

MIL-S-41825F(NU)

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SUPERSEDING

MIL-S-41825E

10 October 1984

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.

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

Type II - Flared leg

Class 1 - Polyester/Wool, Tropical, Blue 3346 (Navy, Officers and Enlisted)

1.2.2 Sizes and lengths.

Sizes: 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 18, 20, and 22

Lengths: Short, Regular, and Long

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, 21 Strathmore Road, Natick, MA 01760-2490 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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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 specification to the extent specified. Unless otherwise specified, the issue 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.

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)

MILITARY

- 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, Twill, Polyester; Polyester and Cotton; Polyester and Rayon
- MIL-P-15011 - Pallet, Material Handling, Wood, Post Construction, 4 Way Entry

STANDARDS

FEDERAL

- FED-STD-751 - Stitches, Seams, and Stitchings

MILITARY

- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
- MIL-STD-129 - Marking for Shipment and Storage
- MIL-STD-147 - Palletized Unit Loads
- MIL-STD-656 - Provisions for Evaluating Quality of Slacks, Women's

(Copies of specifications, standards, drawings, and publications required by contractors in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

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2.1.2 Other Government documents, drawings, and publications. The following other Government documents, drawings, and publications form a part of this specification to the extent specified herein. Unless otherwise specified, the issues shall be those in effect on the date of solicitation.

LAWS AND REGULATIONS

U.S. POSTAL SERVICE MANUAL

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

* 2.2 Other 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 specified in the solicitation. Unless otherwise specified, the issue of documents not listed in the DODISS shall be the issue of the nongovernment document which is current on the date of the solicitation.

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 Sewing Threads
Department of Defense Standard Shades for Buttons

Color Association of the United States, 343 Lexington Avenue, New York, NY 10016.

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).

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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.

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 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

3.3.3.1 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

3.3.3.2 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.

3.3.4 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 3.3.3.

3.3.4.1 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.

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3.3.5 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.

3.3.6 Slide fastener. The slide fastener shall conform to type I, style 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. 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.

3.3.6.3 Color. The color of all slide fastener tape shall approximate the shade of the basic material. The plastic coil slider shall be black. The plastic coil shall be black or colorless.

3.3.6.4 Colorfastness. The dyed slide fastener tape 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.

3.3.7 Label.

3.3.7.1 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

3.3.7.2 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 3.3.7.3.

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3.3.7.3 Size label. The size label for the slacks shall conform to type VI, class 2 and shall bear the following inscription:

Size 14R (Example)
STOCK NO: 8410-00-000-0000 (Example)

NOTE: The lengths (short, regular and long) may be abbreviated as S, R or L

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 patterns allow 1/2 inch seam allowance for all seams, except as otherwise indicated in Table I. 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 allowed on the working patterns.

* 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 1/
	Placket	1
Twill Cloth	Pockets	2 2/

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 stitching. 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 operation, any one of them may be used. Seam allowances 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 slacks. Ends of all seams produced by stitch type 401 shall be caught in other seams or stitchings.

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

3.6.1.2 Thread breaks and ends of seams. The ends of all seams and stitching, when not caught in other seams or stitching, shall be backstitched not less than 3/8 inch. The ends of the label stitching shall be overlapped not less than 3 stitches; or shall run past the label 1/2 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. The seat seam must be completely resewn. Thread ends at lower ends of darts shall not be trimmed closer than 1/2 inch in length or when an automatic dart machine is used the thread ends at lower end of dart shall be backstitched. A 1/2 inch chain shall extend from the end of 401 stitching at the outseam and inseams. 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.

3.6.2 Bartacks. Unless otherwise specified, all bartacks shall be 1/4 (+ 1/16) inch long and 1/8 (+ 1/32) inch wide.

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 as specified, provided the finished slacks are identical to those produced by following the sequence of operations as specified in Table I.

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
Mchne	-	Machine
Brck	-	Bartack
Comrc1	-	Commerical
sm1ar	-	similar
Btnhl	-	Buttonhole
incl	-	including
dbl	-	double

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TABLE I - CONSTRUCTION OF SLACKS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread 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, drill 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 pocket facings, and placket piece, 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. 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.</p>				
2.	<p><u>Replacement of defective components</u></p> <p>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.</p>				
*3.	<p><u>Shade marking</u></p> <p>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.</p> <p>b. The use of corrosive metal fastening devices or sewn-on tickets for shade marking is prohibited.</p>				

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TABLE I - CONSTRUCTION OF SLACKS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread Ndl Bob/ Lpr	
	c. Adhesive tickets which discolor or adhere to the material upon removal of the tickets are prohibited.					
	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 10f), 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.					

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TABLE I - CONSTRUCTION OF SLACKS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
	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.					
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

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TABLE I - CONSTRUCTION OF SLACKS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
	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					
*	h. As an alternate, operations f and g may be performed in one operation by simultaneously stitching and overedging.	515 or	SSa-1	8-10	50	70
					(chain-stitching)	
		516 or			70	70
					(over-edge stitching)	
		519				
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
	j. Finished pocket shall measure 3-1/2 (+ 1/4) inches wide at the opening and 4 (+ 1/4) inches deep.				50	50
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

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TABLE I - CONSTRUCTION OF SLACKS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
	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
	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 to 5/8 inch welt.	301	SSak-1	12-14	50	50
	f. For use with style 1a (continous 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	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	50 70
	b. Press inseams open and flat.					

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TABLE I - CONSTRUCTION OF SLACKS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
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. Match notches on left and right waistband with folded edge of placket piece and welt respectively, leaving extensions as indicated by pattern notches.					
	b. 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
	NOTE: Top of fastener chain shall be not more than 3/8 inch from waistband joining seam nor shall it extend under waistband.					
	c. Fold waistband in half lengthwise; seam straight ends and pointed end, trim, turn, and work out corners and point.	301	SSe-2(a)	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. 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
	e. 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.					
	f. Turn serged edge to inside of slacks and top stitch to slacks on outside; continue edge stitching along tab ends and top of waistband. The topstitching shall be 1/16 inch from folded edge of waistband joining seam. Care shall be taken to avoid closing the waist pocket opening during waistband attachment. Or, the bottom waistband edge may be turned under and topstitched.	301	BSg-2(b) or BSp-2(b) and SSe-2(b) and OSf-1	12-14	50	50
	g. The finished waistband shall measure 1 (+ 1/8) inch in width.					
	NOTE: Prior to operation a, 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 can not be repaired, it must be completely resewn.					
	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.					

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TABLE I - CONSTRUCTION OF SLACKS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread	
					Ndl	Bob/ Lpr
	d. Stitch down seam outlet across bottom of waistband with stitching superimposed on waistband stitching.	301		12-14	50	50
	e. Tack across top of center outlet seam on waistband. Tack shall measure 1/2 to 3/4 inch.	301		12-14	50	50
12.	<u>Buttonhole</u>					
	a. <u>Stitch</u> 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.					
13.	<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
	NOTE: The button shall be measured from the center of its circumference.					
14.	<u>Cleaning</u>					
	a. All ends of stitching shall be trimmed and loose threads removed from slacks, inside and outside.					

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TABLE I - CONSTRUCTION OF SLACKS

No.	Operation	Stch Type	Seam/ Stch type	Stch in	Thread Ndl Bob/ Lpr
	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.				
*15.	<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		2-4 stitches per tack 6-8 stitches per tack	
16.	<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 Tables II. All measurements and tolerances are expressed in inches.

Table II - Sizes and measurements

Size	(A) Waist	(B) Hips	(C) Length inseam			(D) Knee	(E) Bottom
			Short	Regular	Long		
6	23-1/2	36-1/2	30	32	34	18-3/4	22
7	24	37	30	32	34	18-3/4	22
8	24-1/2	37-1/2	30	32	34	19	22-1/4
9	25	38	30	32	34	19	22-1/4
10	25-1/2	38-1/2	30	32	34	19-1/4	22-1/2
11	26-1/4	39-1/4	30	32	34	19-1/2	22-3/4
12	27	40	30	32	34	19-1/2	22-3/4
13	27-3/4	40-3/4	30	32	34	19-1/2	22-3/4
14	28-1/2	41-1/2	30	32	34	19-3/4	23
15	29-1/4	42-1/4	30	32	34	20	23-1/4
16	30	43	30	32	34	20	23-1/4
18	32	45	30	32	34	20-1/4	23-1/2
20	34	47	30	32	34	20-1/2	23-3/4
22	36	49	30	32	34	20-3/4	23-3/4
Tolerance							
	+1/2	+1/2	+1/2	+1/2	+1/2	+1/2	+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) Inseam - Length measurement taken along inseam from crotch seam to unfinished bottom of legs.
- (D) 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 - 16 (+1/4) inches; Regular - 17 (+1/4) inches; Long - 18 (+1/4) inches.
- (E) Bottom - Twice the measurement taken from folded edge to folded edge across unfinished bottom of leg.

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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, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or 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 assure supplies and services conform to prescribed requirements.

4.1.1 Responsibility for compliance. All items must meet all requirements of section 3 and 5. The inspection set forth in this specification shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the contractor of the responsibility of assuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling in quality conformance does not authorize submission of known defective material, either indicated or actual nor does it commit the Government to acceptance of defective material.

4.1.2 Certificate of compliance. 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.

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. A certificate of compliance will be acceptable for the plastic coil slide fastener requirements of 3.3.6.2, and the requirements that all metal components of the slide fastener have been furnished by one supplier (see 3.3.6.1).

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:

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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.

5. PACKAGING

5.1 Preservation-packaging. Packaging 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.

5.1.2 Level C. Slacks shall be packaged 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).

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* 5.2.1 Level A. Twenty-four (24) pairs of slacks, of one 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 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 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 Service Manual, Uniform Freight Classification Rules or National Motor Freight Classification Rules, as applicable.

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

5.3.1 Polyethylene bagged packages. Polyethylene bagged packages shall have the required 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
QUANTITY

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5.4 Palletization. When specified (see 6.2) item packed as specified 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 bonding means C, K, and L or O or P. Pallet pattern 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 group I, II, III or IV, Grade A of NN-P-71, or 4-way, Style 1, Size A, Type I, Class 1 fabricated from wood 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 be approved by the contracting officer.

6. NOTES

6.1 Intended use. The slacks are intended for wear by enlisted and commissioned female personnel of the Department of the Navy. The slacks are intended to be worn with the coat, women's, blue, dress.

6.2 Ordering data. Procurement documents should specify the following:

- a. Title, number, and date of this specification.
- b. Sizes and lengths required (see 1.2).
- c. When first article 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 examinations, quantity, and testing and approval of the first article.
- d. Selection of applicable levels of packaging and packing (see 5.1 and 5.2).
- e. When palletization is required (see 5.4).

6.3 Samples and patterns. For access to samples and patterns, address the procurement office issuing the invitation for bids.

6.4 Shrinkage of slide fastener. Experience has shown that slide fasteners containing a durable press finish will meet the shrinkage requirements specified in 3.3.6.

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

* 6.6 Subject term (key word) listing:

Blue 3346
Dress
Polyester/wool 55/45

Custodian:
Navy - NU

Preparing Activity:
Navy - NU

Review Activity:
DLA - CT

Project No. 8410-N676

MIL-S-41825F,

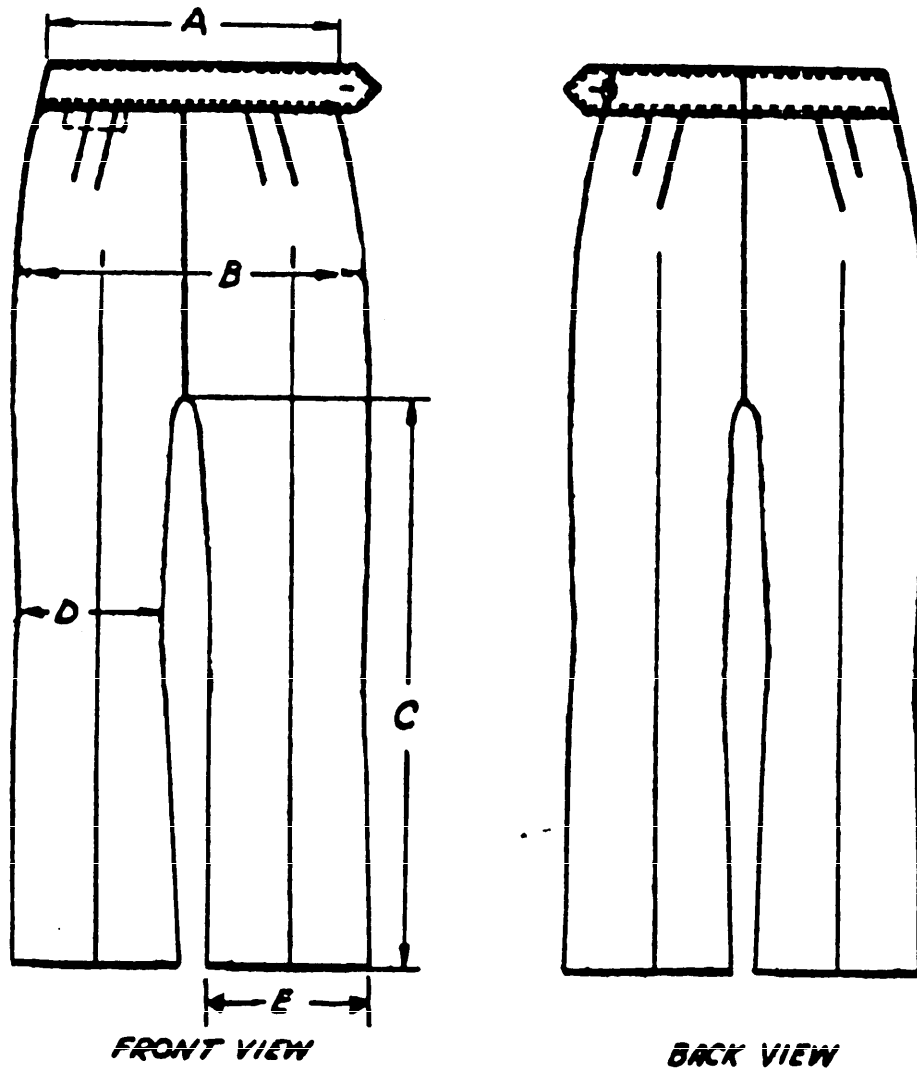


Figure 1

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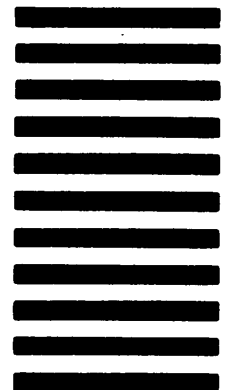
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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL*(See Instructions - Reverse Side)***1. DOCUMENT NUMBER**

Mil-S-41825F

2. DOCUMENT TITLE

SLACKS, WOMEN'S

3a. NAME OF SUBMITTING ORGANIZATION**4. TYPE OF ORGANIZATION (Mark one)**☐

VENDOR

☐

USER

☐

MANUFACTURER

☐

OTHER (Specify): _____

b. ADDRESS (Street, City, State, ZIP Code)**5. PROBLEM AREAS****a. Paragraph Number and Wording:****b. Recommended Wording:****c. Reason/Rationale for Recommendation:****6. REMARKS****7a. NAME OF SUBMITTER (Last, First, MI) - Optional****b. WORK TELEPHONE NUMBER (Include Area Code) - Optional****c. MAILING ADDRESS (Street, City, State, ZIP Code) - Optional****8. DATE OF SUBMISSION (YYMMDD)**