

INCH-POUND

MIL-S-29630(NU)

5 March 1991

MILITARY SPECIFICATION

SLACKS, WOMEN'S

This specification is approved for use by the Navy Clothing and Textile Research Facility, 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 women's slacks with body types and lengths.

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

1.2.2 Sizes.

<u>Body type</u>	<u>Length</u>
Juniors - J	Petite (Short) - P
Misses - No designation	Regular - R
Womens - W	Tall (Long) - T

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Officer in Charge, Navy Clothing and Textile Research Facility, P.O. Box 59, Natick, MA 01760-0001 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8410

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Schedule of sizes

<u>Petite (P)</u>	<u>Misses</u> <u>Regular (R)</u>	<u>Tall (T)</u>
4	4	4
6	6	6
8	8	8
10	10	10
12	12	12
14	14	14
16	16	16
18	18	18
20	20	20

<u>Petite (P)</u>	<u>Womens</u> <u>Regular (R)</u>	<u>Tall (T)</u>
6	6	6
8	8	8
10	10	10
12	12	12
14	14	14
16	16	16
18	18	18

<u>Petite (P)</u>	<u>Juniors</u> <u>Regular (R)</u>	<u>Tall (T)</u>
10	10	10
12	12	12
14	14	14
16	16	16

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications, standards, and handbooks. The following specifications, standards and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents 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).

SPECIFICATIONS

FEDERAL

V-B-871	- Button, Sewing Hole, and Button Staple (Plastic)
V-F-106	- Fasteners, Slide, Interlocking
V-T-276	- Thread, Cotton
V-T-280	- Thread, Gimp, Cotton, Buttonhole
NN-P-71	- Pallet, Material Handling, Wood, Stringer Construction, 2 Way and 4 Way (Partial)
DDD-L-20	- Label; For Clothing, Equipage, and Tentage (General Use)

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- MIL-B-17757 - Boxes, Shipping, Fiberboard (Modular Sizes)
- MIL-C-21115 - Cloth, Tropical: Wool, Polyester/Wool
- MIL-T-43548 - Thread, Polyester, Core: Cotton, -Rayon, or Polyester Covered
- MIL-C-43718 - Cloth, Polyester; Polyester and Cotton; Polyester and Rayon, for Pockets
- MIL-P-15011 - Pallet, Material Handling, Wood, Post Construction, 4 Way Entry

STANDARDS

FEDERAL

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

MILITARY

- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
- MIL-STD-129 - Marking for Shipment and Storage
- MIL-STD-147 - Palletized Unit Loads
- MIL-STD-656 - Provisions for Evaluating Quality of Slacks, Women's
- MIL-STD-2073-1 - DOD Materials Procedures for Development and Application of Packaging Requirements
- MIL-STD-2073-2 - Packaging Requirement Codes

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

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

U.S. POSTAL MANUAL

(Copies of the manual may be obtained from the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402-0001.)

2.2 Non-Government publications. The following document(s) form a part of this specification to the extent specified herein. Unless otherwise specified, the issue of 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 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

(Applications for copies should be addressed to the American Trucking Association, ATTN: Traffic Department, 1616 P Street, N.W., Washington, DC 20036-1404).

UNIFORM CLASSIFICATION COMMITTEE, AGENT

Uniform Freight Classification

(Application for copies should be addressed to the Uniform Classification Committee, Room 1106, 222 South Riverside Plaza, Chicago, Illinois 60606-5808).

THE COLOR ASSOCIATION OF THE UNITED STATES

Department of Defense Standard Shades for Buttons

Department of Defense Standard Shades for Sewing Threads

(Application for copies of color cards should be addressed to the Color Association of the United States, 343 Lexington Avenue, New York, NY 10016-0927.)

(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 informatinal services.)

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

3. REQUIREMENTS

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

3.2 First article. When specified, the contractor shall furnish sample unit(s) for first article inspection and approval (see 4.3 and 6.2).

3.3 Material.

3.3.1 Basic material. The basic material for the slacks shall be cloth, tropical, polyester and wool, conforming to type III, class 3 of MIL-C-21115. The color shall be shade 3346. The piece number for the standard sample is 40-01369.

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3.3.2 Pocketing. The material for the pockets shall be a twill cloth, conforming to class 1 of MIL-C-43718. As an alternate the basic material specified in 3.3.1 may be used. The color shall be black.

3.3.3 Tape, waistband, non-slip. The woven non-slip tape for the waistband shall be constructed of either polyester or polyester/nylon, natural or white in color, with two rows of chloroprene or nitrile rubber threads, woven or stitched to the tape (see 6.5). The width of the completed tape shall be 7/8 inch and shall not shrink more than 2% for drycleaning when tested as specified in 4.4.1. There shall be a minimum distance of 3/16 inch from the rubber thread to edge of tape.

3.3.4 Thread. The thread used for seaming and stitching the slacks shall be polyester core thread conforming to the requirements of MIL-T-43548 except that the polyester covering shall not be used. The thread shall be shade Black AA, Cable No: 66043 in accordance with the DOD Standard Shades for Threads and in the following sizes:

Operation	Ticket No.	Ply
Seaming, stitching and tacking	50-70	2 or 3
Overedging	70	2 or 3
Buttons	50	2 or 3

3.3.4.1 Thread, cotton. As an alternate to the polyester core thread, a cotton thread conforming to V-T-276, type I, may be used. The color shall be the same as specified above in the following types and sizes.

Operation	Type	Ticket No.	Ply
Seaming and stitching	IA3	30, 50	3
Tacking, buttonholes	IC2	0	3
Overedging	IA3	70	2
Buttons	IB3	30	3

3.3.4.2 Colorfastness. The dyed thread shall show colorfastness to wet-dry cleaning and light equal to or better than the standard sample when tested as specified in V-T-276 or MIL-T-43548. As a limit of acceptability or when no standard sample is available, the thread shall show a minimum of "good" colorfastness to wet-dry cleaning and light.

3.3.5 Gimp. The gimp for reinforcing the buttonhole shall conform to type I or II, size No. 8 of V-T-280. The color of the gimp shall be the same as indicated for thread in 3.3.4.

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3.3.5.1 Colorfastness. The dyed gimp shall show fastness to wet-dry cleaning equal to or better than the standard sample. As a limit of acceptability or when no standard sample is available the gimp shall show a minimum of "good" fastness to wet-dry cleaning as specified in V-T-280.

3.3.6 Button. The button shall be a 24-line, conforming to type II, class D, style 20 and 21 of V-B-871. The color of the button shall be shade Black BT, Cable No. 62001 in accordance with the Standard Shades for Buttons.

3.3.7 Slide fastener. The slide fastener shall conform to type I, stlye 1a (continuous chain) or 3 (pre-assembled), short tab pull, size LS, of V-F-106. The slide fastener shall be a continuous monofilament nylon or polyester coil. The complete slide fastener shall not shrink more than 2 percent when tested as specified in V-F-106 (see 6.4). The component parts of the slide fastener shall approximate the color of the basic material, or the color of the coil may be clear. The style 1a (continuous chain) requires the application of a slider and bottom stop during production of the slacks.

3.3.7.1 Color. The color of all slide fastener tape shall approximate the shade of the basic material.

3.3.7.2 Colorfastness. The dyed slide fastener tape shall shall show colorfastness to wet-dry cleaning equal to or better than the standard sample. As a limit of acceptability or when no standard sample is available, the tape shall show a minimum of "good" colorfastness to wet-dry cleaning when tested as specified in V-F-106.

3.3.8 Label.

3.3.8.1 Combination Label. Each pair of slacks shall have an identification, instruction and personal label, conforming type VI, classes 10 and 15 of DDD-L-20. The label shall show colorfastness to dry cleaning and the inscription shall be as follows:

NAME:
 SERVICE NO:
 SLACKS, WOMEN'S
 FIBER CONTENT; Polyester (55%) and Wool (45%)(Example)
 CONTRACT NO: DLA-100-00-0-0000 (Example)
 CONTRACTOR'S NAME:
 NAME OF MANUFACTURER: (If other than contractor)

DRY CLEAN ONLY

3.3.8.2 Removable size ticket. Each pair of slacks shall have a commercial type size ticket attached to the outside of the waistband, centered above the back waist darts. The ticket shall be approximately 3 inches long and 1 inch high, made of a suitable plain white cardboard. The corners of the ticket may be double perforated for ease in tacking. The size (22R-Example) shall be printed or stamped on the upper left hand corner in black or blue ink. The lettering for the size shall be 1/4 inch in height. Abbreviations for lengths shall be allowed in accordance with 3.3.8.3.

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3.3.8.3 Size label. The size label shall conform to type VI, class 2 of DDD-L-20. The label shall indicated size (body type and length) and stock number, and shall bear the following inscription:

SIZE: 14JT (Example- 14 Junior Tall) or 14T (Example - 14 Misses Tall)
STOCK NO: 8410-00-000-0000 (Example)

NOTE: Abbreviations for the applicable lengths shall be P for Petite, R for Regular, and T for Tall. Abbreviations for the applicable body types shall be J for Juniors and W for Womens.

3.4 Design. The slacks shall have front and back waist darts, right hand front waistband pocket, two section waistband with buttonhole tab extension and left side slide fastener closure with placket. The leg shall be flared and unhemmed (see Figure 1).

3.4.1 Figure. Figure 1 is furnished for information purposes only. To the extent of any inconsistencies between the written specification and the figure, the written specification shall govern.

3.5 Patterns. Standard patterns to be used to cut working patterns will be furnished by the Government (see 6.3). The working patterns shall be identical to the Government patterns. Neither the Government patterns nor the working patterns shall be altered in any way, 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 the specification. The seam allowance shall be 1/2 inch except as otherwise indicated by Table I.

3.5.1 List of pattern parts. The component parts of the slacks shall be cut from material as specified.

Material	Nomenclature of pattern parts	Cut parts
Basic material	Front	2
	Back	2
	Waistband	1
	Waistband-back left side	1
	Pocket facing	1 <u>1/</u>
	Placket	1
Twill Cloth	Pockets	2 <u>2/</u>

1/ When pocket is cut from basic material the facing may be included in the one piece pocket part.

2/ Pocket may be cut in one piece. Pocket may be cut from basic material.

3.6 Construction.

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3.6.1 Stitches, seams and stitchings. Stitch, seam and stitching types specified in Table I shall conform to FED-STD-751. Whenever two or more methods for seam or stitch types are given for the same part of the operation any one may be used. Seam allowance shall be maintained with seams sewn so that no raw edges, runoffs, twists, pleats, puckers or open seams result. All seams shall start and finish evenly. Thread tension shall be maintained so that there is no tight or loose stitching. Where stitch type 401 is used, the looper (underthread) shall be on the inside of the trousers. Ends of all seams produced by stitch type 401 shall be caught in other seams or stitching. Top stitching and edge stitching shall be 1/16 to 1/8 inch from the edge. The bight of the overedge stitching shall be 3/16 inch. The guide and knife shall be set to trim only the ravelled ends of the fabric. Double needle stitching shall be 1/4 (+ 1/16) inch gauge, with the outer row of stitching 1/16 to 1/8 inch from the finished edge. Buttonholes shall be clean cut and the stitching shall be securely caught in the fabric. Bartacks shall be 1/4 (+ 1/16) inches long and the width shall be 1/8 (+ 1/32) inch wide.

3.6.2 Thread breaks and end of seams. End of all seams and stitching when not caught in other seams or stitching shall be backtacked not less than 3/8 inch. The ends of a continuous line of stitching (except label) shall be overlapped not less than 1/2 inch. The ends of label stitching shall be overlapped not less than 3 stitches. Thread breaks (all stitch type) shall be repaired by stitching back of the break not less than 1/2 inch. Skipped stitches or thread breaks on 401 stitch type may be repaired by using 301 stitch type, except for seat seam which shall be resewn. When ends of overedge stitching are not caught in other seams or stitching, the ends shall be tacked.

3.6.3 Stitches per inch. The minimum and maximum number of stitches per inch shall be as specified in Table I.

3.7 Manufacturing operations requirements. The slacks shall be manufactured in accordance with all operation requirements specified in Table I. The contractor is not required to follow the exact sequence of operations listed, provided that the finished slacks are identical to those produced by following the sequence of operations as listed in Table I. Minor modifications are permitted where necessary when using automatic equipments. These modifications shall not alter the dimensional, serviceability, or appearance requirements cited in the specification.

3.7.1 Pressing. All pressing required in Table I shall be done with a heated pressing iron or machine.

3.7.2 Abbreviations in table of operations. The abbreviations used in Table I are as follows:

Stch	-	stitch
in	-	inch
Ndl	-	Needle
Bob	-	Bobbin
Lpr	-	Looper
Brck	-	Bartack
Bthl	-	Buttonhole
chnstch	-	chainstitch

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TABLE I - CONSTRUCTION OF SLACKS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread Ndl Bob/ Lpr
1.	<u>Cutting</u> a. Cut the slacks in strict accordance with patterns furnished, which shall show size, placement of component parts, directional lines for cutting, drill marks (for finished length of darts) and notches for proper assembly of parts. b. All component parts of the basic material shall be cut from one piece of material except pocket facings, and placket piece, which may be cut from ends. Parts cut from ends shall approximate the shade of the main assembly. c. Place fronts and backs so that the directional line is in the warp direction. The directional line may vary from the warp direction by not more than 1 inch on fronts and backs. Measurement shall be taken from the top and bottom of the directional line on the pattern to the selvage edge of the fabric. The difference between the two measurements shall not exceed the tolerance specified.				
2.	<u>Replacement of defective components</u> During the spreading, cutting and manufacturing process, components having material defects or damages that are classified as defects in MIL-STD-656 shall be removed from production and replaced with non-defective and properly matched components.				
3.	<u>Shade marking</u> a. All parts of the basic material shall be marked or ticketed to insure a uniform shade and proper assembly throughout the slacks except parts cut from ends. b. The use of corrosive metal fastening devices or sewn-on tickets for shade marking is prohibited. c. Adhesive tickets which discolor or adhere to the material upon removal of the tickets are prohibited.				

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TABLE I - CONSTRUCTION OF SLACKS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread Ndl Bob/ Lpr	
	d. The use of ink pad numbering machine, rubber stamp, or pencil is acceptable provided the numbers do not show on the outside of the slacks. Whenever possible, numbers shall be covered by the seam allowance.					
4.	<u>Overedge stitching</u>					
	a. Overedge stitch the raw edges of the inseams, outseams, center front seam and bottom of foreparts.	503 or 504 or 602	EFd-1	8-10	70	70
	b. Overedge stitch the raw edges of the inseams, outseams, seat seam and bottom of back parts. Overedge ends of waistband at the outlet and the inside bottom edges of waistband. (When contractor exercises the option to turn waistband edge under (see operation 12a), the bottom edge need not be overedged).	503 or 504 or 602	EFd-1	8-10	70	70
	c. Fold placket piece in half lengthwise and overedge stitch side and bottom raw edges together.	503 or 504 or 602	SSa-1	8-10	70	70
5.	<u>Make darts</u>					
	The darts shall be tapered on the inside without twists or puckers.					
	a. Fold and stitch darts as indicated by notches and drill holes. Drill holes shall not be exposed on the outside of the slacks. When using drill holes, they should be 1/4 to 1/2 inch above bottom point of dart.	301	OSf-1	12-14	50	50
	b. Press folded darts toward the center front and center back respectively.					

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TABLE I - CONSTRUCTION OF SLACKS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread Ndl Bob/ Lpr	
6.	<u>Set pocket (right front waist) and attach label</u>					
	a. Stitch the combination personal, identification, instruction label on all four sides to the bottom of pocketing on outside. The label shall face the slacks when worn. Pocket stitching shall not be through label.	301	LSbj-1	12-14	50	50
	NOTE: When pocket is cut from basic material and no facing is used, allow for fold back and topstitching when placing the label.					
	b. Superimpose facing on inner pocket piece, turn in lower raw edge of facing and stitch to pocket piece. When facing is cut on selvage, the edge need not be turned. When facing and pocketing are cut in one piece from basic fabric, turn facing portion back over inner pocket, turn under raw edge and topstitch.	301	EFt-2	12-14	50	50
	or					
	c. As an option, to facilitate assembly, sides and top edge of facing may be stitched to pocket piece.	301	SSa-1	12-14	50	50
	d. Stitch outer pocket piece to top edge of right front between notches, 3/8 inch from raw edge.	301	SSe-2(a)	12-14	50	50
	e. Notch to seam at each end of pocket opening, turn and topstitch pocket piece to slacks, 1/16 inch from folded edge.	301	SSe-2(b)	12-14	50	50
	f. Stitch inner and outer pocket pieces together around sides and bottom, 1/4 to 5/16 inch from raw edge.	301 or 401	SSa-1	12-14	50 50	50 70
	g. Overedge stitch sides and bottom of pocket plies.	503 or 504 or 602	SSa-1	8-10	70	70
	or					

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TABLE I - CONSTRUCTION OF SLACKS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread Ndl Bob/ Lpr	
	h. As an alternate, operations f and g may be performed in one operation by simultaneously stitching and overedging.	515 or 516 or 519	SSa-1	8-10	50 70 (chain- stitch- ing) 70 70 (over- edge stitch- ing)	
	NOTE: The pocket may be cut in one piece.					
	i. Tack or bartack pocket at each end of opening through all plies with a vertical tack or bartack visible below waistband. The tack or bartack shall be 1/4 inches in length.	Bartack or 301		21-28 per brtck 10-14	50 50 50 50	
	j. Finished pocket shall measure 3-1/2 (+ 1/4) inches wide at the opening and 4 (+ 1/4) inches deep.					
7.	Join outseams and attach slide fastener					
	a. Match notches of left front and back at outseam and join 1/2 inch from edge. Stitching shall terminate at bottom of side closure opening.	301 or 401	SSa-1	12-14	50 50 50 70	
	b. When style 3 (pre-assembled) slide fastener is used: Position back edge of slide fastener tape on placket piece with center of chain 1 (+1/16) inch from folded edge and stitch 1/8 to 1/4 inch from chain on overedge side. The bottom stop shall finish at the fly notch. The top stop shall be placed no further than 1/4 inch from waistband joining seam.	301	SSak-1	12-14	50 50	
	c. When style 1a (continuous chain) slide fastener is used: Position back edge of slide fastener tape to placket piece with center of chain 1 (+ 1/16) inch from folded edge and stitch 1/8 to 1/4 inch from chain on overedge side. The coil shall extend past the fly notch at the bottom and extend into the waistband at the top.	301	SSak-1	12-14	50 50	

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TABLE I - CONSTRUCTION OF SLACKS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
	d. Place placket piece (chain side down) on back edge of slacks with teeth of chain in line with side seam and stitch to opening. Turn placket piece to finished position and top stitch 1/16 inch from folded edge of slacks through all plies (slacks, placket and fastener tape).	301	SSa-1 and similar to LSq-1	12-14	50	50
	e. Fold front opening at notch and stitch to fastener tape forming a 1/2-5/8 inch welt.	301	SSak-1	12-14	50	50
	f. For use with style 1a (continuous chain) slide fastener: Attach slide fastener and with the chain even, apply bottom stop.					
	g. Stitch across bottom of welt to side seam (width of welt), catching the ends of the tape and the placket in the stitching. The welt shall cover the slide fastener when closed.					
	h. Match notches on right front and back at outseam and join, 1/2 inch from edge.	301 or 401	SSa-1	12-14	50	50 70
	i. Press outseams open and flat.					
8.	<u>Join inseams</u>					
	a. Match notches at front and back inseam and stitch 1/2 inch from the edge.	301 or 401	SSa-1	12-14	50	50 70
	b. Press inseams open and flat.					
9.	<u>Join front seam</u>					
	a. Join center front seam 1/2 inch from edge, from top of waist to the crotch. If the double needle seamer is used, the needles shall be 1/64 to 1/32 inch apart.	301 or 401	SSa-1 SSa-2	12-14	50	50 70
	b. Press seam open and flat.					
10.	<u>Attach waistband and size label</u>					
	a. Fold waistband in half lengthwise. Position top edge of non-slip waistband tape on the overedge side of waistband, 1/8 inch down from folded edge. Stitch 1/16 inch from each edge of tape. The rows of rubber gripper threads shall face the wearer.	301 or 401	LSbj-1	12-14	70	70 70

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TABLE I - CONSTRUCTION OF SLACKS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
	b. Match notches on left and right waistband with folded edge of placket piece and welt respectively, leaving extensions as indicated by pattern notches.					
	c. Seam, 3/8 inch from the raw edge, the waistband section to top of slacks on the outside, working in fullness evenly between notches at front, catching top ends of fastener tape, darts, front seam, pockets, and folded placket piece. The size label, positioned 2 (+ 1/4) inches to the left of the center back seam, shall be caught in the seaming.	301	BSg-2(a) BSp-2(a)	12-14	50	50
	d. Seam straight ends and pointed end, trim, turn, and work out corners and point.	301	SSe-2(a)	12-14	50	50
	OR					
	e. As an alternate, pointed and straight end(s) of waistband may be seamed, trimmed, turned, and edge-stitched prior to setting the waist.	301	SSe-2	12-14	50	50
	f. The front extension of the waistband shall measure 1-1/2 (+ 1/4) inches beyond fold of welt to the finished point of tab. The back extension shall finish flush with placket edge.					
	NOTE: Prior to operation b, the folded edge of all darts and raw edge of pockets may be tacked on fronts.					
11.	<u>Join seat seams</u>					
	a. Join back seat seam in one continuous operation with a double needle seat seamer with the two rows of stitching 1/64 to 1/32 inch apart. The crotch seam shall meet at inseam junction.	401	SSa-2	12-14	50	70

NOTE: The seat seam stitching cannot be repaired, it must be completely resewn.

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TABLE I - CONSTRUCTION OF SLACKS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread Ndl Bob/ Lpr	
	b. The outlet seam allowance shall be gradually tapered in stitching from 1-1/4 (+ 1/4) inches from top of waistband to 1/2 inch at crotch.					
	c. Press seat seam open and flat.					
12.	<u>Turn and finish waistband.</u>					
	a. Turn serged edge to inside of slacks and edgestitch the waistband joining seam 1/16 inch above the seam, with the waistband seam and seam allowance folded up. Continue edgestitching along tab ends and top of waistband. Care shall be taken to avoid closing the waist pocket opening during waistband attachment. Or the bottom waistband edge may be turned under and edgestitched.	301	BSg-2(b) or BSp-2(b) and SSe-2(b) and OSf-1	12-14	50	50
	b. The finished waistband shall finish 1-1/4 (+1/8) inch in width.					
13.	<u>Buttonhole</u>					
	a. Stitch a 3/4 inch horizontal eyelet end taper bar buttonhole, centered and with center of eyelet end of buttonhole 5/8 (+ 1/8) inch from pointed tab of front waistband.	Button- hole		44-46 per button- hole)	70	70
	b. The stitching shall be securely caught to the fabric, with the purling on the outside, worked over gimp and end of buttonhole securely tacked.					

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TABLE I - CONSTRUCTION OF SLACKS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread		
					Ndl	Bob/ Lpr	
14.	<u>Buttons</u>						
	a. Buttons shall be sewn through both plies with ends of stitching securely tacked. Hand sewn buttons shall be tacked off with not less than two stitches.						
	b. Mark and sew a 24-line button to the outside back end of waistband, centered to properly engage buttonhole in pointed end of tab.	101 or 301		20-24 per button) 14-16 (per button)	50 50	50	
15.	<u>Cleaning</u>						
	a. All ends of stitching shall be trimmed and loose threads removed from slacks, inside and outside.						
	b. All spots and stains shall be removed. Shade tickets shall be removed without injury to the material.						
	Note: Care shall be taken when trimming thread ends that damage to fabric does not result.						
16.	<u>Removable size ticket</u>						
	Tack all corners of removable size ticket to outside of the waistband, centered above the left back waist darts.	Hand or Machine		2-4 stitches per tack 6-8 stitches per tack			
17.	<u>Press slacks</u>						
	a. The tops, including placket opening and pockets, shall be pressed smooth.						
	b. The legs shall be pressed smooth and creased in the center with the seams matching at bottom and in the crotch; or the inseam in the crotch may be slightly back of the outside seam.						

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3.8 Sizes and measurements. Unless otherwise specified, finished measurements of slacks shall be as listed in Table II. All measurements and tolerances are expressed in inches.

Table II - Sizes and measurements

Size	(A) Waist	Junior	(B) Hip Misses	Women	(C) Knee	(D) Bottom
4	24-1/2	-	37-1/2	-	19-1/8	22
6	25-1/2	-	38-1/2	40-1/2	19-3/4	22-1/4
8	26-1/2	-	39-1/2	41-1/2	19-5/8	22-1/2
10	28	39-1/4	41	43	19-7/8	22-3/4
12	29-1/2	40-3/4	42-1/2	44-1/2	20-1/8	23
14	31	42-1/4	44	46	20-3/8	23-1/4
16	33	44-1/4	46	48	20-5/8	23-1/2
18	35	-	48	50	20-7/8	23-3/4
20	37	-	50	-	21-1/8	24
Tolerance:						
	$\pm 1/2$	$\pm 1/2$	$\pm 1/2$	$\pm 1/2$	$\pm 1/4$	$\pm 1/4$

Inseam length (E): All Petites (P) - 32
 All Regulars (R) - 33
 All Talls (T) - 35
 Tolerance - $\pm 1/2$

NOTE: Waist and hip measurements of the slacks shall be taken with slide fastener fully closed and waistband tab buttoned. All measurements shall be taken with slacks smooth and flat. A, B, C, D, and E refer to Figure 1.

- (A) Waist - Twice the measurement taken from folded edge to folded edge across the center of waistband.
- (B) Hips - Twice the measurement taken from folded edge to folded edge 1 inch below bottom of slide fastener.
- (C) 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: Petite (P) - 20 ($\pm 1/4$) inches; Regular (R) - 20 ($\pm 1/4$) inches; Tall - 21 ($\pm 1/4$) inches.

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- (D) Bottom - Twice the measurement taken from folded edge to folded edge across unfinished bottom of leg.
- (E) Inseam - Length measurement taken along inseam from crotch seam to unhemmed bottom of legs.

3.9 Workmanship. The finished slacks shall conform to the quality of product established by this specification. The occurrence of defects shall not exceed the applicable acceptable point value.

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 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 ensure supplies and services conform to prescribed requirements.

4.1.1 Responsibility for compliance. All items must meet all requirements of sections 3 and 5. The inspection set forth in this 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 ensuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations, is 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 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 4.3).
2. Quality conformance inspection (see 4.4).

4.3 First article inspection. When required, the first article submitted in accordance with 3.2 shall be inspected as specified in 4.4.2 for compliance with design, construction, workmanship, appearance and dimensional requirements.

4.4 Quality conformance inspection. Sampling for inspection shall be performed in accordance with MIL-STD-656, except where otherwise indicated.

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4.4.1 Component and material inspection. In accordance with 4.1 above, components and materials shall be 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 procurement documents. In addition testing shall be performed on the non-slip waistband components listed in below in Table III. The methods of testing specified in FED-STD-191, wherever applicable and as listed in Table III shall be followed.

Table III - Component testing

Component	Characteristic	Requirement Paragraph	Test Method
Non-slip tape	Shrinkage		
	Drycleaning	3.3.3	5580 <u>1/</u>

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

4.4.2 Examination of the end item. The item examination provisions for the finished slacks shall be as specified for Dress (D) in MIL-STD-656. In addition, the following defect also applies:

<u>Label</u>	<u>Point value</u>
Removable size ticket missing, incorrect or illegible	3

4.4.3 Packaging inspection. Packaging inspection shall be in accordance with MIL-STD-656.

4.4.4 Palletization examination. An examination shall be made to determine that the palletization complies with the section 5 requirements. Defects shall be scored in accordance with the list below. The sample unit shall be one palletized unit load fully packaged. The lot size shall be the number of palletized unit loads in the end item inspection lot. The inspection level shall be S-1 and the AQL, expressed in terms of defects per hundred units, shall be 6.5 in accordance with MIL-STD-105.

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

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5. PACKAGING

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

5.1.1 Level A. Each pair of slacks shall be neatly folded so that the garment measures approximately 11-1/2 by 15 inches. Each pair of folded slacks shall be inserted in a snug-fitting flat clear polyethylene film bag of 0.00125 inch thickness (+ 20% tolerance). The bag shall be formed with heat sealed seams that are straight, continuous and parallel to each other. The final closure of the bag shall be heat sealed with the seam 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. As an alternate, the polyethylene bag may be of the tuck-in or reverse flap type, in which a heat seal closure and corner vent hole are not required and the final closure of the bag shall be made with the flap tucked in or reversed.

5.1.2 Level C. Slacks shall be preserved to afford adequate protection against physical damage during shipment from the contractor to the first receiving activity. The package 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 C (see 6.2).

5.2.1 Level A. Twenty-four (24) pairs of slacks, of one size (body type 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 DW, grade V15c, size 2A of MIL-B-17757. The fiberboard for the liner shall conform to type CF, class domestic of MIL-B-17757. Level A packages shall be stacked two in length, one in width and twelve in depth within the 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 Level B. Twenty-four (24) pairs of slacks, of one size (body type 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 domestic, variety DW, grade 200, size 2A of MIL-B-17757. The fiberboard for the liner shall conform to type CF, class domestic of MIL-B-17757. Level A packages shall be stacked two in length, one in width and twelve in depth within the shipping container. Each container shall have the contents completely covered on top and bottom with a sheet of commercial grade kraft paper.

5.2.3 Level C. Slacks, 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. The quantity per shipping container shall be the same as that normally used by the contractor for detail distribution. Containers shall comply with the U.S. Postal Manual, Uniform Freight Classification Rules or National Motor Freight Classification Rules, as applicable.

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5.3 Marking. In addition to any special marking required by the contract or order, unit packs, intermediate or exterior containers, and palletized unit loads shall marked in accordance with MIL-STD-129.

5.4 Palletization. When specified (see 6.2), item, packed as specified in 5.2, shall be palletized on a 4-way entry pallet in accordance with load type Ia of MIL-STD-147. Each prepared load shall be bonded with primary and secondary straps in accordance with the bonding methods C and D or Film bonding F or G. Pallet patterns shall be in accordance with the appendix of MIL-STD-147. The pallet shall be 4-way, type IV; type V, class 1, size 2; or type VIII, fabricated from wood groups I, II, III or IV, grade A of NN-P-71, or 4-way, style 1, size A, type I, class 1 fabricated from groups specified of MIL-P-15011. 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 first be approved by the contacting officer.

5.5 MIL-STD-2073. When specified (see 6.2), Preservation and Packing shall be in accordance with MIL-STD-2073-1 and MIL-STD-2073-2.

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 are intended for wear by female personnel of the Navy as part of the service dress blue uniform.

6.2 Acquisition requirements. Acquisition documents should specify the following:

- a. Title, number, and date of this specification
- b. Sizes (body types and lengths) required (see 1.2)
- c. Issue of DODISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.1 and 2.2)
- d. When first article sample is required (see 3.2). The item will be tested and should be a first article sample. The contracting officer should include specific instructions in acquisition documents regarding arrangements for examination, quality, testing and approval of the first article.
- e. Levels of packaging and packing required (see 5.1 and 5.2)
- f. When palletization is required (see 5.4)
- g. When all packaging data is to be found in MIL-STD-2073-1 and MIL-STD-2073-2 (see 5.5).

6.3 Samples and patterns. For access to samples and patterns, address the procurement office issuing the invitation for bids (see 3.1 and 3.5).

6.4 Shrinkage of slide fastener. Experience has shown that slide fasteners containing a durable press finish will meet the shrinkage requirements specified in 3.3.7.

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6.5 Tape, waistband. A non-slip waistband tape conforming to the requirements of 3.3.3 may be obtained from Empire Bias Binding Co., 18 West 20th Street, New York, NY, Atlantic Bias Products, Inc., 16 West 19th Street, New York, NY, United Elastic (Division of J.P. Stevens) Stuart Plant, Stuart, VA 24171, Style #N3 - 7675 or Silver Elastic Co., 37 Tweed Drive, Randolph, MA or equal (see 6.6).

6.6 Equal item. Prior to the use of an "or equal" item the contractor shall submit the item with supporting data to the contracting officer for subsequent approval or disapproval.

6.7 Size (body type and length) abbreviations. The size (body type and length) abbreviations (example - 12JP) used in this specification follow the current industry practice of listing numerical size and one letter abbreviations for body type variation (Juniors and Womens only) and length (Petites, Regulars, and Talls).

The size (body type and length) abbreviations used on the patterns list a numerical size, a one letter abbreviation for length (Petites, Regulars, and Talls) and a two letter abbreviation for body type variation (Juniors and Womens only).

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

6.9 Subject term (key word) listing:

Blue 3346
Dress
Polyester/wool 55/45
Uniform, Service Dress Blue
Uniform, female

Custodian:
Navy - NU

Preparing Activity:
Navy - NU

Review Activity:
DLA - CT

Project 8410-N743

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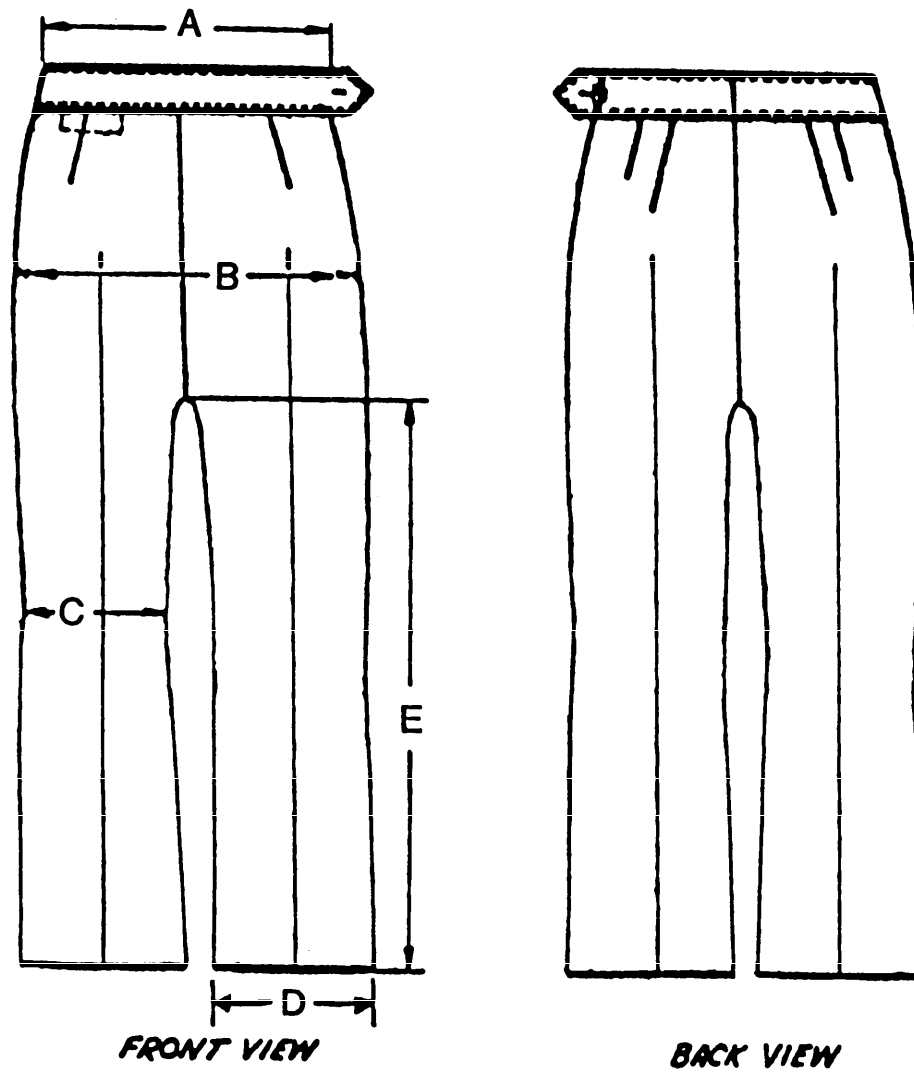


FIGURE 1

SLACKS, WOMEN'S

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