

MIL-S-87054C(NU)  
29 September 1988  
SUPERSEDING  
MIL-S-87054B(NU)  
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MILITARY SPECIFICATION

SLACKS, WOMEN'S, BELTED

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 polyester/cotton and polyester/wool women's dress slacks.

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

1.2.1 Classes.

Class 1 - Slacks, Women's, Belted Polyester/Wool Blue 3346

Class 3 - Slacks, Women's, Belted Polyester/Cotton White 3053

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

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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.

ASMC NA

FSC 8410

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## MIL-S-87054C(NU)

## 2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications, standards, and handbooks. Unless otherwise specified, the following specifications, standards, and handbooks of the issue listed in that issue of the Department of Defense Index of Specifications and Standards (DoDISS) specified in the solicitation form a part of this specification to the extent specified.

## SPECIFICATIONS

## FEDERAL

- |           |   |
|-----------|---|
| V-F-106   | - Fasteners, Slide, Interlocking  |
| NN-P-71   | - Pallet, Material Handling, Wood, Stringer Construction, 2 Way and 4 Way (Partial) |
| CCC-C-438 | - Cloth, Buckram, Woven, and Nonwoven   |
| DDD-L-20  | - Label; for Clothing, Equipage, and Tentage (General Use)                          |

## MILITARY

- |             |  |
|-------------|--|
| MIL-P-15011 | - Pallet, Material Handling, Wood, Post Construction, 4 Way Entry          |
| MIL-B-17757 | - Boxes, Shipping, Fiberboard (Modular Sizes)                              |
| MIL-C-24910 | - Cloth Tropical: Polyester and Wool                                       |
| MIL-C-29127 | - Cloth, Twill, Polyester/Cotton (Crease Resistant Finish)                 |
| MIL-T-43548 | - Thread, Polyester; Cotton-; Rayon; and Polyester-Covered                 |
| MIL-C-43718 | - Cloth, Polyester; Polyester and Cotton, Polyester and Rayon, for Pockets |

## STANDARDS

## FEDERAL

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

## MILITARY

- |             |  |
|-------------|--|
| MIL-STD-105 | - Sampling Procedures and Table 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.)

MIL-S-87054C(NU)

\* 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 may be obtained from the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402.)

2.2 Other publications. The following document(s) form a part of this specification to the extent specified herein. The issues of documents which are indicated as DoD adopted shall be the issue listed in the current DoDISS and supplement thereto, if applicable. Unless otherwise specified, the issue of documents not listed in the DODISS shall be the issue of the nongovernment documents which is current on the date of the solicitation.

NATIONAL MOTOR FREIGHT TRAFFIC ASSOCIATION, INC., AGENT

National Motor Freight Classification

(Application 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 Thread

Department of Defense Standard Shades for Buttons

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

TECHNICAL MANUAL OF THE AMERICAN ASSOCIATION  
OF TEXTILE CHEMISTS AND COLORISTS

Test Method - 135-1978 - Dimensional Changes in Automatic Home Laundering of  
Woven and Knit Fabrics

(Application for copies should be addressed to the AATCC, P.O. Box 12215, Research Triangle Park, NC 27709-2215).

## MIL-S-87054C(NU)

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.

## 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 material for the slacks shall conform to 3.3.1.1 and 3.3.1.2.

3.3.1.1 Class 1 slacks. The material for the class 1 blue slacks shall be polyester/wool tropical blend cloth, shade Blue 3346, conforming to MIL-C-24910.

3.3.1.2 Class 3 slacks. The material for the class 3 slacks shall be a polyester and cotton twill cloth conforming to class 2 of MIL-C-29127. The color shall be shade White 3053.

3.3.2 Pocketing and waistband lining. The material to be used for the front and back plies of the pocketing and for waistband lining, shall be a twill cloth material conforming to class 1 of MIL-C-43718. The color for the class 1 blue slacks shall be dark grey or black, and white for the class 3 white slacks.

3.3.3 Fusible interlining. The pocket welts shall be fused with a woven or nonwoven thermal bonded consisting of 85-100% polyester with the remaining fiber being nylon. The material shall be free of chemical binders. The fusible adhesive system shall be a polyester paste dot uniformly distributed over one side of the material. The color shall approximate the shade of base fabric. The total weight of the nonwoven fusible shall be  $1.1 + .2$  oz/yd<sup>2</sup>. The fused sample, consisting of fusible interlining and base fabric, shall conform to the requirements stated below when tested as specified in Table III.

MIL-S-87054C(NU)

Component Testing Requirements

Appearance of fused samples 1/

Initial 2/ - No evidence of bubbling or delamination of the bond, change of color, or strike through.

After 5 dry cleanings 2/ - No evidence of bubbling or delamination of the bond, change of color, or strike through.

Bond strength 3/

22 oz min. - initially

18 oz - after 5 launderings

18 oz - after 5 dry cleanings

Shrinkage

After 3 launderings - 2.5 % max.

After 3 dry cleanings - 2.5 % max

1/ Applies to quality conformance and in-process tests.

2/ After evaluation for initial appearance and shrinkage, samples may be used for the remainder of appearance tests.

3/ When a nonwoven fusible is used, the item will be accepted if the fusible either splits from itself rather than separates from the outershell material or if it begins to separate from the outershell material higher than the minimal bond strength and then splits from itself.

3.3.3.1 Colorfastness. All dyed, finished, fusible interlining materials shall show fastness to laundering (3 cycles) and dry cleaning (3 cycles), equal to or better than the standard sample. When no standard sample is available the finished, dyed fusibles shall show a minimum of "fair" fastness after 3 launderings and 3 dry cleanings (see Table III).

3.3.4 Buckram. The material for interlining the waistband shall be bleached or unbleached cotton buckram conforming to type II, class 1 of CCC-C-438. As an alternate, a nonwoven conforming to type IV, class 1 of CCC-C-438 may be used.

3.3.5 Tape, waistband, non-slip. The woven non-slip tape for the waistband lining assembly 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. The width of the completed tape shall be 7/8 inch and shall not shrink more than 2% in the length direction when subjected to the manufacturer's standard procedures for determining dimensional stability to laundering and dry cleaning as appropriate for the end item. There shall be a minimum distance of 3/16 inch from the rubber thread to edge of tape (see 4.4.1 and 6.5).

## MIL-S-87054C(NU)

3.3.6 Hook and eye. The hook and eye shall be North and Judd (hook Flex H-49 and E-50); Universal Fastener, Inc. (#8 hook with #8 eye or #85 eye); Akim Co. (Slim-Slak with MB eye and Slik-Slak) or equal. (See 4.4.1 and 6.6). The finish shall be nickel plate.

3.3.7 Thread. The thread for seaming and stitching the slacks shall be polyester/covered conforming to MIL-T-43548, ticket No. 70, 2 or 3 ply. The color of the thread for the class 1 blue slacks shall be shade Black AA, C.A. 66043, shade White AH, C.A. 66050 for the class 3 white slacks and should be in accordance with the DoD Standard Shades for Threads.

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

3.3.8 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 chain 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. The length of the style 3 slide fasteners from the top stop to the bottom edge of the bottom stop shall be as follows:

<u>Size</u>	<u>Short</u>	<u>Regular</u>	<u>Long</u>
6-10	6-1/2	7	7-1/2
11-15	7	7-1/2	8
16-22	7-1/2	8	8-1/2

3.3.8.1 Color. The color of the slide fastener tape shall be black for the class 1 blue slacks, and white for the class 3 white slacks.

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

3.3.9 Labels.

MIL-S-87054C(NU)

3.3.9.1 Combination label. Each pair of slacks shall have a combination personal, identification, size and instruction label conforming to type VI, classes 10 and 15 of DDD-L-20. The label shall show colorfastness to wet-dry cleaning and laundering. The inscription and format shall be as follows:

NAME:  
SERVICE NO:  
SLACKS, WOMEN'S, BELTED CLASS 1 (EXAMPLE)  
FIBER CONTENT: 75% POLYESTER/25% WOOL (EXAMPLE)  
CONTRACT NO: DLA-100-00-0-0000 (EXAMPLE)  
NAME OF CONTRACTOR:  
NAME OF MANUFACTURER: (if other than contractor)

Applicable to class 1 slacks only:

Washing Instructions

Machine Wash Permanent Press Cycle - Warm Water (120°F. max)  
Do Not Bleach - Tumble Dry - Medium Heat - Remove Immediately  
May also be Dry Cleaned

or

Follow NAVEDTRA Manual 414-01-45-81, Formula III

Applicable to class 3 slacks only:

Washing Instructions

Machine Wash- Normal Cycle - Warm Water  
Do Not Bleach - Tumble Dry  
Medium Heat - Remove Promptly

OR

Follow NAVEDTRA Manual 414-01-45-81, Formula II.

3.3.9.2 Size label. The size label shall conform to type IV, class 2 of DDD-L-20. The inscription and format shall be as follows:

SIZE: 12R (EXAMPLE)  
STOCK NUMBER: 8410-00-000-0000 (EXAMPLE)

NOTE: Abbreviations for applicable lengths shall be as follows:

S - Short                      R - Regular                      L - Long

## MIL-S-87054C(NU)

3.3.9.3. Removable size ticket. Each slack shall have a commercial type size ticket attached to the outside of the waistband above the left back dart. 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 (12R - 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. Abbreviation for lengths shall be allowed in accordance with 3.3.9.2.

3.4 Design. The slacks shall have front and back waist darts, two front welt pockets, waistband with hook and eye closure and a fly front slide fastener closure. The leg bottoms shall be unhemmed (see Figure 1).

3.4.1 Figure. The figure 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. The patterns provide a 3/8 inch seam allowance for waistband and fly and 1/2 inch for all other seams except as otherwise indicated in table of operations.

3.5.1 Pattern parts. The component parts of the slacks shall be cut from materials as specified in accordance with the number of parts required as shown below.

Material	Pattern nomenclature	Cut parts
Basic cloth, (as specified)	Front	2
	Back	2
	Waistband	2
	Left fly	1
	Right fly facing	1
	Pocket welt	2
	Pocket facing	2
Cloth, twill	Left fly lining	1
	Pocketing (front ply)	2
	Pocketing (back ply)	2
Fusible interlining	Pocket welt interlining	2

## MIL-S-87054C(NU)

### 3.6 Construction.

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 part of the operation, any one of them may be used. Where stitch type 401 is used, the looper (underthread) shall be on the inside of the slacks. Unless otherwise specified in Table I, edge or topstitching shall be 1/16 inch from folded 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. Operation requiring stitching and overedging a seam simultaneously may be performed in two separate operations.

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 produced with 301 stitch type, when not caught in other seams or stitching, shall be backstitched not less than 3/8 inch. Thread breaks (all stitch types) shall be secured by stitching back of the break not less than 1/2 inch. Skipped stitches (except seat seam) may be repaired by using 301 stitch types. The seat seam must be resewn. The ends of a continuous line of stitching shall be overlapped not less than 1/2 inch. Thread ends of darts shall be trimmed to a length of 1/2 inch. When automatic dart machine is used, the ends shall be backstitched not less than 3 stitches. When stitch type 401 is permitted as an option, it shall not be used unless the ends are caught in other seams or stitching.

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 All fusing of the fusible to the basic material shall be on a single ply basis (no stacking allowed).

\* 3.7.3 The statement "press fusible to various cut parts in accordance with the fusible manufacturer's recommendation" refers to time, temperature, and pressure.

## MIL-S-87054C(NU)

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

- (1) Corrosive metal fastening devices
- (2) Sew-on shade tickets
- (3) Adhesive type tickets which leave traces of adhesive on the material after removal of tickets

NOTE: The use of ink pad numbering machine, rubber stamp or pencil is allowed, provided the numbering does not show on the outside of the garment (area up to 1/2 inch from outside of leg bottom excluded) and wherever possible, is covered by the seam allowances.

3.7.5 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
Brtck	-	Bartack
Comrcl	-	Commercial
smlr	-	similar
Btnhl	-	Buttonhole
incl	-	including
dbl	-	double

## MIL-S-87054C(NU)

TABLE 1 - CONSTRUCTION OF SLACKS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
1.	<p><u>Cutting.</u></p> <p>a. Spread the material without tension, face to face.</p> <p>b. Cut the slacks in strict accordance with patterns furnished which show directional line for cutting, sizes, and marks for proper assembly of all component parts. Drill holes are not permitted except for darts.</p> <p>c. Cut all parts of the slacks out of the same piece of basic material except right fly facing and left fly), pocket facing, waistband lining, waistband interlining, and belt loops, which may be cut from ends. Parts cut from ends shall approximate the shade of the basic material.</p> <p>d. Cut the stripping for belt loops of sufficient width to conform with finished measurements (see operation 4).</p> <p>e. Cut waistband lining, non-slip tape and waistband interlining of sufficient length and width to comply with operation 15.</p> <p style="text-align: center;">or</p> <p>As an alternate, waistband lining may be a commercial type using the lining and interlining maerial specified in operations 15a-d.</p>				
2.	<p><u>Replacement of defective components.</u></p> <p>During the spreading, cutting and manufacturing process, components having material defects as specified in MIL-STD-656 shall be removed from production and replaced with non-defective and properly matched components.</p>				
3.	<p><u>Marking.</u> (See 3.7.4)</p> <p>Mark or ticket all parts except those parts cut from ends, to insure a uniform shade and size throughout the slacks.</p>				

## MIL-S-87054C(NU)

TABLE 1 - CONSTRUCTION OF SLACKS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
4.	Make stripping for belt loops. Fold stripping in half with edges turned under along one side and stitch 1/16 inch from each folded edge. The finished stripping shall measure 5/16 to 3/8 inch in width.	301 or 401	EFp-2	10-14	70	70
	OR					
	Make belt loops by folding stripping with edges abutted at center and double stitch with each row of stitching not less than 1/16 inch from folded edge and the covering stitch on the underside.	406	EFh-1	10-14	70	70
5.	<u>Overedging.</u> a. Overedge all raw edges of slack panels except waist edge and outseam. Overedge the right front waistband edge.	503 or 504	EFd-1	8-10	70	70
6.	<u>Make darts.</u> a. Fold darts and stitch as indicated by marks on patterns, tapering lower end of dart to nothing. Drill holes, when used, should not be less than 3/4 inch above dart taper.	301 or auto dart mach	OSf-1	10-14	70	70
	b. Press darts flat with inside folded edge of darts on back panels facing seat seam and inside folded edge of darts on front panels facing center front.					
7.	<u>Make welts.</u> a. Position fusible interlining on underside of welt and press in accordance with the directions of the fusible manufacturer.					
	b. Fold welt in half lengthwise, face to face and stitch across each end of welt through all plies 1/4 inch from raw edges.	301	SSa-1	10-14	70	70
	c. Trim corners, turn welt to finished position, and work out seamed edges and corners.					
	d. Topstitch ends and top edge of welt 1/4 inch from edges.	301	SSe-2(b) and OSf-1	10-14	70	70

## MIL-S-87054C(NU)

TABLE 1 - CONSTRUCTION OF SLACKS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
8.	<u>Make pocket and attach label.</u> NOTE: Twill direction of the finished pocket welts shall be the same as twill direction on the finished slack front.					
	a. Position the pocket (front ply) against the back portion of the welt. Center the welt on the top edge of the pocket, aligning raw edges. Overedge stitch together.	503, 504 or 602	SSa-1	8-10	70	70
	b. Position the front portion of welt assembly top edge down, on the front of the slacks. Slack front may be pre-slashed so the lower notched ends meet the end of the stitch line as marked on pattern. Stitch welt assembly to front along stitchline 1/4 inch seam allowance, thru all plies. The ends of the stitching shall finish at the welt ends.	301	LSbj-1	10-14	70	70
	c. Overedge bottom edge of pocket facing except when edge has a selvage, or when contractor exercises the option to turn and stitch facing to pocket (see oper 8d).	503, 504, or 602	EFd-1	8-10	70	70
	d. Align the lower serged or selvaged pocket facing edge with the notches at the back ply of pocket. Or, turn under raw facing edge 1/4 inch and align folded edge with the notches at the back ply of pocket. Stitch close to finished edge.	301	LSbj-1 or LSd-1	10-14	70	70
	e. Stitch combination label on all four sides to the outside of the right back pocket ply. Label shall be centered on the pocket with the side edge positioned approximately 1/2 inch below and parallel to the facing piece seam. The label inscription shall be perpendicular to the facing piece seam and shall face the wearer. The stitching shall not be through the printing.	301	LSbj-1	10-12	70	70
	f. If not previously slashed, slash front about 1/4 inch above stitchline, 3/8 inch short of the welt ends and parallel to welt. Tongue notch opening to ends of stitchline and toward waist. Turn welt through opening to finished position. The notches shall not appear beyond the welt.					

## MIL-S-87054C(NU)

TABLE 1 - CONSTRUCTION OF SLACKS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	g. Superimpose the back ply of pocket on the front ply, face to face, matching lower and curved edge. Overedge together the side and bottom edges of pocketing, extending overedging along the raw side edges of the back pocket ply.	503 or 504 or 602	SSa-1 and EFd-1	8-10	70	70
	h. Stitch the side and bottom edges of pocketing 3/8 inch from serged edge.	301 or 401	SSa-1	10-14	70	70
	OR					
	As an alternate, the side and bottom edges of the pocketing may be stitched with a 3/8 inch gauge safety stitch.	515, 516 or 519	SSa-2 and EFd-2	10-14	70	70
	i. Fold under upper lip of front pocket opening toward the waist and stitch 1/16 inch from the folded edge through the pocket facing and the back ply of pocketing. Tightness, twisting, or distortion shall not be present in the facing, slacks or pocketing.	301	LSa-1	10-14	70	70
	j. As an alternate to operations 8f-i, the following operations may be performed: Slash front in accordance with operation 8f. Align top edge of pocket facing face to face with top edge of slashed pocket opening and stitch 1/4 inch from raw edges. Fold pocket facing to finished position. Perform operations 8g-i.	301	SSa-1	8-10	70	70
	k. Topstitch across each end of welt 1/16 inch from edge through all plies. From the top edge of the welt, the topstitching shall continue diagonally down to meet the corner of the previously stitched row of 1/4 inch topstitching, then superimposed on the stitchline to the bottom of the welt.	301	SSE-2(b)	10-14	70	70

NOTE: Tongue notches shall be folded in and caught in the topstitching of operation 8k.

l. The finished welts shall measure 1 to 1-1/8 inches deep and 4-1/8 to 4-3/8 inches wide for all sizes. The pocket depth shall measure 5 3/4 (+ 1/4) inches deep for all sizes and lengths.

## MIL-S-87054C(NU)

TABLE 1 - CONSTRUCTION OF SLACKS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
9.	<u>Join outseams.</u>					
	a. Match outseams according to marks on patterns and join with a 3/8 inch gauge safety stitch.	515 or 516 or 519	SSa-2	10-14	70	70
	b. Turn seam allowances toward fronts and top stitch 3/16 to 1/4 inch from folded edge.	301 or 401	LSq-2(b)	10-14	70	70
	c. Bottom edges shall match within 1/2 inch.					
10.	<u>Join inseams.</u>					
	a. Match inseams according to marks on patterns and stitch.	301 or 401	SSa-1	10-14	70	70
	b. Press inseams open and flat.					
	c. Bottom edges shall match within 1/2 inch.					
11.	<u>Make flies.</u>					
	a. Overedge back edge of right fly facing.	503 or 504 or 602	EFd-1	8-10	70	70
	b. For use with style 3, preassembled slide fastener: Double stitch the back of fastener tape 1/4 inch or 3/16 inch gauge to the right fly facing. The right coil edge shall be 3/8 to 1/2 inch from the front edge of the fly in the finished slacks. The bottom stop shall be positioned at the fly notch. In the finished slack, the top stop shall be placed no further than 1/4 inch from waistband joining seam.	301 or 401	SSa-2	10-14	70	70
	c. For use with style 1a, continuous chain slide fastener: Position and stitch in accordance with operation 11b above. The coil shall extend past the fly notch at the bottom, and extend into the waistband at the top. The coil may be clipped below the fly notch to enable slider to be put on following center front seaming. The finished length of the slide fastener from the bottom edge of the applied bottom stop to the waistband seam shall be as for pre-assembled fasteners (indicated in 3.3.8).	301 or 401	SSau-2	10-12	50 50	50 70

## MIL-S-87054C(NU)

TABLE 1 - CONSTRUCTION OF SLACKS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	d. Stitch the left fly and left fly lining together face to face along the outer curved edge 1/4 inch from raw edges. Turn and topstitch.	301	SSe-2	10-14	70	70
	e. Place fastener tape of back edge of left fly, and overedge.	503 or 504 or 602	EFd-1	8-10	70	70
12.	<u>Sew on right and left flies.</u>					
	a. Position the left fly assembly on the front, face to face, matching raw edges, top edges and notches. Stitch 3/8 inch from the aligned edges to the bottom of the fly.	301	SSj-1	10-14	70	70
	b. Fold back front edge of left slack section against the seam and topstitch 1/16 inch from the folded edge. Care shall be taken not to damage the slide fastener coil.	301	LSq-2(b)	10-14	70	70
	c. Sew right fly facing (with slide fastener attached) to front edge of right front 3/8 inch from raw edges, from top of front to below the fly notch. Clip at base of stitching, turn seam allowance against right fly facing and topstitch seam 1/16 inch from folded edge.	301	LSq-2	10-14	70	70
	NOTE: Stitching to a point below the fly notch is necessary to obtain the required slide fastener length following seaming of fronts and when applicable, attaching of bottom stop.					
13.	<u>Attach waistband and belt loops.</u>					
	a. <u>Finished appearance</u> - The finished waistband shall finish smooth and flat, without fullness, gathers, or pleats. The belt loops shall be positioned with the ends inserted not less than 1/2 inch in the bottom of the waistband, and caught in the stitching (except center back loop).					

## MIL-S-87054C(NU)

TABLE 1 - CONSTRUCTION OF SLACKS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	<p>b. The slacks shall have 5 belt loops positioned as follows:</p> <ul style="list-style-type: none"> <li>- one loop on each panel adjacent to the front darts abutting the folded edge of the dart.</li> <li>- one loop on each back panel abutting the side seams.</li> <li>- one loop centered on the seat seam (to be attached following waistband joining).</li> </ul>					
	<p>c. Stitch right and left waistband sections to outside top edge of each slack section, inserting belt loops and matching ends of waistband with raw seat seam outlet edges and right fly edge. The waistband should extend 3/8 inch beyond finished left fly edge. Distribute fullness evenly under the waistband.</p>	301 or 401	SSa-1	10-14	70	70
	<p>NOTE: Prior to operation 13c, the folded darts, side seams, end of belt loops and top of back pocket ply may be staystitched at waist edge. Top of back ply of pocket shall be smoothed out to assure it lays flat when waistband is attached.</p>	301	SSa-1	6-8	70	70
14.	<p><u>Attach hook and eye.</u></p> <p>a. Position and attach the hook on the center (1/4 inch off center tolerance) of right waistband with the rolled edge of the hook aligned with the slide fastener scoops. Attach through a suitable reinforcement.</p> <p>b. Position and attach the eye on the left waistband aligned with the slide fastener to correspond to the hook on waistband. Attach through a suitable reinforcement.</p> <p>NOTE: When hook and eye is engaged on the finished slacks, the closure shall not bulge, pucker or twist.</p>					

## MIL-S-87054C(NU)

TABLE 1 - CONSTRUCTION OF SLACKS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
15.	<u>Make non-slip waistband lining.</u> Note: See Figure 1 for side view of assembly.					
	a. Position the center of the non-slip tape 1 + 1/16 inch below the top edge of a 1-5/8 to 1-3/4 inch wide woven or nonwoven buckram strip. Buckram may be pieced by butting ends and joining. Not more than one seam per waistband shall be permitted.					
	b. Cut the waistband lining material (see oper 1e) on the bias in two portions to attach above and below the rubberized threads of the non-slip tape as follows:  - The lower portion shall be cut wide enough to fold around the bottom edge of the buckram and extend 1/4 inch beyond the lower row of rubberized threads, front and back. The lower lining portion shall measure 3/4 + 1/16 inch wide when finished and attached to the slacks.  - The top portion shall be cut to extend 5/8 inch beyond the top row of rubberized threads and 1/4 inch beyond the top edge of the buckram. The top lining portion shall measure 5/8 + 1/16 inch wide when finished and attached to slacks.  The lining may be pieced with not more than one seam per portion of waistband using a 1/4 inch seam spread open and flat.	301 or 401	SSa-1	10-14	70	70 or cmrcl
	c. Turn under the lower edge of the top portion of waistband lining material 1/4 inch. With fold adjacent to the top row of the rubberized threads of the non-slip tape, stitch close to fold through lining and non-slip tape.	101, 301 or 401	smlr to LSd-1	8-10	70	70 or cmrcl
	d. Turn under the top edge of the front of the lower portion of waistband lining material 1/4 inch. Place fold adjacent to the lower row of the rubberized threads of the non-slip tape. Stitch close to fold through lining on front, non-slip tape, buckram and portion of lining turned to back.	101 301 or 401	smlr to BSb-1	8-10	70	70 or cmrcl

## MIL-S-87054C(NU)

TABLE 1 - CONSTRUCTION OF SLACKS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	e. As an alternate, a commercial waistband conforming to specified requirements may be used (see operation 1c).					
16.	<u>Attach waistband lining assembly to waistband and close seat seam.</u>					
	a. Lap the top edge of waistband 3/8 to 1/2 inch over the top edge of the buckram from left front of waistband and center front at right to back waistband edges. Turn the top edge of the lining under 1/4 to 3/8 inch and position the turned edge against the waistband edge. Stitch waistband lining to top edge of waistband along fold, catching the buckram underneath in the seam.	304 or 404	LSb-1 except buckram shall be on underside	10-14	70	70
	Finished appearance - The seat seam shall be joined with stitch tension of sufficient elasticity to meet strain encountered in sitting and stooping. The waist shall be measured before the seat seam is stitched to assure correct waist size. In the joining of the seat seam the inseams shall meet and the right and left waistband joining seams and waistband/waistband lining assembly joining seams shall be aligned. The base of the right fly shall lap the left fly by 1/8 inch on outside of the finished slacks.					
	NOTE: Front seam (from crotch to notch) may be joined during the assembly of the fly (prior to operation 12c) to facilitate the use of preassembled slide fastener.					
	b. Stitch seat seam from base of fly to end of waistband lining with a double needle seat seamer with the two rows of stitches 1/64 to 1/32 inch apart. The seam from the waistband joining seam to the end of the waistband lining shall be perpendicular (90 degree angle) to the waistband joining seam. Broken seat seam must be completely resewn.	401	SSa-2	8-10 each needle	70	70
	c. Press seat seam open to crotch area.					
	d. Outlet seam shall finish 1-1/4 inches at top tapering to 1/2 inch at crotch. The crotch and seat seams shall not be staggered by more than 3/8 inch. The inseam lengths shall match within 1/2 inch.					

## MIL-S-87054C(NU)

TABLE 1 - CONSTRUCTION OF SLACKS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
17.	<u>Finish waistband.</u>					
	a. Turn right front waistband against itself at fly edge. Stitch across top of waistband and turn so waistband finishes square and of required width.	301	SSa-1	10-14	70	70
	b. Turn left front waistband lining against itself at top of waistband. Stitch across front even with fly edge. Turn. Waistband shall finish square and be of required width.	301	SSa-1	10-14	70	70
	c. When style 1a (continuous chain) slide fastener is used: Attach slide fastener, and with chain even, apply bottom stop.					
	d. Turn under the waistband lining outlet at center back diagonally against the underside of the waistband lining.					
	e. Turn the top edge of the waistband down against the top edge of the buckram. Turn waistband joining seam allowance toward top of the slacks and the belt loops downward. Topstitch waistband through all plies uniformly gauged at 1/16 to 1/8 inch from the waistband joining seam.	301	smlr to BSp-2(b)	8-10	70	70
	f. Fold lower portion of waistband curtain even with the finished left fly and edge stitch through all plies from the waistband joining seam to the bottom of the curtain. This operation may be performed simultaneously with operation 17e.	301	SSc-1	8-10	70	70
	g. The finished waistband shall be uniform in width and shall measure 1-1/8 to 1-1/4 inches wide.					
	h. Stitch inner and top edge of slack front 1 1/8 (+ 1/16) inch from front edge of fly, extending from top of waistband and curving to fly notch, forming "J" stitching.	301	LSa-1	8-10	70	70
	i. Bartack base of fly with a horizontal bartack 1/4 (+ 1/16) inch above fly ("J") stitching. The bartack shall not extend onto the left front. The bartack shall catch the left portion of the slide fastener tape and the left fly piece.	Brtck		28 per brtck	70	70

## MIL-S-87054C(NU)

TABLE 1 - CONSTRUCTION OF SLACKS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	j. Bartack the inside of the fly, securing the right fly to the left fly. The bartack shall not be visible from the outside and shall not interfere with the operation of the slide fastener.	Brtck		28 per brtck	70	70
18.	<u>Tack belt loops.</u>					
	a. Drop belt loops and straight tack or bartack across (but not beyond) the width of the loops 3/16 to 5/16 inch below the waistband joining seam.	301 or Brtck		10-14 21 or 28 per brtck	70	70
	b. Fold belt loops up against bartack and turn under top of each belt loop with folded edge positioned even with the top folded waistband edge. Straight tack or bartack loops through all plies of waistband, 1/8 inch below the top of waistband edge. The turn-under shall not be more than 1/2 inch long.	301 or brtck or Auto loop tacker	LSd-1	10-14 21 or 28 per brtck 24-28 per tack	70	70
	c. Position center back loop over center of seat seam.					
	d. With the end of the center back belt loop abutting the bottom edge of the waistband, straight tack or bartack loop 3/16 to 5/16 inch below waistband seam. The stitch shall extend the width of the loop and not beyond.	301 or brtck		10-14 21 or 28 per brtck	70	70
	e. Fold center back belt loop up against bartack and turn under top of belt loop with folded edge positioned even with the top folded waistband edge and centered over center back seam. Straight tack or bartack loops through all plies of waistband, 1/8 inch below top of waistband edge. The turn-under shall not be more than 1/2 inch long.	301 or brtck or Auto loop tacker	LSd-1	10-14 21 or 28 per brtck 24-28 per tack	70	70
	f. The finished belt loop openings shall finish 1-3/8 to 1-1/2 inches between bartacks.					
19.	<u>Cleaning.</u>					
	a. All ends of stitching shall be trimmed and loose threads removed from slacks.					

NOTE: Care shall be taken when trimming thread ends that damage to the fabric does not result.

## MIL-S-87054C(NU)

TABLE 1 - CONSTRUCTION OF SLACKS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	THREAD	
				STCH IN	NDL BOB/ LPR
	c. Attach removable size ticket to outside of waistband above the left back dart, tacking all four corners of ticket.	Hand or Machine		2-4 stch/tack 2-4 stch/tack	
20.	<u>Press slacks.</u>				
	a. The top, including fly and pockets, shall be pressed smooth.				
	b. The legs shall be pressed smooth and creased in the center with the seams matching at the bottom and in crotch; or the inseams in the crotch may be slightly back of the outside seam.				

## MIL-S-87054C(NU)

3.8 Sizes and measurements. Unless otherwise specified, finished measurements of the slacks shall be as listed in Table II (see figure 1). All measurements and tolerances are expressed in inches.

Table II - Sizes and Measurements

Size	(A)	(B)	Inseam (C)			(D)
	Waist	Hip	S	R	L	Bottom
6	23-1/2	36	30-1/4	32-1/4	34-1/4	20
7	24	36-1/2	30-1/4	32-1/4	34-1/4	20
8	24-1/2	37	30-1/4	32-1/4	34-1/4	20-1/4
9	25	37-1/2	30-1/4	32-1/4	34-1/4	20-1/4
10	25-1/2	38	30-1/4	32-1/4	34-1/4	20-1/2
11	26-1/4	38-3/4	30-1/4	32-1/4	34-1/4	20-1/2
12	27	39-1/2	30-1/4	32-1/4	34-1/4	20-3/4
13	27-3/4	40-1/4	30-1/4	32-1/4	34-1/4	20-3/4
14	28-1/2	41	30-1/4	32-1/4	34-1/4	21
15	29-1/4	41-3/4	30-1/4	32-1/4	34-1/4	21
16	30	42-1/2	30-1/4	32-1/4	34-1/4	21-1/4
18	32	44-1/2	30-1/4	32-1/4	34-1/4	21-1/2
20	34	46-1/2	30-1/4	32-1/4	34-1/4	21-3/4
22	36	48-1/2	30-1/4	32-1/4	34-1/4	22
Tolerance	$\pm 1/2$	$\pm 1/2$	$\pm 1/2$	$\pm 1/2$	$\pm 1/2$	$\pm 1/2$

NOTE: Waist and hip measurements of the slacks shall be taken with slide fastener fully closed and waistband secured. All measurements shall be taken with slacks smooth and flat.

(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 1-1/4 inch below fly bartack. The measurement shall be taken with slacks smooth, flat and held snug.

(C) Inseam - Length measurement taken along inseam from crotch seam to unfinished bottom of legs.

## MIL-S-87054C(NU)

(D) Bottom - Twice the measurement taken from folded edge to folded edge across unfinished bottom of leg.

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 or defect limit.

#### 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 sections 3 and 5. The inspection set forth in this specification shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the contractor of the responsibility of assuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling 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 for compliance with design, construction, workmanship, appearance, and dimensional requirements.

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

## MIL-S-87054C(NU)

4.4.1 Component and material inspection. In accordance with 4.1 above, components and materials shall be inspected and tested in accordance with all the requirements of referenced specifications, drawings, and standards unless otherwise excluded, amended, modified, or qualified in this specification or applicable purchase documents. A certificate of compliance will be acceptable for the non-slip tape requirements of 3.3.5, the hook and eye requirements of 3.3.6, and the plastic coil slide fastener requirements of 3.3.8. In addition, testing shall be performed on components listed in Table III and in accordance with characteristics noted. The methods of testing specified in FED-STD-191, wherever applicable and as listed in Table III shall be followed. All requirements are applicable to the sample unit. All test reports shall contain the individual values used in expressing the final result. The lot shall be unacceptable if one or more sample units fail to meet any of the test requirements specified. The lot size and sample size shall be in accordance with the following:

Component	Lot expressed as	Sample unit for testing
Fusible interlining	Yards	Two 24 by 24 inch specimen <u>1/</u>

1/ Prepared by the contractor during the same period and under the same conditions as for the fusing of the end item.

Table III - Component testing

Component	Characteristic	Requirement paragraph	Test Method
Interlining fused to basic cloth	Construction	3.3.3	<u>1/</u>
	Appearance	3.3.3	Visual
	Weight	3.3.3	5041
Bond strength <u>4/</u>	-initial	3.3.3	5951
	-after 5 launderings	3.3.3	AATCC TM 135-1978 <u>3/</u>
	-after 5 dry cleanings	3.3.3	5580 <u>2/</u>
			and
			5951
All dyed fusible interlinings	Shrinkage		
	-after 3 launderings	3.3.3	AATCC TM 135-1978 <u>3/</u>
	-after 3 dry cleanings	3.3.3	5580
All dyed fusible interlinings	Colorfastness to		
	-after 3 launderings	3.3.3.1	AATCC TM 135-1978 <u>3/</u>
	-after 3 dry cleanings	3.3.3.1	5622

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

2/ Pressing and shrinkage requirements shall not apply.

3/ Laundered on permanent press cycle (120°F) and tumble dried at (120°F) for three complete cycles.

4/ All bond strength test samples shall have a 1 inch minimum nonfused area at the top, perpendicular to the warp. Both the basic material and the fusible shall be fused with the warps (or machine direction) parallel.

## MIL-S-87054C(NU)

4.4.2 In-process inspection. Inspection shall be made at any point or during any phase of the manufacturing process to determine whether operations or assemblies are carried out as specified. The Government reserves the right to exclude from consideration for acceptance any material or service for which in-process inspection has indicated nonconformance.

4.4.2.1 Sample size. The size of the fused check sample shall correspond to the total area covered by the pocket welts which are fused at one time on the press.

4.4.2.2 Number of check samples. One check sample shall be prepared following fusing of every 1000 pocket welts or once every four hours, whichever occurs first.

4.4.2.3 Appearance of the fused check sample. Each check sample shall be visually inspected for color change, bleed through, bubbling, and delamination. If there is any evidence of these conditions present, the previously fused pieces represented by the sample shall be inspected for the above conditions. Any fused part exhibiting one of the above conditions shall be removed from the lot (see 3.3.3 and 3.3.3.1).

4.4.3 End item examination. Sampling and examination of the end item shall be performed in accordance with the provisions and defects for dress slacks in MIL-STD-656.

4.4.4 Palletization examination. An examination shall be made to determine that the palletization complies with 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.

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

## MIL-S-87054C(NU)

## 5. PACKAGING

5.1 Preservation-packaging. Packaging shall be level A or C (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 for class 1, slacks, 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).

5.2.1 Level A. Fourteen (14) pairs of slacks, of one class, size and length only, packaged as specified in 5.1, shall be packed in a fiberboard shipping container, assembled, closed and reinforced conforming to type CF, class weather-resistant, variety DW, grade V15C, size 2A of MIL-B-17757. The fiberboard for the liner shall conform to type CF, class domestic, conforming to MIL-B-17757. Level A packages shall be stacked as follows: two in length, one in width and seven 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. Fourteen (14) pairs of slacks, of one class, size and length only, packaged as specified in 5.1, shall be packed in a fiberboard shipping container, assembled, closed and reinforced conforming to type CF, class domestic, variety DW, grade 200, size 2A of MIL-B-17757. The fiberboard for the liner shall conform to type CF, of MIL-B-17757. Level A packages shall be stacked as follows: two in length, one in width and seven 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 retail distribution. Containers shall comply with the US Postal Service Manual, Uniform Freight Classification Rules or National Motor Freight Classification Rules, as applicable.

## MIL-S-87054C(NU)

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  
CLASS, SIZE AND LENGTH  
QUANTITY

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 banded with primary and secondary straps in accordance with the banding means C, K and L, or O or P. 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.

## 6. NOTES

6.1 Intended use. The slacks are intended to be worn by female personnel of the Navy.

6.2 Ordering data.

- (a) Title, number, and date of this specification
- (b) Class, 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 instruction in acquisition documents regarding arrangement 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)

## MIL-S-87054C(NU)

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 3.3.8.

6.5 Tape waistband. A non-slip waistband tape conforming to the requirements of 3.3.5 may be obtained from Empire Bias Binding Co., 18 West 20th Street, NY, NY; Atlantic Bias Products, Inc., 16 West 19th Street, NY, NY; United Elastic (Division of J.P. Stevens) Stuart Plant, Stuart, VA 24171. Style #N3 - 7675 or Silver Elastic Co., Inc, 37 Tweed Dr., 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 by the responsible Military Agency.

\* 6.7 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.

6.8 Polyester khaki and polyester/cotton khaki slacks are available as optional items and shall meet the requirements specified through the Certification Program.

6.9 Subject term (key word) listing:

Slacks, Women's, Belted  
Tropical, Polyester/Wool  
Twill, Polyester/Cotton  
Uniform, Woman's  
Waistband, Non-slip Tape

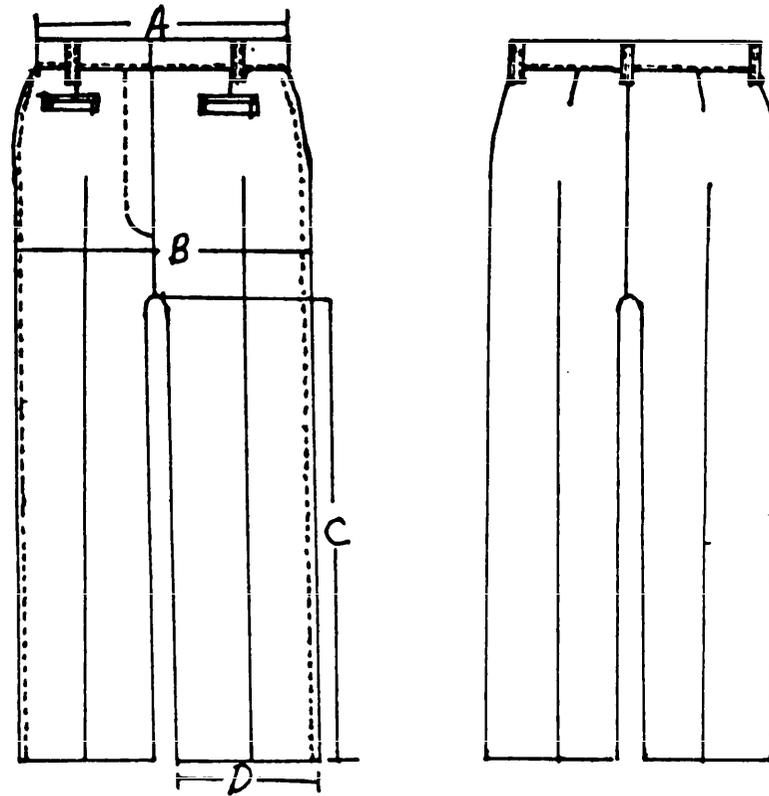
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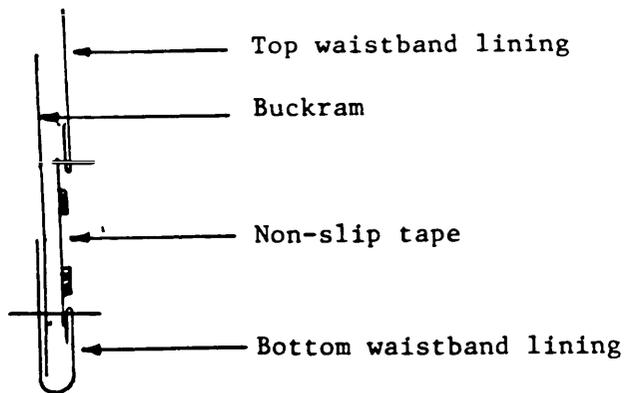
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MIL-S-87054C(NU)



Front

Back



Side view of waistband lining

Figure 1 - Slacks, Women's, Belted

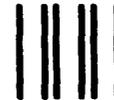
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