

INCH-POUND

MIL-S-87225A (USAF)

7 May 1990

SUPERSEDING

MIL-S-87225 (USAF)

20 September 1985

MILITARY SPECIFICATION

- * SHIRTS, WOMEN'S: SHORT AND LONG SLEEVES, POLYESTER/COTTON (DURABLE PRESS)
AND LONG SLEEVES, POLYESTER/WOOL

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 blue polyester/cotton, durable press shirts, short and long sleeves, and a polyester/wool long sleeve shirt.

* 1.2 Classification. The shirts shall be of the following types and classes, as specified (see 6.2):

Type I - Short sleeve

Class 1 - Polyester/cotton broadcloth, USAF Blue 1550

Type II - Long sleeve

Class 1 - Polyester/cotton broadcloth, USAF Blue 1550

Class 2 - Polyester/wool tropical cloth, USAF Blue 1609

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.

ANEC N/A

FSC 8410

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1.2.1 Sizes. The women's shirts, short and long sleeves, shall be furnished in the following lengths and sizes, as specified (see 6.2):

Schedule of sizes (types I and II) and sleeve lengths (type II)

<u>Short</u>	<u>Short plus</u>	<u>Regular</u>	<u>Regular plus</u>	<u>Long</u>	<u>Long plus</u>
6S	6S+	6R	6R+	6L	6L+
8S	8S+	8R	8R+	8L	8L+
10S	10S+	10R	10R+	10L	10L+
12S	12S+	12R	12R+	12L	12L+
14S	14S+	14R	14R+	14L	14L+
16S	16S+	16R	16R+	16L	16L+
18S	18S+	18R	18R+	18L	18L+
20S	20S+	20R	20R+	20L	20L+
		22R	22R+	22L	22L+

2. APPLICABLE DOCUMENTS

2.1 Government documents

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

SPECIFICATIONS

FEDERAL

A-A-203	Paper, Kraft, Untreated
A-A-50083	Bag, Plastic, Folded Garment
V-B-871	Button, Sewing Hole, and Button, Staple, (Plastic)
V-T-276	Thread, Cotton
DDD-L-20	Label: For Clothing, Equipage, and Tentage, (General Use)
PPP-B-601	Boxes, Wood, Cleated-Plywood
PPP-B-636	Boxes, Shipping, Fiberboard

MILITARY

MIL-L-10547	Liners, Case, and Sheet, Overwrap; Water-Vaporproof or Waterproof, Flexible
MIL-C-21115	Cloth, Tropical: Wool, Polyester/Wool
MIL-F-21840	Fastener Tapes, Hook and Pile, Synthetic
MIL-T-43548	Thread, Polyester Core: Cotton-, Rayon-, or Polyester-Covered
MIL-C-43594	Cloth, Interlining, Polyester
MIL-T-43624	Thread, Polyester Spun
MIL-C-43992	Cloth, Broadcloth, Polyester/Cotton Durable Press

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STANDARDS

FEDERAL

FED-STD-751 Stitches, Seams, and Stitchings

MILITARY

MIL-STD-105 Sampling Procedures and Tables for Inspection by
Attributes
MIL-STD-129 Marking for Shipment and Storage
MIL-STD-147 Palletized Unit Loads
MIL-STD-2073-1 DoD Materiel Procedures for Development and Application of
Packaging Requirements

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

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

AMERICAN ASSOCIATION OF TEXTILE CHEMISTS AND COLORISTS (AATCC)

AATCC TECHNICAL MANUAL

Test Method 88B Appearance of Seams in Durable Press Items After Repeated
Home Laundering
Test Method 124 Appearance of Durable Press Fabrics After Repeated Home
Laundering

(Application for copies of the AATCC Technical Manual should be addressed to the American Association of Textile Chemists and Colorists, 1 Davis Dr., P.O. Box 12215, Research Triangle Park NC 27709-2215.)

AMERICAN IRON AND STEEL INSTITUTE (AISI)

STEEL PRODUCTS MANUAL

Stainless and Heat Resisting Steel, Types 304 and 316

(Application for copies of the AISI Steel Products Manual should be addressed to the American Iron and Steel Institute, 1133 15th St., N.W., Suite 300, Washington DC 20005-2701.)

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AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM D 204 Standard Methods of Testing Sewing Threads
ASTM D 3951 Standard Practice for Commercial Packaging (DoD adopted)

(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 1968

Department of Defense (DoD) Standard Shades for Buttons 1966

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

(Non-Government standards and other publications are normally available from the organizations that prepare or distribute the documents. These documents also may be available in or through libraries or other informational services.)

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

3. REQUIREMENTS

3.1 First article. When specified (see 6.2), a sample shall be subjected to first article inspection (see 6.3) in accordance with 4.3.

3.2 Guide samples. Guide samples, when furnished, are solely for guidance and information to the contractor (see 6.4). Variations from the document may appear in the sample, in which case the document shall govern.

3.3 Materials. It is encouraged that recycled material be used when practical as long as it meets the requirements of this document.

* 3.3.1 Basic material. The basic material for the type I and type II, class 1 shirts shall be polyester/cotton broadcloth, USAF Blue, Shade No. 1550 conforming to class 3 or 4 of MIL-C-43992 and polyester/wool tropical cloth, USAF Blue, Shade No. 1608 conforming to type III, class 4 of MIL-C-21115 for the type II, class 2 shirt.

3.3.2 Interlining. The material used for interlining the front, shoulder loops, collar stand, and collar leafs of the type I and type II shirts and the cuffs of the type II shirt shall be polyester fiber cloth conforming to MIL-C-43594.

3.3.3 Fastener pile tape. The nylon fastener pile tape to secure the necktab to the shirt shall be White, Shade No. 3054 and shall be 5/8 inch wide by 3/4 inch long conforming to type I, class 1 of MIL-F-21840.

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3.3.4 Thread. The thread shall be cotton-covered polyester, Ticket No. 70, 2 or 3 ply or Ticket No. 100, 2 or 3 ply conforming to MIL-T-43548. Spun polyester thread, Ticket No. 70, 2 or 3 ply or Ticket No. 100, 2 ply conforming to MIL-T-43624 may be substituted for the cotton-covered polyester thread. The thread shall be stabilized so as not to shrink in boiling water more than 1.5 percent when tested as specified in 4.4.1. In addition, when purl type buttonholes are used, thread conforming to types IA2 and IA3, Ticket Nos. 40, 4 ply or 40, 6 ply (needle) and 80, 2 ply (bobbin) of V-T-276 shall be used.

* 3.3.4.1 Color. The color of the thread for the type I and type II, class 1 shirts shall be White AH, C.A. 66050 and the thread for the type II, class 2 shirt shall be Navy Blue AT, C.A. 66060 (see DoD Standard Shades for Sewing Threads).

* 3.3.5 Buttons. The buttons shall conform to type II, class K, style 25 of V-B-871 with 17-line for neck closure, and 19-line for front, cuffs (type II shirt), and shoulder loops, and the color shall be White BA, C.A. 62031 for the type I and type II, class 1 shirts and Blue BV, C.A. 62003 for the type II, class 2 shirt (see DoD Standard Shades for Buttons 1966).

3.3.6 Elastic. The elastic for the collar closure loop shall be white, polyester fiber, 1/8 to 3/16 inch wide.

3.3.7 Labels. Each shirt shall have a size label, identification label, and instruction label or a combination identification and instruction label conforming to DDD-L-20. The fastness to laundering requirements of DDD-L-20 shall apply.

3.3.7.1 Size labels. The size label shall conform to type IV or type VI, class 2.

3.3.7.2 Identification label. The identification label shall conform to type VI, class 1.

* 3.3.7.3 Instruction labels.

3.3.7.3.1 Type I and type II, class 1 shirts. The instruction label for the type I and type II, class 1 shirts shall conform to type VI, class 3 and contain the following instructions:

WASHING INSTRUCTIONS

MACHINE WASH: Use permanent press cycle, moderately hot water (115°F), and soap or mild detergent.

HAND WASH: Use moderately hot water (115°F), and soap or mild detergent.

DO NOT WRING OR TWIST

MACHINE DRY: Dry in tumble dryer at warm setting. Remove immediately at end of drying. Shape and hang.

DRIP DRY. Remove from water before last spin cycle. Shape and hang.

PRESSING. Press at moderate heat setting.

DO NOT REMOVE THIS LABEL

* 3.3.7.3.2 Type II, class 2 shirt. The instruction label for the type II, class 2 shirt shall conform to type VI, class 3 and shall specify: DRY CLEAN ONLY.

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3.3.7.4 Combination identification and instruction label. The combination identification and instruction label shall conform to type VI, class 15 and shall include the instructions specified in 3.3.7.3. When combined, the item nomenclature shall not be repeated. The coating requirement of the type VI, class 3 label shall apply.

* 3.4 Design. The shirt design shall be semi-form fitting, with a five-button front, princess lines, shoulder loops, ornamental sleeve cuffs (type I), convertible collars, vest-type front, and an elastic loop for closing the collar. The type II shirts shall be the same body design except with long sleeves and button through cuffs (see figures 1 through 5). The figures show the general style of the short and long sleeve shirts and are furnished for information purposes only.

3.5 Patterns. Standard patterns will be furnished by the Government (see 6.5) and, unless otherwise indicated, provide seam allowance of 1/4 inch for the collar, collar stand, cuffs, and sleeve plackets and 3/8 inch for all other seams. The standard patterns shall not be altered in any way and are to be used as a guide for cutting the contractor's working patterns. The standard patterns show size, seam allowances, directional lines for cutting and are marked or notched for proper placement and assembly of the component parts. The working patterns shall be identical to the standard patterns.

3.5.1 Pattern parts. The components of the shirts shall be cut from the materials, as specified, in accordance with the pattern parts indicated in table I.

TABLE I. List of pattern parts.

Material	Pattern nomenclature	Cut parts
Basic material (see 3.3.1)	Front	2
	Side front	2
	Center back	1
	Side back	2
	Sleeve (type I)	2
	Sleeve (type II)	2
	Collar	2
	Collar stand	2
	Cuffs (type II)	4
	Sleeve binding (type II)	2
	Shoulder loop	4
Interlining (see 3.3.2)	Shoulder loop	2
	Front	2
	Collar	1
	Collar stand	1
	Cuffs (type II)	2
Marker	Front buttonholes	

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3.6 Construction. The construction of the shirts shall conform in all respects to the requirements specified in table II and herein. Should any inconsistencies exist between the requirements of this document and the figures, the requirements of this document shall govern.

3.6.1 Stitches, seams, and stitching. Stitches, seams, and stitching types, as specified in table II, shall conform to FED-STD-751. When two or more methods of seams or stitches are given for the same operation, any one may be used. The looper (underthread), of stitch type 401, shall be on the inside of the shirt. The guides and knives on machines producing stitch types 515, 516, 517, 518, and 519 shall be set to trim only the ravelled ends of the fabric. If a knife is used on the overedging machine, only the ravelled ends shall be trimmed off; the edge of the fabric shall not be cut off. The trimming shall not exceed 1/16 inch. Seam allowances shall be maintained. Seams shall be sewn so that there will be no raw edges, run-offs, twists, pleats, or puckers. All seams shall start and finish evenly. Thread tension shall be maintained (see 6.6) so that there is no tight or loose stitching.

3.6.1.1 Type 301 stitching. Ends of all stitching shall be backstitched or overstitched not less than 1/4 inch except where ends are turned under or caught in other seams or stitching. 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.

3.6.1.2 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 sewing, the stitching shall be repaired by restarting the stitching a minimum of 1/4 inch back of the end of the stitching. 1/

b. Except for prestitching, thread breaks, or two or more consecutively skipped or run-off stitches noted during inspection of the item shall be repaired by overstitching. The stitching shall start a minimum of 1/4 inch in 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. 1/

1/ When making the above repairs, the ends of the stitching are not required to be backstitched.

3.6.1.3 Types 401, 502, 503, 504, 515, 516, 517, 518, and 519 stitching. Thread tension shall be maintained so that there will be no loose or excessively tight stitching resulting in puckering of the materials sewn. Type 301 stitching may be used to repair type 401 stitching.

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TABLE II. Manufacturing operations.

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
1.	<p><u>Cutting.</u></p> <p>a. Cut the shirt in strict accordance with patterns furnished by the Government.</p> <p>b. Cut all materials in the direction indicated by directional lines on the pattern. The straight of the material shall indicate the warp direction.</p> <p>c. Cut each shirt from one piece of basic material, except the under collar, underply of collar stand, underply of cuffs, and underply of shoulder loops may be cut from ends, but when cut from ends, the parts shall match the shade of the shirt. The bias binding for the armhole cuff opening may be strip cut and placed on rolls. The bias binding for the armhole cuff opening may be strip cut and placed on rolls. The binding shall be cut of sufficient width (1-5/8 inch) to finish 3/8 to 1/2 inch wide.</p> <p>d. Cut 1/8 to 3/16 inch wide elastic, 2-3/4 inches long for neck closure loop.</p> <p>e. Cut the polyester fiber interlining in accordance with directional lines on patterns.</p>					

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
2.	<p><u>Replacement of defective or damaged parts.</u></p> <p>a. Any part that contains a hole or any weakening defect such as a smash, multiple floats, or a loose slub that might develop into a hole shall be replaced at the time of cutting.</p> <p>b. Any part that contains workmanship damage such as a hole, a scissor or knife cut, a tear, a mend, a burn, or needle chews that might develop into a hole shall be replaced during the manufacturing process.</p>					
3.	<p><u>Component marking.</u></p> <p>Mark, ticket or bundle all component parts cut from one piece of basic material, except those parts cut from ends, to insure uniform shade and size throughout the shirt. Parts cut from ends shall be identified for size (see 3.7.1).</p>					
4.	<p><u>Attach or apply labels.</u></p> <p>a. See Operations 12.b, 12.f, and 12.g for application of size label.</p>					

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
4.	<u>Attach or apply labels.</u> - Contd					
	b. Position identification and instruction labels or combination identification and instruction label on left facing and stitch on all four sides so that in the finished shirt the label shall be midway between the seamed front edge of shirt and back edge of facing. The bottom edge of label shall be approximately 3 inches from finished bottom edge of shirt. The label shall not be visible from outside of shirt.	301	LSbj-1	8-14	70-2	70-2
5.	<u>Make collar.</u>					
	Finished appearance. The completed collar shall finish smooth and flat without distortion. Edges shall be uniformly even. The seams shall finish at the edges of the collar. The points and seamed edges shall be neatly and completely forced out. The points shall be uniform in length.					
	a. The collar and collar stand each shall be made of two plies of basic material and one ply of interlining.					
	b. Seam interlining and top collar together 1/8 inch from each edge. Trim excess interlining along edges, where necessary.	301	SSa-1 (each edge)	12-14	70-2	70-2

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
5.	<u>Make collar.</u> - Contd					
	c. Seam interlining and top collar stand 1/8 inch from top and lower edge. Trim excess interlining along edges, where necessary.	301	SSa-1	12-14	70-2	70-2
	d. Position under collar stand on outside of under collar with notches matching and join together at the lower edge with a 1/4-inch seam.	301	LSq-2(a)	12-14	70-2	70-2
	e. Turn under collar stand and stitch 1/16 inch from raised edge.	301	LSq-2(b)	12-14	70-2	70-2
	f. Position top collar stand on outside of top collar with notches matching and join together at lower edge with a 1/4-inch seam.	301	LSq-2(a)	12-14	70-2	70-2
	g. Turn top collar stand and stitch 1/16 inch from raised edge.	301	LSq-2(b)	12-14	70-2	70-2
	h. Position under collar and top collar face to face with top notches matching and edges even and seam together along top and side edges with 1/4-inch seam.	301	SSe-2(a)	12-14	70-2	70-2
	i. Trim points and turn collar on a heated collar point turning and pressing machine, working out the points completely and working seam line to edge.					
	j. Edge stitch the upper and side edges of the collar uniformly, 1/4 inch from seamed edges.	301	SSe-2(b)	12-14	70-2	70-2

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
5.	<u>Make collar.</u> - Contd					
	k. Press collar smooth and flat (see Operation 24).					
	OR					
	l. Seam the three plies together 1/4 inch from top and side edges, with the interlining on top and all edges even.	301	SSe-1(a)	12-14	70-2	70-2
	m. The interlining may be stitched to the underply of collar 1/8 inch from outer edges before joining to the top ply of collar.	301	SSa-1	12-14	70-2	70-2
	n. Trim points and turn collar on a heated collar point turning and pressing machine, working out the points completely and working seam line to edge.					
	o. Edge stitch the upper and side edges of the collar uniformly 1/4 inch from seamed edges.	301	SSe-2(b)	12-14	70-2	70-2
	p. Press collar smooth and flat (see Operation 24).					
	OR					
	q. The collar leaf may be basted along the seamed edge.					

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
5.	<u>Make collar.</u> - Contd					
	r. Position the raw edge of collar between the top and under collar stand with interlining as indicated by notches on pattern and stitch from end to end along top edge of collar stand, 3/16 to 1/4 inch from edge.	301	SSq-2(a)	12-14	70-2	70-2
	OR					
	s. The collar stand interlining may be stitched to the under collar stand 1/8 inch from the raw edges before joining to collar.	301	SSa-1	12-14	70-2	70-2
	t. Turn top and under collar stand to finish position and raise stitch 1/16 inch from turned edge.	301	SSq-2(b)	12-14	70-2	70-2
	u. Press collar smooth and flat (see Operation 24).					
6.	<u>Attach elastic loop to collar.</u>					
	Fold the elastic in half, forming a loop. Position the loop on the lower edge of the underside of the collar 1/2 inch from the right end, with the ends of the loop even with the raw edge of the collar. Stitch loop to collar 3/16 from raw edge. The finished loop shall measure 1 \pm 1/8 inch.	301	SSa-1	12-14	70-2	70-2

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
7.	<u>Attach interlining to front facing.</u>					
	a. Position the left and right front facings on their respective front interlinings with edges even and notches matching. Stitch the two plies together at the gorge, top and front bottom angled corner 1/8 inch from raw edge.	301	SSa-1	12-14	70-2	70-2
	b. Overedge stitch the shoulder and back edge of facing, catching the interlining in the stitching.	502 or 503	EFd-1	10-14	70-2	70-2
8.	<u>Assemble front and front side panels.</u>					
	Finished appearance. The fronts and side front panels shall be properly positioned and finished without pleats, puckers, or gathers.					
	a. Position front and side front panels together with notches matching, evenly distributing the fullness in the bust area, with a 1/4-inch seam allowance.	301 or 401	SSa-1	12-14	70-2	70-2
	b. Overedge stitch raw edges of front and front panel seams together.	503 or 504	EFd-1	10-14	70-2	70-2
	OR					
	c. The front and side front panel may be joined in one operation by seaming and overedge stitching the raw edges together.	515 or 516 or 517 or 518	SSa-2	10-14	70-2	70-2

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
8.	<u>Assemble front and front side panels.</u> - Contd d. Press the front and side front panel joining seams smooth and flat (see Operation 24) The seams shall be pressed toward the center front.					
9.	<u>Assemble back.</u> a. Position the left and right side back to center back with edges even and notches matching. Stitch together with 1/4-inch seam.	301 or 401	SSa-1	12-14	70-2	70-2
	b. Overedge stitch the raw edges of the back and side back seams together.	503 or 504	EFd-1	10-14	70-2	70-2
	OR c. The left and right side body may be joined to the center back by seaming and overedge stitching the raw edges together in one operation.	515 or 516 or 517 or 518	SSa-2	10-14	70-2	70-2
	d. Press the right and left back seams smooth and flat (see Operation 24). The back seams shall be pressed toward the center back.					
10.	<u>Seam shoulders.</u> a. Join back to fronts at the shoulder with 1/4-inch seam.	301 or 401	SSa-1	12-14	70-2	70-2
	b. Overedge stitch the raw edges of the shoulder seams together.	503 or 504	EFd-1	10-14	70-2	70-2
	OR					

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
10.	<u>Seam shoulders.</u> - Contd					
	c. The raw edges of the back and front seams at the shoulder may be joined by seaming and overedge stitching in one operation.	515 or 516 or 517 or 518	SSa-2	10-14	70-2	70-2
11.	<u>Mark lower front corners.</u>					
	Turn facing to the front at the notch on the bottom of the shirt with the raw edges of the bottom and angle even and stitch across the angle and bottom with 1/4-inch seam. The seam at the bottom edge shall extend the width of the facing and be in line with the bottom turn-up mark.	301	SSa-1	12-14	70-2	70-2
12.	<u>Set collar with size label.</u>					
	a. Position collar between facing and front with the lower end of collar in line with the lapel notch and with raw edge of collar and gorge even. Stitch all plies together with 1/4-inch seam along the gorge from the lapel notch up to approximately 1 inch in back of the joining seam line of collar and collar stand.	301	SSa-1	12-14	70-2	70-2
	b. Notch all plies at the end of stitching line and continue to stitch the lower (neck) edge of the under collar stand to front and back part from gorge seam to gorge seam. When used, the type VI size label shall be centered on the back part and caught in seam joining collar to shirt.	301	SSa-1	12-14	70-2	70-2

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
12.	<p><u>Set collar with size label.</u> - Contd</p> <p>c. Turn facing to the inside of fronts, working out the points and seamed edges and lapping back edge of facing on front end of bottom, turn up.</p> <p>d. Stitch the shoulder edge of facing to the shoulder seam allowance 3/16 inch from edge.</p> <p>e. Position size label at center back and stitch 1/8 to 3/16 inch from raw edge of neck area (type VI label, if applicable).</p> <p>f. Turn under lower edge of collar stand from gorge seam, lapping the folded edge on facing and fronts at the shoulder and on the back. Stitch through all plies 1/16 inch from the folded edge, catching the top of the type VI size label in the stitching.</p> <p>g. Stamp the size of the shirt on the collar stand with the marking centered on the collar stand approximately 1/4 inch from its inner edge (type IV label, if applicable).</p> <p>h. In the finished garment, the ends of the collar shall be 2-3/4 ±1/8 inches long when measured from junction point of collar and lapel.</p>	301	SSa-1	12-14	70-2	70-2
		301	SSa-1	12-14	70-2	70-2
		301	BSg-2(b) or BSj-2(b)	12-14	70-2	70-2

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
13.	<p><u>Attach pile fastener tape to shirt under the collar.</u></p> <p>Finished appearance. The application of attaching fastener tape to shirt shall not cause any distortion to the collar, interlining, or shirt, either in an open collar or buttoned collar position.</p> <p>a. The 5/8- by 3/4-inch piece of pile fastener tape shall be positioned 1/16 \pm 1/16 inch above the collar gorge seam at the point where the under collar stand begins. The pile fastener tape shall be stitched on all four sides 1/16 inch from the edge through all plies of the shirt.</p> <p>NOTE: The 3/4 inch side of the pile fastener tape shall be parallel to the gorge seam.</p>	301	SSa-1	12-14	70-2	70-2
14.	<p><u>Make ornamental sleeve cuffs (type I).</u></p> <p>Finished appearance. The cuffs shall finish smooth and flat without distortion and shall be uniform in shape and size. The edge stitching shall be of uniform gage.</p> <p>a. Turn under (to the right side) the lower raw edge of the sleeve 1/2 inch, forming the finished curve and pointed edge in accordance with the shape of the pattern. Press smooth and flat, creasing the edge (see Operation 24).</p>					

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
14.	<u>Make ornamental sleeve cuffs (type I).</u> - Contd					
	b. Fold cuff back to the right side against body of the sleeve at the folding notches, with the pointed end of the cuff face up and stitch the cuff through all plies, 1/4 inch from the upper folded edge, catching the turned under portion in the stitching.	301	SSa-1	12-14	70-2	70-2
15.	<u>Make cuffs (type II).</u>					
	Finished appearance. The cuffs shall finish smooth and flat without distortion and shall be uniform in shape and size. The edge stitching shall be of uniform gage. The cuffs shall finish 2-1/4 \pm 1/8 inches wide and shall have rounded lower corners. The buttonholes shall be clean cut, well made and correctly positioned, and the stitching shall be securely caught in the fabric with the purling on the outside and no loose stitching.					
	a. The cuffs shall be made of two plies of basic material and one ply of interlining.					
	b. Position the interlining on the inside of the top ply of the cuff with the side and bottom edges even and stitch together 1/8 inch from raw edge.	301	SSa-1	12-14	70-2	70-2

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
15.	<u>Make cuffs (type II).</u> - Contd					
	c. Fold the top raw edge of the outer ply of cuff over and even with top edge of interlining and single stitch, 1/4 to 5/16 inch from folded edge, catching interlining in the stitching.	301 or 401	SSbc-1	12-14	70-2	70-2
	d. Stitch the top and under ply of the cuff and interlining together along the bottom and side edges with a 1/4-inch seam.	301 or 401	SSe-2(a)	12-14	70-2	70-2
	e. Turn the cuff completely and edge stitch uniformly 1/4 inch from the seamed edge. The edge stitching shall finish 1/2 inch from the top edge of finished cuff. The edge stitching may taper to edge of cuffs at ends of stitching and need not be backstitched.	301	SSe-2(b)	12-14	70-2	70-2
	f. Make a horizontal 9/16 \pm 1/16 inch long straight-cut, purl or whip type buttonhole in the center of each cuff (1/4 inch off center tolerance) with the end of the buttonhole 1/2 \pm 1/8 inch from the edge. The purl side, if applicable, of the buttonhole shall face toward the outside of the cuff.	304 or 304	purl or whip per button- hole in- cluding tack	42-52 per button- hole in- cluding tack or 42-52	40-4 or 40-6 or 70-2	80-2 or 70-2
	g. Press cuffs (see Operation 24).					

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
16.	<p><u>Make and attach shoulder loops.</u></p> <p>Finished appearance. The shoulder loops shall finish smooth and flat and uniform in construction and placement. The buttonholes shall be clean cut and correctly positioned. The shoulder loops shall measure 1-3/4 to 1-15/16 inches wide at the armhole seam tapering to a width of 1-7/16 to 1-9/16 inches at pointed end.</p> <p>a. Join the three plies of each shoulder loop along the sides and the point with 1/4-inch seam.</p> <p>b. Turn each shoulder loop. Work out the edges and the point and edge stitch along sides and point 1/4 inch from edge.</p> <p>c. Locate and make a horizontal straight cut, purl or whip type, buttonhole barred one each end, in accordance with the pattern marks, in each shoulder loop. The end of the buttonhole shall be 1/2 \pm 1/8 inch from pointed edge of the shoulder loop. The buttonhole opening shall be 1/2 \pm 1/16 inch long. The purl side, if applicable, of the buttonhole shall face toward the outside of the shoulder loop.</p> <p>d. Press the shoulder loops flat (see Operation 24).</p>	<p>301 or 401</p> <p>301</p> <p>304</p> <p>or 304</p>	<p>SSe-2(a)</p> <p>SSe-2(b)</p> <p>purl</p> <p>or whip</p>	<p>12-14</p> <p>10-14</p> <p>42-52 per buttonhole including tack or 42-52 per buttonhole including tack</p>	<p>70-2</p> <p>70-2</p> <p>40-4 or 40-6</p> <p>or 70-2</p>	<p>70-2</p> <p>70-2</p> <p>80-2</p> <p>or 70-2</p>

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
16.	<u>Make and attach shoulder loops.</u> - Contd					
	e. Trim and measure the shoulder loops to fit the shoulders and match with the shirt. Center the shoulder loops on the shoulder seams so that the pointed end will extend to within 1/8 to 1/4 inch of the collar seam. Stitch each shoulder loop to the shirt 1/16 to 3/16 inch from the armhole edge. The shoulder loops will be paired. They will be attached by sewing left and right shoulder loops to corresponding shoulder.	301	SSa-1	12-14	70-2	70-2
17.	<u>Set sleeve and overedge stitch.</u> Finished appearance. The sleeves shall be set without distortion.					
	a. Join sleeves to shirt around the entire armhole with a 1/4-inch seam, matching the notches.	301 or 401	SSa-1	12-14	70-2	70-2
	b. Overedge stitch the raw edges of the sleeve and armhole together.	504	EFd-1	10-14	70-2	70-2
	OR					
	c. The sleeves may be joined to the shirt by seaming and over-edge stitching the raw edges together in one operation.	515 or 516 or 517 or 518	SSa-2	10-14	70-2	70-2

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
18.	<u>Close sleeves and sides.</u>					
	a. Join fronts and back at the sides and close the sleeve underarm with a 3/8-inch seam, with the armhole seam flat against the sleeve.	301 or 401	SSa-1	12-14	70-2	70-2
	b. Overedge stitch the raw edges of the side and sleeve seam allowance.	504	EFd-1	10-14	70-2	70-2
	OR					
	c. The raw edges of the sleeve and side seam allowance may be joined by seaming and overedge stitching in one operation.	515 or 516 or 517 or 518	SSa-1	10-14	70-2	70-2
	d. Turn type I sleeve allowance in Operation 19.b toward the back and place a bartack across the seam allowance at the end of the sleeve joining seam. The bartack shall be 1/4 inch long and 1/16 to 1/8 inch from the finished folded edge of the sleeve hem.	301 or bartack		12-14 28 per bartack	70-2	70-2
19.	<u>Bind sleeve opening (type II).</u>					
	a. Bind the raw edges of the sleeve at the sleeve opening with a strip of basic material, with the raw edges of the binding turned under and caught in the stitching 1/16 inch from the inner folded edges. The binding shall finish 1/2 to 3/8 inch wide on inside and outside of the sleeve.	301	BSc-1	12-14	70-2	70-2

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
19.	<u>Bind sleeve opening</u> (type II). - Contd					
	b. Turn binding to inside of sleeve and bartack diagonally through binding only. An automatic tack may be used.	bartack		28 per bartack	70-2	70-2
20.	<u>Join cuffs to sleeve (type II).</u> Finished appearance. The finished cuffs shall be uniform in width without raw edges, distortion, twist and puckers. On the finished shirt, the cuffs shall be 2-1/4 \pm 1/8 inches wide.					
	a. Position the underply of the cuff on the lower inside end of the sleeve with edges even. Join sleeve and cuff together with 3/8 inch seam, turning the sleeve closing seam toward the back and catching the sleeve seam in the stitching. The bound edge of the sleeve opening shall be turned to the inside at the buttonhole end of cuff and caught in the stitching.	301 or 401	LSg-2(a)	12-14	70-	70-2
	b. Turn cuff on the outside with the hemmed edge lapped on the outside of the sleeve and stitch the top ply of the cuff to the sleeve 1/16 inch from the finished edge.					

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
21.	<p><u>Overedge and blindstitch bottom of shirt.</u></p> <p>Finished appearance. The finished bottom edge of the shirt shall be uniformly overedged then blindstitched without puckers or gathers. The bottom turn up shall be uniform in width. The side front seams shall be pressed toward the front and the side back seams toward the center back (see Operations 8.d and 9.d).</p> <p>a. Overedge stitch the raw edges of the bottom edge of the shirt with the side seams turned toward the back.</p> <p>b. Mark shirt 1-1/4 inches from the serged edge for bottom turn up.</p> <p>c. Blindstitch the overedged bottom edge to the body of the shirt, catching the facings in the stitching. The blindstitch shall run onto the facing not less than 1/4 inch nor more than 1 inch.</p>	<p>503 or 504</p> <p>103 or 106</p>	EFd-1	<p>10-14</p> <p>3-4</p>	70-2	70-2
22.	<p><u>Make buttonholes.</u></p> <p>Finished appearance. The buttonholes shall be clean cut, well made and correctly positioned. The stitching shall be securely caught in the fabric. The buttonholes shall be in vertical alignment with each other.</p>					

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
22.	<p><u>Make buttonholes.</u> - Contd</p> <p>a. Mark the right front in accordance with pattern marker for the location in five equally spaced buttonholes 3/4 inch from the front edge.</p> <p>b. Make a vertical 9/16 \pm 1/16 inch long straight type buttonhole, tacked at each end, at each mark on the front.</p> <p>c. The buttonholes shall be made to fit 19-line sewing hole buttons. The purling of the buttonholes shall be on the outside of the shirt.</p>	304	whip	42-46 per buttonhole including tack	70-2	70-2
23.	<p><u>Clean shirts.</u></p> <p>a. Trim all thread ends and remove loose threads from shirts. Remove all spots and stains. The shirt shall be free of residual fiber particles, lint and dust, or other foreign substances.</p> <p>b. Remove all shade tickets.</p>					

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
24.	<p><u>Pressing.</u></p> <p>Press the bottom of shirt, side seams, and underarm seams on a hot head pressing machine or with a heated iron at a permanent press (moderate) setting.</p> <p>NOTE: The use of a steam inflated bag type pressing machine is prohibited. The hot head pressing machine shall be equipped with controls for accurate temperature (350 to 370°F), time (minimum 10 seconds), and pressure (100 psi gauge).</p>					
25.	<p><u>Mark for buttons.</u></p> <p>Finished appearance. The location of the buttons shall be marked so that in the finished shirt, each button shall engage its corresponding buttonhole or loop when the shirt is buttoned. The position of the top button shall provide a smooth closure, with the ends of the collar at the neck meeting without overlapping or spreading apart.</p> <p>a. Mark the left front for the location of five 19-line sewing hole buttons thru the center of the buttonholes 7/8 inch from the front edge.</p> <p>b. Mark the top left front panel (under the collar) below the gorge seam line and 1/2 inch from left end of collar, for one 17-line button, to properly engage the closure loop.</p>					

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
26.	<p><u>Sew on buttons.</u></p> <p>Finished appearance. The buttons shall be securely sewn with the ends of the stitching securely tacked and properly aligned with the buttonholes to secure a smooth and complete closure without bulging or misalignment.</p> <p>a. Sew a 19-line sewing hole button at each mark on the left front. The buttons shall be sewn through the front, interlining and facing.</p> <p>b. Sew one 17-line sewing hole button at the mark on the top left front. Sew one 17-line sewing hole button at the mark on the top right front, located adjacent to the elastic loop. The buttons shall be sewn with a back reinforced stay consisting of basic or alternate material (see NOTE). Position the buttons with button stay between the front and facing. The stitching shall not penetrate the facing material. The buttons shall be sewn through the front and interlining only.</p> <p>NOTE: A 1/2 inch diameter piece or a 1-1/2 inch square piece of a suitable commercial nonwoven material or the basic fabric shall be used to reinforce the top buttons only.</p>	<p>301 or 101</p> <p>301 or 101</p>		<p>14-16 per button</p> <p>14-16 per button</p>	70-2	70-2

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TABLE II. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
26.	<u>Sew on buttons.</u> - Contd					
	c. Type II only. Sew two 19-line sewing hole buttons on each cuff. The first button shall correspond to the button-hole and be 3/8 inch from the back end of cuff and the second button 3/4 inch from the center of the first button placement.	301 or 101		14-16 per button	70-2	70-2
	d. Sew 19-line button on each shoulder. The buttons shall be securely sewn and aligned with the center of the corresponding buttonholes in the shoulder loops.	301 or 101		14-16 per button	70-2	70-2
27.	<u>Touch-up pressing and closing shirt.</u>					
	a. Examine for complete shirt pressing.					
	b. When required, touch-up fronts, backs, cuffs, bottom hems and collars, before folding and packaging, with a heated iron at a permanent press (moderate) setting.					
	c. Button shirt fully.					

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 the stitching.

3.6.1.5 Thread ends. All thread ends shall be trimmed to 1/4 inch maximum length.

3.6.2 Bartacks. Bartacks shall be 1/4 \pm 1/16 inch long, 1/8 \pm 1/32 inch wide, and shall contain 28 stitches (minimum). Bartacks shall be free from thread breaks and loose stitching.

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

* 3.6.4 End item seam appearance. The appearance rating of the seams and stitching of the finished shirt shall be 4.0 or greater when tested as specified in 4.5. This requirement shall be applicable to all seams including the collar, shoulder loops, armholes, side and underarm seams, side front seam, side back seam, hem, type I ornamental sleeve cuffs and the type II and type III cuffs and plackets.

3.6.5 Buttonholes. The buttonholes shall be straight-cut, purl, or whip type, and the finished cut length shall be $1/2 \pm 1/16$ to $9/16 \pm 1/16$ inch long. The stitching shall be securely caught in the fabric and the ends shall be securely tacked. When a purl-type buttonhole is used, the purling shall be on the outside of the shirt, face toward the outside of the cuffs and outside of the shoulder loops. All loose thread ends shall be trimmed or fused to within $1/8$ inch of the tack.

3.6.6 Repairs. Repairs such as mends, darns, patches, or splices are not permitted on the shirt.

3.7 Manufacturing operation requirements. The shirt shall be manufactured in accordance with operation 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 shirt.

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

a. Corrosive metal fastening devices. (Metal devices shall not be used on the lining material.)

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.

d. Any marking medium which would tend to leave a permanent mark.

3.7.1.1 Ink pad numbering machine, rubber stamp or pencil. The use of ink pad numbering machine, rubber stamp, or pencil will be acceptable provided the numbers do not show through the outside of the shirt and wherever possible are covered by the seam allowance.

3.8 Finished measurements. The finished measurements shall conform to table III.

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TABLE III. Finished measurements (inches).

Size	Collar length	1/2 Bust (regular sizes)	1/2 Bust (plus sizes)	Back length			Type I Sleeve length			Type II Sleeve length		
				S	R	L	S	R	L	S	R	L
6	13-3/4	17-1/4	17-5/8	21-1/4	22-1/2	23-3/4	3-7/8	4-3/8	4-7/8	17	18	19
8	14	17-3/4	18-1/8	21-3/8	22-5/8	23-7/8	3-7/8	4-3/8	4-7/8	17	18	19
10	14-1/4	18-1/4	18-5/8	21-1/2	22-3/4	24	3-7/8	4-3/8	4-7/8	17	18	19
12	14-1/2	19	19-3/8	21-5/8	22-7/8	24-1/8	3-7/8	4-3/8	4-7/8	17	18	19
14	14-3/4	19-3/4	20-1/8	21-3/4	23	24-1/4	3-7/8	4-3/8	4-7/8	17	18	19
16	15	20-1/2	20-7/8	21-7/8	23-1/8	24-3/8	3-7/8	4-3/8	4-7/8	17	18	19
18	15-1/4	21-1/2	21-7/8	22	23-1/4	24-1/2	3-7/8	4-3/8	4-7/8	17	18	19
20	15-1/2	22-1/2	22-7/8	22-1/8	23-3/8	24-5/8	3-7/8	4-3/8	4-7/8	17	18	19
22	15-3/4	23-1/2	23-7/8	22-1/4	23-1/2	24-3/4	3-7/8	4-3/8	4-7/8	17	18	19
Tolerance	+1/4 -1/8	+3/8	+3/8	+1/2	+1/2	+1/2	+1/4	+1/4	+1/4	+1/4	+1/4	+1/4

* 3.9.1 Methods of measuring. Shirts shall be buttoned and laid smooth and flat and measured as follows:

Collar length - Measure along inside from collar end to collar end at the gorge.

1/2 bust - Measure across front of shirt from folded edge to folded edge, 1/4 inch below the seam where the sleeve joins the side body. The blouse shall be held in a slightly taut position when the measurement is taken.

Back length - Measure from lower edge of collarstand to bottom edge of shirt.

Sleeve length - Measure along underarm seam, from the base of armhole seamline to the bottom edge of cuff.

3.9 Workmanship. The finished shirt shall conform to the quality of product established by this specification. As a final step in the contractor's production control plan, before formation of a lot, each shirt shall be examined, buttoned, pressed and laid out flat on a table prior to folding for packaging. A shirt containing a selected defect shall not be included in the end item lot. Selected defects are those defects indicated by an asterisk (*) in table VI. The occurrence of defects shall not exceed the acceptable quality level.

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4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements (examinations and tests) as specified herein. Except as otherwise specified in the contract or purchase order, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in this specification where such inspections are deemed necessary to ensure 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 a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the contractor of the responsibility of ensuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations, is an acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to accept defective material.

4.1.2 Certificates of compliance. When certificates of compliance are submitted, the Government reserves the right to check test such items to determine the reliability of certification.

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

- a. First article inspection (see 4.3).
- b. Quality conformance inspection (see 4.4).

4.3 First article inspection. When required (see 3.1 and 6.2), the first article shall be inspected for the defects listed in 4.4.3 and 4.4.4. The presence of any defect shall be cause for rejection of the first article.

4.4 Quality conformance inspection. Unless otherwise specified, sampling for inspection shall be performed in accordance with MIL-STD-105 and the acceptance criteria, as specified in the contract or purchase order, shall be binding.

4.4.1 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 specification or applicable purchase document.

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4.4.1.1 Component testing. In addition to any testing required by 4.4.1, the component listed in table IV shall be tested for the characteristic noted. The methods of testing specified in table IV shall be followed. The lot and sample sizes shall be as follows:

<u>Lot size</u>	<u>Sample size</u>
800 or less	2
801 to 22,000 inclusive	3
22,001 and over	5

The lot shall be unacceptable if one or more sample units fail to meet any test requirement specified. The lot size units and sample units shall be as follows:

<u>Component</u>	<u>Lot size unit</u>	<u>Sample unit</u>
Thread	Spool	3 each

TABLE IV. Component test.

Component	Characteristic	Requirement paragraph	Test method
Thread	Shrinkage	3.3.4	ASTM D 204 1/

1/ Shrinkage in dry heat shall not apply.

4.4.2 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.

4.4.3 End item visual examination. The end item shall be examined for the defects listed in table V. The lot size shall be expressed in units of shirts. The sample unit shall be one shirt. The inspection level shall be III and the acceptable quality level (AQL), expressed in terms of defects per hundred units (dhu) shall be 1.5 dhu for major defects, 6.5 dhu for major and minor A (combined) defects, and 15.0 dhu for total (major, minor A and minor B combined) defects. If one or more of the major defects found in the sample is an asterisk (*) defect, it shall be cause for rejection of the lot as listed below.

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<u>Lot size</u>	<u>Sample size</u>	<u>Maximum number of selected (*) defects acceptable in sample</u>
Up to 90	20	0
91 thru 150	32	0
151 thru 280	50	0
281 thru 500	80	0
501 thru 1200	125	1
1201 thru 3200	200	1
3201 thru 10,000	315	2
10,001 thru 35,000	500	3
35,001 and over	800	5

4.4.4 End item dimensional examination. Shirts shall be examined for conformance to the dimensions specified in table III. Any dimensions deviating from the specified requirement and sleeves uneven in length by 1/4 inch or more shall be classified as defects. The lot size shall be expressed in units of shirts. The sample unit shall be one shirt. The inspection level shall be S-3 and the AQL shall be 2.5 dhu.

4.4.5 Inspection of packaging. An examination shall be made to determine that the preservation, packing, and marking comply with section 5 requirements of this specification. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully packaged except that it need not be sealed. Defects of closure listed below shall be examined on shipping containers fully packaged. The lot size shall be the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 and the AQL shall be 2.5 dhu.

<u>Examine</u>	<u>Defect</u>
Marking (exterior and interior)	Omitted; incorrect; illegible; of improper size, location, sequence or method of application.
Materials	Any component missing, damaged, or not as specified.
Workmanship	Inadequate application of components, such as: incomplete closure of container flaps, loose strapping, improper taping or improper adhesive application, inadequate stapling. Bulged or distorted container.
Content	Number of shirts per container is more or less than specified. <u>1/</u>

1/ For this defect, one shipping container shall be examined.

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TABLE V. End item visual defects.

	Defect	Major	Minor A	Minor B
I.	<u>Material defect and damage</u>			
	a. Any hole, cut, tear, needle chew, burn, mend, darn, patch, multiple float, loose or unsightly slub or shade bar:			
	(1) On outside.	*		
	(2) On inside.		201	
	b. Permanent crease in cloth (when caught in stitching).	101		
II.	<u>Shaded part</u>			
	a. Outside part, except collar stand, shaded.	102		
	b. Top collar stand, or under collar stand badly shaded.			301
III.	<u>Cleanliness</u>			
	a. Any spot or stain clearly noticeable:			
	(1) On outside.	103		
	(2) On inside.			302
	b. One or more marking tickets not removed.			303
	c. Any marking clearly visible on outside.	104		
	d. Thread ends not trimmed, or loose threads not removed.			304
	e. Visible basting thread not removed.			305
IV.	<u>Cutting</u>			
	a. Any component part not cut in conformance with directional lines indicated on pattern or not in accordance with specification requirements.	105		

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TABLE V. End item visual defects. - Continued

	Defect	Major	Minor A	Minor B
V.	<u>Component and assembly</u>			
	a. Any component part or required operation omitted or added (unless otherwise classified herein).	106		
	b. Any operation not performed as specified (unless otherwise classified herein).			306
VI.	<u>Pressing</u>			
	a. Omitted.		202	
	b. Shirt burned or scorched.	107		
	c. Gloss, wrinkles, or creases.			307
	d. Edge bulky (not pressed solidly).			308
	e. Sleeve center creased.			309
	f. One or more darts or seams not pressed in the direction specified.			310
	g. Cuff not pressed evenly.			311
VII.	<u>Seams and stitchings</u>			
	a. Accuracy of seaming:			
	(1) Seams twisted, puckered or pleated (see 4.5).	108		
	(2) Any part of shirt caught in any unrelated operation or stitching:			
	(a) Caught in or up to, and including, 1/4 inch of stitching.		203	
	(b) Caught in or more than 1/4 inch of stitching.	109		
	(3) Stitching overlapping end of thread break less than 1/2 inch.			312

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TABLE V. End item visual defects. - Continued

	Defect	Major	Minor A	Minor B
VII.	<u>Seams and stitchings</u> - Contd			
	(4) End of stitching when not caught in other seams or stitching backtacked less than 1/4 inch.			313
	(5) Ends of a continuous line of stitching overlapped less than 1/2 inch on all continuous stitching.			314
	(6) Raw edge more than 1/4 inch long.			315
	b. Gage of stitching:			
	(1) Irregular, i.e., unevenly gaged or corresponding stitchings not uniform (to be scored only when condition exists along major portion of seam).		204	
	(2) Beyond range of width specified or varying more than 1/16 inch when no range is specified.			316
	c. Stitches broken or missing (except button-holes):			
	(1) All stitching except overedging:			
	(a) Up to 1/4 inch inclusive.			317
	(b) More than 1/4 but less than 1/2 inch inclusive.		205	
	(c) More than 1/2 inch.	110		
	(2) On overedging:			
	(a) 1 inch or more.			318
	d. Skipped stitches or runoffs:			
	(1) More than 1/4 inch but less than 1/2 inch long.			319
	(2) More than 1/2 inch long.		206	

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TABLE V. End item visual defects. - Continued

	Defect	Major	Minor A	Minor B
VII.	<u>Seams and stitchings</u> - Contd			
	e. Seam and stitch type:			
	(1) Not specified seam or stitch type.		207	
	f. Stitches per inch (to be scored only when condition exists on major portion of seam or stitching):			
	(1) Less than the minimum or more than the maximum specified.			320
	g. Stitch tension (except buttonholes):			
	(1) Loose tension resulting in a loose seam.	111		
	(2) Loose tension (exposed loops of top or bottom threads) more than 1/2 inch in length.			321
	(3) Tight tension (stitches break when strain is applied to seam or stitching).		208	
	h. Blindstitching on bottom turn-up shows on outside, affecting appearance.		209	
VIII.	<u>Buttonholes</u>			
	a. One or more omitted or added.	112		
	b. Opening in any one of the lower five buttonholes less than 23/32 inch or more than 25/32 inch from front edge of shirt.		210	
	c. One or more slanted.		211	
	d. Buttonholes positioned from top to bottom different from buttonhole marker (each size must be checked).	*		
	e. One or more of the five buttonholes positioned horizontally.			322

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TABLE V. End item visual defects. - Continued

	Defect	Major	Minor A	Minor B
VIII.	<u>Buttonholes</u> - Contd			
	f. The five buttonholes unequally spaced by more than 1/4 inch.			323
	g. Stitches not securely caught in fabric (stitches pull away from fabric).	113		
	h. Two or more uncut warp yarns in button-hole (not caught in overcast stitching).		212	
	i. Two or more broken stitches or continuous skipped stitches in one or more buttonholes.		213	
	j. One or more broken stitches or continuous skipped stitches in one or more buttonholes.			324
	k. Loose stitch tension.			325
	l. Ragged edge in one or more.			326
	m. Not specified type or uncut.			327
	n. Tacking omitted on end.		214	
IX.	<u>Buttons</u>			
	a. One or more buttons missing, broken or malformed.	114		
	b. Not specified size, type or color.		215	
	c. Hand sewn button tacked off with less than two stitches.			328
	d. Front buttons not sewn through facing or insecurely sewn.		216	
	e. Collar button sewn through facing.		217	
	f. Collar button misplaced more than $\pm 1/8$ inch.		218	

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TABLE V. End item visual defects. - Continued

	Defect	Major	Minor A	Minor B
IX.	<u>Buttons</u> - Contd			
	g. Collar button not wrapped (shanked).			329
	h. Buttons not aligned with buttonholes.		219	
	i. Stitches not locked at end of cycle (tug at loose end of thread to determine if it will ravel).		220	
X.	<u>Labels or marking</u>			
	a. Size label:			
	(1) Missing, incorrect, illegible, not completely on top collarstand or strike through.	115		
	(2) Horizontally off center by more than 1/4 inch or vertically off center by more than 1/8 inch (type IV label).			330
	(3) When stitched, the top of label not completely caught in seam.		221	
	b. Identification and instruction labels (or combination label, if applicable):			
	(1) Missing, incorrect, or illegible.		222	
	(2) Not positioned on lower left facing.		223	
	(3) Bottom of label positioned less than 1/4 inch from back edge of facing.			331
	(4) Right side of label less than 2-1/2 inches or more than 3-1/2 inches from finished shirt bottom.			332
	(5) When stitched, the top of label not completely caught in seam.		224	

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TABLE V. End item visual defects. - Continued

	Defect	Major	Minor A	Minor B
XI.	<u>Collar, lapel, and front closure</u>			
	a. Not uniform in size or shape, any point varying:			
	(1) More than 3/8 inch with corresponding point on matching part.	116		
	(2) 1/4 inch up to and including 3/8 inch with corresponding point on matching part.		225	
	b. Collar point uneven in length by:			
	(1) 1/8 inch up to and including 1/4 inch.			333
	(2) More than 1/4 inch up to and including 3/8 inch.		226	
	(3) More than 3/8 inch.	117		
	c. Twisted, not smooth, too full, short or tight causing collar to turn out.	118		
	d. Collar point not properly forced out.	119		
	e. Facing/front edges not worked to the seam line (having folds 1/16 inch or more on inside or outside).		227	
	f. Under collar exposed beyond edge of top collar for a distance of more than 1/2 inch.		228	
	g. Stitching joining top collar interlining visible on outside of collar.	120		
	h. Top end of either facing not securely caught in seam allowance.		229	
	i. Ends of collar overlapping more than 3/16 inch when shirt is buttoned and neck closure loop is hooked.		230	

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TABLE V. End item visual defects. - Continued

	Defect	Major	Minor A	Minor B
XI.	<u>Collar, lapel, and front closure</u> - Contd			
	j. Either facing does not lie flat on front in the area between second button and edge of shoulder seam allowance.			334
	k. Edge of collar not properly forced out, i.e., having a fold of:			
	(1) 1/16 inch up to and including 1/8 inch in depth.			335
	(2) More than 1/8 inch in depth.		231	
XII.	<u>Collar elastic loop</u>			
	a. Missing.	121		
	b. Misplaced, i.e., not inserted in gorge seam line.	122		
	c. Distance from right end of collar more than 5/8 inch or less than 3/8 inch.		232	
	d. Loop opening more than 1-1/8 inches or less than 7/8 inches.		233	
	e. Not securely attached.			336
XIII.	<u>Pile fastener tape</u>			
	a. Missing (one or both sides).	123		
	b. Misplaced 1/4 inch or more.	124		
	c. Not stitched on all four sides.	125		
	d. Less than specified size.		234	
XIV.	<u>Sleeve and cuffs</u>			
	a. Sleeve setting seam at underarm staggered more than 1/4 inch (measured from center of seam to center of seam).			337

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TABLE V. End item visual defects. - Continued

	Defect	Major	Minor A	Minor B
XIV.	<u>Sleeve and cuffs</u> - Contd			
	b. Sleeve setting stitching irregular.		235	
	c. Width of cuff less than 2-1/8 inches or more than 2-3/8 inches wide (type II shirt).			338
	d. Cuff twisted.		236	
	e. Cuff not uniform in width.		237	
	f. Bottom edge of cuff at underarm seam, uneven by 1/16 inch or more.		238	
* XV.	<u>Bartack or tack</u>			
	One or more:			
	a. Missing, insecure, misplaced, not specified size or type, or not serving intended purpose:			
	Bartack for reinforcement.			339
	b. Loose stitch tension.			340
XVI.	<u>Sears</u>			
	a. Side sears not turned toward back of shirt at hem or bottom of sleeve or sleeve setting seam not turned toward sleeve.			341
	b. Sleeves reversed.	126		
XVII.	<u>Shoulder loops</u>			
	a. Upper side of shoulder loop full or twisted.		239	
	b. Poorly shaped.		240	
	c. Misplaced so that it will not lie flat when buttoned, causing bulge or twist on shoulder loop.		241	

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TABLE V. End item visual defects. - Continued

	Defect	Major	Minor A	Minor B
XVI.	<u>Shoulder loops</u> - Contd			
	d. Misplaced so that shoulder seam is exposed.	127		
	e. Misplaced, i.e., one shoulder loop further forward or back from position of other shoulder loop:			
	(1) More than 3/16 inch up to 1/4 inch.		242	
	(2) More than 1/4 inch.	128		
	f. Width of shoulder loop at pointed end less than 1-7/16 inches or more than 1-9/16 inches.		243	
	g. Shoulder loop long, i.e., point extending beyond collar seam.	129		
	h. Interlining omitted.		244	
	i. Interlining not caught in stitching.			342
	j. Width of shoulder loop at armhole end less than 1-13/16 inches or more than 1-15/16 inches.		245	
	k. Underside of shoulder loop exposed 1/8 inch along edges for a distance of 1/2 inch or more.			343
	l. Button not aligned with buttonhole, causing bulge or twist on shoulder loop or puckers on shoulder.		246	
	m. Buttonhole finished with purling on reverse side.	130		
	n. Buttonhole off center with width of shoulder loop more than 1/8 inch but not more than 1/4 inch.			344
	o. Buttonhole off center with width of shoulder loop more than 1/4 inch.		247	

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TABLE V. End item visual defects. - Continued

	Defect	Major	Minor A	Minor B
XV.	<u>Shoulder loops</u> - Contd			
	p. Shoulder loop off center with shoulder seam:			
	(1) More than 1/8 inch up to 3/16 inch.		248	
	(2) More than 3/16 inch.	131		
	q. Shoulder loop short, i.e., point more than 5/8 inch from collar seam.	132		
	r. Pointed end of shoulder loop less than 1/4 inch or more than 3/8 inch from collar.			345
	s. Buttonhole less than 3/8 inch or more than 5/8 inch from pointed end of shoulder loop.			346
	t. Underside of shoulder loop exposed 1/8 inch along edges for a distance of 1/2 inch or more.			347

4.4.5.1 Palletization examination. An examination shall be made to determine that the palletization complies with the section 5 requirements. Defects shall be scored in accordance with the list below. The sample unit shall be one palletized unit load fully packaged. The lot size shall be the number of palletized unit loads in the inspection lot. The inspection level shall be S-1, and the AQL shall be 6.5 dhu.

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

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4.5 Methods of inspection

4.5.1 Appearance of seams. Seams suspected of being puckered shall be examined at a distance of three feet in comparison with the AATCC photographic comparative ratings for single needle seams, Test Method 88B. Puckering on a major portion of a seam that is worse than a rating of 4 shall be scored as a puckered seam (see 6.6).

5. PACKAGING

5.1 Preservation. In accordance with the requirements of MIL-STD-2073-1, preservation shall be level A, C, or Commercial as specified (see 6.2).

5.1.1 Level A.

5.1.1.1 Unit packing. Each fully buttoned shirt shall be neatly folded to measure approximately 14 by 7-1/2 inches. The folded shirt shall be secured with stainless steel (AISI Type 304 or 316) pins, aluminum clips, or plastic fasteners and inserted in a snug-fitting, clear polyethylene film bag conforming to A-A-50083.

5.1.1.2 Intermediate packing. Twenty shirts, of one type, class, and size only, unit packed as specified in 5.1.1.1, shall be packed in an intermediate fiberboard container conforming to type CF, class domestic, variety SW, grade 175, style FTC of PPP-B-636. Shirts shall be alternated end for end, 20 in depth within the intermediate container. The inside dimensions of the container shall approximate 14 inches in length, 8 inches in width, and 11 inches in depth. (Approximate dimensions are furnished as a guide only.) Intermediate containers shall be closed in accordance with method II for style FTC of PPP-B-636.

5.1.2 Level C. Each shirt shall be preserved in accordance with MIL-STD-2073-1 requirements for this level.

5.1.3 Commercial. Each shirt shall be preserved in accordance with the applicable requirements of ASTM D 3951.

5.2 Packing. In accordance with the requirements of MIL-STD-2073-1, packing shall be level A, B, C, or Commercial as specified (see 6.2).

* 5.2.1 Level A. Eighty shirts of one size only for type I and 68 shirts of one size and class only for type II, preserved as specified in 5.1, shall be packed in a snug-fitting shipping container conforming to overseas type, style A or I, grade A or B, type 2 load of PPP-B-601. Shipping containers that conform to PPP-B-601 shall be closed and reinforced in accordance with the appendix of PPP-B-601 and waterproofed with a sealed case liner conforming to type I or II, grade C of MIL-L-10547. Shipping containers packed with waterproof packages need not be waterproofed. The contents of each wood shipping container shall not exceed 150 pounds. Level A packages shall be packed flat, front up, collars alternated front to rear, two in length, one in width, and forty in depth within the 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 wrapping paper conforming to A-A-203.

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* 5.2.2 Level B. Eighty shirts of one size only for type I and 68 shirts of one size and class only for type II, preserved as specified in 5.1, shall be packed in a fiberboard shipping container conforming to type CF or SF, class domestic, variety DW, grade 275, style RSC 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 domestic boxes. Level A packages shall be packed flat, two in length, one in width, and two in depth within the shipping container. The inside dimensions of each shipping container shall approximate 17 inches in length, 15 inches in width, and 23 inches in depth. (Approximate dimensions are furnished as a guide only.) Each shipping container shall have the contents completely covered on the top and bottom with a sheet of 30 pound minimum basis weight, kraft wrapping paper conforming to A-A-203 and shall be closed in accordance with method II as specified in the appendix of PPP-B-636.

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

* 5.2.3 Level C. Shirts, of one type, class, and size only, preserved as specified in 5.1, shall be packed in accordance with MIL-STD-2073-1 requirements for this level.

5.2.4 Commercial. Shirts, of one type, class, and size only, preserved as specified in 5.1, shall be packed in accordance with the applicable requirements of ASTM D 3951.

5.3 Palletization. When specified (see 6.2), shirts packed as specified in 5.2 shall be palletized on a 4-way entry pallet in accordance with load type Ia of MIL-STD-147. Each prepared load shall be bonded with primary and secondary straps in accordance with the bonding means K and L or film bonding means O or P. Pallet patterns 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 first be approved by the contracting officer.

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

5.4.1 Polyethylene packages. The polyethylene packages shall have the stock number, the nomenclature, the quantity and the size of the shirts contained therein 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.

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6. NOTES

* (This section contains information of a general or explanatory nature that may be helpful, but is not mandatory.)

6.1 Intended use. The short and long sleeve shirts are intended for wear by female military personnel of the Department of the Air Force.

* 6.2 Acquisition requirements. Acquisition documents should specify the following:

- a. Title, number, and date of the specification.
- b. Type, class, size, and length required (see 1.2).
- c. Issue of DoDISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.1 and 2.2).
- d. When a first article is required (see 3.1).
- e. Selection of applicable levels of preservation and packing (see 5.1 and 5.2).
- f. When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).
- g. When palletization is required (see 5.3)

* 6.3 First article. When a first article inspection is required, the item should be a first article sample. The contracting officer should also 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. Bidders should not submit alternate bids unless specifically requested to do so in the solicitation.

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

* 6.5 Government furnished patterns. The contracting officer should arrange to furnish the patterns listed in 3.5.

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6.6 Seam appearance. In order to avoid puckering and to produce the flattest seams possible, consideration must be given to the following:

- a. The needle should be the smallest size possible with a slim point.
- b. The smallest throat plate hole possible shall be used to prevent flagging.
- c. The feed dogs should contain 18 to 20 teeth per inch for normal sewing and 20 to 25 teeth per inch for stitching down. Pressure on the pressure foot should be just enough to insure a steady flow of material and to prevent the stretching of the top ply of material.
- d. All attachments should be as smooth as possible to permit free flowing of the material through the machine.
- e. The lightest possible thread tensions, while maintaining a good stitch, should be used. The upper and lower threads shall be balanced.
- f. Checks to insure that blunt needles are eliminated and that machine adjustments are maintained should be made frequently.

* 6.7 Subject term (key word) listing.

garment, long-sleeved
 garment, short-sleeved
 uniform, dress, security police

6.8 Changes from previous issue. The margins of this specification are marked with asterisks 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.

Custodian:
 Air Force - 11

Preparing activity:
 Air Force - 11

Review activities:
 Air Force - 82, 99
 DLA - CT

Project No. 8410-F728

User activity:
 Air Force - 45

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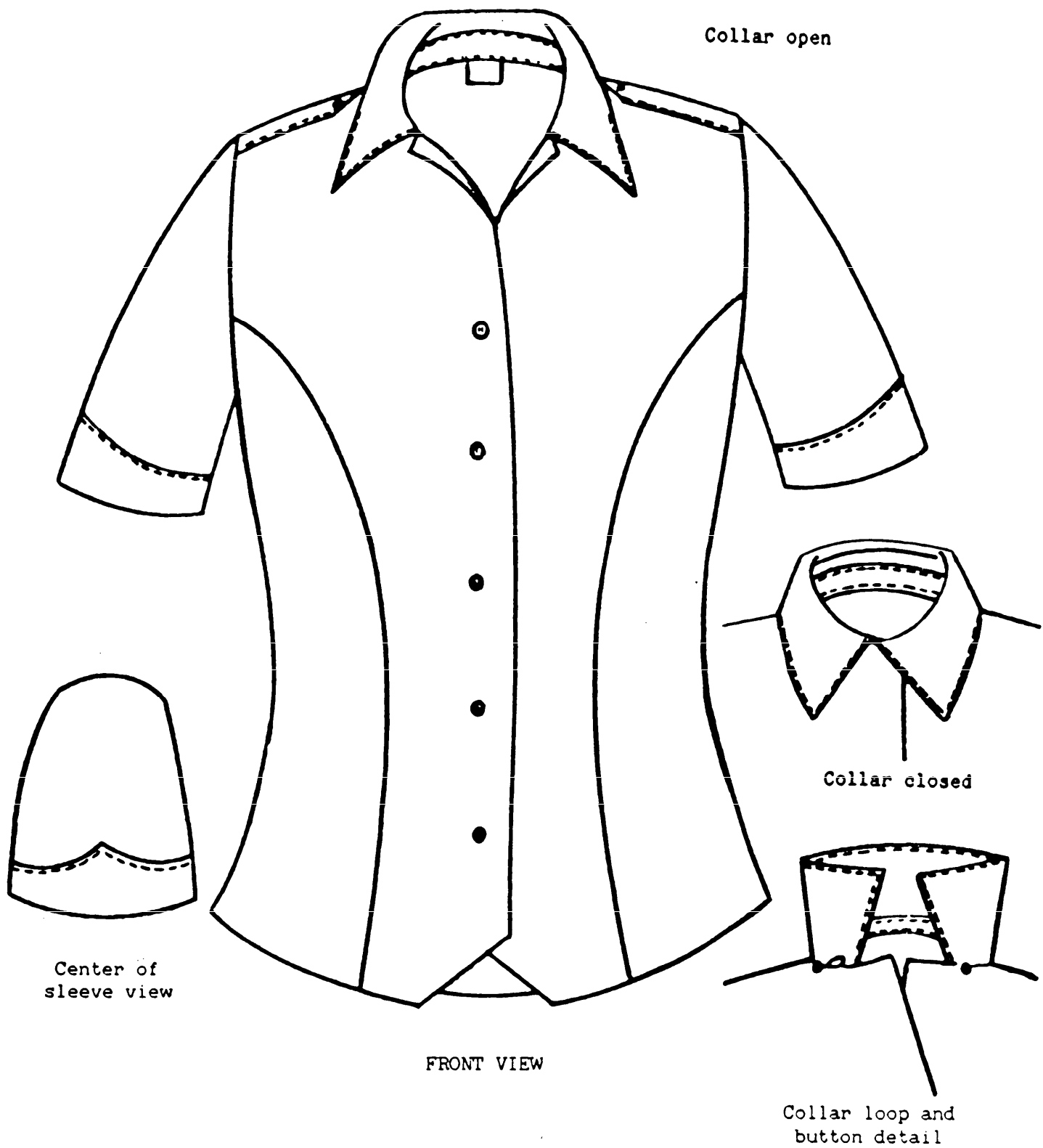
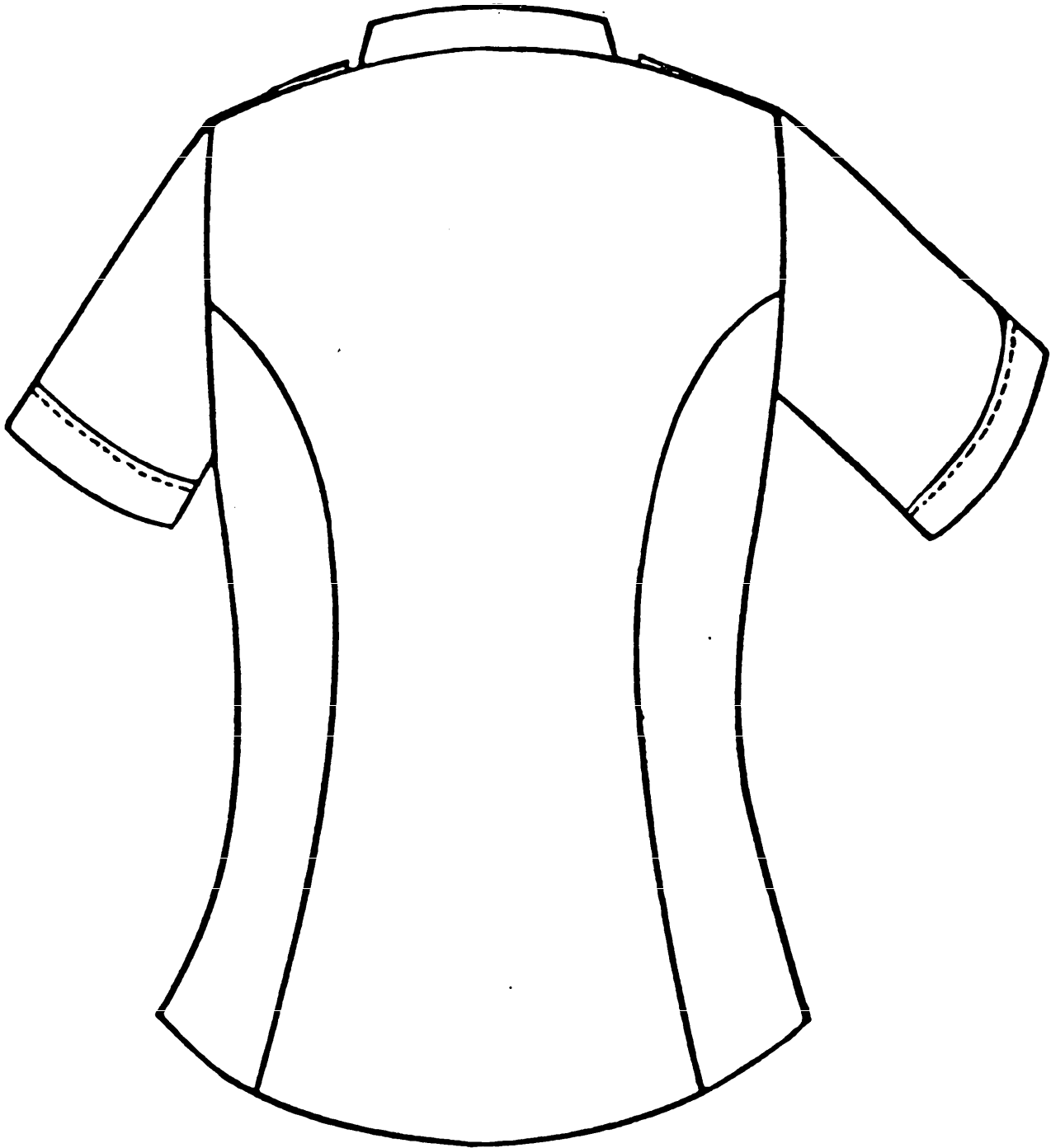


FIGURE 1. Woman's short sleeve shirt, type I.

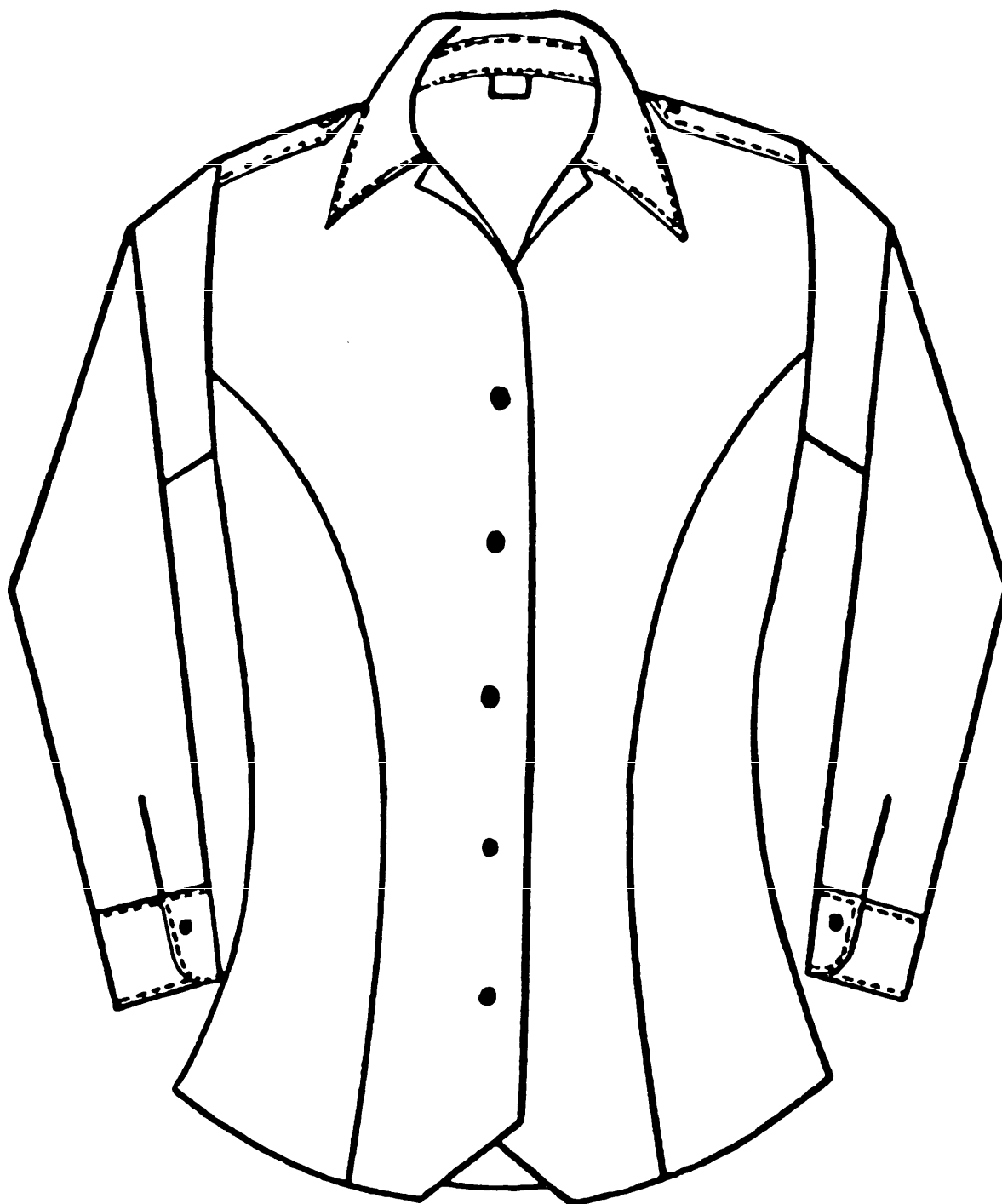
MIL-S-87225A(USAF)



BACK VIEW

FIGURE 2. Woman's short sleeve shirt, type I.

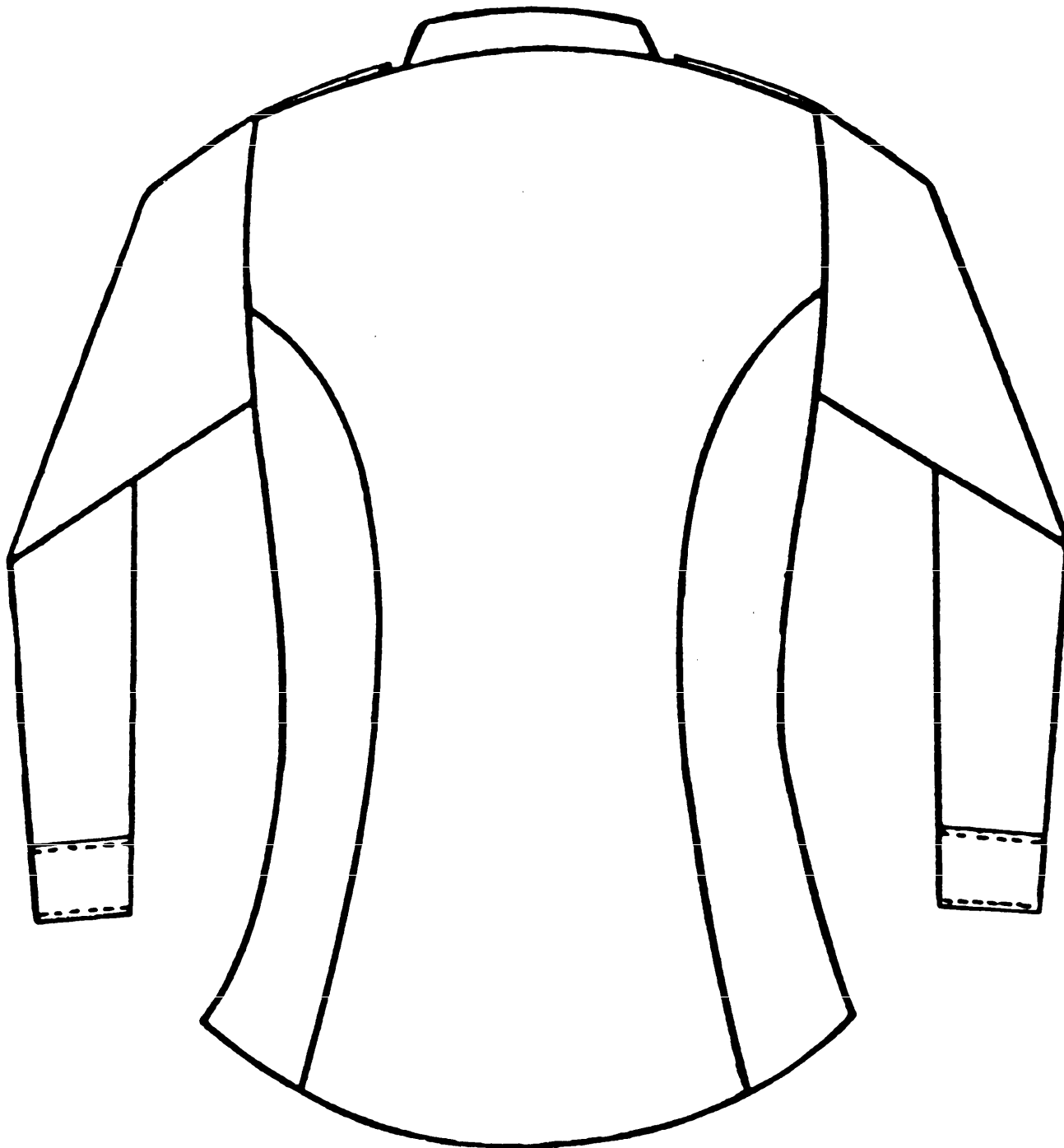
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FRONT VIEW

FIGURE 3. Woman's long sleeve shirt, type II.

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BACK VIEW

FIGURE 4. Woman's long sleeve shirt, type II.

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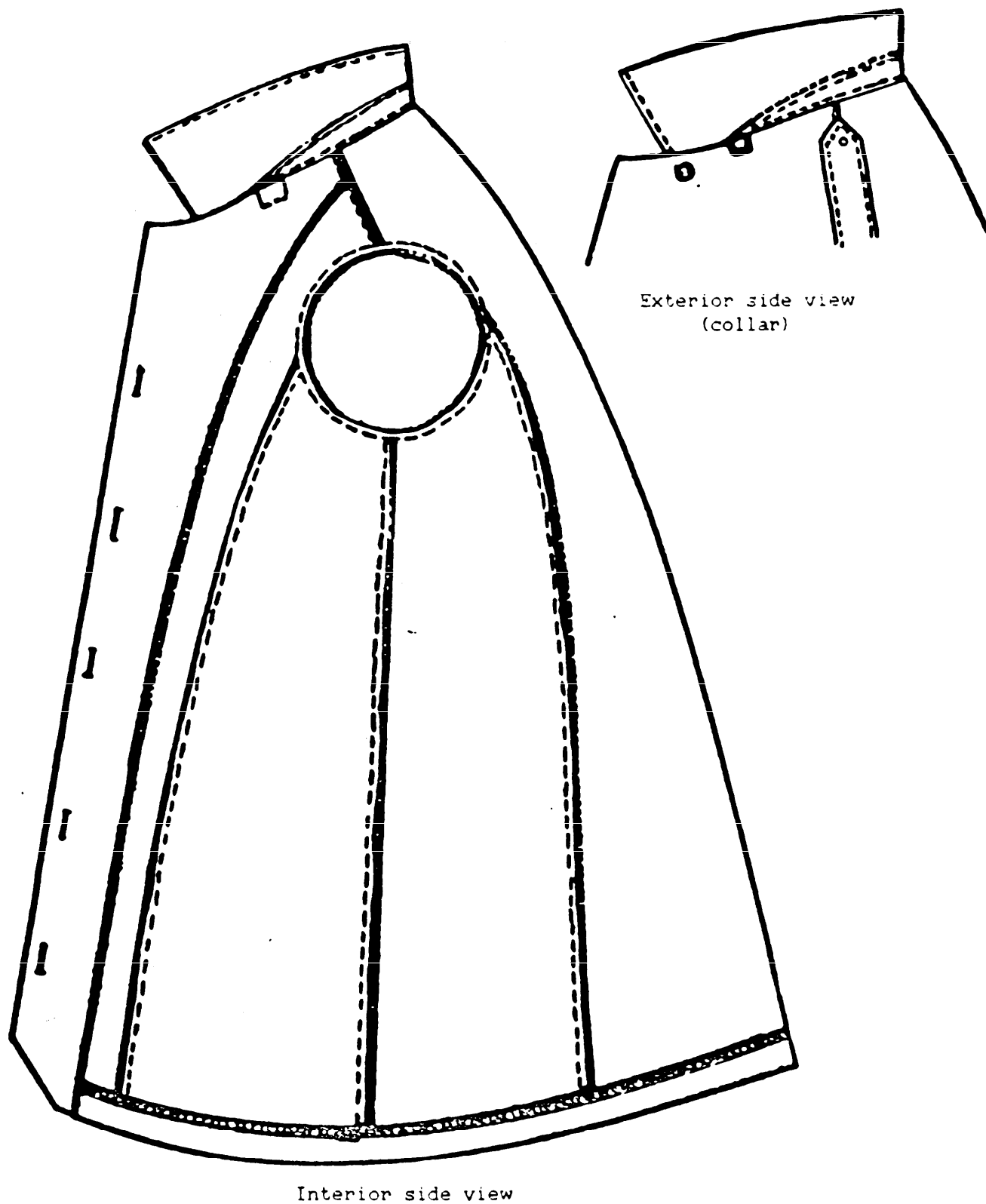


FIGURE 5. Woman's shirts, types I and II.

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

INSTRUCTIONS

1. The preparing activity must complete blocks 1, 2, 3, and 8. In block 1, both the document number and revision letter should be given.
2. The submitter of this form must complete blocks 4, 5, 6, and 7.
3. The preparing activity must provide a reply within 30 days from receipt of the form.

NOTE: This form may not be used to request copies of documents, nor to request waivers, or clarification of requirements on current contracts. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements.

RECOMMEND A CHANGE:		1. DOCUMENT NUMBER MIL-S-87225A(USAF)	2. DOCUMENT DATE (YYMMDD) 900507
3. DOCUMENT TITLE SHIRTS, WOMEN'S: SHORT AND LONG SLEEVES, POLYESTER/COTTON (DURABLE PRESS) AND LONG SLEEVES, POLYESTER/WOOL			
4. NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)			
5. REASON FOR RECOMMENDATION			
6. SUBMITTER			
a. NAME (Last, First, Middle Initial)		b. ORGANIZATION	
c. ADDRESS (Include Zip Code)		d. TELEPHONE (Include Area Code) (1) Commercial (2) AUTOVON (If applicable)	e. DATE SUBMITTED (YYMMDD)
8. PREPARING ACTIVITY			
a. NAME ASD/ENES		b. TELEPHONE (Include Area Code) (1) Commercial (2) AUTOVON (513) 255-6295 785-6295	
c. ADDRESS (Include Zip Code) Wright-Patterson AFB OH 45433-6503		IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT: Defense Quality and Standardization Office 5203 Leesburg Pike, Suite 1403, Falls Church, VA 22041-3466 Telephone (703) 756-2340 AUTOVON 289-2340	