

INCH-POUND

MIL-S-19984E(MC)

20 September 1989

SUPERSEDING

MIL-S-19984D(MC)

3 August 1984

MILITARY SPECIFICATION

SHIRT, MAN'S: KHAKI; WITH QUARTER LENGTH SLEEVE

This specification is approved for use by the U. S. Marine Corps, Department of the Navy, and is available for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification covers the requirements for men's shirts with quarter-length sleeves.

1.2 Classification. The shirts shall be of one type in the following classes and sizes as specified (see 6.2):

Class 1 - Tropical, Polyester and Wool (Standard)

Class 2 - Tropical, Polyester/Wool (Optional)

Schedule of Sizes

Neck Sizes: 13-1/2, 14, 14-1/2, 15, 15-1/2, 16, 16-1/2, 17, 17-1/2

2. APPLICABLE DOCUMENTS

2.1 Government documents

2.1.1 Specifications and standards. The following specifications and standards form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those listed in the issue of the Department of Defense Index of Specifications and Standards (DoDISS) and supplement thereto, cited in the solicitation (see 6.2).

SPECIFICATIONS

FEDERAL

V-B-871

- Button, Sewing Hole, and Button, Staple, (Plastic)

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to the Commanding General (PSE-C), Marine Corps Research, Development and Acquisition Command, Washington, D.C. 20380, by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document of by letter.

AMSC N/A

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

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DD-L-20 - Label, for Clothing, Equipage and Tentage (General Use)

MILITARY

MIL-B-17757 - Box, Shipping, Fiberboard (Modular Sizes)
 MIL-C-21115 - Cloth, Tropical, Wool, Polyester/Wool
 MIL-C-29404 - Cloth, Tropical, Polyester and Wool
 MIL-T-43548 - Thread, Polyester, Cotton Covered and Rayon Covered
 MIL-C-43594 - Cloth, Interlining, Polyester

STANDARDS

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

MILITARY

MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
 MIL-STD-129 - Marking for Shipping and Storage
 MIL-STD-147 - Palletized Unit Loads
 MIL-STD-1492 - Provisions for Evaluating Quality of Men's Shirts

(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from the Naval Publications and Forms Center (Attn: NPONS), 5801 Tabor Avenue, Philadelphia, PA 19120-5099.)

2.1.2 Other Government documents and publications. The following other Government documents and publications form a part of this document to the extent specified herein. Unless otherwise specified, the issues are those cited in the solicitation.

LAWS AND REGULATIONS

U.S. Postal Service Manual

(Application for copies should be addressed to the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402.)

Department of Defense (DoD) Standard Shades for Buttons 1966

Department of Defense (DoD) Standard Color Card of
 Official Standardized shades for Sewing Threads 1968

(Application for copies should be addressed to the Color Association of the United States, Inc., 343 Lexington Avenue, New York, NY 10016.)

2.2 Non-Government Publications. The following document(s) form a part of this document to the extent specified herein. Unless otherwise specified, the issues of this document 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 DODISS are the issues of the documents cited in the solicitation (see 6.2).

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NATIONAL MOTOR FREIGHT TRAFFIC ASSOCIATION, INC., AGENT

National Motor Freight Classification

(Application for copies should be addressed to American Trucking Association, ATTN: Order Section, 1616 P Street, N.W., Washington, D.C. 20026.)

UNIFORM CLASSIFICATION COMMITTEE, AGENT

Uniform Freight Classification Rules

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

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

3. REQUIREMENTS

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

3.2 First article. When specified (see 6.2), the contractor shall furnish a sample unit for first article inspection and approval (see 4.2 and 6.4).

3.3 Material.

3.3.1 Basic material. The basic material for each class of shirt shall be as follows:

3.3.1.1 Class 1. Cloth, tropical, polyester and wool, 6.5 to 7.0 ounce, khaki shade 2122, conforming to type I of MIL-C-29404.

3.3.1.2 Class 2. Cloth, tropical, polyester/wool, 8.5 to 9.5 ounce, khaki shade M-1 conforming to type III, class 1 of MIL-C-21115.

3.3.2 Interlining. The material for interlining the collar, front facings and breast pocket flaps shall be polyester fiber cloth conforming to MIL-C-43594.

As an alternate, a nonwoven fusible may be used. The fusible shall be 1.25 to 1.75 ounces per square yard, 80 to 85% polyester, 15 to 20% nylon with a thermal bonded polyester adhesive paste dot and the color shall be white. The fusing conditions shall be as follows:

Temperature	280° - 290° F
	140° - 145° CE
Time	12 - 15 sec.
Pressure	4 to 6 PSI

The fusible interlining shall be Pellon S/8322 or equal to or better.

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3.3.3 Thread. The thread shall be polyester, cotton or polyester covered for seaming and stitching the shirt and shall conform to MIL-T-43548 (see below).

<u>Use</u>	<u>Ticket No.</u>	<u>Ply</u>
General seaming and overedging	70	2 or 3
Button and buttonhole	40	6

3.3.3.1 Color and colorfastness. The thread shall be dyed khaki shade P-1, cable No. 66019. The dyed thread shall show good fastness to perspiration, combined laundering and bleaching, and light equal to or better than the standard sample when tested as specified in MIL-T-43548. (See DoD Standard Color Card of Official Standardized Shades for Sewing Threads 1968.)

3.3.4 Buttons. The buttons shall be melamine formaldehyde composition, glossy finish, conforming to type II, class D, style 24, 20 line of V-B-871. The color shall be khaki shade AL, cable No. 62026. (See DoD Standard Shades for Buttons 1966.)

3.3.5 Labels. Each shirt shall have an identification/instruction label and a size label conforming to DDD-L-20 as follows. The class 2 shirts are intended to be dry cleaned and the labels shall show fastness to dry cleaning.

3.3.5.1 Identification/instruction label, cloth, printed. The identification/instruction label shall be type VI, class 15 and shall measure not less than 2-1/2 inches by 1-1/2 inches. The content and format of the identification information shall be as follows:

Nomenclature (item identification)
 Contract Number
 Name of Contractor
 Wool Products Act Information
 Dry clean or launder by hand
 Caution: Bleach, fabric softener, starch
 and/or hot water (excluding 100°F) will
 harm the fabric of the shirt.

3.3.5.2 Identification/instruction marking. In lieu of the printed cloth label, the required identification/instruction information may be marked on the shirts by heat transfer (decalcomania), direct printing, or stamping. The markings shall conform to type III or type IV, class 1 of DDD-L-20.

3.3.5.3 Size label, cloth, printed. The size label shall be type VI, class 2 and shall measure not less than 1-1/4 inches by 1-1/2 inches. The size designation (see 1.2), and stock number shall be indicated on the label as shown in the following sample:

16
 Stock Number

The stock number may be omitted from the size label, but when omitted it shall be included in the identification label.

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3.3.5.4 Size marking. In lieu of the printed cloth label, the size designation and the stock number may be marked on the shirts by heat transfer (decalcomania), direct printing, or stamping. The markings shall conform to type III or type IV, class 2 of DDD-L-20.

3.4 Design. The shirts shall be the U.S. Marine Corps design shown on Figures 1 through 4 consisting of a five-button, coat-style front having grown-on facings, back yoke, open style collar and lapels, quarter length sleeves and two patch pockets with button-down flaps. The class 1 shirts shall have safety stitch armhole, side and sleeve seams and a sandwich type shoulder seam and the class 2 shirts shall have double-lapped, double-stitched shoulder, armhole, side and sleeve seams.

3.5 Patterns. Standard patterns will be furnished by the Government (see 6.3). The standard patterns shall not be altered in any way and shall be used for cutting the contractor's working patterns. The working patterns shall be identical to the standard patterns except that additional notches for use during construction are permitted on the working patterns. Also, minor modifications are permitted where necessary when using automatic equipment. These modifications shall not alter the dimensional, serviceability or appearance requirements cited in this specification. For class 1, the standard pattern provides 1/4-inch seam allowance for safety stitch construction. For class 2, the standard pattern provides 1/2-inch seam allowance for double-lapped and double-stitched seams. All other seam allowances are 1/4-inch except as otherwise specified in Table I. Standard patterns show size, seam allowance, directional lines for cutting and are marked or notched for proper placement and assembly of the component parts. Unless otherwise indicated in Table I, seams shall be in accordance with the seam allowances.

3.5.1 Pattern parts. The component parts of the shirts shall be cut from the material specified herein in accordance with the pattern parts indicated below:

Item	Pattern Nomenclature	No of cut parts
<u>Material: Basic material</u>		
1.	Back	1
2.	Yoke	2
3.	Front	2
4.	Sleeve	2
5.	Collar	2
6.	Pocket	2
7.	Flaps	4
<u>Material: Interlining</u>		
8.	Front	2
9.	Collar	1
10.	Collarstand	1
11.	Pocket flap	2

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Item	Pattern Nomenclature	No of cut parts
	<u>Markers</u>	
12.	Finished flap	
13.	Finished pocket	
14.	Pocket and buttonhole	

3.6 Construction. The shirts shall be constructed as specified in Table I. Unless otherwise specified in Table I, the manufacturer will not be required to follow the exact sequence of operations as listed in Table I. Stitch, seam, and stitching types shall conform to FED-STD-751. The stitches per inch specified in Table I shall be interpreted to be the minimum and the maximum permitted. Wherever two or more methods of seams or stitchings are given for the same parts of an operation, any one of them may be used. The looper (under thread) of stitch type 401 shall be on the inside of the shirt. Double rows of stitches shall be uniformly 1/4-inch gage. Seam allowances shall be maintained. Seams shall be sewn so that there will be not raw edges, runoffs, twists, pleats, or puckers. Ends of seams and stitching produced with 301 type stitch, when not caught in other seams or stitching, shall be backtacked not less than 1/4-inch. Thread breaks (all stitch types) shall be secured by stitching back of break not less than 1/2-inch. When stitch type 401 is used, ends of seams and stitching shall be caught in other seams or stitching, and skipped stitches and thread may be repaired using stitch type 301 backstitched not less than 1/2-inch on each side of the skip or break.

3.6.1 Automatic equipment. Minor modifications are permitted where necessary using automatic equipment. These modifications shall not alter the dimensional, serviceability or appearance requirements cited in this specification.

3.6.2 Shade marking. The component parts of the shirt, cut from one piece of basic material, shall be marked to insure a uniform shade and size throughout the garment. Any method of shade marking may be used except:

- (1) Corrosive metal fastening devices
- (2) Sew-on shade tickets
- (3) Adhesive-type tickets which show discoloration and the adhesive mass adheres to the material upon removal of tickets.

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
1.	<u>Cutting.</u> a. Cut the shirts in strict accordance with patterns furnished by the Government. b. Cut the materials in the direction indicated by directional lines on the pattern. c. Cut all parts from one piece of basic material except the following which may be cut from ends: under-collar and underply of pocket flaps. All parts cut from ends shall harmonize with the shade of the shirt. d. Cut the interlining from the interlining cloth for collar, front facings, and pocket flaps.					
2.	<u>Replacement of damaged parts.</u> a. The watch pocket may be joined by seaming and overedge stitching the raw edges together in one operation. b. Replace all parts damaged during the manufacturing process by needle chews which may be expected to develop into a hole, scissors, or knife cuts, tears, holes, mends or burns in the material affecting appearance.					
3.	<u>Shade marking.</u> a. Mark all component parts as specified in 3.6.2 except those parts cut from ends (see oper. 1.c.) in order to insure proper assembly and a uniform shade and size throughout the garment.					
4.	<u>Make breast pockets.</u> Finished appearance. The hem of the breast pocket shall be uniformly stitched and shall finish smooth					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
	and flat. The breast pocket shall be uniform in shape and size in accordance with patterns.					
	a. The breast pocket shall be made of one ply of basic material.					
	b. Hem the top edge of breast pockets, in accordance with notches indicated by the pattern, with two rows of stitching 1/4-inch gage and with the outer row 1/6-inch from the folded edge.	301 or 401	EFa-2 EFa-2	12-16 12-16	70 70	70 70
	c. Turn under the side and bottom edges of the breast pocket in accordance with the finished shaper and crease in an edge creasing machine. The creased pocket shall conform to the finished pocket marker.					
5.	<u>Make breast pocket flaps.</u>					
	Finished appearance. The breast pocket flaps shall be uniformly stitched with seams worked out to the edges. The flaps shall finish smooth and flat without twists, puckers, pleats, or other distortions. The flaps shall be uniform in shape and size in accordance with the patterns. The buttonholes shall be securely tacked at each end.					
	a. The breast pocket flaps shall be made of two plies of basic material and one ply of interlining.					
	b. Seam the three plies together 1/4-inch from side and bottom edges.	301	SSe-2(a)	12-16	70	70
	c. Turn flap, working the corners and points out completely and working the seams out to the edges.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
5.	<u>Make breast pocket flaps.</u> (cont'd)					
	d. Edgestitch the flaps uniformly 1/8 inch from seamed edges.	301	SSe-2(b)	12-16	70	70
	e. Trim top edge of breast pocket flaps evenly.					
	f. Make a vertical straight type buttonhole, cut 5/8 inch long, through the center of each breast pocket flap, securely tacking each end. The lower end of the buttonhole shall be 3/8 to 1/2 inch above the center point. The buttonhole shall have the purling on the outside of breast pocket flap, and shall fit a 20-line button.	But- ton- hole		55 per- button- hole in- cluding tack	40/6	40/6
6.	<u>Make collar.</u>					
	Finished appearance. The collar shall be uniformly stitched and shall finish smooth and flat without twists, puckers, pleats, or other distortions. The points shall be worked out completely and shall be uniform in length. The seam shall be worked to the edge of the collar.					
	a. The collar shall consist of two plies of basic material, one ply of interlining, and one ply of collarstand interlining.					
	b. Seam collarstand interlining to the undercollar at the mark for the collarstand as indicated by marks on pattern.	301	SSa-1	12-16	70	70
	c. Properly position undercollar-assembly, topcollar and interlining with topcollar and undercollar face-to-face. Seam all plies together 1/4 inch from top and side edges.	301	SSe-2(a)	12-16	70	70
	d. Trim the points and turn collar on a heated collar-point turning and pressing machine, working out					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
6.	<u>Make collar.</u> (cont'd) the points completely and working the seams to the edges. e. Edgestitch the upper and side edges of collar uniformly 1/8 inch from seamed edge.	301	SSe-2(b)	12-16	70	70
7.	<u>Attach interlining to front facing.</u> a. Position interlining on the respective front facing with edges even. Stitch the two plies together at the gorge, shoulder, back edge of facing, and across bottom of interlining. b. Overedge stitch shoulder and back edge of facing.	301 502 or 503	SSa-1 SSa-1 SSa-1	12-16 6-8 6-8	70 70 70	70 70 70
8.	<u>Join yoke to back.</u> Finished appearance. The yoke shall be seamed to the back without twists, puckers, pleats, or other distortions and shall be uniform in appearance and placement. <u>Class 1</u> a. Position the top edge of back between the two lower edges of yoke, with edges even, and stitch together with a 1/4-inch seam. Turn the top ply of yoke and topstitch 1/16 inch from the turned edge. (Do not catch the underply of yoke in the topstitching). <u>Class 2</u> b. Position the top edge of back between the two lower edges of yoke with edges even and stitch together with a 1/2-inch seam. The yoke shall be topstitched with two rows of stitching, 1/4-inch gage. The outer row of stitching shall be 1/16 inch from turned edge of yoke.	301 301	LSbp-2(a) LSbp-2(c) SSq-3(a) and SSq-3(b)	12-16 12-16	70 70	70 70

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
8.	<u>Join yoke to back.</u> (cont'd) c. On the finished shirt, the yoke shall be $3\frac{1}{2} + \frac{1}{8}$ inches when measured at the center back from lower edge of neck seam of under-collar.					
9.	<u>Sew on label.</u> Finished appearance. When cloth identification label is used, it shall be positioned so that in finished shirt the label shall be midway between the folded front edge of shirt and back edge of facing. The bottom edge of label shall be toward the back edge of facing, and the lower end of label shall be approximately 3 inches from finished bottom edge of shirt. a. Position the identification/instruction label lengthwise on outside of wearer's left facing and stitch label $\frac{1}{8}$ inch from each edge (see oper. 20).	301	LSbj-1	12-16	70	70
10.	<u>Set breast pockets and breast pocket flaps.</u> Finished appearance. The breast pockets and breast pocket flaps shall be uniform in appearance and placement, and shall lie smooth and flat without twists, puckers, pleats, or other distortion. The breast pockets and flaps shall be uniformly stitched to the fronts. The sides of the breast pocket shall not extend beyond the sides of breast pocket flaps. On the finished shirt, the breast pockets and flaps shall be parallel to the front edge of shirt when buttoned. The breast pocket and flap on left and right sides, respectively, shall be in alignment with each other. The breast pockets and flaps shall conform to the measurements shown in Table III.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
10.	<u>Set breast pocket and breast pocket flaps.</u> (cont'd)					
	a. Mark fronts for position of breast pockets and breast pocket flaps, as indicated by pattern marker.					
	b. Position breast pocket flaps at the mark on the front. Seam breast pocket flaps to the fronts 1/8 inch from raw edge of flap.	301	LSq-2(a)	12-16	70	70
	c. Turn down the breast pocket flaps at seam and top stitch 1/4 inch from raised edge.	301	LSq-2(a)	12-16	70	70
	d. Position pre-creased breast pockets at the marks on front.					
	e. Seam breast pocket to fronts uniformly 1/16 inch from side and bottom turned edges, securely tacking the top corners.	301	LSd-1	12-16	70	70
11.	<u>Seam shoulders.</u>					
	Finished appearance. The shoulder seam shall be uniformly stitched and shall finish evenly without twists, puckers, pleats, or other distortion. The back shall be lapped on the fronts.					
	<u>Class 1</u>					
	a. Position the top edge of each front between the yoke pieces, with edges even and stitch together with a 1/4-inch seam. Turn and topstitch front yoke 1/16 inch from turned edges through all plies.	301	SSq-3(a) and SSq-3(b)	12-16	70	70
	-or-					
	This operation may be performed using a double folder for top and bottom ply of yoke.	301	LSe-1	12-16	70	70
	<u>Class 2</u>					
	b. Join the yoke and front together at the shoulders with a double-lapped and double-stitched seam, 1/4-inch gage, with the outer row 1/16 inch from the folded edge.	301	LSe-2	12-16	70	70

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
12.	<p><u>Set collar with size label.</u></p> <p>Finished appearance. The collar shall be uniformly stitched to the shirt without twists, puckers, pleats, or other distortion. On the finished shirt, the ends of collar shall be $3\frac{1}{4} + \frac{1}{8}$ inches long when collar is turned up and measured from neck seam to collar point. The cloth size label, when used, shall be properly positioned and caught in seam joining collar to shirt. The collar shall lay flat and measure $2\frac{7}{8} + \frac{1}{8}$ inches wide from neck seam to edge at center back.</p> <p>a. Position the collar on the outside of shirt, with lower end of collar aligned with the fold notch, and the raw edge of collar and gorge even. Fold facing back over the collar at the fold notch and seam through all plies to the top facing notch. Cut through all plies at facing notch, pull facing and topcollar back, and continue to stitch the undercollar to front and back neck.</p> <p>b. Turn facings to the inside, forcing out the seam at the end of collar. Place end of facings under topcollar. Turn under lower edge of topcollar. Position the size label at center back with lower edge of topcollar lapped on top end of label. Stitch together to neck of shirt $\frac{1}{16}$ inch from folded edge, from notch to notch, with the top end of label caught in the seam (see oper. 20).</p>	301	SSa-1	12-16	70	70
		301	LSb-1	12-16	70	70
13.	<p><u>Attach facing to shoulder seam.</u></p> <p>a. The shoulder edge of facing shall be stitched flat through the shoulder seam stitching, under the collar, catching all plies of the shirt.</p>	301	SSa-1	10-12	70	70

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
14.	<p><u>Set sleeves.</u></p> <p>Finished appearance. The sleeve shall be properly set and uniformly stitched without twists, puckers, pleats, or other distortion.</p> <p>a. Trim yoke even with back at armhole, if required.</p> <p><u>Class 1</u></p> <p>b. Set sleeves by overedging and seaming the raw edges together in one operation.</p> <p><u>Class 2</u></p> <p>c. Join sleeves to shirt around the armhole with a double-lapped and double-stitched seam, 1/4-inch gage, with the outer row 1/16 inch from folded edge. The fronts, yoke and back shall be lapped on the sleeve.</p>	<p>515 or 516 or 519</p> <p>301 or 401</p>	<p>SSa-2</p> <p>LSc-2 LSc-2</p>	<p>10-14</p> <p>12-16 12-16</p>	<p>70</p> <p>70 70</p>	<p>70</p> <p>70 70</p>
15.	<p><u>Close sides and sleeves.</u></p> <p>Finished appearance. The sleeve and side seams shall be uniformly stitched without twists, puckers, pleats, or other distortion. The seams shall start and finish evenly. The back may be lapped on the front or the front on the back, but not on both.</p> <p><u>Class 1</u></p> <p>a. Join side and underarm seams by overedging and seaming the raw edges together in one operation.</p> <p><u>Class 2</u></p> <p>b. Join fronts and back at the sides and close the sleeve underarm with a double-lapped and double-stitched seam. The ends of the</p>	<p>301</p> <p>515 or 516 or 517 or 518 or 519</p> <p>301</p>	<p>LSb-1</p> <p>SSa-2 SSa-2</p> <p>SSa-1</p>	<p>12-16</p> <p>10-14 10-14</p> <p>10-12</p>	<p>70</p> <p>70 70</p> <p>70</p>	<p>70</p> <p>70 70</p> <p>70</p>

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
15.	<u>Close sides and sleeves.</u> (cont'd) armhole seam shall not be staggered more than 3/8 inch. The double row of stitches shall be 1/4-inch gage with the outer row 1/16 inch from the folded edge.					
16.	<u>Hem bottom of shirts.</u> Finished appearance. The sleeve hems shall be uniformly stitched without twists, puckers, pleats, or other distortions, and shall finish 3/16 to 1/4 inch wide. a. Turn bottom of fronts and back of shirt with the raw edge turned in and single stitched through the shirt 1/16 inch from the upper folded edge, forming the hem.	301	EFb-1	12-16	70	70
17.	<u>Hem sleeves.</u> Finished appearance. The sleeve hems shall be uniform in width, without twists, puckers, pleats, or other distortion. The stitching shall start and finish on the in-seam. The gage of stitching shall be uniform in width. a. Turn under the bottom edge of sleeve with the raw edge turned in and stitch 1/16 to 1/8 inch from upper folded edge. The finished hem shall measure 1 + 1/8 inches wide. As an alternate, the shirt sleeve may be hemmed before closing the side and underarm seam. The seam shall be turned toward the back and tacked with a 3/8 inch bartack.	301	EFb-1	12-16	70	70
18.	<u>Make buttonholes.</u> Finished appearance. The buttonholes shall be clean cut, well made and correctly positioned. The buttonholes shall be straight type, and shall be made to fit a 20-line sewing hole button. The purling					

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
18.	<p><u>Make buttonholes.</u> (cont'd)</p> <p>shall be on the outside of the shirt. The buttonholes shall be $3/4 + 1/16$ inch from left front edge.</p> <p>a. Mark left facing for location of five buttonholes in accordance with marker.</p> <p>b. Make one vertical straight type buttonhole, $5/8$-inch cut, at each mark on the left front securely tacking each end of the buttonhole.</p>	But- ton- hole		55 per button- hole includ- ing tack	40/6	40/6
19.	<p><u>Sew on buttons.</u></p> <p>Finished appearance. The buttons shall be securely sewn and shall properly engage buttonholes in left front and pocket flaps.</p> <p>a. Sew five 20-line sewing hole buttons to the right front with center of button $7/8 + 1/8$ inch from front edge of button stand.</p> <p>b. Sew on 20-line sewing hole button to each pocket through the hem to correspond with flap buttonhole.</p>	101 or 301		22 per button 16 per button	40/6 40/6	40/6
20.	<p><u>Identification and size markings.</u></p> <p>a. When marking is used in lieu of cloth identification or size labels, the identification marking shall be applied to the shirt at the location specified for the cloth label (see oper. 9.a.) and the size shall be marked at the inside center back in the area of the back yoke.</p>					
21.	<p><u>Cleaning.</u></p> <p>a. Trim all ends of stitching and remove the loose ends from the shirt.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
21.	<u>Cleaning.</u> (cont'd) b. Remove without injury to the material all spots, stains, shade tickets or markings.					
22.	<u>Pressing.</u> Finished appearance. The entire shirt shall be well pressed. Pressing shall be accomplished with a heated pressing iron or pressing machine of a type suitable to obtain the desired appearance in accordance with good manufacturing practice. The use of a steam inflated bag type machine for pressing is prohibited. a. Press the collar smooth and flat. b. Press facings smooth and flat. c. Press entire shirt; fronts, back, sleeves, pocket flaps, and pockets, removing all wrinkles. Button the fronts and pocket flaps.					

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3.7 Finished measurements. The finished shirts shall conform to the measurements shown in Tables II and III.

Table II. Shirt measurement 1/

Size	Breast <u>2/</u> inches	Back length <u>3/</u> inches
13-1/2	37	30-3/4
14	39	30-3/4
14-1/2	41	30-3/4
15	43	31-1/4
15-1/2	45	31-1/4
16	47	31-1/4
16-1/2	49	31-1/4
17	51	31-3/4
17-1/2	53	31-3/4

- 1/ Tolerance: $\pm 1/2$ inch for the breast measurement and $\pm 1, -1/2$ inch for back length measurement.
- 2/ Twice the measurement taken from folded edge to folded edge in line with pit of armhole with shirt buttoned.
- 3/ The back length measurement shall be taken at center-back from lower edge of undercollar to bottom edge of shirt.

Table III. Breast pocket and breast pocket flap measurement 1/

Components	Sizes - 13-1/2, 14, 14-1/2,	Sizes - 15, 15-1/2, 16, 16-1/2, 17, 17-1/2
<u>Pockets</u>		
Width	4-1/2	5-1/8
Length	5-3/4	6
<u>Flaps</u>		
Width at top edge	4-3/4	5-3/8
Length at sides	1-5/8	1-7/8
Length at center	2	2-7/8
Overall length of pocket and flaps	6-1/4	6-1/2

- 1/ Tolerance: $\pm 1/8$ inch

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3.8 Workmanship. The finished shirt shall conform to the quality established by this specification.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract, 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 the specification where such conform to the prescribed requirements.

4.1.1 Responsibility for compliance. All items must meet all requirements of section 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 requirements in the specification shall not relieve the contractor of the responsibility of assuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling in quality conformance does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to acceptance of defective material.

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

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

1. First article inspection (see 4.4).
2. Quality conformance inspection (see 4.5).

4.3 Inspection conditions. Unless otherwise specified, all inspections shall be performed in accordance with the test conditions specified in MIL-STD-105, except where otherwise indicated in MIL-STD-1492.

4.4 First article inspection. The first article submitted in accordance with 3.2 shall be inspected as specified in 4.5.3 for compliance with design, construction, workmanship, and dimensional requirements of this specification.

4.5 Quality conformance inspection. Inspection shall be performed in accordance with MIL-STD-1492.

4.5.1 Component inspection. In accordance with 4.1 above, components shall be inspected and tested in accordance with all the requirements of referenced specifications, drawings, and standards unless otherwise excluded, amended, modified, or qualified in this specification or applicable purchase documents. Wherever applicable, tests shall be conducted in accordance with methods prescribed in FED-STD-191.

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4.5.2 Sampling for testing. Testing shall be in accordance with sampling provisions tables cited in MIL-STD-1492.

4.5.3 Examination of the end item. As a final step in the contractor's production control plan before formation of a lot, each shirt shall be examined, button, pressed, and laid out flat on a table prior to folding for packaging. A shirt containing a selected defect shall not be included in the end item lot. Selected defects are those defects listed in MIL-STD-1492 indicated by an asterisk (*). The end item examination provisions for the finished shirt shall be as specified for Dress ("D") shirts in MIL-STD-1492.

4.5.4 Dimensional examination. The dimensional examination provisions for the finished shirts shall be as listed in 3.7 and as specified in MIL-STD-1492.

4.5.5 Examination of preparation for delivery requirements. The examination for the finished shirts shall be as listed in 3.7 and as specified in MIL-STD-1492.

5. PACKAGING

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

5.1.1 Level A. Each fully-buttoned shirt shall be folded in accordance with standard practice to approximate dimensions of 14 by 10-1/2 inches. The folded shirt shall be secured with noncorrosive pins or clips, and placed in a polyethylene bag approximately 14-1/2 inches long by 11 inches wide, with a 1 inch lip along the open 11-inch dimension. The polyethylene flexible film shall be 0.0015 inch thick. The final closure of the bag shall be heat-sealed with the heat seal made as close as possible to the open end. A 1/4-inch diameter hole shall be made at one corner of the polyethylene bag to allow excess air to escape. Alternatively, the final closure of the bag may be accomplished by means of a tuck or reverse flap. Each bag shall contain a label (see 5.3.1).

5.1.2 Commercial. Shirts shall be packaged to afford adequate protection against physical damage during shipment from the supplier to the first receiving activity. The packaging and the quantity per package shall be the same as that normally used by the contractor for retail distribution.

5.2 Packing. Packing shall be level A, B, or commercial (see 6.2).

5.2.1 Level A.

5.2.1.1 Method 1. Sixty (60) shirts of one class and size shall be packed in a fiberboard shipping container with liner, conforming to class-weather resistant, size No. 3A of MIL-B-17757. Each shipping container shall be assembled, closed, and reinforced as specified in the appendix thereto.

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5.2.1.2 Method 2. When specified (see 6.2), three level B shipping containers, 180 shirts of one class and size only, shall be overpacked in a fiberboard shipping container conforming to class-weather resistant, size No. 4 of MIL-B-17757, assembled, closed, and reinforced as specified in the appendix thereto.

5.2.2 Level B. Sixty (60) shirts of one class and size only shall be packed in a fiberboard shipping container with liner, conforming to class domestic, size No. 3A of MIL-B-17757. The fiberboard used in fabricating the box shall be grade 275. Each shipping container shall be assembled, closed, and reinforced as specified in the appendix thereto.

5.2.3 Commercial. Shirts, packaged as specified in 5.1, shall be packed in a manner to insure carrier acceptance and safe delivery at destination at the lowest transportation rate for such supplies. Containers shall be in accordance with Uniform Freight Classification Rules, National Motor Freight Classification and U. S. Postal Service Manual or regulations of other carriers applicable to the mode of transportation.

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

5.3.1 Polyethylene bagged packages. Polyethylene bagged packages shall have the following information legibly printed or stamped in black, bold letters 1/4 inch in height directly on the bag across the center face, or on a white paper label inserted within the bag, so as to permit ready identification.

Nomenclature _____
 Stock Number _____
 Size _____
 Contract Number _____
 Name of contractor _____

5.4 Palletization. When specified (see 6.2), slacks packed as specified in 5.2 shall be palletized on a 4-way entry pallet in accordance with load type 1A of MIL-STD-147. Each prepared load shall be banded with primary and secondary straps in accordance with banding means C, K and L or O and P. Pallet pattern shall be in accordance with the appendix of MIL-STD-147. The pallet pattern shall be 4-way, Type I, Class 1, Style 1, Size A, Wood Group I, II, III, or IV of MIL-P-15011, or, 4-way, Type IV, V or VIII, Class 1, Style A, Size 2, Wood Group I, II, III or IV, Grade A of NN-P-71. Interlocking of loads shall be effected by reversing the pattern of each course. If the container is of a size which does not conform to any of the patterns specified in MIL-STD-147, the pallet pattern used shall be approved by the contracting officer.

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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 shirts covered by this specification are intended for wear by male personnel of the U. S. Marine Corps.

6.2 Acquisition requirements. Acquisition documents must specify the following:

(a) Title, number and date of this specification.

(b) Sizes required (see 1.2).

(c) Whether first article is required (see 3.2).

(d) Number of shirts in first article (see 3.2).

(e) Selection of applicable levels of packaging and packing (see 5.1 and 5.2).

(f) When level A, method 2, packing is required (see 5.2.1.2).

(g) When palletization is required (see 5.4).

6.3 Standard samples, shade samples, and patterns. For information regarding the availability of standard samples of the shirt, standard shades, and patterns specified, address inquiry to the procuring activity.

6.4 First article. When a first article is required, it shall be inspected and approved under the appropriate provisions of FAR 52.209 and the requirements of this specification. The sample(s) presented for inspection may be first article, preproduction samples, first production or sample(s) taken from the first lot depending on the contractors history and will be as directed by the Contracting Officer. The Contracting Officer shall include specific instructions in all acquisition instruments regarding arrangements for selection, inspection, and approval of the first article.

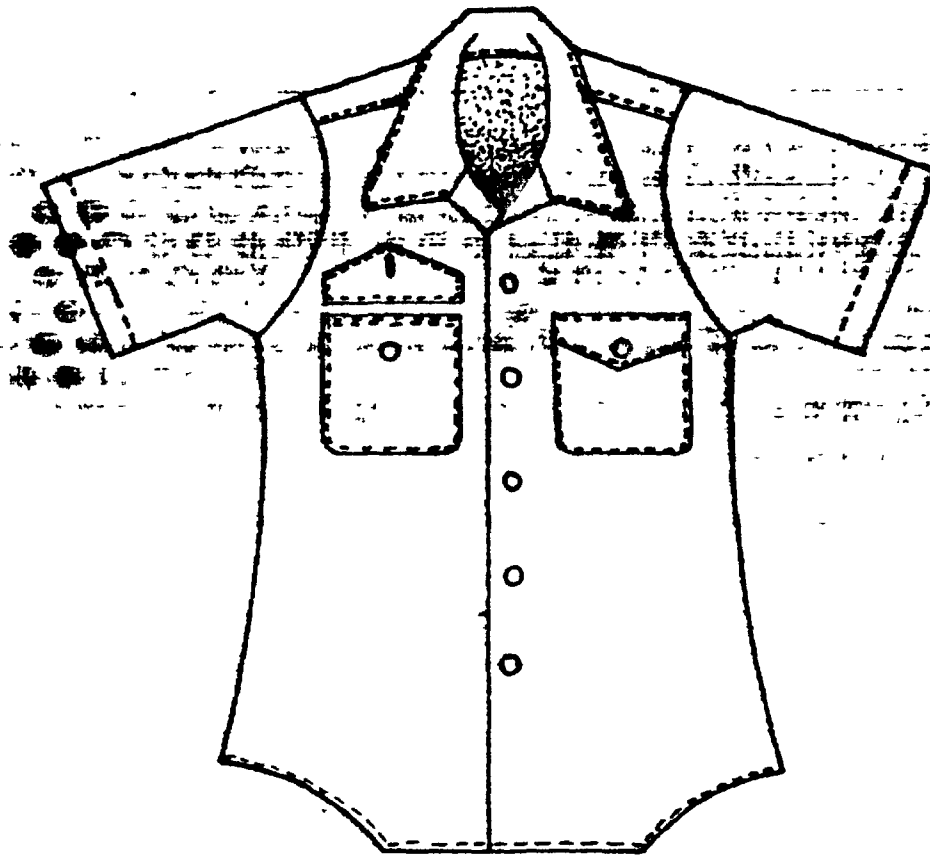
6.5 Subject term (keyword) listing.

Cloak
Male
Polyester/Wool

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

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

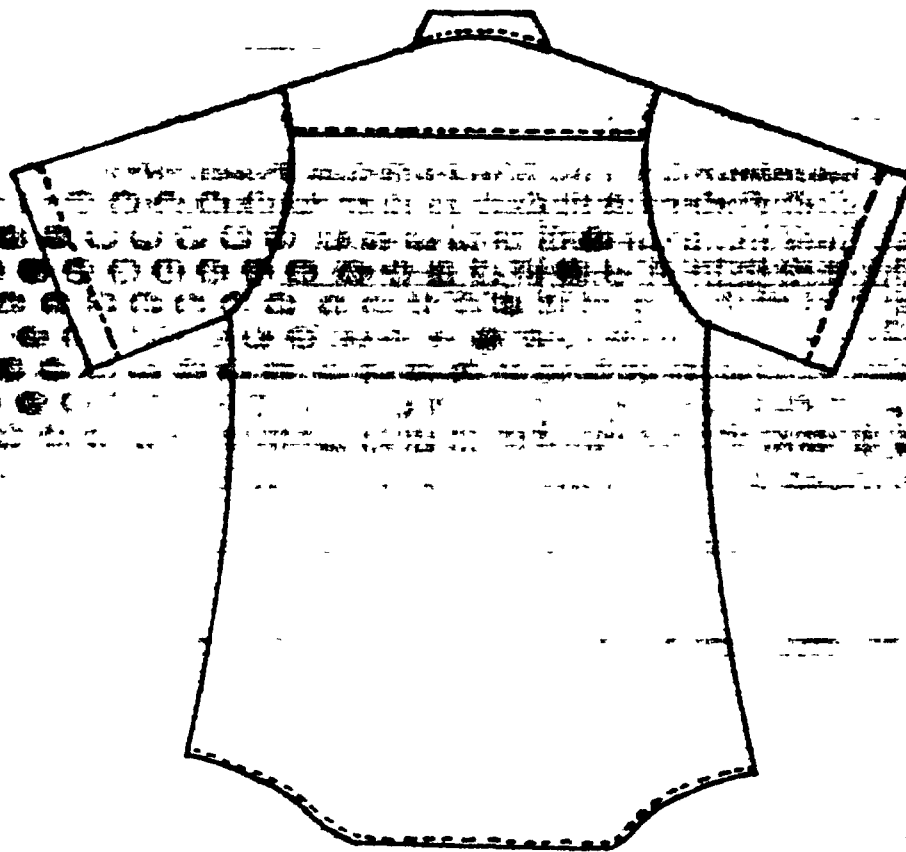
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FRONT VIEW

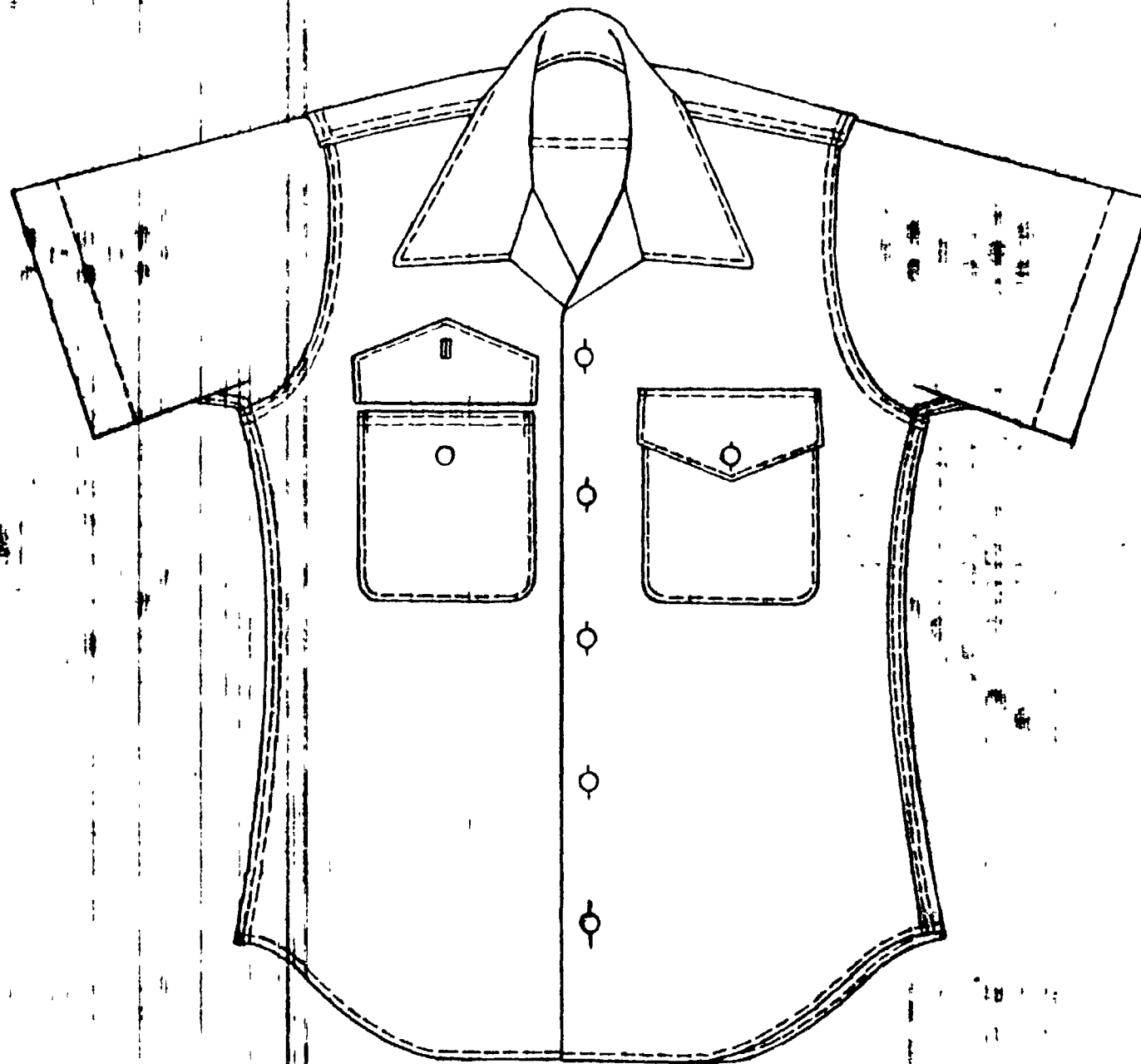
MIL-S-19984E(MC) SHORT-SLEEVED, MAN'S, KHAKI, WITH QUARTER
LENGTH SLEEVE, CLASS 1

REF ID: A66454
DECLASS-1998-12 (DEC)



BACK VIEW

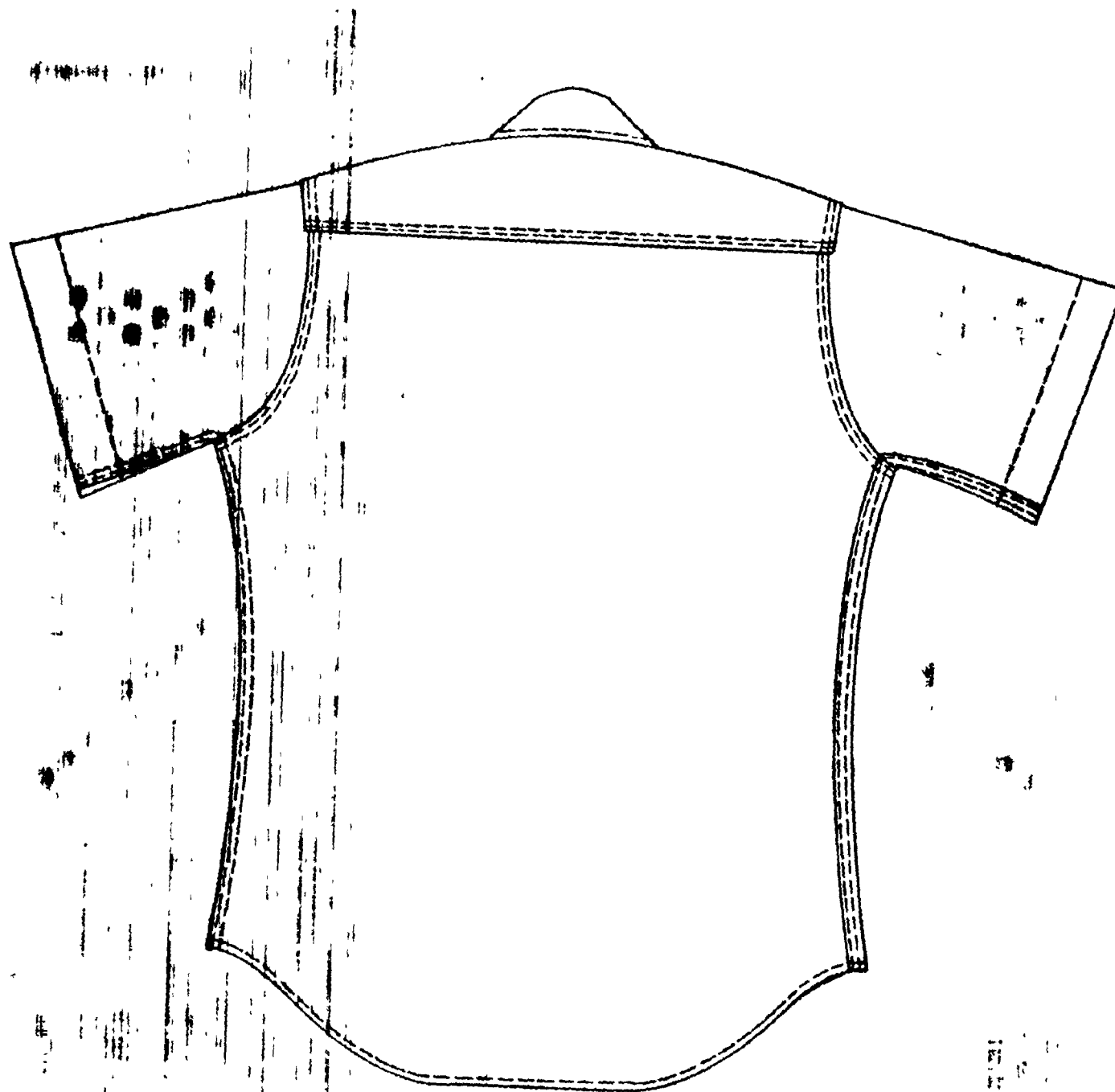
FIG. 2 SHIRT MAN'S, KAHKI, WITH
QUARTER LENGTH SLEEVE



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FIGURE 3 SHIRTS: MAN'S, KHAKI, WITH QUARTER LENGTH SLEEVE
CLASS 2

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FIGURE 4. SHIRTS, MAN'S, KHAKI; WITH QUARTER LENGTH SLEEVE
CLASS 2

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Preparing Activity
Navy - MC
Project No. 8405-N116

(STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL)*(See Instructions - Reverse Side)*

1 DOCUMENT NUMBER MIL-S-19948E(MC)		2 DOCUMENT TITLE SHIRT, MAN'S: KHAKI: WITH QUARTER LENGTH SLEEVE	
3a NAME OF SUBMITTING ORGANIZATION		4 TYPE OF ORGANIZATION (Mark one)	
b ADDRESS (Street, City, State, ZIP Code)		<input type="checkbox"/> VENDOR	
		<input type="checkbox"/> USER	
		<input type="checkbox"/> MANUFACTURER	
		<input type="checkbox"/> OTHER (Specify) _____	
5 PROBLEM AREAS			
a. Paragraph Number and Wording			
b. Recommended Wording			
c. Reason/Rationale for Recommendation			
6 REMARKS			
NAME OF SUBMITTER (Last, First MI) - Optional		b WORK TELEPHONE NUMBER (Include Area Code) - Optional	
c MAILING ADDRESS (Street, City, State, ZIP Code) - Optional		8 DATE OF SUBMISSION (YYMMDD)	