

INCH-POUND

MIL-S-29395A(MC)

9 MARCH 1994

SUPERSEDING
MIL-S-29395(MC)
19 MARCH 1981

MILITARY SPECIFICATION

SLACKS, WOMEN'S; MUSICIAN'S

This specification is approved for use by 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 slacks for wear by female members of the U. S. Marine Band.

1.2 Classification. The slacks shall be of one type in the following classes, sizes and lengths (see 6.2).

CLASS

Class 1 - Polyester/Wool, Gabardine: Sky Blue 2319
Class 2 - Polyester/Rayon, Gabardine: White 2400
Class 3 - Polyester/Rayon, Gabardine: White 2400 (Lined)

Schedule of Sizes and Lengths

Sizes X0,2,4,6,8,10,12,14,16,18
Lengths: Short, Regular and Long

2. APPLICABLE DOCUMENTS

2.1 Government documents.

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

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to the Commander (PSC), Marine Corps Systems Command, Quantico, VA 22134-5010 by using the Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8410

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SPECIFICATIONS

FEDERAL

- A-A-50083 - Bag, Plastic, Folded Garment
- A-A-50196 - Thread, Silk
- A-A-50198 - Thread, Gimp, Cotton
- A-A-50199 - Thread, Polyester Core, Cotton or Polyester Covered
- A-A-52094 - Thread Cotton
- A-A-52106 - Cloth, Twill or Plain Weave, Polyester or Polyester Blend
- V-B-871 - Button, Sewing Hole and Button, Staple(Plastic)
- V-F-106 - Fastener, Slide, Interlocking
- V-T-295 - Thread, Nylon
- DDD-L-20 - Label; For Clothing, Equipage and Tentage (General Use)

MILITARY

- MIL-C-10176 - Cloth, Gabardine, Wool, Polyester and Wool
- MIL-B-17757 - Box, Shipping, Fiberboard (Modular Sizes)
- MIL-C-29405 - Cloth, Broadcloth, Wool and Wool/Nylon
- MIL-C-41820 - Cloth, Gabardine, Polyester and Rayon
- MIL-C-44296 - Cloth, Fusibles
- MIL-C-87059 - Cloth, Nylon, Tricot

STANDARDS

FEDERAL

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

MILITARY

- MIL-STD-129 - Marking for Shipment and Storage
- MIL-STD-656 - Provisions for Evaluating Quality of Slacks Women's
- MIL-STD-984 - Provisions for Size Labeling of Women's Uniform Clothing

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

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

Department of Defense (DoD) Standard Color Card of
Sewing Threads 1968

Department of Defense (DoD) Standard Shades for Buttons 1966

(Copies may be obtained from the Color Association of the United States, Inc., 343 Lexington Avenue, New York, New York 10016.)

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

AMERICAN SOCIETY OF TESTING AND MATERIALS

ASTM D 3951 - Standard Practice for Commercial Packaging

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

(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).

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

3. REQUIREMENTS

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

3.2 First article. When specified (see 6.2), in the contract or purchase order, the contractor shall furnish sample slacks for first article inspection and approval (see 4.4 and 6.4).

3.3 Materials.

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

a. Class 1. Cloth, 10.6 ounce, polyester/wool gabardine, sky blue shade 2319 conforming to type II, class 12 of MIL-C-10176.

b. Class 2. Cloth, 8 ounce, polyester and rayon, gabardine, white shade 2400 to type III, class 1 of MIL-C-41820.

c. Class 3. Cloth, 8 ounce, polyester and rayon, gabardine, white shade 2400 to type III, class 1 of MIL-C-41820.

3.3.2 Lining and pocketing. The material for the pockets, crotch lining and pocket stays shall be twill or plain weave cloth, polyester or polyester blend cloth conforming to class I of A-A-52106. The color shall be white.

3.3.3 Lining. The material for lining the class 3 slacks shall be cloth, nylon, tricot warp knit, 2.7 oz/sq yard, shade White 3006 conforming to MIL-C-87059.

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3.3.4 Ornamental stripes. The material for the ornamental stripes shall be cloth, wool, broadcloth, scarlet shade 2501 and white, 16.5 ounce conforming to type I, class 4 of MIL-C-29405.

3.3.5 Thread. The thread for each class of slacks shall be as follows:

a. Class 1, 2, and 3. Cotton thread shall be used conforming to A-A-52094 as follows:

Operation	Type	Ticket No.	Ply
Buttonholes	III	0	3
Seams, stitching	III	30, 50	3
Overedging	I	70	2
Buttons	II	16, 20	4

As an alternate to the cotton thread, a polyester, cotton-covered thread conforming to A-A-50199, ticket No. 50, 3 ply or ticket No. 70, 2 ply may be used. CAUTION: Some automatic machines will not operate properly with this thread.

3.3.3.1 Automatic button sewing. If an automatic machine which sews and shanks (wraps) the buttons in one operation is used, the thread shall be waxed nylon monocord special No. 5, having a minimum breaking strength of 16 pounds and a minimum length per pound of 2150 yards. This thread shall be tested for these requirements and for colorfastness (see 3.3.4.3) in accordance with test methods in V-T-295.

3.3.3.2 Color. The color of the thread for each class of slacks shall conform to the following:

- a. Class 1. Blue, AT, Cable No 66060
- b. Class 2 and 3. White, AG, Cable No 66049

NOTE: See DoD Standard Color Card of Official Standardized Shades for Sewing Threads 1968.

3.3.3.3 Colorfastness. The colored thread shall show fastness to light and wet dry cleaning equal to or better than the standard sample. When a standard sample is not available, the colored thread shall show "good" fastness to light and wet dry cleaning.

3.3.4 Gimp. The gimp for reinforcing the buttonhole shall conform to type I or II, size No. 8 of A-A-50198. The color of the gimp shall be the same as indicated for thread in 3.3.3.2 with same colorfastness requirements specified for thread in 3.3.3.3.

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3.3.5 Button. The button for the waistband shall be 27-line and for hip pocket 22-line conforming to type II, class D, style 4 of V-B-871. The color of the buttons for each class of slacks shall be as follows: (See DOD Standard Shades for Buttons, 1966.)

- a. Class 1. Blue, Shade BV, Cable No 62003.
- b. Class 2 and 3. White, Shade BA, Cable No 62031

3.3.6 Slide fasteners. The slide fasteners shall conform to either 3.3.6.1 or 3.3.6.2.

3.3.6.1 Metal. The slide fasteners shall conform to type I, style 3, short tab pull, cam lock size LS (commercial No. 4), of V-F-106, except that the salt spray test shall not be required. All the components of the slide fastener shall be brass and from the same supplier (see 4.5.1). The tape shall be cotton or synthetic or a combination. The length of the slide fastener shall be 7 inches for all sizes.

3.3.6.2 Plastic coil. The slide fastener shall be manufactured of polyester or nylon consisting of an automatic or cam lock and shall be equal to commercial size No. 2. The tape shall be a blend of nylon and cotton or polyester and cotton or polyester. The length of the slide fastener shall be 7 inches for all sizes.

3.3.6.3 Color. The color of the slide fastener tape shall be as follows:

- a. Class 1. Blue, Shade AA, Cable No 66527.
- b. Class 2 and 3. White, Shade C, Cable No 66503

3.3.6.4 Colorfastness. The dyed slide fastener tape shall show colorfastness to laundering equal to or better than the guide sample when tested as specified in V-F-106. When a guide sample is not available, the tape shall show "good" colorfastness when tested as specified in V-F-106.

3.3.7 Combination label. Each pair of slacks shall have a combination identification, and instruction label conforming to type VI, classes 1 and 3 of DDD-L-20. The slacks are intended to be dry cleaned and the labels shall show fastness to dry cleaning. The inscription shall be as follows:

SLACKS, WOMEN'S	
FIBER CONTENT:	
CONTRACT NO.:	DLA-100-C-0000 (Example)
NAME OF CONTRACTOR	
DRY CLEAN ONLY	

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3.3.7.1 Size labels. The size label shall conform to type VI, Class 2 of DDD-L-20 except the stock number is not required. The inscription on the size label shall conform to MIL-STD-984; Table II, Body Measurements for Marine Corps, Table III Height Ranges and Figure 2. Examples of labels for women's slacks is as follows: Note: The label on the bottom of Figure 2 shall be used for Marine Corps items.

Example:
 Hip Circ 36"
 Waist Circ 25-1/2"
 Height 63-1/2 to 67" R
 (Size Code 6)

3.3.8 Fusible interlining. The fusible interlining for the waistband and left fly shall be black or gray. The fusible shall conform to type V, Class 1, Style B of MIL-C-44296. Fusible interlining f/classes 2 and 3 shall be white, nonwoven. Class 1 may be black or gray. All have the same requirements. The fusible shall be fused to the basic material as recommended by the supplier of the fusible.

3.3.9 Hook and Eye. The hook and eye shall be North and Judd(Hook Flex H-49, K-50, H-89 and E-90); Universal Button Co. (Talon #3, #7 and #8 hook with #8 eye); Akim Co or Patwin, Inc., Junior Series, Type JB; Stimpson (P-536, D-4086, D04457, D-4288); Rau (OA50, OX 1256, 080415); Patwin, Inc. (Slim-Slak with MB eye, and Slik-Slax) or equal. The finish shall be nickel plate. Prior to use of an "or Equal" item, the supplier shall submit the item with supporting data to the contracting officer for approval. (see 4.5.1)

3.4 Design. The slacks shall be the U. S. Marine Corps design shown on Figures 1 and 2, having a two-piece waistband with button closure, with hook and eye, two (2) back pockets w/flaps, outlet at the seat seam, front fly with slide fastener and slightly tapered legs with unhemmed overedged bottoms. The class 1 slacks shall have a scarlet and white ornamental stripe sewn to each outseam. The class 3 slacks shall be lined.

3.5 Patterns. Standard patterns to be used to cut working patterns will be furnished by the Government. The patterns allow 1/2-inch seam allowance for all seams, except as otherwise indicated herein. The working patterns shall be identical to the Government patterns. Neither the Government patterns nor the working patterns shall be altered in any way.

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

Pattern Nomenclature

Item	Basic Material	No. of Cut Parts
1.	Front	2
2.	Back	2
3.	Left Waistband	1
4.	Right Waistband	1
5.	Left Fly	1
6.	Right Fly Placket	1
7.	Back Pocket Bearer	2
8.	Back Pocket Facing	2
9.	Back Pocket Flap	4
<u>Interlining (Fusible)</u>		
10.	Left Fly	1
11.	Left Waistband	1
12.	Right Waistband	1
13.	Back Pocket Flap	2
<u>Lining (Cloth Twill)</u>		
14.	Crotch Lining	2
15.	Pockets	2

3.6 Construction. The slacks shall be manufactured in accordance with operation requirements as specified in Table I. The contractor is not required to follow the exact sequence of operations as listed in Table I, but all operations specified shall be used to manufacture the slacks.

3.6.1 Stitches, seams, and stitching. Stitch, seam and stitching types specified in Table I shall conform to FED-STD-751. Whenever two or more methods for seam or stitching types are given for the same part of the operation, any one of them may be used. Where stitch 401 is used, the looper (underthread) shall be on the inside of the slacks. The minimum and maximum number of stitches per inch shall be as specified in Table I.

3.6.1.1 Thread breaks and ends of seams. The ends of all seams and stitching produced with 301 stitch type, when not caught in other seams or stitching, shall be backstitched not less than 1/4 inch. Thread breaks (all stitch types) shall be secured by stitching back of the break not less than 1/2 inch. Skipped stitches may be repaired by using 301 stitch type. The ends of a continuous line of stitching shall be overlapped not less than 1/2 inch. Thread ends of darts shall be trimmed to a length of 1/2 inch. When an automatic dart machine is used, the ends shall be backstitched not less than 3 stitches.

3.6.2 Buttonhole. The buttonhole shall be eyelet end, taper bar type. The finished cut length of buttonhole shall be 3/4 inch for front of waistband, and 5/8 inch for backpocket flaps.

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3.6.3 Pressing. Pressing as required in Table I shall be accomplished with a heated pressing iron or machine.

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

- a. Corrosive metal fastening devices.
- b. Sew-on shade tickets.
- c. Adhesive type tickets, which leave traces of paper or adhesive on material after removal of tickets.

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
1	<p><u>Cutting.</u></p> <p>a. Cut the slacks in strict accordance with patterns furnished, which shall show size, placement of component parts, directional lines for cutting, marks for finished length of darts and notches for proper assembly of parts.</p> <p>b. All component parts of the basic material shall be cut from one piece of material except fly facings, which may be cut from ends. Parts cut from ends shall approximate the shade of the main assembly.</p> <p>c. Place fronts and backs so that the directional line is in the warp direction.</p> <p>d. Cut the waistbands left fly and pocket flap interlining in accordance with the patterns.</p> <p>e. Cut the crotch lining, and pockets from the twill cloth in accordance with the patterns.</p> <p>f. Cut the ornamental stripes in the warp direction. Cut two white stripes 1-1/4 inches wide and four scarlet stripes 1 inch wide.</p>					
2	<p><u>Shade marking.</u></p> <p>a. Mark or ticket all component parts of slacks except parts cut from ends, to insure a correct size and uniform shade throughout the slacks (or uniform).</p> <p>b. The use of corrosive metal fastening devices or sew-on tickets for shade marking is prohibited.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
4	<u>Make ornamental stripes.</u> (cont'd)					
	d. Position the two scarlet stripes on each side of the corded white stripe with one folded edge of each scarlet stripe abutted against the corded edge. Stitch each inner edge of the scarlet stripe to the white stripe 1/16 inch from the folded edge.	301	SSav-4	10-14	A	A
5	<u>Make darts (basic material).</u>					
	The darts shall be tapered on the inside without twists or puckers. Thread ends at lower end of darts shall not be trimmed closer than 1/2 inch in length. End of dart need not be backtacked except when automatic dart machine is used.					
	a. Fold and stitch back darts as indicated by notches and marks on the pattern. Press toward center back. Stitch across top of dart 1/8 inch from raw edge.	301	OSf-1	12-14	50/3	50/3
	b. Fold and stitch front darts as indicated by notches and marks on the pattern. Press toward the center front. Stitch across the top of dart 1/8 inch from raw edge.	301	OSf-1	12-14	50/3	50/3
6	<u>Make darts (lining - class 3).</u>					
	a. The darts shall be tapered on the inside without twists or puckers. Thread ends at lower end of darts shall not be trimmed closer than 1/2 inch in length. End of dart need not be backtacked except when automatic dart machine is used.					
	b. Fold and stitch back darts as indicated by notches and marks on the pattern. Press toward center back. Stitch across top of dart 1/8 inch from raw edge.	301	OSf-1 and SSa-1	12-14	50/3	50/3

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
6	<u>Make darts (lining - class 3).</u> (cont'd)					
	c. Fold and stitch front darts as indicated by notches and marks on the pattern. Press toward center front. Stitch across top of dart 1/8 inch from raw edge.	301	OSf-1 and SSa-1	12-14	50/3	50/3
7	<u>Join lining to slacks (class 3).</u>					
	Finished appearance. The front and back lining parts shall be joined to the front and back of the slacks without twists, puckers, pleats or distortion.					
	a. Position front and front lining back to back with edges even and notches matching. Seam together 1/8 inch from all edges.	301	SSa-1	12-14	50/3	50/3
	b. Position back and back lining back to back with edges even and notches matching. Seam together 1/8 inch from all edges.	301	OSf-1	12-14	50/3	50/3
8	<u>Join crotch pieces.</u>					
	Fold crotch pieces in half lengthwise and attach the raw edge to the crotch of the front panels with a 1/8 inch seam at the raw edge. It may also be attached in the overedge operation.	301	SSa-1	12-14	50/3	50/3
9	<u>Overedge stitching.</u>					
	a. Overedge stitch the raw edges of outseams and inseams of front and back parts.	503 or 504	EFd-1	8-10	70/2	70/2
	b. Overedge stitch the raw edges of center front seam, and seat seam.	503 or 504	EFd-1	8-10	70/2	70/2
	c. Fold fly piece in half lengthwise and overedge stitch side and bottom raw edges together.	503 or 504	EFd-1	8-10	70/2	70/2

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
9	<u>Overedge stitching.</u> (cont'd)					
	d. Position the interlining on the left fly facing and overedge stitch the back edge of interlining and facing together.	503 or 504	EFd-1	8-10	70/2	70/2
10	<u>Set hip pocket bearer.</u> Finished appearance. The back pocket bearer and facing shall be properly positioned and securely sewn with the stitching of uniform gauge and without pleats, puckers or other distortions.					
	a. The back pocket bearers shall each be a single ply of basic material.					
	b. Position the bearer on the pocket material in accordance with notches indicated by marks on the pattern.					
	c. Fold under the lower raw edge of bearer and facing 1/4 to 3/8 inch and stitch to the pocket 1/8 inch from the folded edge. Continue stitching across the bottom raw edge. A selvage edge need not be turned.	301	LSd-1 and LSbj-1	10-14	50/3	50/3
	d. Position the label on the folded edge of right pocket, facing the wearer, and stitch the label to the pocket 1/16 to 1/8 inch from the label edge.	301	SSa-1	10-14	50/3	50/3

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
11	<p><u>Make hip pocket flaps.</u></p> <p>Finished appearance. The hip pocket flaps shall finish smooth and flat, without twists, pleats, or puckers and shall be uniform in shape and size in accordance with patterns. The lining shall not be exposed on the outside. The edges of the flaps shall be well forced out and the edgestitching shall be uniform in width. The buttonholes shall be correctly positioned, clean cut, and well made, and the stitching securely caught in the basic material.</p> <p>a. Flaps for the hip pockets shall be made of two plies of basic material and one ply of fusible interlining. Fuse interlining to top ply of flap.</p> <p>b. Stitch the two plies of basic material together 3/16 to 1/4 inch from the side and bottom edges. Evenly trim the edges for proper turning when necessary.</p> <p>c. Turn the flaps, working out the seamed edges, corners and points completely. Edgestitch the seamed edges of flaps uniformly 1/16 to 3/32 inch from seamed edges, working the lining or under ply back from the finished edge of the flaps. The lining underply shall not be exposed on the outside.</p> <p>d. Make a vertical, eyelet end, taper bar type buttonhole cut 5/8 inch long through the center of the flap with the edge of the eyelet 1/2 to 5/8 inch above the center point. Buttonholes shall be well worked over gimp to fit a 22-line button with the ends of the buttonholes securely tacked. The purling of the buttonhole shall be on the outside of the flaps.</p>	<p>301 or 401</p> <p>301</p> <p>Button hole</p>	<p>SSe-2 (a) SSe-2</p> <p>SSe-2 (b)</p>	<p>10-16 10-16</p> <p>10-16</p> <p>52-54 per buttonhole including bartack</p>	<p>0 0</p> <p>0</p> <p>0</p>	<p>0 0</p> <p>0</p>

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
11	<u>Make hip pocket flaps.</u> (cont'd) e. The finished hip pocket flap shall measure $4-1/2 \pm 1/8$ inches across top.					
12	<u>Attach hip pocket, flaps and label.</u> Finished appearance. The pockets shall finish smooth and flat without bulkiness, bulges or other distortions on the outside of the finished slacks. The stitchings shall be uniform and secure. The pocket openings and flaps shall be in proper alignment.					
	a. Position pocket flaps on the outside of the back in line with the mark as indicated by pattern, with the pocketing on the under side. Stitch through all plies 3/16 to 1/4 inch from the mark.	301	LSg-2 (a)	12-16	50/3	50/3
	b. Position the hip pocket cord on the outside of slacks in line with the mark and stitch through all plies 3/16 to 1/4 inch from the mark.	301	SSe-2 (a)	12-16	50/3	50/3
	c. Cut pocket opening through the back and pocket, simultaneously. The opening shall not extend beyond the ends of the flap. Turn the cord piece through the opening and raise stitch, forming a 1/8 to 3/16 inch cord edge at lower edge of pocket opening.	301	SSe-1 (shows finished seam)	12-16	0 or 50/3	0 or 50/3
	d. Turn under the lower raw edge of cord facing and seam pocketing 1/16 to 1/8 inch from folded edge.	301	LSd-1 or	10-16	50/3	50/3
	When cord facing is cut on selvage, the edge need not be turned under.	301	LSbj-1 (selvage)	10-16	50/3	50/3

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
12	<u>Attach hip pocket, flaps and label.</u> (cont'd)					
	e. Turn the pocketing wrong side out, matching notches with pocket opening, and stitch sides 3/16 to 1/4 inch from raw edges. The stitching may extend across the bottom folded edge.	301 or 401	SSea-2 (a) SSea-2	12-16 12-16	50/3 50/3	50/3 50/3
	f. Turn pocketing, forcing out corners and seamed edges. Fold and stitch the pocket 1/4 to 3/8 inch from the side edges. Continue to stitch along the bottom edges. The stitching may extend across the bottom folded edge.	301 or 301	SSe-2 (b) OSf-1	12-16 12-16	50/3 50/3	50/3 50/3
	g. Turn flap down and raise stitch through all plies, 1/16 inch from joining seam, closing top of pocket.	301	LSg-2 (b) (show finished seams)	12-16	0 or 50/3	0 or 50/3
	h. Position the combination personal identification size instruction label on the top of the right pocketing so that on the finished slacks it will face the wearer. No part of the label printing shall be covered by the waistband interlining curtain. Stitch the label on all four sides 1/16 to 3/32 inch from the edges. Stitching shall not be through printing.	301	LSbj-1	10-16	50/3	50/3
	-or-					
	i. Stitch top edge of combination personal, identification, size instruction label to the lower edge of the waistband lining above the right hip pocket. The ends of stitching need not be tacked provided the stitching extends at least 1/2 inch beyond each side of label.	301	LSa-1	12-16	0 or 50/3	0 or 50/3

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
12	<u>Attach hip pocket, flaps and label.</u> (cont'd)					
	j. Securely bartack both ends of the pocket opening through all plies of material.	301	SSa-1 (each end)	12-16	50/3	50/3
	-or-					
	k. Operations 10c, 12a, 12b and 12c may be accomplished on an automatic machine which sets the flap, stitches, cuts and turns cord facing in one operation. When this machine is used, the bearer may be trimmed to permit insertion into machine and the recommended pocket stay material may be used.	101		12-16	50/3 or A/3	
	-and-					
	l. Raise stitch the joining seam of the lower edge of pocket opening through back of slacks and cord facing, only. Raise stitch the back at upper edge of pocket opening through all plies, closing the top of the pocket. Securely tack both ends of pocket opening.	301		12-16	0 or 50/3	0 or 50/3
	m. The depth of the pockets shall be 5 to 5-1/2 inches when measured on the inside of pocket from top edge of cord facing to bottom.					
	n. The finished pocket opening (after bartacking) shall not exceed the hip pocket flap.					
	o. On the finished slacks, the pocket flaps shall be $2-1/8 \pm 1/4$ inches at center measured from seam to center point.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
13	<u>Join outseams.</u> Finished appearance. Outseams shall be carefully joined with notches matching and without twists, puckers or pleats. The seams shall start and finish evenly and lie smooth and flat. a. Join the outseam with a 1/2 inch seam, matching the notches as indicated by marks on the patterns. b. Spread open the outseams from top edge of slacks to bottom and press smooth and flat with a heated pressing machine.	 301 or 401	 SSa-1 SSa-1	 12-14 12-14	 30/3 30/3	 30/3 30/3
14	<u>Attach ornamental stripes.</u> (Class 1) Finished appearance. Ornamental stripes shall be set on the slacks from top edge of fronts to bottom edge of legs, with the top end to finish in the waistband seam. The ornamental stripes shall be securely and uniformly stitched, properly positioned and shall finish without distortion. a. Position the ornamentation centered on the outseam. Seam to slacks from top to bottom 1/8 inch from edge of ornamentation.	 301	 SSat-2	 10-14	 A	 A
15	<u>Make waistband.</u> Finished appearance. The two piece waistband shall be constructed with left and right parts. Each part shall consist of 1 ply of basic material and 1 ply of interlining. The left waistband shall have a pointed front end and the right waistband shall have a square end. The center back of the waistbands shall have square ends. a. Overedge stitch the inside raw edge of left and right waistbands, and interlinings.	 503 or 504	 EFd-1	 8-10	 70/2	 70/2

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
16	<u>Make waistband.</u> (cont'd)					
	b. Fold the left waistband in half lengthwise, face to face with ends even and notches matching. Join the plies together at the pointed end with a 1/4 inch seam, starting at the notches, forming the pointed end and stitching up to the folded edge. Finish the square end of left waistband with a 1/4-inch seam, turning up 1/4 inch of raw edge and seaming across the width of the waistband through all plies to close end.	301	SSe-2 (a)	12-14	50/3	50/3
	c. Fold the right waistband in half lengthwise face to face with ends even. Finish each square end with a 1/4-inch seam, turning up 1/4 inch of raw edge and seaming across the width of the waistband through all plies to close the end.	301	SSe-2 (a)	12-14	50/3	50/3
	d. Trim the excess material at each end to 1/8 inch from the seams. Turn the right and left waistbands, forcing out the corners and point completely. Edgestitch 1/16 inch from the seamed edges at the pointed and squared ends.	301	SSe-2 (b)	12-14	50/3	50/3
	e. Continue to edgestitch along the length of the waistband 1/16 inch from the upper folded edge.	301	OSf-1	12-14	50/3	50/3
	f. The edgestitching may be performed continuously with the top stitching on the outside of the waistband in operation 19a.					
17	<u>Join inseams.</u>					
	a. Match notches at front and back of inseam and join with a 1/2-inch seam from notch to bottom.	301 or 401	SSa-1	12-14	50/3 50/3	50/3 50/3
	b. Press inseam open and flat.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
18	<p><u>Join crotch and seat seam.</u></p> <p>Finished appearance. The crotch and seat seams shall be joined with stitch tension of sufficient elasticity to meet strain encountered in sitting and stooping. The waist shall be measured before joining crotch and seat seam to assure correct waist size. In the finished slacks, the inseams shall meet and the right and left waistband joining seams shall be aligned; the base of the left fly shall cover the right fly on the outside.</p> <p>a. Measure waist to proper size before joining crotch, seat and waist seam.</p> <p>b. Join crotch and seat seams from the base of the fly to the notch with a 1/2-inch seam, tapering from the notch through waistband to accomplish the measured size and leaving a tail of stitching 3/4 to 1 inch long.</p> <p>c. Spread open crotch and seat seams and press smooth and flat with a heated pressing machine tucking in the stitching tail under the pressed open seat seam.</p> <p>d. The inseam at the crotch shall not stagger more than 3/16 inch.</p> <p>e. Topstitch through the finished waistband superimposing the topstitching and catching the pressed open seat seam at the top of the waistband.</p>	401	SSa-1	8-10 (each needle)	AA Poly ester	AA Poly ester
	e. Topstitch through the finished waistband superimposing the topstitching and catching the pressed open seat seam at the top of the waistband.	301	LSq-1	8-10	A	A
19	<p><u>Make left fly.</u></p> <p>Finished appearance. The left fly shall finish smooth and flat without twists, puckering or distortion. The overedge stitching shall be securely caught in the fabric.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
19	<u>Make left fly.</u> (cont'd)					
	a. Position the slide fastener on the left fly facing and left fly interlining with bottom end of chain 1/4 inch above the fly notch and top edges even. The front edge of chain shall be 1/2 to 5/8 inch from front edge of finished fly. Stitch slide fastener tape to the fly through the interlining with a double row of stitches 3/16 to 1/4 inch gage.	301	LSbj-2	12-14	50/3	50/3
20	<u>Make right fly.</u>					
	Finished appearance. The right fly shall finish without bulkiness, twists, puckers or pleats.					
	a. Position the slide fastener on the fly with the slide fastener tape 1/2 inch from the overedged seam and the top edges even. Stitch the slide fastener to the fly 1/2 inch from the back edge of fly.	301	LSbj-2	12-14	50/3	50/3
21	<u>Join left and right fly to front.</u>					
	Finished appearance. The seam joining the fly assemblies to the front shall be without pleats, puckers, twists or other distortions.					
	a. Position the left fly assembly on the outside of left front, face to face, with notches matching. Join left fly assembly to front with a 1/2-inch seam.	301	SSa-1	12-14	50/3	50/3
	b. Turn joining seam onto fly assembly and stitch 1/16 inch from seamed edge, starting at top raw edge of fly and stitching to the notch.	301	LSb-1	12-14	50/3	50/3

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
21	<p><u>Join left and right fly to front.</u> (cont'd)</p> <p>c. Turn left fly to the inside with joining seam 1/16 to 1/8 inch back of folded edge. Press front edge without damage to the fastener, forcing out the seams to the edge.</p> <p>d. Stitch left fly to left front, starting at the top and continuing with a curve to the bottom notch. The stitching shall be $1-1/4 \pm 1/8$ inches from the front edge of the fly.</p> <p>e. Position right fly assembly on right front with overedged edges and top raw edges even. Join right fly to front with 1/2-inch seam.</p> <p>f. Press right and left fly flat with heated pressing iron, with the seam toward the side seam.</p> <p>g. Edge stitch 1/16 inch from the front seamed edge, through the slide fastener tape and the placket.</p>	301	SSa-1	12-14	50/3	50/3
		301	SSa-1	12-14	50/3	50/3
		301	LSq-2 (b)	12-14	50/3	50/3
22	<p><u>Join waistband to slacks.</u></p> <p>Finished appearance. The waistband shall be joined without twists, puckers, pleats or distortions. The back square ends of the waistband shall be even with the seat seams.</p> <p>a. Position the left waistband on the left front, face to face, with the notch and finished left fly opening matching. Join together with a 3/8-inch seam.</p> <p>b. Position the right waistband on the outside of slacks, face to face, with square end and folded edge of placket even. Join together with a 3/8-inch seam.</p>	301	SSa-1	12-14	50/3	50/3
		301	SSa-1	12-14	50/3	50/3

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
23	<p><u>Attach hooks and eyes.</u></p> <p>Finished appearance. In the finished trousers, when hook and eye is engaged, the closure shall not bulge, pucker or twist.</p> <p>a. Position the hook at the center (1/4 inch off center tolerance) of the left waistband with the rolled edge of hook aligned with the slide fastener scoops. Attach hook to left waistband through a suitable reinforcement.</p> <p>b. Position the eye at the center of the right waistband aligned with slide fastener scoops and to correspond with hook and left waistband. Attach eye to right waistband through a suitable reinforcement.</p>					
24	<p><u>Topstitch waistband.</u></p> <p>Finished appearance. The waistband shall be sewn on smoothly and evenly and shall have a flat appearance throughout, without gathers, puckers, pleats or other distortions either in the waistband, front part or back part, and shall be even in width along the entire length. The waistband shall be $1\frac{3}{8} \pm \frac{1}{8}$ inches wide.</p> <p>a. Topstitch the waistband to the slacks 1/16 inch from the lower folded edge, catching the overedge stitched portion of waistband in the stitching, and with the stitching extending the entire length of the waistband.</p>	301	BSr-2 (a)	12-14	50/3	50/3
25	<p><u>Bartack fly.</u></p> <p>Finished appearance. The bartacks shall be properly positioned and correctly placed to reinforce the points of strain.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
25	<u>Bartack fly.</u> (cont'd)					
	a. Bartack the bottom end of the fly horizontally through all plies at the juncture of the crotch seam and fly (see Figure 2).	Bartack		21-28 per bartack	0	0
	b. Bartack the inside front edge of right fly to back of left fly with a horizontal bartack. Bartack shall be $1 \pm 1/4$ inch from bottom folded point of right fly.	Bartack		21-28 per bartack	0	0
	c. Bartacks shall be $3/8$ to $1/2$ inch long and shall be stitched through all plies of material at the point of bartacking.					
26	<u>Finish slack bottoms.</u>					
	a. Overedge stitch or pink the slack bottoms.	503 or 504	EFd-1	8-10	70/2	70/2
27	<u>Make buttonhole on waistband.</u>					
	Finished appearance. The buttonhole shall be clean cut, well made and correctly positioned. The stitching shall be securely caught in the basic material. The buttonhole shall be well worked over gimp to fit a 27-line button. The purling of the buttonhole shall be on the outside of the waistband.					
	a. Make $3/4$ -inch-long horizontal, eyelet-end, taper-bar type buttonhole through the center of the pointed end of waistband with the inside, purled edge of the eyelet $1/2$ to $5/8$ inch from the finished ends to waistband.	Button hole	44-46 per Button hole includ ing tack		0	0
28	<u>Clean slacks.</u>					
	a. All ends of stitching shall be trimmed and the loose threads removed from slacks. Pull and remove any basting threads.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
28	<u>Clean slacks.</u> (cont'd) b. Any spots, stains and shade tickets or markings shall be removed without injury to the material.					
29	<u>Sew on button.</u> a. Close the slide fastener and mark or gage the outside ends of waistband with the location for sewing on the button to correspond with the eyelet of buttonhole. b. The button shall be positioned to engage with the eyelet end of buttonhole so that on the finished slacks, the ends of the waistband lie smooth and flat without twisting, bulging, or other distortions. c. Securely sew a 27-line button at the mark. The thread ends of hand sewn buttons shall be securely tacked. The button shall be sewn through all plies of waistband.	101 or Hand		14-16 per button 4 dou- ble per button not in- cluding shank wrap- ping	20/4 20/4 10/4	20/4
30	<u>Press slacks.</u> a. The tops shall be pressed smooth. b. The legs shall be pressed smooth and creased in the center with the seams matching at the bottom and in the crotch.					

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3.7 Finished measurement. Finished measurements of slacks shall be as listed in Table II.

TABLE II. Finished measurements. 1/

Size	Waist 2/	Hips 3/	Length Inseam 4/			Knee 5/	Bottom 6/
			Short	Regular	Long		
X0	22-1/2	35	32	34	36	19	16-1/2
2	23-1/2	36	32	34	36	19	16-1/2
4	24-1/2	37	32	34	36	19-1/2	17
6	25-1/2	38	32	34	36	19-1/2	17
8	27	39-1/2	32	34	36	20	17-1/2
10	28-1/2	41	32	34	36	20	17-1/2
12	30	42-1/2	32	34	36	20-1/2	18
14	32	44-1/2	32	34	36	20-1/2	18
16	34	46-1/2	32	34	36	21	18-1/2
18	36	48-1/2	32	34	36	21	18-1/2
Tolerance							
	± 1/2	± 1/2	± 1/2	± 1/2	± 1/2	± 1/2	± 1/2

1/ All measurements and tolerances are expressed in inches.

2/ Waist. Twice the measurement taken in center of waistband from folded edge to folded edge.

3/ Hips. Twice the measurement taken from folded edge to folded edge 7 inches from bottom of waistband.

4/ Inseam. Length measurement taken along inseam from crotch seam to unfinished bottom of legs.

5/ Knee. Twice the measurement taken from folded edge to folded edge across the width of slack leg at a point up from unfinished bottom of leg as follows: Short - 19-1/2 ($\pm 1/4$) inches; Regular - 20-1/2 ($\pm 1/4$) inches; Long - 21 ($\pm 1/4$) inches.

6/ Bottom. Twice the measurement taken from folded edge to folded edge across unfinished bottom of leg.

3.8 Workmanship. The finished slacks shall conform to the quality and grade of product established by this specification. The occurrence of defects shall not exceed the applicable acceptable point value or defect limit.

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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 the specification where such inspections are deemed necessary to assure supplies and services conform to the prescribed requirements.

4.1.1 Responsibility for compliance. All items must meet all requirements of sections 3 and 5. The inspection set forth in this 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 inspection as part of manufacturing operation 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 acceptance of defective material.

4.1.2 Responsibility for dimensional requirements. Unless otherwise specified in the contract or purchase order, the contractor is responsible for 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 Certificate of compliance. Where certificates of compliance are submitted, the Government reserves the right to check test such items to determine the validity of the certification.

4.2 Classification of inspection. 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-656.

4.4 First article inspection. When first article is required, inspection shall be made of a completely fabricated pair of slacks for all provisions in this specification.

4.5 Quality conformance inspection. Inspection shall be performed in accordance with MIL-STD-656.

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4.5.1 Testing of components. Testing of components shall be in accordance with the applicable subsidiary specifications and standards to the extent applicable, except that this specification shall govern in the event of conflict. The method of testing shall be as specified in FED-STD-191, wherever applicable. Testing shall be performed on components listed in Table III for characteristics noted. A certificate of compliance will be acceptable for the plastic coil slide fastener requirements of 3.3.7.2. In addition, the requirements that all components of the slide fastener have been furnished by one supplier shall be accepted on a certification of compliance (see 3.3.6.1).

4.5.2 In process inspection. Inspection shall be performed during the manufacturing of the end item to ascertain that the operations are performed as specified herein. The Government reserves the right to determine the acceptability of construction methods not performed in accordance with specified requirements for operations or subassemblies.

4.5.3 End item examination. Samplings and examination of the end item shall be performed for dress (D) slacks in accordance with the provisions of MIL-STD-656.

4.5.3.1 Finished measurement examination. The provisions for the finished measurement examination of the finished slacks shall be as specified in MIL-STD-656.

4.5.4 Examination of packaging requirements. The examination for compliance with packaging, packing and marking requirements shall be as specified in MIL-STD-656.

5. PACKAGING

5.1 Preservation. Preservation shall be level A or commercial (see 6.2).

5.1.1 Level A. Each pair of slacks shall be neatly folded so that the length dimension is approximately 23 inches. Each pair of folded slacks shall be inserted in a snug-fitting flat clear polyethylene film bag conforming to A-A-50083.

5.1.2 Commercial. Slacks shall be preserved in accordance with ASTM D 3951.

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

5.2.1 Level A. Twenty (20) pairs of slacks of one class, size, and length only, packaged as specified in 5.1, shall be packed in a fiberboard shipping container, assembled, closed and reinforced conforming to type CF, class weather-resistant, variety SW, Grade V3c, size 2A, of MIL-B-17757. The fiberboard for the liner shall conform to type CF, class weather-resistant, variety DW, grade V15c of MIL-B-17757. Level A folded slacks shall be packed flat, alternated end for end, within a shipping container. Each container shall have the contents completely covered on top and bottom with a sheet of commercial grade kraft paper.

5.2.2 Commercial. Slacks preserved as specified in 5.1, shall be packed in accordance with ASTM D 3951.

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5.3 Marking. In addition to any special marking required by the contract or purchase order, interior 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 directly on the bag across the center face or on a white paper label inserted within the bag so as to permit ready identification. The bag or label shall indicate the following information.

STOCK NUMBER
NOMENCLATURE
SIZE AND LENGTH

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 slacks described herein are intended for wear by female personnel of the Marine Corps.

6.2 Acquisition requirements. Acquisition documents should specify the following:

- a. Title, number and date of this specification.
- b. Classes, sizes and lengths required (see 1.2).
- c. Whether first article is required (see 3.2).
- d. Selection of applicable levels of packaging and packing (see 5.1 and 5.2).
- e. Acceptance criteria (see 6.5).

6.3 Guide samples and shade samples. For information regarding the availability of samples, address inquiry to the procuring activity issuing the invitation for bids.

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

6.5 Acceptance criteria. The acceptance criteria as specified in the contract or purchase order shall be binding.

6.6 Subject term (key word) listing.

Female
Pants

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

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6.8 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.

Preparing Activity
Navy - MC
Project No 8410-N725

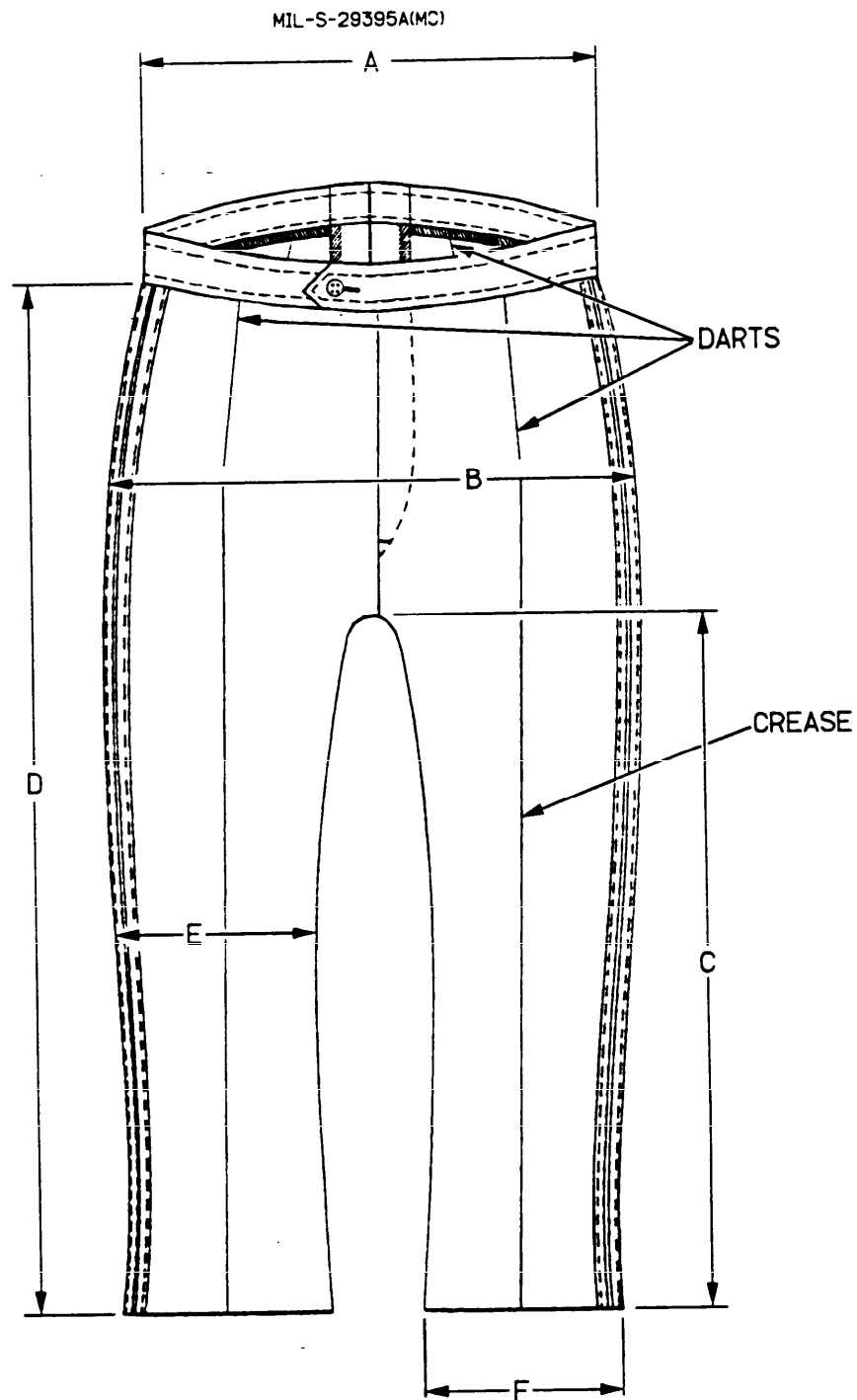
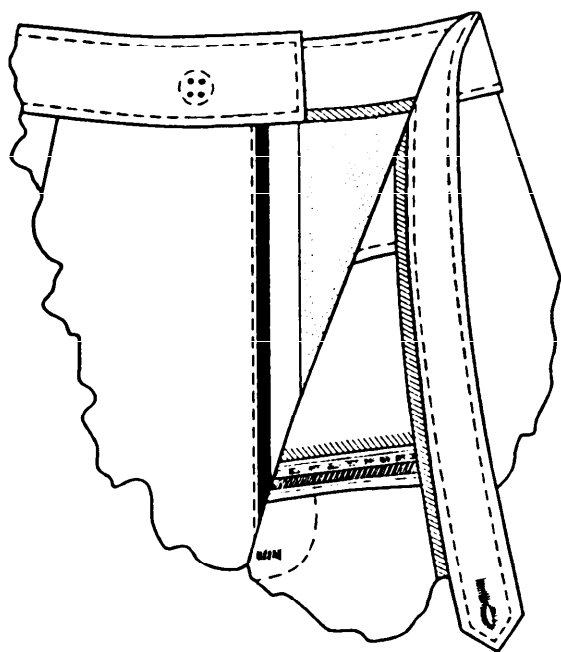
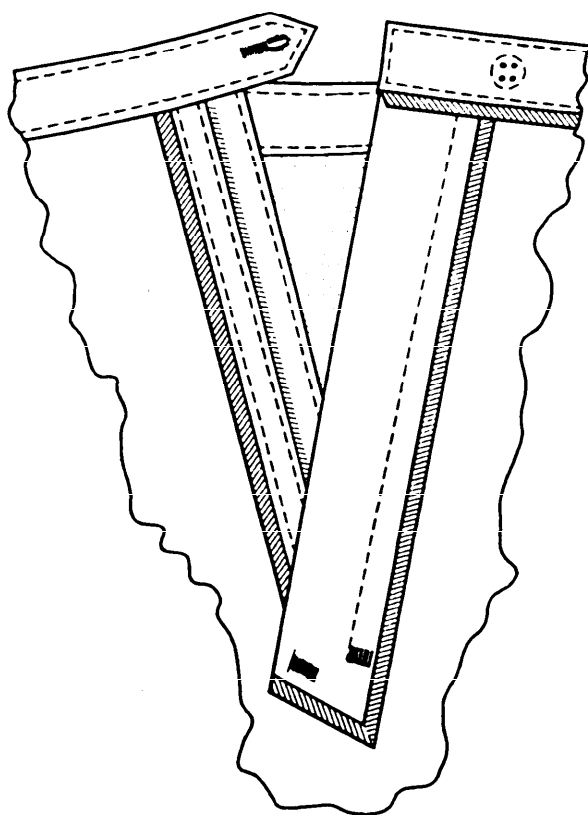


FIGURE 1: SLACKS, WOMEN'S, MUSICIAN'S

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OUTSIDE VIEW



INSIDE VIEW

FIGURE 2: SLACKS, WOMEN'S , MUSICIAN'S

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-S-29395A(MC)	2. DOCUMENT DATE (YYMMDD) 9 March 1994
3. DOCUMENT TITLE SLACKS, WOMEN'S; MUSICIAN'S			
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) COMMANDER		b. ORGANIZATION MARINE CORPS SYSTEMS COMMAND	
c. ADDRESS (Include Zip Code) PROGRAM SUPPORT DIRECTORATE PSE-C/S 2033 BARNETT AVENUE SUITE 315 QUANTICO VA 22134-5010		d. TELEPHONE (Include Area Code) (1) Commercial 703-640-4584 (2) AUTOVON 276-4584 (if applicable)	7. DATE SUBMITTED (YYMMDD) 930308
8. PREPARING ACTIVITY			
a. NAME		b. TELEPHONE (Include Area Code) (1) Commercial (2) AUTOVON	
c. ADDRESS (Include Zip Code)		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	