

INCH-POUND

MIL-P-43496F

16 April 1990

SUPERSEDING

MIL-P-43496E

31 December 1986

MILITARY SPECIFICATION

PARKA, EXTREME COLD WEATHER

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

1. SCOPE

1.1 Scope. This specification covers one type of extreme cold weather parka made of cotton-nylon oxford cloth.

1.2 Classification. The parka shall be in the following sizes as specified (see 6.2).

Schedule of sizes

X-Small

Small

Medium

Large

X-Large

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 Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8415

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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 document to the extent specified herein. Unless otherwise specified, the issues of these documents are those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

SPECIFICATIONS

FEDERAL

- A-A-203 - Paper, Kraft, Untreated
- V-B-871 - Button, Sewing Hole, and Button, Staple, (Plastic)
- V-F-106 - Fasteners, Slide, Interlocking
- V-T-280 - Thread, Gimp, Cotton, Buttonhole
- JJ-W-155 - Webbing, Textile, (Cotton, Elastic)
- CCC-C-438 - Cloth, Buckram, Woven and Nonwoven
- DDD-L-20 - Label: For Clothing, Equipage, and Tentage
(General Use)
- PPP-B-636 - Boxes, Shipping, Fiberboard

MILITARY

- MIL-B-371 - Braid, Textile, Tubular
- MIL-C-508 - Cloth, Oxford, Nylon, 3 Ounce
- MIL-T-3530 - Thread and Twine; Mildew Resistant or Water
Repellent Treated
- MIL-C-3760 - Cloth, Flannel, Wool and Cotton; Wool and Nylon
- MIL-C-3924 - Cloth, Oxford, Cotton Warp and Nylon Filling,
Quarrel Treated
- MIL-T-5038 - Tape, Textile and Webbing, Textile, Reinforcing,
Nylon
- MIL-F-10884 - Fasteners, Snap
- MIL-C-17155 - Cloth, Knitted, Nylon, Fleece
- MIL-E-20652 - Eyelets, Metallic, Rolled Flange Type; and Eyelet
Washer
- MIL-L-35078 - Loads, Units: Preparation of Semiperishable
Subsistence Items; Clothing, Personal Equipment
and Equipage; General Specification for
- MIL-C-43303 - Cord, Elastic Cotton
- MIL-T-43548 - Thread, Polyester Core: Cotton-, Rayon-, or
Polyester-Covered
- MIL-T-43566 - Tape, Textile, Cotton or Polyester, General Purpose,
Natural or in Colors

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STANDARDS

FEDERAL

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

(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from the Standardization Documents Order Desk, Bldg. 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.)

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

THE COLOR ASSOCIATION OF THE UNITED STATES

Standard Color Card of America

Department of Defense Standard Color Card for Sewing Thread

Department of Defense Standard Shades for Buttons

Quartermaster Standard Shades of Slide Fastener Tapes

(Color cards may be available from the Color Association of the United States, 343 Lexington Avenue, New York, NY 10016-0927. If color cards are not available from the Color Association, individual color samples may be obtained from the contracting activity or as directed by the contracting activity.)

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

D 3951 - Standard Practice for Commercial Packaging

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

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

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2.3 Order of precedence. In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 Samples.

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

3.1.2 Guide sample. Guide samples, when furnished, are solely for guidance and information to the contractor (see 6.4). Variation from this specification may appear in the sample, in which case this specification shall govern.

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

3.2.1 Basic material. The basic material shall be cotton warp and nylon filling oxford cloth, water repellent, Olive Green 107 conforming to class 2 of MIL-C-3924 except that the colorfastness requirements for perspiration shall not apply.

3.2.2 Flannel. The material for lining side pockets shall be either 12 ounce, Olive Green 108, wool and nylon flannel cloth conforming to type III of MIL-C-3760 or 9.5 ounce minimum, Green 3405, knitted nylon fleece cloth conforming to type I of MIL-C-17155.

3.2.3 Cloth, nylon oxford. The material for pocket binding shall be 3-ounce nylon oxford cloth, OG-106, conforming to type I, class 2 of MIL-C-508.

3.2.4 Buckram. The material for interlining the collar shall be cotton buckram cloth conforming to type I, class 1, natural or bleached of CCC-C-438.

3.2.5 Webbing, elastic. The webbing for sleeve adjusting straps shall be cotton, elastic, 1-1/4 inches wide, Olive Drab 7 conforming to type I, class 8 of JJ-W-155. Alternatively, the webbing for sleeve adjusting straps shall be cotton, elastic, 1-1/4 inches wide, Olive Drab 7, shuttleless type conforming to type I, class 28 of JJ-W-155.

3.2.6 Tapes, reinforcing.

3.2.6.1 Webbing, nylon. The reinforcements for drawcord outlets, for socket portion of snap fasteners at back of parka, and for neck button tabs shall be nylon webbing, 1 inch in width, Olive Drab 7 conforming to type IV of MIL-T-5038.

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3.2.6.2 Tape. The tape for reinforcing the name tape shall be cotton, 1-1/2 inches in width, Olive Drab 7 conforming to type I, class 3 of MIL-T-43566.

3.2.7 Braids, drawcord.

3.2.7.1 Waist drawcord. The waist drawcord shall be solid tubular cotton braid conforming to type IV, class 1, 4/32 inch diameter or type V, class 1, 6/32-inch diameter, Olive Drab 7 of MIL-B-371.

3.2.7.2 Bottom drawcords. The drawcords at bottom of the parka shall be cotton elastic cord, 3/16 inch diameter, Olive Drab 7, conforming to class 2 of MIL-C-43303.

3.2.8 Resin impregnating agent. The resin agent used for dipping or impregnating the ends of the drawcords shall be cellulose acetate or cellulose acetate butyrate to prevent ravelling. The dipped or impregnated end shall be at least 1/2 inch in length (see table II, operation 1.1).

3.2.9 Hanger loop braid. The material for the hanger loop shall conform to type VII, class 2 of MIL-B-371. The color shall match the basic material.

3.2.10 Thread. The thread shall be cotton-covered polyester thread conforming to MIL-T-43548, ticket numbers 30 and 50, 2 or 3 ply and 70, 2 ply. The thread shall be dyed Olive Drab S-1, C.A. 66022 and shall be water-repellent treated in accordance with type II, class 3 of MIL-T-3530.

3.2.10.1 Colorfastness of thread. The dyed thread shall show fastness to light and laundering (after 3 cycles) equal to or better than the standard sample (see 6.4). When no standard sample is available, the dyed thread shall show "good" fastness to light and laundering (after 3 cycles).

3.2.11 Gimp. The cotton gimp for reinforcing buttonholes shall be size 8, Olive Drab S-1, C.A. 66022, conforming to type I or type II of V-T-280.

3.2.12 Buttons. The buttons shall conform to type II, class D, style 26, 30-line and style 20 or 21, 45-line of V-B-871. The color of the buttons shall be Olive Green Shade BP, Cable No. 62016 and the finish shall be dull.

3.2.13 Fastener, slide, interlocking. The slide fasteners for the coat fronts shall be type IV, style 8, size MHS, 22 inches long individual element brass or molded plastic chain according to V-F-106 requirements except that the plastic chain shall have a crosswise breaking strength of 160 pounds (min). The tape shall be in accordance with V-F-106 requirements and dyed Olive Drab Shade S, Cable No. 66519. Plastic chain color shall match the tape and be equipped with a slider pull having a hole with sufficient size to accommodate the 3/8 inch thong. Brass chain shall have a slider with wire stirrup pull and 3/8 inch thong.

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3.2.14 Snap fasteners. The snap fasteners shall conform to style 2A, brass, finish 2, male and female complete, consisting of stud and eyelet size 1 or 2 with button size 1 or 2 and socket of MIL-F-10884 except an uncapped button may be used to attach the socket.

3.2.15 Eyelets. The eyelets for drawcord outlets shall be brass and shall conform to M20652/1-BBE 117 of MIL-E-20652, except that the finish shall approximate the shade of the basic material.

3.2.16 Labels. Each parka shall have a combination identification-size label and an instruction label conforming to type VI of DDD-L-20. The labels shall show fastness to laundering. The following cable numbers of the Standard Color Card of America are furnished for information and guidance as to the intensity of the shade desired for the labels. The label shall be medium green.

Cable No. 70034

Cable No. 70130

Cable No. 70131

3.2.16.1 Identification-size label. The combination identification-size label shall be a combination of class 1 and class 2 labels. The size information shall be as follows:

<u>X-Small</u>	<u>Small</u>	<u>Medium</u>
Chest: Up to 33 inches	Chest: From 33 to 37 in.	Chest: From 37 to 41 in.
Stock No.	Stock No.	Stock No.
NATO Size: 7080/7484	NATO Size: 7080/8494	NATO Size: 7080/9404
	<u>Large</u>	<u>X-Large</u>
	Chest: From 41 to 45 inches	Chest: From 45 inches and upward
	Stock No:	Stock No:
	NATO Size: 7080/0414	NATO Size: 7080/1424

3.2.16.2 Instruction label. The instruction label shall conform to class 3, and contain the following information:

PARKA, EXTREME COLD WEATHER

1. Wear as outer garment in cold-dry climate.
2. Button in liner for extra warmth. Remove it when damp or wet and allow to dry.
3. Button on fur ruffed hood for increased head protection.
4. Fasten drawstrings at waist and bottom for maximum warmth. Tighten sleeve cuffs by drawing elastic tabs tightly around wrists and buttoning tabs.

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PARKA, EXTREME COLD WEATHER (cont'd)

5. Tie the drawstrings around each thigh to provide greater freedom of movement and an additional water repellent surface to sit on. When bottom extension is not needed, turn it up on inside of parka and fasten with snap fasteners.
6. Loosen drawstrings, open zipper, and unbutton elastic tabs on sleeve cuffs to ventilate. AVOID overheating.
7. Brush off snow and frost before entering heated shelters.
8. Avoid contact with heated stoves, open fires, or other high heat sources; fabric may fuse.
9. Lubricate brass slide fastener with lead pencil, graphite or wax.
10. For cleaning and restoring of water repellency return to laundry for machine washing in accordance with established procedure for Quarrel treated garments. The slide fastener shall be closed when laundered.
11. Pressing is acceptable provided the front flap of the parka overlaps the zipper and the temperature of the steam press does not exceed 300°F. When using a hand iron, do not iron over zipper.

DO NOT REMOVE THIS LABEL

3.2.16.3 Combination size, identification, and instruction label. The identification label (class 1), size label (class 2) and instruction label (class 3) may be combined into one label. The combination label shall conform to the requirements of the class 14 label.

3.3 Design. The parka is a single breasted outer garment without hood and with slide fastener front closure with snap fasteners, sleeves with adjustable cuffs, two slit type breast pockets with flap and snap fastener closure, waist and hem line drawcords, inside buttons for attachment of liner, and buttonholes on stand-up collar for attachment of fur ruffed hood.

3.4 Figure. Figure 1 is furnished for information only. If there are any inconsistencies between the written specification and the figure, the written specification shall control.

3.5 Patterns. Standard patterns shall be furnished by the Government and will provide an allowance of 1/2 inch for double-lapped and double-stitched seam and 3/8 inch for all other seams. The standard patterns are provided as a guide for cutting contractor's working patterns and shall not be altered in any way. The working patterns shall be identical to the standard patterns.

3.5.1 List of pattern parts. The pattern parts shall be cut from material as specified and according to the number of parts listed in table I.

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TABLE I List of pattern parts

Materials	Nomenclature	Cut parts
Cotton warp and nylon filling, oxford cloth	Collar	2
	Right front	1
	Left front	1
	Back	2
	Pocket flap	4
	Sleeve adjustment tab	2
	Pocket welt	2
	Hanging pocket	4
	Left facing interlining (wide)	1
	or	
	Left facing interlining (narrow)	1
	Right facing interlining (wide)	1
	or	
	Right facing interlining (narrow)	1
	Top sleeve	2
Under sleeve	2	
Sleeve tunnel	2	
Wool and cotton flannel cloth or knitted nylon fleece cloth	Hanging pocket lining	4
Buckram	Collar interlining	1

3.6 Construction.

3.6.1 Stitches, seams, and stitching. All stitches, seams, and stitching shall conform to FED-STD-751. The type of seam, stitching, and stitches per inch shall be as specified in table II. Seam allowances shall be maintained with seams sewn so that no raw edges, run-offs, pleats, puckers, or open seams occur. When two or more methods of seams or stitches are given for the same operation, any one may be used. Where stitch type 401 is used, the looper (under thread) shall be on the inside of the parka. Unless otherwise indicated, the gage of stitching for the double-lapped, double-stitched seam shall be 3/8 to 3/16 inch. Seams required to be worked out having a depth between the fold of 1/16 inch or more shall be considered a defect.

3.6.1.1 Type 301 stitching. Ends of all stitchings shall be backstitched or overstitched not less than 1/4 inch except where ends are turned under or caught in other seams or stitching. Ends of a continuous line of stitching shall overlap not less than 1/2 inch. Thread tensions shall be maintained so that there will be no loose bobbin or top thread or excessively tight stitching resulting in puckering of the materials sewn. The lock shall be imbedded in the materials sewed.

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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 stitching, the stitching shall be repaired by restarting the stitching a minimum of 1/2 inch back of the end of the stitching. 1/

b. Thread breaks or two or more consecutive skipped or run-off stitches noted during inspection of the item shall be repaired by overstitching. The stitching shall start a minimum of 1/2 inch in back of the defective area, continue over the defective area, and continue a minimum of 1/2 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. All repairs shall be in accordance with 3.6.1.1.1 a. and 3.6.1.1.1 b. Repairs to stitch type 401 may be accomplished by use of stitch type 301.

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

3.6.3 Buttonholes. Buttonholes shall be the cut after, eyelet end, taper bar type, worked over gimp with not less than four tacking stitches at bar end (not counting crossover stitch). The purling shall be on the outside unless otherwise specified.

3.6.4 Bartacking. Bartacking shall be $1/2 \pm 1/16$ inch in length and $1/8 \pm 1/32$ inch in width and shall contain 28 stitches. Bartacking shall be free from thread breaks and loose or tight stitching.

3.6.5 Use of automated apparel equipment. Automated apparel equipment may be used to perform any of the operations specified in table I, providing that the seam and stitch type are as specified and the finished component conforms to the required configuration. When a government furnished shaper pattern is forwarded, the component shall conform to that pattern.

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

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NO.	TABLE II. MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
1.	<p><u>Cutting.</u></p> <p>a. Cut the material in strict accordance with patterns furnished which show directional lines, marks, and notches for proper assembly. Directional lines shall be placed in the warp direction of the material.</p> <p>b. Cut all parts from one piece of material, except waist drawcord tunnels, pocket flap linings, pocket welts, right and left facing interlining, hanging pockets, sleeve tunnels, and sleeve adjustment tabs which may be cut from ends.</p> <p>c. The sleeve tunnels and sleeve adjustment tabs shall approximate the shade of the parka. The pocket welts and waist tunnel may be cut and placed on rolls for machine attachment.</p> <p>d. Cut reinforcements for pocket flaps from basic material or buckram of sufficient size to reinforce the snap fastener pockets (see operation 6.a).</p> <p>e. Cut 1-1/4 inch elastic webbing pieces for sleeve closure adjustment of sufficient length to conform to finish measurements of operation 14.f.</p> <p>f. Cut 1 inch webbing for drawcord eyelet reinforcements, on fronts of parka, of sufficient length to conform with operation 19.a. (Cut two per parka).</p> <p>g. Cut 1 inch webbing for reinforcement for socket portion of snap fastener of sufficient length to comply with operation 11.c. (Cut one per parka).</p>						

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NO.	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D																				
					NEEDLE	BOBBIN/ LOOPER	COVER																		
1.	<p><u>Cutting.</u> (cont'd)</p> <p>h. Cut drawcords in the following minimum lengths:</p> <table border="1"> <thead> <tr> <th>Sizes</th> <th>Waist (cut one) (inches)</th> <th>Bottom (cut two) (inches)</th> </tr> </thead> <tbody> <tr> <td>X-Small</td> <td>50</td> <td>39</td> </tr> <tr> <td>Small</td> <td>54</td> <td>41</td> </tr> <tr> <td>Medium</td> <td>58</td> <td>43</td> </tr> <tr> <td>Large</td> <td>62</td> <td>45</td> </tr> <tr> <td>X-Large</td> <td>66</td> <td>47</td> </tr> </tbody> </table> <p>i. Impregnate or dip ends of the drawcords (see 3.2.8).</p> <p>j. Cut 1-inch webbing for neck button tabs of sufficient length to comply with operation 23. The ends of all the nylon webbing shall be fused.</p> <p>k. Cut reinforcement tape for name tape to finish $6 \pm 1/8$ inches in length (see operation 10.b.).</p> <p>l. Cut waist tunnel of sufficient length and width to conform to operations 20.e and 20.g.</p> <p>m. Cut hanger loop of sufficient length to comply with finished length in operation 23.</p> <p>n. Cut the back snap fastener reinforcement piece of basic material to finish $1 + 1/8$ inch in width and $4 + 1/2$ inches in length (see operation 11.c).</p> <p>o. Cut the pocket binding of nylon oxford cloth, on the bias, of sufficient width to conform to operation 8.m.</p>	Sizes	Waist (cut one) (inches)	Bottom (cut two) (inches)	X-Small	50	39	Small	54	41	Medium	58	43	Large	62	45	X-Large	66	47						
Sizes	Waist (cut one) (inches)	Bottom (cut two) (inches)																							
X-Small	50	39																							
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NO.	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN/ LOOPER COVER
2.	<p><u>Replacement of defective or damaged parts.</u></p> <p>During the spreading, cutting and manufacturing process, components having material defects or damages that are classified as defects in 4.4.2 shall be removed from production and replaced with non-defective and properly matched components.</p>					
3.	<p><u>Marking.</u></p> <p>Mark, ticket or bundle all components, except those cut from ends, to insure a uniform shade and size throughout the parka. Any method of marking may be used except:</p> <ul style="list-style-type: none"> a. Corrosive metal fastening devices. b. Sew-on type tickets. c. Adhesive type tickets which leave traces of paper or adhesive on the material upon removal of the tickets. 					
4.	<p><u>Labeling.</u></p> <p>Stitch around four sides of each label, not more than 3/16 inch from edges of the label, to inside of the parka in the following locations:</p> <ul style="list-style-type: none"> a. <u>Identification-size label.</u> Center label over back seam, 1 to 1-1/2 inches below collar seam. b. <u>Instruction label.</u> Position label on right front at bottom, 1 + 1/2 inches up from top edge of hem and 2 + 1/2 inches from right front facing. 	301	LSbj-1	10-14	50	50

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NO.	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN/ LOOPER COVER
4.	<p><u>Labeling.</u> (cont'd)</p> <p>c. Combination, size, identification and instruction label. (See 3.2.16.3) Attach as specified in a. above.</p>					
5.	<p><u>Make collar.</u></p> <p>a. Position interlining on undercollar and collar and stitch around top and side edges, trim, turn, work out points and edges and edge stitch 3/16 to 1/4 inch from edge, leaving ends open for joining collar to neck.</p>	301 or 401 and 301	SSe-2(a) SSe-2(b)	10-14 10-14	50 50 50	50 70 50
6.	<p>b. Make four 3/4 to 7/8 inch buttonholes on collar at marks as indicated by marks on pattern with eyelet end toward top of collar with purling finishing to underside of collar.</p> <p><u>Make pocket flaps.</u></p> <p>a. Attach socket part of snap fastener to lining through reinforcement piece (see operation 1.d), centered on the width of the pocket flap, with center of socket 1 + 1/8 inches from point of flap when finished.</p> <p>b. Seam the outer edges of flap and lining pieces together, trim, turn flap, and work out edges and points.</p> <p>c. Single stitch 3/16 to 1/4 inch from turned edge.</p>	Button- hole 301 or 401 301	-	44-46 per button- hole in- cluding tack	30	50 50 50 50

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NO.	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN/ LOOPER COVER
7	<u>Make two pocket welts.</u> Fold the welt piece of the basic material as shown by patterns and stitch 1/8 to 3/8 inch from folded edge. Place a second row of stitching 1 to 1-1/4 inches from first row.	301	OSf-2	10-14	50	50
8	<u>Make side pockets.</u> a. Seam basic material and flannel pocket pieces together 3/16 to 1/4 inch from edge. (This operation may be omitted if it is not necessary for satisfactory performance of operation b.) b. Position underplies of hanging pockets and flaps to fronts at marks as indicated by patterns and stitch through flap, front, and underplies of hanging pocket with a second row of stitching 1/2 inch below top row of stitching. On the finished parka, the flannel shall be on the inside of the pockets. c. Cut pocket opening, forming a tongue notch at each corner. d. Insert the lower side of the opening between welt pieces with the edges of the welt turned in; single stitch 1/16 to 1/8 inch from edge through pocket and welt. - or - e. Seam one ply of welt piece to inside of lower side of pocket opening. Turn up welt, turn under the other ply of welt, and stitch through lower side of pocket opening.	301 301 and 301	SSa-1 SSa-2	4-8 10-14	50 50	50 50 50 50 50

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NO.	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN/LOOPER COVER
8.	<p><u>Make side pockets.</u> (cont'd)</p> <p>f. Turn in the raw edges of corners of pocket opening and securely tack catching corners of the welt. Turn in ends of welt and seam to flap with ends of stitching securely tacked.</p> <p>g. Bartack corners of welt to the flap.</p> <p>h. Stitch the under and upper plies of hanging pockets together through the flap joining seam allowance with the stitching on the underply of pocket 1/16 to 1/8 inch gage from the flap joining seam.</p> <p>i. Turn down flap and raise stitch through pocket 1/16 to 1/8 inch from edge.</p> <p>j. Attach snap fastener stud to parka corresponding to the socket in pocket flap, through front and underplies of hanging pocket piece.</p> <p>k. Seam the hanging pocket pieces together across top edge.</p> <p>l. Seam pocket pieces together around the outside edges with the safety stitch 7/16 ± 1/16 inch from the edge.</p> <p>m. Bind around edges of pockets, with raw edges of binding turned in a minimum of 1/4 inch. The binding shall be stitched 3/16 to 1/4 inch gage from the pocket edges. The binding shall finish 1/2 + 1/16 inch in width with all binding turn-ins <u>securely sewn.</u></p>	<p>301 and 301</p> <p>Bartack</p> <p>301</p> <p>301</p> <p>301</p> <p>301</p> <p>515 or 516</p> <p>301</p>	<p>LSD-1 and LSB-1</p> <p>-</p> <p>SSa-1</p> <p>LSq-2</p> <p>SSa-1</p> <p>SSa-2</p> <p>BSc-1</p>	<p>10-14</p> <p>10-14</p> <p>28 per bartack</p> <p>10-14</p> <p>10-14</p> <p>10-14</p> <p>10-14</p> <p>10-14</p>	<p>50</p> <p>50</p> <p>50</p> <p>50</p> <p>50</p> <p>50</p> <p>50</p> <p>50</p>	<p>50</p> <p>50</p> <p>50</p> <p>50</p> <p>50</p> <p>50</p> <p>50</p>

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NO	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D	
					NEEDLE	BOBBIN/ LOOPER COVER
8.	<p><u>Make side pockets.</u> (cont'd)</p> <p>n. Fold back the end of the binding and securely tack or bartack. The free end of the binding shall be trimmed close to the bartack.</p>	301 or Bartack	-	10-14 28 per bartack	50 50	50 50
9.	<p><u>Make front facings.</u></p> <p>a. Position the wide interlinings to fronts as indicated by marks on patterns, with front edges even. Stitch interlining to the fronts along front edge. Turn interlinings to back side of fronts and edge stitch fronts 3/16 to 1/4 inch from edge.</p> <p style="text-align: center;">- or -</p> <p>b. Position narrow interlinings to fronts as indicated by marks on pattern; turn front edges of fronts over front edge of interlinings, turn in raw edges of fronts, and edge stitch fronts through center of turned under hems.</p> <p>c. Attach five snap fastener socket parts through left facing and interlinings as indicated by marks on pattern, $3/4 + 1/16$ inch from finished front edge of parka.</p>	301 or 401 and 301	SSe-2(a) SSe-2(b)	10-14 10-14	50 50 50	50 70 50
10.	<p><u>Make fronts.</u></p> <p>Finished appearance. The fronts shall finish flat and smooth without twists, gathers, puckers or raw edges and without distortion of the front edges.</p>	301	SSI-1	10-14	50	50

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NO.	MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN/LOOPER COVER
10.	<p><u>Make fronts.</u> (cont'd)</p> <p>a. Turn facings and interlining to inside as indicated by marks on pattern; edge stitch front edges, through interlinings and facings, 3/16 to 1/4 inch from turned edges. The stitching shall continue to bottom raw edges.</p> <p>b. Turn under raw ends of the reinforcement tape (for name tape) and stitch to right front as indicated by marks on pattern, 1/16 to 1/8 inch from edge (see operation l.k).</p>	301	OSF-1	10-14	50	50
11.	<p><u>Make backs.</u></p> <p>a. Hem the edges of the V-opening on back with the raw edges turned in and single stitch 1/4 to 3/8 inch from edges.</p> <p>b. Join the center back seam of parka from neck to top of vent with a double lapped, double stitched seam 1/4 to 5/16 inch gage. The right or left back parts may be on the top.</p> <p>c. Position reinforcement for socket portion of snap fasteners (see operation l.g) on the inside of parka, center across center back seam as indicated by marks on pattern, and stitch on all four sides. The reinforcement shall finish 4 + 1/2 inches long. A double ply of the basic material with all raw edges turned in may be used in lieu of the tape for reinforcement (see operation l.n).</p>	301 301 or 401	EFB-1 LSc-2 LSbj-1	10-14 10-14 10-14	50 30 30	50 30 50

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NO.	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D	
					NEEDLE	BOBBIN/ LOOPER COVER
11.	<u>Make backs.</u> (cont'd) d. Attach two snap fastener sockets to the backs of parka, through the reinforcement and back as indicated on patterns with the socket parts on the inside of parka.	301 or 401	LSc-2	10-14	30 30	30 50
12.	<u>Join shoulder seams.</u> Join the shoulder seams with a double-lapped and double-stitched seam with the fronts on top of the backs.	301 or 401	LSc-2	10-14	30 30	30 50
13.	<u>Make sleeves.</u> a. Join back arm seam of sleeves with a double-lapped and double stitched seam with the top sleeves on top of the undersleeves. The pleats shall be formed on the undersleeve as indicated by pattern, with outside folded edge of pleat toward bottom edge of sleeve, and caught in backarm seam. b. The pleats may be formed and stitched prior to the joining operation.	301	SSa-1	10-14	50	50
14.	<u>Make two elastic sleeve adjusting straps.</u> a. Make sleeve adjusting strap from elastic webbing and equip with a buttonhole tab made of basic material (see figure 1). b. Fold the buttonhole tab in half lengthwise, seam the raw edges of the side and point, trim, turn, and work out point.	301 or 401	SSe-2(a)	10-14	50 50	50 70

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NO.	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN/LOOPER COVER
14.	<p><u>Make two elastic sleeve adjusting straps.</u> (cont'd)</p> <p>c. Insert the elastic webbing into the tab for a distance of $3/4 + 1/4$ inch.</p> <p>d. Turn in the raw edges of the opening of the tab and single stitch $1/16$ to $1/8$ inch with the stitching continued all around buttonhole tab, $3/16$ to $1/4$ inch from edge, catching the elastic webbing in the stitching with the ends of the stitching securely tacked.</p> <p>e. Place a second row of stitching across back end of tab $5/16 + 1/8$ inch from first row, catching the elastic webbing.</p> <p>f. The finished length of the completed adjusting strap shall be $8 + 1/2$ inches (see operation 1.e).</p>	301	LSe-1 and SSE-2 and OSf-1	10-14	50	50
15.	<p><u>Make buttonhole in tab.</u></p> <p>Make a $1-1/4$ to $1-3/8$ inch (finished cut length) buttonhole in the center of the adjusting strap tab ($1/4$ inch off center tolerance) with the inside edge of eyelet $1/2$ to $5/8$ inch from point.</p>	301	LSe-2 show finished seam	10-14	50	50
16.	<p><u>Make tunnel for sleeve adjusting strap and attach to sleeve.</u></p> <p>a. Hem one end of the tunnel facing with the raw edge turned in and stitch to form outlet for adjusting strap. Hem shall measure $1/2 + 1/8$ inch wide.</p>	Button-hole		72-74 per button-hole including tack	30	50
		301	EFb-1	10-14	50	50

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NO.	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD		
					NEEDLE	BOBBIN/LOOPER	COVER
16.	<p><u>Make tunnel for sleeve adjusting strap and attach to sleeve.</u> (cont'd)</p> <p>b. Seam the tunnel facing to the bottom of the sleeve on the outside with a double row of stitching, 1-1/2 + 1/8 inch gage, with all raw edges turned in and caught within the stitching. Tunnel facing shall finish 1-7/8 + 1/8 inches wide. Leave end of tunnel open a sufficient length for sleeve seam joining.</p> <p>c. The hemmed end shall finish at the underarm seam with the tunnel opening facing the undersleeve.</p> <p>d. The sleeve adjusting strap shall be inserted into tunnel and seamed through sleeve and facing, catching the back edge of the elastic webbing in the stitching.</p> <p>e. The buttonhole tab shall extend 1/4 to 1/2 inch beyond the outlet.</p>	301	LSK-2	10-14	50	50	
17.	<p><u>Sew in sleeve.</u></p> <p><u>Finished appearance.</u> The sleeves shall be uniformly set to the armhole without gathers, pleats or raw edges.</p> <p>Join the sleeve to the armhole at marks indicated on pattern with a double-lapped and double-stitched seam, 1/4 to 5/16 inch gage, with the fronts and back on top of sleeve.</p>	301 401	LSc-2	10-14	30 30	30 50	

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NO	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
18.	<p><u>Join side and sleeve seams.</u></p> <p>a. Join side seam and underarm sleeve seams with a double-lapped and double-stitched seam, with the fronts on top of backs.</p> <p>b. Complete the seaming of the end of the sleeve tunnel facing with a double row of stitching, 1-1/2 + 1/8 inch gage. Side edges of elastic webbing and adjustment tab shall not be caught in the stitching. All ends of stitching shall be securely backstitched.</p>	301 or 401	LSc-2	10-14	30 30	30 50	
19.	<p><u>Attach reinforcement piece and eyelet for waist drawcord.</u></p> <p>a. Position eyelet reinforcements (see operation 1.f) on each front as indicated by marks on pattern and stitch on all four sides. The reinforcements shall finish 1 + 1/4 inches long.</p> <p>b. Prepunch a hole through the materials prior to eyelet attachment. The hole should be slightly smaller than the eyelet diameter. Attach an eyelet in the center of each reinforcement piece through the prepunched hole of the reinforcement piece and basic material with rim of eyelet to the outside of the parka.</p>	301	LSK-2	10-14	50	50	
20.	<p><u>Make tunnel for waist drawcord.</u></p> <p>a. Mark position for waist tunnel on parka as indicated by marks on pattern.</p>		LSbj-1	10-14	50	50	

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NO.	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN/ LOOPER COVER
20.	<p><u>Make tunnel for waist drawcord.</u> (cont'd)</p> <p>b. Turn in the raw edges of the end of the tunnel strip $1/2 + 1/8$ inch and stitch across folded ends $1/4$ to $5/16$ inch from turned edge.</p> <p>- or -</p> <p>c. The raw edges of the ends of the tunnel strip may be turned in $1/2 + 1/8$ inch and caught in the tunnel stitching.</p> <p>d. Turn in the raw edges of the sides of the tunnel strip and stitch to inside of the parka as indicated by marks on pattern, $1/16$ to $1/8$ inch from each turned edge, with drawcord inserted. Drawcord shall not be caught in tunnel stitching.</p> <p>e. The ends of the tunnel shall begin and end $1/2$ to 1 inch from each side seam on the back of the parka (see operation 1.1).</p> <p>f. Thread the drawcord through exit eyelet on front with the drawcord in back of the pocket. Knot the ends of drawcord to prevent return into tunnel.</p> <p>g. The tunnel shall finish $1 + 1/8$ inches wide (see operation 1.1).</p>	301	EFa-1	10-14	50	50
		301	-	10-14	50	50
		301	Lsd-1 each edge	10-14	50	50
21.	<p><u>Hem bottom of parka, insert drawcords.</u></p> <p>a. Hem bottoms with the raw edges turned in $1/4$ to $3/8$ inch and stitch $1/16$ to $1/8$ inch from turned-in edge, enclosing the drawcords within the fold.</p>	301	EFb-1	10-14	50	50

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NO.	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN/LOOPER COVER
21.	<p><u>Hem bottom of parka, insert drawcords.</u> (cont'd)</p> <p>The hem shall finish $1-1/8 + 1/4$ inches wide. Drawcords shall not be caught in the stitching.</p> <p>b. See operation 26 and 3.6.4 for bartack requirements.</p>					
22.	<p><u>Sew on slide fastener.</u></p> <p>a. Mark the position for slide fastener on right front and left facing as indicated on patterns. Catch the top edge of the tape in collar neck seam in subsequent operation 23.</p> <p>b. Seam the tape full length through shell and facing $1/16$ to $1/8$ inch from each edge of tape; with a second row of stitching $1/4 + 1/16$ inch from back edge of slide fastener chain.</p>	301	SSau-2	10-14	50	50
23.	<p><u>Attach collar, neck tabs and hanger loop.</u></p> <p><u>Finished appearance.</u> The collar at neck shall finish smooth without being tight, puckered, twisted, or pleated. The hanger loop and three button tabs shall be caught in seaming of the undercollar to the neck of the parka. The hanger loop shall finish $5-1/4 + 1/4$ inches in length and shall be centered on neck with the ends positioned $4 + 1/4$ inches apart, (measured from outer edge to outer edge). The three button tabs shall be positioned as indicated by marks on pattern. The tabs shall finish $1-1/2 + 1/4$ inches in length (see operation 1.J).</p>					

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NO.	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	THREAD	
					NEEDLE	BOBBIN/LOOPER COVER
23.	<p><u>Attach collar, neck tabs and hanger loop.</u> (cont'd)</p> <p>a. Seam undercollar to neck of coat, turn up undercollar, and raise stitch 1/16 to 1/8 inch from edge.</p> <p>b. Turn in raw edge of top collar and seam to neck of coat, 1/16 to 1/8 inch from turned edge.</p> <p>c. Secure each end of hanger loop with a horizontal bartack through collar.</p>	301 301 Bartack	LSq-2 LSD-1	10-14 10-14 28 per bartack	30 30 50	30 30 50
24.	<p><u>Mark and attach studs.</u></p> <p>a. Mark the position for five stud parts of snap fasteners on the right front of parka to correspond with socket parts on left front and securely attach the studs through front and facing at marks. The studs shall be 2-3/4 + 1/16 inch from finished front edge of parka. Studs shall not catch slide fastener tape.</p> <p>b. Mark the position of socket for accommodating the hood. The socket part shall be on the underside of right front as indicated by pattern. Clinch socket through all plies.</p>					
25.	<p><u>Buttons.</u></p> <p>a. Sew three 30-line buttons to button tabs, centered 5/8 to 3/4 inch from bottom edge of tab.</p>	301 or 101		14-16 per button 14-16 per button	30 30	30

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NO.	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
25.	<p><u>Buttons.</u> (cont'd)</p> <p>b. Sew five 30-line buttons on inside of parka through facing and right front as indicated by marks on pattern, 1/8 inch off marks indicated shall be acceptable.</p> <p>c. Sew five 30-line buttons on inside of parka through left front facing and interlining only, as indicated by marks on pattern, 1/8 inch off marks indicated shall be acceptable.</p> <p>d. Sew one 45-line button on each undersleeve through all plies, centered on facing (1/4 inch off center tolerance) and 6 ± 1/2 inches from sleeve adjustment outlet.</p> <p>e. Sew two 30-line buttons on the inside of each sleeve, one through undersleeve seam and one through top sleeve seam, each button 2-1/4 + 1/4 inches from end of sleeve</p>	<p>301 or</p> <p>101</p> <p>301 or</p> <p>101</p> <p>301 or</p> <p>101</p> <p>301 or</p> <p>101</p>		<p>14-16 per button</p> <p>14-16 per button</p> <p>14-16 per button</p> <p>14-16 per button</p> <p>14-16 per button</p> <p>14-16 per button</p> <p>14-16 per button</p>	<p>30</p> <p>30</p> <p>30</p> <p>30</p> <p>30</p> <p>30</p> <p>30</p>	<p>button</p> <p>button</p> <p>button</p> <p>button</p> <p>button</p> <p>button</p>	
26.	<p><u>Bartacks</u> (see 3.6.4).</p> <p>a. Bartack the bottom end of each slide fastener tape at the back edge with a diagonal or horizontal bartack.</p> <p>b. Bartack the top of the vent at bottom of back panels with a horizontal bartack.</p> <p>c. Bartack each end of the stitching on bottom draw-cord hem with horizontal bartacks.</p>	<p>Bartack</p> <p>Bartack</p> <p>Bartack</p>		<p>28 per bartack</p> <p>28 per bartack</p> <p>28 per bartack</p>	<p>50</p> <p>50</p> <p>50</p>		

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NO	TABLE II. (cont'd) MANUFACTURING OPERATIONS REQUIREMENTS	STITCH TYPE	SEAM AND STITCHING TYPE	STITCHES PER INCH	T H R E A D		
					NEEDLE	BOBBIN/ LOOPER	COVER
26.	<p><u>Bartacks (see 3.6.4).</u> (cont'd)</p> <p>d. Bartack the outside corners of side pocket with vertical bartack.</p> <p>e. Bartack the bottom drawcords with vertical bartacks through the tunnels, center on side seams.</p>	Bartack Bartack		28 per 28 per bartack bartack	50 bartack 50 50		
27.	<p><u>Attach vent fasteners (stud).</u></p> <p>Securely attach a snap fastener stud through bottom hem on each side of vent opening with the stud part on the inside of the parka. The stud shall be positioned toward the bottom of the hem.</p>						
28.	<p><u>Clean parka.</u></p> <p>a. Trim and remove all thread ends.</p> <p>b. Remove all spots and stains.</p> <p>c. Remove all shade and size tickets or markings.</p>						

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3.8 Measurements. The parka shall conform to the finished measurements shown in table III.

TABLE III. Finished measurements (inches)

Size	Half chest <u>1/</u>	Back length <u>2/</u>	Sleeve length <u>3/</u>
X-Small	25	41	25
Small	27	41-1/2	25-1/2
Medium	29	42	26
Large	31	42-1/2	26-1/2
X-Large	33	43	27
Tolerance	+ 3/4	+ 1	+ 3/4

1/ The chest shall be measured at the base of the armholes, from folded edge to folded edge, with front closed.

2/ The back length shall be measured along center back from neck seam to extreme bottom edge of garment.

3/ The sleeve shall be measured from top of sleeve to bottom of sleeve (see figure 1).

3.9 Workmanship. The finished parka shall conform to the quality of product established by this specification and the occurrence of defects shall not exceed the applicable acceptable quality levels.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements (examinations and tests) as specified herein. Except as otherwise specified in the contract or purchase order, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in this specification where such inspections are deemed necessary to ensure supplies and services conform to prescribed requirements.

4.1.1 Responsibility for compliance. All items shall meet all requirements of sections 3 and 5. The inspection set forth in this specification shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirement in the specification shall not relieve the contractor of the responsibility of ensuring that all products or supplies

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submitted to the Government for acceptance comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations is an acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to accept defective material.

4.1.2 Responsibility for dimensional requirements. Unless otherwise specified in the contract or purchase order, the contractor is responsible for ensuring 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 ensure compliance with all dimensional requirements.

4.1.3 Certificates of compliance. When certificates of compliance are 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).

4.3 First article inspection. When a first article is required (see 3.1.1 and 6.2), it shall be examined for the defects specified in 4.4.2 and 4.4.3

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

4.4.1 Component and material inspection. In accordance with 4.1, components and materials shall be inspected in accordance with all the requirements of referenced documents unless otherwise excluded, amended, modified, or qualified in this specification or applicable purchase document.

4.4.2 End item visual examination. The end items shall be examined for the defects listed in table IV. The lot size shall be expressed in units of parkas. The sample unit shall be one parka. The inspection level shall be II and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 2.5 for major defects, 15 for major and minor A combined defects, and 40 for total (major, minor A, and minor B combined) defects.

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TABLE IV. End item visual defects

Examine	Defect	Classification	
		Major	Minor A B
Material defects and damages	Any weakening defect such as a smash, multiple float, or slub	101	
	Any hole, cut, tear, mend, burn, or needle chew	102	
	Shade bar on outside		201
	One or more drill holes exposed		202
Shaded parts	Any outside part shaded (except parts cut from ends)		203
Cleanness	Any spot or stain on outside		204
	Two or more shade or size tickets not removed or thread ends not trimmed or not removed throughout parka		301
Components and assembly	Any component part or required operation omitted (unless otherwise classified)	103	
	Any operation not performed as specified (unless otherwise classified herein)		302
Cutting	Any part not cut in accordance with directional lines on pattern or not cut in accordance with document requirements	104	
Seams and stitching	Accuracy of seaming:		
	1. Seam twisted, puckered, or pleated		205
	2. Seam not lapped as specified (unless otherwise classified)		206
	3. Part of parka caught in any unrelated operation or stitching	105	
	4. End of stitching (when not caught in other seams or stitching) backtacked less than 1/4 inch		207
	5. Thread break secured by stitching back of the break less than 1/2 inch		303
6. Ends of a continuous line of stitch- ing overlapped less than three stitches on labels and box stitching or less than 1/2 inch on all other stitching		304	

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TABLE IV. End item visual defects (cont'd)

Examine	Defect	Classification	
		Major	Minor A B
Seams and stitching (cont'd)	Gage of stitching and seam allowances:		
	1. Irregular i.e., unevenly gaged or corresponding stitchings not uniformly gaged (to be scored only when condition exists along major portion of seam)		208
	2. Edge of raised stitching sewn too close to edge resulting in damage to cloth		209
	3. Width not as specified or not within range of gage specified or varies more than 1/16 inch when no range is specified		305
	4. Seam allowance not as specified		210
	Broken, missing, or skipped stitches		
	1. On all joining seams except at waist, bottom, and sleeve tunnels and at back edge of facings: -up to 1/4 inch inclusive -more than 1/4 inch to 1 inch, inclusive -more than 1 inch	106	306 211
	2. On waist, bottom and sleeve tunnels or at back edge of facings: -up to 3/4 inch inclusive -more than 3/4 inch		307 212
	Raw edges more than 1/4 inch long		308
	Run-offs over 1 inch		309
	Seam and stitch type:		
	1. Not specified seam or stitch type		213
	2. Looper thread exposed on the outside of parka when 401 stitch type is used	107	
	Stitch tension (except on bartacks):		
	1. Loose tension resulting in a loose seam	108	
	2. Loose tension on edge or raised stitching resulting in exposed bobbin or top thread		214

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TABLE IV. End item visual defects (cont'd)

<u>Examine</u>	<u>Defect</u>	<u>Classification</u>	
		<u>Major</u>	<u>Minor</u> A B
Seams and stitching (cont'd)	3. Tight tension (stitches break when strain is applied in direction of seam)	109	
	Stitches per inch (to be scored only when the condition exists on the major portion of the seam or stitching) more than maximum or less than minimum		310
Bartacks	Missing, insecure, or misplaced to the extent that they do not serve the intended purpose:		
	-one bartack		311
	-two or more bartacks	215	
	Loose stitch tension on one or more bartacks		312
	Broken stitch or stitches		313
Buttonholes	Stitching not securely caught in fabric causing stitching to pull away from fabric	110	
	Finished cut length not as specified		216
	One or more broken or two or more continuous skipped stitches		314
	Not type specified		315
	Gimp omitted		316
	Incomplete stitching		317
	Uncut buttonhole(s)		318
	One or more buttonholes finished with purling on other than specified side		319
	One or more buttonholes omitted, added or misplaced	111	
	Not positioned as specified		217
	Ragged edges		320
	End of buttonholes insecurely tacked (see 3.6.3):		
	-on one buttonhole		218
-on two or more buttonholes	112		

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TABLE IV. End item visual defects (cont'd)

Examine	Defect	Classification	
		Major	Minor A B
Buttons	Missing, misplaced, loose, broken, defective, not attached as specified, or insecurely sewn:		
	-one button		321
	-two or more buttons		219
Drawcords	Cord caught in tunnel stitching	113	
	Dipping or impregnation omitted on: -one or both ends of two or more drawcords		220
	-one or both ends of one drawcord		322
	Knot omitted on both ends of one or more cords		323
	Any drawcord less than specified cut length		221
	Dipping or impregnation less than 1/2 inch in length		324
Snap fasteners	Any part of assembly missing, mismatched, broken, cracked, bent, not securely clinched, affecting function:		
	-one snap fastener		222
	-two or more snap fasteners	114	
	One or more clinched too tightly cutting surrounding fabric	115	
	Loose, i.e., socket or stud spins freely or wobbles in connection portions		223
	One or more having rough or sharp edge	116	
Labels	Not stitched on four sides		325
	Combination identification-size label missing, incorrect, or illegible	117	
	Instruction label missing, incorrect, or illegible		224
	Not attached as specified, misplaced, or stitching through the printing		326
	Combination size, identification and instruction label, missing, incorrect, or illegible	118	

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TABLE IV. End item visual defects (cont'd)

Examine	Defect	Classification	
		Major	Minor A B
Collar	Undercollar or top collar tight at neck seam causing puckering or pleating on fronts or backs		225
	Top collar twisted, causing collar to have diagonal twist		226
	Top collar tight, causing edges to curl		227
	Fullness or puckering on top collar		228
	Collar edge uneven or not properly forced out		229
	Collar buttonholes:		
	1. Eyelets of buttonholes toward bottom of collar		230
	2. Purling on outside of collar		327
	Collar edge not even with front edge by:		
	-more than 1/4 up to 1/2 inch inclusive		328
-more than 1/2 inch		231	
Fronts	Construction:		
	1. Edge irregular		232
	2. Back overlapping front at side seam		329
	Length of closed fronts:		
	1. Fronts uneven at bottom:		
	-1/2 inch up to 3/4 inch, inclusive		330
	-more than 3/4 inch		233
	2. Fronts uneven at neck:		
	-1/4 inch up to 1/2 inch inclusive		331
	-more than 1/2 inch		234
	Snap fastener placement:		
	1. Socket and stud out of alignment causing a noticeable bulge or twist on front when fastened		235
	2. Reversed, i.e., socket on right front and stud on left front		332
3. Out of vertical alignment by 1/4 inch or more		236	
4. Unequally spaced by more than 1/4 inch		237	
5. One or more sockets attached through outside surface of left front	119		
6. One or more studs not attached through right front facing	120		
7. One or more studs catching slide fastener tape	121		

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TABLE IV. End item visual defects (cont'd)

Examine	Defect	Classification		
		Major	Minor A B	
Fronts (cont'd)	Slide fastener:			
	1. Malfunctioning, affecting service-ability	122		
	2. Slide pull broken	123		
	3. Tape:			
	-attached with less than two rows of stitching		238	
	-set on too loosely or too tightly, causing noticeable bulging on tapes or on the opening when closed		239	
	-stitching not through shell and facing on right and left sides		240	
	-stitching too close to metal chain, not allowing chain to be closed or slider to function properly	124		
	-top ends of one or both tapes not caught in collar neck seam		333	
	Short or twisted, causing excessive fullness or twist on front		241	
	Reinforcement tape for name tape:			
	1. Not stitched on four sides or not positioned as specified		242	
	2. Less than 5-7/8 inches or more than 6-1/8 inches in length		334	
	Pockets and flaps	Out of alignment by more than 1/2 inch		243
	Welt construction:			
1. Welt formed with one row of stitching		335		
2. Raw edge on end of welt not turned when stitched to flap		244		
Flap construction:				
Flap lining tight, short, or twisted, causing edge of flap to curl or twist		245		
Pocket construction:				
1. Raw edge at corner of pocket opening not turned under		246		
2. Corner of pocket opening not securely tacked		247		
3. Oxford, fiannel, or fleece piece of hanging pocket omitted	125			

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TABLE IV. End item visual defects (cont'd)

Examine	Defect	Classification	
		Major	Minor A B
Pockets and flaps (cont'd)	4. Hanging pocket parts reversed, i.e., flannel or fleece on outside and oxford on inside	126	
	Binding:		
	1. Stitching around edge of hanging pocketing prior to binding omitted		248
	2. Binding short, not permitting hanging pocket to hang smoothly		336
	3. End of binding not folded back and tacked or bartacked		249
	4. Binding not securely caught to edge of hanging pocket, causing binding to pull away easily		250
	5. End of binding extending beyond bartack more than 1/2 inch		337
	6. Binding less than 7/16 or more than 9/16 inch wide		338
	7. Binding not stitched with two rows of stitching		251
	Pocket snap fasteners (position):		
	1. Socket attached through outside of flap or not attached through reinforcement piece	127	
	2. Center of socket from point of flap less than 7/8 inch or more than 1-1/8 inches		339
	3. Stud out of alignment with socket, causing a noticeable bulge or twist on front of flap when fastened		252
	4. Stud attached through all plies of hanging pocket	128	
	5. Stud not attached through front of garment and underplies of hanging pocket		340
Sleeves	Construction:		
	1. Fold of pleat toward top of sleeve		341
	2. Undersleeve overlapping top sleeve		342

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TABLE IV. End item visual defects (cont'd)

Examine	Defect	Classification	
		Major	Minor A B
Sleeves (cont'd)	Setting:		
	1. Sleeve overlapping front and back at armhole seam		253
	2. Sleeve tight at armhole, causing puckers on front or back		254
	3. Sleeve fullness misplaced or sleeve pleated at armhole seam		255
	4. Distance from sleeve back arm seam to shoulder seam unequal by 3/4 inch or more		343
	Sleeve tunnel:		
	1. Stitched to inside of sleeve	129	
	2. Finished less than 1-3/4 inches or more than 2 inches wide		344
	3. Badly twisted or irregular in width by 1/4 inch or more		256
	4. Hemmed end of facing finished on outside of tunnel facing		257
	5. Hemmed end of facing more than 1/2 inch in either direction from underarm seam		258
	Adjustment straps:		
	1. Back end of elastic webbing: -not securely stitched to tab -stitched to tab with one row of stitching	130	259
	2. Finished length of adjustment strap less than 7-1/2 inches or more than 8-1/2 inches long		260
	3. Adjustment strap buttonhole tab extending less than 1/4 inch or more than 1/2 inch beyond outlet		261
	4. Adjustment strap caught in tunnel facing stitching affecting function	131	
	Adjustment strap buttonhole tab raw edge not turned under when stitched to elastic webbing		262

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TABLE IV. End item visual defects (cont'd)

Examine	Defect	Classification		
		Major	Minor A B	
Sleeves (cont'd)	Tab button:			
	1. Placed:			
	-less than 5-1/2 inches or more than 6-1/2 inches from sleeve adjustment outlet		263	
	-off center of facing by more than 1/4 inch		345	
	2. Stitching not caught through sleeve		264	
	Liner button:			
	1. Less than 2 inches or more than 2-1/2 inches from bottom end of sleeve		346	
	2. Not placed on sleeve seams		347	
	Backs	Back V-opening:		
		1. Uneven in length:		
-by 3/8 inch or more but not more than 5/8 inch inclusive			348	
-by more than 5/8 inch			265	
2. Stitching on vent hem less than 1/4 or more than 3/8 inch from finished edge of vent			349	
Webbing strip or basic material for reinforcing snap fastener sockets				
1. Finished less than 3-1/2 inches or more than 4-1/2 inches long			350	
2. Not stitched on four sides			266	
3. Ends not fused			351	
4. Reinforcement piece not double ply (basic material)			267	
5. Raw edges not turned under (basic material)			268	
6. Reinforcement less than 7/8 inch or more than 1-1/8 inches in width (basic material)			352	
Snap fastener sockets:				
1. Not clinched through reinforcement		132		
2. Stud attached in lieu of socket		133		

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TABLE IV. End item visual defects (cont'd)

Examine	Defect	Classification	
		Major	Minor A B
Backs (cont'd)	3. Out of horizontal alignment by more than 1/4 inch		353
	4. Unequally spaced from center seam by more than 1/4 inch		354
	Hem for bottom drawcord less than 1 inch or more than 1-1/4 inches wide		355
	Vent studs of fasteners:		
	1. Placed with stud on outside instead of inside of parka	134	
	2. Attached through top edge of bottom hem instead of bottom edge		356
Waist tunnel	Construction and placement:		
	1. Ends of tunnel finished less than 1/2 inch or more than 1 inch from side seams on back of parka		357
	2. Tunnel set in crookedly	269	
	3. Less than 7/8 inch or more than 1-1/8 inches wide		358
	4. Ends turned in less than 3/8 inch or more than 5/8 inch		359
Waist drawcord eyelets and reinforcements	Eyelets not securely attached on one or both fronts or not clinched through reinforcement piece	135	
	Reinforcement pieces:		
	1. One or more missing	136	
	2. Not stitched on four sides or ends not fused		360
	3. Front reinforcement(s) less than 3/4 inch or more than 1-1/4 inches long		361
	Rim of eyelet positioned on the inside of parka		362
Hanger	Omitted or ends not securely caught in bartacks or seaming of collar	270	
	Finished less than 5 inches or more than 5-1/2 inches long		363

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TABLE IV. End item visual defects (cont'd)

<u>Examine</u>	<u>Defect</u>	<u>Classification</u>	
		<u>Major</u>	<u>Minor</u> A B
Hanger (cont'd)	Ends of hanger less than 3-3/4 inches or more than 4-1/4 inches from outer edge to outer edge		364
Neck button tabs	Construction and placement:		
	1. Not securely caught in collar joining seam	137	
	2. Less than 1-1/2 inches or more than 2 inches long		365
	Tab buttons:		
	1. Stitching of one or more tab buttons caught through parka		271
	2. Less than 7/8 inch or more than 1 inch from bottom edge		366
Liner buttons	Right side placed beyond specified location		272
	Left side:		
	1. One or more buttons sewn through front		273
	2. Placed less than 1/2 inch or more than 5/8 inch from back edge of left facing		274
	3. Sewn through front of parka		367
	4. Not sewn through facing interlining and facing		275

4.4.3 End item dimensional examination. The end items shall be examined for conformance to the measurements specified in table III. Any dimension not within the specified tolerance and any sleeve length uneven in length by 1/2 inch or more shall be classified as defects. The lot size shall be expressed in units of parkas. The sample unit shall be one parka. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 4.0.

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4.4.4 Packaging examination. The fully packaged end items shall be examined for the defects listed below. The lot size shall be expressed in units of shipping containers. The sample unit shall be one shipping container fully packaged. The inspection level shall be S-2 and the AQL, expressed in terms of defects per hundred units, shall be 2.5.

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

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

4.4.5 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>Defects</u>
Finished dimensions	Length, width, or height exceeds specified maximum requirement
Palletization	Pallet pattern not as specified Interlocking of loads not as specified Load not bonded as specified
Weight	Exceeds maximum load limits
Marking	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application

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5. PACKAGING

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

5.1.1 Level A preservation. Each parka shall be laid flat, front up, with the slide fastener open. The parka shall be adjusted to a width of approximately 23 inches by over-lapping one half of the front with the other. The sleeves shall be folded one over the other across the chest. The bottom edge of the parka shall be folded up to meet the lower edges of the sleeves. Each parka shall then be folded in half the length. The completely folded parkas shall measure approximately 23 inches by 14-1/2 inches. Five folded parkas of one size only shall be neatly stacked in a bundle and securely tied with cotton tape or twine approximately 4 inches from each end.

5.1.2 Commercial preservation. The parkas 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. Twenty parkas of one size only, preserved as specified in 5.1, shall be packed flat in a snug-fitting fiberboard shipping container, conforming to style RSC-L, grade V2s of PPP-B-636. The inside of each shipping container shall be fitted with a box liner conforming to type CF, class weather-resistant, variety DW, grade V15c of PPP-B-636. Level A unit packs shall be packed flat, four in depth. Inside dimensions of each container shall approximate 23-1/2 inches in length, 15 inches in width, and 15 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 4.4.4. 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 non-metallic strapping, except for type II, class F loads.

5.2.2 Level B packing. Twenty parkas of one size only, preserved as specified in 5.1, shall be packed 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 shipping container shall be fitted with a box liner conforming to type CF, class domestic, variety DW, grade 275 of PPP-B-636. Inside dimensions of each container shall approximate 23-1/2 inches in length, 15 inches in width, and 15 inches in depth. Approximate dimensions are furnished as a guide only. Level A unit packs shall be packed flat, four in

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depth within a shipping container. Each fiberboard 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 4.4.4.

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 4.4.4.

5.2.3 Commercial packing. Parkas, preserved as specified in 5.1, shall be packed in accordance with ASTM D 3951.

5.3 Palletization. When specified (see 6.2), parkas 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 C and D or film bonding means F or G. Pallet pattern shall be number 3 in accordance with appendix the 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, shipping containers and palletized unit loads shall be marked in accordance with MIL-STD-129 or ASTM D 3951, as applicable.

6. NOTES

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

6.1 Intended use. The parka is a component of the cold/dry uniform and is intended for wear by military personnel of the Department of Defense.

6.2 Acquisition requirements. Acquisition documents must specify the following:

- a. Title, number and date of this specification.
- b. Size required (see 1.2).
- c. Issue of DODISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.1.1 and 2.2).
- d. When a first article is required (see 3.1.1, 4.3, and 6.3).
- e. Levels of preservation and packing (see 5.1 and 5.2).
- f. Type and class of unit load required (see 5.2.1).

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- g. When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).
- h. When palletization is required (see 5.3).

6.3 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 acquisition documents regarding arrangements for selection, inspection, and approval of the first article.

6.4 Sample. For access to samples, address the contracting activity issuing the invitation for bids or request for proposal.

6.5 International standardization agreements. Certain provisions of this document are the subject of international standardization agreement as cited in NATO, STANAG No. 2333. When amendment, revision, or cancellation of this document is proposed which will affect or violate the international agreement concerned, the preparing activity will take appropriate reconciliation action through international standardization channels including departmental standardization offices, if required.

6.6 Subject term (key word) listing.

Cold/dry uniform
Extreme cold weather clothing
Outer garment

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

Custodians:

Army - GL
Navy - NU
Air Force - 99

Preparing activity:

Army - GL
(Project 8415-0691)

Review activities:

Army - MD
Navy - MC
Air Force - 82
DLA - CT

User activity:

Air Force - 45

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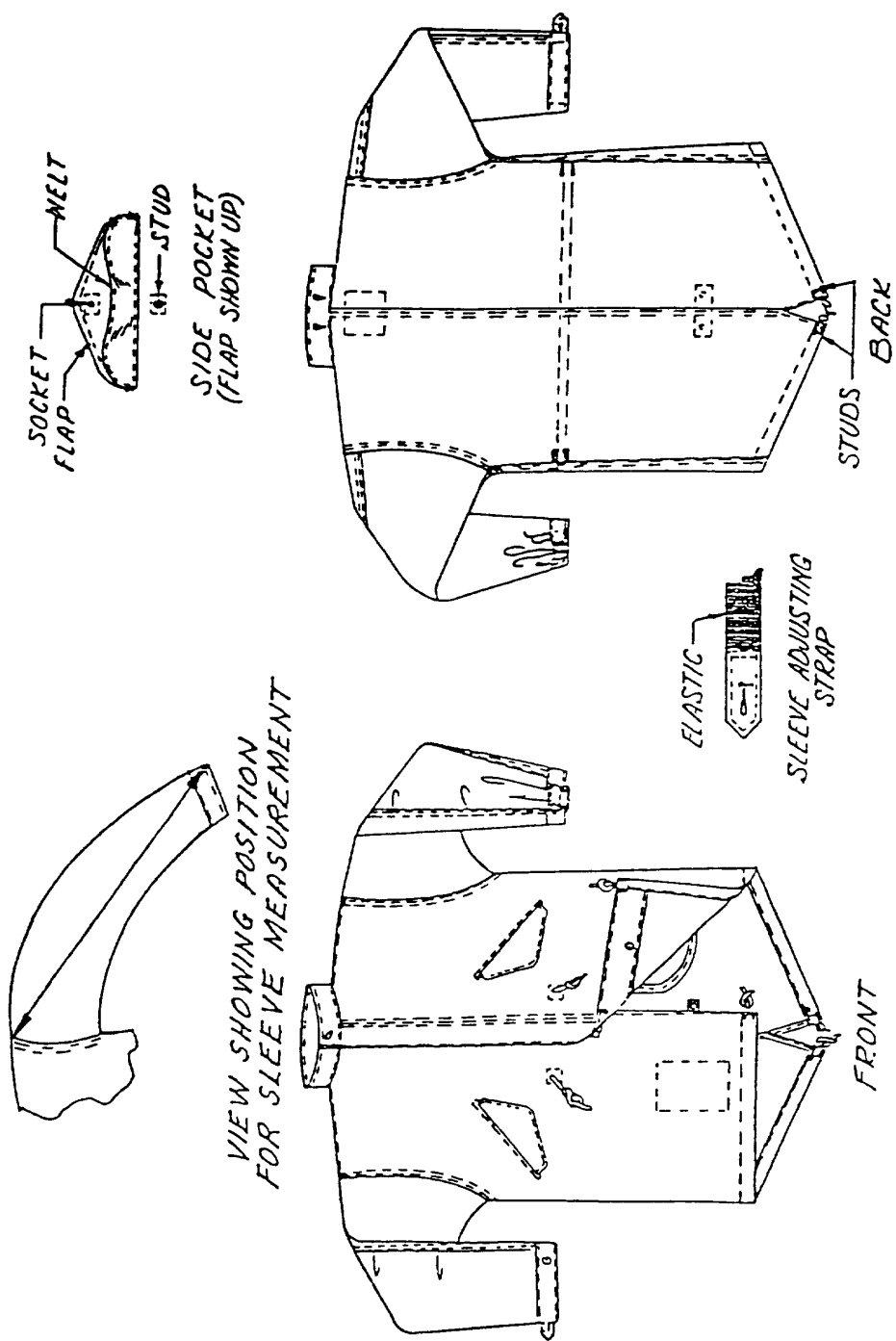


FIG. 1. PARKA, EXTREME COLD WEATHER

2-1-707E

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

INSTRUCTIONS

- 1 The preparing activity must complete blocks 1, 2, 3, and 8 In block 1, both the document number and revision letter should be given
- 2 The submitter of this form must complete blocks 4, 5, 6, and 7
- 3 The preparing activity must provide a reply within 30 days from receipt of the form

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

1. RECOMMEND A CHANGE:		1 DOCUMENT NUMBER MIL-P-43496I	2 DOCUMENT DATE (YYMMDD) 23/04/16
3 DOCUMENT TITLE PARKA, EXTREME COLD WEATHER			
4 NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible Attach extra sheets as needed)			
5 REASON FOR RECOMMENDATION			
6. SUBMITTER			
a. NAME (Last, First, Middle Initial)		b. ORGANIZATION	
c. ADDRESS (Include Zip Code)		a. TELEPHONE (Include Area Code) (1) Commercial (2) AUTOVON (If applicable)	7. DATE SUBMITTED (YYMMDD)
8 PREPARING ACTIVITY			
a NAME U S Army Natick RD&E Center		b TELEPHONE (Include Area Code) (1) Commercial 508-651-5221 (2) AUTOVON 256-5221	
c ADDRESS (Include Zip Code) Commander, U S Army Natick RD&E Center ATTN STRNC-ES Natick, MA 01760-5014		IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT Defense Quality and Standardization Office 5203 Leesburg Pike, Suite 1403 Falls Church, VA 22041 3466 Telephone (703) 756-2340 AUTOVON 289-2340	