.
- * 3.1.10 Buttons. The buttons for the outer protection flap shall conform to type II, class D of V-B-871. The front buttons shall be style 20 or 21, 45-line size. The stay buttons shall be style 15, 18-line size. The color of the buttons shall approximate the color of the outer-shell fabric.

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- * 3.1.11 Braid. The braid for the loops on the parka front closure shall conform to type II, class 2, of MIL-B-371. The braid shall be dyed to match the color of the outer-shell material.
- 3.1.12 Slide fastener. The slide fastener shall conform to type IV, style 8, size MHS of V-F-106. The chain shall be brass or zinc alloy with a short pull tab furnished with a 3/8-inch webbing conforming to type I, class 3 of MIL-W-530. The tape shall be cotton or cotton warp and nylon filling and shall be 3/4 inch (plus or minus 1/32 inch) wide. The finish of the metal parts shall be natural crank finish or equal if zinc alloy and black chemical finish if brass. The chain portion of the slide fastener shall be of sufficient length to extend from the lower notch on the parka front up and to within 1/4 inch (plus or minus 1/8 inch) from the top of the protective flap.
- 3.1.12.1 Color of tape. The color of the slide-fastener tape shall approximately match the color of the approved shade of the basic fabric and shall show fair colorfastness to laundering, bleaching, light, wet or dry cleaning, and weathering.
- 3.1.13 Leather reinforcement for pocket. The leather reinforcement for the pocket shall be made of leather conforming to type I, class 2, selection C of KK-L-169 or selection B or C, type I, class 1 or 2, 2/64 to 4/64 inch thick of KK-L-271. The color of the leather shall be black.
- 3.2 Design. The parka shall be single breasted, shall have a cotton coated outer shell interlined with a insulated batt fabric, and shall be lined with a cotton cloth. The parka shall include a slide-fastener front closure with a protective flap beneath and over the slide fastener, running the full course of the slide fastener. The parka shall be equipped with a hood fabricated from two layers of the outershell fabric and insulated with the same insulation used for the parka. The hood shall have attached swiveling side flaps for face protection and overlapping tabs for the neck closure. The parka shall have two welt type slash pockets constructed of outer-shell material and lined with the parka lining material and two lower welt type inside hanging pockets constructed from the parka lining material. The slash and the inside hanging pockets shall have flaps and snap-fastener closures. The parka shall have a two-piece raglan type sleeve insulated in the same manner as the parka and inside knitted wristlets.
- * 3.3 Construction. The parka shall be constructed in accordance with Table I, but the manufacturer is not required to follow the exact sequence of operations as listed therein.
- 3.3.1 Stitches, seams, and stitchings. Stitches, seams, and stitchings used in the construction of the parka shall conform to FLD-CLL-751. Whenever two or more methods, seams, or stitches are specified for the same operation, any one of them may be used. Where stitch type 401 is used, the looper (under-thread) shall be on the inside of the garment.
- 3.3.1.1 Stitches per inch. Unless otherwise specified, a tolerance of plus 2 or minus 1 stitch per inch shall be permitted.
- 3.3.1.2 Ends of seams and thread breaks. Ends of all seams and stitchings, when not caught in other seams or stitching, shall be backstitched not less than 1/4 inch. Thread breaks (all stitch types) shall be secured by stitching back of the breaks not less than 1/2 inch. Skipped stitches or thread breaks (stitch type 401) may be repaired using stitch type 301.

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TABLE I - SEWING OPERATIONS

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
1	<p>CUTTING. The jacket shall be cut in accordance with patterns that show size, shape, placement of pockets, and notches for proper assembling of all parts</p> <p>a. Except for the inside pocket facings, inside of outer fly, the flap linings, the hanger and the pocketing, which may be cut from ends, all component parts of the outer shell and the linings shall be cut from one piece of material.</p> <p>b. Patterns shall be laid in accordance with directional lines indicated on the patterns in the direction of the warp for each component part of the parka. The interlining may be cut in either the warp or the filling direction. However, all parts of the interlining in each completed shell shall be cut in the same direction.</p> <p>c. The uncoated side of the outer-shell material shall be to the outside, the coated side shall be to the inside, toward the interlining (insulation).</p>			
2.	<p>SHADE MARKING. Except for those parts cut from ends as indicated in No. 1a and the interlining (insulation), all component parts shall be marked or ticketed to insure a uniform shade and proper assembly throughout the garment. Metal-fastening devices or sewn-on tickets shall not be used on the coated material.</p>			
3.	<p>POCKET FLAPS. The finished flaps shall measure 8 inches (plus or minus 1/4 inch) in length by 3-1/8 inches (plus or minus 1/8 inch) in width. The flaps shall have a button snap and socket located at the center and 3/4 inch from the edge.</p>			

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TABLE I - SEWING OPERATIONS (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
4	a. Sew the flap to the flap lining, with a 1/4-inch to 3/8-inch seam.	301	SSe-2(a)	10-12
	b. Turn the flaps and raise with a single row of stitching 3/16 inch to 1/4 inch from the edge.	301	SSe-2(b)	10-12
	FRONTS - OUTER SHFL			
	UPPER POCKET The upper pockets shall be welt type with flap. The welt shall finish 3/4 to 7/8 inch wide			
	a. Stitch the pocket insulation to the pocketing around all edges 1/4 inch (plus or minus 1/16 inch) from the edge.	301	SSa-1	8-10
	b. Fold under 3/8 inch and sew the welt and facing pieces to the pocketing material, with a single row of stitching 1/16 to 1/8 inch from the folded edges. Selvage need not be turned over.	301	LSd-1	10-12
	c. Position the raw edges of the flap and the assembled hanging pocket (bottom ply) on the foreparts at the drill holes, and stitch through all plies the full length of the flap 3/8 inch from the raw edges. The ends of the stitching shall be securely tacked	301		10-12
	d. Position the assembled hanging pockets (top ply) with the raw edges adjacent to the raw edge of the flap, and stitch 3/8 inch from the raw edge of the pocketing. The ends of the stitching shall be securely tacked.	301		10-12
	e. Cut the pockets through, forming a triangular-shared tongue at each corner			

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TABLE I - SEWING OPERATIONS (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	f Turn the pocketing through the slit, double over forming a 3/4-inch to 7/8-inch welt and stitch on the front at the bottom of the welt through all plies 1/16 inch to 1/8 inch from the seamed edge.	301		10-12
	g Sew around the pocketing, with a single row of stitching approximately 1/2 inch from the edge, catching the tongue notch at each corner closing the pocket.	301	SSa-1	10-12
	h Raise stitch across the ends of the welt and across the top of the flap on the front through all plies 1/16 to 1/8 inch from the seamed edge	301		10-12
	i. Bartack the corners of the pocket openings, with a 1/2 inch to 3/4-inch bartack at each end. The ends of bartack shall extend to the edge of the pocket.	bartack		42 per bartack
	j. Install a button and a snar socket on the flap centered, with the center of the socket positioned 3/4 to 7/8 inch from the bottom edge of the flap. Install stud and eyelet on each side of top plies of the parka to correspond to the button snaps on the flap. The stud shall be through the front and top ply of the hanging pocket.			
5.	LOWER POCKET. The two lower front pockets shall be reinforced on each end of the pocket opening with a leather triangular-shaped reinforcement piece. The opening shall be in accordance with the drill marks. The depth of the pocket shall be 9 inches (plus or minus 1/2 inch). A stud and eyelet shall be installed on the parka to correspond with the button snap and the socket on the flap.			
	a. Stitch the pocket insulation to the pocketing around all edges 1/4 inch (plus or minus 1/16 inch) from the edge	301	SSa-1	8-10

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TABLE I - SEWING OPERATIONS (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	b. Fold under 3/8 inch and sew the facing pieces to the pocketing material, with a single row of stitching 1/16 to 1/8 inch from the folded edge. Selvage need not be turned under.	301	LSc-1	10-12
	c. Position the raw edges of the flap and the assembled hanging pocket (bottom ply) on the foreparts at the drill holes and stitch through all plies the full length of the flap 3/8 inch from the raw edges. The ends of the stitching shall be securely tacked.	301		10-12
	d. Position the assembled hanging pocket (top ply) with the raw edges adjacent to the raw edges of the flap, and stitch 3/8 inch from the edge of the pocketing with the ends of the stitching extending 3/8 to 1/2 inch beyond each end of the flap. The ends of stitching shall be securely tacked.	301		10-12
	e. Cut the pockets through, forming a triangular-shaped tongue at each corner.			
	f. Turn the pocketing through the slit, and edge stitch the pocket opening 5/16 to 1/4 inch from the edge.	301	Sc-1(b)	10-12
	g. Sew around the sides and the bottom edges of the pocketing, with a single row of stitching approximately 1/2 inch from the edge catching the tongue notches at each corner closing the pocket. The lower corner may be sewn round.	301	Sc-1	10-12
	h. Make stitch across the ends of the tongue notches and across the top of the flap on the fronts, through all plies, 1/16 to 1/8 inch from the seamed edge.	301		10-12

TABLE I - SWING OPERATIONS (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	<p>i. The corners of the pocket openings shall be reinforced. Cut a 1-1/4-inch-square piece of leather diagonally to form two triangular pieces. Place the long side of the triangular cut leather piece parallel with the edges of the pocket flap and sew all around, with a single row of stitching, 1/16 inch from the edge. The leather pieces shall cover the stitching on each end of the pocket. An automatic box-tacker may be used.</p> <p>j. Install a button and a socket on the flap centered, with the center of the socket positioned 3/4 to 7/8 inch from the bottom edge of the flap, install a stud and eyelet on each side of the parka through the top plies of the pocket to correspond to the button on the flap.</p> <p>NOTE: Install the flap so that the top edge of the pocket is against the inside of the flap, and flap lays smooth when fastened.</p>	301	SSa-1	10-12
6.	<p>JOINING OUTER SHELL</p> <p>JOINING OUTER SHELL. Join the back to the front of the outer shell at the side seams, back overlapping the front, double lapped and sewn with a double row of stitching, 1/4-inch to 5/16-inch edge, 1/16 inch from the seamed edge.</p> <p>a. The back may be joined to the fronts at the side seams, with a single row of stitching 1/2 inch from the edge. Turn the garment to the back with a double row of stitching, 1/4-inch to 5/16-inch edge, 1/16 inch from the seamed edge.</p>	301 or 401	LSa-2	10-12
7.	<p>MAKE AND ATTACH PENCIL POCKET. Per the top of the pocket by folding at the notches and stitch with a double row of stitching, 1/4-inch edge. The first row of stitching shall be 1/16 to 1/8 inch from the folded edge.</p>	301	LSq-3	10-12
		301	PSa-2	8-10

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TABLE I - SEWING OPERATIONS (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
8.	a. Fold the sides and the bottom of the pocket under 3/8 inch, position on the marks on the left topsleeve, and stitch to the sleeve, with a single row of stitching, 1/16 to 1/8 inch from the folded edge around the sides and the bottom.	301	LSd-1	8-10
	b. Place a single row of stitching lengthwise through the pocket and the sleeve from the top edge to the bottom edge of the pocket.	301	SSv-1	10-12
	JOIN SLEEVES			
	a. Join the sleeve inseam, with the topsleeve overlapping the undersleeve, double lapped and sewn with a double row of stitching, 1/4-inch to 5/16-inch gage, 1/16 inch from the folded edge.	301 or 401	LSc-2	10-12
	b. Join the sleeve to the front and the back at the shoulder, with a single row of stitching, 1/2 inch from the edge.	301	LSq-3	10-12
	c. Turn and raise on the fronts and the back, with a double row of stitching, 1/4-inch to 5/16-inch gage, 1/16 inch from the folded edge.	301	LSq-3(b)	10-12
	d. Join elbow seam, with a single row of stitching, 1/2 inch from the edge.	301	LSq-3(a)	10-12

TABLE I - SEWING OPERATIONS (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	e. Turn and raise or topstitch, overlapping under-sleeve with a double row of stitching, 1/4 inch to 5/16 inch 1/16 inch from the folded edge OF	301	LSc-3(h)	10-12
	f. Join the top seam of the sleeve front over back with a double row of stitching, 1/4-inch or 5/16-inch gage, 1/16 inch from the edge	301 or 401	LSc-2	10-12
	g. Join the sleeve to the front and the back at the shoulder with the back and the front over the sleeve, double lapped, with a double row of stitching, 1/4-inch to 5/16 inch gage, 1/16 inch from the edge.	301 or 401	LSc-2	10-12
	PREPARE HOOD - OUTER SHELL			
9.	The coated outer shell fabric shall be used for the outer shell and the lining of the hood. The coated side of the fabric shall be toward the quilted insulation.			
	a. Join the front panels of the outer shell at the top, with a double row of stitching 1/4 to 5/16 inch gage, 1/16 inch from edge	301 or 401	LSc-2	8-12
	b. Join the back side panels to the center back panel with side back panels overlapping center back panel with a double row of stitching 1/4 to 5/16 inch gage, 1/16 inch from edge.	301 or 401	LSc-2	8-12
	c. Complete the outer shell by joining the front and back panel assembly with double row of stitching 1/4 to 5/16 inch gage, 1/16 inch from the edge.	301 or 401	LSc-2	8-12

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F I - SEWING OPERATIONS (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
11	Fabricate the lining shell using the procedures of a, b, and c of Operation 9.			
12	<u>Interlining.</u> Join the front panels at top, 3/8 seam lap with a row of stitching 3/16 plus or minus 1/32 inch from the edge.	301	LSa-1	8-10
	a Join the back side panels to the center back panel, 3/8 lap seam with a single row of stitching, 3/16 plus or minus 1/32-inch from the edge	301	LSa-1	8-10
	b Join the insulation shell by joining the front and back panel assemblies with a single row of stitching, 3/16 plus or minus 1/32 inch from the edge	301	LSa-1	8-10
	c Join the nylon fleece facing strip at the top with a single row of stitching 3/8 seam.	301	SSz-3a	8-10
	d Spread the seam and stitch on each side, 3/16 plus or minus 1/32-inch from turned edge	301	SSz-3b	8-10
	e Join the facing strip to the uncoated side of lining shell by positioning the strip, nap side up, around the face contour with nap side up and the edge 3/8-inch from edge of lining shell. Stitch to shell with one row of stitching, 1/8 plus or minus 1/32-inch around both sides and ends. The joining seam on the facing strip shall be centered over the top joining seam for the front face panels	301	LSb-1	8-10

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TABLE I - SEWING OPERATIONS (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	f. Join the hook portions of the hook and pile tape to the uncoated (outside) of the outer shell on the left side of the shell. Use one row of stitching around the sides and ends $1/8$ plus or minus $1/32$ -inch from edge of tape. Use the correct size template to establish position of the tape.	301	LSb _j	8-10
	g. Join the pile portions of the hook and pile tape to the uncoated (outside) of the outer shell on the right side. Use one row of stitching around the sides and ends $1/8$ plus or minus $1/32$ -inch from edge of the tape. Use the correct size template to establish position of the tape.	301	LSb _j	8-10
	h. Join the edges of the shape darts on the outer shell and nylon fleece fabric for the side flaps.	301	LSq-2a	8-10
	i. Fuse on the cotton side of the outer shell fabric and on the napred side of the nylon fleece.	301	LSq-2b	8-10
	j. Join the pile portion of the two part hook and pile tape to the uncoated side of the outer shell fabric for the left face flap in accordance with pattern marks. Use one row of stitching around the sides and ends of each strip, $1/8$ plus or minus $1/32$ -inch from tape edges.	301	LSb _i	8-10
	k. Join the hook portion of the two part hook and pile tape to the uncoated side of the outer shell fabric for the right face flap in accordance with pattern marks. Use one row of stitching around the sides and end of each strip, $1/8$ plus or minus $1/32$ -inch from the tape edges.	301	LSb _i	8-10

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TABLE I - SEWING OPERATIONS (Cont'd)

No.	Description of Operation	Stitch Type	Sear and Stitching Type	Stitches Per Inch
1	Join the nylon fleece and outer shell material for the face flaps by placing the coated side of the material against the uncoated side of the fleece together and sear all around with a $1/4$ to $3/8$ inch seam.	301 or 401	CSa-1	8-10
2	Bind the edges of the face flap with bias-cut lining material around the curved sides and ending at the straight edge that attaches to the hood. The binding shall finish $1/4$ to $3/8$ inch wide with raw edges turned in and caught in the stitching.	301	SCC-1	8-10
3	(a) Join the pile portion of the hood and pile tane to the nylon fleece innerlining on the left face flap in accordance with pattern marks. Use one row of stitching around the sides and ends of the strip, $1/8$ plus or minus $1/32$ -inch from the tape edges.	301	LSb-1	8-10
4	Install the neck portion of the two part hook and pile tane to the outer shell on the right side of the neck flap in accordance with the template markings for the correct size.	301	LSb-1	8-10
5	Install the pile portion of the two part hook and pile tane on the uncoated side of the left neck flap on the inner lining shell in accordance with the template markings for the correct size. Use one row of stitching around the ends and sides, $1/8$ plus or minus $1/32$ -inch from the tape edges.	301	LSa-2a	8-10
6	Join the nylon fleece and coated outer-shell fabric for the forehead flap napred side of fleece to uncoated side of coated fabric around the ends and one side. Use one row of stitching plus nothing minus $1/16$ -inch from the edges.	301	LSa-2a	8-10

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TABLE I - STITCHING OPERATIONS (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	<p>q. Turn and raise on the uncoated side of outer-shell fabric with a single row of stitching $1/8$ plus or minus $1/32$-inch from turned edges</p> <p>r. Assemble the three shells of the hood so that the insulation shell shall be between the lining and the outer shell on the completed hood stitch around the face contour, the throat and the throat flaps to the side notches with a single row of stitching $1/8$ inch, plus $1/16$ inch minus 0 from edge. The face flaps may be inserted during this operation on the right and left sides so that the flaps will be the outside and fastened together properly. The forehead flap shall be inserted at the same time. The flaps shall be so inserted that the coated material will be on the inside.</p> <p>s. Then bind these edges beginning at the side notches around the throat flaps continuing along the contour of the hood and ending on the opposite side at the notch. The ends of the binding shall have sufficient length to be inserted between the shells of the parts in the hood setting operation. The bound seam shall be turned to the inside of the hood and beginning at the bottom of the face flap stitched through the binding and all plies of the hood. This stitching shall terminate at the bottom of the face flap on the opposite side</p>	301	LSa-2b	9-10
		301 or 401	SSa-1	8-10
		301	BSc-1	8-10
12.	<p>JOIN HOOD TO PARTIAL OUTER CUFF. Turn the shells of the hood to the partial outer shell around the neck opening with a single row of stitching $3/4$ inch $\pm 1/16$-inch from the edges. Turn up hood and complete the raise stitching. The back and fronts shall overlap the hood.</p>	301	CSq-2t	8-10

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TABLE I - SEWING OPERATIONS (Cont'd)

No	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
13	<p>a. Smooth out the shells of the hood and install a bartack on the top of the hood in the joining seam for the combined front side panels and combined back side panels. The bartack shall be even with the front to back joining seam for the front side panels</p> <p>b. LUF FLY. The outer fly shall be fabricated from two plies of outer shell material and one ply of interlining (insulated) material.</p> <p>c. Join the underside ply of the outer-shell material to the interlining (insulated) material, with a diagonal stitch, with the stitches approximately 3 inches apart. The diagonal stitched portion of the fly shall face inward. The quilting may be performed with four rows of parallel stitching in lieu of the diagonal stitching.</p> <p>d. Place a single row of stitching, 1 inch from the edge of the protective fly or the side area from the loons</p> <p>e. Prepare four loops fabricated from cotton braid 3-1/2 inches long. Fold the loops in half and attach to the protective fly, at the notch marks, with a double row of stitching.</p> <p>f. Join the fly pieces together, with a single row of stitching, 1/2 inch from the edge, on the top, the lower side and the bottom</p> <p>g. Turn and raise the fly pieces, with a single row of stitching, 1/4 inch from the edge</p>	301	SSV-1	10-12
		301	SSA-1	10-12
		301	SSA-2	10-12
		301 or 401	SSA-2(a)	10-12
		301	SSA-2(b)	10-12

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TABLE I - SEWING OPERATIONS (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per inch
14	<p>INNER FLY The inner fly shall be fabricated from two plies of the outer-shell material and one ply of insulating batting.</p> <p>a. Join the two plies of the outer-shell material to the one ply of insulating batting, with a single row of stitching 1/2 inch from the edge, on the top along the outside and the bottom edge. The top and the bottom ends of the batting shall not be caught in the joining seam.</p> <p>b. Turn and raise with a single row of stitching 1/4 inch from the edge.</p> <p>c. Quilt the fly through and through, with a single row of diagonal stitching approximately 3 inches apart. The quilting may be performed with four rows of parallel stitching in lieu of the diagonal stitching.</p>	301	SSe-2(a)	10-12
15	<p>JOINING OUTER PROTECTIVE FLY Sew the protective fly to the left forepart of the outer shell in accordance with the notch and with the top end of the fly, terminating at the neckline joining seam of the hood seam with a 1/2-inch seam. Attach slide fastener to outer shell. Attach the slide fastener to the right and left front edges of the outer shell approximately 1/2 inch below the neckline, with a single row of stitching, 1/4 inch seam. The slide fastener tape shall be exposed approximately 1/2 inch.</p> <p>a. The slide fastener shall be attached without excessive length of tape put in at any one point. The tape at the top shall be turned under and finished with raw edges exposed. The finished hem of the pants shall be even on the right and left fronts.</p>	301	SCa-1	10-12

TABLE I - I G OPERATIONS (cont'd)

No	Description of Operation	Stitch Time	Seam and Stitching Type	Stitches Per Inch
16	JOINING INNER PROTECTIVE FLY Sew the inner protective fly to the right forepart of the outer-shell material, in accordance with marks, with a single row of stitching 1/2 inch from the edge	301	CSA-1	10-12
17.	MAKE HANGERS. Fold the two sides, and stitch edge to edge, with a double row of stitching 1/16 to 1/8 inch from each edge. The hanger shall finish 3/8 to 5/8 inch wide and 3 to 3-1/2 inches long when attached to the back	301	PPA-2	9-10
18	PREPARE INTERLACING (INCULCATION) FOR BODY AND SLEEVES. Stitch the corresponding lining and interlining parts together along the raw edges with a single row of stitching 1/8 to 1/4 inch from the edge	301	CSA-1	9-10
19	ATTACH HANGERS AND LABEL. Position the label to the back assembly, centered, with the top edge of the label positioned 1-1/2 to 2 inches from the raw edges of the neckline, and sew with a single row of stitching on all four sides. a. Fold under the raw ends and position the hanger at the center of the neck directly above the label, sew through the label assembly with a double row of stitching 1/4-inch to 3/8-inch from or bartack at each end	301 or bartack	PPA-2	9-10 12 per bartack
20	COVER THE INTERLACING. Fold the back to the fronts at the side seams with a single row of stitching 3/8 inch from the edge a. Join the inserts and the elbow seams of the sleeves with a single row of stitching 3/8 inch from the edge	301 or 401 301 or 401	CSA-1 CSA-1	10-12 10-12

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TABLE I - SEWING OPERATIONS (Cont'd)

NO	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
21	b. Stitch the wristlets at the bottom of the sleeves as indicated by the notches on the patterns, with a double row of stitching (single-needle or double-needle machine). The first row of stitching shall be 3/16 inch from the raw edge of the wristlets, and the second row of stitching shall be 1/4 to 3/8 inch from the first row of stitching.	301		10-12
	c. Join the sleeves to the armholes, in accordance with the notches on the patterns, with a single row of stitching 3/8 inch from the edge.	301 or 401	Ssa-1	10-12
	JOIN ASSSEMBLED INNER SHELL AND OUTER SKILL. In the finished parka, the interlining (insulation) shall be between the outer shell and the lining.	301	Sse-2(a) and Ssq-2(a)	10-12
	a. Stitch the inner shell to the outer shell around the bottom, fronts, and the hood with a single row of stitching 1/2 inch from the edge, leaving an opening at the bottom of the parka for turning.	301	Sse-2(a)	10-12
	b. Stitch the sleeve bottom of the inner and the outer shell together with their respective seams matching (plus or minus 1/4 inch) with a single row of stitching 3/8 to 1/2 inch from the edge.	301	Sse-2(a)	10-12
	c. Trim the bottom corners of the parka, turn right side out and force out the corners			
	d. Edge stitch around the bottom (closing the opening), the fronts, and the hood 1/4-inch from	301	Sse-2(b), Ssq(b), and Ssc-1	10-12

11-1-1-1

TABLE I MILITARY OPERATIONS (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches per Inch
22.	<p>e. Edge stitch around the bottom of the sleeves 1/4-inch gage</p> <p>PLACEMENT OF STUDS, SOCKETS, AND SNAPS ON OUTER PROTECTIVE FLY</p> <p>Install a button snap and a socket on the lower end of the fly at the seam joining outer protective fly. Install a stud and an eyelet on the inner protective fly to correspond to the button snap and socket on the outer protective fly</p> <p>a. Install a button snap and a socket on the lower end of the left front 1-1/2 inches up from the finished bottom edge and 1 inch from the finished front edge.</p> <p>b. Install a stud and an eyelet on the inner protective fly to correspond with the button and the socket on the left front and in a manner to 027987-7-11W bottom edges and the front edges of the parka are even and lay smooth when the parka is closed with the slide fastener and the outer protective fly fastened in place.</p>	301	SS-2(t)	10-12
23.	<p>Sew four 45-line buttons on the front of the parka. The buttons shall be reinforced on inside of parka with stay buttons. The two upper buttons shall be installed through the outer shell, the interlining and lining, the two lower buttons shall be installed through the outside of the pocket, with stay buttons on the inside of the pocket. All buttons shall be tightly wrapped to form a shank, and the ends shall be tacked off. Mark position of buttons to correspond with loops</p>	101 or 301		20 to 22 per button 16 to 22

TABLE I - SEWING OPERATIONS (Cont'd)

NO.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
24.	<p>CLEANING.</p> <p>a. All loose ends of thread shall be trimmed, and loose thread shall be removed.</p> <p>b. Remove any soil or spots</p> <p>c. Remove shade marking tickets.</p>			
25.	<p>FASTENING Close slide fastener, fasten snap fasteners, and button per a.</p>			
26.	<p>FINISHING TOLERANCES Unless otherwise specified, the sewing tolerance shall be plus 0, minus 1/8 inch for 5/16-inch rafe seams, plus or minus 1/16 inch for 1/4-inch rafe seams, and plus 1/32 inch, minus 0 for 1/16 inch from the edge.</p>			

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3.3.2 Patterns. The manufacturer's patterns shall be identical in size and shape to the patterns referenced on 63B4171.

3.3.2.1 Pattern parts. The pattern parts shall be as follows

<u>PART</u>	<u>NO. TO BE CUT</u>
Outer shell (coated fabric)	
Front	2
Back	1
Topsleeve	2
Undersleeve	2
Flaps (upper and lower)	8
Lower pocket facings	4
Upper pocket welt and facing	4
Pencil pocket	1
Protective fly (right)	2
Front flap (left)	2
Forehead flap	1
hood center panel	1
hood side panel	2
hood front panel	2
Face piece	2
Lining	
Front	2
Back	1
Topsleeve	2
Undersleeve	2
Upper hanging pockets	4
Lower hanging pockets	4
Hood center panel	1
Hood side panel	2
hood front panel	2
Interlining (insulation)	
Front	2
Back	1
Topsleeve	2
Undersleeve	2
Protective fly (right)	1
Front flap (left)	1
Forehead flap fleece	1
Hood center panel	1
Hood side panel	2
Hood front panel	2
Hood front panel facing fleece	2
Face piece fleece	2
Upper hanging pockets	4
Lower hanging pockets	4

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- * 3.4 Identification of product. A printed label conforming to type I, class 1 of DDD-L-20 shall be securely sewn to the lining of each parka. The label shall be approximately 2 inches wide by 3 inches long. The parka is intended to be laundered or dry cleaned. The label shall contain the following specific information

Parka, Man's CWU-8/P
 MIL-P-38184C
 Size*
 Stock No.*
 Contract No.*
 Manufacturer's name or trademark*
 Launder or dry clean
 Do not subject to heat in excess of 200°F

*The manufacturer shall include the applicable information.

- * 3.5 Finished measurements. The finished measurements shall conform to Table II.

TABLE II - FINISHED MEASUREMENTS IN INCHES

Measurement 1/	Size				Tolerance
	Small	Medium	Large	Extra Large	Plus or Minus
1/2 chest	26-1/2	28-1/2	30-1/2	32-1/2	1/2
Sleeve inseam	19	19	19-1/4	19-1/2	1/2
Back length	33	34	35	36	1/2

1/ NOTE. The slide fastener shall be closed and the front smoothed out, the front cover flap shall be fastened over the closed slide fastener. The measurement of the 1/2 chest shall then be taken from the base of one armhole to the base of the armhole on the opposite side

The inseam of the sleeve shall be measured from the base of the armhole to the bottom of the sleeve.

The back length shall be measured from the hood joining seam to the bottom.

- * 3.6 Workmanship. The parka shall conform to the quality of product established by this specification. The occurrence of defects shall not exceed the specified acceptable quality levels.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the supplier may use his own or any other facilities

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suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements

4.2 Inspection for acceptance Unless otherwise specified, inspection shall be in accordance with MIL-STD-105.

- * 4.2.1 Testing of components Inspection shall be performed on components listed in Table III for the characteristics noted therein. The other components shall be tested for the requirements contained in their respective specifications.

TABLE III - TESTING OF COMPONENTS

Component and Characteristic	Test Method	No. of Determinations Per Sample Unit
BATTING INTERLINING (SEE 3.1.2)		
Material identification <u>1/</u>	Note 1	1
Denier <u>2/</u>	Note 2	1
Type construction	visual	1
Length fibers	Linear measure	1
Process <u>1/</u>	Note 1	1
Bonding Agent <u>3/</u>	Resin (Trade Name when used)	
QUILTED FABRIC (SEE 3.1.2)		
Thickness	See para 4.4.2	
Thickness after compression	See para 4.4.2	
Weight	5041 of FED-STD-191	

1/ A certificate of compliance will be acceptable for this requirement

2/ Denier shall be reported to the nearest whole number and shall be calculated as follows

$$\text{denier} = \frac{\text{weight of specimen in grams times } 9840}{\text{length of specimen in yards}}$$

3/ A certificate of compliance is mandatory for this requirement, when used, and it shall include a certifie statement of the approved trade name of the resin used. (See 6.5)

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- * 4.2.1.1 Lot size and sample size Unless otherwise specified in the applicable subsidiary specification, the lot size and the sample size for testing components and material shall conform to Table I. Lot shall be unacceptable if one or more units fail to meet any specified requirement

TABLE IV - LOT SIZE AND SAMPLE SIZE

Lot Size (Units)	Sample Size
800 or less	2
801 to 22,000	3
22,001 and over	5

4.2.2 Examination of end item. The end item shall be examined for defects. Except for defects with an asterisk (*), defects found during examination shall be classified as specified in 4.2.2.1, 4.2.2.2, and 4.2.2.3. Defects with an asterisk shall be classified a major defect when affecting appearance or serviceability seriously and as minor A defects when affecting appearance or serviceability but not seriously.

4.2.2.1 General defects shall be classified as follows

	Classification		
	Major	Minor	
		A	B
1. BARTACKS			
a. Missing, insecure, or misplaced not serving intended purpose			
-one bartack			X
-two bartacks		X	
-three bartacks	X		
2. BUTTONS AND STAY BUTTONS			
a. Not specified size, type, or color			X
b. Missing, loose, broken, or misplaced			
-one button		X	
-two or more buttons	X		
-one or more stay buttons			X
3. CLEANNESS			
a. Indelible ink shade stamping exposed on outside or spots and stains of permanent nature		*	
b. Removable spot or stain, clearly noticeable		X	
c. Thread ends not trimmed or one or more shade tickets not removed			X

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	Classification	
	Major	Minor
4. COMPONENTS AND ASSEMBLY		
a. Any defective component		*
b. Any component part omitted		*
c. Any required operation omitted or improperly performed		*
5. CUTTING		
a. Any component part not cut in accordance with directional lines or patterns or specified requirements		*
6. LABELS		
a. Identification label		
-missing or size marking omitted, incorrect, or illegible	Y	
-information (other than size) missing, incorrect, or illegible		Y
-not stitched on four sides to lining		X
7. MATERIAL DEFECTS AND WORKMANSHIP DAMAGES. Material defects or workmanship damages that are inconspicuous and definitely do not weaken the fabric shall not be classified as defects. Material defects and workmanship damages shall be classified as indicated when the condition definitely weakens the fabric. If the material defects and workmanship damages do not weaken the fabric but are conspicuous when the garment is worn, they shall be classified as indicated.		
a. Any weakening fabric defect such as a hole, slash, multiple float, and loose slub that may develop into a hole		*
b. Shade bars, unsightly slubs, or other similar non-weakening fabric defects affecting appearance		
-on outside of garment		*
-on inside of garment		Y
c. Large drill hole, cut, tear, mend, burn, or needle chew that may develop into a hole		*
d. Ruptured fibers in the line of sewing (usually caused by broken, blunt, or hooked needles) affecting appearance or serviceability	Y	

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	Classification	
	Major	Minor A B
e. Accuracy of seaming		
(1) Seam twisted, puckered, or pleated		*
(2) Part of garment caught in any unrelated operation or stitching		*
(3) Thread(s) used on outside not same shade or not satisfactorily matching shade of garment		X
(4) Thread breaks or end(s) of stitching (when not caught in other seams or stitching) not securely backstitched		X
f. Gage of stitching (edge, top, or raise stitching)		
(1) Irregular, i.e., unevenly gaged or corresponding stitchings not uniformly gaged, affecting appearance		X
(2) Not within range of gage specified or varies more than 1/16 inch when no range is specified		X
g. Open seam. A break in a line of stitching or continuous skipped or run-off stitches (except on edge, top, or raise stitching) shall constitute an open seam.		
(1) Over 1/8 inch to and including 1/4 inch		X
(2) Over 1/4 inch		X
h. Stitches skipped or broken (on edge, top, or raise stitching when seam is seamed, turned, and stitched)		
(1) Over 1/4 inch to and including 1/2 inch		X
(2) Over 1/2 inch		X
i. Raw edges. A raw edge shall be classified as such when it occurs along an edge required to be turned under but the edge is securely caught in the stitching		
If the edge is not securely caught in the stitching, it shall be scored as an open seam.		
(1) On outside		
-over 1/8 inch to and including 1/4 inch		X
-over 1/4 inch		*
(2) On inside		
-over 1/2 inch to and including 1 inch		X
-over 1 inch		X

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	Classification	
	Major	Minor A B
j. Run-offs		
(1) On joining seams, when resulting in an open seam, score as open seam		
(2) On edge, top, or raise stitching when not resulting in open seam (outside only)		
-over 1/4 inch to and including 1 inch		X
-over 1 inch	Y	
k. Stitch or seam type not as specified	Y	
l. Stitch tension. (Puckering is evidence of tight tension. When puckering is evident, seam shall be tested by exerting normal pull in the lengthwise direction of seam or stitching.)		
(1) Loose tension, resulting in a loose seam	X	
(2) Loose tension on edge, top, or raise stitching, recognized by loosely exposed loops of top or lower thread		A
(3) Tight tension (stitches break when normal strain is applied to seam or stitching) shall be scored as open seam.		
m. Stitches per inch (to be scored only when the condition exists on major portion of seam or stitching)		
(1) Less than minimum number permitted by minus tolerance by		
-one or two stitches		Y
-three stitches		
-four or more stitches		
(2) One or more stitches in excess of maximum number permitted by plus tolerance		
n. SHADED PARTS		
a. Outside parts shaded (visible when garment is worn)	*	
b. Lining and inside parts (not visible when garment is worn) badly shaded		

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9. SLIDE FASTENER

- a. Not type or size specified
- b. Garment part stitched too close to metal chain not permitting slider to pass
- c. Top end of slide-fastener tapes not turned under when stitched
- d. Webbing not securely knotted to pull tab

10. SNAP FASTENERS

- a. Missing, mismatched, not securely clinched, or otherwise defective affecting function
 - one fastener
 - two or more fasteners
- b. One or more clinched too tightly, i.e., cutting surround fabric
- c. Rough or sharp edges on one or more studs or sockets

Classification		
Major	Minor	
	A	B
	*	
X		
	Y	
		X
X	X	
X		
	X	

4.2.2.2 Detailed defects. Detailed defects shall be classified as follows

1. HOOD

- a. Front panels overlapping back panels
- b. Side and front panels overlapping crown
- c. Fronts or backs lapped on hood at neck joining seam
- d. Lining tight, short, or twisted, causing fullness or twist on outside of hood
- e. Two part tape improperly placed or crooked, on side flaps or hood
- f. Two part tape improperly placed on throat flaps or crooked
- g. Side flaps improperly placed, high or low or not in line with two part tape on hood proper
- h. Hook or pile tape not placed on the required right or left side
- i. Bartack on top of hood improperly placed

Classification		
Major	Minor	
	A	B
		X
		Y
	X	
	*	
X		
	X	
Y		
X		
	Y	

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	Classification	
	Major	Minor
1. KNOTS		
a. Buttons and loops out of alignment, causing an excessive bulge when buttoned.		
b. Buttons out of vertical alignment by 3/8 inch or more		
c. Stitches on one or both lower button caught through hanging pockets restricting use of pocket		
d. Loops		
-unequally spaced by more than 3/8 inch		
-ends of one or more not securely caught in stitching		
-one or more too small not permitting button to enter		
-too long not engaging button securely		
e. Snap fasteners on lower end of fly not aligned, causing noticeable bulge or twist when fly is closed		
f. Slide fasteners		
-tapes set on too loosely or too tightly causing excessive bulging on opening, affecting appearance		
g. Slash pockets		
-width of welt less than 3/4 inch or more than 1 inch		
-bartacks at ends less than 1/2 inch long		
-out of alignment with each other by 1/8 inch or more		
-sockets less than 3/4 or more than 7/8 inch from point of flap (measured from center of sockets)		
-sockets off-center with center of flaps by more than 3/8 inch		
h. Outer fly converging points of diagonal stitching through interlining less than 2-1/2 or more than 3-1/2 inches apart		
i. Inner fly converging points of diagonal stitching less than 2-1/2 or more than 3-1/2 inches apart		
j. Fronts sagging, twisted, or bulging across chest caused by tightness of lining or interlining	*	
k. Lower pockets		
-omitted triangular-cut leather reinforcement piece at one or both corners of opening		
-depth less than 8-1/2 or more than 9-1/2 inches		
-socket off-center of flap by more than 1/4 inch or positioned less than 3/8 inch or more than 7/8 inch from bottom edge (measurement made from center fasteners)		

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	Classification		
	Major	Minor	
		A	B
3. SLEEVES			
a. Sagging, twisted, bulging, or short caused by shortness, tightness, or incorrect position of lining or interlining		*	
b. Back part of sleeve overlapping forepart of sleeve at inseam			X
c. Back part of sleeve overlapping forepart of sleeve at elbow seam		X	
d. Sleeve overlapping body parts at joining seam	X		
e. Knitted wristlets			
-not specified type or color		X	
-twisted in the attachment to sleeve bottom affecting appearance		X	
f. Pencil pocket			
-omitted	X		
-less than two openings		X	
4. BACK			
a. Front overlapping back at side seams			X
5. INSIDE OF JACKET			
a. Hanger			
-end(s) not securely stitched or bartacked		X	
-finishing less than 3 inches or more than 3-1/2 inches long			X
-less than 3/8 inch wide			X
-1 inch or more off-center with center of back			X
-stitched or bartacked through outer shell		X	
b. Label			
-positioned less than 1-1/2 inches below neck seam			X
-off-center with hanger by 1/2 inch or more			X
-stitched through outer shell		X	
-size shown on label not in conformance with size shown on intermediate or outer container as applicable		X	

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- * 4.2.2.3 Finished measurement defects. Any finished measurement deviating by more than the specific tolerance from the nominal measurements specified in Table IV shall be classified as a finished measurement defect. Sleeve lengths uneven by 1/2 inch or more shall be classified as a finished measurement defect.

- * 4.2.2.4 Inspection levels and acceptable quality levels. The inspection levels shall be II of MIL-STD-105 for 4.2.2.1 and 4.2.2.2 and S-3 of MIL-STD-105 for 4.2.2.3. The acceptable quality level for 4.2.2.1 and 4.2.2.2 expressed as defects per 100 units shall be 2.5 for major defects, 15.0 for major and minor A defects, and 40.0 for major and minor A and B defects. The acceptable level for 4.2.2.3 expressed as defects per 100 units shall be 4.0 (one class) for defects.

4.3 Examination of preparation for delivery requirements. An examination shall be made to determine if packaging, packing, and marking requirements have been met. The sample unit shall be one shipping container fully prepared for delivery with the exception that it need not be sealed. The lot size shall be the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 of MIL-STD-105, the acceptable quality level shall be 2.5 defects per 100 units. Shipping containers fully prepared for delivery shall be examined for the following defects

<u>Examine</u>	<u>Defect</u>
Marking (exterior and interior)	Omitted, incorrect, illegible, of improper size, location, sequence, or method of application
Materials	Any component missing Any component damaged, affecting serviceability
Workmanship	Inadequate application of components, such as incomplete closure of case liners, container flaps, loose strapping, inadequate stapling Bulging or distortion of containers
Weight or content (exterior and interior)	Number per intermediate container is more or less than required, gross or net weight exceeds requirements.

- * 4.4 Test methods. The methods of testing shall be as specified in FED-STD-191 whenever applicable and specified in Table III.
- * 4.4.1 Apparatus. The test apparatus shall consist of a base plate and a circular pressure plate with a bearing surface of 20 square inches, and means of applying 0.01 and 5.0 pounds per square inch loading on the sample. This pressure shall be evenly distributed over the 20 square inch area. The thickness measuring device shall be capable of measuring the thickness of the sample (distance between base and pressure plate) to an accuracy of 0.01 inch.
- 4.4.2 Procedure. The 0.01 pound per square inch pressure shall be applied to the test specimen, and the thickness reading shall be taken and recorded as "initial thickness." Immediately after determining the initial thickness, the pressure shall be increased to 5 pounds per square inch and maintained for one minute. The pressure shall then be completely removed and the specimen

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shall be allowed to relax for 5 minutes. Immediately after the 5 minutes relaxation period, the thickness of the specimen shall again be determined under 0.01 pound per square inch pressure and be recorded as the "thickness of the specimen after compression.

5. PREPARATION FOR DELIVERY

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

5.1.1 Level A. Each unbuttoned parka shall be laid flat with the front up. The hood shall be folded down full length and the sleeves shall be folded one over the other across the chest. When necessary, the sides shall be evenly folded over to maintain a width of approximately 23 inches. The bottom edge shall be brought up to meet the sleeves. Each parka shall then be folded in half by bringing the lower portion up even with the shoulder line. The completely folded parka shall measure approximately 23 inches by 14-1/2 inches.

5.1.2 Level C. Parkas shall be packaged in a manner to afford adequate protection against deterioration and physical damage during shipment from supply source to the first receiving activity. This level may conform to the supplier's commercial practice provided the latter meets the requirements of this level.

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

5.2.1 Level A. Eight parkas of one size only, packaged as specified in 5.1, shall be packed in a fiberboard shipping container assembled, closed, and reinforced in accordance with class weather-resistant, size 3A of MIL-B-17757. The parkas shall be packed flat, eight in depth. In addition, each container shall have the contents completely covered on the top and the bottom with a sheet of 30-pound minimum basis weight kraft paper conforming to grade B of UU-P-268. Toward the end of the contract or when there are less than the quantity of the same size required per container, mixed sizes (see 5.3.1) may be packed in the same container.

* 5.2.2 Level B. Eight parkas of one size only, packaged as specified in 5.1, shall be packed in a fiberboard shipping container assembled and closed in accordance with class domestic, grade 275, size 3A of MIL-B-17757. The parka shall be packed flat, eight in depth. In addition, the content of each container shall be completely covered on the top and the bottom with a sheet of 30-pound minimum basis weight paper conforming to grade B of UU-P-268. Toward the end of the contract or where there are less than the quantity of the same size required per container, mixed sizes (see 5.3.1) may be packed in the same container.

5.2.3 Level C. Parkas, packaged as specified in 5.1, shall be packed in a manner to insure acceptance by the carrier and safe delivery to destination at the lowest transportation rate for such supplies. Containers shall be in accordance with the rules of carriers or regulations applicable to the mode of transportation.

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

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5.3.1 Mixed sizes. Each shipping container packed with mixed sizes (see 5.2.1 and 5.2.2) shall have securely attached to the end and the side, directly under the printing or stenciling, a white paper label that is 5 inches by 4 inches. The words mixed sizes shall be plainly stamped or printed on the label and under these words shall be legibly printed the quantity and sizes of parkas contained therein.

6. NOTES

6.1 Intended use. The parka covered by this specification is intended to be worn in the very cold temperature zone.

6.2 Ordering data. Procurement documents should specify the following

- a. Title, number, and date of this specification.
- b. Size required (see 1.1).
- c. Selection of applicable levels of packaging and packing (see 5.1 and 5.2).

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

6.4 Figures.

6.4.1 Figure 1 shows general style and is for information only.

6.4.2 Figure 2 shows quilting pattern.

* 6.5 Approved bonding agents

<u>Bonding Agent</u>	<u>Manufacturer</u>
Aerotex M-3	American Cyanamid Co.
Colab CR-205	Colab Resin Corp (Tewksbury MA)
Hanflex T-15	Nyanza Inc (Lawrence MA)
Paisley 75-5547-0	Paisley Products, Inc
Paisley 75-5675-0	Paisley Products, Inc
Resyn 25-2812	National Starch and Chemical Corp.
Resyn 2802F	National Starch and Chemical Corp.
Rhoplex HA-16	Rohm & Hass Company
Phoplex HA-20	Rohm & Hass Company
S.T.A.R. Resin ST-340	Star (Cohoes NY)
460X-1	B.F. Goodrich Co
Rhoplex TR-407	Rohm & Hass Company

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

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Custodian
Air Force - 02

Preparing Activity
Air Force - 02

Review Activities
Air Force - 11
DCA - CT

Project No. 8415-P848

MI, F 10

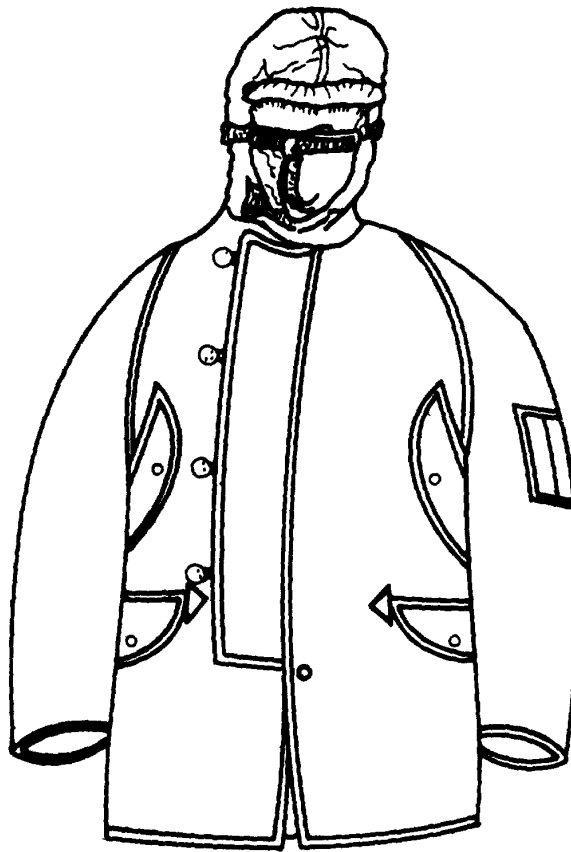


FIGURE 1 - PARKA, TYPE CWU-8/P

MIL-P-38184c

A = $3\frac{3}{4} \pm \frac{1}{4}$ INCHES

C = $\frac{7}{8} \pm \frac{1}{4}$ INCH

B = $5\frac{1}{4}$ INCHES

D = $\frac{1}{4} \pm \frac{1}{8}$ INCH

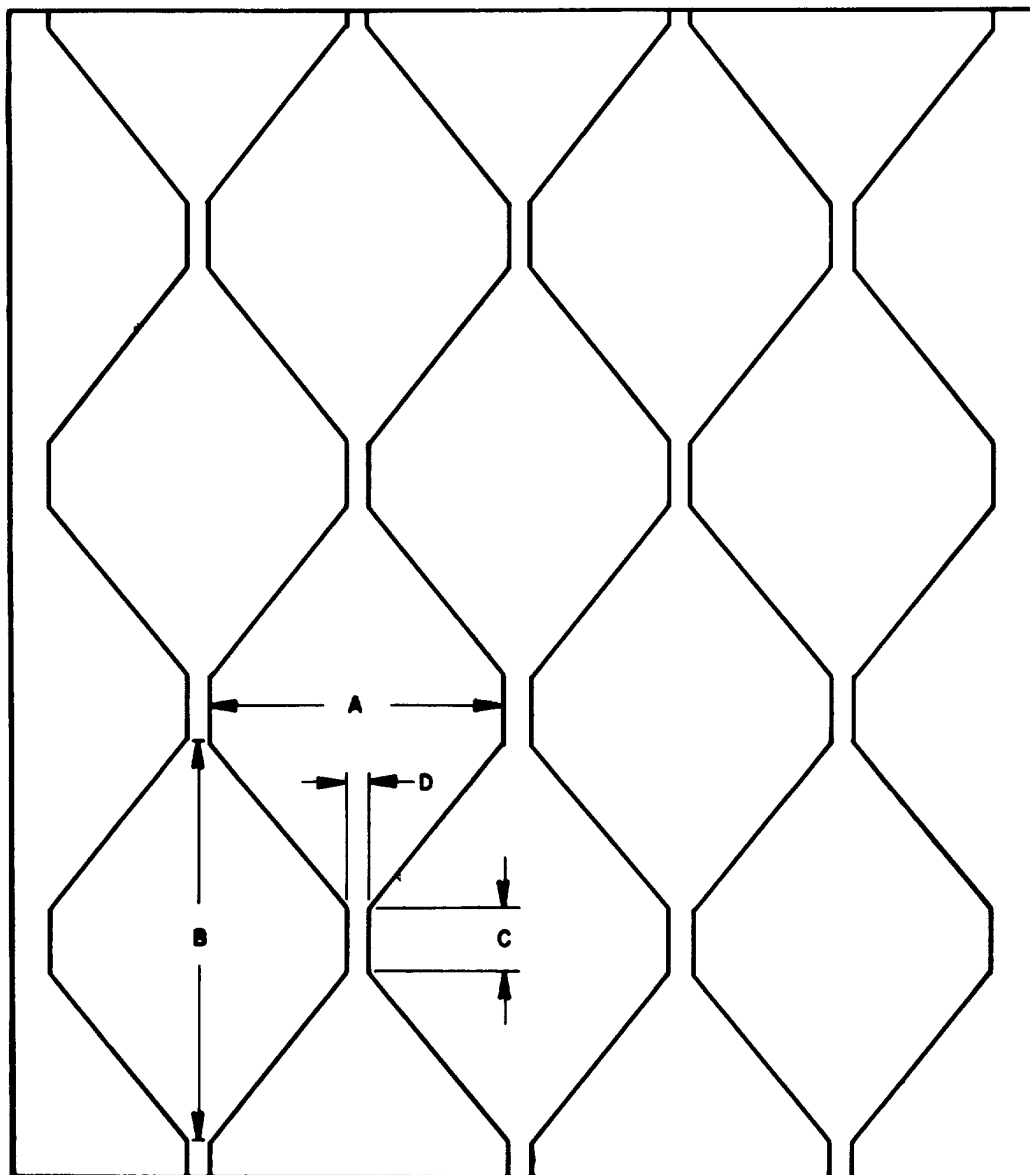


FIGURE 2 - QUILTING PATTERN

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

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