

MIL-S-83482B(USAF)  
1 June 1988  
 SUPERSEDING  
 MIL-S-83482A(USAF)  
 19 December 1984

## MILITARY SPECIFICATION

### SLACKS, WOMEN'S

This specification is approved for use within the Department of the Air Force, 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 furnished in the following classes, as specified (see 6.2):

Class 1 - Polyester/wool, USAF Blue 1578, 10.00 oz.

Class 2 - Polyester/wool, USAF Blue 1608, 10.25 oz.

1.2.1 Lengths and sizes. The slacks shall be furnished in the following lengths and sizes, as specified (see 6.2):

#### Schedule of lengths and sizes

Short	6	8	10	12	14	16		
Regular	6	8	10	12	14	16	18	20
Long	6	8	10	12	14	16	18	

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: ASD/ENES, Wright-Patterson AFB OH 45433-6503 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 3410

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## 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.

## SPECIFICATIONS

## FEDERAL

V-F-106	Fasteners, Slide, Interlocking
V-T-276	Thread, Cotton
NN-P-71	Pallets, Material Handling, Wood, Stringer Construction, 2-Way and 4-Way (Partial)
UU-P-268	Paper, Kraft, Wrapping
DDD-L-20	Label: For Clothing, Equipage, and Tentage, (General Use)
PPP-B-636	Boxes, Shipping, Fiberboard

## MILITARY

MIL-C-21115	Cloth, Tropical: Wool, Polyester/Wool
MIL-P-15011	Pallets, Material Handling, Wood Post Construction, 4-Way Entry
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-C-44296	Cloth, Fusibles

## STANDARDS

## FEDERAL

FED-STD-751	Stitches, Seams, and Stitchings
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## 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 Materiel Procedures for Development and Application of Packaging Requirements

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

LAWS AND REGULATIONS

Rules and Regulations Under the Wool Products Labeling Act

(Application for copies should be addressed to the Superintendent of Documents, Government Printing Office, Washington DC 20402-0001.)

(Copies of specifications, standards, and other Government documents required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting activity.)

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

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM D 3951                      Standard Practice for Commercial Packaging

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

THE COLOR ASSOCIATION OF THE UNITED STATES

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

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

(Nongovernment standards and other publications are normally available from the organization which prepare or which 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 specification shall take precedence. Nothing in this specification, however, shall supersede applicable laws and regulations unless a specific exemption has been obtained.

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## 3. REQUIREMENTS

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

3.2 First article. When specified in the contract or purchase order, a sample shall be subjected to first article inspection (see 4.4 and 6.2).

3.3 Materials (see 6.5)

3.3.1 Basic material. The basic material for the class 1 slacks shall be USAF Color Blue, Shade No. 1578 conforming to type III, class 3 of MIL-C-21115. Material for the class 2 slacks shall be USAF Color Blue, Shade No. 1608 conforming to type III, class 4 of MIL-C-21115.

3.3.2 Twill cloth. The material for the left fly lining and for the side pockets shall be twill cloth conforming to class 1 of MIL-C-43718 and shall match the color of the basic material or shall be USN Color Black, Shade No. 3212 (see 6.3).

3.3.3 Fusible material. The fusible material for the waistband, fly, and side pockets shall be type VI, style A, class 2 of MIL-C-44296 and the color shall be black.

3.3.4 Slide fastener. The slide fastener shall be either a continuous chain metal slide fastener or plastic coil slide fastener. The continuous chain metal slide fastener shall conform to type I, style 3, short tab pull, size LS of V-F-106 except that the salt spray test shall not be required and that all components shall be from the same supplier (see 4.5.1). All the components of the continuous chain metal slide fastener shall be brass. The plastic coil slide fastener shall consist of an automatic or cam lock and tape and shall be equal to commercial size No. 2. The plastic coil slide fastener shall be made of polyester or nylon.

3.3.4.1 Tape. The tape for the metal slide fastener shall be cotton, sythetic, or a combination of cotton and sythetic. The tape for the plastic coil slide fastener shall be a blend of nylon and cotton or polyester and cotton or all polyester or nylon in both the warp and the filling directions and shall have a width of 7/16 to 1/2 inch for each side. The color of the tape of the slide fastener shall approximately match the color of the slacks (see 3.3.1).

3.3.4.1.1 Colorfastness. The tape of the slide fastener shall have colorfastness to wet dry cleaning equal to or better than the standard sample. When no standard sample is available, the tape shall have "good" fastness to wet dry cleaning.

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3.3.5 Hooks and eyes. The hooks and the eyes shall be North and Judd (Hook Flex H-49, K-50, H-89, and E-90); Universal Button Co. (Talon No. 3, No. 7, and No. 8 hook with No. 8 eye or No. 85 eye); Akim Co. or Patwin, Inc., Junior Series, Type JB; Stimpson (P-536, D-4086, D-4457, D-4288; Rau (OA50, OX 1256, 080415), Patwin, Inc. (Slim-Slak with MB eye, and Slik-Slak), or equal. The finish of the hooks and the eyes shall be nickel plate. Prior to the use of an "or equal" item, the manufacturer of the slacks shall submit the item with supporting data to the contracting officer for approval (see 4.5.1).

3.3.6 Labels. Each pair of slacks shall have a size label and a combination identification and instruction label conforming to DDD-L-20. The labels shall have colorfastness to dry cleaning.

3.3.6.1 Size label. The size label shall show the size and length of the slacks in black numerals and letters and shall conform to type VI, class 2. The length may be abbreviated as follows: S (Short), R (Regular), or L (Long).

3.3.6.2 Combination label. The combination identification and instruction label shall conform to type VI, class 15 and shall include the following information:

Slacks, Women's

Contract No.: DLA-100-00-0-0000 (Example) 1/

Wool Products Labeling Act (information as applicable) 1/

Contractor: 1/

DRY CLEAN ONLY

1/ The contractor shall include the applicable information.

3.3.7 Thread. The thread for seaming and stitching and overedging shall be cotton conforming to type 1A3, ticket Nos. 50, 3 ply and 70, 2 ply of V-T-276 or cotton-covered or rayon-covered polyester conforming to ticket Nos. 50, 2 or 3 ply and 70, 2 ply of MIL-T-43548. The thread for bartacking shall be cotton conforming to type 1C2, ticket No. 0, 3 ply of V-T-276 or cotton-covered or rayon-covered polyester conforming to ticket No. 50, 2 or 3 ply of MIL-T-43548. The color of the thread shall be Navy Blue AT, C.A. 66060 (see DoD Color Card).

3.3.7.1 Colorfastness. The dyed thread shall show fastness to light and wet dry cleaning equal to or better than the standard sample (see 6.3). When no standard sample is available, the dyed thread shall show "good" fastness to light and wet dry cleaning.

3.4 Design. The slacks shall have a two-section waistband with a tab extension, two quarter top side pockets, front and back waist darts, a center front closure that consists of a slide fastener and hooks and eyes, and straight legs that are unhemmed.

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3.5 Patterns. Standard patterns which provide a seam allowance of 1/2 inch for all seams and a 3/8 inch seam allowance for the waistband joining seam, will be furnished by the Government. The standard patterns shall not be altered in any way and are to be used only as a guide for cutting the contractor's working patterns. The working patterns shall be identical to the Government patterns.

3.5.1 Pattern parts. The components of the slacks shall be cut from the materials specified in accordance with the number of parts indicated in table I.

TABLE I. List of pattern parts.

Material	Pattern Nomenclature	Cut Parts
Basic cloth (see 3.3.1)	Front	2
	Back	2
	Waistband (one right and one left)	2
	Fly (one left fly and one right fly)	2
	Side pocket front facing	2
	Side pocket back facing	2
Twill cloth (see 3.3.2)	Side pocket	2
	Left fly lining	1
Fusible material (see 3.3.3)	Waistband (one right and one left)	2
	Right fly interlining	1
	Side pocket reinforcement <u>1/</u>	2

1/ A pattern part will not be furnished for the side pocket reinforcements. Each side pocket reinforcement shall be 3/4 inch wide and 8 inches long.

3.6 Construction. The construction of the slacks shall conform in all respects to the requirements specified in table II. Figures are furnished for guidance and information only. If there are any inconsistencies between the specification and the figures, the specification shall govern.

3.6.1 Stitches, seams, and stitchings. All stitches, seams, and stitching shall conform to FED-STD-751. The type of seams, stitchings, and stitches per inch shall be as specified in table II. Seam allowances shall be maintained with seam sewn so that no raw edges, run-offs, pleats, puckers, or open seams occur. When two or more seam or stitch types are specified for the same part of the operation, any one may be used. Where stitch type 401 is used, the looper (underthread) shall be on the inside of the finished slacks.

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TABLE II. Manufacturing operations.

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
1.	<p data-bbox="334 506 456 537"><u>Cutting.</u></p> <p data-bbox="334 569 984 768">a. Cut the slacks in strict accordance with Government furnished patterns, which show directional lines, size and placement of pockets, drill marks for finished length of darts, and notches for proper assembly of parts.</p> <p data-bbox="334 831 919 894">b. Cut all parts of the basic fabric from one piece of cloth.</p> <p data-bbox="334 926 984 1115">c. Measurements shall be taken at the top and bottom edges of the pattern from the directional line to the selvaged edge of the fabric and the difference between the two measurements shall not exceed one inch.</p>			
2.	<p data-bbox="334 1146 789 1178"><u>Replacement of damaged parts.</u></p> <p data-bbox="334 1209 967 1430">a. 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> <p data-bbox="334 1461 951 1587">b. Replace any part cut of the fusible interlining if it exhibits any of the following conditions: color change, bleed through, or bubbling.</p>			
3.	<p data-bbox="334 1619 456 1650"><u>Marking.</u></p> <p data-bbox="334 1682 967 1818">Mark, ticket, or bundle all component parts of the slacks to insure correct size, proper assembly, and uniform shade throughout the slacks.</p>			

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
4.	<u>Overedge stitching.</u>			
	a. Overedge stitch the raw edges of the outseams, the inseams, and the bottom of the legs.	502 or 503	EFd-1	6-10
	NOTE: Operation 4a shall be performed after Operation 8c but before Operation 9a.			
	b. Overedge stitch the raw edges of the center front seam, the seat seam, and the ends of the waistband at the outlet.	502 or 503	EFd-1	6-10
	c. Overedge stitch the raw edges of the the front, the bottom, and the back edge of the fly parts.	502 or 503	SSa-1	6-10
	d. Overedge the free edge (inside edge) of the waistband seam.	502 or 503	SSa-1	6-10
5.	<u>Make darts.</u>			
	Finished appearance. The finished darts shall be tapered on the inside without twists or puckers. The thread ends at the lower end of the darts, after trimming, shall be not less than 1/2 inch long. The darts may be backtacked and ends trimmed when using an automatic dart sewing machine.			
	a. Fold and stitch the darts on fronts and backs as indicated by the notches and the drill holes.	301	OSf-1	10-14
	b. Press darts flat with the inside folded edges turned toward the center and back, respectively.			



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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
6.	<u>Fuse pocket reinforcements to pocket openings.</u>  Position the pocket reinforcements on the pocket openings. Press the pocket reinforcements in accordance with the recommendations of the manufacturer of the fusible material.			
7.	<u>Make pockets.</u>  Place a pocket facing and a pocket bearer on each pocket; stitch along the inner side, with the raw edge turned in, and across the lower end. A selvage edge need not be turned in.	301 301	LSd-1 and LSbj-1	10-16 10-16
8.	<u>Attach pockets.</u>  Finished appearance. The edges of the pocket openings shall not be distorted. The finished pocket openings shall be uniform in length and shall be not more than 1/2 inch out of alignment with each other.  a. Seam a pocket to each front, as indicated by the pattern marks. Notch for the pocket opening, but avoid notching the pocket on the underside beyond the width of the side seam allowance. Turn each pocket to the finished position with the seam to the back of the front edge, and stitch 3/16 to 1/4 inch from the edge.  b. Turn the pocket right side out, and seam the raw edges from the step to the folded edge of the pocketing.	301   301 or 401	SSe-2   SSae-2(a) SSae-2(a)	12-16   12-16 12-16

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
8.	<u>Attach pockets.</u> - Contd			
	c. Tack the ends of each pocket opening to the pocket bearer with a tack that is 1/4 to 3/8 inch long. The distance between the tacks of each opening shall be not less than 5 3/4 inches nor more than 6-1/4 inches.	301		12-16
9.	<u>Join outseams.</u>			
	a. Join each outseam, with the notches matched, catching the pocket and the pocket facing in the outseam.	301 or 401	SSa-1	12-16
	b. Press the outseams open, from the bottom to the top of the slacks.			
10.	<u>Finish pockets.</u>			
	Stitch around the bottom of each pocket to the folded edge 1/4 to 3/8 inch from the edge, and securely backstitch the edge of the seam.	301  301	SSc-1 and SSae-2(b)	12-16
11.	<u>Make flies.</u>			
	Finished appearance. The edges of the chain of the slide fastener in the finished slacks shall be 1/2 to 5/8 inch from the edge at the top, tapering to 1/4 to 3/8 inch from the edge at the bottom. The flies and the waistband shall lie smooth when the finished slacks are closed.			
	a. Position the right fly interlining on the right fly. Press the right fly interlining in accordance with the recommendations of the manufacturer of the fusible material.			

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
11.	<u>Make flies.</u> - Contd			
	b. Stitch the back edge of the slide fastener tape to the right fly (through the right fly interlining where applicable) with two rows of stitching. The ends of the scoops shall be 1/4 to 1/2 inch above the fly notch when the fasteners are cut and the scoops are removed.	301 or 401	LSbj-2  LSbj-2	12-16  12-16
	c. After the fasteners are cut and the scoops are removed, stitch the slide fastener tape to the back edge of the left fly, with the bottom end of the scoops 1/4 to 1/2 inch above the fly notch.	301	SSa-1	12-16
	d. Seam the left fly lining to the front edge of the left fly to the top of the left fly.	301 or 401	SSe-2(a)  SSe-2(a)	10-16  10-16
	e. Overedge stitch the back edge of the right fly (and the right fly interlining when applicable).	503 or 504	SSa-1	6-10
12.	<u>Attach flies.</u>			
	Finished appearance. The finished flies shall be even at the ends when the flies are joined to the crotch seam. The flies shall lie flat without twists or puckers when the slide fastener is closed. The top corners of the right fly (if applicable) and of the left fly shall be completely forced out and shall not be bulky. The stitching of the right fly shall be uniformly spaced from the edge of the fly. The seam joining the right fly to the front shall not be exposed on the outside of the slacks when the slide fastener is closed. The			

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
12.	<p><u>Attach flies.</u> - Contd</p> <p>left fly lining shall not be exposed on the outside of the slacks. The flies shall be smooth without twists, puckers, or excessive fullness.</p> <p>a. Sew the right fly (with the slide fastener attached) to the front with the notches matching.</p> <p>b. Sew the left fly (with the slide fastener attached) to the front with the notches matching.</p> <p>c. Turn the flies to the inside with the seam 1/16 to 1/8 inch back of the folded edge. Press the front edge, without damaging the slide fastener.</p> <p>d. Raise stitch the right fly 1/16 inch from the seamed edge; turn to the finished position and stitch approximately 1-1/2 inches from the front edge at the top following the configuration of the fly, stitching and tapering off to the notch at the bottom.</p>	301	SSa-1	12-16
		301	SSa-1	12-16
13.	<p><u>Join seams.</u></p> <p>a. Match the notches on the fronts and the backs at the inseams, and join each inseam 1/2 inch from the edge. The seams shall start and finish evenly.</p> <p>b. Press the inseams open and flat.</p>	301 or 401	SSa-1	10-14
14.	<p><u>Join crotch and seat seam.</u></p> <p>Finished appearance. The crotch and seat seam shall be joined with stitch tension of sufficient elasticity to meet the strain encountered in sitting or stooping. The crotch and seat seam shall be joined</p>			

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
14.	<p><u>Join crotch and seat seams.</u> - Contd</p> <p>so that the inseams will meet and the right and the left waistband joining seams will be aligned. The base of the right fly shall cover the left fly on the outside of the finished slacks.</p> <p>a. Before joining the crotch and seat seam, measure the waist of the slacks to assure the correct waist size.</p> <p>NOTE: Operation 17.a shall be performed prior to Operation 14.b.</p> <p>b. Join the crotch and seat seam from the base of the flies to the end of the waistband with a double-needle seat seamer, with the rows of stitching 1/64 to 1/32 inch apart. The stitching of the outlet seam allowance shall be gradually tapered from 1-1/4 + inches at the top of the waistband to 1/2 inch at the crotch.</p> <p>NOTE: See Operation 21.c.</p> <p>c. Press the crotch and seat seam open.</p>	401	SSa-2	8-10 per needle
15.	<p><u>Tack darts.</u></p> <p>The folded edges of all darts may be tacked to the fronts before the waistband is attached to the slacks.</p>			
16.	<p><u>Fuse waistband interlining to waistband.</u></p> <p>Position the waistband interlining on the left and the right waistband sections. Press the waistband interlining in accordance with the recommendations of the manufacturer of the fusible material.</p>			

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
17.	<u>Attach waistband.</u>			
	<p>Finished appearance. The top edge of the slide fastener chain and the tape shall extend beyond the waistband seam a minimum of 3/8 inch, shall be encased within the waistband, and shall be caught in the 1/16-inch waistband raised stitching. the finished back extension of the waistband shall be flush with the left fly. The finished tab extension of the waistband shall be 1-1/2 <u>+1/4</u> inches beyond the fold of the right fly to the finished square end of the waistband tab. The finished waistband shall be 1-1/4 <u>+1/8</u> inches wide.</p>			
	<p>a. Match the notches on the left and the right waistband sections leaving the tab extension as indicated by the pattern marks. Seam the waistband sections to top of the slacks on the outside 3/8 inch, working in fullness evenly between the notches at the front and catching the top ends of the slide fastener tape, the darts, the top of the pockets and the labels in the stitching. The size label in the finished slacks shall be 2 <u>+1/4</u> inches to the left of the center back seam. Position the combination identification and instruction label on the top of front pocketing so that it will be visible on the inside of the slacks.</p>	301	BSf-2(a)	10-14
	<p>b. Fold the waistband in half lengthwise. Seam across the ends of the tab extension. Trim, turn, and work out the corners of the tab extension.</p>	301	SSe-2(a)	10-14
	OR			

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
17.	<u>Attach waistband.</u> - Contd			
	c. As an option to Operation 17.b, the ends of the tab extension may be seamed, trimmed, turned, and edge stitched before the waistband is set to the waist.	301	SSe-2	10-14
	d. Turn the free edge of the waistband to the inside, and topstitch the waistband 1/16 inch from the seamed edge through all plies. Continue the top stitching along the tab extension ends and the top of the waistband.	301	BSf-2(b) or SSe-2(b) or OSf-1	12-14
18.	<u>Assemble fasteners.</u>			
	Attach slider and, with the end of the chain even, staple the fastener together.			
	NOTE: Staple shall not be attached more than 1/2 inch above fly notch.			
19.	<u>Stitch left fly lining extensions.</u>			
	Turn in the raw edges of the left fly lining extension piece and machine stitch or hand fell to each side of the pressed open crotch and seat seam.	301 or Hand	SSac-3(b)(c) (d) SSac-3(b)(c) (d)	10-16  6-8
20.	<u>Attach hooks and eyes.</u>			
	a. Attach two hooks through a suitable reinforcement to the waistband as follows: Position one hook on the center (1/4 inch tolerance) of the right waistband so that the rolled edge of the hook will be aligned with the slide fastener scoops. Position one hook on the center (1/4 inch tolerance) of the right waistband tab extension so that the edge of the hook will be 1/2 inch from the finished edge.			

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
20.	<p><u>Attach hooks and eyes.</u> - Contd</p> <p>b. Attach two eyes through a suitable reinforcement to the waistband as follows: Position one eye on the center of the left waistband so that the eye will be aligned with the slide fastener scoops and will correspond with the hook on the right waistband. Position one eye on the center of the left waistband to correspond with the hook on the right waistband tab extension.</p> <p>NOTE: When the hooks and the eyes of the finished slacks are engaged, the closure of the slacks shall not bulge, pucker, or twist.</p>			
21.	<p><u>Bartack.</u></p> <p>Finished appearance. The bartacks shall be well made and correctly placed to reinforce the points of strain as specified.</p> <p>a. Bartack the upper end of each pocket opening 1/2 inch below the waistband seam. Bartack the lower end of each pocket opening so that the bartack will extend 1/16 to 1/8 inch beyond the out-seam. The bartacks shall be perpendicular to the pocket openings.</p> <p>b. Bartack the slacks at the base of the fly at the junction of the crotch seam and fly. The bartack may be either diagonal in line with the fly stitching or horizontal and shall extend beyond the crotch seam.</p>	<p>Bartack</p> <p>Bartack</p>		<p>28 stitches per bartack</p> <p>28 stitches per bartack</p>



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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
21.	<u>Bartack.</u> - Contd  c. Insert thread chain from seat joining seam (see Operation 14.b) under seat seam outlet and place a 3/8 inch horizontal bartack across top of waistband centered over the seat seam catching the thread chain. The bartack shall be located 1/8 +1/16 inch from the top edge of the open waistband.	Bartack		28 stitches per bartack
22.	<u>Clean slacks.</u>  Trim thread ends and remove loose threads; remove spots, stains, and shade or size markings.			
23.	<u>Press slacks.</u>  a. Press top of slacks smooth and flat.  b. Place legs, seam on seam, and press slacks smooth and flat.			

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

3.6.1.1.1 Repairs of type 301 stitching. Repairs of type 301 stitching shall be as follows:

a. When thread breaks, skipped stitches, run-offs, or bobbin runouts occur during stitching, the stitching shall be repaired by restarting the stitching a minimum of 1/4 inch back of the end of the stitching (see NOTE).

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b. Except for prestitching, thread breaks, or two or more consecutive skipped or run-off stitches noted during inspection of the item (in-process or end item) shall be repaired by overstitching. The stitching shall start a minimum of 1/4 inch back of the defective area, continue over the defective area, and continue a minimum of 1/4 inch beyond the defective area onto the existing stitching. Loose or excessively tight stitching shall be repaired by removing the defective stitching without damaging the materials, and restitching in the required manner (see NOTE).

NOTE: When making the above repairs the ends of the stitching are not required to be backstitched.

3.6.1.2 Types 401, 502, 503, and 504 stitching. Thread tension shall be maintained so that there will be no loose or excessively tight stitching resulting in puckering of the materials sewn. All repairs shall be in accordance with 3.6.1.1. Typ 301 stitching may be used to repair type 401 stitching.

3.6.1.3 Bartacks. Unless otherwise specified, all bartacks shall be 3/8 +1/16 inch long, 1/8 +1/32 inch wide, and shall contain 28 stitches (minimum). Bartacks shall be free from thread breaks and loose stitching.

3.6.1.4 Automatic stitching. Automatic machines may be used to perform any of the stitch patterns provided the requirements for the stitch pattern, stitches per inch, and size and type of thread are met; and at least three tying, overlapping, or backstitches are used to secure the ends of stitches.

3.6.1.5 Thread ends. All thread ends shall be trimmed to 1/4 inch maximum length. The thread ends of the darts shall be trimmed to a length of 1/2 inch.

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

3.7.1 Shade and size marking. The component parts of the slacks shall be marked, ticketed, or bundled 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 type tickets.
- c. Adhesive type tickets which show discoloration and the adhesive mass which adheres to the material upon removal of the ticket.

NOTE: The use of an ink pad numbering machine, rubber stamp, or pencil is allowed provided the numbering does not show on the outside of the slacks and wherever possible is covered by the seam allowance.

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3.7.2 Pressing. All pressing required in table II shall be done with a heated pressing iron or machine.

3.8 Finished measurements. The finished measurements of the slacks shall be as specified in table III.

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

#### 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 as specified herein. Except as otherwise specified in the contract or purchase order, the contractor may use his own or any other facility 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 prescribed requirements.

4.1.1 Responsibility for compliance. All items shall meet all requirements of sections 3 and 5. The inspection set forth in this specification shall become 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 Certificates of compliance. When certificates of compliance are submitted, the Government reserves the right to inspect such items to determine the validity of the certification.

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

- a. First article inspection (see 4.4).
- b. 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 4.5.1.

4.4 First article inspection. When a first article is required (see 6.2), it shall be examined for the defects specified in 4.5.3 and 4.5.4. The presence of any defect shall be cause for rejection of the first article.

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TABLE III. Finished measurements (inches).

Size	Waist <u>1/</u>	Hips <u>2/</u>	Inseam Length <u>3/</u>	Bottom <u>4/</u>	Knees <u>5/</u>
<u>Short</u>					
6	23	36	31-1/4	19	19
8	24	37	31-3/4	19-1/2	19-1/2
10	25	38	32-1/4	20	20
12	26	39	32-3/4	20-1/2	20-1/2
14	27-1/2	40-1/2	33-1/4	21	21
16	29	42	33-3/4	21-1/2	21-1/2
<u>Regular</u>					
6	23	36	31-3/4	19	19
8	24	37	32-1/4	19-1/2	19-1/2
10	25	38	32-3/4	20	20
12	26	39	33-1/4	20-1/2	20-1/2
14	27-1/2	40-1/2	33-3/4	21	21
16	29	42	34-1/4	21-1/2	21-1/2
18	30-1/2	43-1/2	34-3/4	22-1/4	22-1/4
20	32-1/2	45-1/2	35-1/4	22-3/4	22-3/4
<u>Long</u>					
6	23	36	32-1/4	19	19
8	24	37	32-3/4	19-1/2	19-1/2
10	25	38	33-1/4	20	20
12	26	39	33-3/4	20-1/2	20-1/2
14	27-1/2	40-1/2	34-1/4	21	21
16	29	42	34-3/4	21-1/2	21-1/2
18	30-1/2	43-1/2	35-1/4	22-1/4	22-1/4
Tolerances	<u>+1/2</u>	<u>+1/2</u>	<u>+1/4</u>	<u>+1/2</u>	<u>+1/2</u>

- 1/ Measure the waist from folded edge to folded edge across the center of the waistband, with the slide fastener closed, and multiply the measurement by two.
- 2/ Measure the hips from folded edge to folded edge, 8-1/2 inches below the top of the waistband, with the slide fastener closed, and multiply the measurement by two.
- 3/ Measure the inseam length, along the inseam, from the crotch seam to the unhemmed bottom of the leg.
- 4/ Measure the unhemmed bottom of the leg from folded edge to folded edge and multiply the measurement by two.

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TABLE III. Finished measurements (inches). - Continued

5/ Measure the knee from folded edge to folded edge across the width of the leg and multiply the measurement by two. The distance from the unhemmed bottom of the leg at which the knee is measured shall be 16  $\pm$  1/4 inches for Short, 17  $\pm$  1/4 inches for Regular and 18  $\pm$  1/4 inches for Long.

4.5 Quality conformance inspection. Unless otherwise specified, sampling for inspection shall be performed in accordance with MIL-STD-656.

4.5.1 Component and material inspection. In accordance with 4.1, components and materials shall be inspected in accordance with all the requirements of referenced documents unless otherwise excluded, amended, modified, or qualified in this document or applicable purchase document. Certificates of compliance will be acceptable for the following requirements: requirements that all components of the metal slide fastener shall be from the same supplier (see 3.3.4); requirements for the plastic coil slide fastener (see 3.3.4 and 3.3.4.1); and the requirements for the hooks and eyes (see 3.3.5).

4.5.2 In-process inspection. Inspection shall be made at any point or during any phase of the manufacturing process to determine whether construction details which cannot be examined in the finished product are in accordance with specified requirements. This inspection shall include verification that the working patterns conform to the Government patterns in all respects. Whenever nonconformance is noted, corrections shall be made to the items affected and lot in process. Items which cannot be corrected shall be removed from production.

4.5.3 Point count inspection. Sampling and inspection provisions for end item examination of dress (D) slacks, dimensional examination, and packaging inspection shall be performed in accordance with MIL-STD-656. The occurrence of defects during these examinations shall not exceed the applicable point value or defect limit specified.

4.5.4 Palletization examination. 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 inspection lot. The inspection level shall be S-1 and the acceptable quality level, expressed in terms of defects per hundred units, shall be 6.5 as specified in MIL-STD-105.

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<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 or film as specified. Straps loose.
Weight	Exceeds maximum limits.
Marking	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application.

## 5. PACKAGING

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

5.1.1 Level A. Each pair of slacks shall be folded to measure approximately 11-1/2 by 15 inches. Each pair of folded slacks shall be dusted with 1/4 ounce of naphthalene flakes (see 6.2), and inserted into a snug-fitting flat style clear polyethylene film bag of 0.00125 (+25 percent tolerance) inch thickness. The polyethylene bag shall be formed with heat-sealed seams that are straight, continuous, and parallel to each other and the formed edges of the bag. The final closure of the bag shall be heat sealed with the heat seal made as close as possible to the open end. The bag may be fabricated from polyethylene film tubing or sheeting. A 1/4-inch diameter hole shall be made at one corner of each polyethylene bag to allow excess air to escape. Alternatively, the final closure of the polyethylene bag may be accomplished by means of a tuck or reverse flap.

5.1.2 Level C. Each pair of slacks shall be preserved in accordance with MIL-STD-2073-1.

5.1.3 Commercial. The slacks shall be preserved in accordance with ASTM D 3951.

5.2 Packing. Packing shall be level A, B, C, or Commercial as specified (see 6.2).

5.2.1 Level A. Twenty pairs of slacks of the same size, preserved as specified in 5.1, shall be packed in a fiberboard shipping container conforming to type CF, class weather-resistant, variety SW, grade V3c, of PPP-B-636. The inside of each container shall be fitted with a box liner conforming to the requirements in PPP-B-636 for liners for class weather-resistant boxes. Level A unit packs shall be packed flat, two in length, one in width, and ten in depth within a shipping container. Each container

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shall have the contents completely covered on the top and bottom with a sheet of 30-pound minimum basis weight kraft paper conforming to type I, grade B of UU-P-268. Toward the end of the contract or when there are less than the required amount of slacks per container of the same size, mixed sizes may be packed within the same shipping container.

**5.2.2 Level B.** Twenty pairs of slacks of the same size, preserved as specified in 5.1, shall be packed in a fiberboard shipping container conforming to type CF, class domestic, variety SW, grade 275, of PPP-B-636. The inside of each shipping container shall be fitted with a box liner conforming to the requirements in PPP-B-636 for liners for domestic boxes. Level A unit packs shall be packed flat, two in length, one in width, and ten in depth within a shipping container. Each container shall have the contents completely covered on the top and bottom with a sheet of 30-pound minimum basis weight kraft paper conforming to type I, grade B of UU-P-268. Toward the end of the contract or when there are less than the required amount of slacks per container of the same size, mixed sizes may be packed within the same shipping container.

**5.2.2.1 Weather-resistant fiberboard container.** When specified (see 6.2), the shipping container shall be a grade V3c, V3s, or V4s fiberboard box fabricated in accordance with PPP-B-636 and closed in accordance with the closing requirements of PPP-B-636.

**5.2.3 Level C.** Slacks, preserved as specified in 5.1, shall be packed in accordance with MIL-STD-2073-1.

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

**5.3 Palletization.** When specified (see 6.2), slacks packed as specified in 5.2, shall be palletized on a 4-way, type I, style 1A or 1B, size A, class 1 pallet fabricated in accordance with MIL-P-15011 or on a 4-way, type IV, V, or VIII, class 1, size 2, grade A pallet fabricated in accordance with NN-P-71. Each prepared load shall be in accordance with load type I or 1a and bonded with the applicable strap bonding or film bonding means specified in MIL-STD-147. The pallet pattern shall be in accordance with the appendix of MIL-STD-147. 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. Inspection shall be as specified in 4.5.4.

**5.4 Marking.** In addition to any special markings required by the contract or purchase order, the bagged unit packs, the shipping containers, and the palletized unit loads shall be marked in accordance with MIL-STD-129 or ASTM D 3951, as applicable.

**5.4.1 Bar code markings.** Bar code markings, when specified (see 6.2), shall be in accordance with MIL-STD-129.



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5.4.2 Polyethylene packages. Each polyethylene bag (see 5.1.1) shall have the stock number, nomenclature, size, and quantity of slacks contained therein legibly printed, stamped, or bar coded in black across the center face of the bag, or a white paper label with the required information printed thereon in black shall be placed in the bag so that it is readable through the polyethylene.

5.4.2 Labels, mixed sizes. Each shipping container that is packed with mixed sizes shall have securely attached to the end and side, directly under the printing or stenciling, a white paper label 5 by 4 inches with the words "MIXED NSN'S" plainly stamped or printed thereon and under these words shall be legibly stamped or printed the correct quantity and NSN's contained therein.

## 6. NOTES

6.1 Intended use. The slacks covered by this specification are intended to be worn by female security police of the Department of the Air Force as part of the dress uniform.

### 6.2 Ordering data

6.2.1 Acquisition requirements. Acquisition documents should specify the following:

- a. Title, number, and date of this specification.
- b. Length and size required (see 1.2).
- c. When a first article is required (see 3.2).
- d. Selection of applicable levels of preservation and packing (see 5.1 and 5.2).
- e. When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).
- f. When palletization is required (see 5.3).
- g. When bar code markings are required (see 5.4).

6.2.2 Naphthalene flakes. The naphthalene flakes requirement is not applicable when Government furnished material of wool or part wool content has been mothproof treated (see 5.1.1).

6.3 Samples. For access to guide samples of the end item and shade samples, address the contracting activity issuing the invitation for bids.



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6.4 First article. When a first article sample is required it shall be inspected and approved under the appropriate provisions of FAR 52.209-4. The first article should be a preproduction sample or initial production item. The contracting officer should include specific instructions in acquisition documents regarding arrangements for examinations, approval of first article test results and disposition of first article. Invitations for bids should provide that the Government reserves the right to waive the requirement for samples for first article inspection to those bidders offering a product which has been previously acquired or tested by the Government, and that bidders offering such products, who wish to rely on such production or test, must furnish evidence with the bid that prior Government approval is presently appropriate for the pending contract.

6.5 Recycled material. It is encouraged that recycled material be used when practical as long as it meets the requirements of this document (see 3.3).

6.6 Subject term (key word) listing.

Slacks, security police  
Slacks, woman's  
Uniform, dress

6.7 Changes from previous issue. Asterisks (\*) are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.

Custodian:

Air Force - 11

Preparing activity:

Air Force - 11

Review activities:

Air Force - 82, 99

DLA - CT

User:

Air Force - 45

Project No. 8410-F671

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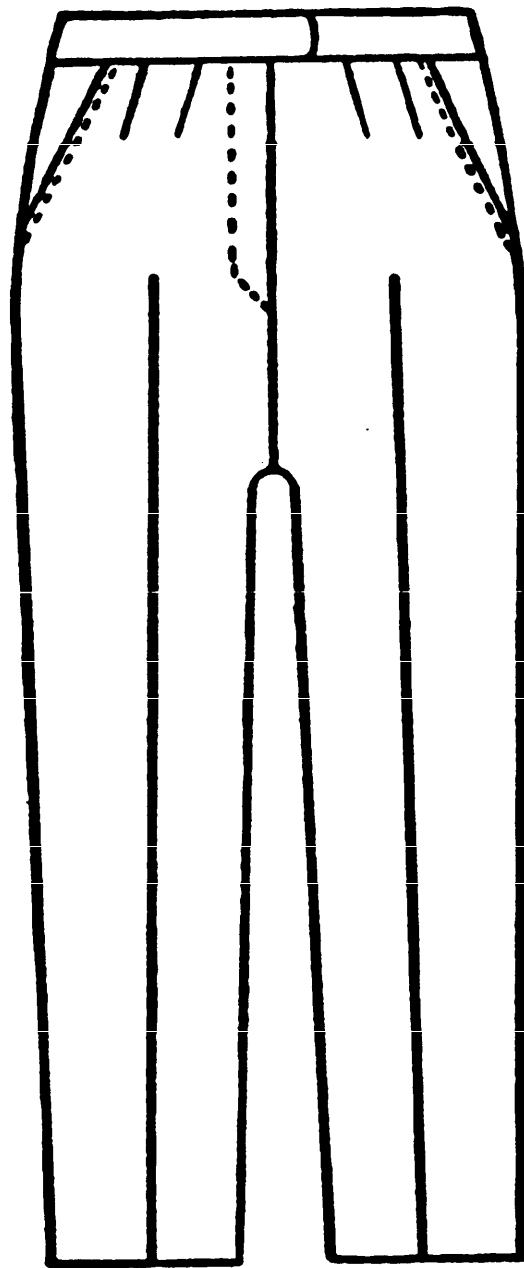


FIGURE 1. Slacks, women's (front view).

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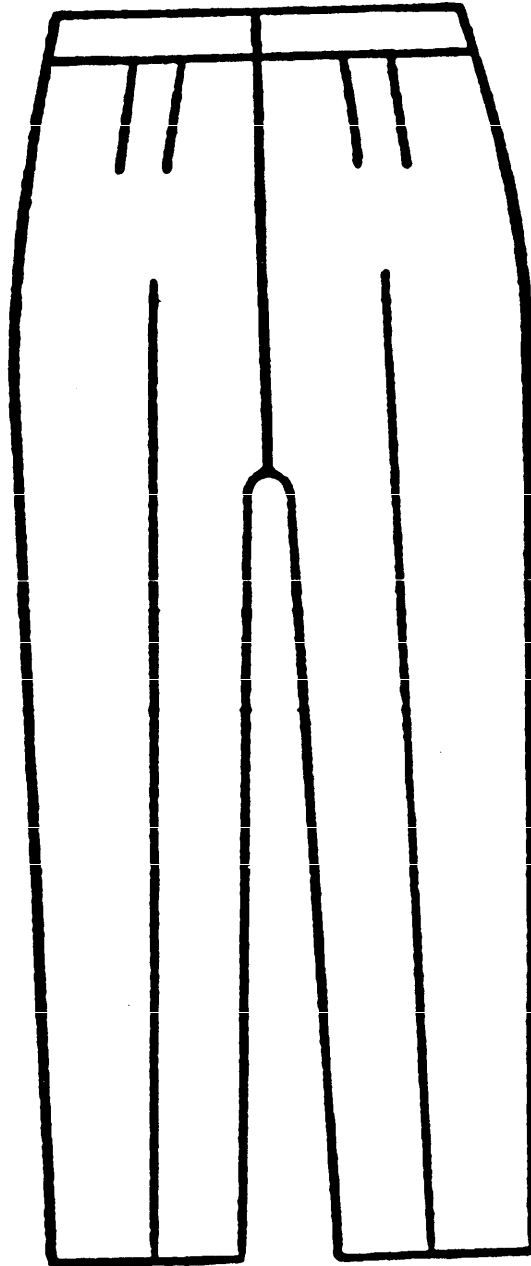


FIGURE 2. Slacks, women's (back view).

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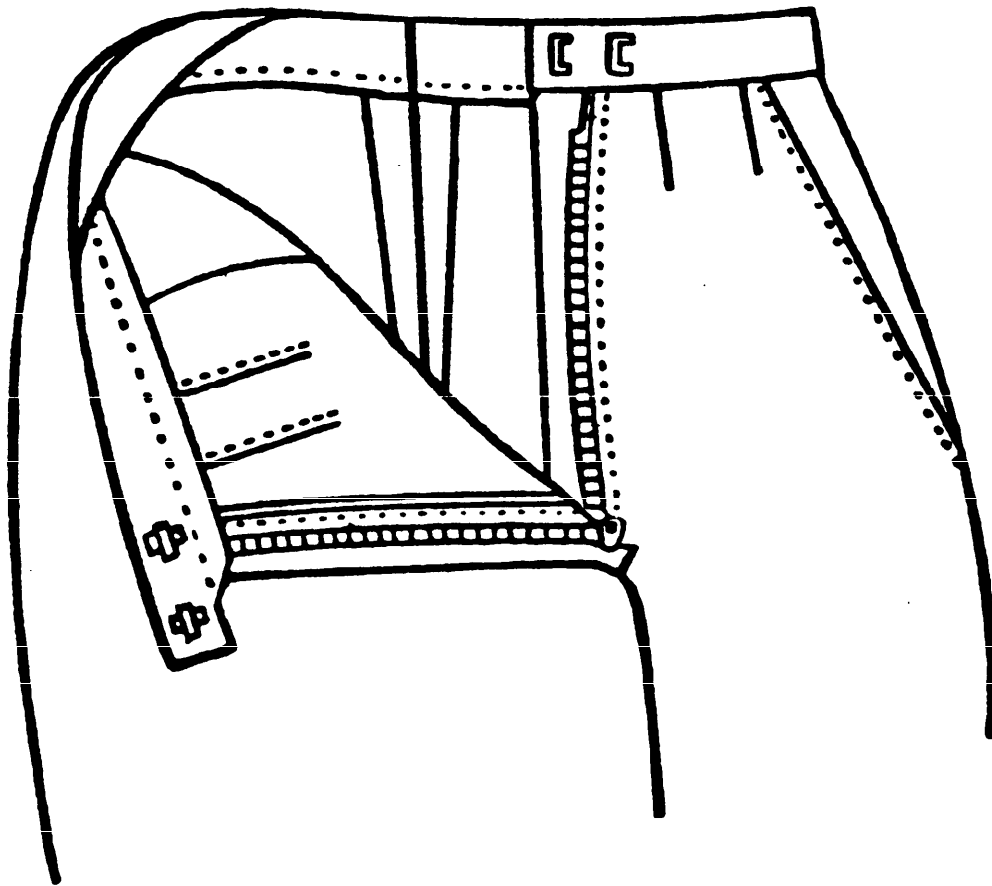


FIGURE 3. Slacks, women's (front closure).

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**NOTE:** This form may not be used to request copies of documents, nor to request waivers, deviations, or clarification of specification 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.

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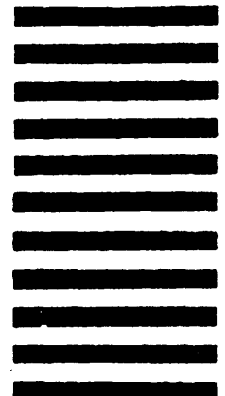
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## STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

## 1. DOCUMENT NUMBER

MIL-S-83482B(USAF)

## 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)

(TO DETACH THIS FORM, CUT ALONG THIS LINE.)